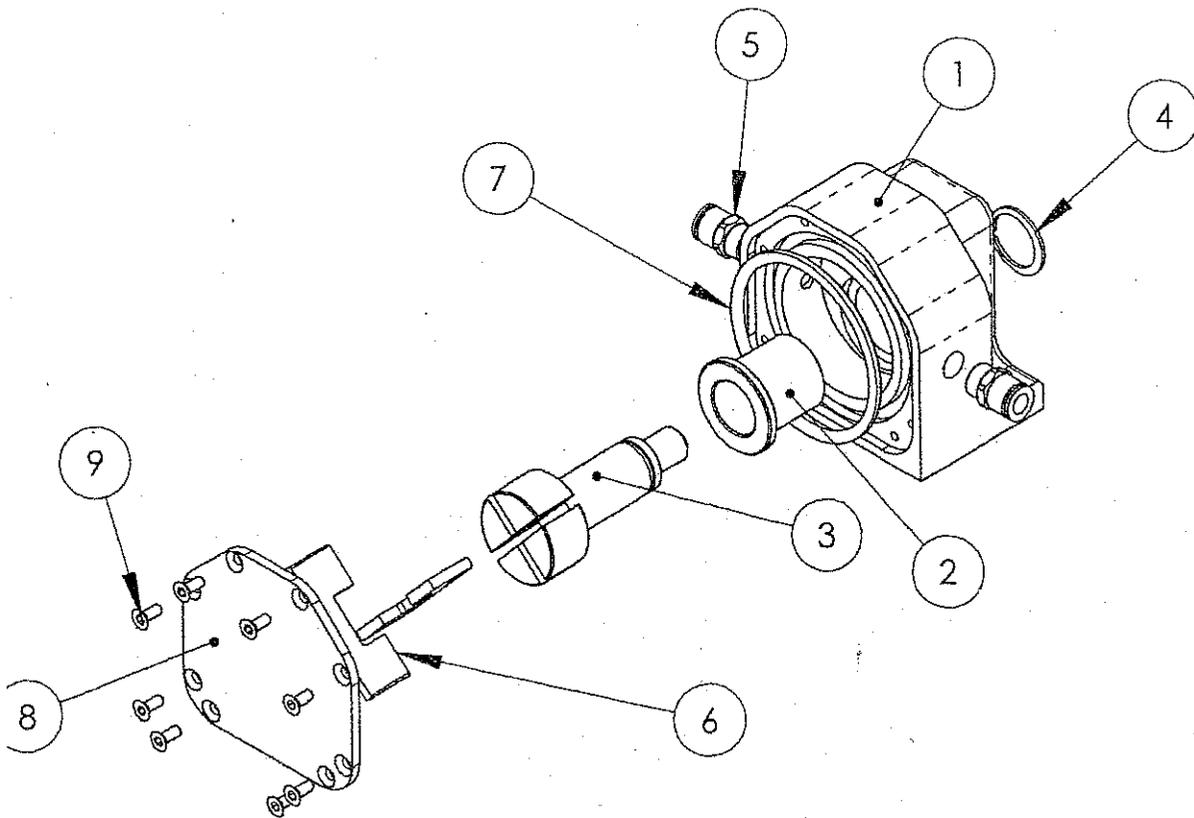
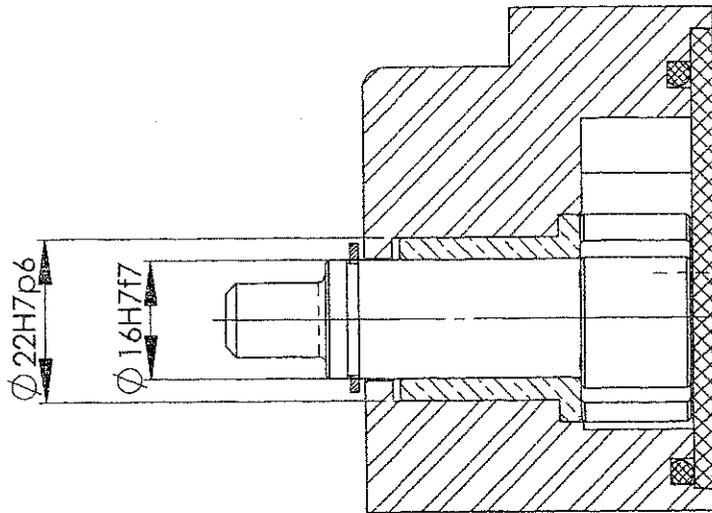


BEP Métiers de la Production Mécanique Informatisée**EP2: Préparation d'une fabrication****DOSSIER TECHNIQUE****DOCUMENTS**

