

MICRO-Line

Micro-forets / Centreurs NC

Microbohrer / NC-Zentrierbohrer

Micro drills / NC centering drills

	Spiral	L2	Type	page
	25°	-	1680-90 / 2680-90	23
	25°	-	1680-120 / 2680-120	24
	30°	-	1010 / 2010	25
	35°	-	2011	26
	24°	-	2012	26
	35°	-	2013	27
	30°	-	2014	27
	30°	2 x D1	2020	28
	35°	6 x D1	2023	30
	25°	12 x D1	2026	33
	35°	5 x D1	2030 [Z=3]	35

Paramètres de coupe indicatifs

Empfohlene Schnittwerte

Standard machining data

Matière Werkstoff Material	VC (m/min)	fz [mm/z]			
		Ø 0.4 - 0.6	Ø 0.6 - 1.0	Ø 1.0 - 3.0	Ø 3.0 - 6.0
Acier Stahl Steel < 700 N/mm ²	60 - 100	0.004 - 0.008	0.006 - 0.015	0.010 - 0.040	0.040 - 0.100
Acier Stahl Steel > 700 N/mm ²	30 - 60	0.003 - 0.005	0.005 - 0.012	0.010 - 0.040	0.040 - 0.080
Acier inoxydable Rostfreistahl Stainless steel	30 - 60	0.003 - 0.006	0.005 - 0.012	0.010 - 0.040	0.040 - 0.080
Titane Titan Titanium	25 - 50	0.002 - 0.005	0.004 - 0.010	0.008 - 0.030	0.030 - 0.070
Aluminium	60 - 150	0.004 - 0.010	0.006 - 0.030	0.020 - 0.070	0.050 - 0.150
Cuivre Kupfer Copper	50 - 80	0.004 - 0.012	0.007 - 0.020	0.050 - 0.060	0.050 - 0.120
Laiton Messing Brass	60 - 100	0.005 - 0.015	0.008 - 0.030	0.020 - 0.070	0.060 - 0.150
Or Gold Gold	50 - 100	0.004 - 0.010	0.006 - 0.030	0.020 - 0.070	0.060 - 0.150