

FRAISE DE SUPERFINITION MULTIDENTS
SUPERSCHLICHTFRÄSER MEHRLIPPIG
SUPERFINISHING MULTI-FLUTES ENDMILL

22144X-25

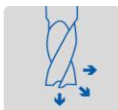
Version du
12.06.2020



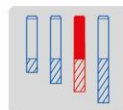
E2

$\lambda = 45^\circ$
 $\gamma = 8^\circ$

$\emptyset \leq 6$ $\emptyset > 6$
90° 45°



l_1
3 x D



Compatibilité outil / matière
Werkzeug / Werkstoffverträglichkeit
Tool / Material compatibility

● 1/3
● 2/3
● 3/3

Gruppe Vc [m/min]
EZI - DUR 3



ESHOP / EZI CUT

ACIERS ALLIÉS ET NON ALLIÉS UNLEGIERTER STÄHLE NON-ALLOYED STEELS	Rm < 450 N/mm ²	1a	260	●
	Rm 450 - 700 N/mm ²	1b	150	●
	Rm 700 - 900 N/mm ²	1c	125	●
	Rm < 1200 N/mm ²	1d	80	●
ACIERS INOX ROSTFREIE STÄHLE STAINLESS STEELS	Rm < 650 N/mm ²	2a	110	●
	Rm 650 - 950 N/mm ²	2b	80	●
	Rm > 950 N/mm ²	2c	65	●
ACIERS TREMPÉS GEHÄRTETE STÄHLE HARDENED STEELS	44 - 56 HRC	3a	60	●
	57 - 67 HRC	3b	35	●
MATÉRIAUX EXOTIQUES EXOTISCHE WERKSTOFFE EXOTIC MATERIALS	< 32 HRC	4a	50	●
	> 32 HRC	4b	30	●
GRAPHITE		5	180	●
FONTES GUSS CAST IRON	< 32 HRC	6a	80	●
	> 32 HRC	6b	60	●
TITANE TITAN	Rm < 800 N/mm ²	7a	65	●
	800 < Rm N/mm ²	7b	55	●
ALLIAGES NICKEL NICKEL NICKEL ALLOYS	Rm < 1000 N/mm ²	8a	50	●
	1000 < Rm N/mm ²	8b	35	●
CUIVRE, LAITON, BRONZE KUPFER, MESSING, BRONZE COPPER, BRASS, BRONZE	Rm < 850 N/mm ²	9a	360	●
	850 < Rm N/mm ²	9b	250	●
ALUMINIUM	Si < 0.5%	10a	400	●
	0.5% < Si < 5%	10b	320	●
	Si > 5%	10c	250	●
MATIÈRES SYNTHÉTIQUES KUNSTSTOFFE SYNTHETIC MATERIALS	Thermoplast	11a	210	●
	Duraplast	11b	150	●
MATIÈRES COMPOSITES FASERVERST. MATERIALEN COMPOSITE MATERIALS	Fibre de verre	12a	160	●
	Fibre de carbone	12b	120	●
MÉTAUX PRÉCIEUX EDELMETALLE PRECIOUS MATERIALS	Or • Gold	13a	280	●
	Platine	13b	40	●



D (h10)	25
d (h6)	25
L	121
L1	55
I3	
d3	
R	
e	
Z	10
Chanfrein	0.1
K	
w° collision	