FILETAGE

GEWINDEN

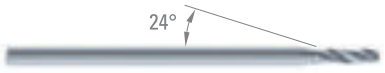
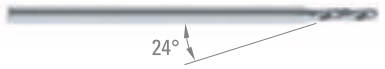
THREADING

FILETTATURA

MENET

SÉLECTION DES OUTILS À FILETER

✓ = article de stock

MICRO-TARAUDS COUPANTS		Z	Page		☐ CARBURE	■ DI-TOP			
DIXI 1712 R S 0.30 - M 2.00		3	286	NIHS 06 ISO 60°	✓				
DIXI 1712 L S 0.60 - S 1.00		3	286	NIHS 06	✓				
DIXI 1713 S 0.40 - S 1.40		3	287	NIHS 06	✓				
DIXI 1708 S 0.30 - S 1.40		3	287	NIHS 06	✓	✓			
DIXI 1710 S 0.30 - S 1.40		3	288	NIHS 06	✓				
MICRO-TARAUDS À REFOULER									
DIXI 1715 S 0.40 - S 1.40 M 1.00 - M 2.20		-	289	NIHS 06 ISO 60°		✓			
DIXI 1716 S 0.40 - S 1.40 M 1.00 - M 1.40		-	290	NIHS 06 ISO 60°		✓			
JAUGES FILETÉES									
DIXI 1718-NT R+L **R** S 0.30 - S 1.40 **L** S 0.50 - S 1.20		-	291	NIHS 06	✓				
DIXI 1718-RT S 0.30 - S 1.40		-	291	NIHS 06	✓				
DIXI 1719-NT/RT R+L **R** S 0.30 - S 1.40 **L** S 0.50 - S 1.20		-	291	NIHS 06	✓				
DIXI 1718-M M 1.00 - M 3.00		-	292	ISO 1502	✓				
DIXI 1719-M M 1.00 - M 3.00		-	292	ISO 1502	✓				
SET DE JAUGES		-	293	NIHS 06	✓				

○ bien ◎ excellent

Acier + Pb	Acier faibl. allié	Aciers fort. allié	Acier inox aust.	Aciers Fontes 45-65 HRC	Fontes	Super alliages Ni / Co	Titane, alliages de titane	Alliage Cu Argent Or	Alliage Cu difficile	Alu	Graphite	Plastique
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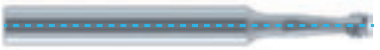
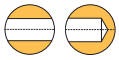
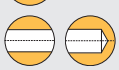
○	◎	○	◎					○	○	○		
○								◎	◎	◎		

SÉLECTION DES OUTILS À FILETER

✓ = article de stock

OUTILS À TOURBILLONNER	Z	Page		CARBURE	TiAlN	CUTINOX	DI-TOP	DAC
DIXI 1739 S 0.30 - S 1.40 Profil partiel 	1	293	NIHS 06	✓				
DIXI 1738 S 0.70 - M 3.00 Profil partiel 	3	294	NIHS 06, ISO 60°	✓		✓		
DIXI 1730 M 0.80 - M 10.00 	3 - 6	295	ISO 60°	✓	✓			
DIXI 1731 M 0.80 - M 10.00 	3 - 6	296	ISO 60°	✓	✓			
DIXI 1735 UNF N°1 - UNC 1/2" 	3 - 6	297	UN 60°	✓	✓			
DIXI 1736 UNF N°1 - UNC 1/2" 	3 - 6	298	UN 60°	✓	✓			
TOURBILLONNEURS-PERCEURS								
DIXI 1740 S 0.80 - M 10.00 	1 - 3	299	NIHS 06, ISO 60°	✓		✓		
DIXI 1742 M 5.00 - M 10.00 	2	300	ISO 60°, 					✓
DIXI 1744 M 5.00 - M 10.00 	4	300	ISO 60°, 			✓		
FILETAGE AUTOFREIN								
DIXI 1712-AF/BT S 0.70 - M 1.40 	3	301	DIXI NORM, 	✓				
DIXI 1716-AF/BT S 0.70 - M 1.40 	-	301	DIXI NORM, 				✓	
DIXI 1738-AF/BT S 0.70 - M 3.00 Profil partiel 	3	302	DIXI NORM	✓				
DIXI 1740-AF/BT S 0.80 - M 3.00 	1 - 2	302	DIXI NORM	✓				

○ bien ◎ excellent

Acier + Pb	Acier faibl. allié	Aciers fort. allié	Acier inox aust.	Aciers Fontes 45-65 HRC	Fontes	Super alliages Ni / Co	Titane, alliages de titane	Alliage Cu Argent Or	Alliage Cu difficile	Alu	Graphite	Plastique
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		◎	◎			○	◎					
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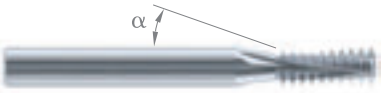
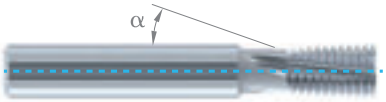
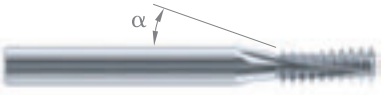
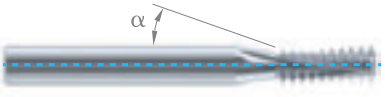
SÉLECTION DES OUTILS À FILETER

✓ = article de stock

		Z	Page		☐ CARBURE	TiAlN	CUTINOX		
FILETAGE AUTOFREIN									
DIXI 1718-AF/BT S 0.70 - M 3.00		-	303	DIXI NORM	✓				
DIXI 1719-AF/BT S 0.70 - M 3.00		-	303	DIXI NORM	✓				
FRAISES À FILETER PAR POLYGONAGE									
DIXI 1660 S 0.40 - S 1.40		94	304	NIHS 06	✓				
FRAISES À FILETER									
DIXI 7910 M 1.4 - M 24.0		2 - 4	305	ISO 60°	✓	✓			
DIXI 7908 M 2.0 - M 24.0		3 - 6	306	ISO 60°	✓	✓			
DIXI 7913 M 10 - M 30		4 - 5	307	ISO 60°	✓		✓		
DIXI 7920 UNC N°2 - UNC 3/4"		2 - 4	308	UN 60°	✓	✓			
DIXI 7918 UNF N°2 - UNC 3/4"		3 - 5	309	UN 60°	✓	✓			
DIXI 7923 UNJF N°10 - UNJF 1/2"		3 - 4	310	UNJ 60°	✓				
DIXI 7940 G1/16" - G1"		3 - 4	310	BSP 55°	✓				
DIXI 7946 R1/16" - R2-1/2"		3 - 4	311	BSPT 55°	✓				
DIXI 7950 NPT 1/16" - NPT 2"		3 - 4	311	NPT 60°	✓				
DIXI 7956 NPTF 1/16" - NPTF 2"		3 - 4	312	NPTF 60°	✓				

○ bien ◎ excellent

Acier + Pb	Acier faibl. allié	Aciers fort. allié	Acier inox aust.	Aciers Fontes 45-65 HRC	Fontes	Super alliages Ni / Co	Titane, alliages de titane	Alliage Cu Argent Or	Alliage Cu difficile	Alu	Graphite	Plastique
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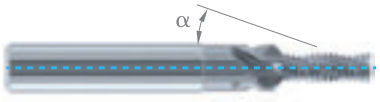
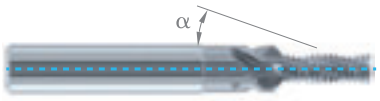
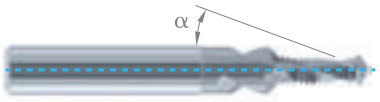
SÉLECTION DES OUTILS À FILETER

✓ = article de stock

FRAISES À FILETER ET CHANFREINER		Z	Page		☐ CARBURE	■ CUTINOX			
DIXI 7915 M 4.0 - M 16.0		3 - 4	312	ISO 60°	✓	✓			
DIXI 7925 UNC N°8 - UNC 5/8''		3 - 4	313	UN 60°	✓	✓			
FRAISES À PERCER, FILETER ET CHANFREINER									
DIXI 7985 M 4.0 - M 16.0		2	314	ISO 60°	✓	✓			

◯ bien ◎ excellent

Acier + Pb	Acier faibl. allié	Aciers fort. allié	Acier inox aust.	Aciers Fontes 45-65 HRC	Fontes	Super alliages Ni / Co	Titane, alliages de titane	Alliage Cu Argent Or	Alliage Cu difficile	Alu	Graphite	Plastique
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◎	◯	◯	◯		◎		◯	◎	◎	◎		◎

					◎			◎	◎	◎		

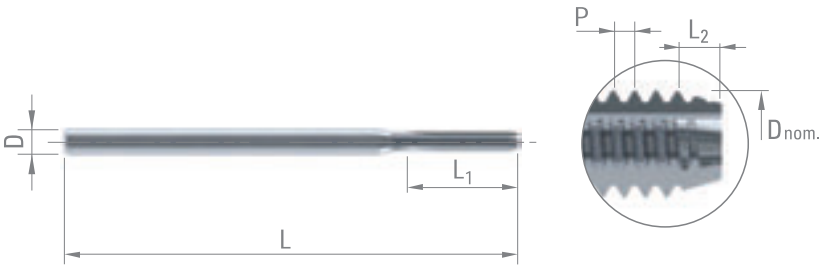
DIXI 1712 R

MICRO-TARAUDS COUPANTS

Z = 3

P. 315
P. 318

Acier + Pb | Alliage Cu Argent Or



D nom.	Pas	Ø perç. laiton	Ø perç. acier	L_1	L_2	D_{h5}	L	NIHS-3G CARBURE	NIHS-3G+ CARBURE	ISO2-6H CARBURE
S 0.30	0.08	0.23	0.24	1.0	0.25	1.5	30	62326		
S 0.35	0.09	0.27	0.28	1.5	0.27	1.5	30	965342		
S 0.40	0.10	0.32	0.33	2.0	0.30	1.5	30	62327	62328	
S 0.50	0.125	0.40	0.42	2.5	0.38	1.5	30	62329	62330	
S 0.60	0.15	0.48	0.50	3.0	0.45	1.5	30	62331	62332	
S 0.70	0.175	0.56	0.58	3.0	0.52	1.5	30	62334	62335	
S 0.80	0.20	0.64	0.66	3.5	0.60	1.5	30	62337	62338	
S 0.90	0.225	0.72	0.74	4.0	0.67	1.5	30	62342	62343	
S 1.00	0.25	0.80	0.82	4.0	0.76	1.5	30	62345	62346	
S 1.20	0.25	1.00	1.02	5.0	0.76	1.5	30	62348		
S 1.40	0.30	1.15	1.17	5.0	0.85	1.5	30	62351		
M 1.50	0.30	1.26	1.28	6.0	0.85	2.0	38			62353
M 2.00	0.40	1.65	1.68	11.0	1.00	2.5	43			62354

n Vitesse de rotation [tr/min] **500 - 2500**

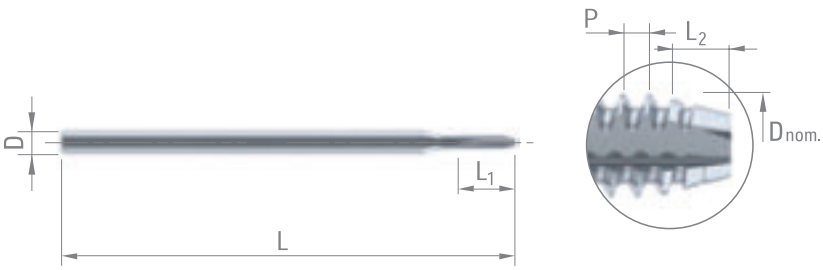
DIXI 1712 L

MICRO-TARAUDS COUPANTS
COUPE À GAUCHE

Z = 3

P. 315
P. 318

Acier + Pb | Alliage Cu Argent Or



D nom.	Pas	Ø perç. laiton	Ø perç. acier	L_1	L_2	D_{h5}	L	NIHS-3G CARBURE
S 0.60	0.15	0.49	0.51	4.0	0.45	1.5	30	969369
S 0.70	0.175	0.57	0.59	4.0	0.52	1.5	30	969370
S 0.80	0.20	0.65	0.67	4.0	0.60	1.5	30	969371
S 0.90	0.225	0.73	0.75	4.0	0.67	1.5	30	969372
S 1.00	0.25	0.81	0.83	4.0	0.75	1.5	30	969373

n Vitesse de rotation [tr/min] **500 - 2500**

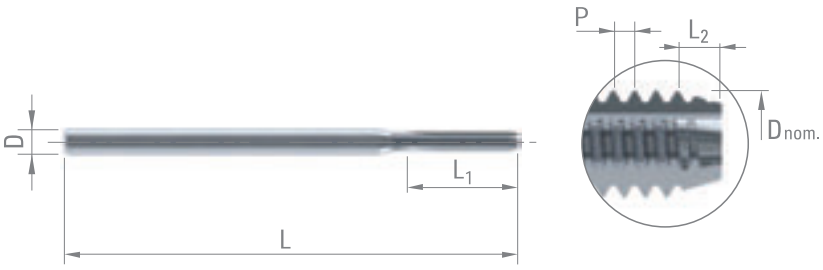
DIXI 1713

MICRO-TARAUDS COUPANTS
HAUTE PERFORMANCE

Z = 3

P. 315
P. 318

Acier + Pb | Alliage Cu Argent Or | Alliage Cu difficile | Alu



D nom.	Pas	Ø perç. laiton	Ø perç. acier	L_1	L_2	D_{h5}	L	NIHS-3G CARBURE
S 0.40	0.10	0.33	0.34	2.5	0.30	2.0	30	969795
S 0.50	0.125	0.41	0.43	3.5	0.38	2.0	30	969474
S 0.60	0.15	0.49	0.51	4.0	0.45	2.0	30	969497
S 0.70	0.175	0.57	0.59	4.0	0.52	2.0	30	969498
S 0.80	0.20	0.65	0.67	4.0	0.60	2.0	30	969499
S 0.90	0.225	0.73	0.75	4.0	0.67	2.0	30	969500
S 1.00	0.25	0.81	0.83	4.0	0.76	2.0	30	969501
S 1.20	0.25	1.01	1.03	5.0	0.76	2.0	30	969502
S 1.40	0.30	1.16	1.18	5.0	0.85	2.0	30	969503

n Vitesse de rotation [tr/min] **500 - 2500**

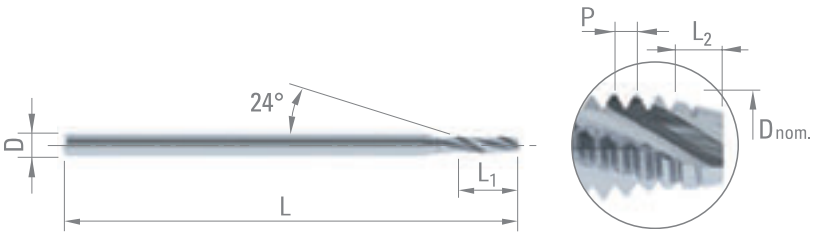
DIXI 1708

MICRO-TARAUDS COUPANTS
HÉLICE À DROITE, COUPE À DROITE

Z = 3

P. 315
P. 318

Acier de décolletage | Alliage Cu Argent Or | Alliage Cu difficile



D nom.	Pas	Ø perç. laiton	Ø perç. acier	L_1	L_2	D_{h5}	L	NIHS-3G CARBURE	NIHS-3G DI-TOP
S 0.30	0.08	0.23	0.24	1.0	0.25	1.5	30	986881	303483
S 0.35	0.09	0.27	0.28	1.5	0.27	1.5	30	986882	303484
S 0.40	0.10	0.32	0.33	2.5	0.30	1.5	30	986883	303485
S 0.50	0.125	0.40	0.42	3.5	0.38	1.5	30	984405	303486
S 0.60	0.15	0.48	0.50	4.0	0.45	1.5	30	983633	303487
S 0.70	0.175	0.56	0.58	4.0	0.52	1.5	30	986884	303488
S 0.80	0.20	0.64	0.66	4.0	0.60	1.5	30	986885	303489
S 0.90	0.225	0.72	0.74	4.0	0.67	1.5	30	986886	303490
S 1.00	0.25	0.80	0.82	4.0	0.76	1.5	30	986887	303491
S 1.20	0.25	1.00	1.02	5.0	0.76	1.5	30	986888	303492
S 1.40	0.30	1.15	1.17	5.0	0.85	1.5	30	986889	303493

n Vitesse de rotation [tr/min] **500 - 2500**

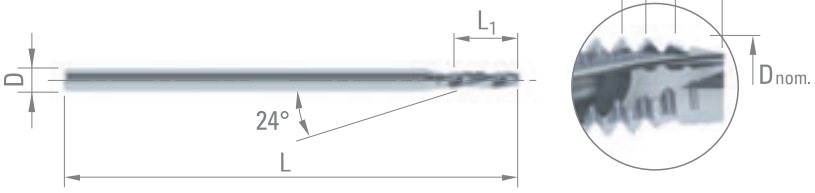
DIXI 1710

MICRO-TARAUDS COUPANTS
HÉLICE À GAUCHE, COUPE À DROITE

Z = 3

P. 315
P. 318

NIHS 06



Acier de décolletage | Alliage Cu Argent Or | Alliage Cu difficile

D nom.	Pas	Ø perç. laiton	Ø perç. acier	L_1	L_2	D_{h5}	L	NIHS-3G CARBURE
S 0.30	0.08	0.23	0.24	1.0	0.25	1.5	30	986890
S 0.35	0.09	0.27	0.28	1.5	0.27	1.5	30	986891
S 0.40	0.10	0.32	0.33	2.5	0.30	1.5	30	986892
S 0.50	0.125	0.40	0.42	3.5	0.38	1.5	30	986893
S 0.60	0.15	0.48	0.50	4.0	0.45	1.5	30	986894
S 0.70	0.175	0.56	0.58	4.0	0.52	1.5	30	986895
S 0.80	0.20	0.64	0.66	4.0	0.60	1.5	30	986896
S 0.90	0.225	0.72	0.74	4.0	0.67	1.5	30	986897
S 1.00	0.25	0.80	0.82	4.0	0.76	1.5	30	986898
S 1.20	0.25	1.00	1.02	5.0	0.76	1.5	30	986899
S 1.40	0.30	1.15	1.17	5.0	0.85	1.5	30	986900

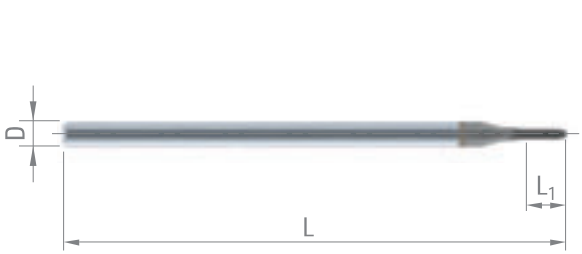
n Vitesse de rotation [tr/min] **500 - 2500**

DIXI 1715 DI-TOP

MICRO-TARAUDS À REFOULER

P. 315
P. 318

NIHS 06 | ISO 60°



Acier + Pb | Acier faibl. allié | Acier fort. allié | Acier inox aust. | Alliage Cu Argent Or | Alliage Cu difficile | Alu

D nom.	Pas	Ø perç. laiton	Ø perç. acier	L_1	L_2	D_{h5}	L	NIHS-3GX DI-TOP
S 0.40	0.10	0.36 - 0.37	0.37 - 0.38	1.6	0.30	1.5	30	974654
S 0.50	0.125	0.45 - 0.46	0.46 - 0.47	2.0	0.37	1.5	30	972407
S 0.60	0.15	0.54 - 0.55	0.55 - 0.56	2.4	0.45	1.5	30	970899
S 0.70	0.175	0.62 - 0.63	0.63 - 0.64	2.8	0.52	1.5	30	970900
S 0.80	0.20	0.70 - 0.71	0.71 - 0.72	3.2	0.60	1.5	30	970901
S 0.90	0.225	0.81 - 0.82	0.82 - 0.83	3.6	0.67	1.5	30	970902
S 1.00	0.25	0.89 - 0.90	0.90 - 0.91	4.0	0.75	1.5	30	305793
S 1.20	0.20	1.11 - 1.12	1.12 - 1.13	4.8	0.60	1.5	30	305794
S 1.20	0.25	1.08 - 1.09	1.09 - 1.10	4.8	0.75	1.5	30	305795
S 1.40	0.20	1.30 - 1.32	1.32 - 1.33	5.6	0.60	1.5	30	305796
S 1.40	0.30	1.27 - 1.28	1.28 - 1.29	5.6	0.90	1.5	30	305797

