

Fig. 1

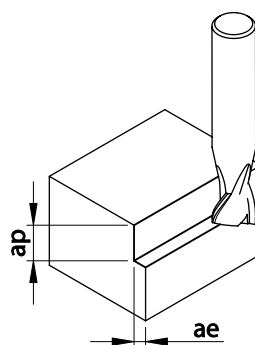


Fig. 2

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MATIERE	Vc (m/min)		fz (mm)			Fig. 1		Fig. 2	
	MD/HM	AlCrON	Ø2	Ø4	Ø6	ap	ae	ap	ae
Acier < 25HRC	80	120	0.009	0.022	0.032	0.5xØ	Ø	Ø	0.1xØ
Acier < 40HRC	60	90	0.007	0.018	0.03	0.25xØ	Ø	Ø	0.1xØ
Acier < 50HRC		75	0.006	0.015	0.025	0.25xØ	Ø	Ø	0.1xØ
Inox		75	0.006	0.015	0.025	0.25xØ	Ø	Ø	0.1xØ
Titane	40	60	0.005	0.008	0.016	0.2xØ	Ø	Ø	0.1xØ
Fonte	70	100	0.01	0.018	0.025	0.5xØ	Ø	Ø	0.1xØ
Aluminium	250		0.015	0.025	0.04	0.5xØ	Ø	Ø	0.1xØ

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MATIERE	Vc (m/min)		fz (mm)								Fig. 1	
	MD/HM	TiAlN X	Ø1	Ø1.2	Ø1.4	Ø1.5	Ø1.6	Ø1.8	Ø2	Ø2.5	ap	ae
Acier < 25HRC		90	0.004	0.005	0.005	0.006	0.007	0.008	0.009	0.01	0.1xØ	Ø
Acier < 40HRC		70	0.003	0.004	0.004	0.005	0.006	0.007	0.008	0.009	0.1xØ	Ø
Acier < 55HRC		50	0.001	0.002	0.002	0.003	0.0035	0.004	0.0045	0.005	0.1xØ	Ø