



TRONÇONNAGE

ABTRENNEN

SLITTING

TRONCATURA

DARABOLÁS

TRONZADO

SÉLECTION DES FRAISES À FENDRE 242



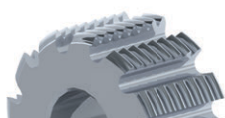
FRAISES À FENDRE 246



TASSEaux PORTE-FRAISES 256



FRAISES À T 257



FRAISES-MÈRES 260



CIBLES DE ROULAGE 263



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CONDITIONS DE COUPE 268

SÉLECTION DES FRAISES

✓ = article de stock

FRAISES À FENDRE

		Page		☐ CARBURE	☐ CUTINOX			
DIXI 1531 Ø 15 - 125		246	 	✓				
DIXI 1533 Ø 15 - 160		248	 	✓				
DIXI 1539 Ø 10 - 50		251		✓				
DIXI 1534 Ø 20 - 100		253	 	✓				
DIXI 1537 Ø 50 - 100		254	 		✓			
DIXI 1640 Ø 50 - 100		255		✓				

TASSEaux PORTE-FRAISES

DIXI 2713 Ø 3 - 16		256						
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FRAISES À T

DIXI 1525 Ø 2 - 30		257		✓	✓			
DIXI 1528 Ø 4 - 30		258		✓	✓			
DIXI 1527 Ø 4 - 16		259		✓	✓			

○ bien ⊙ excellent

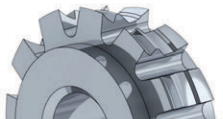
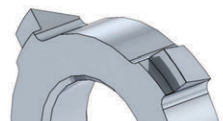
Acier + Pb	Acier faibl. allié	Acier fort. allié	Acier inox aust.	Aciers Fontes 45-65 HRC	Fontes	Super alliages Ni / Co	Titane, alliages de titane	Alliage Cu Argent Or	Alliage Cu difficile	Alu	Graphite	Plastique
⊙	⊙	⊙	○		⊙	⊙	⊙	○	○	○		○
○	○	○	○		⊙	○	○	○	○	○		○
○	○	○	○		⊙	○	○	○	○			
○	○	○	⊙		○	○	○	⊙	⊙	⊙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

⊙	⊙	○	○		⊙	○	○	⊙	○	⊙		○
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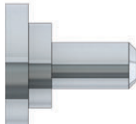
SÉLECTION DES FRAISES-MÈRES

✓ = article de stock

FRAISES-MÈRES

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DIXI 1680 Ø 6 - 24		260		✓				
DIXI 1685 Ø 6 - 24		261		✓				
DIXI 1690 Ø 10 - 12		262		✓				
DIXI 1674 Ø 6 - 24		262		✓				
DIXI 1672 Ø 4 - 6		261		✓				
DIXI 1673 Ø 4 - 6		261		✓				

CIBLES DE ROULAGE

DIXI 0700 DIXI 0710		263		✓				
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○ bien ⊙ excellent

Acier + Pb	Acier faibl. allié	Acier 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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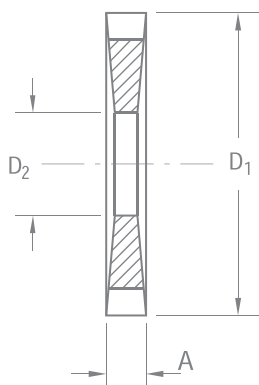
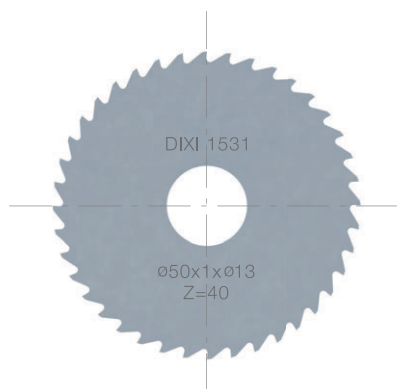
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⊙	⊙	○	○				○	⊙	○	⊙		
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⊙	⊙	○	○				○	⊙	○	⊙		

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DIXI 1531

FRAISES À FENDRE DENTURE LARGE



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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
Plastique				

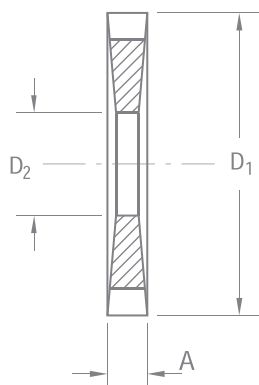
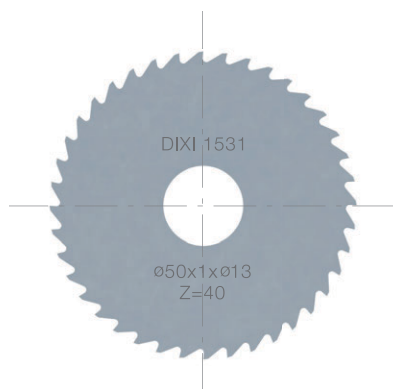
D ₁ js12	A ±0.01	D ₂ H6	Z	CARBURE
15	0.20	5	32	37180
15	0.30	5	24	37182
15	0.40	5	24	35382
15	0.50	5	24	35383
15	0.60	5	20	601
15	0.70	5	20	603
15	0.80	5	20	2532
15	0.90	5	20	7707
15	1.00	5	20	602
15	1.20	5	16	38947
15	1.50	5	16	38948
15	1.60	5	16	42457
15	1.80	5	16	42536
15	2.00	5	16	38949
20	0.20	5	40	35384
20	0.30	5	32	35385
20	0.40	5	32	3281
20	0.50	5	24	31481
20	0.60	5	24	604
20	0.70	5	24	605
20	0.80	5	24	37080
20	0.90	5	20	3282
20	1.00	5	20	3283
20	1.20	5	20	2425
20	1.50	5	20	3287
20	1.60	5	20	3288
20	1.80	5	20	3290
20	2.00	5	16	42458
20	2.50	5	16	42459
25	0.30	8	40	37740
25	0.40	8	32	42461
25	0.50	8	32	42376
25	0.60	8	24	42377
25	0.70	8	24	42378
25	0.80	8	24	2479
25	0.90	8	24	42379
25	1.00	8	24	42380
25	1.20	8	24	42462
25	1.50	8	20	3299
25	1.60	8	20	3300
25	1.80	8	20	3301
25	2.00	8	20	3303
25	2.50	8	20	3305

D ₁ js12	A ±0.01	D ₂ H6	Z	CARBURE
30	0.30	8	40	37845
30	0.40	8	40	37841
30	0.50	8	40	35386
30	0.60	8	32	30662
30	0.70	8	32	3309
30	0.80	8	32	41350
30	0.90	8	32	41351
30	1.00	8	32	36413
30	1.20	8	24	1327
30	1.50	8	24	3316
30	1.60	8	24	3317
30	1.80	8	24	3319
30	2.00	8	24	3321
30	2.50	8	20	42466
30	3.00	8	20	42467
30	4.00	8	20	42468
40	0.40	10	48	42470
40	0.50	10	40	2662
40	0.60	10	40	6348
40	0.70	10	40	17953
40	0.80	10	40	42471
40	0.90	10	32	38817
40	1.00	10	32	3034
40	1.20	10	32	3307
40	1.50	10	32	3326
40	1.60	10	32	3798
40	1.80	10	24	39499
40	2.00	10	24	42472
40	2.50	10	24	42473
40	3.00	10	24	42474
40	4.00	10	20	42475
50	0.40	13	48	26023
50	0.50	13	48	42477
50	0.60	13	48	42478
50	0.70	13	48	14681
50	0.80	13	40	3330
50	0.90	13	40	41064
50	1.00	13	40	8636
50	1.20	13	40	8637
50	1.40	13	32	3336
50	1.50	13	32	25731
50	1.60	13	32	3337
50	1.80	13	32	3657





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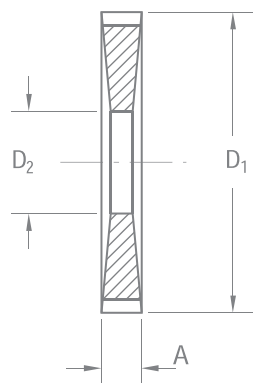
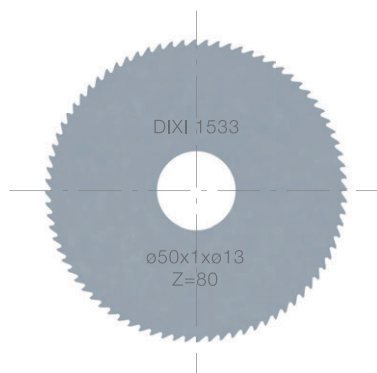


Acier + Pb	Acier faibl. allié	Acier fort. allié	Acier inox aust.	Fontes
Super alliages Ni / Co	Titane, alliage de titane	Alliage Cu Argent Or	Alliage Cu difficile	Alu
Plastique				

D_1 js12	$A_{\pm 0.01}$	D_2 H6	Z	CARBURE
50	2.00	13	32	2533
50	2.50	13	32	3339
50	3.00	13	32	42479
63	0.80	16	48	3342
63	0.90	16	48	49467
63	1.00	16	48	609
63	1.20	16	40	3658
63	1.50	16	40	3345
63	1.60	16	40	3346
63	1.80	16	40	3347
63	2.00	16	40	610
63	2.50	16	32	42483
63	3.00	16	32	611
80	0.80	22	64	6070
80	0.90	22	64	49665
80	1.00	22	48	3054
80	1.20	22	48	4016
80	1.50	22	48	3349
80	1.60	22	48	34808
80	1.80	22	40	22178
80	2.00	22	40	2807
80	2.50	22	40	42484
80	3.00	22	40	21847
100	1.00	22	64	38542
100	1.20	22	64	38543
100	1.50	22	48	35387
100	1.60	22	48	39146
100	1.80	22	48	38927
100	2.00	22	48	38928
100	2.50	22	48	36588
100	3.00	22	48	38713
125	1.00	22	80	42489
125	1.20	22	64	42490
125	1.50	22	64	38480
125	1.60	22	64	42492
125	1.80	22	64	42493
125	2.00	22	64	39005

DIXI 1533

FRAISES À FENDRE DENTURE FINE



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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
Plastique				

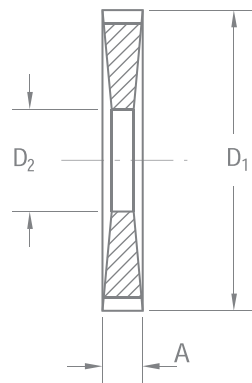
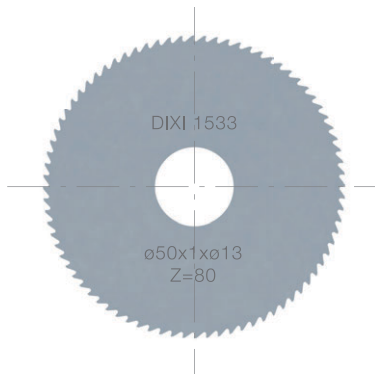
D ₁ js12	A ±0.01	D ₂ H6	Z	CARBURE
15	0.20	5	64	36382
15	0.25	5	64	35635
15	0.30	5	48	3707
15	0.40	5	48	3708
15	0.50	5	48	613
15	0.60	5	40	5453
15	0.70	5	40	6183
15	0.80	5	40	3244
15	0.90	5	40	3245
15	1.00	5	40	614
15	1.10	5	32	43250
15	1.20	5	32	37174
15	1.50	5	32	40710
15	1.60	5	32	40711
15	1.70	5	32	40712
15	1.80	5	32	40713
15	2.00	5	32	37175
20	0.20	5	80	617
20	0.25	5	64	618
20	0.30	5	64	34590
20	0.40	5	64	1659
20	0.50	5	48	18560
20	0.60	5	48	36647
20	0.70	5	48	39659
20	0.80	5	48	627
20	0.90	5	48	623
20	1.00	5	40	35565
20	1.10	5	40	2689
20	1.20	5	40	38141
20	1.30	5	40	3407
20	1.40	5	40	3408
20	1.50	5	40	624
20	1.60	5	40	3010
20	1.80	5	40	23600
20	2.00	5	32	625
20	2.50	5	32	36690
20	3.00	5	32	626
25	0.15	8	80	42274
25	0.20	8	80	1660
25	0.25	8	80	3249
25	0.30	8	80	2421
25	0.35	8	80	1688