D nom.	Pas	Ø perç. laiton	Ø perç. acier	L_1	L_2	D_{h5}	L	4HX DI-TOP	5HX DI-TOP	6HX DI-TOP
M 1.00	0.25	0.89 - 0.90	0.90 - 0.91	4.0	0.75	1.5	30		970903	
M 1.20	0.20	1.11 - 1.12	1.12 - 1.13	4.8	0.60	1.5	30	978772		
M 1.20	0.25	1.09 - 1.10	1.10 - 1.11	4.8	0.75	1.5	30		970904	
M 1.40	0.20	1.31 - 1.32	1.32 - 1.33	5.6	0.60	1.5	30	973645		
M 1.40	0.30	1.27 - 1.28	1.28 - 1.29	5.6	0.90	1.5	38		970905	
M 1.50	0.30	1.37 - 1.38	1.38 - 1.39	6.0	0.90	2.0	38			971650
M 1.60	0.35	1.45 - 1.46	1.46 - 1.47	6.0	1.05	2.0	38			970906
M 1.80	0.20	1.71 - 1.72	1.72 - 1.73	7.0	0.60	2.0	38	975090		
M 2.00	0.20	1.91 - 1.92	1.92 - 1.93	8.0	0.60	2.5	43	976259		
M 2.00	0.40	1.83 - 1.84	1.83 - 1.84	8.0	1.20	2.5	43			970907
M 2.20	0.25	2.09 - 2.10	2.10 - 2.11	8.0	0.75	2.5	43		974959	

n Vitesse de rotation [tr/min] **500 - 2500**

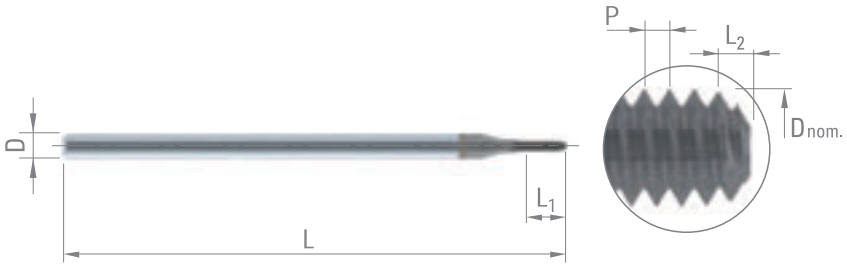
DIXI 1716 DI-TOP

MICRO-TARAUDS À REFOULER

P. 315
P. 318

NIHS 06 | ISO 60°

Acier + Pb | Alliage Cu Argent Or | Alliage Cu difficile | Alu



D nom.	Pas	Ø perç. laiton	Ø perç. acier	L_1	L_2	D_{h5}	L	NIHS-3GX DI-TOP
S 0.40	0.10	0.36 - 0.37	0.37 - 0.38	1.6	0.20	1.5	30	992498
S 0.50	0.125	0.45 - 0.46	0.46 - 0.47	2.0	0.25	1.5	30	992509
S 0.60	0.15	0.54 - 0.55	0.55 - 0.56	2.4	0.30	1.5	30	992514
S 0.70	0.175	0.62 - 0.63	0.63 - 0.64	2.8	0.35	1.5	30	992515
S 0.80	0.20	0.70 - 0.71	0.71 - 0.72	3.2	0.40	1.5	30	992516
S 0.90	0.225	0.81 - 0.82	0.82 - 0.83	3.6	0.45	1.5	30	992517
S 1.00	0.25	0.89 - 0.90	0.90 - 0.91	4.0	0.50	1.5	30	305799
S 1.20	0.20	1.11 - 1.12	1.12 - 1.13	4.8	0.40	1.5	30	305800
S 1.20	0.25	1.08 - 1.09	1.09 - 1.10	4.8	0.50	1.5	30	305801
S 1.40	0.20	1.31 - 1.32	1.32 - 1.33	5.6	0.40	1.5	30	305802
S 1.40	0.30	1.27 - 1.28	1.28 - 1.29	5.6	0.60	1.5	30	305804

D nom.	Pas	Ø perç. laiton	Ø perç. acier	L_1	L_2	D_{h5}	L	4HX DI-TOP	5HX DI-TOP
M 1.00	0.25	0.89 - 0.90	0.90 - 0.91	4.0	0.50	1.5	30		992518
M 1.20	0.20	1.11 - 1.12	1.12 - 1.13	4.8	0.40	1.5	30	992519	
M 1.20	0.25	1.08 - 1.09	1.09 - 1.10	4.8	0.50	1.5	30		992520
M 1.40	0.20	1.31 - 1.32	1.32 - 1.33	5.6	0.40	1.5	30	992521	
M 1.40	0.30	1.27 - 1.28	1.28 - 1.29	5.6	0.60	1.5	38		992522

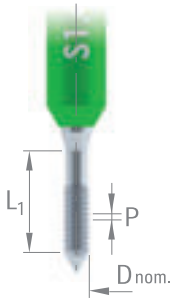
n Vitesse de rotation [tr/min] **500 - 2500**

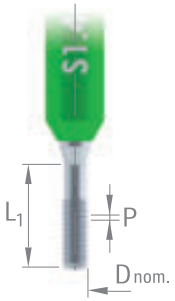
DIXI 1718-NT, -RT - DIXI 1719-NT/RT

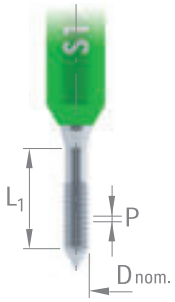
JAUGES FILETÉES NIHS
"GO" - "NO GO"

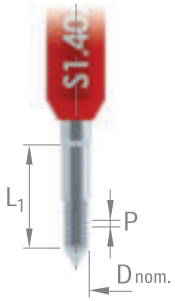
P. 316

NIHS 06









D nom.	Pas	L_1	**1718-NT** GO	**1718-NT** (fond plat) GO	**1718-RT** GO	**1719-NT/RT** NO GO
S 0.30	0.08	1.0	965295	978958	983114	965312
S 0.35	0.09	1.3	965296	978959	983468	965313
S 0.40	0.10	2.0	965297	978960	983115	965314
S 0.50	0.125	2.5	965298	978961	983116	965315
S 0.60	0.15	3.0	965299	978962	983117	965316
S 0.70	0.175	3.0	965300	978963	983236	965317
S 0.80	0.20	3.5	965301	978964	983118	965318
S 0.90	0.225	4.0	965302	978965	983119	965319
S 1.00	0.25	4.0	965303	978966	983120	965320
S 1.20	0.25	5.0	965304	978967	983121	965321
S 1.40	0.30	5.0	965305	978968	983122	965322

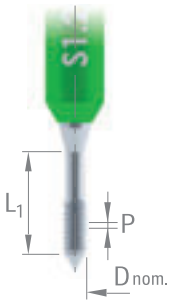
Chaque jauge est livrée avec sa valeur de diamètre sur flancs

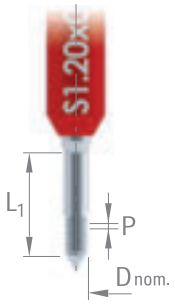
DIXI 1718-NT L - DIXI 1719-NT/RT L

JAUGES FILETÉES NIHS
"GO" - "NO GO"
POUR FILETAGE À GAUCHE

P. 316

NIHS 06



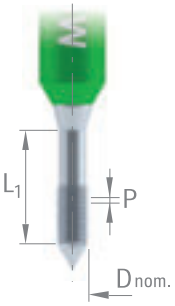


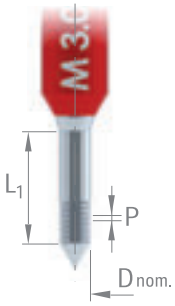
D nom.	Pas	L_1	**1718-NT L** GO	**1719-NT/RT L** NO GO
S 0.50	0.125	2.5	968369	968370
S 0.60	0.15	3.0	968345	968346
S 0.70	0.175	3.0	968344	968347
S 0.80	0.20	3.5	968343	968348
S 0.90	0.225	4.0	968925	968926
S 1.00	0.25	4.0	969395	969396
S 1.20	0.25	5.0	982638	982639

Chaque jauge est livrée avec sa valeur de diamètre sur flancs

JAUGES FILETÉES ISO
"GO" - "NO GO"

ISO 1502





D nom.	Pas	L_1	Tol.	1718-M GO	1719-M NO GO
M 1.00	0.25	5.0	5H	976633	976635
M 1.20	0.20	5.0	4H	305894	305900
M 1.20	0.20	5.0	5H	980934	980935
M 1.20	0.25	5.0	5H	976634	976636
M 1.40	0.20	5.0	4H	305895	305901
M 1.40	0.30	6.0	5H	976693	976710
M 1.50	0.30	6.0	6H	976694	976711
M 1.60	0.20	5.0	4H	305896	305902
M 1.60	0.20	5.0	5H	976695	976713
M 1.60	0.35	6.0	6H	975716	975717
M 1.80	0.20	5.0	4H	305897	305903
M 1.80	0.35	6.0	6H	976024	976026
M 2.00	0.20	5.0	4H	305898	305904
M 2.00	0.40	6.0	6H	976699	976716
M 2.20	0.20	5.0	4H	305899	305905
M 2.20	0.25	5.0	5H	976701	976718
M 2.20	0.45	8.0	6H	976702	976719
M 2.50	0.20	5.0	5H	976703	976720
M 2.50	0.25	5.0	5H	976706	976707
M 2.50	0.35	6.0	6H	303652	303653
M 2.50	0.45	8.0	6H	976704	976721
M 3.00	0.50	8.0	6H	976705	976722

Chaque jauge est livrée avec sa valeur de diamètre sur flancs

DIXI 1718 - SET

SET DE JAUGES FILETÉES NIHS
"GO" - "NO GO"

P. 316

NIHS 06

Contenu	Art.
DIXI 1718-NT GO (S0.30-S1.40) DIXI 1719-NT/RT NO GO (S0.30-S1.40)	305989
DIXI 1718-RT GO (S0.30-S1.40) DIXI 1719-NT/RT NO GO (S0.30-S1.40)	305990
DIXI 1718-NT GO (S0.30-S1.40) DIXI 1718-RT GO (S0.30-S1.40) DIXI 1719-NT/RT NO GO (S0.30-S1.40)	305991

Composez votre propre sélection et personnalisez votre set de jauges.

NB: 2 x 11 emplacements ou 3 x 11 emplacements

DIXI 1739

OUTILS À TOURBILLONNER
PROFIL PARTIEL

Z = 1

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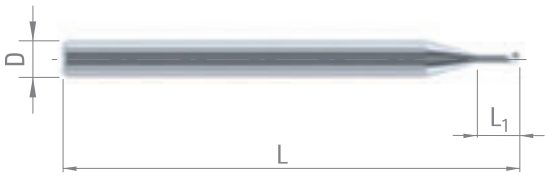
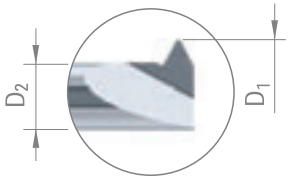
NIHS 06





Acier + Pb	Acier faibl. allié	Acier fort. allié	Acier inox aust.	Titane, alliage de titane
Alliage Cu Argent Or	Alliage Cu difficile	Alu	Plastique	

D nom.	Pas	Ø perçage	D_1	L_1	D_2	D_{h5}	L	CARBURE
S 0.30	0.08	0.23	0.22	0.70	0.13	3	38	961147
S 0.35	0.09	0.27	0.25	0.90	0.15	3	38	984299
S 0.40	0.10	0.32	0.30	0.90	0.19	3	38	961149
S 0.50	0.125	0.40	0.38	1.20	0.24	3	38	961163
S 0.60	0.15	0.48	0.46	1.50	0.29	3	38	961164
S 0.70	0.175	0.56	0.54	1.80	0.34	3	38	961165
S 0.80	0.20	0.64	0.60	2.00	0.37	3	38	961166
S 0.90	0.225	0.72	0.68	2.20	0.42	3	38	961167
S 1.00	0.25	0.80	0.76	2.40	0.48	3	38	961168
S 1.20	0.25	1.00	0.94	3.00	0.66	3	38	961169
S 1.40	0.30	1.15	1.10	3.30	0.76	3	38	961170

DIXI 1738

OUTILS À TOURBILLONNER
PROFIL PARTIEL

Z = 3

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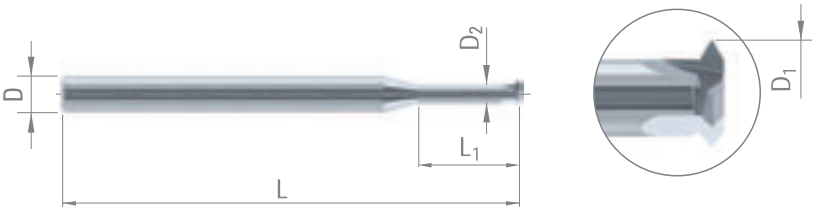
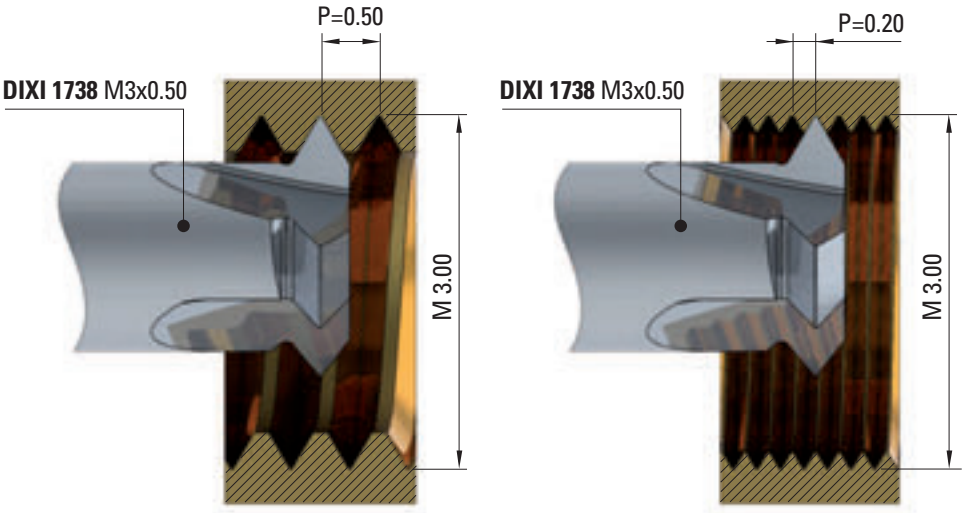
NIHS 06 ISO 60°

Acier fort. allié | Acier inox aust. | Super alliages Ni / Co | Titane, alliage de titane



D nom.		Pas	Ø perçage ISO	Ø perçage NIHS	D_1	L_1	D_2	D_{h5}	L	CARBURE	CUTINOX
	S 0.70	0.175		0.56	0.54	1.80	0.33	3	38	984319	985156
	S 0.80	0.20		0.64	0.62	2.30	0.38	3	38	965997	966008
	S 0.90	0.225		0.72	0.70	2.50	0.43	3	38	965996	966007
M 1.00	S 1.00	0.25	0.75	0.80	0.78	2.80	0.44	3	38	964485	966006
M 1.20	S 1.20	0.25	0.95	1.00	0.98	3.40	0.64	3	38	965664	965943
M 1.40	S 1.40	0.30	1.10	1.15	1.12	4.00	0.71	3	38	965988	965999
M 1.40		0.20	1.22		1.18	4.00	0.74	3	38	965989	965998
M 1.60		0.35	1.30		1.26	4.50	0.72	3	38	965990	966000
M 1.80		0.35 (0.20)	1.50 1.60		1.45	5.10	0.77	3	38	965991	966001
M 2.00		0.40 (0.20)	1.65 1.80		1.60	5.60	0.85	3	38	965992	966002
M 2.20		0.45 (0.25)	1.80 1.95		1.70	6.20	0.91	3	38	965993	966003
M 2.50		0.45 (0.35) (0.25) (0.20)	2.10 2.15 2.25 2.30		2.00	7.00	1.20	3	38	965994	966004
M 3.00		0.50 (0.35) (0.25) (0.20)	2.50 2.65 2.75 2.80		2.40	8.40	1.60	3	38	965995	966005

Un seul outil pour usiner plusieurs pas (exemple, de 0.20 à 0.50)



DIXI 1730

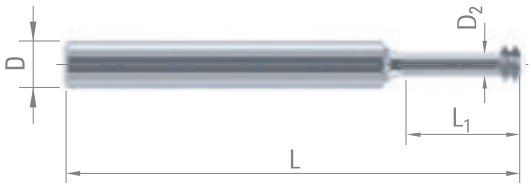
OUTILS À TOURBILLONNER
PROFIL COMPLET

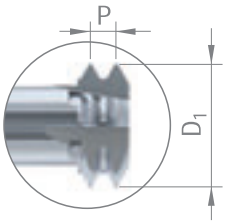
L_1 = 2 x Ø nom.

Z = 3-6

P. 318 P. 320

ISO 60°





Acier + Pb	Acier faibl. allié	Acier fort. allié	Acier inox aust.	Fontes
Super alliages Ni / Co	Titane, alliage de titane	Alliage Cu Argent Or	Alliage Cu difficile	Alu
Graphite	Plastique			

D nom.	Pas	D_1	L_1	D_2	D_{h5}	L	Z	CARBURE	TiAlN
M 0.80	0.20	0.60	1.85	0.27	3	38	3	958853	960446
M 0.90	0.225	0.66	2.10	0.33	3	38	3	953216	960117
M 1.00	0.25	0.73	2.30	0.34	3	38	3	953217	960118
M 1.20	0.25	0.92	2.80	0.53	3	38	3	953218	960450
M 1.40	0.30	1.05	3.20	0.60	3	38	3	953219	960451
M 1.60	0.35	1.21	3.70	0.69	3	38	3	953220	960453
M 1.80	0.20	1.41	4.10	0.89	3	38	3	961128	961130
M 1.80	0.35	1.41	4.10	0.89	3	38	3	953221	960454
M 2.00	0.40	1.55	4.60	0.96	3	38	3	953222	960455
M 2.20	0.20	1.72	5.10	1.08	3	38	3	961129	961132
M 2.20	0.45	1.72	5.10	1.08	3	38	3	953223	960456
M 2.50	0.25	2.00	5.80	1.35	3	38	3	960062	960459
M 2.50	0.35	2.00	5.80	1.35	3	38	3	960063	960460
M 2.50	0.45	2.00	5.80	1.35	3	38	3	953225	960461
M 3.00	0.50	2.44	7.00	1.70	4	42	3	955698	960462
M 4.00	0.70	3.20	9.30	2.25	4	42	3	955699	960463
M 5.00	0.80	4.00	11.50	2.80	6	57	4	957925	960464
M 6.00	1.00	4.85	13.80	3.15	6	57	4	957982	960465
M 8.00	1.25	6.50	18.40	4.65	8	75	6	958039	960466
M 10.00	1.50	7.90	23.00	5.60	8	75	6	958040	960467

DIXI 1731

OUTILS À TOURBILLONNER PROFIL COMPLET

Z = 3-6

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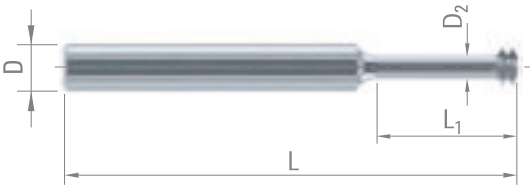
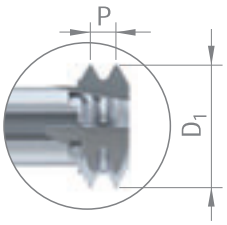
ISO 60°

L_1 = 3 x Ø nom.