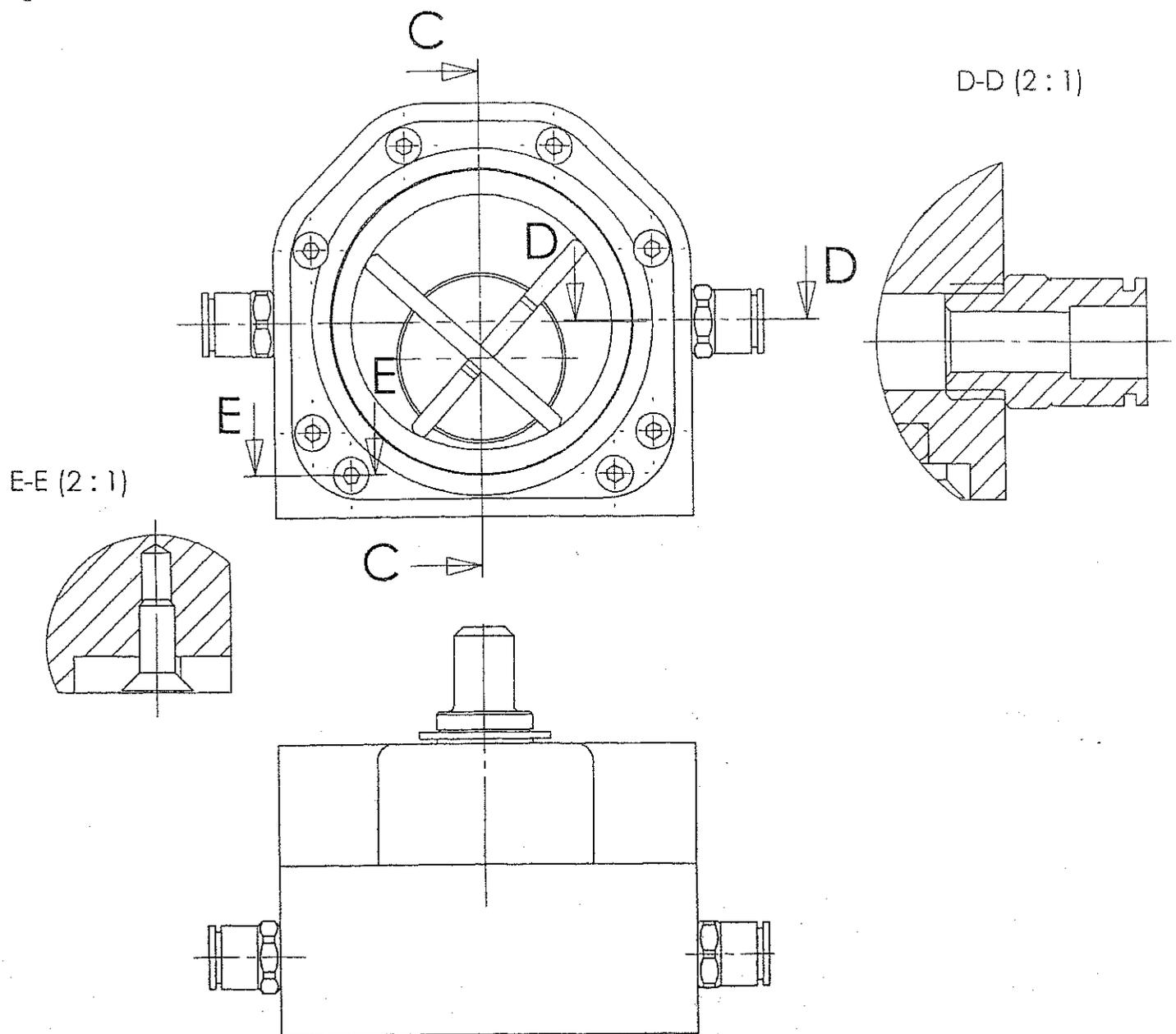
| | |
|--|------------|
| Dessin d'ensemble | Doc DT 1/6 |
| Contrats de phases des pièces usinées : | |
| - Arbre Phase 30 | Doc DT 2/6 |
| - Corps Phase 20 | Doc DT 2/6 |
| Graphe d'assemblage | Doc DT 3/6 |
| Mode opératoire de contrôle | Doc DT 4/6 |
| Symbolisation des éléments technologiques d'appui et de maintien | Doc DT 4/6 |
| Extrait documentation SANDVIK | Doc DT 5/6 |
| Structure de programme de la phase 30 du corps rep. 1 | Doc DT 6/6 |
| Extrait documentation MOTUL | Doc DT 6/6 |

C-C



DT 1 / 6

| | | | | | |
|--|--|--|--|------------------------------------|--|
| Tol. Dim.: Tol. Géom.: Rugosité: | | ENSEMBLE: Pompe à palettes DT1 | | Académie de Clermont-Ferrand | |
| Dessinateur: Date: | | DESIGNATION: ENSEMBLE | | Echelle 1:1 | |
| Matière: Spécification: Etat: | | PLAN NUMERO: 1000 2431-0 | | | |
| Format A3 | | Traitement: | | | |



| N°PLAN | Rep. | Nb | Désignation | Matière |
|-------------|------|----|----------------------------------|--------------|
| 1000 2431-1 | 1 | 1 | Corps | EN AW-2017 |
| 1000 2431-2 | 2 | 1 | Coussinet à collerette 16x22x25 | Métal fritté |
| 1000 2431-3 | 3 | 1 | Arbre | X10CrNi19-11 |
| 1000 2431-4 | 4 | 1 | Anneau élastique pour arbre 16x1 | |
| 1000 2431-5 | 5 | 2 | Embout de tube 3/8e | |
| 1000 2431-6 | 6 | 2 | Palette | PFE |
| 1000 2431-7 | 7 | 1 | Joint torique 50.40x3.53 | |
| 1000 2431-8 | 8 | 1 | Plaque | |
| 1000 2431-9 | 9 | 8 | Vis ISO 10642-M3x12-8.8 | |

CONTRAT DE PHASE

Phase 20

Ensemble POMPE A PALETTES

Pièce CORPS

Matière 2017 - Al Cu4 Mg Si



FRAISAGE CN
NUM1060 F

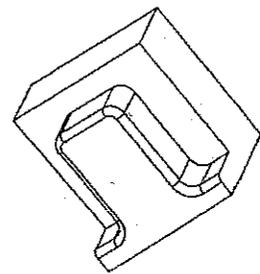
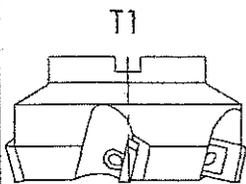
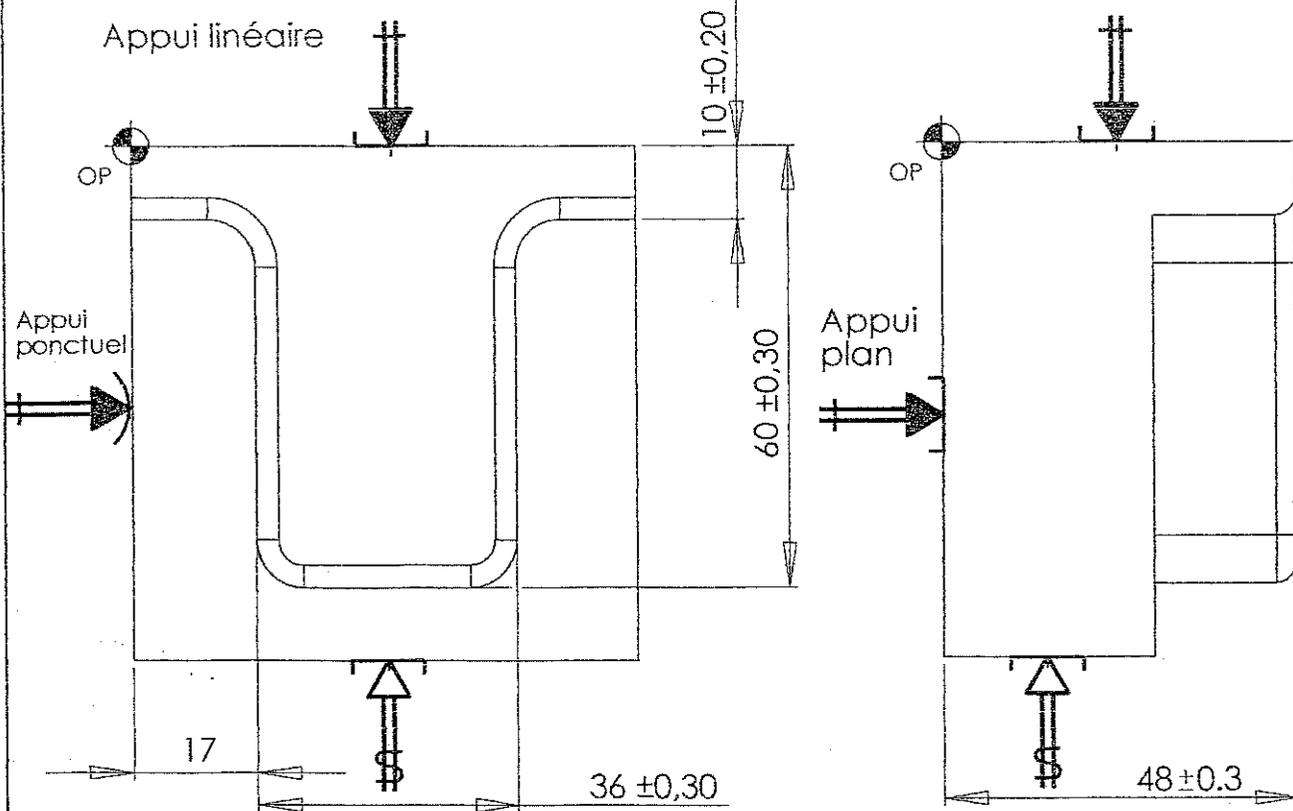
Série