D ₁ js12	A ±0.01	D ₂ H6	Z	CARBURE
25	0.40	8	64	37661
25	0.50	8	64	14254
25	0.60	8	64	630
25	0.70	8	64	36365
25	0.80	8	48	632
25	0.90	8	48	633
25	1.00	8	48	634
25	1.10	8	48	2422
25	1.20	8	48	3250
25	1.30	8	48	3410
25	1.40	8	48	3412
25	1.50	8	40	35450
25	1.60	8	40	3413
25	1.80	8	40	3414
25	2.00	8	40	636
25	2.50	8	40	637
25	3.00	8	32	38971
25	4.00	8	32	3728
30	0.20	8	100	14689
30	0.25	8	100	4262
30	0.30	8	80	638
30	0.40	8	80	639
30	0.50	8	80	18429
30	0.60	8	64	18375
30	0.70	8	64	37731
30	0.80	8	64	35516
30	0.90	8	64	36052
30	1.00	8	64	2376
30	1.10	8	48	35420
30	1.20	8	48	36384
30	1.30	8	48	3417
30	1.40	8	48	2424
30	1.50	8	48	2924
30	1.60	8	48	3418
30	1.70	8	48	5948
30	1.80	8	48	6362
30	2.00	8	48	645
30	2.50	8	40	
30	2.50	8	40	6361
30	3.00	8	40	3419
30	4.00	8	40	33482
30	5.00	8	32	35095





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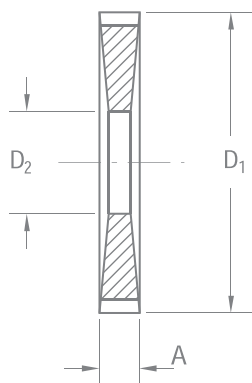
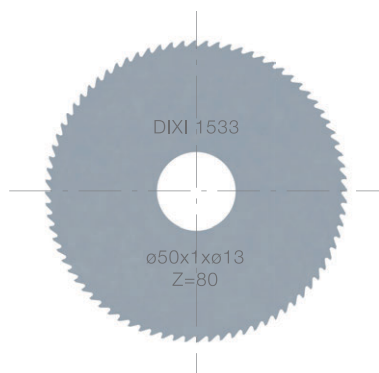
Acier + Pb	Acier faibl. allié	Acier fort. allié	Acier inox aust.	Fontes
Super alliages Ni / Co	Titane, alliage de titane	Alliage Cu Argent Or	Alliage Cu difficile	Alu
Plastique				

D ₁ js12	A ±0.01	D ₂ H6	Z	CARBURE
40	0.20	10	128	24084
40	0.25	10	100	22049
40	0.30	10	100	35370
40	0.40	10	100	4690
40	0.50	10	80	648
40	0.60	10	80	677
40	0.70	10	80	649
40	0.80	10	80	35444
40	0.90	10	80	35369
40	1.00	10	64	653
40	1.10	10	64	3253
40	1.20	10	64	36049
40	1.30	10	64	43352
40	1.40	10	64	3422
40	1.50	10	64	36050
40	1.60	10	64	36051
40	1.70	10	64	6170
40	1.80	10	64	3424
40	2.00	10	48	656
40	2.50	10	48	36648
40	3.00	10	48	658
40	4.00	10	40	3737
40	5.00	10	40	35097
50	0.20	13	128	36385
50	0.25	13	128	3426
50	0.30	13	128	659
50	0.40	13	100	35234
50	0.50	13	100	31880
50	0.60	13	100	3030
50	0.70	13	100	2957
50	0.80	13	80	661
50	0.90	13	80	3255
50	1.00	13	80	662
50	1.10	13	80	1663
50	1.20	13	80	2536
50	1.30	13	80	3429
50	1.40	13	80	43114
50	1.50	13	64	37517
50	1.60	13	64	663
50	1.70	13	64	8001
50	1.80	13	64	36336
50	2.00	13	64	37806

D ₁ js12	A ±0.01	D ₂ H6	Z	CARBURE
50	2.50	13	64	37732
50	3.00	13	48	35636
50	4.00	13	48	667
50	5.00	13	48	35109
63	0.30	16	128	5398
63	0.40	16	128	669
63	0.50	16	128	2969
63	0.60	16	100	2634
63	0.70	16	100	3207
63	0.80	16	100	36739
63	0.90	16	100	36386
63	1.00	16	100	671
63	1.20	16	80	35233
63	1.40	16	80	5093
63	1.50	16	80	2774
63	1.60	16	80	676
63	1.70	16	80	3432
63	1.80	16	80	3433
63	2.00	16	80	672
63	2.50	16	64	673
63	3.00	16	64	674
63	4.00	16	64	3748
63	5.00	16	48	31882
80	0.80	22	128	35817
80	0.90	22	128	46466
80	1.00	22	100	679
80	1.20	22	100	680
80	1.50	22	100	35721
80	1.60	22	100	19241
80	1.80	22	100	14115
80	2.00	22	80	17745
80	2.50	22	80	4030
80	3.00	22	80	684
80	4.00	22	80	21256
80	5.00	22	80	35122



DIXI 1533



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DIN
1837

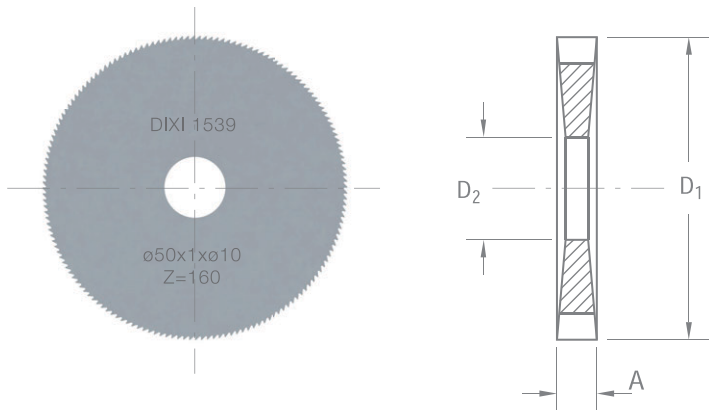
DIN
1840A

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
Plastique				

D_1 js12	$A_{\pm 0.01}$	D_2 H6	Z	CARBURE
100	0.80	22	128	685
100	1.00	22	128	35816
100	1.20	22	128	38383
100	1.50	22	100	36363
100	1.60	22	100	3438
100	1.80	22	100	6057
100	2.00	22	100	36048
100	2.50	22	100	689
100	3.00	22	80	36364
100	4.00	22	80	35138
100	5.00	22	80	35136
125	1.00	22	160	30687
125	1.20	22	128	35141
125	1.50	22	128	34954
125	2.00	22	128	34827
125	3.00	22	100	35294
160	1.20	32	160	34523
160	1.50	32	160	35299



FRAISES À FENDRE DENTURE EXTRA-FINE



P. 270



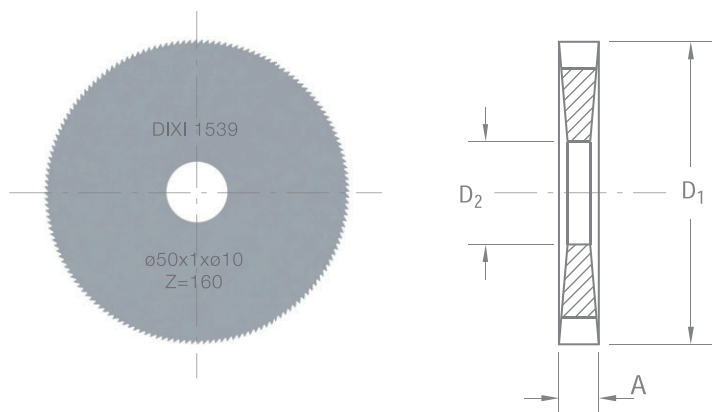
Acier + Pb	Acier faibl. allié	Acier fort. allié	Acier inox aust.	Fontes
Super alliages Ni / Co	Titane, alliage de titane	Alliage Cu Argent Or	Alliage Cu difficile	

D ₁ ±0.03	A ±0.005	D ₂ H6	Z	CARBURE
10	0.10	3	60	964494
10	0.11	3	60	964499
10	0.12	3	60	964500
10	0.13	3	60	964501
10	0.14	3	60	964502
10	0.15	3	60	964503
10	0.16	3	60	964504
10	0.17	3	60	964505
10	0.18	3	60	964506
10	0.19	3	60	964507
10	0.20	3	60	964508
10	0.22	3	60	965568
10	0.24	3	60	963179
15	0.08	5	80	45005
15	0.10	5	80	40599
15	0.11	5	80	57238
15	0.12	5	80	23559
15	0.13	5	80	46325
15	0.14	5	80	38354
15	0.15	5	80	40588
15	0.16	5	80	28784
15	0.17	5	80	57240
15	0.18	5	80	27224
15	0.19	5	80	46858
15	0.20	5	80	19385
15	0.21	5	80	66021
15	0.22	5	80	60191
15	0.23	5	80	58358
15	0.24	5	80	950356
15	0.25	5	80	19823
15	0.30	5	80	26517
15	0.35	5	80	40299
15	0.40	5	80	19825
15	0.50	5	80	19826
15	0.60	5	80	40300
15	0.70	5	80	40301
15	0.80	5	80	40302
15	0.90	5	80	40303
15	1.00	5	80	26518
15	1.10	5	80	40304
15	1.20	5	80	40305
15	1.40	5	80	40306
15	1.50	5	80	33843

D ₁ ±0.03	A ±0.005	D ₂ H6	Z	CARBURE
20	0.12	5	100	40314
20	0.14	5	100	40307
20	0.15	5	100	43684
20	0.16	5	100	4913
20	0.18	5	100	16032
20	0.20	5	100	4914
20	0.25	5	100	28665
20	0.30	5	100	28340
20	0.35	5	100	40317
20	0.40	5	100	38355
20	0.50	5	100	35628
20	0.60	5	100	40320
20	0.70	5	100	40322
20	0.80	5	100	40324
20	0.90	5	100	40326
20	1.00	5	100	40328
20	1.10	5	100	40330
20	1.20	5	100	40332
20	1.40	5	100	40334
20	1.50	5	100	40336
20	0.12	6	100	40315
20	0.14	6	100	40308
20	0.16	6	100	40309
20	0.18	6	100	40310
20	0.20	6	100	40311
20	0.25	6	100	40312
20	0.30	6	100	40313
20	0.35	6	100	40316
20	0.40	6	100	40318
20	0.50	6	100	40319
20	0.60	6	100	40321
20	0.70	6	100	40323
20	0.80	6	100	40325
20	0.90	6	100	40327
20	1.00	6	100	40329
20	1.10	6	100	40331
20	1.20	6	100	40333
20	1.40	6	100	40335
20	1.50	6	100	40337



P. 270



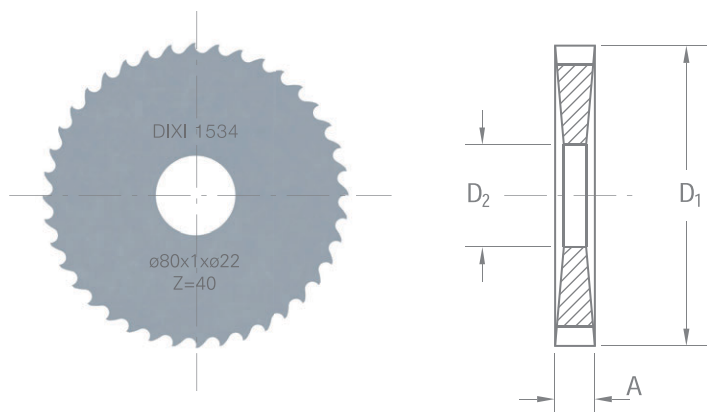
Acier + Pb	Acier faibl. allié	Acier fort. allié	Acier inox aust.	Fontes
Super alliages Ni / Co	Titane, alliage de titane	Alliage Cu Argent Or	Alliage Cu difficile	