Acier + Pb	Acier faibl. allié	Acier fort. allié	Acier inox aust.	Fontes
Super alliages Ni / Co	Titane, alliage de titane	Alliage Cu Argent Or	Alliage Cu difficile	Alu
Graphite	Plastique			

D nom.	Pas	D_1	L_1	D_2	D_{h5}	L	Z	CARBURE	TiAlN
M 0.80	0.20	0.60	2.60	0.27	3	38	3	961148	961176
M 0.90	0.225	0.66	2.90	0.33	3	38	3	961150	961177
M 1.00	0.25	0.73	3.20	0.34	3	38	3	961151	961178
M 1.20	0.25	0.92	3.85	0.53	3	38	3	961152	961179
M 1.40	0.30	1.05	4.50	0.60	3	38	3	961153	961180
M 1.60	0.35	1.21	5.10	0.69	3	38	3	961154	961181
M 1.80	0.20	1.41	5.80	0.89	3	38	3	961155	961182
M 1.80	0.35	1.41	5.80	0.89	3	38	3	961156	961183
M 2.00	0.40	1.55	6.40	0.96	3	38	3	961157	961184
M 2.20	0.20	1.72	7.10	1.08	3	38	3	961158	961185
M 2.20	0.45	1.72	7.10	1.08	3	38	3	961159	961186
M 2.50	0.25	2.00	8.00	1.35	3	38	3	961160	961187
M 2.50	0.35	2.00	8.00	1.35	3	38	3	961161	961188
M 2.50	0.45	2.00	8.00	1.35	3	38	3	961162	961189
M 3.00	0.50	2.44	9.60	1.70	4	42	3	961171	961190
M 4.00	0.70	3.20	12.80	2.25	4	42	3	961172	961191
M 5.00	0.80	4.00	16.00	2.80	6	57	4	961173	961192
M 6.00	1.00	4.85	19.20	3.15	6	57	4	961174	961193
M 8.00	1.25	6.50	25.60	4.65	8	75	6	961175	961194
M 10.00	1.50	7.90	32.00	5.60	8	75	6	960883	961195

DIXI 1735

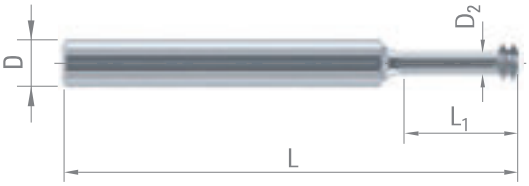
OUTILS À TOURBILLONNER PROFIL COMPLET

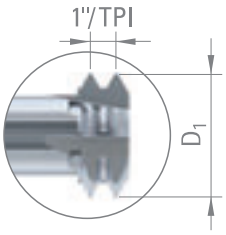
Z = 3-6

P. 318 P. 320

UN 60°

L_1 = 2 x Ø nom.





Acier + Pb	Acier faibl. allié	Acier fort. allié	Acier inox aust.	Fontes
Super alliages Ni / Co	Titane, alliage de titane	Alliage Cu Argent Or	Alliage Cu difficile	Alu
Graphite	Plastique			

UNC	UNF	UNEF	UN	TPI	D_1	L_1	D_2	D_{h5}	L	Z	CARBURE	TiAlN
	N°1			72	1.40	4.3	0.85	3	38	3	966664	966833
N°1	N°2			64	1.40	4.3	0.80	3	38	3	966663	966834
N°2	N°3			56	1.65	5.0	0.95	3	38	3	966662	966835
N°3	N°4			48	1.90	5.8	1.10	3	38	3	966661	966836
	N°5			44	2.00	7.3	1.15	3	38	3	966660	966837
N°4				40	2.10	6.6	1.17	4	42	3	966659	966838
N°5	N°6			40	2.45	7.3	1.52	4	42	3	966658	966839
	N°8			36	3.30	9.6	2.15	4	42	3	966657	966841
N°6				32	2.55	8.1	1.30	4	42	3	960656	966840
N°8	N°10	N°12		32	3.10	9.6	1.90	4	55	3	960205	960628
	N°12		5/16"	28	4.20	12.6	2.85	6	63	3	966655	966842
	1/4"	7/16"	5/16"	28	5.00	14.6	3.55	6	63	4	966654	966843
N°10				24	3.40	11.1	1.90	4	55	3	960395	960629
N°12	5/16"			24	4.10	12.6	2.70	6	57	4	960396	960360
1/4"			5/16"	20	4.70	14.6	2.90	6	57	4	960397	960631
5/16"	9/16"			18	6.10	18.2	4.00	8	63	6	960398	960635
3/8"			7/16"	16	7.50	21.9	5.30	8	63	6	960399	960636
7/16"	7/8"			14	8.70	25.6	6.20	10	75	6	960400	960637
1/2"				13	10.00	29.2	7.30	12	75	6	960402	960638

DIXI 1736

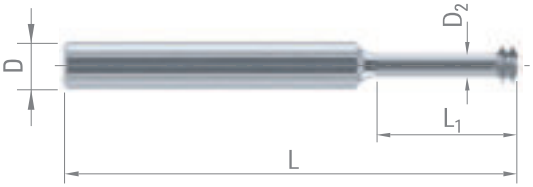
OUTILS À TOURBILLONNER PROFIL COMPLET

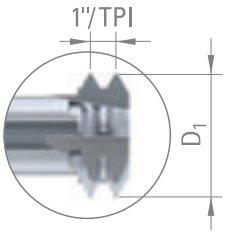
Z = 3-6

P. 318 P. 320

UN 60°

L_1 = 3 x Ø nom.





Acier + Pb	Acier faibl. allié	Acier fort. allié	Acier inox aust.	Fontes
Super alliages Ni / Co	Titane, alliage de titane	Alliage Cu Argent Or	Alliage Cu difficile	Alu
Graphite	Plastique			

UNC	UNF	UNEF	UN	TPI	D_1	L_1	D_2	D_{h5}	L	Z	CARBURE	TiAlN
	N°1			72	1.40	6.0	0.85	3	38	3	966653	966852
N°1	N°2			64	1.40	6.0	0.80	3	38	3	966652	966851
N°2	N°3			56	1.65	7.0	0.95	3	38	3	966651	966850
N°3	N°4			48	1.90	8.1	1.10	3	38	3	966650	966849
	N°5			44	2.00	10.2	1.15	3	42	3	966649	966848
N°4				40	2.10	9.1	1.17	4	42	3	966648	966847
N°5	N°6			40	2.45	10.2	1.52	4	42	3	966647	966846
	N°8			36	3.30	13.4	2.15	4	42	3	966646	966845
N°6				32	2.55	11.3	1.30	4	42	3	966645	966844
N°8	N°10	N°12		32	3.10	13.4	1.90	4	55	3	961020	961062
	N°12	7/16"	5/16"	28	4.20	17.6	2.85	6	63	3	966644	966643
	1/4"	7/16"	5/16"	28	5.00	20.3	3.55	6	63	4	966641	966642
N°10				24	3.40	15.5	1.90	4	55	3	961052	961063
N°12	5/16"	9/16"		24	4.10	17.6	2.70	6	57	4	961053	961082
1/4"	1/2"		5/16"	20	4.70	20.3	2.90	6	63	4	961054	961085
5/16"	9/16"			18	6.10	25.4	4.00	8	75	6	961055	961086
3/8"	3/4"		7/16"	16	7.50	30.5	5.30	8	75	6	961056	961087
7/16"	7/8"			14	8.70	35.5	6.20	10	86	6	961057	961088
1/2"				13	10.00	40.6	7.30	12	93	6	961058	961060

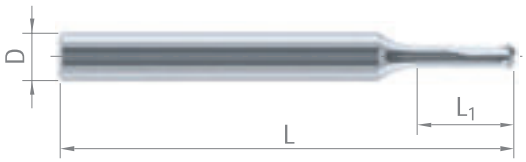
DIXI 1740

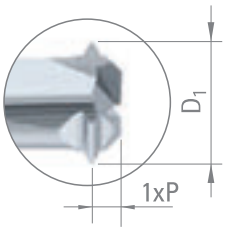
TOURBILLONNEURS-PERCEURS

Z = 1-3

P. 318 P. 322

ISO 60°

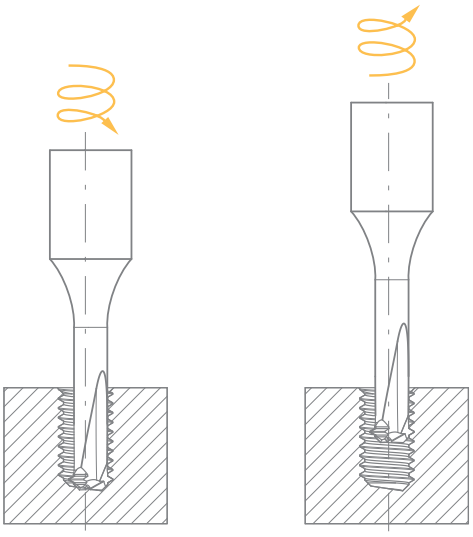




Acier + Pb	Acier faibl. allié	Acier fort. allié	Acier inox aust.	Fontes	
Super alliages Ni / Co	Titane, alliage de titane	Alliage Cu Argent Or	Alliage Cu difficile	Alu	
Graphite	Plastique				

D nom.	Pas	D_1	L_1	D_{h5}	L	Z	CARBURE	CUTINOX
S 0.80	0.20	0.60	2.4	3	38	1	977703	977716
S 0.90	0.225	0.66	2.7	3	38	1	977704	977717
M 1.00	0.20	0.80	3.0	3	38	1	985121	985134
M 1.00	0.25	0.73	3.0	3	38	1	977656	977698
M 1.20	0.20	1.00	3.6	3	38	1	985136	985143
M 1.20	0.25	0.92	3.6	3	38	1	977705	977718
M 1.40	0.20	1.20	4.2	3	38	1	985144	985145
M 1.40	0.30	1.05	4.2	3	38	1	977706	977719
M 1.60	0.35	1.21	4.8	3	38	1	977707	977720
M 2.00	0.40	1.55	6.0	3	38	2	977708	977721
M 2.50	0.45	2.00	7.5	3	38	2	977709	977722
M 3.00	0.50	2.44	9.0	6	57	2	977710	977723
M 4.00	0.70	3.20	12.0	6	57	2	977711	977724
M 5.00	0.80	4.00	15.0	6	57	2	977712	977725
M 6.00	1.00	4.85	18.0	6	57	3	977713	977726
M 8.00	1.25	6.50	24.0	8	75	3	977714	977727
M 10.00	1.50	7.90	30.0	8	75	3	977715	977728

Exemple pour usinage de matières difficiles (titane, acier inox).
Pour les matières faciles à usiner, l'opération n° 2 n'est pas nécessaire.



❶ Plongée en spirale au Ø d'ébauche (Ø fini -2%)

❷ Usinage au Ø fini du filetage en remontant

DIXI 1742

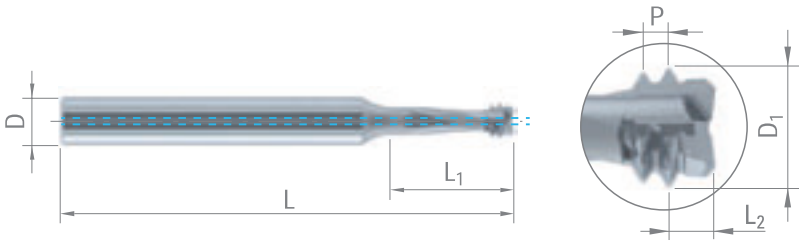
TOURBILLONNEURS-PERCEURS
À TROU DE LUBRIFICATION

Z = 2

P. 318 P. 324

ISO 60°

Alliage Cu Argent Or | Alliage Cu difficile | Alu | Graphite | Plastique



D nom.	Pas	D_1	L_1	L_2	D_{h5}	L	DAC
M 5.00	0.80	4.00	12.5	1.50	8	75	303475
M 6.00	1.00	4.80	15.0	1.85	8	75	303476
M 8.00	1.25	6.40	20.0	2.30	8	75	303477
M 10.00	1.50	7.80	25.0	2.75	8	75	303478

DIXI 1744

TOURBILLONNEURS-PERCEURS
À TROU DE LUBRIFICATION

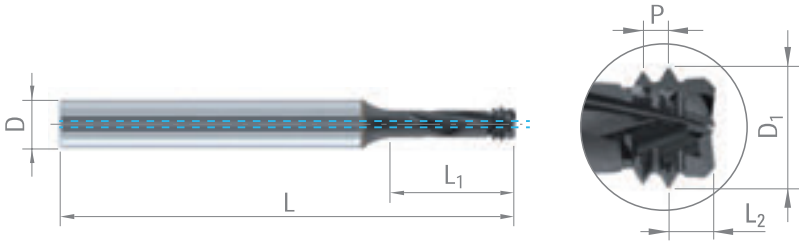
Z = 4

P. 318 P. 324

ISO 60°

Acier + Pb | Acier faibl. allié | Acier fort. allié | Acier inox aust. | Fontes

Super alliages Ni / Co | Titane, alliage de titane



D nom.	Pas	D_1	L_1	L_2	D_{h5}	L	CUTINOX
M 5.00	0.80	4.00	12.5	1.50	8	75	303479
M 6.00	1.00	4.80	15.0	1.85	8	75	303480
M 8.00	1.25	6.40	20.0	2.30	8	75	303481
M 10.00	1.50	7.80	25.0	2.75	8	75	303482

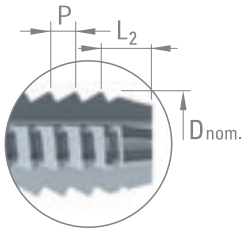
DIXI 1712-AF/BT

MICRO-TARAUDS COUPANTS
PROFIL AUTOFREIN AF/BT

Z = 3

P. 317

DIXI NORM



Acier + Pb | Alliage Cu Argent Or

D nom.	Pas	Ø perç.	L_1	L_2	D_{h5}	L	CARBURE
S 0.70	0.175	0.59	3.0	0.35	1.5	30	995574
S 0.80	0.20	0.68	3.5	0.40	1.5	30	995676
S 0.90	0.225	0.76	4.0	0.45	1.5	30	995677
M 1.00	0.25	0.84	4.0	0.50	1.5	30	995678
M 1.20	0.25	1.04	5.0	0.50	1.5	30	995679
M 1.40	0.30	1.21	5.0	0.60	1.5	30	995680

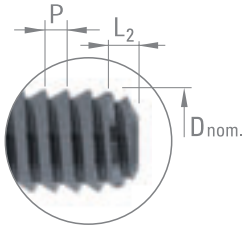
n Vitesse de rotation [tr/min] **500 - 2500**

DIXI 1716-AF/BT

MICRO-TARAUDS À REFOULER
PROFIL AUTOFREIN AF/BT

P. 317

DIXI NORM



Acier + Pb | Alliage Cu Argent Or | Alliage Cu difficile | Alu

D nom.	Pas	Ø perç.	L_1	L_2	D_{h5}	L	DI-TOP
S 0.70	0.175	0.65	2.8	0.35	1.5	30	995723
S 0.80	0.20	0.74	3.2	0.40	1.5	30	995745
S 0.90	0.225	0.83	3.6	0.45	1.5	30	995746
M 1.00	0.25	0.92	4.0	0.50	1.5	30	995747
M 1.20	0.25	1.12	4.8	0.50	1.5	30	995748
M 1.40	0.30	1.31	5.6	0.60	1.0	30	995749

n Vitesse de rotation [tr/min] **500 - 2500**

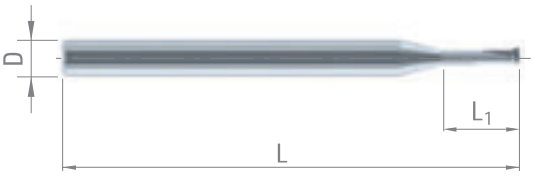
DIXI 1738-AF/BT

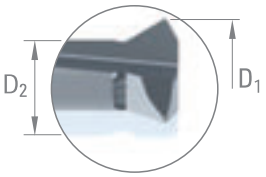
OUTILS À TOURBILLONNER
PROFIL PARTIEL
PROFIL AUTOFREIN AF/BT

Z = 3

P. 317 P. 320

DIXI NORM





Acier + Pb	Acier faibl. allié	Acier fort. allié	Acier inox aust.	Super alliages Ni / Co
Titane, alliage de titane	Alliage Cu Argent Or	Alliage Cu difficile	Alu	Plastique

D nom.	Pas	Ø perç.	D_1	L_1	D_2	D_{h5}	L	CARBURE
S 0.70	0.175	0.59	0.54	1.8	0.34	3	38	995725
S 0.80	0.20	0.68	0.62	2.3	0.39	3	38	995880
S 0.90	0.225	0.76	0.70	2.5	0.44	3	38	995881
M 1.00	0.25	0.84	0.80	2.8	0.51	3	38	995882
M 1.20	0.25	1.04	0.98	3.4	0.69	3	38	995883
M 1.40	0.30	1.21	1.12	4.0	0.77	3	38	995884
M 1.60	0.35	1.38	1.26	4.5	0.86	3	38	995885
M 2.00	0.40	1.75	1.60	5.6	1.14	3	38	995886
M 2.20	0.45	1.91	1.70	6.2	1.18	3	38	995887
M 3.00	0.50	2.68	2.40	8.4	1.82	3	38	995888

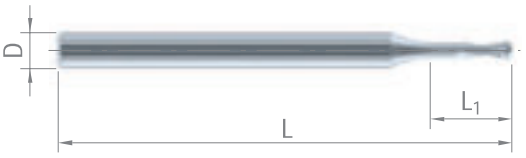
DIXI 1740-AF/BT

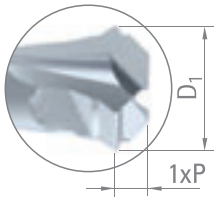
TOURBILLONNEURS-PERCEURS
PROFIL AUTOFREIN AF/BT

Z = 1-2

P. 317 P. 322

DIXI NORM





Acier + Pb	Acier faibl. allié	Aciers fort. allié	Acier inox aust.	Fontes	
Super alliages Ni / Co	Titane, alliage de titane	Alliage Cu Argent Or	Alliage Cu difficile	Alu	
Graphite	Plastique				

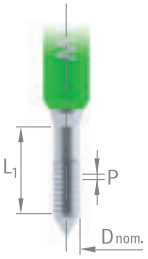
D nom.	Pas	D_1	L_1	D_{h5}	L	Z	CARBURE
S 0.80	0.20	0.60	2.4	3	38	1	300295
S 0.90	0.225	0.66	2.7	3	38	1	300435
M 1.00	0.25	0.73	3.0	3	38	1	300436
M 1.20	0.25	0.92	3.6	3	38	1	300437
M 1.40	0.30	1.05	4.2	3	38	1	300438
M 1.60	0.35	1.21	4.8	3	38	1	300439
M 2.00	0.40	1.55	6.0	3	38	2	300440
M 2.20	0.45	1.70	6.6	3	38	2	300441
M 2.50	0.45	2.00	7.5	3	38	2	300444
M 3.00	0.50	2.44	9.0	6	57	2	300445

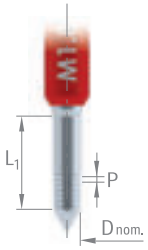
DIXI 1718-AF/BT - DIXI 1719-AF/BT

JAUGES FILETÉES
"GO" - "NO GO"
PROFIL AUTOFREIN AF/BT

P. 317

DIXI NORM



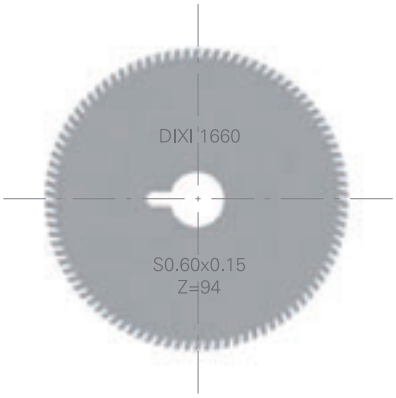


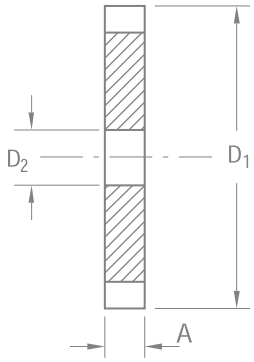
D nom.	Pas	L_1	1718-AF/BT GO	1719-AF/BT NO GO
S 0.70	0.175	3.0	995572	995573
S 0.80	0.20	3.5	995615	995664
S 0.90	0.225	4.0	995616	995665
M 1.00	0.25	4.0	995617	995666
M 1.20	0.25	5.0	995619	995667
M 1.40	0.30	5.0	995620	995668
M 1.60	0.35	6.0	995621	995669
M 1.80	0.35	6.0	995622	995670
M 2.00	0.40	6.0	995623	995671
M 2.20	0.45	8.0	995624	995672
M 2.50	0.45	8.0	995631	995674
M 3.00	0.50	8.0	995626	995675

