

FRAISE Z4 POUR ALLIAGES RM<1000 AVEC ARROSAGE CENTRAL  
FRÄSER Z4 FÜR RM<1000-LEGIERUNGEN MIT INNENKÜHLUNG  
ENDMILL FOR ALLOYS RM < 1000 WITH INTERNAL COOLING

28138A-3-6

Version du  
31.03.2025



Compatibilité outil / matière  
Werkzeug / Werkstoffverträglichkeit  
Tool / Material compatibility

● 1/3  
● 2/3  
● 3/3

EZI - ALPHA 3

Groupe Vc [m/min]

|                                                                            |                                |     |     |   |
|----------------------------------------------------------------------------|--------------------------------|-----|-----|---|
| ACIERS ALLIÉS ET NON ALLIÉS<br>UNLEGIERTE STÄHLE<br>NON-ALLOYED STEELS     | Rm < 450 N/mm <sup>2</sup>     | 1a  | 340 | ● |
|                                                                            | Rm 450 - 700 N/mm <sup>2</sup> | 1b  | 260 | ● |
|                                                                            | Rm 700 - 900 N/mm <sup>2</sup> | 1c  | 180 | ● |
|                                                                            | Rm < 1200 N/mm <sup>2</sup>    | 1d  | 100 | ● |
| ACIERS INOX<br>ROSTFREIE STÄHLE<br>STAINLESS STEELS                        | Rm < 650 N/mm <sup>2</sup>     | 2a  | 100 | ● |
|                                                                            | Rm 650 - 950 N/mm <sup>2</sup> | 2b  | 90  | ● |
|                                                                            | Rm > 950 N/mm <sup>2</sup>     | 2c  | 70  | ● |
| ACIERS TREMPÉS GEHÄRTETE<br>STÄHLE HARDENED STEELS                         | 44 - 56 HRC                    | 3a  | 40  | ● |
|                                                                            | 57 - 67 HRC                    | 3b  | 30  | ● |
| MATÉRIAUX EXOTIQUES<br>EXOTISCHE WERKSTOFFE<br>EXOTIC MATERIALS            | < 32 HRC                       | 4a  | 70  | ● |
|                                                                            | > 32 HRC                       | 4b  | 40  | ● |
| GRAPHITE                                                                   |                                | 5   |     |   |
| FONTES GUSS CAST IRON                                                      | < 32 HRC                       | 6a  | 180 | ● |
|                                                                            | > 32 HRC                       | 6b  | 130 | ● |
| TITANE TITAN                                                               | Rm < 800 N/mm <sup>2</sup>     | 7a  | 90  | ● |
|                                                                            | 800 < Rm N/mm <sup>2</sup>     | 7b  | 70  | ● |
| ALLIAGES NICKEL<br>NICKEL<br>NICKEL ALLOYS                                 | Rm < 1000 N/mm <sup>2</sup>    | 8a  | 40  | ● |
|                                                                            | 1000 < Rm N/mm <sup>2</sup>    | 8b  | 30  | ● |
| CUIVRE, LAITON, BRONZE<br>KUPFER, MESSING, BRONZE<br>COPPER, BRASS, BRONZE | Rm < 850 N/mm <sup>2</sup>     | 9a  |     |   |
|                                                                            | 850 < Rm N/mm <sup>2</sup>     | 9b  |     |   |
| ALUMINIUM                                                                  | Si < 0.5%                      | 10a |     |   |
|                                                                            | 0.5% < Si < 5%                 | 10b |     |   |
|                                                                            | Si > 5%                        | 10c |     |   |
| MATIÈRES SYNTHÉTIQUES<br>KUNSTSTOFFE<br>SYNTHETIC MATERIALS                | Thermoplast                    | 11a |     |   |
|                                                                            | Duraplast                      | 11b |     |   |
| MATIÈRES COMPOSITES<br>FASERVERST. MATERIALIEN<br>COMPOSITE MATERIALS      | Fibre de verre                 | 12a |     |   |
|                                                                            | Fibre de carbone               | 12b |     |   |
| MÉTAUX PRÉCIEUX<br>EDELMETALLE<br>PRECIOUS MATERIALS                       | Or • Gold                      | 13a |     |   |
|                                                                            | Platine                        | 13b | 40  | ● |



ESHOP / EZI CUT

|              |      |
|--------------|------|
| D (h10)      | 3    |
| d (h6)       | 6    |
| L            | 57   |
| l1           | 4.5  |
| l3           |      |
| d3           |      |
| R            |      |
| e            |      |
| Z            | 3    |
| Chanfrein    | 0.1  |
| K            |      |
| w° collision | 8.1° |