D_1 js10	$A_{\pm 0.01}$	D_2 H6	Z	CARBURE
25	0.20	6	120	3649
25	0.25	6	120	40339
25	0.30	6	120	40341
25	0.35	6	120	40343
25	0.40	6	120	40345
25	0.50	6	120	40347
25	0.60	6	120	40349
25	0.70	6	120	40351
25	0.80	6	120	40353
25	0.90	6	120	40355
25	1.00	6	120	40357
25	1.10	6	120	40359
25	1.20	6	120	40361
25	1.40	6	120	40363
25	1.50	6	120	40365
25	0.20	8	120	40338
25	0.25	8	120	40340
25	0.30	8	120	40342
25	0.35	8	120	40344
25	0.40	8	120	40346
25	0.50	8	120	40348
25	0.60	8	120	40350
25	0.70	8	120	40352
25	0.80	8	120	40354
25	0.90	8	120	40356
25	1.00	8	120	40358
25	1.10	8	120	40360
25	1.20	8	120	40362
25	1.40	8	120	40364
25	1.50	8	120	40366
30	0.30	8	128	40367
30	0.35	8	128	40368
30	0.40	8	128	40369
30	0.50	8	128	40370
30	0.60	8	128	40371
30	0.70	8	128	40372
30	0.80	8	128	40373
30	0.90	8	128	40374
30	1.00	8	128	40375
30	1.10	8	128	40376
30	1.20	8	128	40377
30	1.40	8	128	40378
30	1.50	8	128	40379

D_1 js10	$A_{\pm 0.01}$	D_2 H6	Z	CARBURE
40	0.30	8	160	40393
40	0.35	8	160	40395
40	0.40	8	160	40397
40	0.50	8	160	40399
40	0.60	8	160	40401
40	0.70	8	160	40403
40	0.80	8	160	40405
40	0.90	8	160	40407
40	1.00	8	160	40409
40	1.20	8	160	40413
40	1.40	8	160	40415
40	1.50	8	160	40417
40	0.30	10	160	40394
40	0.35	10	160	40396
40	0.40	10	160	40398
40	0.50	10	160	40400
40	0.60	10	160	40402
40	0.70	10	160	40404
40	0.80	10	160	40406
40	0.90	10	160	40408
40	1.00	10	160	40410
40	1.10	10	160	40412
40	1.20	10	160	40414
40	1.50	10	160	40418
50	0.30	10	160	40445
50	0.40	10	160	40447
50	0.50	10	160	40448
50	0.60	10	160	40449
50	0.70	10	160	40450
50	0.80	10	160	40451
50	0.90	10	160	40452
50	1.00	10	160	40453
50	1.20	10	160	40455
50	1.50	10	160	40457

DIXI 1534

FRAISES À FENDRE DENTURE HELLER



P. 268



DIN 1838

DIN 1840A



Alu



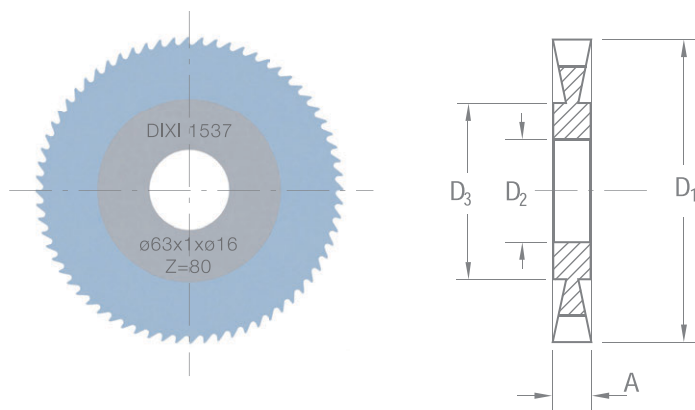
Plastique

D_1 js12	$A \pm 0.01$	D_2 H6	Z	CARBURE
20	0.30	5	32	34869
20	0.50	5	24	29836
20	0.60	5	24	29541
20	0.70	5	24	29282
20	0.80	5	24	31598
20	1.00	5	20	39176
20	1.20	5	20	42582
20	1.50	5	20	31267
20	2.00	5	16	39550
25	0.30	8	40	29785
25	0.50	8	32	42427
25	0.60	8	32	42428
25	0.80	8	24	29542
25	0.90	8	24	42430
25	1.00	8	24	30411
25	1.30	8	24	42431
25	1.50	8	20	38204
30	0.30	8	40	42434
30	0.40	8	40	42435
30	0.50	8	40	28826
30	0.60	8	32	3308
30	0.80	8	32	38804
30	1.00	8	32	38806
30	1.20	8	24	36576
30	1.30	8	24	38114
30	1.50	8	24	36577
30	1.60	8	24	38756
30	2.00	8	24	35379
40	0.50	10	40	34152
40	0.80	10	40	29793
40	1.00	10	32	32137
40	2.00	10	24	35310
50	0.50	13	48	14901
50	0.80	13	40	29704
50	1.00	13	40	5111
50	1.50	13	40	39153
50	2.00	13	32	37281

D_1 js12	$A \pm 0.01$	D_2 H6	Z	CARBURE
63	0.40	16	64	34999
63	0.50	16	64	2872
63	0.60	16	48	37364
63	0.80	16	48	29794
63	1.00	16	48	28979
63	1.30	16	40	40597
63	1.50	16	40	28990
63	1.60	16	40	41638
63	1.80	16	40	37787
63	2.00	16	40	28845
63	2.50	16	32	35380
63	3.00	16	32	28828
80	0.80	22	64	36043
80	1.00	22	48	29219
80	1.20	22	48	35967
80	1.50	22	48	18568
80	2.00	22	40	28829
100	0.80	22	64	35381
100	1.00	22	64	35429
100	1.20	22	64	35431
100	1.50	22	48	25267
100	1.60	22	48	25335
100	2.00	22	48	29408

DIXI 1537 CUTINOX

FRAISES À FENDRE POUR ACIERS INOXYDABLES



P. 272

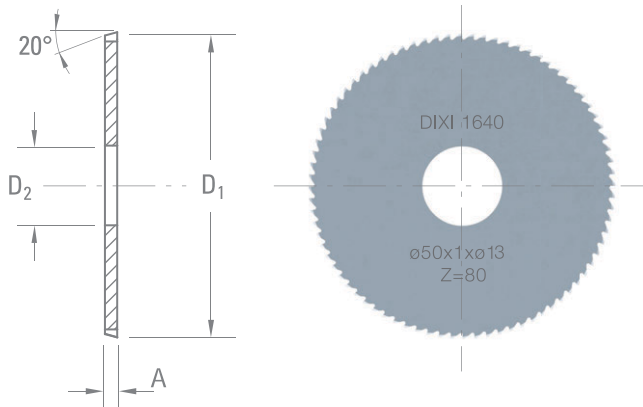


Acier + Pb	Acier faibl. allié	Acier fort. allié	Acier inox aust.	Super alliages Ni / Co
Titane, alliage de titane	Alliage Cu Argent Or	Alliage Cu difficile	Alu	Plastique

D_1 js12	$A_{\pm 0.01}$	D_3	D_2 H6	Z	CUTINOX
50	0.80	30	13	68	954330
50	1.00	30	13	68	954331
63	0.60	40	16	80	60407
63	0.80	40	16	80	60408
63	1.00	40	16	80	60409
80	0.60	50	22	100	60410
80	0.80	50	22	100	60411
80	1.00	50	22	100	60414
100	0.80	60	22	120	60412
100	1.00	60	22	120	60413

DIXI 1640 R + L

FRAISES À TRONÇONNER À DROITE ET À GAUCHE

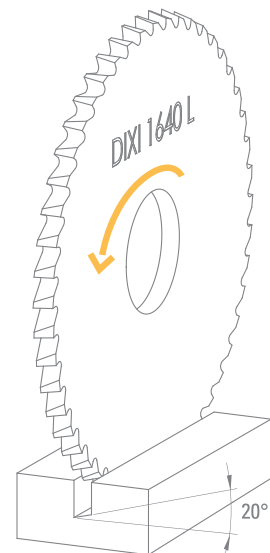


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Acier + Pb	Acier faibl. allié	Acier fort. allié	Acier inox aust.	Fontes
Super alliages Ni / Co	Titane, alliage de titane	Alliage Cu Argent Or	Alliage Cu difficile	Alu
Plastique				

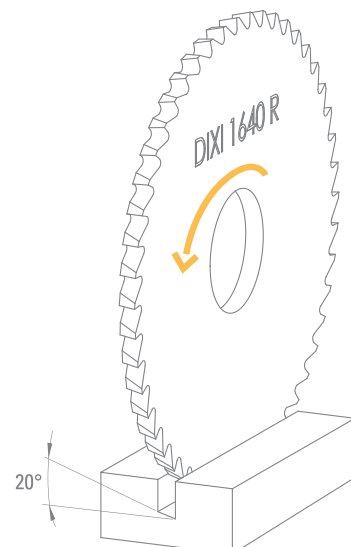
DIXI 1640 L

D ₁ js12	A ±0.01	D ₂ H6	Z	CARBURE	CUTINOX
50	0.50	13	100	977529	977548
50	0.80	13	80	977530	957215
50	1.00	13	80	977531	977549
63	0.50	16	128	977532	977552
63	0.80	16	100	954255	977553
63	1.00	16	100	977533	955787
80	0.80	22	128	975393	975569
80	1.00	22	100	977534	977554
100	0.80	22	100	977535	977555
100	1.00	22	100	977536	977556



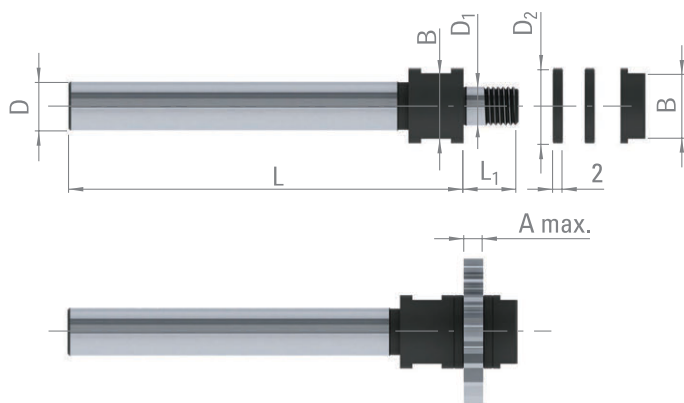
DIXI 1640 R

D ₁ js12	A ±0.01	D ₂ H6	Z	CARBURE	CUTINOX
50	0.50	13	100	977520	977537
50	0.80	13	80	977521	977538
50	1.00	13	80	59024	977539
63	0.50	16	128	977522	977540
63	0.80	16	100	977523	977541
63	1.00	16	100	977524	977542
80	0.80	22	128	977525	977543
80	1.00	22	100	977526	977544
100	0.80	22	100	977527	977545
100	1.00	22	100	977528	977547



DIXI 2713

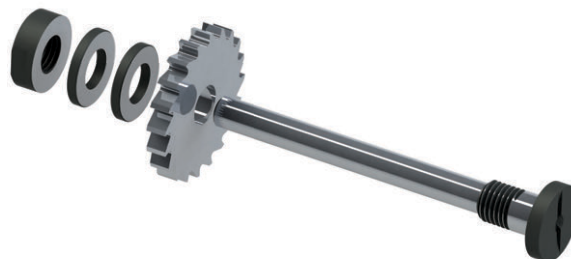
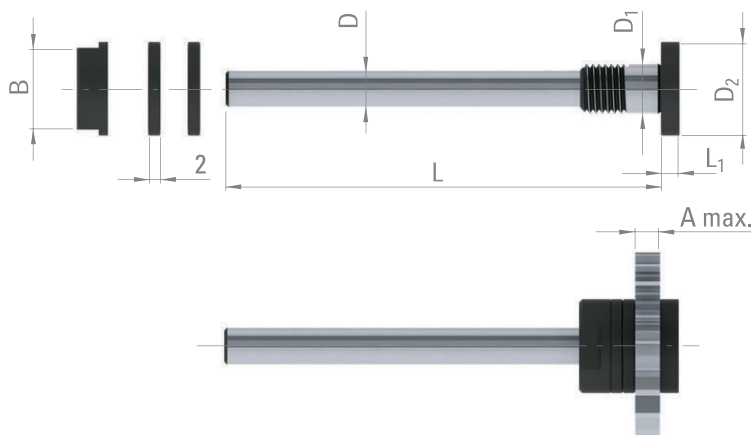
TASSEaux PORTE-FRAISES AVEC SERRAGE AVANT