FRAISES À FILETER PAR POLYGONAGE POUR VIS HORLOGÈRES NIHS

Z = 94

NIHS 06



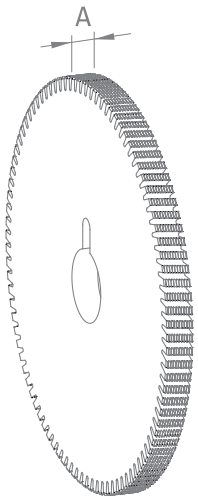


Acier + Pb | Acier faibl. allié | Acier fort. allié | Acier inox aust. | Titane, alliage de titane

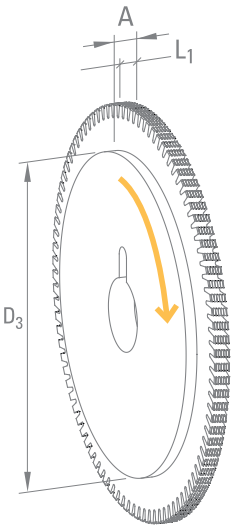
Alliage Cu Argent Or | Alliage Cu difficile

D nom.	Pas	$D_{1\ \pm 0.03}$	$D_{2\ h5}$	A	L_1	D_3	Réf.	CARBURE
S 0.40	0.10	45	8	3	1.00	35	B	301926
					1.00	35	C	301927
S 0.50	0.125	45	8	3	1.10	35	B	301928
					1.10	35	C	301929
S 0.60	0.15	45	8	3	1.35	35	B	301930
					1.35	35	C	301305
					3.00	-	A	301931
S 0.70	0.175	45	8	3	1.60	35	B	301932
					1.60	35	C	301943
					3.00	-	A	301945
S 0.80	0.20	45	8	3	1.80	35	B	301946
					1.80	35	C	301947
					3.00	-	A	301948
S 0.90	0.225	45	8	3	2.00	35	B	301949
					2.00	35	C	301950
					3.00	-	A	301951
S 1.00	0.25	45	8	3	3.00	-	A	301952
S 1.40	0.30	45	8	3	3.00	-	A	301953

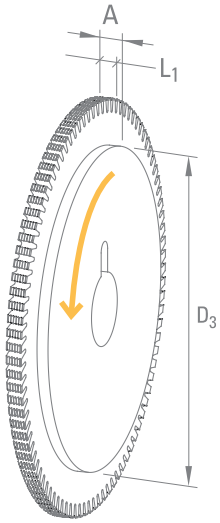
Réf. A

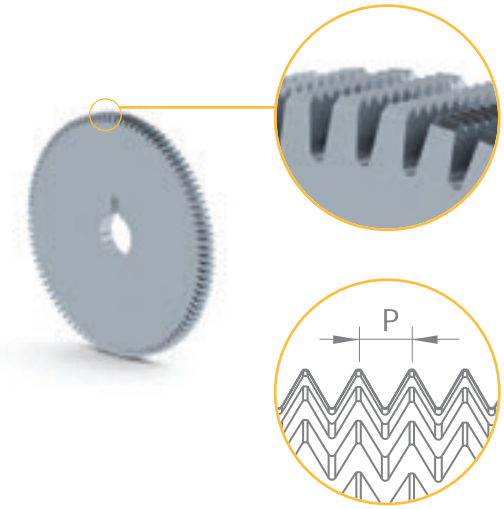


Réf. B



Réf. C





DIXI 7910

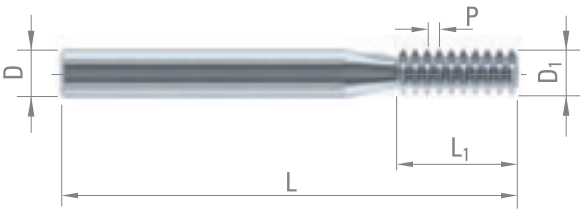
FRAISES À FILETER

Z = 2-4

P. 318 P. 326

ISO 60°

Acier + Pb	Acier faibl. allié	Acier fort. allié	Acier inox aust.	Fontes
Titane, alliage de titane	Alliage Cu Argent Or	Alliage Cu difficile	Alu	Plastique



D nom.	Pas	D_1	L_1	D_{h5}	L	Z	CARBURE	TiAlN
M 1.4	0.30	0.90	2.10	3	38	2	41565	56990
M 1.6	0.35	1.00	2.45	3	38	2	41566	56991
M 2.0	0.40	1.30	3.20	3	38	2	41568	56993
M 2.3	0.40	1.50	3.20	3	38	2	41569	56994
M 2.5	0.35	1.30	2.80	3	38	2	41567	56992
M 2.5	0.45	1.50	3.60	3	38	2	41570	56995
M 3.0	0.50	2.10	4.50	3	38	3	41571	56996
M 4.0	0.50	2.60	5.50	3	38	3	41572	56997
M 4.0	0.70	2.60	6.30	3	38	3	41573	56998
M 4.5	0.75	3.00	6.75	4	42	3	41574	56999
M 5.0	0.80	3.60	8.00	4	42	3	41576	57001
M 6.0	1.00	4.00	9.00	6	57	3	42578	55510
M 8.0	0.75	5.90	15.00	6	57	3	42577	57000
M 8.0	1.25	5.00	12.50	6	57	3	42579	57003
M 10.0	1.50	5.90	15.00	6	57	3	42580	57004
M 12.0	1.00	7.90	20.00	8	63	4	42554	57002
M 12.0	1.75	7.90	19.25	8	63	4	42590	57007
M 14.0	1.50	9.90	24.00	10	72	4	42561	57005
M 14.0	2.00	9.90	24.00	10	72	4	42591	57008
M 18.0	1.50	11.90	30.00	12	83	4	42589	57006
M 18.0	2.00	11.90	30.00	12	83	4	42592	57009
M 18.0	2.50	11.90	30.00	12	83	4	42593	57010
M 24.0	3.00	15.90	36.00	16	92	4	42594	

DIXI 7910 E = Extérieur

D nom.	Pas	D_1	L_1	D_{h5}	L	Z	CARBURE	TiAlN
M 3.0	0.50	5.90	15.00	6	57	3	42597	57013
M 4.5	0.75	7.90	19.50	8	63	4	42598	57014
M 6.0	1.00	9.90	24.00	10	72	4	41471	57015
M 10.0	1.50	11.90	30.00	12	83	4	41472	57016
M 14.0	2.00	11.90	30.00	12	83	4	41473	57017

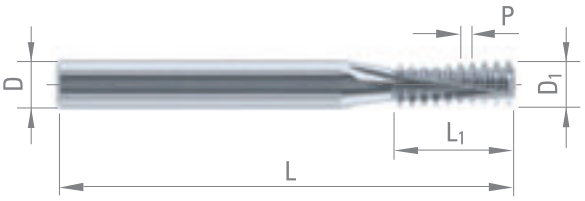
DIXI 7908

FRAISES À FILETER HÉLICOÏDALES

Z = 3-6

P. 318 P. 328

ISO 60°



Acier + Pb	Acier faibl. allié	Acier fort. allié	Acier inox aust.	Fontes
Titane, alliage de titane	Alliage Cu Argent Or	Alliage Cu difficile	Alu	Plastique

D nom.	Pas	D_1	L_1	D_{h5}	L	Z	CARBURE	TiAlN
M 2.0	0.40	1.30	3.20	3	38	3	67417	952932
M 2.3	0.40	1.50	3.20	3	38	3	951593	952933
M 2.5	0.45	1.50	3.60	3	38	3	67419	952937
M 3.0	0.50	2.10	4.50	3	38	3	67420	952938
M 4.0	0.50	2.60	5.50	3	38	3	951594	952939
M 4.0	0.70	2.60	6.30	3	38	3	67452	952940
M 4.5	0.75	3.00	6.75	4	42	3	67453	952941
M 5.0	0.80	3.60	8.00	4	42	3	67454	952942
M 6.0	1.00	4.00	9.00	6	57	3	67455	952013
M 8.0	0.75	5.90	15.00	6	57	5	67461	952944
M 8.0	1.25	5.00	12.50	6	57	3	67274	952014
M 10.0	1.50	5.90	15.00	6	57	5	67456	952015
M 12.0	0.50	9.90	10.00	10	50	5	957036	957037
M 12.0	1.00	7.90	20.00	8	63	5	67462	952946
M 12.0	1.75	7.90	19.25	8	63	5	67457	952016
M 14.0	1.50	9.90	24.00	10	72	5	67463	952948
M 14.0	2.00	9.90	24.00	10	72	5	67459	952949
M 18.0	1.50	11.90	30.00	12	83	5	67464	952951
M 18.0	2.00	11.90	30.00	12	83	5	67465	952956
M 18.0	2.50	11.90	30.00	12	83	5	67458	952851
M 24.0	3.00	15.90	36.00	16	92	6	67460	952953

DIXI 7908 E = Extérieur

D nom.	Pas	D_1	L_1	D_{h5}	L	Z	CARBURE	TiAlN
M 3.0	0.50	5.90	15.00	6	57	5	67466	952943
M 4.5	0.75	7.90	19.50	8	63	5	67467	952945
M 6.0	1.00	9.90	24.00	10	72	5	67468	952947
M 10.0	1.50	11.90	30.00	12	83	5	67469	952950
M 14.0	2.00	11.90	30.00	12	83	5	67470	952952

DIXI 7913

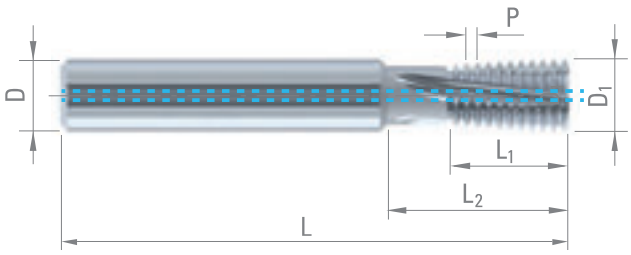
FRAISES À FILETER ISO, PAS FIN
À TROU DE LUBRIFICATION

Z = 4-5

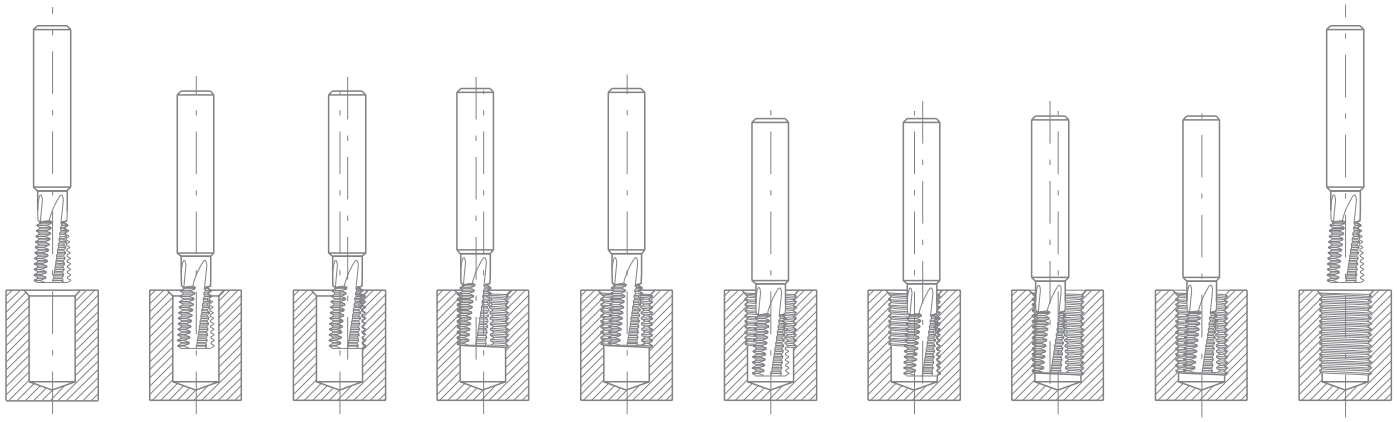
P. 318 P. 328

ISO 60°

Acier + Pb	Acier faibl. allié	Acier fort. allié	Acier inox aust.	Fontes
Titane, alliage de titane	Alliage Cu Argent Or	Alliage Cu difficile	Alu	Plastique



Pas	D nom.	D_1	L_1	L_2	D_{h5}	L	Z	CARBURE	CUTINOX
0.50	M 10	7.95	16	-	8	64	4	303435	303455
	M 14	11.95	20	31	12	80	4	303436	303456
0.75	M 10	7.95	16	-	8	64	4	303437	303457
	M 12	9.95	16	25	10	70	4	303438	303458
	M 14	11.95	20	31	12	80	4	303439	303459
1.00	M 12	9.95	16	25	10	70	4	303440	303460
	M 16	11.95	20	31	12	80	4	303441	303461
	M 20	15.95	25	40	16	90	5	303442	303462
	M 24	19.95	33	50	20	105	5	303443	303463
1.25	M 14	9.95	16	25	10	70	4	303444	303464
	M 16	11.95	20	31	12	80	4	303445	303465
1.50	M 14	9.95	16	25	10	70	4	303446	303466
	M 16	11.95	20	31	12	80	4	303447	303467
	M 22	15.95	25	40	16	90	5	303448	303468
	M 26	19.95	33	50	20	105	5	303449	303469
2.00	M 16	11.95	20	31	12	80	4	303450	303470
	M 22	15.95	25	40	16	90	5	303451	303471
	M 27	19.95	33	50	20	105	5	303452	303472
2.50	M 22	15.95	25	40	16	90	5	303453	303473
	M 30	19.95	33	50	20	105	5	303454	303474



❶ ❷ ❸ ❹ ❺ ❻ ❼ ❽ ❾ ❿

DIXI 7920

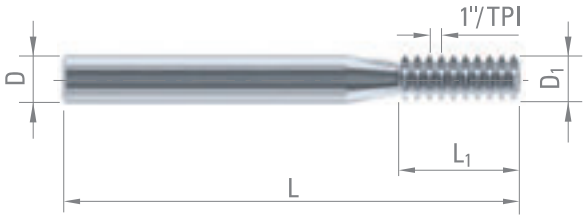
FRAISES À FILETER

Z = 2-4

P. 318 P. 326

UN 60°

Acier + Pb	Acier faibl. allié	Acier fort. allié	Acier inox aust.	Fontes
Titane, alliage de titane	Alliage Cu Argent Or	Alliage Cu difficile	Alu	Plastique



UNC	UNF	UNEF	UN	TPI	D_1	L_1	D_{h5}	L	Z	CARBURE	TiAlN
N°2	N°3			56	1.50	3.17	3	38	2	41581	953797
N°3	N°4			48	1.50	3.17	3	38	2	39808	953796
N°5	N°6			40	2.10	4.44	3	38	3	41582	953798
	N°8			36	3.00	6.35	4	42	3	39811	953799
N°8	N°10	N°12		32	3.00	6.35	4	42	3	41583	65997
		5/16"	7/16"	32	5.90	14.28	6	57	3	39813	953806
	N°12		5/16"	28	3.60	8.16	4	42	3	41584	64133
		7/16"	9/16"	28	7.90	19.95	8	63	4	39815	953812
N°12	5/16"			24	4.00	8.46	6	57	3	41585	953802
1/4"			5/16"	20	4.00	10.16	6	57	3	42599	953800
	1/2"	3/4 "	9/16"	20	9.90	22.86	10	72	4	41475	953819
5/16"				18	5.00	12.70	6	57	3	41587	953803
	9/16"			18	9.90	23.98	10	72	4	41476	953817
3/8"			7/16"	16	5.90	14.28	6	57	3	42600	953804
			5/8"	16	11.90	28.57	12	83	4	42601	63605
7/16"				14	7.90	16.33	8	63	4	41478	953808
1/2"				13	7.90	19.53	8	63	4	39824	953807
9/16"			5/8"	12	9.90	23.28	10	72	4	39825	953815
	1"		1-1/16"	12	11.90	29.63	12	83	4	39826	63606
5/8"				11	9.90	23.09	10	72	4	39827	953814
3/4"				10	11.90	27.94	12	83	4	39828	953820

DIXI 7920 E = Extérieur

D nom.	TPI	D_1	L_1	D_{h5}	L	Z	CARBURE	TiAlN
UNC N°6	32	5.90	14.28	6	57	3	39850	953805
UNF N°12	28	7.90	19.95	8	63	4	39851	953810
UNC 1/4"	20	9.90	22.86	10	72	4	39852	953818
UNC 5/16"	18	9.90	23.98	10	72	4	39853	953816
UNC 3/8"	16	11.90	28.57	12	83	4	39854	953822
UNC 9/16"	12	11.90	29.63	12	83	4	39855	953821

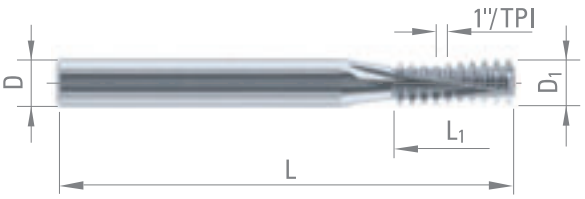
DIXI 7918

FRAISES À FILETER HÉLICOÏDALES

Z = 3-5

P. 318 P. 328

UN 60°



Acier + Pb	Acier faibl. allié	Acier fort. allié	Acier inox aust.	Fontes
Titane, alliage de titane	Alliage Cu Argent Or	Alliage Cu difficile	Alu	Plastique

UNC	UNF	UNEF	UN	TPI	D_1	L_1	D_{h5}	L	Z	CARBURE	TiAlN
	N°2			64	1.50	3.17	3	38	3	951595	952964
N°2	N°3			56	1.50	3.17	3	38	3	67489	952963
N°3	N°4			48	1.50	3.17	3	38	3	67490	952962
	N°5			44	2.10	4.62	3	38	3	951482	952966
N°5	N°6			40	2.10	4.44	3	38	3	67491	952965
	N°8			36	3.00	6.35	4	42	3	67492	952968
N°8	N°10	N°12		32	3.00	6.35	4	42	3	67493	952967
		5/16"	7/16"	32	5.90	14.28	6	57	5	67497	952975
	N°12		5/16"	28	3.60	8.16	4	42	3	67494	952969
		7/16"	9/16"	28	7.90	19.95	8	63	5	67498	952979
N°12	5/16"	5/8"		24	4.00	8.46	6	57	3	67495	952971
1/4"			5/16"	20	4.00	10.16	6	57	3	67496	952970
	1/2"	3/4"	9/16"	20	9.90	22.86	10	72	5	67499	952985
5/16"				18	5.00	12.70	6	57	3	67500	952972
	9/16"			18	9.90	23.98	10	72	5	67501	952983
3/8"			7/16"	16	5.90	14.28	6	57	5	67502	952973
			5/8"	16	11.90	28.57	12	83	5	67503	952990
7/16"				14	7.90	16.33	8	63	5	67504	952977
1/2"				13	7.90	19.53	8	63	5	67505	952976
9/16"				12	9.90	23.28	10	72	5	67512	952981
	1"		1-1/16"	12	11.90	29.63	12	83	5	67506	952988
5/8"				11	9.90	23.09	10	72	5	951597	952980
3/4"				10	11.90	27.94	12	83	5	951667	952986

DIXI 7918 E = Extérieur

D nom.	TPI	D_1	L_1	D_{h5}	L	Z	CARBURE	TiAlN
UNC N°6	32	5.90	14.28	6	57	5	67507	952974
UNF N°12	28	7.90	19.95	8	63	5	67508	952978
UNC 1/4"	20	9.90	22.86	10	72	5	67509	952984
UNC 5/16"	18	9.90	23.98	10	72	5	67510	952982
UNC 3/8"	16	11.90	28.57	12	83	5	67511	952989
UNC 9/16"	12	11.90	29.63	12	83	5	951668	952987

DIXI 7923

FRAISES À FILETER HÉLICOÏDALES
À TROU DE LUBRIFICATION

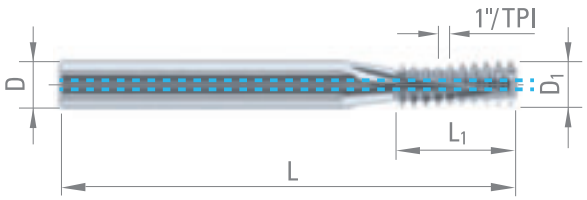
L_1 = 2 x Ø nom.

