

FORET HÉLICOÏDAL Z3 ~ 6 \* D  
BOHRER Z3 ~ 6 \* D  
DRILL Z3 ~ 6 \* D

48300E-9

Version du  
15.06.2020



E2

$\lambda = 30^\circ$



Compatibilité outil / matière  
Werkzeug / Werkstoffverträglichkeit  
Tool / Material compatibility

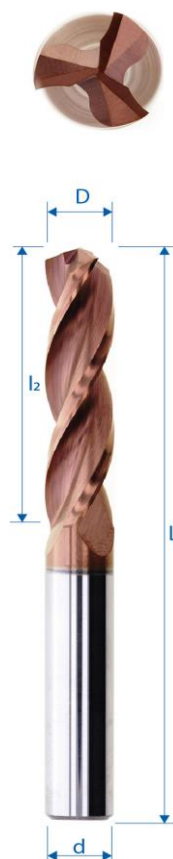
● 1/3  
● 2/3  
● 3/3

HELICA  
Groupe Vc [m/min]



ESHOP / EZI CUT

|                                                                            |                                |     |     |   |
|----------------------------------------------------------------------------|--------------------------------|-----|-----|---|
| ACIERS ALLIÉS ET NON ALLIÉS<br>UNLEGIERTE STÄHLE<br>NON-ALLOYED STEELS     | Rm < 450 N/mm <sup>2</sup>     | 1a  | 110 | ● |
|                                                                            | Rm 450 - 700 N/mm <sup>2</sup> | 1b  | 90  | ● |
|                                                                            | Rm 700 - 900 N/mm <sup>2</sup> | 1c  | 70  | ● |
|                                                                            | Rm < 1200 N/mm <sup>2</sup>    | 1d  | 50  | ● |
| ACIERS INOX<br>ROSTFREIE STÄHLE<br>STAINLESS STEELS                        | Rm < 650 N/mm <sup>2</sup>     | 2a  | 70  | ● |
|                                                                            | Rm 650 - 950 N/mm <sup>2</sup> | 2b  | 60  | ● |
|                                                                            | Rm > 950 N/mm <sup>2</sup>     | 2c  | 40  | ● |
| ACIERS TREMPÉS GEHÄRTETE<br>STÄHLE HARDENED STEELS                         | 44 - 56 HRC                    | 3a  | 25  | ● |
|                                                                            | 57 - 67 HRC                    | 3b  | 15  | ● |
| MATÉRIAUX EXOTIQUES<br>EXOTISCHE WERKSTOFFE<br>EXOTIC MATERIALS            | < 32 HRC                       | 4a  | 30  | ● |
|                                                                            | > 32 HRC                       | 4b  | 20  | ● |
| GRAPHITE                                                                   |                                | 5   | 120 | ● |
| FONTES GUSS CAST IRON                                                      | < 32 HRC                       | 6a  | 50  | ● |
|                                                                            | > 32 HRC                       | 6b  | 40  | ● |
| TITANE TITAN                                                               | Rm < 800 N/mm <sup>2</sup>     | 7a  | 40  | ● |
|                                                                            | 800 < Rm N/mm <sup>2</sup>     | 7b  | 30  | ● |
| ALLIAGES NICKEL<br>NICKEL<br>NICKEL ALLOYS                                 | Rm < 1000 N/mm <sup>2</sup>    | 8a  | 25  | ● |
|                                                                            | 1000 < Rm N/mm <sup>2</sup>    | 8b  | 20  | ● |
| CUIVRE, LAITON, BRONZE<br>KUPFER, MESSING, BRONZE<br>COPPER, BRASS, BRONZE | Rm < 850 N/mm <sup>2</sup>     | 9a  | 210 | ● |
|                                                                            | 850 < Rm N/mm <sup>2</sup>     | 9b  | 150 | ● |
| ALUMINIUM                                                                  | Si < 0.5%                      | 10a | 240 | ● |
|                                                                            | 0.5% < Si < 5%                 | 10b | 190 | ● |
|                                                                            | Si > 5%                        | 10c | 150 | ● |
| MATIÈRES SYNTHÉTIQUES<br>KUNSTSTOFFE<br>SYNTHETIC MATERIALS                | Thermoplast                    | 11a | 120 | ● |
|                                                                            | Duraplast                      | 11b | 90  | ● |
| MATIÈRES COMPOSITES<br>FASERVERST. MATERIALEN<br>COMPOSITE MATERIALS       | Fibre de verre                 | 12a | 90  | ● |
|                                                                            | Fibre de carbone               | 12b | 70  | ● |
| MÉTAUX PRÉCIEUX<br>EDELMETALLE<br>PRECIOUS MATERIALS                       | Or • Gold                      | 13a | 150 | ● |
|                                                                            | Platine                        | 13b | 30  | ● |



|              |    |
|--------------|----|
| D (h10)      | 9  |
| d (h6)       | 10 |
| L            | 80 |
| L1           | 40 |
| L3           |    |
| d3           |    |
| R            |    |
| e            |    |
| Z            | 3  |
| Chanfrein    |    |
| K            |    |
| w° collision |    |