

FRAISE Z4  
FRÄSER Z4  
ENDMILL Z4

22102-7-8

Version du  
12.06.2020



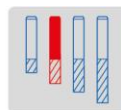
E2

$\lambda = 35^\circ$   
 $\gamma = 10^\circ$

$\phi \leq 6$   $\phi > 6$   
90° 45°



$l_1$   
2.2 x D



Compatibilité outil / matière  
Werkzeug / Werkstoffverträglichkeit  
Tool / Material compatibility



ESHOP / EZI CUT

● 1/3  
● 2/3  
● 3/3

Gruppe E2  
Vc [m/min]

|                                                                            |                                |     |     |   |
|----------------------------------------------------------------------------|--------------------------------|-----|-----|---|
| ACIERS ALLIÉS ET NON ALLIÉS<br>UNLEGIERTE STÄHLE<br>NON-ALLOYED STEELS     | Rm < 450 N/mm <sup>2</sup>     | 1a  | 140 | ● |
|                                                                            | Rm 450 - 700 N/mm <sup>2</sup> | 1b  |     |   |
|                                                                            | Rm 700 - 900 N/mm <sup>2</sup> | 1c  |     |   |
|                                                                            | Rm < 1200 N/mm <sup>2</sup>    | 1d  |     |   |
| ACIERS INOX<br>ROSTFREIE STÄHLE<br>STAINLESS STEELS                        | Rm < 650 N/mm <sup>2</sup>     | 2a  |     |   |
|                                                                            | Rm 650 - 950 N/mm <sup>2</sup> | 2b  |     |   |
|                                                                            | Rm > 950 N/mm <sup>2</sup>     | 2c  |     |   |
| ACIERS TREMPÉS GEHÄRTETE<br>STÄHLE HARDENED STEELS                         | 44 - 56 HRC                    | 3a  |     |   |
|                                                                            | 57 - 67 HRC                    | 3b  |     |   |
| MATÉRIAUX EXOTIQUES<br>EXOTISCHE WERKSTOFFE<br>EXOTIC MATERIALS            | < 32 HRC                       | 4a  |     |   |
|                                                                            | > 32 HRC                       | 4b  |     |   |
| GRAPHITE                                                                   |                                | 5   | 180 | ● |
| FONTES GUSS CAST IRON                                                      | < 32 HRC                       | 6a  |     |   |
|                                                                            | > 32 HRC                       | 6b  |     |   |
| TITANE TITAN                                                               | Rm < 800 N/mm <sup>2</sup>     | 7a  |     |   |
|                                                                            | 800 < Rm N/mm <sup>2</sup>     | 7b  |     |   |
| ALLIAGES NICKEL<br>NICKEL<br>NICKEL ALLOYS                                 | Rm < 1000 N/mm <sup>2</sup>    | 8a  |     |   |
|                                                                            | 1000 < Rm N/mm <sup>2</sup>    | 8b  |     |   |
| CUIVRE, LAITON, BRONZE<br>KUPFER, MESSING, BRONZE<br>COPPER, BRASS, BRONZE | Rm < 850 N/mm <sup>2</sup>     | 9a  | 320 | ● |
|                                                                            | 850 < Rm N/mm <sup>2</sup>     | 9b  | 250 | ● |
| ALUMINIUM                                                                  | Si < 0.5%                      | 10a | 300 | ● |
|                                                                            | 0.5% < Si < 5%                 | 10b | 250 | ● |
|                                                                            | Si > 5%                        | 10c |     |   |
| MATIÈRES SYNTHÉTIQUES<br>KUNSTSTOFFE<br>SYNTHETIC MATERIALS                | Thermoplast                    | 11a | 180 | ● |
|                                                                            | Duraplast                      | 11b | 120 | ● |
| MATIÈRES COMPOSITES<br>FASERVERST. MATERIALEN<br>COMPOSITE MATERIALS       | Fibre de verre                 | 12a | 130 | ● |
|                                                                            | Fibre de carbone               | 12b | 90  | ● |
| MÉTAUX PRÉCIEUX<br>EDELMETALLE<br>PRECIOUS MATERIALS                       | Or • Gold                      | 13a | 320 | ● |
|                                                                            | Platine                        | 13b |     |   |



|              |      |
|--------------|------|
| D (h10)      | 7    |
| d (h6)       | 8    |
| L            | 63   |
| l1           | 16   |
| l3           |      |
| d3           |      |
| R            |      |
| e            |      |
| Z            | 4    |
| Chanfrein    | 0.1  |
| K            |      |
| w° collision | 1.7° |