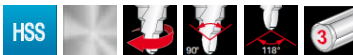


101



Foret étages HSS, Taillés meulés au CBN

Goujures droites et affûtage en croix,

Le chanfrein facilite le retrait du foret lors des perçages débouchant.

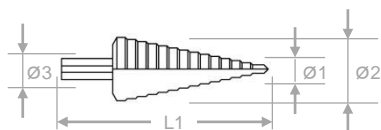


APPLICATION



Aciers (N/mm ²) < 900	■
Aciers (N/mm ²) < 1100	
Aciers (N/mm ²) < 1300	
Aciers Inoxydables	
ALU	■

Cuivre	■
Bronze	□
Plastique	■
Fontes	□
Alliages au titane	



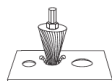
Ø mm	Ø 1 - Ø 2 mm	L1 mm	ART. N°	Cdt.
0/9	4,0 – 12,0 4,0 / 5,0 / 6,0 / 7,0 / 8,0 / 9,0 / 10,0 / 11,0 / 12,0 12,0	58,0	101 009	1
1	4,0 – 20,0 4,0 / 6,0 / 8,0 / 10,0 / 11,0 / 12,0 / 14,0 / 16,0 / 18,0 / 20,0	58,0	101 001	1
2	6,0 – 30,0 6,0 / 8,0 / 10,0 / 11,0 / 12,0 / 14,0 / 16,0 / 18,0 / 20,0 / 24,0 / 26,0 / 28,0 / 30,0	58,0	101 002	1

120



Foret striés HSS

Pour le perçage des trous dans tous matériaux de faible épaisseur (épaisseur max. 5 mm).

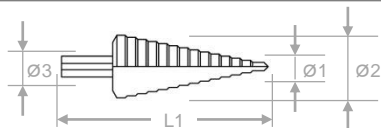


APPLICATION



Aciers (N/mm ²) < 900	■
Aciers (N/mm ²) < 1100	
Aciers (N/mm ²) < 1300	
Aciers Inoxydables	
ALU	■