Programme %3301

Fichier corps_eficn_F10.cn

Nom

Date 12/11/03



Appui plan 1 - 2 - 3 sur cales
Appui linéaire 4 - 5 sur mors fixe
Appui ponctuel 6 sur butée
Serrage sur 20 mm Maxi

Porte-Pièce
Etau

OPERATIONS

- a) Surfacier Plan
- b) Ebaucher contour POCHE OUVERTE
- c) Finition contour POCHE OUVERTE
- d) Congés POCHE OUVERTE

OUTILS

- Fraise à surfacer D = 50
- Fraise ébauche pas fin 3 dents D = 12
- Fraise 2 tailles HSS D = 12
- Fraise quart de cercle D = 6

| Vc | n | f / fz | Vf | T | D |
|-------|--------|------------------|--------|---|---|
| m/min | tr/min | mm/tr mm/dent | mm/min | | |
| 350 | 2228 | 0.12 | 802 | 1 | 1 |
| 180 | 4775 | 0.06 | 860 | 2 | 2 |
| | 5836 | 0.04 | 934 | 3 | 3 |
| 150 | 3979 | 0.04 | 637 | 4 | 4 |

DT 2 / 6

CONTRAT DE PHASE

Phase 30

| | |
|-----------|-------------------|
| Ensemble | Pompe à palette |
| Pièce | Arbre |
| Matière | X30Cr13 (Z30C13) |
| Série | |
| Programme | %2202 |
| Fichier | Abre-eficn_T30.cn |

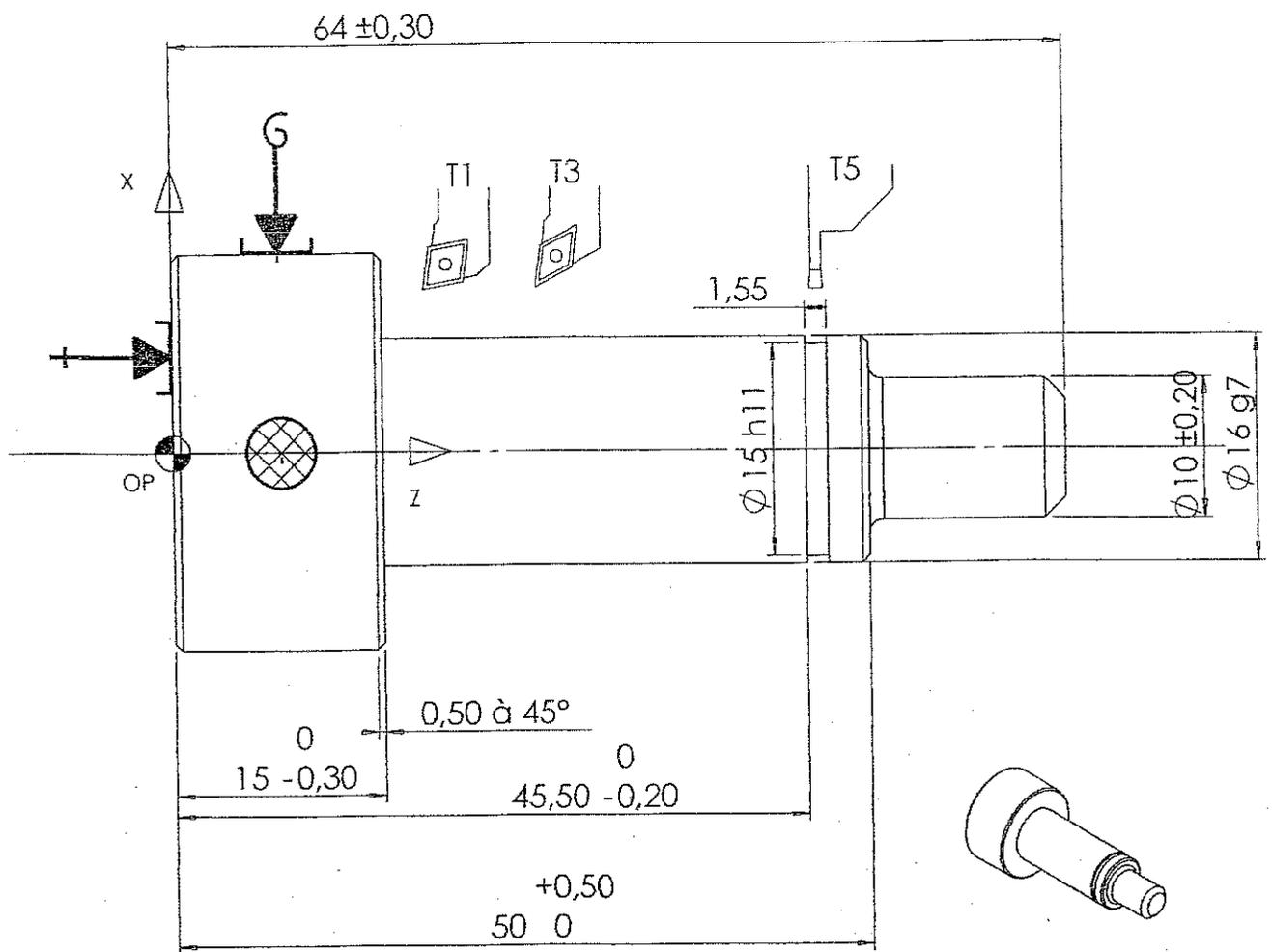


EFICNSW

Nom BEP MPMI

Date 09/11/03

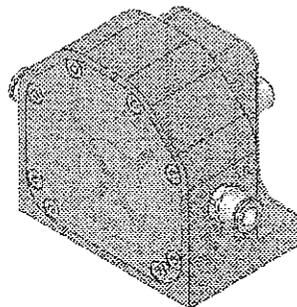
TOURNAGE CN
Somab T400 NUM 1060 T



| | | | |
|---|---|-------------------------|-------|
| Appui plan Centrage court Serrage mors doux | Porte-Pièce Mandrin 3 mors doux épaulés Ø28 X 12 | Temps Total de Coupe | 0 min |
| | | Temps Total Improductif | 0 min |
| | | Temps de Montage | 0 min |
| | | Temps Total de Phase | 0 min |