Z = 3-4

P. 319 P. 328

UNJ 60°

Acier + Pb	Acier faibl. allié	Acier fort. allié	Acier inox aust.	Fontes
Titane, alliage de titane	Alliage Cu Argent Or	Alliage Cu difficile	Alu	Plastique



UNJF	TPI	D_1	L_1	D_{h5}	L	Z	CARBURE
N°10	32	3.90	11.50	6	54	3	303381
1/4''	28	5.20	14.00	6	54	3	303382
5/16''	24	5.95	17.40	6	54	3	303383
3/8''	24	7.95	20.60	8	64	4	303384
7/16''	20	7.95	24.70	8	64	4	303385
1/2''	20	9.95	27.30	10	74	4	303386

DIXI 7940

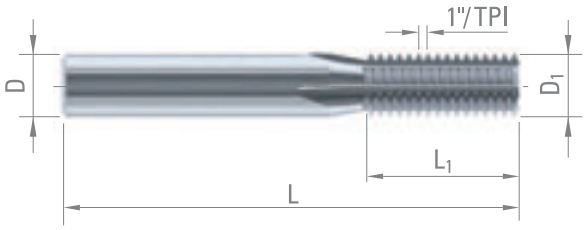
FRAISES À FILETER

Z = 3-4

P. 319 P. 326

BSP 55°

Acier + Pb	Acier faibl. allié	Acier fort. allié	Acier inox aust.	Fontes
Titane, alliage de titane	Alliage Cu Argent Or	Alliage Cu difficile	Alu	Plastique



BSP	TPI	D_1	L_1	D_{h5}	L	Z	CARBURE
G1/16" – G1/8"	28	5.90	14.51	6	57	3	42603
G1/4" – G3/8"	19	7.90	18.71	8	63	4	42604
G1/2" – G5/8"– G3/4"– G7/8"	14	11.90	29.02	12	83	4	42605
G1"	11	15.90	34.63	16	92	4	42606

Pour filetages intérieurs et extérieurs

DIXI 7946

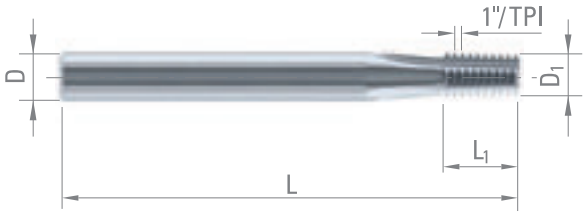
FRAISES À FILETER

Z = 3-4

P. 326

BSPT 55°

Acier + Pb	Acier faibl. allié	Acier fort. allié	Acier inox aust.	Fontes
Titane, alliage de titane	Alliage Cu Argent Or	Alliage Cu difficile	Alu	Plastique



BSPT	TPI	D_1	L_1	D_{h5}	L	Z	CARBURE
R1/16" – R1/8"	28	5.34	9.97	6	57	3	42607
R1/4" – R3/8"	19	7.07	14.70	8	63	4	42608
R1/2" – R5/8" –R3/4" – R7/8"	14	10.77	19.95	12	83	4	41590
R1 " => R2-1/2"	11	14.32	27.70	16	92	4	42610

Pour filetages intérieurs et extérieurs

DIXI 7950

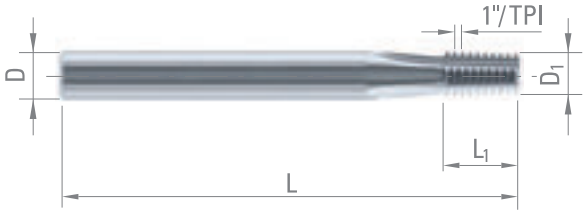
FRAISES À FILETER

Z = 3-4

P. 326

NPT 60°

Acier + Pb	Acier faibl. allié	Acier fort. allié	Acier inox aust.	Fontes
Titane, alliage de titane	Alliage Cu Argent Or	Alliage Cu difficile	Alu	Plastique



NPT	TPI	D_1	L_1	D_{h5}	L	Z	CARBURE
1/16" – 1/8"	27	5.37	9.40	6	57	3	39789
1/4" – 3/8"	18	7.10	14.11	8	63	4	41592
1/2" – 3/4"	14	10.65	19.95	12	83	4	42611
1" – 1-1/4" – 1-1/2" – 2"	11.5	14.38	26.50	16	92	4	39792

Pour filetages intérieurs et extérieurs

DIXI 7956

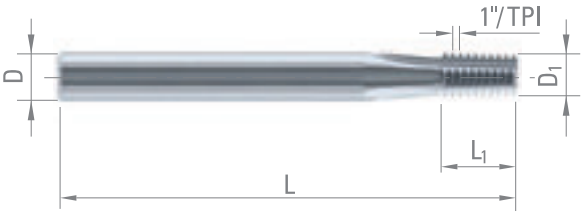
FRAISES À FILETER

Z = 3-4

P. 326

NPTF 60°

Acier + Pb	Acier faibl. allié	Acier fort. allié	Acier inox aust.	Fontes
Titane, alliage de titane	Alliage Cu Argent Or	Alliage Cu difficile	Alu	Plastique



NPTF	TPI	D_1	L_1	D_{h5}	L	Z	CARBURE
1/16" – 1/8"	27	5.37	9.40	6	57	3	39794
1/4" – 3/8"	18	7.10	14.11	8	63	4	39795
1/2" – 3/4"	14	10.65	19.95	12	83	4	39796
1" – 1-1/4" – 1-1/2" – 2"	11.5	14.38	26.50	16	92	4	41591

Pour filetages intérieurs et extérieurs

DIXI 7915

FRAISES À FILETER ET CHANFREINER
À TROU DE LUBRIFICATION

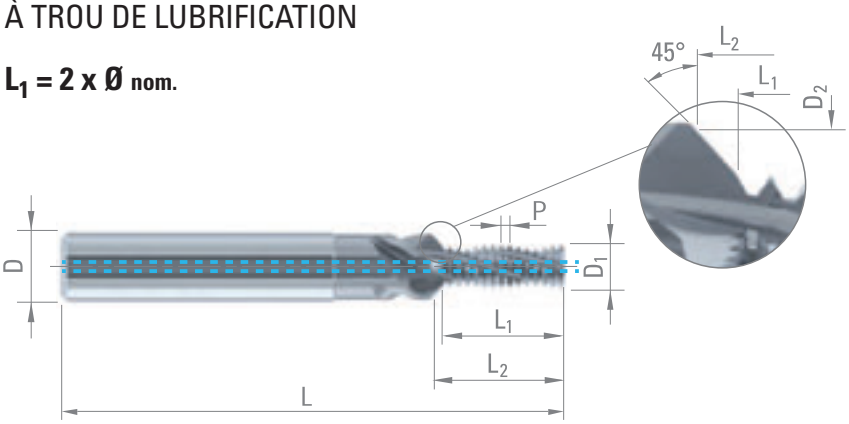
L_1 = 2 x Ø nom.

Z = 3-4

P. 318 P. 328

ISO 60°

Acier + Pb	Acier faibl. allié	Acier fort. allié	Acier inox aust.	Fontes
Titane, alliage de titane	Alliage Cu Argent Or	Alliage Cu difficile	Alu	Plastique

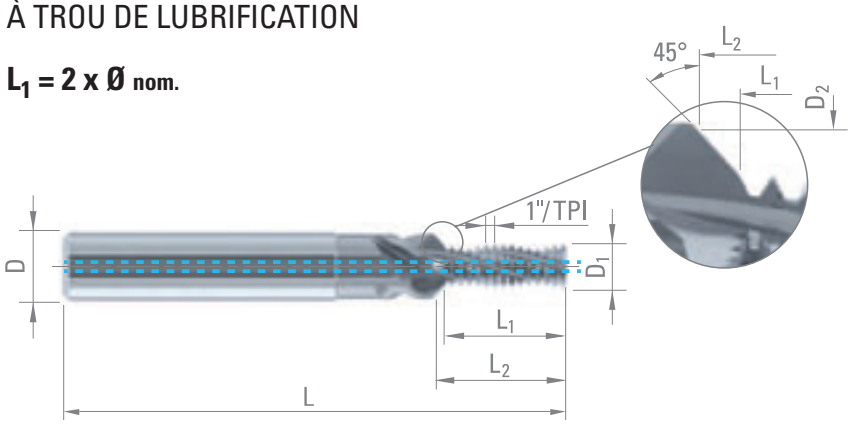


D nom.	Pas	D_1	D_2	L_1	L_2	D_{h5}	L	Z	CARBURE	CUTINOX
M 4.0	0.70	3.10	4.2	8.70	9.3	6	48	3	303387	303394
M 5.0	0.80	3.90	5.3	10.70	11.5	6	54	3	303388	303395
M 6.0	1.00	4.70	6.3	13.40	14.3	8	62	3	303389	303396
M 8.0	1.25	6.40	8.4	18.10	19.1	10	74	3	303390	303397
M 10.0	1.50	8.10	10.5	21.70	22.9	12	80	4	303391	303398
M 12.0	1.75	9.95	12.6	25.30	26.7	14	90	4	303392	303399
M 16.0	2.00	13.40	16.8	34.90	36.6	18	102	4	303393	303400

FRAISES À FILETER ET CHANFREINER À TROU DE LUBRIFICATION

L_1 = 2 x Ø nom.

Z = 3-4

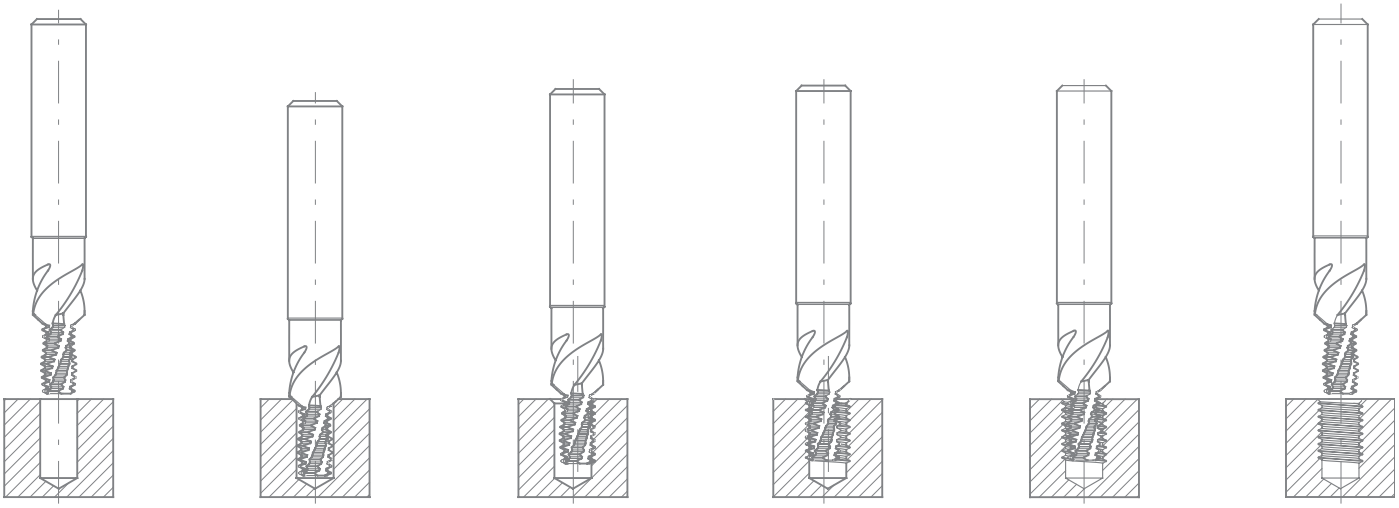


P. 318
P. 328

UN 60°

Acier + Pb	Acier faibl. allié	Acier fort. allié	Acier inox aust.	Fontes
Titane, alliage de titane	Alliage Cu Argent Or	Alliage Cu difficile	Alu	Plastique

UNC	TPI	D_1	D_2	L_1	L_2	D_{h5}	L	Z	CARBURE	CUTINOX
N°8	32	3.10	4.4	9.10	9.7	6	48	3	303401	303411
N°10	24	3.60	5.1	11.00	11.9	6	54	3	303402	303412
N°12	24	4.10	5.8	12.10	13.0	6	54	3	303403	303413
1/4''	20	4.80	6.7	14.50	15.6	8	62	3	303404	303414
5/16''	18	5.95	8.3	17.60	18.7	10	74	3	303405	303415
3/8''	16	7.50	10.0	21.40	22.6	12	80	4	303406	303416
7/16''	14	8.80	11.7	24.40	25.9	12	80	4	303407	303417
1/2''	13	10.30	13.3	28.20	29.8	14	90	4	303408	303418
9/16''	12	10.80	15.0	30.60	32.3	16	102	4	303409	303419
5/8''	11	11.90	16.7	35.70	37.6	18	102	4	303410	303420

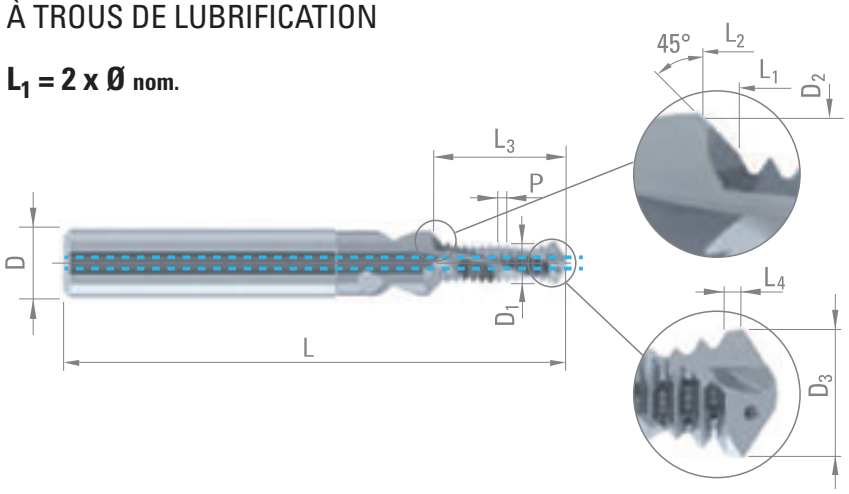


❶ ❷ ❸ ❹ ❺ ❻

FRAISES À PERCER, FILETER ET CHANFREINER À TROUS DE LUBRIFICATION

Z = 2

L_1 = 2 x Ø nom.



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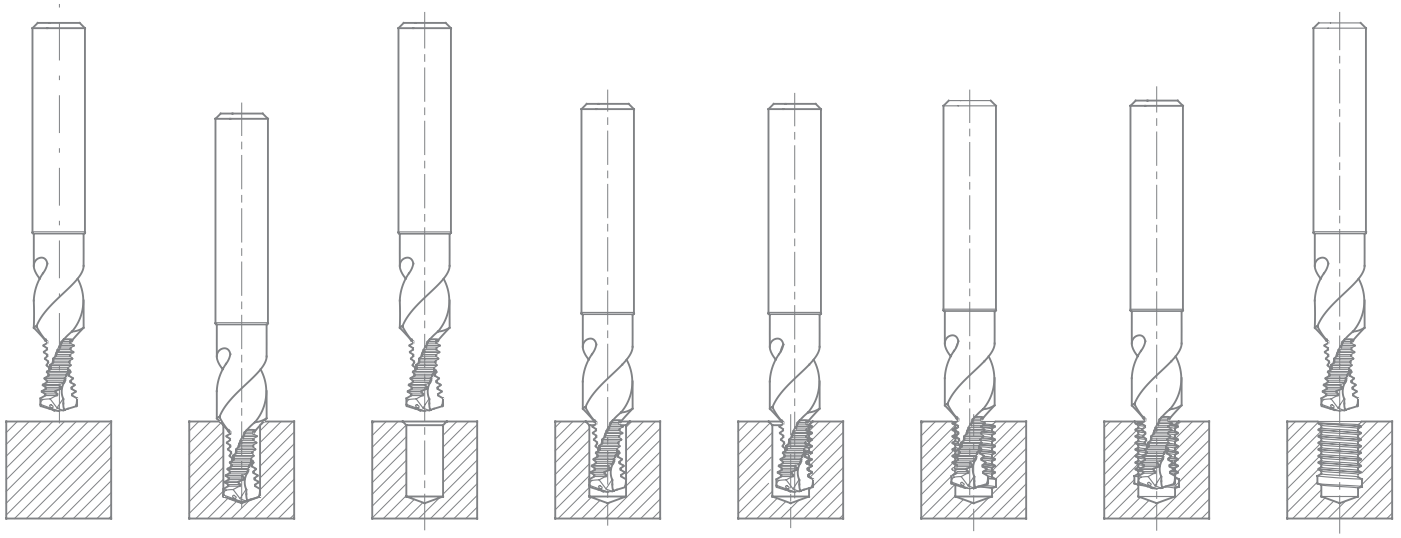
ISO 60°

Fontes	Alliage Cu Argent Or	Alliage Cu difficile	Alu

D nom.	Pas	D_1	D_2	D_3	L_1	L_2	L_3	L_4	D_{h5}	L	CARBURE	CUTINOX
M 4.0	0.70	3.20	4.2	3.30	8.90	8.9	9.5	0.7	6	48	303421	303428
M 5.0	0.80	4.00	5.3	4.20	11.10	11.0	11.8	0.8	6	54	303422	303429
M 6.0	1.00	4.75	6.3	5.00	13.85	13.7	14.6	1.0	8	62	303423	303430
M 8.0	1.25	6.35	8.4	6.75	18.60	18.4	19.6	1.3	10	74	303424	303431
M 10.0	1.50	7.95	10.5	8.50	22.40	22.2	23.7	1.5	12	80	303425	303432
M 12.0	1.75	9.95	12.6	10.25	26.00	25.5	27.4	1.5	14	90	303426	303433
M 16.0	2.00	13.20	16.8	14.00	35.90	35.1	37.6	1.5	18	102	303427	303434