Cuivre	
Bronze	
Plastique	■
Fontes	
Alliages au titane	



Ø 1 - Ø 2 mm	Ø 3 mm	ART. N°	Cdt.
25 x 40	6,0	120 925	1

FORETS ÉTAGÉS

Tableau des vitesses de coupe

Matières.		Acier de construc. non allié jusqu'à 700 N/mm ²	Acier de construc. non allié au-delà de 700 N/mm ²	Acier Alliés jusqu'à 700 N/mm ²	Fonte jusqu'à 250 N/mm ²	Fonte au-delà de 250 N/mm ²	Alliages CuZn cassants	Alliages CuZn tenaces	Alliages Al jusqu'à 11% Si	Thermo-Plastiques	Thermo-durcis sable
Epaisseur maxi mm		jusqu'à 4,0	jusqu'à 4,0	jusqu'à 4,0	jusqu'à 4,0	jusqu'à 4,0	jusqu'à 4,0	jusqu'à 4,0	jusqu'à 4,0	jusqu'à 4,0	jusqu'à 4,0
Vc = m/min		30	20	20	15	10	60	35	30	20	15
Lubrifiant Réfrigérant.		Aérosol De coupe	Aérosol De coupe	Aérosol De coupe	Air comprimé	Air comprimé	Air comprimé	Air comprimé	Aérosol De coupe	Eau	Air comprimé
Gr.	Ø mm	Tr/min	Tr/min	Tr/min	Tr/min	Tr/min	Tr/min	Tr/min	Tr/min	Tr/min	Tr/min
0/9	4,0 – 12,0	800 – 2400	500 – 1600	500 – 1600	400 – 1200	300 – 800	1600 – 4800	900 – 2800	800 – 2400	500 – 1600	400 – 1200
0/9	4,0 – 12,0	800 – 2400	500 – 1600	500 – 1600	400 – 1200	300 – 800	1600 – 4800	900 – 2800	800 – 2400	500 – 1600	400 – 1200
1	4,0 – 20,0	500 – 2400	300 – 1600	300 – 1600	200 – 1200	200 – 800	1000 – 4800	600 – 2800	500 – 2400	300 – 1600	200 – 1200
2	4,0 – 30,0	300 – 2400	200 – 1600	200 – 1600	200 – 1200	100 – 800	600 – 4800	400 – 2800	300 – 2400	200 – 1600	200 – 1200
3	6,0 – 38,0	300 – 1600	200 – 1100	200 – 1100	100 – 800	100 – 500	500 – 3200	300 – 1900	300 – 1600	200 – 1100	100 – 800
4	6,0 – 26,8	400 – 1600	200 – 1100	200 – 1100	200 – 800	100 – 500	700 – 3200	400 – 1900	400 – 1600	200 – 1100	200 – 800
5	4,0 – 32,0	300 – 2400	200 – 1600	200 – 1600	100 – 1200	100 – 800	600 – 4800	300 – 2800	300 – 2400	200 – 1600	100 – 1200
6	6,0 – 32,0	300 – 1600	200 – 1100	200 – 1100	800 – 100	100 – 500	600 – 3200	300 – 1900	300 – 1600	200 – 1100	800 – 100
7	5,0 – 28,0	300 – 1900	200 – 1300	200 – 1300	200 – 1000	100 – 600	700 – 3800	400 – 2200	300 – 1900	200 – 1300	200 – 1000
8	6,0 – 30,5	300 – 1600	200 – 1100	200 – 1100	200 – 800	100 – 500	600 – 3200	400 – 1900	300 – 1600	200 – 1100	200 – 800
9	6,0 – 37,0	300 – 1600	200 – 1100	200 – 1100	100 – 800	100 – 500	500 – 3200	300 – 1900	300 – 1600	200 – 1100	100 – 800
10	4,8 – 10,7	900 – 2000	600 – 1300	600 – 1300	400 – 1000	300 – 700	1800 – 4000	1000 – 2300	900 – 2000	600 – 1300	400 – 1000
11	6,0 – 25,0	400 – 1600	300 – 1100	300 – 1100	200 – 800	100 – 500	800 – 3200	400 – 1900	400 – 1600	300 – 1100	200 – 800
12	6,0 – 32,0	300 – 1600	200 – 1100	200 – 1100	100 – 800	100 – 500	600 – 3200	300 – 1900	300 – 1600	200 – 1100	100 – 800
13	6,0 – 40,0	200 – 1600	200 – 1100	200 – 1100	100 – 800	100 – 500	500 – 3200	300 – 1900	200 – 1600	200 – 1100	100 – 800
14	5,3 – 30,5	300 – 1800	200 – 1200	200 – 1200	200 – 900	100 – 600	600 – 3600	400 – 2100	300 – 1800	200 – 1200	200 – 900
15	6,5 – 32,5	300 – 1500	200 – 1000	200 – 1000	100 – 700	100 – 500	600 – 2900	300 – 700	300 – 1500	200 – 1000	100 – 700
16	5,3 – 38,5	200 – 1800	200 – 1200	200 – 1200	100 – 900	100 – 600	500 – 3600	300 – 2100	200 – 1800	200 – 1200	100 – 900
17	6,5 – 40,5	200 – 1500	200 – 1000	200 – 1000	100 – 700	100 – 500	500 – 2900	300 – 1700	200 – 1500	200 – 1000	100 – 700
18	6,5 – 32,5	300 – 1500	200 – 1000	200 – 1000	100 – 700	100 – 500	600 – 2900	300 – 1700	300 – 1500	200 – 1000	100 – 700
20	12,0 – 20,0	500 – 800	300 – 500	300 – 500	200 – 400	200 – 300	600 – 1600	600 – 900	500 – 300	300 – 500	200 – 400
30	20,0 – 30,0	300 – 500	200 – 300	200 – 300	200 – 200	100 – 200	600 – 400	200 – 600	300 – 200	200 – 300	200 – 200
40	30,0 – 40,0	200 – 300	200 – 200	200 – 200	100 – 200	100 – 100	600 – 300	200 – 400	200 – 200	200 – 200	100 – 200

Gr.	Ø pouces	Tr/min	Tr/min	Tr/min	Tr/min	Tr/min	Tr/min	Tr/min	Tr/min	Tr/min	Tr/min
1	3/16 – 1/2	800 – 2000	500 – 1300	1300 – 500	400 – 1000	300 – 700	1500 – 4000	900 – 2300	800 – 2000	500 – 1300	400 – 1000
2	1/8 – 1/2	800 – 3000	500 – 2000	2000 – 500	400 – 1500	300 – 1000	1500 – 6000	900 – 3500	800 – 3000	500 – 2000	400 – 1500
3	1/4 – 3/4	500 – 1500	300 – 1000	1000 – 300	300 – 800	200 – 500	1000 – 3000	600 – 1800	500 – 1500	300 – 1000	300 – 800
4	3/16 – 7/8	400 – 2000	300 – 1300	1300 – 300	200 – 1000	100 – 700	900 – 4000	500 – 2300	400 – 2000	300 – 1300	200 – 1000
5	5/16 – 1	400 – 1200	300 – 800	800 – 300	200 – 600	100 – 400	800 – 2400	500 – 1400	400 – 1200	300 – 800	200 – 600
6	7/8 – 1 3/8	300 – 400	200 – 300	300 – 200	100 – 200	100 – 100	500 – 900	400 – 500	300 – 400	200 – 300	100 – 200
7	3/8 – 1/2	800 – 1000	500 – 700	700 – 500	400 – 500	300 – 300	1500 – 2000	300 – 1200	800 – 1000	500 – 700	400 – 500
8	7/8	400	300	300	200	100	900	500	400	300	200
9	7/8 – 1 1/8	300 – 400	200 – 300	300 – 200	200 – 200	100 – 100	700 – 900	400 – 500	300 – 400	200 – 300	200 – 200