| OPERATIONS | OUTILS | Vc | n | f / fz | Vf | T | D |
|--|---|-------|--------|------------------|--------|---|---|
| | | m/min | tr/min | mm/tr mm/dent | mm/min | | |
| a) Ebaucher dressage face avant et profil ext. | Outil à charioter-dresser d'extérieur T-MAX P PCLN_2020K12 | 250 | | 0.2 | | 1 | 1 |
| b) Finir dressage face avant et profil ext. | Outil à contourner d'extérieur T-MAX P PDJN_2020K15 | 300 | | 0.1 | | 3 | 3 |
| c) Usiner gorge extérieure | Outil de gorge extérieur T-MAX 154.91-1616-3 160 | 140 | | 0.04 | | 5 | 5 |

GRAPHE
D'ASSEMBLAGE

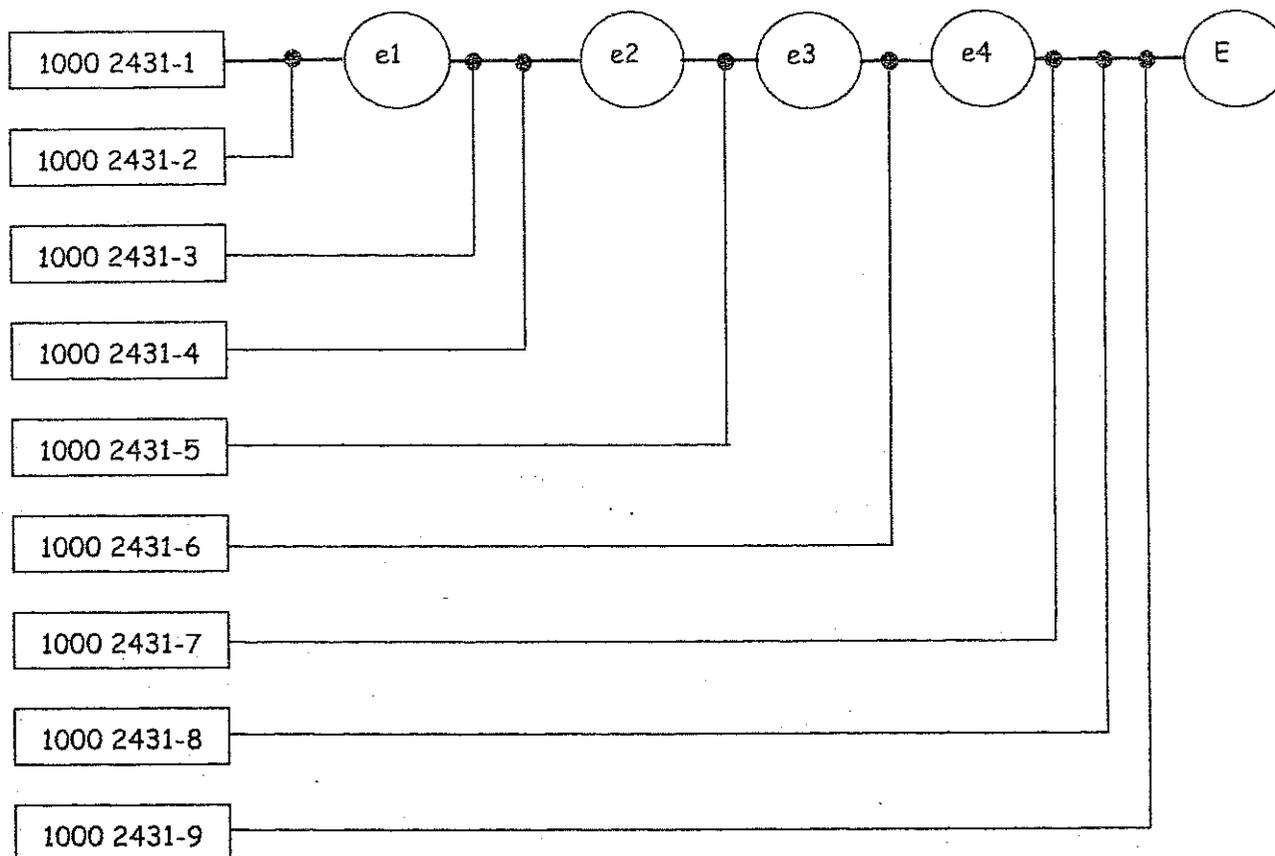


Ensemble :
POMPE A PALETTES

Production : 24 / an

Etabli par : AB

2
2



Interprétation

| | | |
|---------------------|---|---|
| Sous-ensemble e1 | Le corps 1000 2431-1 est choisi comme support. Le coussinet à collerette 1000 2431-2 se monte sur le corps avec la presse. | |
| Sous-ensemble e2 | L'arbre 1000 2431-3 se monte dans le sous-ensemble e1. L'anneau élastique 1000 2431-4 se monte sur l'arbre. | Vérifier si l'arbre tourne |
| Sous-ensemble e3 | Les raccords rapides 1000 2431-5 se montent sur le corps du sous-ensemble e2. | |
| Sous-ensemble e4 | Les palettes 1000 2431-6 se montent dans les rainures de l'arbre du sous-ensemble e3. | Vérifier si l'arbre et les palettes tournent |
| Ensemble E | Le joint torique 1000 2431-7 se monte dans la rainure du corps du sous-ensemble e4. La plaque 1000 2431-8 se monte dans le corps du sous-ensemble e4. Les vis 1000 2431-9 se montent dans le corps du sous-ensemble e4. | Régler le serrage des vis afin que la rotation de l'arbre et des palettes soit « limite serrage » |

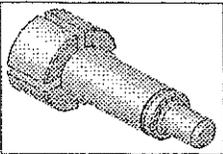
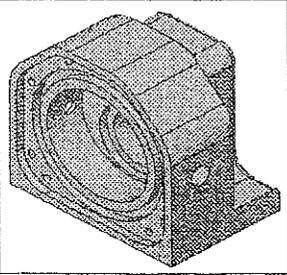
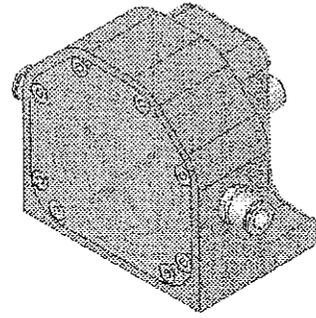
GRAPHE
D'ASSEMBLAGE