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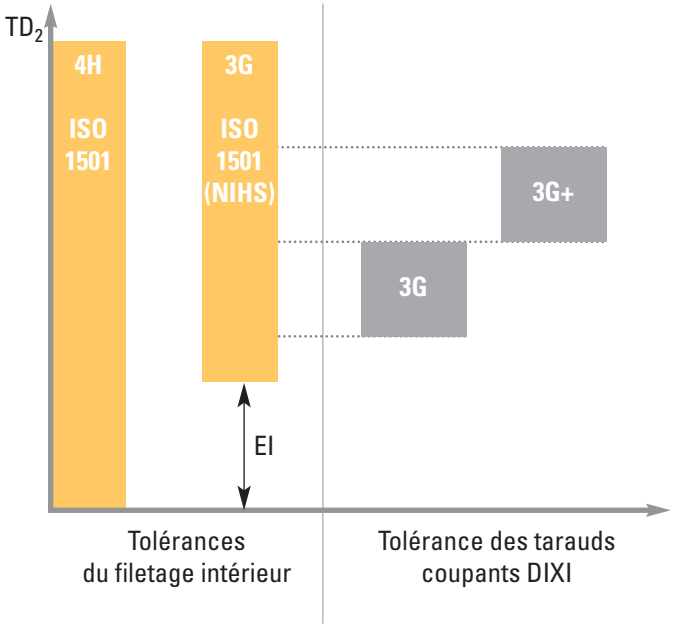
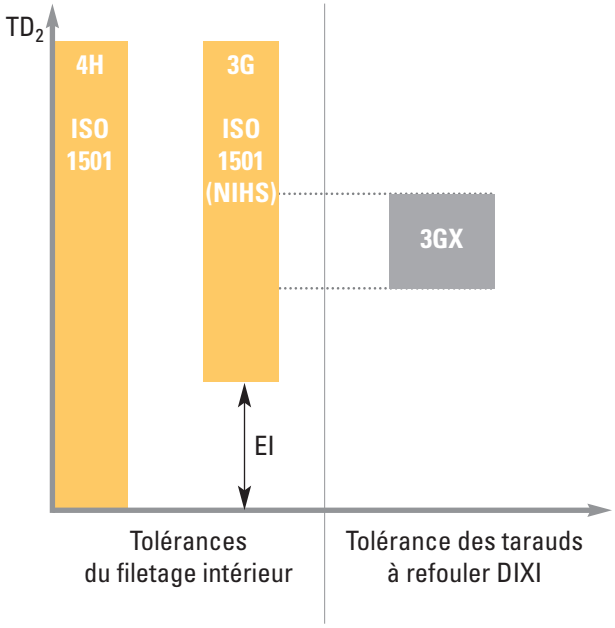
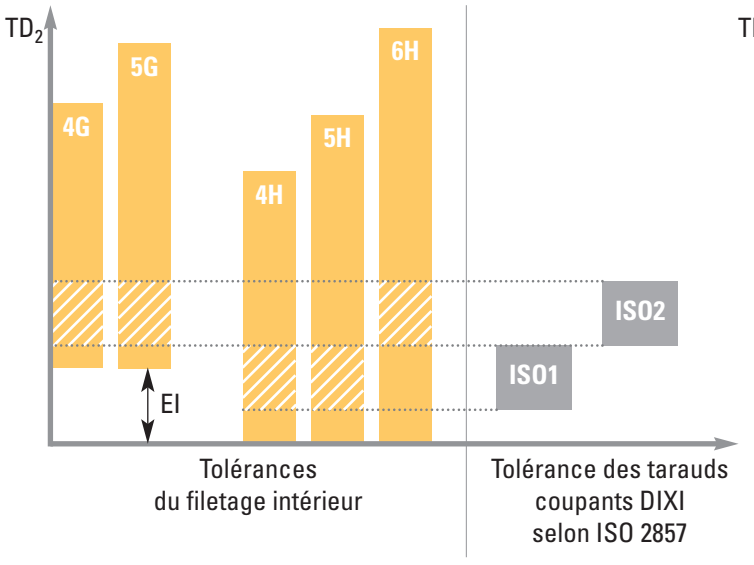
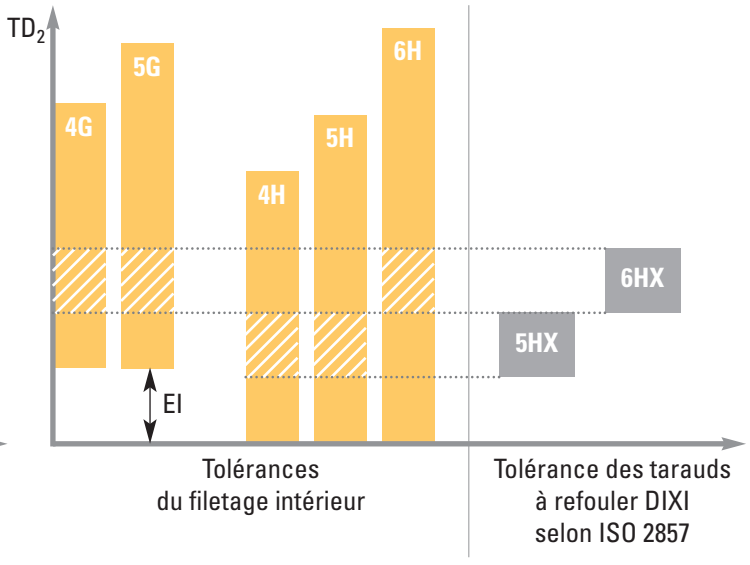
POSITIONNEMENT DES TOLÉRANCES DE DIAMÈTRES SUR FLANCS POUR LES FILETAGES MINIATURES S (ISO 1501 / NIHS 06-05 / DIN 14)



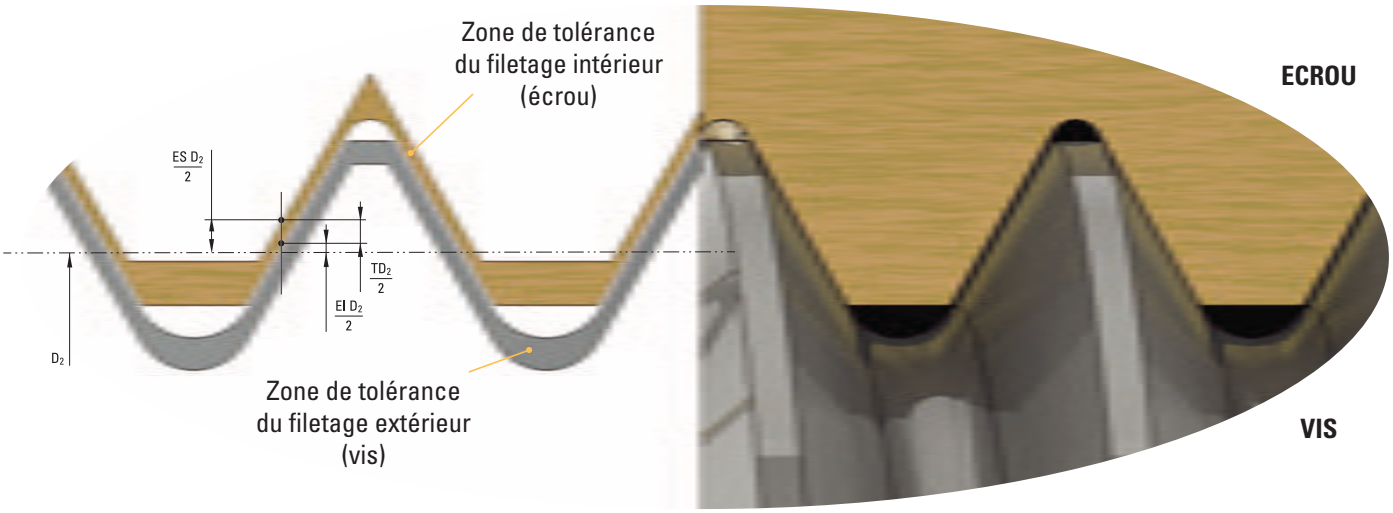


POSITIONNEMENT DES TOLÉRANCES DE DIAMÈTRES SUR FLANCS POUR LES FILETAGES INTÉRIEURS MÉTRIQUES M (ISO 965 / NIHS 06-06 / DIN 13)

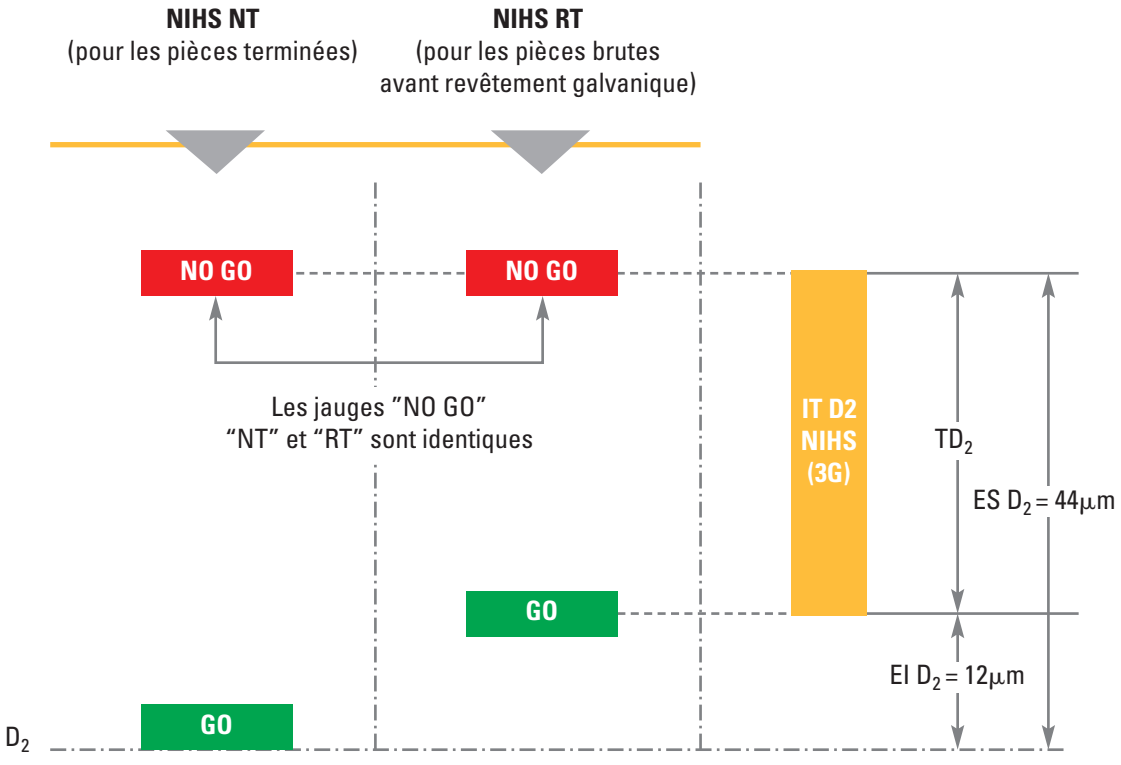




LEXIQUE TECHNIQUE
JAUGES NIHS

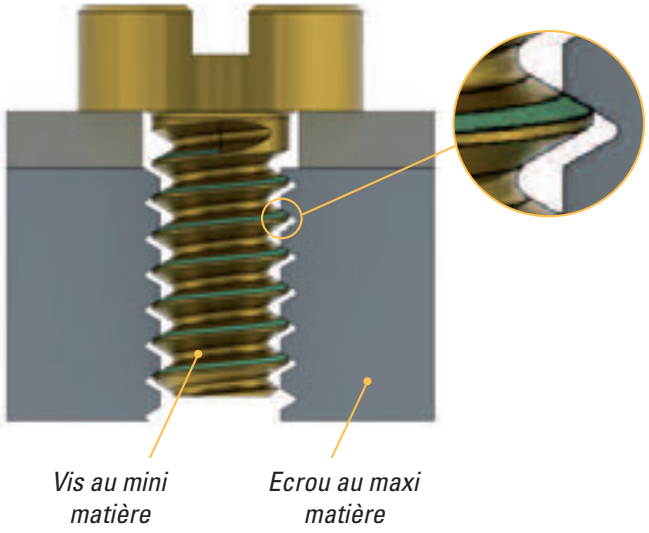


D_2	Diamètre sur flancs.
Ecart EI D_2	Ecart inférieur du diamètre sur flancs D_2.
Ecart ES D_2	Ecart supérieur du diamètre sur flancs D_2.
Tolérance TD_2	Tolérance du diamètre sur flancs D_2. Elle est égale à ES D_2 - EI D_2.
Critère de tolérance NIHS NT	NT est l'abréviation de "Normal Tolerance". Ce critère est utilisé pour le contrôle des taraudages S de pièces terminées (avec ou sans revêtement galvanique).
Critère de tolérance NIHS RT	RT est l'abréviation de "Reduced Tolerance" ou tolérance réduite. Ce critère est utilisé pour le contôle des taraudages S de pièces brutes en production (avant revêtement galvanique).
Jauges NO GO	Les jauges NO GO sont identiques, que ce soit en critère de tolérance NT ou RT. Elles sont utilisées pour le contrôle de pièces brutes (au stade de la production) ou de pièces finies (avec ou sans revêtement galvanique).

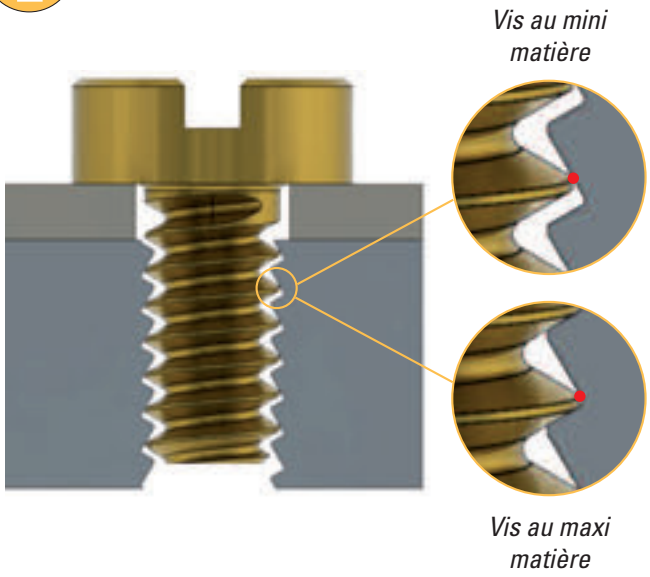


Position des jauges GO et NO GO - Exemple pour un pas de 0.25 mm

FILETAGE AF - AVANTAGES TECHNIQUES



Au jeu des tolérances, sur un assemblage S 1.00x0.25, il peut y avoir jusqu'à 0.05 mm au rayon d'espace libre entre le Ø extérieur de la vis et le Ø extérieur de l'écrou. Tout cet espace laisse un degré de liberté à la vis qui, sous l'effet de vibrations, peut se desserrer. Le phénomène est d'autant plus accentué que la surface de contact théorique entre la vis et l'écrou est faible. Pour éviter les phénomènes de vibrations et ainsi le desserrage, il est possible d'utiliser du frein-filet. Mais cette solution n'est pas appropriée pour les assemblages dont l'aspect visuel a une grande importance (horlogerie, ...).

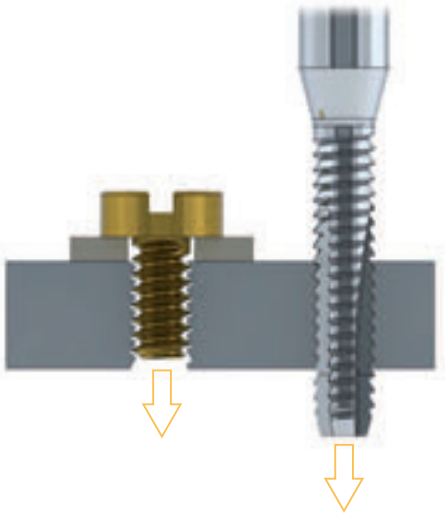


Avec un filetage autofrein AF, que la vis soit au maxi ou au mini matière, le contact entre la vis et l'écrou ne varie pas. Les tolérances de fabrication n'ont donc aucune influence sur la qualité de l'assemblage.

Avec un filetage autofrein AF,
nul besoin d'utiliser de frein filet.

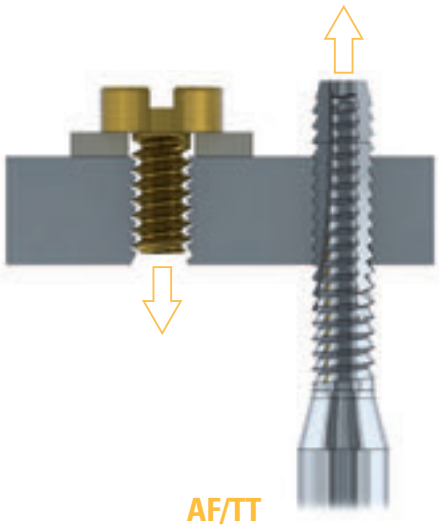
SENS DE PROFIL - SENS DE TRAVAIL

Le profil du filetage AF n'est pas symétrique comme peut l'être un filetage ISO à 60°.
Selon le sens de travail de l'outil, le profil coupant est inversé.



AF/BT

L'outil et la vis entrent dans le même sens de vissage.
OUTILS STOCKÉS



AF/TT

L'outil et la vis entrent dans une direction de vissage inversée.
OUTILS SUR DEMANDE

Ø DE PERÇAGE AVANT TARAUDAGE OU FILETAGE

NIHS 06 (ISO 1501 / DIN 14)

Ø nominal	Pas	Laiton (3G5) Ø noyau min.	Laiton (3G5) Ø noyau max.	Laiton (3G5) Ø perçage	Acier (3G6) Ø noyau min.	Acier (3G6) Ø noyau max.	Acier (3G6) Ø perçage
S 0.30	0.08	0.223	0.240	**0.23**	-	-	-
S 0.35	0.09	0.264	0.286	**0.275**	-	-	-
S 0.40	0.10	0.304	0.330	**0.32**	0.304	0.342	**0.34**
S 0.50	0.125	0.380	0.415	**0.40**	0.380	0.435	**0.42**
S 0.60	0.15	0.456	0.502	**0.48**	0.456	0.522	**0.50**
S 0.70	0.175	0.532	0.585	**0.56**	0.532	0.605	**0.58**
S 0.80	0.20	0.608	0.665	**0.64**	0.608	0.685	**0.66**
S 0.90	0.225	0.684	0.745	**0.72**	0.684	0.765	**0.74**
S 1.00	0.25	0.760	0.825	**0.80**	0.760	0.845	**0.82**
S 1.20	0.25	0.960	1.025	**1.00**	0.960	1.045	**1.02**
S 1.40	0.30	1.112	1.185	**1.15**	1.112	1.205	**1.17**

ISO 965 (DIN 13)

Ø nominal	Pas	Tolérance	Ø noyau min.	Ø noyau max.	Ø perçage
M 0.8	0.20	-	0.608	0.685	**0.65**
M 0.9	0.225	-	0.684	0.765	**0.70**
M 1.0	0.25	5H	0.729	0.785	**0.75**
M 1.1	0.25	5H	0.829	0.885	**0.85**
M 1.2	0.25	5H	0.929	0.985	**0.95**
M 1.4	0.30	6H	1.075	1.142	**1.10**
M 1.6	0.35	6H	1.221	1.321	**1.25**
M 1.7	0.35	6H	1.321	1.421	**1.35**
M 1.8	0.35	6H	1.421	1.521	**1.45**
M 2.0	0.40	6H	1.567	1.679	**1.60**
M 2.2	0.45	6H	1.713	1.838	**1.75**
M 2.5	0.45	6H	2.013	2.138	**2.05**
M 3.0	0.50	6H	2.459	2.599	**2.50**
M 3.5	0.60	6H	2.850	3.010	**2.90**
M 4.0	0.70	6H	3.242	3.422	**3.30**
M 4.5	0.75	6H	3.688	3.878	**3.70**
M 5.0	0.80	6H	4.134	4.334	**4.20**
M 6.0	1.00	6H	4.917	5.153	**5.00**
M 7.0	1.00	6H	5.917	6.153	**6.00**
M 8.0	1.25	6H	6.647	6.912	**6.80**
M 9.0	1.25	6H	7.647	7.912	**7.80**
M 10.0	1.50	6H	8.376	8.676	**8.50**
M 11.0	1.50	6H	9.376	9.676	**9.50**
M 12.0	1.75	6H	10.106	10.441	**10.20**
M 14.0	2.00	6H	11.835	12.210	**12.00**
M 16.0	2.00	6H	13.835	14.210	**14.00**
M 18.0	2.50	6H	15.294	15.744	**15.50**
M 20.0	2.50	6H	17.294	17.744	**17.50**
M 22.0	2.50	6H	19.294	19.744	**19.50**
M 24.0	3.00	6H	20.752	21.252	**21.00**
M 27.0	3.00	6H	23.752	24.252	**24.00**

UNC (ANSI B1.1 / ISO 5854)

