

FORET HÉLICOÏDAL Z2 ~ 6 \* D  
 BOHRER Z2 ~ 6 \* D  
 DRILL Z2 ~ 6 \* D

**48350E-9.4**

Version du  
 15.06.2020



Compatibilité outil / matière  
 Werkzeug / Werkstoffverträglichkeit  
 Tool / Material compatibility

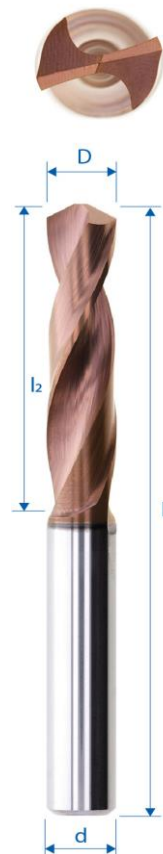


ESHOP / EZI CUT

- 1/3
- 2/3
- 3/3

HELICA  
 Groupe Vc [m/min]

|  |                                | Groupe | Vc [m/min] |   |
|--|--------------------------------|--------|------------|---|
| 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     | 30         | ● |
|  | 57 - 67 HRC                    | 3b     | 10         | ● |
| 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)      | 9.4 |
| d (h6)       | 10  |
| L            | 80  |
| l1           | 40  |
| l3           |     |
| d3           |     |
| R            |     |
| e            |     |
| Z            | 2   |
| Chanfrein    |     |
| K            |     |
| w° collision |     |