Ensemble :
POMPE A PALETTES

Production : 24 / an

Etabli par : AB

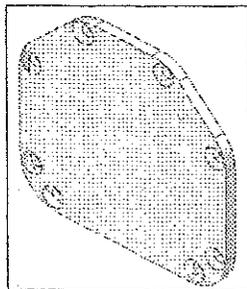
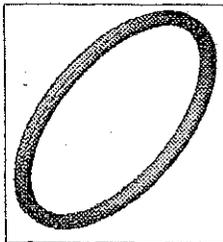
1
2



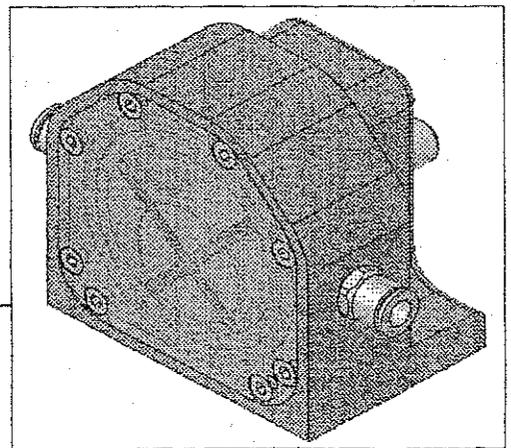
X 2



X 2

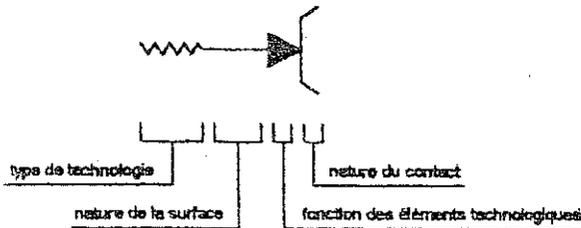


X 8



SYMBOLISATION DES ELEMENTS TECHNOLOGIQUES D'APPUI ET DE MAINTIEN

Construction d'un symbole technologique



Fonction des éléments technologiques

| FONCTION | SYMBOLE | Représentation prolette |
|--|----------------|-------------------------|
| définition d'une surface de mise en position, d'un axe | triangle noir | |
| immobilisation de la pièce, pré-localisation | triangle blanc | |

Nature des surfaces localisées

| Nature des surfaces | SYMBOLE |
|---------------------|---------------|
| surface usinée | un seul trait |
| surface brute | double trait |

Type de technologie

| Type technologique | SYMBOLE |
|---------------------------------|---------|
| Appui fixe | |
| Centrage fixe | |
| Système à serrage | |
| Système à serrage concentrique | |
| Système de soutien irréversible | |
| Système de soutien réversible | |

Nature du contact

| Nature contact | Symbole du contact | Nature contact | Symbole du contact |
|----------------|--------------------|------------------|--------------------|
| Touche plate | | Pointe fixe | |
| Touche striée | | Pointe tournante | |
| Touche bombée | | Vé | |
| Contact dégaçé | | Orienteur | |
| Cuvette | | Palonnier | |

Exemples de symboles

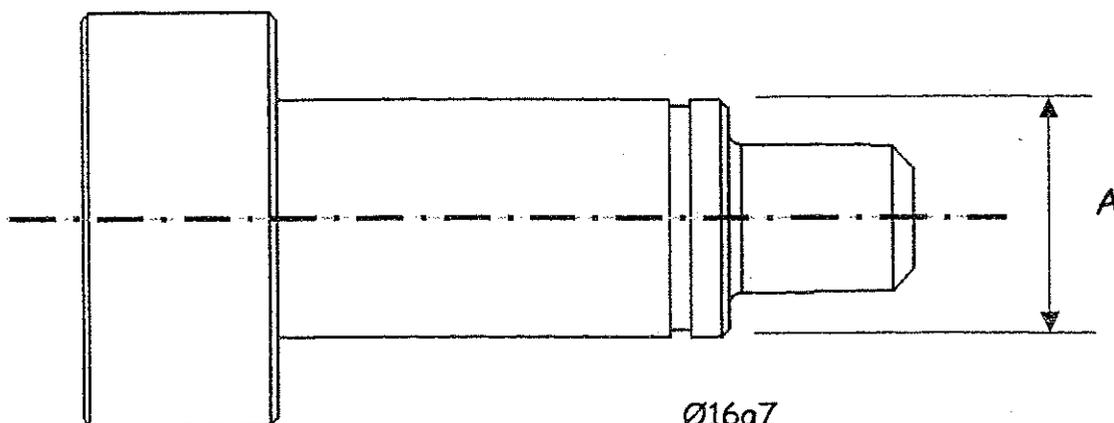
| Symbole | Signification |
|---------|--|
| | Touche plate fixe de départ d'usinage sur une surface usinée |
| | Touche plate éclipsable sur une surface usinée |
| | Mors striés, à serrage concentrique flottant, utilisés comme entraîneurs sur une surface brute |
| | Touche bombée fixe de départ d'usinage sur une surface brute |
| | Touche dégaçée fixe de départ d'usinage sur surface brute |
| | Cuvette axiale utilisée comme point de départ d'usinage sur une surface usinée |
| | Pointe fixe axiale utilisée comme départ d'usinage sur une surface usinée |
| | Pointe tournante axiale, de poupée mobile, utilisée comme point de départ d'usinage sur une surface usinée |
| | Palonnier de bridage possédant des mors striés sur une surface de départ brute |
| | Vé axiale servant de point de départ d'usinage sur une surface usinée |

Le symbole peut être complété par une brève indication écrite, si nécessaire

Mode opératoire de contrôle
ARBRE REP. 1000 2431-3

| | | |
|-------------------|-----------------------------------|-------------------|
| Entreprise : | GAMME DE CONTROLE | Service qualité : |
| Réf. pièce : 3 | Réf. gamme : 1000 2431 - 3 - A | Etabli par : |

Croquis de la pièce :



Ø16g7

Cote maxi : Ø15,994 mm

Cote mini : Ø15,976 mm

Cote moyenne : Ø15,985 mm

| Symb. | Cote | Défaut pour correction | Défaut majeur | Défaut mineur | Action | Moyen de contrôle |
|-------|-------|------------------------|---------------|---------------|--|-------------------|
| A | Ø16g7 | > Ø15,99 | | | D3 X - (valeur relevée - cote moyenne) | ME |
| | | < Ø15,98 | | | D3 X + (cote moyenne - valeur relevée) | ME |

