

CONDITIONS DE COUPE RECOMMANDÉES

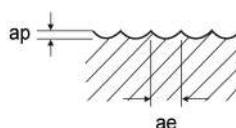
CARBURE, HÉMISPHERIQUES 4 DENTS REVÊTUES TiAlN SÉRIE LONGUE

réf. 30006

VITESSE NORMALE

Matière usinée	Aciers alliés Aciers réfractaires		Aciers trempés		Aciers trempés	
DURETÉ	HRc 30 ~ HRc 40		HRc 40 ~ HRc 50		HRc 50 ~ HRc 55	
RESISTANCE	1000 ~ 1250N/mm²		1250 ~ 1750N/mm²		1750 ~ 2000N/mm²	
DIAMETRE	RPM	Avance	RPM	Avance	RPM	Avance
R0.5 × 1.0	15 760	380	12 720	300	5 800	130
R0.75 × 1.5	15 760	530	12 140	410	5 320	180
R1.0 × 2.0	15 760	800	11 560	480	4 840	160
R1.5 × 3.0	13 100	1 020	10 000	690	4 520	220
R2.0 × 4.0	10 500	1 110	8 400	800	4 200	270
R2.5 × 5.0	9 140	1 230	7 300	870	3 680	270
R3.0 × 6.0	8 490	1 530	6 900	1 250	3 180	280
R4.0 × 8.0	7 160	1 950	5 770	1 380	2 470	330
R5.0 × 10.0	6 370	2 300	5 090	1 530	2 040	340
R6.0 × 12.0	5 840	2 600	4 640	1 650	1 750	370
R8.0 × 16.0	4 770	2 600	3 780	1 600	1 350	370
R10.0 × 20.0	4 140	2 500	3 260	1 560	1 110	375

ap : D1~D6=0.2mm
D8~D20=0.3mm
ae : 0.2×D



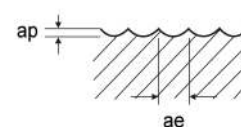
ap : D1~D6=0.2mm
D8~D20=0.3mm
ae : 0.1×D

R.P.M. = tours/minute
Avance = mm/minute

GRANDE VITESSE

Matière usinée	Aciers alliés Aciers réfractaires		Aciers trempés	
DURETÉ	HRc 30 ~ HRc 40		HRc 50 ~ HRc 55	
RESISTANCE	1000 ~ 1250N/mm²		1750 ~ 2000N/mm²	
DIAMETRE	RPM	Avance	RPM	Avance
R0.5 × 1.0	25 000	1 950	25 000	1 200
R0.75 × 1.5	23 000	2 100	23 000	1 290
R1.0 × 2.0	21 000	2 200	21 000	1 400
R1.5 × 3.0	21 000	3 000	17 000	1 560
R2.0 × 4.0	21 000	4 400	13 660	1 740
R2.5 × 5.0	21 000	5 400	12 000	1 800
R3.0 × 6.0	21 000	6 000	10 500	1 880
R4.0 × 8.0	16 700	6 000	8 360	1 880
R5.0 × 10.0	14 000	5 850	7 000	1 800
R6.0 × 12.0	12 200	5 850	6 100	1 740
R8.0 × 16.0	9 550	5 180	4 770	1 500
R10.0 × 20.0	7 960	4 770	3 980	1 380

ap : D1~D6=0.2mm
D8~D20=0.3mm
ae : 0.05×D



R.P.M. = tours/minute
Avance = mm/minute