$D_{1\ h6}$	D_{h6}	D_2	L	L_1	B	$A_{max.}$	Art.
3.00	5	5	60	7.0	4	3	968329
5.00	6	10	70	10.0	8	6	953911
5.00	10	10	80	10.0	8	6	953917
6.00	10	12	80	10.5	10	6	953918
8.00	10	15	80	10.0	13	6	954975
8.00	12	15	90	11.0	13	6	953919
10.00	10	18	80	10.5	15	6	954976
10.00	16	18	100	11.5	15	6	953920
13.00	16	22	110	12.0	19	6	953921
16.00	20	26	120	13.0	22	6	953922

DIXI 2714

TASSEaux PORTE-FRAISES AVEC SERRAGE ARRIÈRE

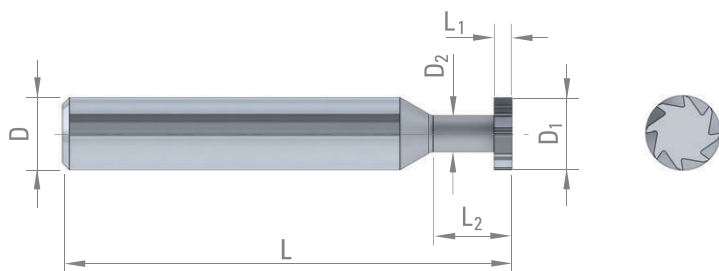


$D_{1\ h6}$	D_{h6}	D_2	L	L_1	B	$A_{max.}$	Art.
5.00	4	10	50	3.0	8	6	953923
6.00	5	12	60	3.0	10	6	953924
8.00	6	15	70	3.0	13	6	953925
8.00	7	15	80	3.0	13	6	953926
10.00	6	18	70	3.5	15	6	953927
10.00	8	18	90	3.5	15	6	953928
13.00	10	22	110	3.5	19	6	953929
16.00	12	26	120	3.5	22	6	953930

FRAISES À T DENTURE DROITE



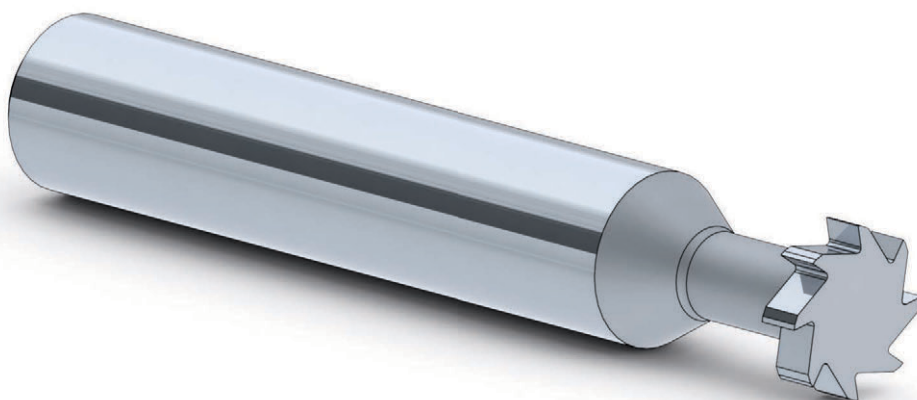
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Acier + Pb	Acier faibl. allié	Acier fort. allié	Acier inox aust.	Fontes
Super alliages Ni / Co	Titane, alliage de titane	Alliage Cu Argent Or	Alliage Cu difficile	Alu
Plastique				

D ₁ Ø < 4.0 ±0.01 Ø ≥ 4.0 -0.05/-0.10	L ₁	D ₂ 0/-0.20	L ₂ ±0.2	D _{h5}	L	Z	CARBURE	CUTINOX
2.0	0.2 - 1.0	1.0	3.0	4	42	3 - 6	□	■
3.0	0.2 - 1.5	1.5	3.5	4	42	3 - 6	□	■
4.0	0.2 - 1.5	2.5	6.0	4	42	3 - 6	□	■
5.0	0.5 - 1.5	3.0	6.0	5	42	3 - 6	□	■
6.0	0.5 - 2.5	3.5	7.0	6	42	4 - 8	□	■
8.0	0.5 - 3.0	4.0	9.0	8	50	5 - 10	□	■
10.0	0.5 - 4.0	5.0	9.0	10	50	5 - 12	□	■
12.0	0.5 - 3.5	5.0	11.5	6	50	6 - 16	□	■
12.0	0.5 - 4.0	6.0	14.0	10	50	6 - 16	□	■
15.0	0.5 - 5.0	8.0	14.0	10	60	8 - 18	□	■
16.0	0.5 - 2.9	8.0	14.0	10	60	8 - 20	□	■
16.0	3.0 - 6.0	8.0	14.0	10	60	8 - 20	□	■
18.0	0.5 - 2.9	8.0	14.0	10	60	10 - 24	□	■
18.0	3.0 - 6.0	8.0	14.0	10	60	10 - 24	□	■
20.0	0.5 - 2.9	8.0	11.0	10	60	10 - 24	□	■
20.0	3.0 - 6.0	8.0	14.0	10	60	10 - 24	□	■
25.0	0.5 - 3.9	8.0	13.0	10	60	10 - 32	□	■
25.0	4.0 - 8.0	8.0	18.0	10	60	10 - 32	□	■
30.0	0.5 - 3.9	8.0	13.0	10	60	10 - 36	□	■
30.0	4.0 - 8.0	8.0	18.0	10	60	10 - 36	□	■

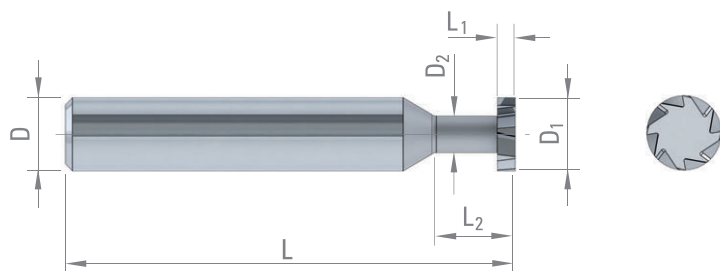
Produit semi-fini, disponible de stock, adaptable selon vos besoins.



FRAISES À T
DENTURE ALTERNÉE



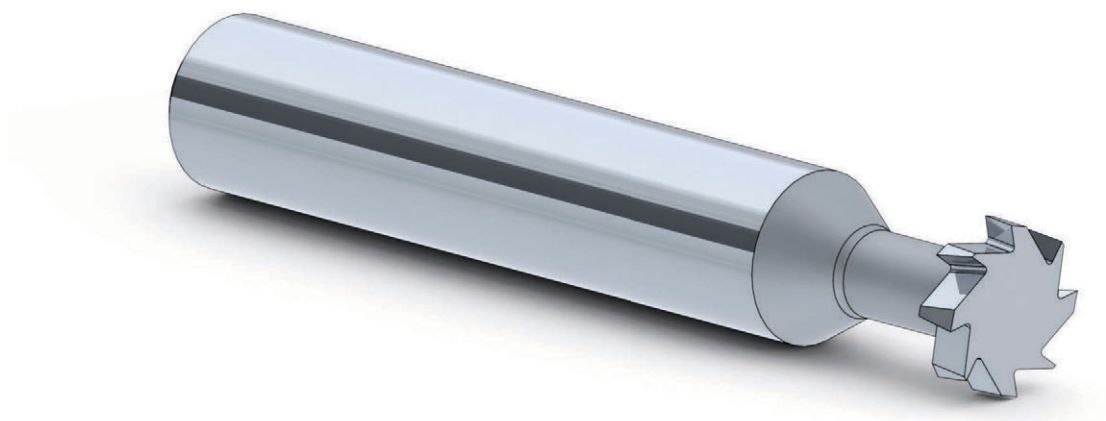
P. 274



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
Plastique				

D ₁ Ø < 4.0 ±0.01 Ø ≥ 4.0 -0.05/-0.10	L ₁	D ₂ 0/-0.20	L ₂ ±0.2	D _{h5}	L	Z	CARBURE	CUTINOX
4.0	0.5 - 3.0	2.5	6.0	4	42	4 - 6	□	■
5.0	0.5 - 3.0	3.0	6.0	5	42	4 - 6	□	■
6.0	0.5 - 3.0	3.5	7.0	6	42	4 - 6	□	■
8.0	1.0 - 4.0	4.0	9.0	8	50	4 - 8	□	■
10.0	1.0 - 4.0	5.0	9.0	10	50	6 - 10	□	■
12.0	0.5 - 3.5	5.0	11.5	6	50	6 - 10	□	■
12.0	1.0 - 5.0	6.0	14.0	10	50	6 - 10	□	■
15.0	1.5 - 6.0	8.0	14.0	10	60	8 - 14	□	■
16.0	1.5 - 3.9	8.0	14.0	10	60	8 - 14	□	■
16.0	4.0 - 6.0	8.0	14.0	10	60	8 - 14	□	■
18.0	1.5 - 3.9	8.0	14.0	10	60	10 - 16	□	■
18.0	4.0 - 6.0	8.0	14.0	10	60	10 - 16	□	■
20.0	1.5 - 3.9	8.0	11.0	10	60	10 - 18	□	■
20.0	4.0 - 6.0	8.0	14.0	10	60	10 - 18	□	■
25.0	1.5 - 4.9	8.0	13.0	10	60	10 - 24	□	■
25.0	5.0 - 10.0	8.0	18.0	10	60	14 - 24	□	■
30.0	1.5 - 4.9	8.0	13.0	10	60	18 - 28	□	■
30.0	5.0 - 10.0	8.0	18.0	10	60	18 - 28	□	■

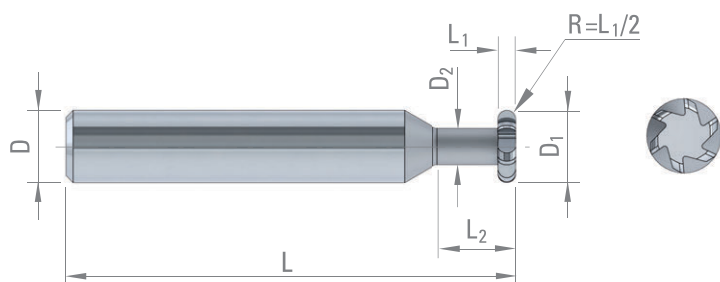
Produit semi-fini, disponible de stock, adaptable selon vos besoins.



FRAISES À T
1/2 RONDES, CONVEXES



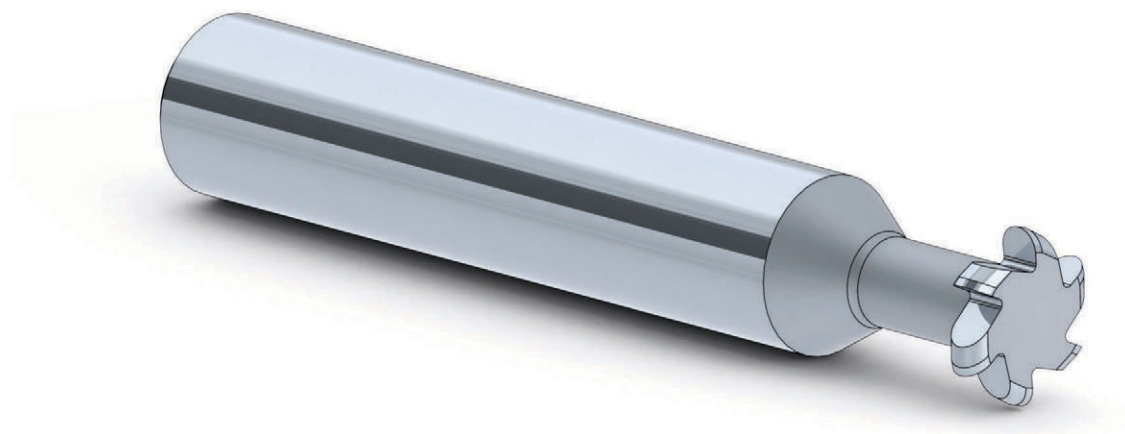
P. 274



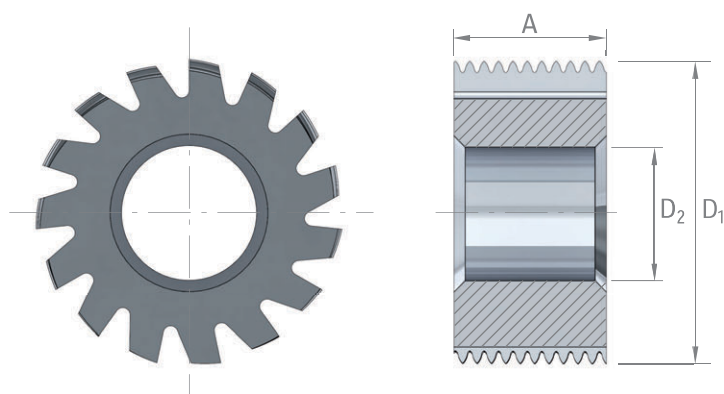
Acier + Pb	Acier faibl. allié	Acier fort. allié	Acier inox aust.	Fontes
Super alliages Ni / Co	Titane, alliage de titane	Alliage Cu Argent Or	Alliage Cu difficile	Alu
Plastique				

D ₁ Ø < 4.0 ±0.03 Ø ≥ 4.0 -0.05/-0.10	L ₁	D ₂ 0/-0.20	L ₂ ±0.2	D _{h5}	L	Z	CARBURE	CUTINOX
4.0	0.4 - 1.5	1.5	6.0	4	42	4	☐	☐
6.0	0.5 - 2.0	3.5	7.0	6	42	6	☐	☐
8.0	1.0 - 3.0	4.0	9.0	8	50	6	☐	☐
10.0	1.0 - 4.0	5.0	9.0	10	50	8	☐	☐
12.0	0.5 - 3.5	5.0	11.5	6	50	10	☐	☐
12.0	1.0 - 5.0	6.0	14.0	10	50	10	☐	☐
16.0	1.0 - 6.0	8.0	14.0	10	60	12	☐	☐

Produit semi-fini, disponible de stock, adaptable selon vos besoins.



