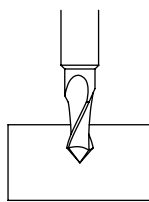
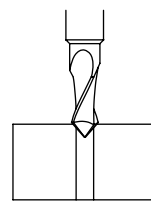


Pointage  
90° - 120°



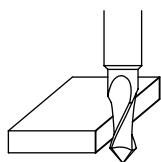
Perçage  
90° - 120°



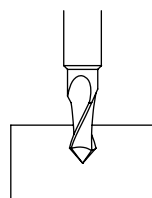
Chanfrein  
60° - 90° - 120°

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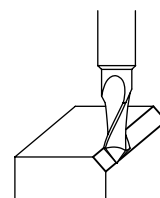
MATIERE	Vc (m/min)		fz (mm)							
	MD/HM	AlCrON	Ø3	Ø4	Ø6	Ø8	Ø10	Ø12	Ø16	Ø20
Acier < 25HRC	40	60	0.04	0.05	0.08	0.1	0.15	0.2	0.22	0.25
Acier < 35HRC		40	0.03	0.045	0.07	0.09	0.12	0.18	0.2	0.22
Inox	40	30	0.03	0.045	0.07	0.09	0.12	0.18	0.02	0.22
Fonte		40	0.04	0.05	0.08	0.1	0.15	0.2	0.22	0.25
Titane		30	0.015	0.04	0.06	0.08	0.11	0.16	0.18	0.2
Aluminium	150	40	0.04	0.05	0.09	0.12	0.15	0.2	0.25	0.3
Cuivre/Bronze	100		0.04	0.05	0.09	0.12	0.15	0.2	0.25	0.3



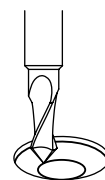
Contournage  
60° - 90° - 120°



Gravage  
60° - 90° - 120°



Chanfrein  
60° - 90° - 120°



Usinage par interpolation  
60° - 90° - 120°

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MATIERE	Vc (m/min)		fz (mm)							
	MD/HM	AlCrON	Ø3	Ø4	Ø6	Ø8	Ø10	Ø12	Ø16	Ø20
Acier < 25HRC	40	60	0.006	0.008	0.013	0.02	0.025	0.035	0.05	0.06
Acier < 35HRC		40	0.006	0.008	0.013	0.02	0.025	0.035	0.05	0.06
Inox	40	30	0.005	0.007	0.01	0.015	0.02	0.025	0.035	0.04
Fonte		40	0.006	0.008	0.013	0.02	0.025	0.035	0.05	0.06
Titane		30	0.005	0.007	0.01	0.015	0.02	0.025	0.035	0.04
Aluminium	150	40	0.01	0.01	0.015	0.022	0.03	0.04	0.055	0.065
Cuivre/Bronze	100		0.01	0.01	0.015	0.022	0.03	0.04	0.055	0.065

Paramètres donnés à titre indicatif