Ø nominal	Pas	Tolérance	Ø noyau min.	Ø noyau max.	Ø perçage
N°1	64	2B	1.425	1.582	**1.50**
N°2	56	2B	1.695	1.871	**1.80**
N°3	48	2B	1.941	2.146	**2.00**
N°4	40	2B	2.157	2.385	**2.25**
N°5	40	2B	2.487	2.697	**2.60**
N°6	32	2B	2.645	2.895	**2.75**
N°8	32	2B	3.302	3.530	**3.50**
N°10	24	2B	3.683	3.962	**3.80**
N°12	24	2B	4.344	4.597	**4.50**
1/4''	20	2B	4.979	5.257	**5.10**
5/16''	18	2B	6.401	6.731	**6.50**
3/8''	16	2B	7.798	8.153	**7.90**
7/16''	14	2B	9.144	9.550	**9.30**
1/2''	13	2B	10.592	11.023	**10.70**
9/16''	12	2B	11.989	12.446	**12.30**
5/8''	11	2B	13.386	13.868	**13.50**
3/4''	10	2B	16.307	16.840	**16.50**

UNF (ANSI B1.1 / ISO 5854)

Ø nominal	Pas	Tolérance	Ø noyau min.	Ø noyau max.	Ø perçage
N°1	72	2B	1.474	1.612	**1.50**
N°2	64	2B	1.756	1.912	**1.80**
N°3	56	2B	2.025	2.197	**2.10**
N°4	48	2B	2.271	2.458	**2.35**
N°5	44	2B	2.551	2.740	**2.60**
N°6	40	2B	2.820	3.022	**2.90**
N°8	36	2B	3.404	3.606	**3.50**
N°10	32	2B	3.963	4.165	**4.05**
N°12	28	2B	4.496	4.724	**4.60**
1/4''	28	2B	5.360	5.588	**5.50**
5/16''	24	2B	6.782	7.035	**6.90**
3/8''	24	2B	8.382	8.636	**8.50**
7/16''	20	2B	9.729	10.033	**9.80**
1/2''	20	2B	11.329	11.607	**11.40**
9/16''	18	2B	12.751	13.081	**12.90**
5/8''	18	2B	14.351	14.681	**14.50**
3/4''	16	2B	17.323	17.678	**17.50**
7/8''	14	2B	20.270	20.675	**20.40**

UN (ANSI B1.1 / ISO 5854)

Ø nominal	Pas	Tolérance	Ø noyau min.	Ø noyau max.	Ø perçage
5/16''	28	2B	6.955	7.169	**7.10**
5/16''	20	2B	6.563	6.855	**6.70**
3/8''	28	2B	8.543	8.756	**8.60**
3/8''	20	2B	8.150	8.442	**8.30**
7/16''	32	2B	10.253	10.441	**10.30**
7/16''	16	2B	9.394	9.752	**9.60**
1/2''	32	2B	11.841	12.029	**11.90**
1/2''	16	2B	10.981	11.340	**11.20**
9/16''	32	2B	13.428	13.616	**13.50**
9/16''	28	2B	13.305	13.519	**13.40**
9/16''	20	2B	12.913	13.205	**13.10**
9/16''	16	2B	12.569	12.927	**12.70**
5/8''	32	2B	15.016	15.204	**15.10**
5/8''	28	2B	14.893	15.106	**15.00**
5/8''	20	2B	14.500	14.792	**14.60**
5/8''	16	2B	14.156	14.515	**14.30**
5/8''	12	2B	13.584	14.043	**13.80**
11/16''	32	2B	16.603	16.791	**16.70**
11/16''	28	2B	16.480	16.694	**16.60**
11/16''	20	2B	16.088	16.380	**16.20**
11/16''	16	2B	15.744	16.102	**15.90**
11/16''	12	2B	15.171	15.631	**15.40**
3/4''	32	2B	18.191	18.379	**18.30**
3/4''	28	2B	18.068	18.281	**18.20**
3/4''	12	2B	16.759	17.218	**17.00**
13/16''	32	2B	19.778	19.966	**19.90**
13/16''	28	2B	19.655	19.869	**19.80**
13/16''	16	2B	18.919	19.277	**19.10**
13/16''	12	2B	18.346	18.806	**18.60**
7/8''	32	2B	21.366	21.554	**21.50**
7/8''	28	2B	21.243	21.456	**21.30**
7/8''	16	2B	20.506	20.865	**20.70**
7/8''	12	2B	19.934	20.393	**20.20**
15/16''	32	2B	22.953	23.141	**23.00**
15/16''	28	2B	22.830	23.044	**22.90**
15/16''	16	2B	22.094	22.452	**22.30**
15/16''	12	2B	21.521	21.981	**21.80**
1''	32	2B	24.541	24.729	**24.60**
1''	28	2B	24.418	24.631	**24.50**
1''	16	2B	23.681	24.040	**23.90**
1 1/16''	28	2B	26.005	26.219	**26.10**
1 1/16''	20	2B	25.613	25.905	**25.80**
1 1/16''	18	2B	25.460	25.783	**25.60**
1 1/16''	16	2B	25.269	25.627	**25.40**
1 1/16''	12	2B	24.696	25.156	**24.90**

Ø DE PERÇAGE AVANT TARAUDAGE OU FILETAGE

UNEF (ANSI B1.1 / ISO 5854)

Ø nominal	Pas	Tolérance	Ø noyau min.	Ø noyau max.	Ø perçage
N°12	32	2B	4.623	4.826	**4.70**
1/4"	32	2B	5.487	5.689	**5.60**
5/16"	32	2B	7.087	7.264	**7.20**
3/8"	32	2B	8.662	8.864	**8.75**
7/16"	28	2B	10.135	10.337	**10.25**
1/2"	28	2B	11.710	11.938	**11.85**
9/16"	24	2B	13.132	13.385	**13.20**
5/8"	24	2B	14.732	14.986	**14.80**
11/16"	24	2B	16.307	16.560	**16.40**
3/4"	20	2B	17.679	17.957	**17.80**

UNJF (ISO 3161)

Ø nominal	Pas	Tolérance	Ø noyau min.	Ø noyau max.	Ø perçage
N°10	32	3B	4.054	4.255	**4.10**
1/4"	28	3B	5.466	5.662	**5.55**
5/16"	24	3B	6.906	7.109	**7.00**
3/8"	24	3B	8.494	8.679	**8.60**
7/16"	20	3B	9.876	10.084	**10.00**
1/2"	20	3B	11.463	11.661	**11.55**

BSP (ISO 228)

Ø nominal	Pas	Ø noyau min.	Ø noyau max.	Ø perçage
G 1/16"	28	6.561	6.843	**6.75**
G 1/8"	28	8.566	8.848	**8.75**
G 1/4"	19	11.445	11.890	**11.60**
G 3/8"	19	14.950	15.395	**15.20**
G 1/2"	14	18.631	19.172	**18.90**
G 5/8"	14	20.587	21.128	**20.90**
G 3/4"	14	24.117	24.658	**24.40**
G 7/8"	14	27.877	28.418	**28.20**
hG 1"	11	30.291	30.931	**30.70**

COMBINAISONS DE DIAMÈTRES NOMINAUX ET PAS SELON NORME ANSI B1.1 / ISO 5854

Ø nom.		**80**	**72**	**64**	**56**	**48**	**44**	**40**	**36**	**32**	**28**	**24**	**20**	**18**	**16**	**14**	**13**	**12**	**11**	**10**	**TPI**
inch	mm	0.318	0.353	0.397	0.454	0.529	0.577	0.635	0.706	0.794	0.907	1.058	1.270	1.411	1.588	1.814	1.954	2.117	2.309	2.54	mm
N°0	1.524	UNF																			
N°1	1.854		UNF	UNC																	
N°2	2.184			UNF	UNC																
N°3	2.515				UNF	UNC															
N°4	2.845					UNF		UNC													
N°5	3.175						UNF	UNC													
N°6	3.505							UNF		UNC											
N°8	4.166								UNF	UNC											
N°10	4.826									UNF		UNC									
N°12	5.486									UNEF	UNF	UNC									
1/4"	6.350									UNEF	UNF		UNC								
5/16"	7.938									UNEF	UN	UNF	UN	UNC							
3/8"	9.525									UNEF	UN	UNF	UN		UNC						
7/16"	11.113									UN	UNEF	UNF			UN	UNC					
1/2"	12.700									UN	UNEF		UNF		UN		UNC				
9/16"	14.288									UN	UN	UNEF	UN	UNF	UN			UNC			
5/8"	15.875									UN	UN	UNEF	UN	UNF	UN			UN	UNC		
11/16"	17.463									UN	UN	UNEF	UN		UN			UN			
3/4"	19.050									UN	UN		UNEF		UNF			UN		UNC	
13/16"	20.638									UN	UN		UNEF		UN			UN			
7/8"	22.225									UN	UN		UNEF		UN	UNF		UN			
15/16"	23.813									UN	UN		UNEF		UN			UN			
1''	25.400									UN	UN		UNEF		UN			UNF			
1-1/16"	26.988										UN		UN	UN	UN			UN			

CONDITIONS DE COUPE

USINAGE AVEC PIÈCE FIXE

	Matières à usiner		CARBURE Vc [m/min]		TiALN Vc [m/min]		CUTINOX Vc [m/min]	
P	Acier non allié / faiblement allié	< 600 N/mm²	**65**	80	**70**	100		
P	Acier non allié / faiblement allié	600 – 1500 N/mm²			**40**	60		
P	Acier fortement allié	700 – 1500 N/mm²			**25**	50	**60**	80
M	Acier inoxydable	400 – 700 N/mm²	**35**	40	**40**	60	**70**	90
M	Acier inox. DUPLEX, acier austénitique inox. sans nickel	> 800 N/mm²			**25**	50	**60**	80
K	Fonte grise / Fonte à graphite sphéroïdal perlitique	< 250 HB	**65**	80	**70**	100		
K	Fonte alliée / Fonte à graphite sphéroïdal perlitique	> 250 HB	**35**	40	**40**	60		
K	Fonte à graphite sphéroïdal ferritique / Fonte malléable		**35**	40	**40**	60		
S	Super alliages / Acier inox. réfractaire	Inconel Nimonic Hastelloy			**25**	50	**40**	60
S	Titane, alliage de titane		**15**	35				
N	Alliage de cuivre / bonne usinabilité (laiton – bronze)		**80**	200				
N	Alliage de cuivre / usinabilité difficile / Bronze à l'aluminium	(CuAlFe) (Ampco)	**70**	150				
N	Or, argent		**80**	200				

USINAGE AVEC DÉCOLLETEUSE - la pièce tourne

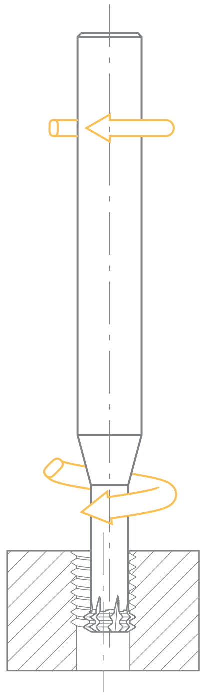
	Matières à usiner	CARBURE Vc [m/min]	fz [mm] pas 0.20 - 0.25	fz [mm] pas 0.30 - 0.35	fz [mm] pas 0.40 - 0.50	fz [mm] pas 0.70 - 1.00
P	Aciers	**50** - 100	**0.002** - 0.004	**0.002** - 0.004	**0.003** - 0.006	**0.005** - 0.013
M	Acier inoxydable	**40** - 80	**0.002** - 0.003	**0.002** - 0.004	**0.002** - 0.005	**0.004** - 0.01
S	Titane, alliage de titane	**50** - 90	**0.002** - 0.003	**0.002** - 0.004	**0.002** - 0.005	**0.004** - 0.01
N	Alliage de cuivre	**60** - 150	**0.002** - 0.005	**0.002** - 0.006	**0.003** - 0.007	**0.005** - 0.013

$$n\,[tr/min] = \frac{Vc\,[m/min] \times 1000}{\pi \times D_1\,[mm]}$$

$$Vf\,[mm/min] = n\,[tr/min] \times fz\,[mm] \times z$$

Avance par dent fz [mm]

Ø D_1 0.20 - 0.60	Ø D_1 0.60 - 1.20	Ø D_1 1.20 - 2.00	Ø D_1 2.00 - 3.00	Ø D_1 3.00 - 5.00	Ø D_1 5.00 - 8.00
0.003 - 0.006	**0.004** - 0.01	**0.01** - 0.03	**0.02** - 0.04	**0.03** - 0.05	**0.04** - 0.07
0.003 - 0.006	**0.004** - 0.01	**0.01** - 0.03	**0.02** - 0.04	**0.03** - 0.05	**0.04** - 0.07
0.003 - 0.006	**0.004** - 0.01	**0.01** - 0.03	**0.02** - 0.04	**0.03** - 0.05	**0.04** - 0.07
0.003 - 0.006	**0.004** - 0.01	**0.01** - 0.03	**0.02** - 0.04	**0.03** - 0.05	**0.04** - 0.07
0.003 - 0.006	**0.004** - 0.01	**0.01** - 0.03	**0.02** - 0.04	**0.03** - 0.05	**0.04** - 0.07
0.003 - 0.006	**0.004** - 0.01	**0.01** - 0.03	**0.02** - 0.04	**0.03** - 0.05	**0.04** - 0.07
0.003 - 0.006	**0.004** - 0.01	**0.01** - 0.03	**0.02** - 0.04	**0.03** - 0.05	**0.04** - 0.07
0.003 - 0.006	**0.004** - 0.01	**0.01** - 0.03	**0.02** - 0.04	**0.03** - 0.05	**0.04** - 0.07
0.003 - 0.006	**0.004** - 0.01	**0.01** - 0.03	**0.02** - 0.04	**0.03** - 0.05	**0.04** - 0.07
0.003 - 0.006	**0.004** - 0.01	**0.01** - 0.03	**0.02** - 0.04	**0.03** - 0.05	**0.04** - 0.07
0.003 - 0.006	**0.004** - 0.01	**0.01** - 0.03	**0.02** - 0.04	**0.03** - 0.05	**0.04** - 0.07
0.003 - 0.006	**0.004** - 0.01	**0.01** - 0.03	**0.02** - 0.04	**0.03** - 0.05	**0.04** - 0.07
0.003 - 0.006	**0.004** - 0.01	**0.01** - 0.03	**0.02** - 0.04	**0.03** - 0.05	**0.04** - 0.07



Exemple pour M2 x 0.40 dans le titane, DIXI 1730 Ø D_1 = 1.55

❶ **Rotation outil n (min^{-1})** $= \frac{1000 \times Vc}{\pi \times Ø D_1}$

$\frac{1000 \times 90}{(\pi \times 1.55)} \Rightarrow 19'000\ min^{-1}$

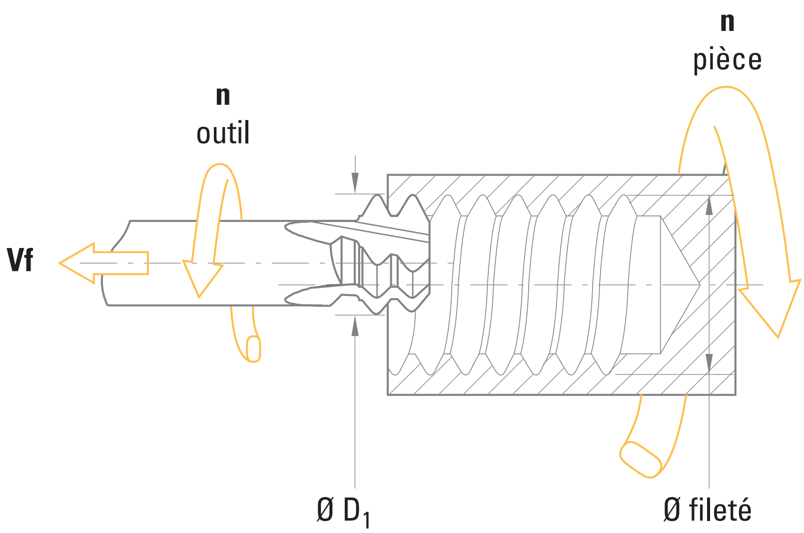
❷ **Avance Vf mm/min** = n x fz x z

19'000 x 0.004 x 3 = 223 mm/min

❸ **Rotation pièce min^{-1}** $= \frac{Vf}{Ø\ fileté \times \pi}$

$\frac{223}{M2 \times \pi} \Rightarrow 36\ min^{-1}$

Si nécessaire, convertir en degrés nb° = min^{-1} x 360° ⇒ 36 min^{-1} x 360° = 12960°



CONDITIONS DE COUPE

Matières à usiner			CARBURE		CUTINOX	
			Vc [m/min]		Vc [m/min]	
P	Acier non allié / faiblement allié	< 600 N/mm²	**100**	150	**120**	180
P	Acier non allié / faiblement allié	600 – 1500 N/mm²	**90**	130	**110**	150
P	Acier de décolletage au plomb		**100**	180	**120**	200
P	Acier fortement allié	700 – 1500 N/mm²	**40**	70	**50**	80
M	Acier inoxydable	400 – 700 N/mm²	**50**	80	**60**	110
M	Acier inox. DUPLEX, acier austénitique inox. sans nickel	> 800 N/mm²	**35**	60	**45**	75
K	Fonte grise / Fonte à graphite sphéroïdal perlitique	< 250 HB	**100**	200	**150**	250
K	Fonte alliée / Fonte à graphite sphéroïdal perlitique	> 250 HB	**100**	140	**120**	160
K	Fonte à graphite sphéroïdal ferritique / Fonte malléable		**70**	110	**80**	140
S	Super alliages / Acier inox. réfractaire	Inconel Nimonic Hastelloy	**20**	45	**30**	60
S	Titane, alliage de titane		**40**	65	**40**	65
N	Alliage de cuivre / bonne usinabilité (laiton – bronze)		**100**	200	**100**	200
N	Alliage de cuivre / usinabilité difficile / Bronze à l'aluminium	(CuAlFe) (Ampco)	**80**	150	**80**	150
N	Alliage d'aluminium	Si < 8%	**100**	250	**100**	250
N	Fonte d'aluminium	Si > 8%	**100**	200	**100**	200
N	Graphite		**100**	200	**100**	200
N	Plastique		**100**	250	**100**	250
N	Or, argent		**100**	200	**100**	200

$$n\ [tr/min] = \frac{Vc\ [m/min] \times 1000}{\pi \times D_1\ [mm]}$$

$$Vf\ [mm/min] = n\ [tr/min] \times fz\ [mm] \times z$$

Avance par dent fz [mm]

Ø D_1 0.60 - 1.00	Ø D_1 1.00 -1.50	Ø D_1 1.50 - 2.00	Ø D_1 2.00 - 3.00	Ø D_1 3.00 - 4.00
0.008 - 0.015	**0.010** - 0.025	**0.015** - 0.030	**0.020** - 0.050	**0.030** - 0.070
0.005 - 0.012	**0.008** - 0.020	**0.013** - 0.025	**0.020** - 0.045	**0.025** - 0.060
0.012 - 0.030	**0.020** - 0.040	**0.025** - 0.055	**0.030** - 0.070	**0.035** -0.080
0.002 - 0.011	**0.008** - 0.015	**0.012** - 0.023	**0.015** - 0.038	**0.023** - 0.060
0.003 - 0.016	**0.011** - 0.023	**0.018** - 0.034	**0.023** - 0.056	**0.034** - 0.090
0.002 - 0.009	**0.007** - 0.014	**0.011** - 0.020	**0.014** - 0.034	**0.020** - 0.054
0.012 - 0.030	**0.020** - 0.040	**0.025** - 0.055	**0.030** - 0.070	**0.050** - 0.100
0.005 - 0.012	**0.008** - 0.020	**0.013** - 0.025	**0.020** - 0.045	**0.025** -0.060
0.005 - 0.012	**0.008** - 0.020	**0.013** - 0.025	**0.020** - 0.045	**0.025** - 0.060
0.001 - 0.007	**0.005** - 0.010	**0.008** - 0.015	**0.010** - 0.025	**0.015** - 0.040
0.008 - 0.015	**0.010** - 0.020	**0.015** - 0.040	**0.030** - 0.060	**0.040** - 0.080
0.015 - 0.035	**0.020** - 0.040	**0.025** - 0.050	**0.030** - 0.070	**0.050** - 0.100
0.012 - 0.030	**0.020** - 0.040	**0.025** - 0.055	**0.030** - 0.070	**0.050** - 0.100
0.015 - 0.035	**0.020** - 0.040	**0.025** - 0.055	**0.030** - 0.070	**0.050** - 0.100
0.015 - 0.035	**0.020** - 0.040	**0.025** - 0.055	**0.030** - 0.070	**0.050** - 0.100
0.015 - 0.035	**0.020** - 0.040	**0.025** - 0.055	**0.030** - 0.070	**0.050** - 0.100
0.015 - 0.035	**0.020** - 0.040	**0.025** - 0.055	**0.030** - 0.070	**0.050** - 0.100
0.015 - 0.035	**0.020** - 0.040	**0.025** - 0.055	**0.030** - 0.070	**0.050** - 0.100