Autres possibilités de dentures et formes page 275

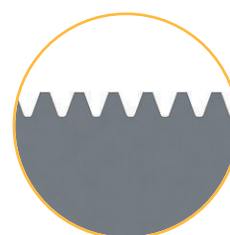
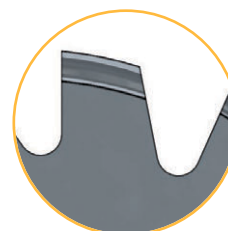
FRAISES-MÈRES
EPICYCLOÏDALES ET DÉVELOPPANTES


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

D_1	A	D_{2H3}	Z	CARBURE
6	4	3.5	12	
	5	3.5	12	
	6	3.5	12	
8	4	3.5	15	
	5	3.5	12	
	6	3.5	12	
10	4	3.5	15	
	5	3.5	12	
	6	3.5	12	
	6	4.5	12	
	6	4.5	15	
12	6	3.5	15	
	6	4.5	12	
	6	4.5	15	
	6	5.0	12	
	6	5.0	15	
	6	6.0	12	
	6	6.0	15	
	8	4.5	15	
	8	5.0	15	
	8	6.0	15	
16	10	8.0	12	
	6	8.0	12	
	6	8.0	15	
	8	8.0	12	
	8	8.0	15	
	10	8.0	12	
	10	8.0	15	
18	16	8.0	12	
	6	6.0	12	
	6	8.0	12	
	6	8.0	15	
	8	8.0	12	
	8	8.0	15	
	10	8.0	12	
24	10	8.0	15	
	10	8.0	12	
	12	8.0	12	
	12	8.0	15	
	16	8.0	12	
	16	8.0	15	
	16	10.0	12	

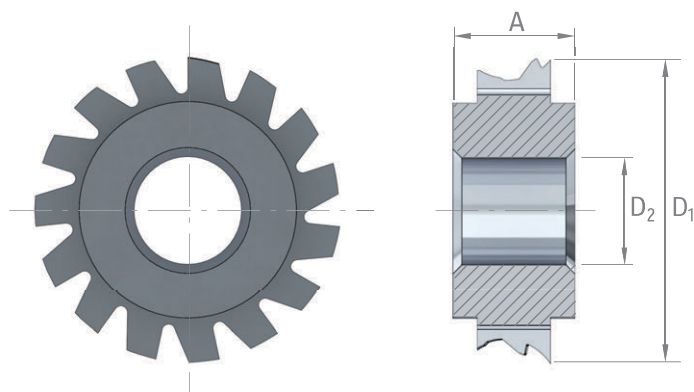
Module (m) = 0.04 - 1.00

DIXI 1675
Epicycloïdale

DIXI 1680
Développante

Profil logarithmique
réaffûtable


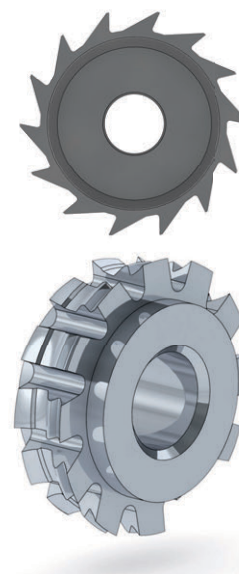
Revêtements sur demande

FRAISES-MÈRES
INDEX



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

D ₁	A	D ₂ H3	Z	CARBURE
6	4	3.5	12	☐
6	5	3.5	12	☐
6	6	3.5	12	☐
8	5	3.5	12	☐
8	6	3.5	12	☐
10	5	3.5	12	☐
10	6	3.5	12	☐
10	6	4.5	12	☐
12	6	4.5	12	☐
12	6	5.0	12	☐
12	6	6.0	12	☐
16	6	8.0	12	☐
16	8	8.0	12	☐
16	10	8.0	12	☐
18	6	6.0	12	☐
18	8	8.0	12	☐
18	10	8.0	12	☐
24	6	8.0	12	☐
24	8	8.0	12	☐
24	10	8.0	12	☐
24	12	8.0	12	☐



Revêtements sur demande

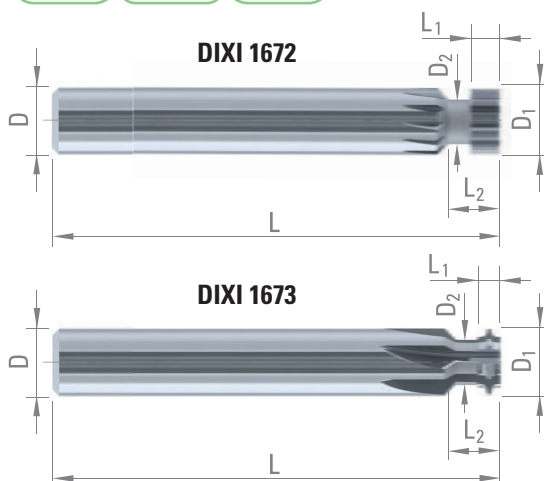
DIXI 1672 - 1673 OUTILS SUR DEMANDE

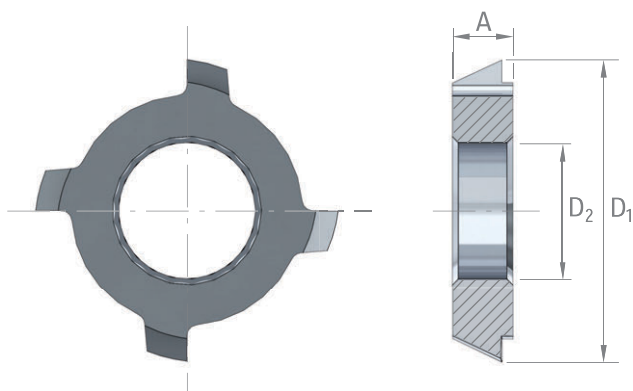
FRAISES-MÈRES

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

D ₁	L ₁	D ₂	L ₂	D _{h5}	L	Z	CARBURE
4.0	4.0	2.4	4.0	4	40	6-10	☐
5.0	4.0	3.0	4.0	5	40	6-10	☐
5.0	4.0	4.0	4.0	6	40	6-10	☐
6.0	4.0	4.0	4.0	6	40	6-10	☐

D ₁	L ₁	D ₂	L ₂	D _{h5}	L	Z	CARBURE
4.0	2.0	2.4	4.0	4	40	5	☐
5.0	2.0	3.0	4.0	5	40	6	☐
5.0	2.0	4.0	4.0	6	40	6	☐
6.0	2.0	4.0	4.0	6	40	6	☐

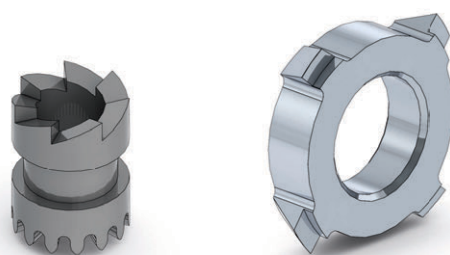


**FRAISES-MÈRES
TAILLAGE FRONTAL**


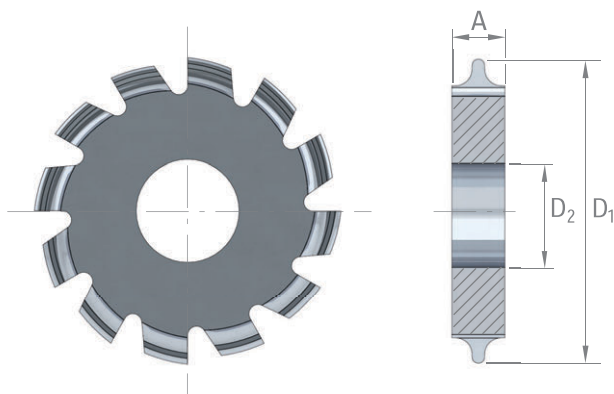
Acier + Pb	Acier faibl. allié	Acier fort. allié	Acier inox aust.	Titane, alliage de titane
Alliage Cu Argent Or	Alliage Cu difficile	Alu		

D ₁	A	D _{2 H3}	Z	CARBURE
10	2	4.5	4	☐
10	2	4.5	5	☐
10	2	4.5	6	☐
12	2	4.5	2	☐
12	2	4.5	3	☐
12	2	4.5	4	☐
12	2	4.5	5	☐
12	2	4.5	6	☐

Module (m) = 0.03 - 1.00



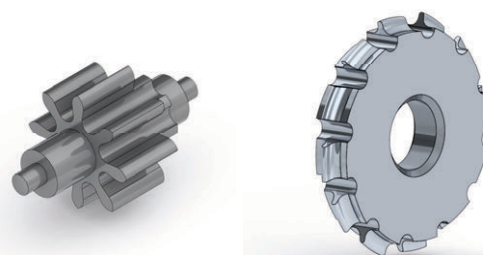
Revêtements sur demande

DIXI 1674 OUTILS SUR DEMANDE
**FRAISES MODULE
TAILLAGE DENT PAR DENT**


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

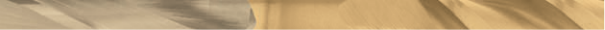
D ₁	A	D _{2 H3}	Z	CARBURE
6	4	3.5	12	☐
8	5	3.5	12	☐
8	6	3.5	12	☐
10	2	3.5	12	☐
10	2	4.5	12	☐
10	2	5.0	12	☐
10	5	3.5	12	☐
10	6	3.5	12	☐
12	2	3.5	12	☐
12	2	4.5	12	☐
12	6	5.0	12	☐
16	6	8.0	12	☐
18	6	8.0	12	☐
24	6	8.0	12	☐

Module (m) = 0.03 - 1.00



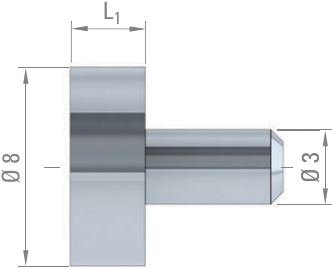
Revêtements sur demande





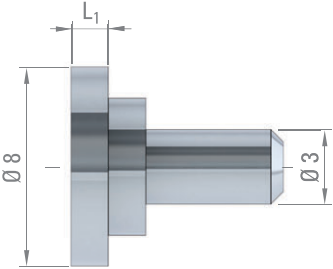
CIBLES DE ROULAGE

DIXI 0700-A



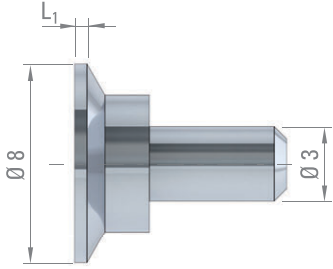
Epaisseur L_1 de 3 à 5 mm
Jusqu'à 8 encoches

DIXI 0700-B



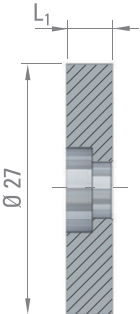
Epaisseur L_1 de 1 à 2.99 mm
Jusqu'à 8 encoches

DIXI 0700-C



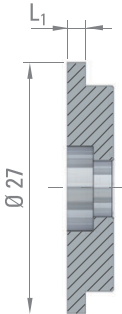
Epaisseur L_1 de 0.05 à 0.99 mm
Jusqu'à 8 encoches

DIXI 0710-D



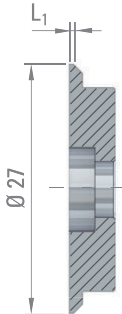
Epaisseur L_1 5 mm
Jusqu'à 24 encoches

DIXI 0710-E



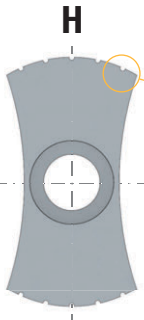
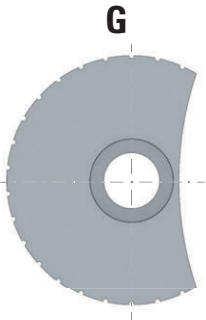
Epaisseur L_1 de 1 à 4 mm
Jusqu'à 24 encoches

DIXI 0710-F

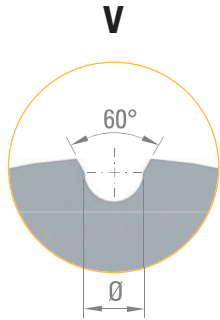
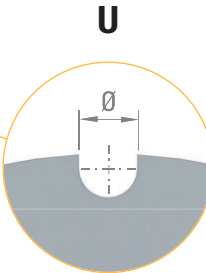


Epaisseur L_1 de 0.05 à 0.99 mm
Jusqu'à 24 encoches

Formes de cibles spéciales pour DIXI 0710



Formes d'encoches



A remplir pour la commande, svp.