N° carte de contrôle pour cote x

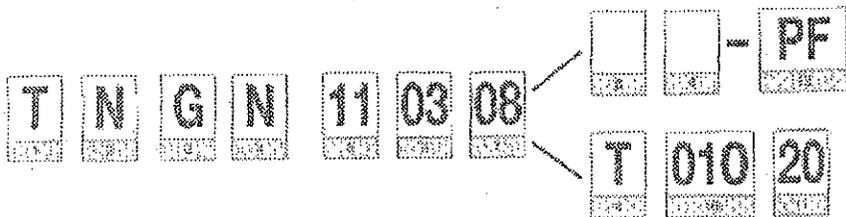
| | | | | |
|-----|-----|-----|-----|-----|
| A : | B : | C : | D : | E : |
| F : | G : | H : | I : | J : |

Matériel de contrôle

| | | |
|----------------------------|-----------------------------|----------------------------|
| PC : Pied à coulisse | JP : Jauge de profondeur | ME : Micro. ext. au 1/1000 |
| MI : Micro. int. au 1/1000 | RP : Rétroprojecteur profil | CM : Colonne de mesure |

| | | |
|-----------------------------|---------------------------|--------------------------|
| Contrôle : en cours de fab. | Prélèvement : 5 / palette | Resp. contrôle réglage : |
| Destinataires : | | Responsable dérogation : |

PLAQUETTES INDEXABLES DE TOURNAGE



Extrait de ISO 1832-1977

| 1. Formes de plaquettes | | 2. Types de dépouilles (à l'usage) | | 3. Tolérances sur les dimensions | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|---|-----------------------|--|--------|----------------------------------|----|---|----------|---|---|--------------|---|---|----------------|----|--|--|--|------------------|-----------------------|--|----|----|------|------|------|-----|--|--|------|--|--|-----|-------|-------|-----|--|--|-----|--|--|-----|--|--|------|------|--|-----|--|--|-----|--|--|-----|------|------|-----|--|--|------|--|--|------|--|------|------|--|--|------|--|--|------|--|--|------|------|--|------|--|--|------|--|--|------|------|------|------|--|--|------|--|--|-------|--|------|------|--|--|--|--|--|--|--|--|------|------|--|--|--|--|--|--|--|--|------|------|--|--|--|--|--|--|--|--|------|------|--|--|--|--|--|--|--|--|------|------|--|--|--|--|--|--|--|--|------|------|--|--|--|--|--|--|--|--|-------|-------|--|--|--|--|--|--|--|--|
| | | <table border="1"> <thead> <tr> <th>Classe</th> <th>ISO</th> <th>IN</th> </tr> </thead> <tbody> <tr> <td>G</td> <td>10-18,25</td> <td></td> </tr> <tr> <td>M</td> <td>18,25-10,125</td> <td></td> </tr> <tr> <td>V</td> <td>10,25-10,25</td> <td></td> </tr> </tbody> </table> | Classe | ISO | IN | G | 10-18,25 | | M | 18,25-10,125 | | V | 10,25-10,25 | | <p>Préciser selon le tableau de tolérances sur les dimensions.</p> <table border="1"> <thead> <tr> <th rowspan="2">Désigne l'insert</th> <th colspan="2">Chaque des tolérances</th> </tr> <tr> <th>AS</th> <th>LI</th> </tr> </thead> <tbody> <tr> <td>0,25</td> <td></td> <td></td> </tr> <tr> <td>0,5</td> <td></td> <td></td> </tr> <tr> <td>0,75</td> <td></td> <td></td> </tr> <tr> <td>1,0</td> <td>+0,05</td> <td>+0,08</td> </tr> <tr> <td>1,5</td> <td></td> <td></td> </tr> <tr> <td>2,0</td> <td></td> <td></td> </tr> <tr> <td>2,5</td> <td></td> <td></td> </tr> <tr> <td>3,0</td> <td></td> <td></td> </tr> <tr> <td>4,0</td> <td></td> <td></td> </tr> <tr> <td>5,0</td> <td></td> <td></td> </tr> <tr> <td>6,0</td> <td></td> <td></td> </tr> <tr> <td>8,0</td> <td></td> <td></td> </tr> <tr> <td>10,0</td> <td></td> <td></td> </tr> <tr> <td>12,5</td> <td></td> <td></td> </tr> <tr> <td>15,0</td> <td></td> <td></td> </tr> <tr> <td>18,0</td> <td></td> <td></td> </tr> <tr> <td>20,0</td> <td></td> <td></td> </tr> <tr> <td>25,0</td> <td></td> <td></td> </tr> <tr> <td>30,0</td> <td></td> <td></td> </tr> <tr> <td>40,0</td> <td></td> <td></td> </tr> <tr> <td>50,0</td> <td></td> <td></td> </tr> <tr> <td>63,0</td> <td></td> <td></td> </tr> <tr> <td>80,0</td> <td></td> <td></td> </tr> <tr> <td>100,0</td> <td></td> <td></td> </tr> </tbody> </table> | | | Désigne l'insert | Chaque des tolérances | | AS | LI | 0,25 | | | 0,5 | | | 0,75 | | | 1,0 | +0,05 | +0,08 | 1,5 | | | 2,0 | | | 2,5 | | | 3,0 | | | 4,0 | | | 5,0 | | | 6,0 | | | 8,0 | | | 10,0 | | | 12,5 | | | 15,0 | | | 18,0 | | | 20,0 | | | 25,0 | | | 30,0 | | | 40,0 | | | 50,0 | | | 63,0 | | | 80,0 | | | 100,0 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Classe | ISO | IN | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| G | 10-18,25 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| M | 18,25-10,125 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| V | 10,25-10,25 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
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| | AS | LI | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 0,25 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 0,5 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 0,75 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 1,0 | +0,05 | +0,08 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
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| <p>4. Table de plaquettes à tourner (forme, type)</p> <table border="1"> <thead> <tr> <th>IC</th> <th>IC</th> <th>C</th> <th>D</th> <th>R</th> <th>S</th> <th>T</th> <th>V</th> <th>W</th> <th>X</th> </tr> <tr> <th>mm</th> <th>mm</th> <th></th> <th></th> <th></th> <th></th> <th></th> <th></th> <th></th> <th></th> </tr> </thead> <tbody> <tr> <td>6,35</td> <td>6,35</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>8,0</td> <td>8,0</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>10,0</td> <td>10,0</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>12,5</td> <td>12,5</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>15,0</td> <td>15,0</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>18,0</td> <td>18,0</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>20,0</td> <td>20,0</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>25,0</td> <td>25,0</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>30,0</td> <td>30,0</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>40,0</td> <td>40,0</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>50,0</td> <td>50,0</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>63,0</td> <td>63,0</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>80,0</td> <td>80,0</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>100,0</td> <td>100,0</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> </tbody> </table> | | | | IC | IC | C | D | R | S | T | V | W | X | mm | mm | | | | | | | | | 6,35 | 6,35 | | | | | | | | | 8,0 | 8,0 | | | | | | | | | 10,0 | 10,0 | | | | | | | | | 12,5 | 12,5 | | | | | | | | | 15,0 | 15,0 | | | | | | | | | 18,0 | 18,0 | | | | | | | | | 20,0 | 20,0 | | | | | | | | | 25,0 | 25,0 | | | | | | | | | 30,0 | 30,0 | | | | | | | | | 40,0 | 40,0 | | | | | | | | | 50,0 | 50,0 | | | | | | | | | 63,0 | 63,0 | | | | | | | | | 80,0 | 80,0 | | | | | | | | | 100,0 | 100,0 | | | | | | | | |
| IC | IC | C | D | R | S | T | V | W | X | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| mm | mm | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 6,35 | 6,35 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 8,0 | 8,0 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 10,0 | 10,0 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
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| 15,0 | 15,0 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 18,0 | 18,0 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 20,0 | 20,0 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 25,0 | 25,0 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 30,0 | 30,0 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 40,0 | 40,0 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 50,0 | 50,0 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 63,0 | 63,0 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 80,0 | 80,0 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 100,0 | 100,0 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| <p>5. Types de dépouilles</p> <table border="1"> <tbody> <tr> <td>A</td> <td>M</td> </tr> <tr> <td>O</td> <td>N</td> </tr> <tr> <td>H</td> <td>W</td> </tr> <tr> <td>T</td> <td></td> </tr> <tr> <td>X</td> <td>Modèle spécial</td> </tr> </tbody> </table> | | | | A | M | O | N | H | W | T | | X | Modèle spécial | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| A | M | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| O | N | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| H | W | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| T | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| X | Modèle spécial | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |

| 4. Tolérances sur les dimensions | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|----------------------------------|--|----|----------|----|----------|----|----------|----|----------|----|----------|----|----------|----|----------|----|----------|----|----------|----|----------|----|----------|----|----------|----|----------|----|----------|----|----------|
| | <table border="1"> <tbody> <tr><td>04</td><td>s = 0,05</td></tr> <tr><td>11</td><td>s = 0,05</td></tr> <tr><td>02</td><td>s = 0,05</td></tr> <tr><td>03</td><td>s = 0,05</td></tr> <tr><td>13</td><td>s = 0,05</td></tr> <tr><td>04</td><td>s = 0,05</td></tr> <tr><td>02</td><td>s = 0,05</td></tr> <tr><td>03</td><td>s = 0,05</td></tr> <tr><td>04</td><td>s = 0,05</td></tr> <tr><td>02</td><td>s = 0,05</td></tr> <tr><td>03</td><td>s = 0,05</td></tr> <tr><td>04</td><td>s = 0,05</td></tr> <tr><td>02</td><td>s = 0,05</td></tr> <tr><td>03</td><td>s = 0,05</td></tr> <tr><td>04</td><td>s = 0,05</td></tr> </tbody> </table> | 04 | s = 0,05 | 11 | s = 0,05 | 02 | s = 0,05 | 03 | s = 0,05 | 13 | s = 0,05 | 04 | s = 0,05 | 02 | s = 0,05 | 03 | s = 0,05 | 04 | s = 0,05 | 02 | s = 0,05 | 03 | s = 0,05 | 04 | s = 0,05 | 02 | s = 0,05 | 03 | s = 0,05 | 04 | s = 0,05 |
| 04 | s = 0,05 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 11 | s = 0,05 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 02 | s = 0,05 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 03 | s = 0,05 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 13 | s = 0,05 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 04 | s = 0,05 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 02 | s = 0,05 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 03 | s = 0,05 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 04 | s = 0,05 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 02 | s = 0,05 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 03 | s = 0,05 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 04 | s = 0,05 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 02 | s = 0,05 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 03 | s = 0,05 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 04 | s = 0,05 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |

| 5. Tolérances sur les dimensions | | | | | | | | | | | | | |
|----------------------------------|--|----|----------|----|----------|----|----------|----|----------|----|----------|----|----------|
| | <table border="1"> <tbody> <tr><td>03</td><td>s = 0,05</td></tr> <tr><td>04</td><td>s = 0,05</td></tr> <tr><td>02</td><td>s = 0,05</td></tr> <tr><td>03</td><td>s = 0,05</td></tr> <tr><td>04</td><td>s = 0,05</td></tr> <tr><td>02</td><td>s = 0,05</td></tr> </tbody> </table> | 03 | s = 0,05 | 04 | s = 0,05 | 02 | s = 0,05 | 03 | s = 0,05 | 04 | s = 0,05 | 02 | s = 0,05 |
| 03 | s = 0,05 | | | | | | | | | | | | |
| 04 | s = 0,05 | | | | | | | | | | | | |
| 02 | s = 0,05 | | | | | | | | | | | | |
| 03 | s = 0,05 | | | | | | | | | | | | |
| 04 | s = 0,05 | | | | | | | | | | | | |
| 02 | s = 0,05 | | | | | | | | | | | | |

| 6. Types de dépouilles | |
|------------------------|-------------------------|
| F | Arête de coupe vive |
| E | Arête arrondie |
| T | Arête quadrée |
| R | Douille quadrée |
| S | Arête quadrée et perçée |

| 7. Direction de coupe | |
|-----------------------|---------|
| R | Arrière |
| L | Arrière |
| H | Arrière |

| 8. Tolérances sur les dimensions | | | | | | | | | | | |
|----------------------------------|---|-----|----------|-----|----------|-----|----------|-----|----------|-----|----------|
| | <table border="1"> <tbody> <tr><td>040</td><td>s = 0,10</td></tr> <tr><td>020</td><td>s = 0,10</td></tr> <tr><td>010</td><td>s = 0,10</td></tr> <tr><td>020</td><td>s = 0,10</td></tr> <tr><td>040</td><td>s = 0,10</td></tr> </tbody> </table> | 040 | s = 0,10 | 020 | s = 0,10 | 010 | s = 0,10 | 020 | s = 0,10 | 040 | s = 0,10 |
| 040 | s = 0,10 | | | | | | | | | | |
| 020 | s = 0,10 | | | | | | | | | | |
| 010 | s = 0,10 | | | | | | | | | | |
| 020 | s = 0,10 | | | | | | | | | | |
| 040 | s = 0,10 | | | | | | | | | | |

| 9. Types de dépouilles | | | | | |
|------------------------|--|----|----------|----|----------|
| | <table border="1"> <tbody> <tr><td>01</td><td>s = 0,10</td></tr> <tr><td>02</td><td>s = 0,10</td></tr> </tbody> </table> | 01 | s = 0,10 | 02 | s = 0,10 |
| 01 | s = 0,10 | | | | |
| 02 | s = 0,10 | | | | |