DIXI 1742

CONDITIONS DE COUPE

Matières à usiner			DAC
			Vc [m/min]
N	Alliage de cuivre / bonne usinabilité (laiton – bronze)		200
N	Alliage de cuivre / usinabilité difficile / Bronze à l'aluminium	(CuAlFe) (Ampco)	150
N	Alliage d'aluminium	Si < 8%	250
N	Fonte d'aluminium	Si > 8%	200
N	Graphite		200
N	Plastique		250
N	Or, argent		200

DIXI 1744

CONDITIONS DE COUPE

Matières à usiner			CUTINOX
			Vc [m/min]
P	Acier non allié / faiblement allié	< 600 N/mm²	150
P	Acier non allié / faiblement allié	600 – 1500 N/mm²	120
P	Acier de décolletage au plomb		160
P	Acier fortement allié	700 – 1500 N/mm²	70
M	Acier inoxydable	400 – 700 N/mm²	90
M	Acier inox. DUPLEX, acier austénitique inox. sans nickel	> 800 N/mm²	60
K	Fonte grise / Fonte à graphite sphéroïdal perlitique	< 250 HB	200
K	Fonte alliée / Fonte à graphite sphéroïdal perlitique	> 250 HB	130
K	Fonte à graphite sphéroïdal ferritique / Fonte malléable		110
S	Super alliages / Acier inox. réfractaire	Inconel Nimonic Hastelloy	50
S	Titane, alliage de titane		60

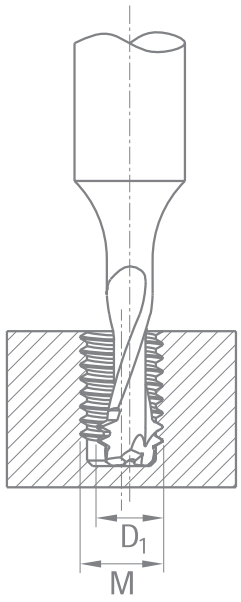
$$n\ [tr/min] = \frac{Vc\ [m/min] \times 1000}{\pi \times D_1\ [mm]}$$

$$Vf\ [mm/min] = n\ [tr/min] \times fz\ [mm] \times z$$

Avance centre outil **Vf [mm/min]**

M5	M6	M8	M10
1000	1000	1000	1000
1000	1000	1000	1000
1000	1000	1000	1000
1000	1000	1000	1000
1000	1000	1000	1000
1000	1000	1000	1000
1000	1000	1000	1000

$$Vf\ centre\ outil = Vf \times \left(1 - \frac{M}{D_1}\right)$$



Avance centre outil **Vf [mm/min]**

M5	M6	M8	M10
800	600	500	500
600	500	350	350
1200	1000	800	800
450	400	250	250
500	450	350	350
400	300	200	200
1000	800	500	500
600	500	350	350
550	450	300	300
250	200	150	150
300	250	200	200

CONDITIONS DE COUPE

Matières à usiner			CARBURE		TiALN	
			Vc [m/min]		Vc [m/min]	
P	Acier non allié / faiblement allié	< 600 N/mm²	**70**	100	**90**	110
P	Acier non allié / faiblement allié	600 – 1500 N/mm²			**70**	90
P	Acier de décolletage au plomb		**70**	100	**90**	110
P	Acier fortement allié	700 – 1500 N/mm²			**40**	55
M	Acier inoxydable	400 – 700 N/mm²	**40**	60	**70**	90
M	Acier inox. DUPLEX, acier austénitique inox. sans nickel	> 800 N/mm²			**40**	55
K	Fonte grise / Fonte à graphite sphéroïdal perlitique	< 250 HB	**70**	100	**90**	110
K	Fonte alliée / Fonte à graphite sphéroïdal perlitique	> 250 HB	**40**	70	**70**	90
K	Fonte à graphite sphéroïdal ferritique / Fonte malléable		**70**	100	**90**	110
S	Titane, alliage de titane		**30**	45	**40**	60
N	Alliage de cuivre / bonne usinabilité (laiton – bronze)		**140**	160	**200**	220
N	Alliage de cuivre / usinabilité difficile / Bronze à l'aluminium	(CuAlFe) (Ampco)	**120**	140	**170**	190
N	Alliage d'aluminium	Si < 8%	**180**	260	**230**	340
N	Fonte d'aluminium	Si > 8%	**140**	160	**210**	230
N	Plastique		**240**	260	**300**	340
N	Or, argent		**140**	160	**200**	220

$$n\ [tr/min] = \frac{Vc\ [m/min] \times 1000}{\pi \times D_1\ [mm]}$$

$$Vf\ [mm/min] = n\ [tr/min] \times fz\ [mm] \times z$$

Avance par dent **fz [mm]**

Ø D_1 0.90 - 1.50	Ø D_1 1.50 -2.00	Ø D_1 2.00 - 2.50	Ø D_1 2.50 - 3.00	Ø D_1 3.00 - 4.00	Ø D_1 4.00 - 6.00	Ø D_1 6.00 - 8.00	Ø D_1 8.00 - 10.00	Ø D_1 10.00 - 12.00	Ø D_1 12.00 - 16.00
		0.008 - 0.02	**0.010** - 0.02	**0.012** - 0.03	**0.016** - 0.04	**0.024** - 0.06	**0.03** - 0.07	**0.04** - 0.08	**0.05** - 0.11
		0.006 - 0.01	**0.008** - 0.01	**0.009** - 0.02	**0.012** - 0.03	**0.018** - 0.04	**0.02** - 0.05	**0.03** - 0.06	**0.04** - 0.08
0.005 - 0.015	**0.008** - 0.020	**0.010** - 0.03	**0.013** - 0.03	**0.015** - 0.04	**0.020** - 0.06	**0.030** - 0.08	**0.04** - 0.10	**0.05** - 0.12	**0.06** - 0.16
			0.008 - 0.01	**0.009** - 0.02	**0.012** - 0.03	**0.018** - 0.04	**0.02** - 0.05	**0.03** - 0.06	**0.04** - 0.08
		0.006 - 0.01	**0.008** - 0.01	**0.009** - 0.02	**0.012** - 0.03	**0.018** - 0.04	**0.02** - 0.05	**0.03** - 0.06	**0.04** - 0.08
			0.008 - 0.01	**0.009** - 0.02	**0.012** - 0.03	**0.018** - 0.04	**0.02** - 0.05	**0.03** - 0.06	**0.04** - 0.08
		0.008 - 0.02	**0.010** - 0.02	**0.012** - 0.03	**0.016** - 0.04	**0.024** - 0.06	**0.03** - 0.07	**0.04** - 0.08	**0.05** - 0.11
			0.008 - 0.01	**0.009** - 0.02	**0.012** - 0.03	**0.018** - 0.04	**0.02** - 0.05	**0.03** - 0.06	**0.04** - 0.08
	0.006 - 0.014	**0.008** - 0.02	**0.010** - 0.02	**0.012** - 0.03	**0.016** - 0.04	**0.024** - 0.06	**0.03** - 0.07	**0.04** - 0.08	**0.05** - 0.11
		0.006 - 0.01	**0.008** - 0.01	**0.009** - 0.02	**0.012** - 0.03	**0.018** - 0.04	**0.02** - 0.05	**0.03** - 0.06	**0.04** - 0.08
0.005 - 0.015	**0.008** - 0.020	**0.010** - 0.03	**0.013** - 0.03	**0.015** - 0.04	**0.020** - 0.06	**0.030** - 0.08	**0.04** - 0.10	**0.05** - 0.12	**0.06** - 0.16
0.003 - 0.008	**0.005** - 0.010	**0.006** - 0.01	**0.008** - 0.01	**0.009** - 0.02	**0.012** - 0.03	**0.018** - 0.04	**0.02** - 0.05	**0.03** - 0.06	**0.04** - 0.08
0.005 - 0.015	**0.008** - 0.020	**0.010** - 0.03	**0.013** - 0.03	**0.015** - 0.04	**0.020** - 0.06	**0.030** - 0.08	**0.04** - 0.10	**0.05** - 0.12	**0.06** - 0.16
0.005 - 0.015	**0.008** - 0.020	**0.010** - 0.03	**0.013** - 0.03	**0.015** - 0.04	**0.020** - 0.06	**0.030** - 0.08	**0.04** - 0.10	**0.05** - 0.12	**0.06** - 0.16
0.006 - 0.023	**0.011** - 0.030	**0.014** - 0.04	**0.018** - 0.04	**0.021** - 0.06	**0.028** - 0.09	**0.042** - 0.12	**0.06** - 0.15	**0.07** - 0.18	**0.08** - 0.24
0.005 - 0.015	**0.008** - 0.020	**0.010** - 0.03	**0.013** - 0.03	**0.015** - 0.04	**0.020** - 0.06	**0.030** - 0.08	**0.04** - 0.10	**0.05** - 0.12	**0.06** - 0.16

CONDITIONS DE COUPE

Matières à usiner			CARBURE		TiALN	
			Vc [m/min]		Vc [m/min]	
P	Acier non allié / faiblement allié	< 600 N/mm²	**70**	100	**90**	110
P	Acier non allié / faiblement allié	600 – 1500 N/mm²	**40**	60	**70**	90
P	Acier de décolletage au plomb		**70**	100	**90**	110
P	Acier fortement allié	700 – 1500 N/mm²	**40**	60	**70**	90
M	Acier inoxydable	400 – 700 N/mm²	**30**	45	**40**	55
M	Acier inox. DUPLEX, acier austénitique inox. sans nickel	> 800 N/mm²	**40**	60	**70**	90
K	Fonte grise / Fonte à graphite sphéroïdal perlitique	< 250 HB	**70**	100	**90**	110
K	Fonte alliée / Fonte à graphite sphéroïdal perlitique	> 250 HB	**40**	70	**70**	90
K	Fonte à graphite sphéroïdal ferritique / Fonte malléable		**70**	100	**90**	110
S	Titane, alliage de titane		**30**	45	**40**	60
N	Alliage de cuivre / bonne usinabilité (laiton – bronze)		**140**	160	**200**	220
N	Alliage de cuivre / usinabilité difficile / Bronze à l'aluminium	(CuAlFe) (Ampco)	**120**	140	**170**	190
N	Alliage d'aluminium	Si < 8%	**180**	260	**230**	270
N	Fonte d'aluminium	Si > 8%	**140**	160	**210**	230
N	Plastique		**240**	260	**300**	340
N	Or, argent		**140**	160	**200**	220

$$n\ [tr/min] = \frac{Vc\ [m/min] \times 1000}{\pi \times D_1\ [mm]}$$

$$Vf\ [mm/min] = n\ [tr/min] \times fz\ [mm] \times z$$

Avance par dent fz [mm]

Ø D_1 0.90 - 1.50	Ø D_1 1.50 -2.00	Ø D_1 2.00 - 2.50	Ø D_1 2.50 - 3.00	Ø D_1 3.00 - 4.00	Ø D_1 4.00 - 6.00	Ø D_1 6.00 - 8.00	Ø D_1 8.00 - 10.00	Ø D_1 10.00 - 12.00	Ø D_1 12.00 - 16.00
0.005 - 0.012	**0.009** - 0.016	**0.012** - 0.02	**0.015** - 0.02	**0.018** - 0.03	**0.024** - 0.05	**0.036** - 0.06	**0.05** - 0.08	**0.06** - 0.10	**0.07** - 0.13
0.004 - 0.009	**0.006** - 0.012	**0.008** - 0.02	**0.010** - 0.02	**0.012** - 0.02	**0.016** - 0.04	**0.024** - 0.05	**0.03** - 0.06	**0.04** - 0.07	**0.05** - 0.10
0.006 - 0.018	**0.011** - 0.024	**0.014** - 0.03	**0.018** - 0.03	**0.021** - 0.05	**0.028** - 0.07	**0.042** - 0.10	**0.06** - 0.12	**0.07** - 0.14	**0.08** - 0.19
0.004 - 0.009	**0.006** - 0.012	**0.008** - 0.02	**0.010** - 0.02	**0.012** - 0.02	**0.016** - 0.04	**0.024** - 0.05	**0.03** - 0.06	**0.04** - 0.07	**0.05** - 0.10
0.004 - 0.009	**0.006** - 0.012	**0.008** - 0.02	**0.010** - 0.02	**0.012** - 0.02	**0.016** - 0.04	**0.024** - 0.05	**0.03** - 0.06	**0.04** - 0.07	**0.05** - 0.10
0.004 - 0.009	**0.006** - 0.012	**0.008** - 0.02	**0.010** - 0.02	**0.012** - 0.02	**0.016** - 0.04	**0.024** - 0.05	**0.03** - 0.06	**0.04** - 0.07	**0.05** - 0.10
0.005 - 0.012	**0.009** - 0.016	**0.012** - 0.02	**0.015** - 0.02	**0.018** - 0.03	**0.024** - 0.05	**0.036** - 0.06	**0.05** - 0.08	**0.06** - 0.10	**0.07** - 0.13
0.004 - 0.009	**0.006** - 0.012	**0.008** - 0.02	**0.010** - 0.02	**0.012** - 0.02	**0.016** - 0.04	**0.024** - 0.05	**0.03** - 0.06	**0.04** - 0.07	**0.05** - 0.10
0.005 - 0.012	**0.009** - 0.016	**0.012** - 0.02	**0.015** - 0.02	**0.018** - 0.03	**0.024** - 0.05	**0.036** - 0.06	**0.05** - 0.08	**0.06** - 0.10	**0.07** - 0.13
0.004 - 0.009	**0.006** - 0.012	**0.008** - 0.02	**0.010** - 0.02	**0.012** - 0.02	**0.016** - 0.04	**0.024** - 0.05	**0.03** - 0.06	**0.04** - 0.07	**0.05** - 0.10
0.006 - 0.018	**0.011** - 0.024	**0.014** - 0.03	**0.018** - 0.03	**0.021** - 0.05	**0.028** - 0.07	**0.042** - 0.10	**0.06** - 0.12	**0.07** - 0.14	**0.08** - 0.19
0.004 - 0.009	**0.006** - 0.012	**0.008** - 0.02	**0.010** - 0.02	**0.012** - 0.02	**0.016** - 0.04	**0.024** - 0.05	**0.03** - 0.06	**0.04** - 0.07	**0.05** - 0.10
0.006 - 0.018	**0.011** - 0.024	**0.014** - 0.03	**0.018** - 0.03	**0.021** - 0.05	**0.028** - 0.07	**0.042** - 0.10	**0.06** - 0.12	**0.07** - 0.14	**0.08** - 0.19
0.006 - 0.018	**0.011** - 0.024	**0.014** - 0.03	**0.018** - 0.03	**0.021** - 0.05	**0.028** - 0.07	**0.042** - 0.10	**0.06** - 0.12	**0.07** - 0.14	**0.08** - 0.19
0.007 - 0.027	**0.012** - 0.036	**0.016** - 0.05	**0.020** - 0.05	**0.024** - 0.07	**0.032** - 0.11	**0.048** - 0.14	**0.06** - 0.18	**0.08** - 0.22	**0.10** - 0.29
0.006 - 0.018	**0.011** - 0.024	**0.014** - 0.03	**0.018** - 0.03	**0.021** - 0.05	**0.028** - 0.07	**0.042** - 0.10	**0.06** - 0.12	**0.07** - 0.14	**0.08** - 0.19

CONDITIONS DE COUPE

Matières à usiner			CARBURE Vc [m/min]		CUTINOX Vc [m/min]	
K	Fonte grise / Fonte à graphite sphéroïdal perlitique	< 250 HB	**80**	140	**100**	200
N	Alliage de cuivre / bonne usinabilité (laiton – bronze)		**100**	250	**150**	350
N	Alliage de cuivre / usinabilité difficile / Bronze à l'aluminium	(CuAlFe) (Ampco)	**100**	250	**150**	350
N	Alliage d'aluminium	Si < 8%	**100**	200	**150**	350
N	Fonte d'aluminium	Si > 8%			**150**	350

$$n\ [tr/min] = \frac{Vc\ [m/min] \times 1000}{\pi \times D_1\ [mm]}$$

PERÇAGE

Vf [mm/min] = n [tr/min] x f [mm]

Avance par tour (**f**)

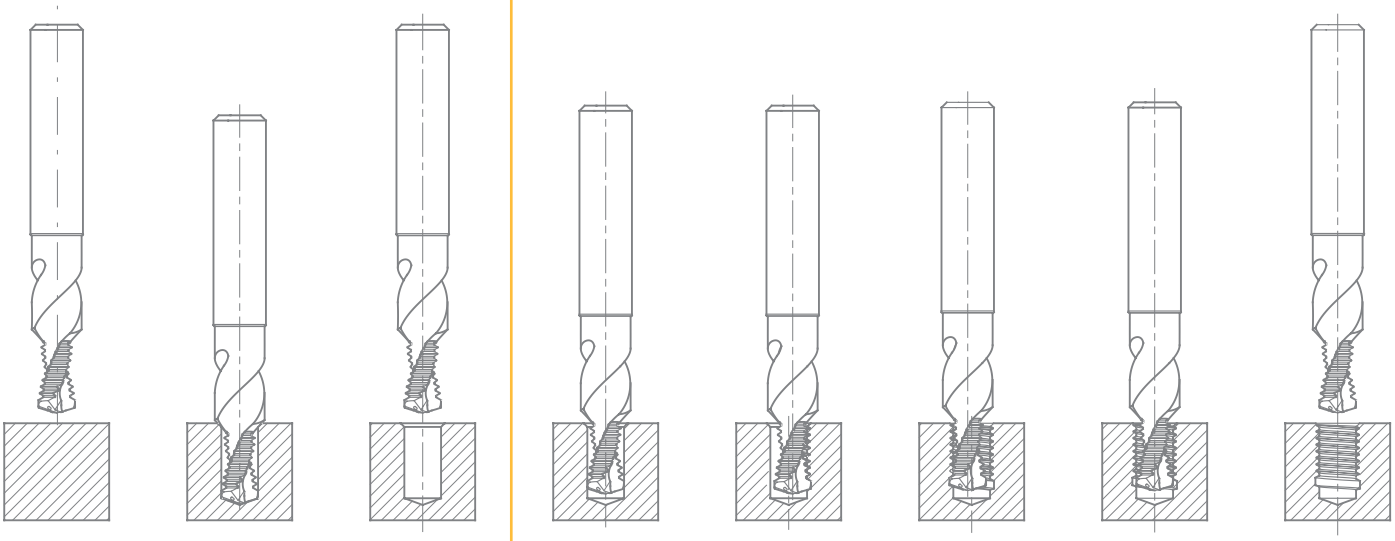
Ø D_1 3.00 -700	Ø D_1 7.00 - 14.00
0.08 - 0.24	**0.18** - 0.40
0.08 - 0.18	**0.14** - 0.30
0.14 - 0.28	**0.18** - 0.40
0.14 - 0.28	**0.18** - 0.40
0.14 - 0.28	**0.18** - 0.40

FILETAGE

Vf [mm/min] = n [tr/min] x fz [mm] x z

Avance par dent (**fz**)

Ø D_1 3.00 -700	Ø D_1 7.00 - 14.00
0.03 - 0.07	**0.05** - 0.12
0.04 - 0.07	**0.06** - 0.15
0.04 - 0.07	**0.05** - 0.15
0.03 - 0.07	**0.06** - 0.15
0.03 - 0.07	**0.06** - 0.15



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