	Nombre de cibles	Réf. DIXI	Epaisseur L_1	Forme de cible G ou H	Forme d'encoche U ou V	Ø encoches	Nombre d'encoches
Ex.	1	0710-E	1	G	U	0.20	3
					V	0.24	5





INFOS DE LA PIÈCE À TAILLER

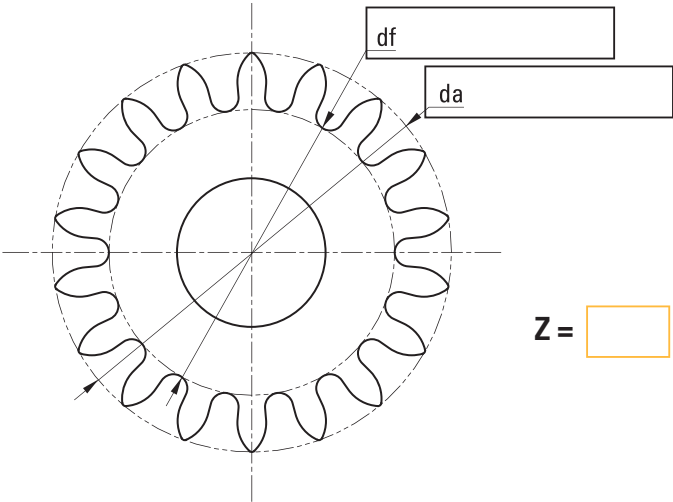
Norme

Plan

DXF

Matière à usiner

Module (m)



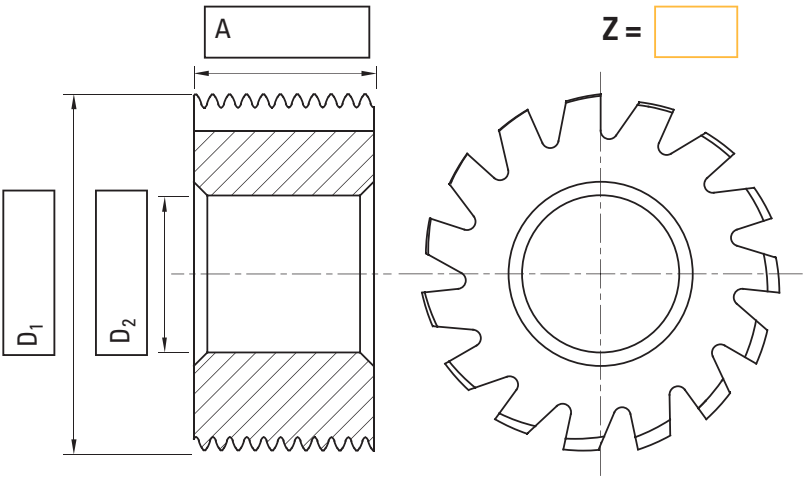
DIXI 1675

Angle d'hélice (profil) ☐ R ☐ L ☐

Nombre de filets

Revêtement

Quantité



DIXI 1672

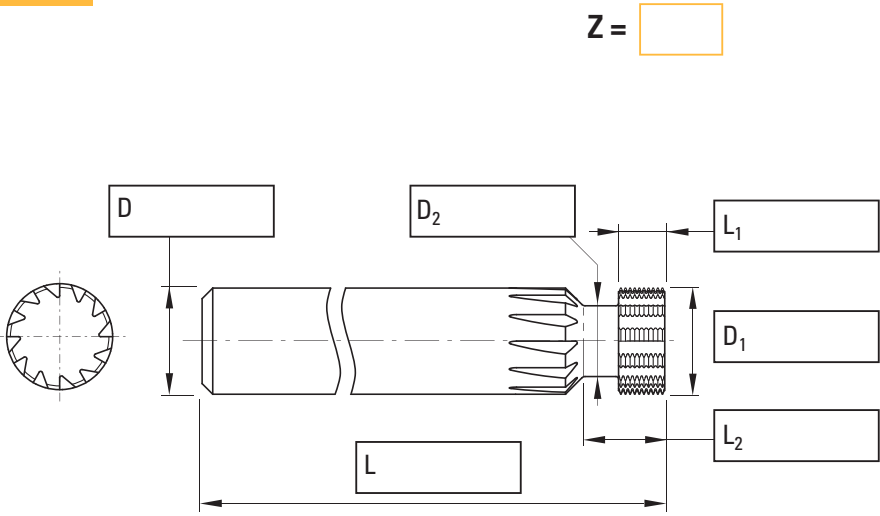
Angle d'hélice (profil) ☐ R ☐ L ☐

Nombre de filets

Revêtement

Quantité

Remarques





INFOS DE LA PIÈCE À TAILLER

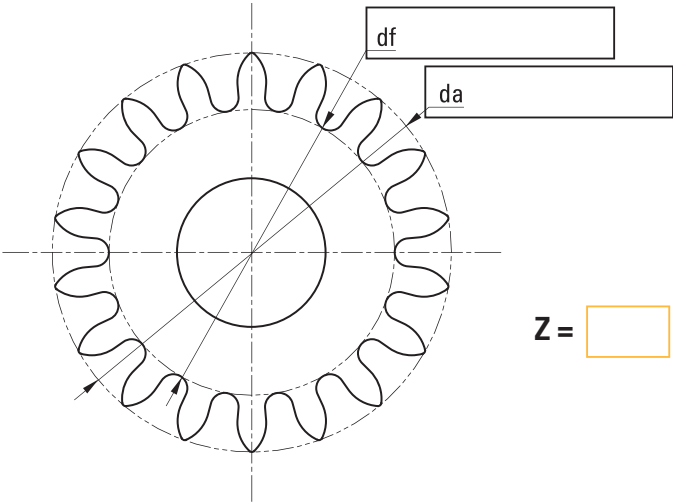
Norme

Plan

DXF

Matière à usiner

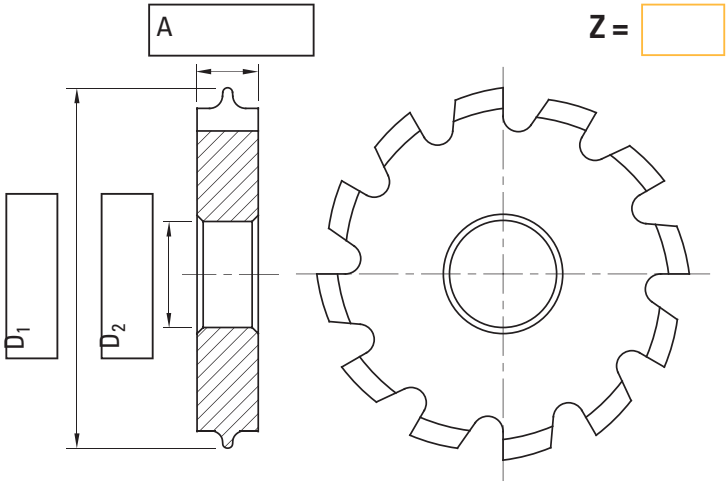
Module (m)



