

47420-7.02

Version du  
21.01.2025



E2

$\lambda = -5^\circ$   
 $\gamma = 5^\circ$

Compatibilité outil / matière  
Werkzeug / Werkstoffverträglichkeit  
Tool / Material compatibility

● 1/3  
● 2/3  
● 3/3

Groupe E2  
Vc [m/min]

|                                                                            |                                |     |    |   |
|----------------------------------------------------------------------------|--------------------------------|-----|----|---|
| ACIERS ALLIÉS ET NON ALLIÉS<br>UNLEGIERTE STÄHLE<br>NON-ALLOYED STEELS     | Rm < 450 N/mm <sup>2</sup>     | 1a  | 30 | ● |
|                                                                            | Rm 450 - 700 N/mm <sup>2</sup> | 1b  | 20 | ● |
|                                                                            | Rm 700 - 900 N/mm <sup>2</sup> | 1c  | 15 | ● |
|                                                                            | Rm < 1200 N/mm <sup>2</sup>    | 1d  | 10 | ● |
| ACIERS INOX<br>ROSTFREIE STÄHLE<br>STAINLESS STEELS                        | Rm < 650 N/mm <sup>2</sup>     | 2a  | 10 | ● |
|                                                                            | Rm 650 - 950 N/mm <sup>2</sup> | 2b  | 10 | ● |
|                                                                            | Rm > 950 N/mm <sup>2</sup>     | 2c  | 7  | ● |
| ACIERS TREMPÉS GEHÄRTETE<br>STÄHLE HARDENED STEELS                         | 44 - 56 HRC                    | 3a  | 5  | ● |
|                                                                            | 57 - 67 HRC                    | 3b  | 5  | ● |
| MATÉRIAUX EXOTIQUES<br>EXOTISCHE WERKSTOFFE<br>EXOTIC MATERIALS            | < 32 HRC                       | 4a  | 5  | ● |
|                                                                            | > 32 HRC                       | 4b  | 5  | ● |
| GRAPHITE                                                                   |                                | 5   | 25 | ● |
| FONTES GUSS CAST IRON                                                      | < 32 HRC                       | 6a  | 10 | ● |
|                                                                            | > 32 HRC                       | 6b  | 10 | ● |
| TITANE TITAN                                                               | Rm < 800 N/mm <sup>2</sup>     | 7a  | 10 | ● |
|                                                                            | 800 < Rm N/mm <sup>2</sup>     | 7b  | 5  | ● |
| ALLIAGES NICKEL<br>NICKEL<br>NICKEL ALLOYS                                 | Rm < 1000 N/mm <sup>2</sup>    | 8a  | 5  | ● |
|                                                                            | 1000 < Rm N/mm <sup>2</sup>    | 8b  | 5  | ● |
| CUIVRE, LAITON, BRONZE<br>KUPFER, MESSING, BRONZE<br>COPPER, BRASS, BRONZE | Rm < 850 N/mm <sup>2</sup>     | 9a  | 55 | ● |
|                                                                            | 850 < Rm N/mm <sup>2</sup>     | 9b  | 35 | ● |
| ALUMINIUM                                                                  | Si < 0.5%                      | 10a | 60 | ● |
|                                                                            | 0.5% < Si < 5%                 | 10b | 50 | ● |
|                                                                            | Si > 5%                        | 10c | 35 | ● |
| MATIÈRES SYNTHÉTIQUES<br>KUNSTSTOFFE<br>SYNTHETIC MATERIALS                | Thermoplast                    | 11a | 30 | ● |
|                                                                            | Duraplast                      | 11b | 20 | ● |
| MATIÈRES COMPOSITES<br>FASERVERST. MATERIALEN<br>COMPOSITE MATERIALS       | Fibre de verre                 | 12a | 25 | ● |
|                                                                            | Fibre de carbone               | 12b | 15 | ● |
| MÉTAUX PRÉCIEUX<br>EDELMETALLE<br>PRECIOUS MATERIALS                       | Or • Gold                      | 13a | 35 | ● |
|                                                                            | Platine                        | 13b | 5  | ● |



ESHOP / EZI CUT

|                |      |
|----------------|------|
| D (0 / +0.003) | 7.02 |
| d (0 / +0.003) | 7.02 |
| L              | 100  |
| L1             | 19   |
| L3             | 59   |
| d3             | 6.70 |
| R              |      |
| e              |      |
| Z              | 6    |
| Chanfrein      | 0.7  |
| K              |      |
| w° collision   |      |