12. Symboles de tolérances sur les dimensions

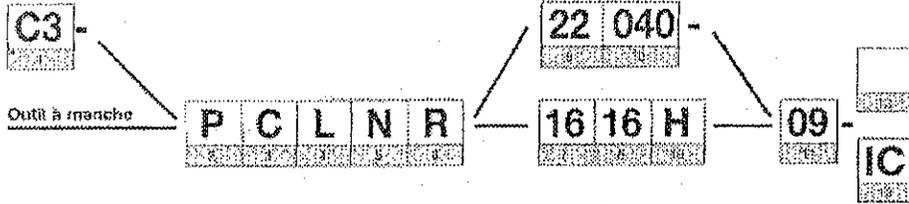
Le code ISO comprend deux symboles. Le Hème et le Hème quadrés doivent être utilisés avec la tolérance. Le Hème est un rectangle avec un angle arrondi. Le Hème quadré est un rectangle avec un angle arrondi. Le Hème est un rectangle avec un angle arrondi. Le Hème quadré est un rectangle avec un angle arrondi.

Extrait de la documentation SANDVIK

DT 5/6

CODE DE DESIGNATION DES OUTILS DE TOURNAGE

Ceromant Capto™



1. Taille et accouplement

C = Ceromant Capto™

d_{11} = taille d'accouplement

Ceromant Capto™

- D3 d_{11} = 32
- D4 d_{11} = 40
- D5 d_{11} = 50
- D6 d_{11} = 63
- D8 d_{11} = 80

2. Mode de fixation

| Fixation par bride | Fixation par trou centré et à bris | Fixation par trou central | Fixation par vis |
|--------------------|------------------------------------|---------------------------|------------------|
| | | | |
| C | M | P | S |

3. Formes de plaquettes

| | |
|--|--|
| | |
| | |
| | |
| | |

4. Type de pointe-paquette

| | | | | | |
|--|--|--|--|--|--|
| | | | | | |
| | | | | | |
| | | | | | |

6. Angle de pointe de la plaquette

| | |
|--|--|
| | |
| | |
| | |

7. Direction de coupe

| |
|--|
| |
| |
| |

7. Hauteur de manche

Hauteur tool

* Les outils doivent être présentés dans la position standard.

10. Longueur de queue

* Les outils doivent être présentés d'un D. ou d'un B. à l'arrière (2)

8. Code 7

10. Longueur des outils L₁₁ mm

Outil à manche

| | |
|---------|---------|
| A = 82 | M = 150 |
| B = 40 | N = 150 |
| C = 92 | P = 170 |
| D = 80 | Q = 150 |
| E = 70 | R = 200 |
| G = 80 | S = 280 |
| H = 102 | T = 280 |
| J = 110 | U = 320 |
| K = 120 | V = 400 |
| L = 140 | W = 400 |

X = Longueur spéciale

Ceromant Capto™

11. Longueur d'arête de coupe (mm)

12. Symbole standard propre au fabricant

Si nécessaire, un symbole supplémentaire de 3 lettres max. peut être ajouté à la fin du code C32, après un trait d'union (-) pour le type de métal.

13. Mode de fixation

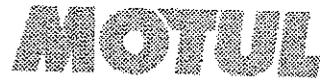
Généralités

IC = Bâtes avec bride-coupeur

IS = Bâtes avec plaque de coupe

IP = Capotés en cermet pour les courbes à 90°, en option uniquement

EXTRAIT D'UNE DOCUMENTATION DU FOURNISSEUR D'HUILE DE LUBRIFICATION



| DESIGNATION | APPLICATIONS | | | | | | | | | | | | | METEUX | | | | VALEUR PH | Dilution % | TH de l'eau |
|-------------|--------------|-------------|-------------|----------|----------|---------|---------|---------------|--------|----------|-----------|----------|-------------|---------|-------------|-----------|-------------|-----------|------------|-------------|
| | ALÉSAGE | DECOLLETAGE | DEFORMATION | FILETAGE | FRAISAGE | PERÇAGE | SHAVING | RECTIFICATION | SCIAGE | TAILLAGE | TARAUDAGE | TOURNAGE | TRONÇONNAGE | FERREUX | NON FERREUX | ALUMINIUM | USINABILITE | | | |

| DESIGNATION | ALÉSAGE | DECOLLETAGE | DEFORMATION | FILETAGE | FRAISAGE | PERÇAGE | SHAVING | RECTIFICATION | SCIAGE | TAILLAGE | TARAUDAGE | TOURNAGE | TRONÇONNAGE | FERREUX | NON FERREUX | ALUMINIUM | USINABILITE | VALEUR PH | Dilution % | TH de l'eau |
|-----------------------|---------|-------------|-------------|----------|----------|---------|---------|---------------|--------|----------|-----------|----------|-------------|---------|-------------|-----------|-------------|----------------|------------|-------------|
| SAFECO STABILIS MHB 5 | * | * | | * | * | * | * | * | * | * | * | * | * | ■ | ■ | ■ | ■ | P A 10,0:15,8 | 100 | 5 à 30 |
| SAFECO STABILIS 791 | * | * | | * | * | * | * | * | * | * | * | * | * | ■ | ■ | ■ | ■ | D 9,4:13,8 | 100 | 20 à 4 |
| SAFECO STABILIS 793 | * | * | | * | * | * | * | * | * | * | * | * | * | ■ | ■ | ■ | ■ | D 9,35:13,8 | 100 | 20 à 4 |
| SAFECO STABILIS 796 | * | * | | * | * | * | * | * | * | * | * | * | * | ■ | ■ | ■ | ■ | D 9,9:13,8 | 100 | 10 à 4 |
| SAFECO 427 | * | * | | * | * | * | * | * | * | * | * | * | * | ■ | ■ | ■ | ■ | M 8,8:13,8 | 150 | 20 à 4 |
| SAFECO STABILIS 800 | * | * | | * | * | * | * | * | * | * | * | * | * | ■ | ■ | ■ | ■ | M B D 9,4:13,8 | 100 | 10 à 4 |
| SAFECO STABILIS NM | * | * | | * | * | * | * | * | * | * | * | * | * | ■ | ■ | ■ | ■ | M B D 9,3:15,8 | 100 | 5 à 4 |
| SURFACO 77 P | * | * | | * | * | * | * | * | * | * | * | * | * | ■ | ■ | ■ | ■ | M B D 8,9:15,8 | 100 | 5 à 4 |

LEGENDE

- * Applications principales des produits
- Compatibilité
- ◆ A éviter
- ◊ Centerless uniquement

Coefficient d'usinabilité

B : R > 70
M : 50 < R < 70
D : R < 50

Structure de programme de la phase30 du corps rep. 1