DIXI 1674

Revêtement

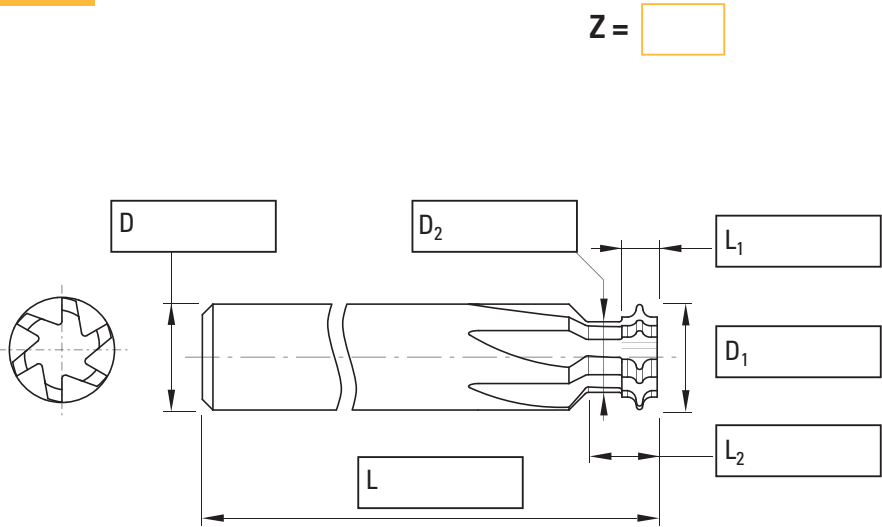
Quantité



DIXI 1673

Revêtement

Quantité



Remarques

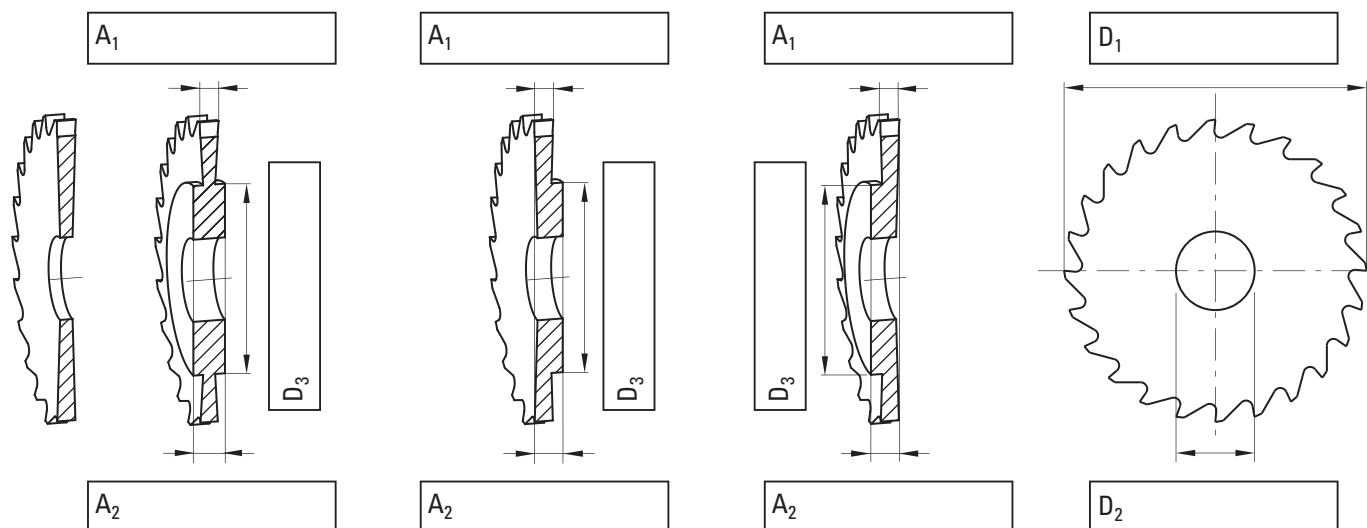




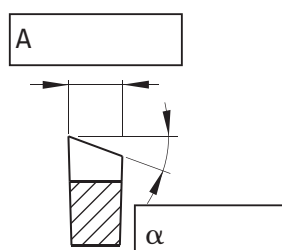
OUTILS SUR DEMANDE

Quantités

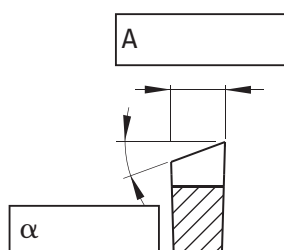
Matière à usiner



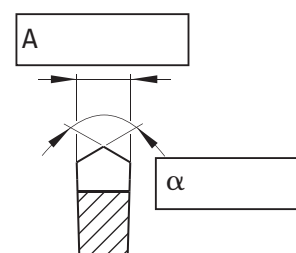
1640 L



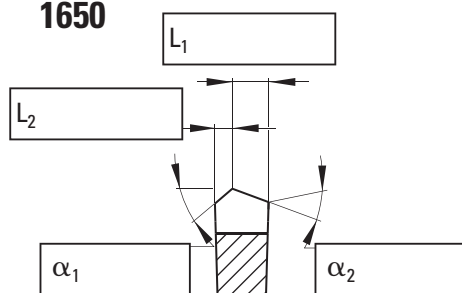
1640 R



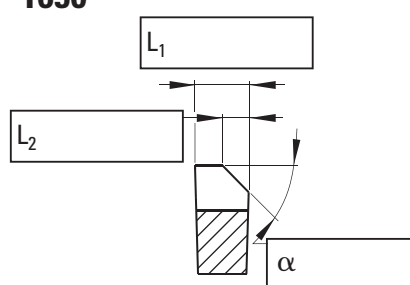
1643



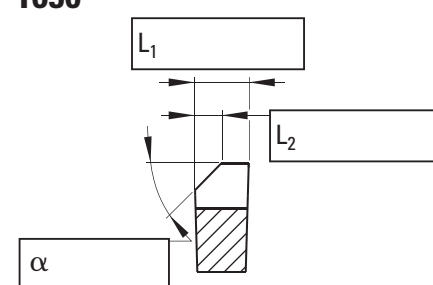
1650



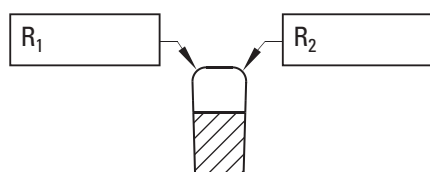
1650



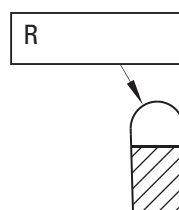
1650



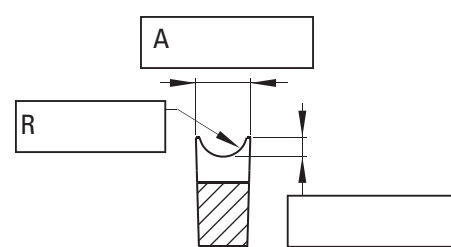
1650



1654



1650





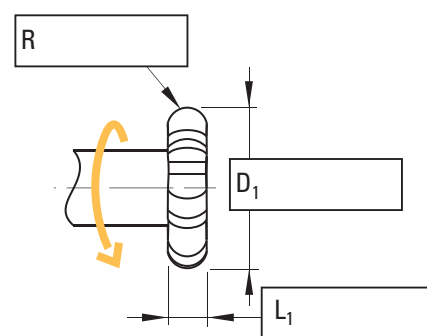
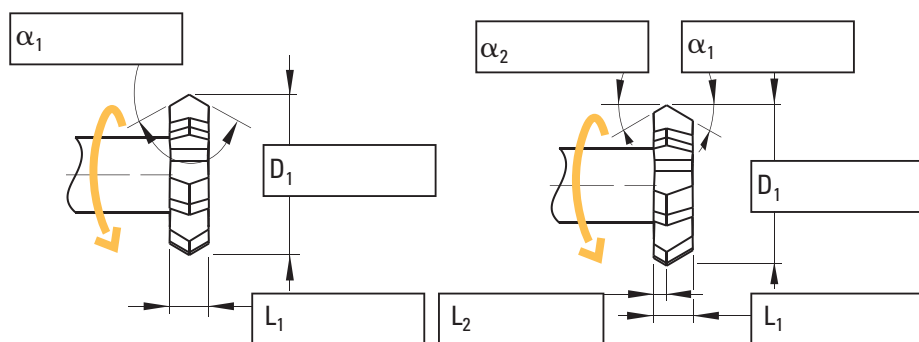
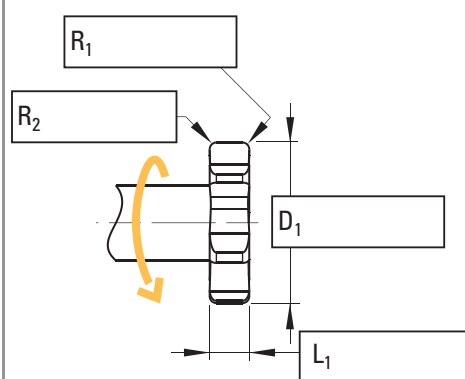
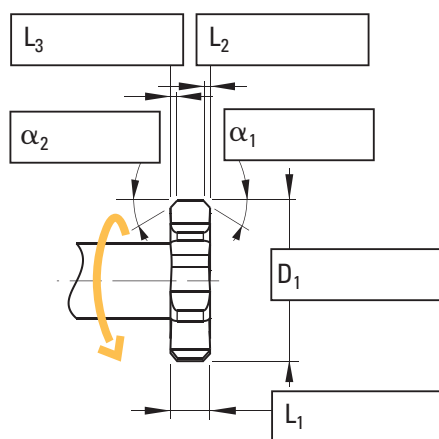
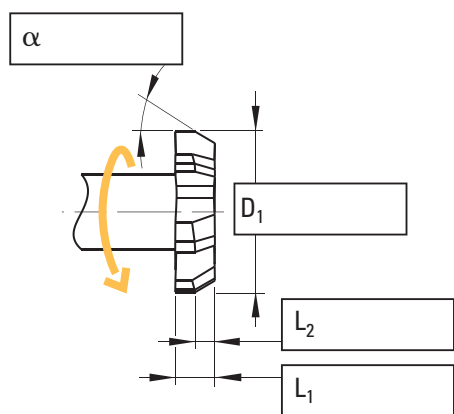
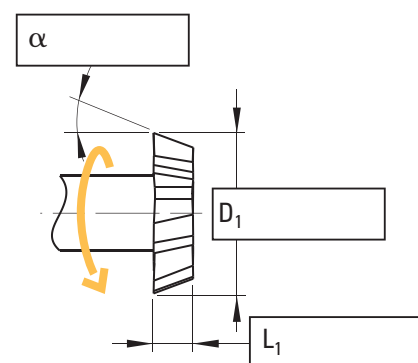
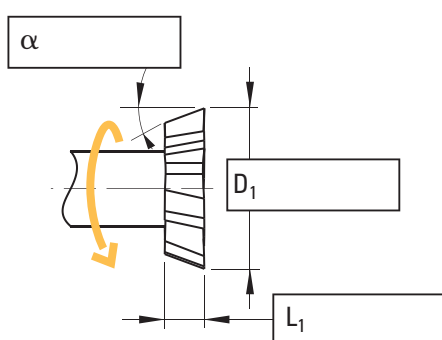
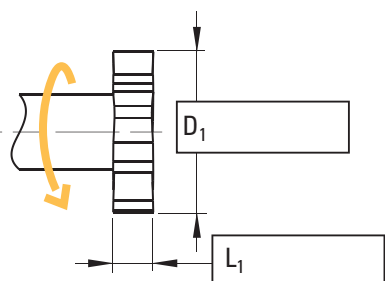
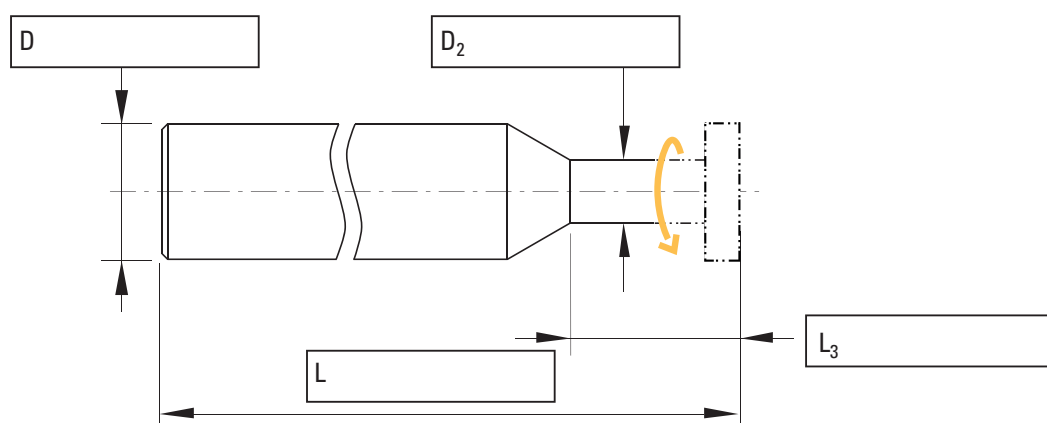
OUTILS SUR DEMANDE

FRAISES À T

Z =

Quantités

Matière à usiner



CONSULTEZ NOTRE FORMULAIRE DE DEMANDE D'OFFRES EN LIGNE SUR
WWW.DIXIPOLYTOOL.COM



CONDITIONS DE COUPE

Matières à usiner

CARBURE

Vc [m/min]

P	Acier non allié / faiblement allié	< 600 N/mm ²	80	140
P	Acier non allié / faiblement allié	600 – 1500 N/mm ²	50	80
P	Acier de décolletage au plomb		120	160
P	Acier fortement allié	700 – 1500 N/mm ²	50	80
M	Acier inoxydable	400 – 700 N/mm ²	80	120
M	Acier inox. DUPLEX, acier austénitique inox. sans nickel	> 800 N/mm ²	50	80
K	Fonte grise / Fonte à graphite sphéroïdal perlitique	< 250 HB	80	140
K	Fonte alliée / Fonte à graphite sphéroïdal perlitique	> 250 HB	50	80
K	Fonte à graphite sphéroïdal ferritique / Fonte malléable		50	80
S	Super alliages / Acier inox. réfractaire	Inconel Nimonic Hastelloy	20	30
S	Titane, alliage de titane		30	70
N	Alliage de cuivre / bonne usinabilité (laiton – bronze)		200	450
N	Alliage de cuivre / usinabilité difficile / Bronze à l'aluminium	(CuAlFe) (Ampco)	150	300
N	Alliage d'aluminium	Si < 8%	200	500
N	Fonte d'aluminium	Si > 8%	200	450
N	Plastique		130	200
N	Or, argent		140	180

