

# MICRO-Line

Fraises à graver

Gravierfräser

Engraving mills

Paramètres de coupe indicatifs

Empfohlene Schnittwerte

Standard machining data

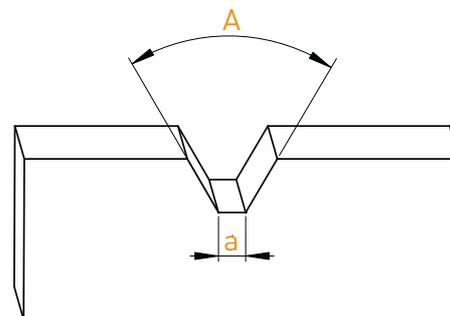
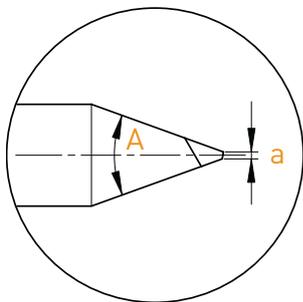
Matière Werkstoff Material	Vf [mm/min]	
Acier Stahl Steel < 700 N/mm <sup>2</sup>	80 - 180	recommended feed rate for rotation speed between 20'000 and 30'000 RPM
Acier Stahl Steel > 700 N/mm <sup>2</sup>	70 - 150	
Acier inoxydable Rostfreistahl Stainless steel	70 - 150	
Titane Titan Titanium	70 - 130	
Aluminium	80 - 250	
Cuivre Kupfer Copper	70 - 150	
Laiton Messing Brass	80 - 200	
Or Gold Gold	80 - 200	

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E300-P



MD  
VHM  
HM

A	a *in steps of 0.01 mm	D2 h4	L1	Art. N°	z	TiCN
30°	0.02-0.10* / 0.12 / 0.15	3.00	33	E330-P-_(a)	■	■
40°	0.02-0.10* / 0.12 / 0.15	3.00	33	E340-P-_(a)	■	■
50°	0.02-0.10* / 0.12 / 0.15	3.00	33	E350-P-_(a)	■	■
60°	0.02-0.10* / 0.12 / 0.15	3.00	33	E360-P-_(a)	■	■
90°	0.02-0.10* / 0.12 / 0.15	3.00	33	E390-P-_(a)	■	■