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

$$V_f \text{ [mm/min]} = n \text{ [tr/min]} \times f_z \text{ [mm]} \times z$$

Avance par dent **fz [mm]**

Ø D ₁ 15 - 30	Ø D ₁ 30 - 50	Ø D ₁ 50 - 80	Ø D ₁ 80 - 125	Ø D ₁ 125 - 160
0.002 - 0.004	0.003 - 0.007	0.004 - 0.008	0.004 - 0.012	0.004 - 0.012
0.001 - 0.004	0.002 - 0.005	0.002 - 0.008	0.003 - 0.012	0.003 - 0.012
0.003 - 0.007	0.004 - 0.008	0.005 - 0.010	0.005 - 0.010	0.005 - 0.012
0.001 - 0.004	0.002 - 0.005	0.002 - 0.008	0.003 - 0.012	0.003 - 0.012
0.001 - 0.004	0.002 - 0.005	0.002 - 0.008	0.003 - 0.012	0.003 - 0.012
0.001 - 0.004	0.002 - 0.005	0.002 - 0.008	0.003 - 0.012	0.003 - 0.012
0.002 - 0.004	0.003 - 0.007	0.004 - 0.01	0.004 - 0.01	0.004 - 0.01
0.001 - 0.004	0.002 - 0.005	0.002 - 0.008	0.003 - 0.012	0.003 - 0.012
0.002 - 0.004	0.003 - 0.007	0.004 - 0.01	0.004 - 0.01	0.004 - 0.01
0.001 - 0.004	0.002 - 0.005	0.002 - 0.008	0.003 - 0.012	0.003 - 0.012
0.001 - 0.004	0.002 - 0.005	0.002 - 0.008	0.003 - 0.012	0.003 - 0.012
0.003 - 0.007	0.004 - 0.008	0.005 - 0.010	0.005 - 0.010	0.005 - 0.012
0.001 - 0.004	0.002 - 0.005	0.002 - 0.008	0.003 - 0.012	0.003 - 0.012
0.003 - 0.007	0.004 - 0.008	0.005 - 0.010	0.005 - 0.010	0.005 - 0.012
0.003 - 0.007	0.004 - 0.008	0.005 - 0.010	0.005 - 0.010	0.005 - 0.012
0.003 - 0.010	0.004 - 0.010	0.005 - 0.012	0.005 - 0.012	0.005 - 0.015
0.003 - 0.007	0.004 - 0.008	0.005 - 0.010	0.005 - 0.010	0.005 - 0.012



CONDITIONS DE COUPE

Matières à usiner

CARBURE

Vc [m/min]

P	Acier non allié / faiblement allié	< 600 N/mm ²	80	140
P	Acier non allié / faiblement allié	600 – 1500 N/mm ²	50	80
P	Acier de décolletage au plomb		120	160
P	Acier fortement allié	700 – 1500 N/mm ²	50	80
M	Acier inoxydable	400 – 700 N/mm ²	80	120
M	Acier inox. DUPLEX, acier austénitique inox. sans nickel	> 800 N/mm ²	50	80
K	Fonte grise / Fonte à graphite sphéroïdal perlitique	< 250 HB	80	140
K	Fonte alliée / Fonte à graphite sphéroïdal perlitique	> 250 HB	50	80
K	Fonte à graphite sphéroïdal ferritique / Fonte malléable		50	80
S	Super alliages / Acier inox. réfractaire	Inconel Nimonic Hastelloy	20	30
S	Titane, alliage de titane		30	70
N	Alliage de cuivre / bonne usinabilité (laiton – bronze)		200	450
N	Alliage de cuivre / usinabilité difficile / Bronze à l'aluminium	(CuAlFe) (Ampco)	150	300

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

$$V_f \text{ [mm/min]} = n \text{ [tr/min]} \times f_z \text{ [mm]} \times z$$

Avance par dent **fz [mm]**

Ø D ₁ 15 - 30	Ø D ₁ 30 - 40	Ø D ₁ 40 - 50	
0.0003 - 0.003	0.0003 - 0.003	0.0003 - 0.003	
0.0003 - 0.003	0.0003 - 0.003	0.0003 - 0.003	
0.0004 - 0.004	0.0004 - 0.004	0.0004 - 0.004	
0.0002 - 0.002	0.0002 - 0.002	0.0002 - 0.002	
0.0002 - 0.002	0.0002 - 0.002	0.0002 - 0.002	
0.0002 - 0.002	0.0002 - 0.002	0.0002 - 0.002	
0.0004 - 0.004	0.0004 - 0.004	0.0004 - 0.004	
0.0003 - 0.003	0.0003 - 0.003	0.0003 - 0.003	
0.0003 - 0.003	0.0003 - 0.003	0.0003 - 0.003	
0.0002 - 0.002	0.0002 - 0.002	0.0002 - 0.002	
0.0003 - 0.003	0.0003 - 0.003	0.0003 - 0.003	
0.0005 - 0.005	0.0005 - 0.005	0.0005 - 0.005	
0.0004 - 0.004	0.0004 - 0.004	0.0004 - 0.004	



CONDITIONS DE COUPE

Matières à usiner

CARBURE

Vc [m/min]

P	Acier non allié / faiblement allié	< 600 N/mm ²	150	200
P	Acier non allié / faiblement allié	600 – 1500 N/mm ²	120	170
P	Acier de décolletage au plomb		150	200
P	Acier fortement allié	700 – 1500 N/mm ²	100	150
M	Acier inoxydable	400 – 700 N/mm ²	180	150
M	Acier inox. DUPLEX, acier austénitique inox. sans nickel	> 800 N/mm ²	100	150
K	Fonte grise / Fonte à graphite sphéroïdal perlitique	< 250 HB	250	350
K	Fonte allée / Fonte à graphite sphéroïdal perlitique	> 250 HB	180	250
K	Fonte à graphite sphéroïdal ferritique / Fonte malléable		150	250
S	Super alliages / Acier inox. réfractaire	Inconel Nimonic Hastelloy	50	100
S	Titane, alliage de titane		80	150
N	Alliage de cuivre / bonne usinabilité (laiton – bronze)		250	400
N	Alliage de cuivre / usinabilité difficile / Bronze à l'aluminium	(CuAlFe) (Ampco)	180	300
N	Alliage d'aluminium	Si < 8%	250	400
N	Fonte d'aluminium	Si > 8%	200	350
N	Plastique		100	250
N	Or, argent		180	300

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

$$V_f \text{ [mm/min]} = n \text{ [tr/min]} \times f_z \text{ [mm]} \times z$$

Avance par dent **fz [mm]**

Ø D ₁ 50	Ø D ₁ 63	Ø D ₁ 80	Ø D ₁ 100	
0.002 - 0.008	0.002 - 0.008	0.002 - 0.008	0.002 - 0.008	
0.002 - 0.007	0.002 - 0.007	0.002 - 0.007	0.002 - 0.007	
0.002 - 0.009	0.002 - 0.009	0.002 - 0.009	0.002 - 0.009	
0.002 - 0.006	0.002 - 0.006	0.002 - 0.006	0.002 - 0.006	
0.002 - 0.006	0.002 - 0.006	0.002 - 0.006	0.002 - 0.006	
0.001 - 0.005	0.001 - 0.005	0.001 - 0.005	0.001 - 0.005	
0.003 - 0.009	0.003 - 0.009	0.003 - 0.009	0.003 - 0.009	
0.002 - 0.008	0.002 - 0.008	0.002 - 0.008	0.002 - 0.008	
0.002 - 0.008	0.002 - 0.008	0.002 - 0.008	0.002 - 0.008	
0.001 - 0.004	0.001 - 0.004	0.001 - 0.004	0.001 - 0.004	
0.002 - 0.008	0.002 - 0.008	0.002 - 0.008	0.002 - 0.008	
0.003 - 0.011	0.003 - 0.011	0.003 - 0.011	0.003 - 0.011	
0.003 - 0.010	0.003 - 0.010	0.003 - 0.010	0.003 - 0.010	
0.003 - 0.011	0.0033 - 0.011	0.003 - 0.011	0.003 - 0.011	
0.002 - 0.009	0.002 - 0.009	0.002 - 0.009	0.002 - 0.009	
0.003 - 0.010	0.004 - 0.010	0.005 - 0.012	0.005 - 0.012	
0.002 - 0.009	0.002 - 0.009	0.002 - 0.009	0.002 - 0.009	



CONDITIONS DE COUPE

Matières à usiner

			CARBURE	CUTINOX
			Vc [m/min]	Vc [m/min]
P	Acier non allié / faiblement allié	< 600 N/mm ²	70 100	
P	Acier non allié / faiblement allié	600 – 1500 N/mm ²	70 90	
P	Acier de décolletage au plomb			70 100
P	Acier fortement allié	700 – 1500 N/mm ²		40 70
M	Acier inoxydable	400 – 700 N/mm ²		60 90
M	Acier inox. DUPLEX, acier austénitique inox. sans nickel	> 800 N/mm ²		40 70
K	Fonte grise / Fonte à graphite sphéroïdal perlitique	< 250 HB	70 100	90 110
K	Fonte allée / Fonte à graphite sphéroïdal perlitique	> 250 HB	40 70	70 90
K	Fonte à graphite sphéroïdal ferritique / Fonte malléable		70 100	90 110
S	Super alliages / Acier inox. réfractaire	Inconel Nimonic Hastelloy		25 35
S	Titane, alliage de titane		30 45	
N	Alliage de cuivre / bonne usinabilité (laiton – bronze)		140 160	
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

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

$$V_f \text{ [mm/min]} = n \text{ [tr/min]} \times f_z \text{ [mm]} \times Z$$

Avance par dent **fz [mm]**

Ø D ₁ 2.00 - 5.00	Ø D ₁ 5.00 - 8.00	Ø D ₁ 8.00 - 12.00	Ø D ₁ 12.00 - 15.00	Ø D ₁ 15.00 - 20.00	Ø D ₁ 20.00 - 25.00	Ø D ₁ 25.00 - 30.00	
0.003 - 0.007	0.005 - 0.011	0.007 - 0.015	0.010 - 0.019	0.015 - 0.028	0.020 - 0.040	0.030 - 0.060	
0.003 - 0.007	0.005 - 0.011	0.007 - 0.015	0.010 - 0.019	0.015 - 0.028	0.020 - 0.040	0.030 - 0.060	
0.003 - 0.007	0.005 - 0.011	0.007 - 0.015	0.010 - 0.019	0.015 - 0.028	0.020 - 0.040	0.030 - 0.060	
0.003 - 0.007	0.005 - 0.011	0.007 - 0.015	0.010 - 0.019	0.015 - 0.028	0.020 - 0.040	0.030 - 0.060	
0.003 - 0.007	0.005 - 0.011	0.007 - 0.015	0.010 - 0.019	0.015 - 0.028	0.020 - 0.040	0.030 - 0.060	
0.003 - 0.007	0.005 - 0.011	0.007 - 0.015	0.010 - 0.019	0.015 - 0.028	0.020 - 0.040	0.030 - 0.060	
0.003 - 0.007	0.005 - 0.011	0.007 - 0.015	0.010 - 0.019	0.015 - 0.028	0.020 - 0.040	0.030 - 0.060	
0.003 - 0.007	0.005 - 0.011	0.007 - 0.015	0.010 - 0.019	0.015 - 0.028	0.020 - 0.040	0.030 - 0.060	
0.003 - 0.007	0.005 - 0.011	0.007 - 0.015	0.010 - 0.019	0.015 - 0.028	0.020 - 0.040	0.030 - 0.060	
0.003 - 0.007	0.005 - 0.011	0.007 - 0.015	0.010 - 0.019	0.015 - 0.028	0.020 - 0.040	0.030 - 0.060	
0.003 - 0.007	0.005 - 0.011	0.007 - 0.015	0.010 - 0.019	0.015 - 0.028	0.020 - 0.040	0.030 - 0.060	
0.003 - 0.007	0.005 - 0.011	0.007 - 0.015	0.010 - 0.019	0.015 - 0.028	0.020 - 0.040	0.030 - 0.060	
0.003 - 0.007	0.005 - 0.011	0.007 - 0.015	0.010 - 0.019	0.015 - 0.028	0.020 - 0.040	0.030 - 0.060	
0.003 - 0.007	0.005 - 0.011	0.007 - 0.015	0.010 - 0.019	0.015 - 0.028	0.020 - 0.040	0.030 - 0.060	
0.003 - 0.007	0.005 - 0.011	0.007 - 0.015	0.010 - 0.019	0.015 - 0.028	0.020 - 0.040	0.030 - 0.060	
0.003 - 0.007	0.005 - 0.011	0.007 - 0.015	0.010 - 0.019	0.015 - 0.028	0.020 - 0.040	0.030 - 0.060	
0.003 - 0.007	0.005 - 0.011	0.007 - 0.015	0.010 - 0.019	0.015 - 0.028	0.020 - 0.040	0.030 - 0.060	
0.003 - 0.007	0.005 - 0.011	0.007 - 0.015	0.010 - 0.019	0.015 - 0.028	0.020 - 0.040	0.030 - 0.060	
0.003 - 0.007	0.005 - 0.011	0.007 - 0.015	0.010 - 0.019	0.015 - 0.028	0.020 - 0.040	0.030 - 0.060	
0.003 - 0.007	0.005 - 0.011	0.007 - 0.015	0.010 - 0.019	0.015 - 0.028	0.020 - 0.040	0.030 - 0.060	
0.003 - 0.007	0.005 - 0.011	0.007 - 0.015	0.010 - 0.019	0.015 - 0.028	0.020 - 0.040	0.030 - 0.060	

