

RRD



**Polyvalence des performances
et longue durée de vie**

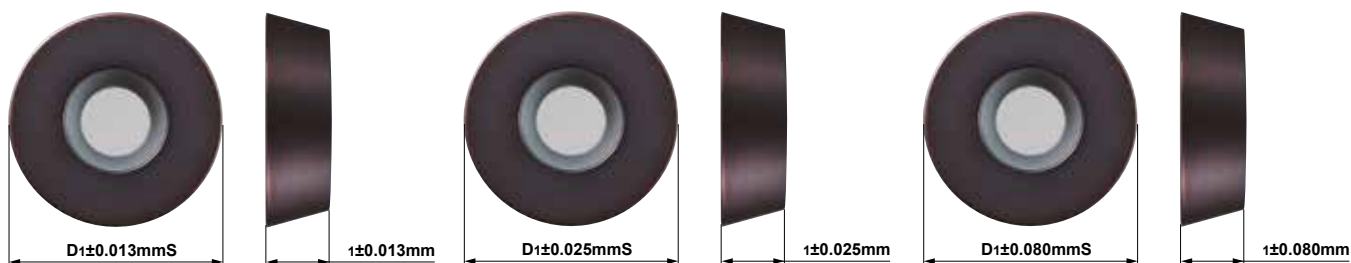


Fraises à plaquettes rondes

RRD

Caractéristiques

Les plaquettes sont disponibles avec 3 différentes tolérances pour s'adapter à toutes les applications.



RDHX

- Précision frittée (Tolérance H)
- Pour haute précision
- Pour semi-finition et finition

RDZX

- Précision frittée (Tolérance E)
- Pour application générale
- Plaquette économique avec grande durée de vie

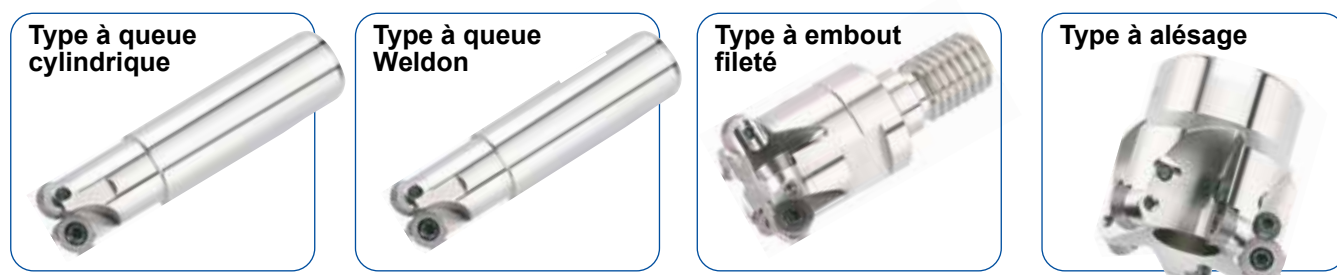
RDMX

- Précision frittée (Tolérance M)
- Pour application générale
- Pour ébauche et semi-finition

Nuances plaquettes de fraisage

ISO	Carbure revêtuC	Cermet / Cermet revêtu	carbure métallique		
P Acier	P01	VP05HT, VP10H, VP15TF, VP20M, E7030	VP25N, NX4545	UT120T	↑ Résistance à l'usure
	P10				
	P20				
	P30				
	P40				
M Acier inoxydable	M01	VP15TF, VP20M, E7030	VP25N, NX4545	UT120T	↑ Résistance à l'usure
	M10				
	M20				
	M30				
	M40				
K Fonte	K01		VP25N	UT120T	↓ Ténacité
	K10				
	K20	VP15TF			
	K30				
T Matières trempées	H01	VP05HT, VP10H, VP15TF			↓ Ténacité
	H10				
	H20				
	H30				

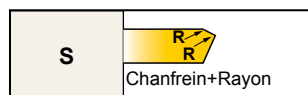
Adaptée aux fraises RRD



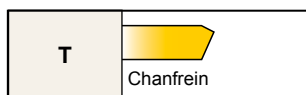
PLAQUETTES

Matière	P	Acier	● ● ● ● ●					●	Conditions de coupe (Guide) : ● : Coupe Stable ● : Coupe Générale ✖ : Coupe Instable Honing : E : Ronde S : Chanfrein + Rayon T : Chanfrein	Dimensions (mm)		Géométrie
	M	Acier Inoxydable	● ● ● ● ●	●	IC	S						
K	Fonte	✖ ✖ ✖ ✖ ✖	✖	Référéntiel		Géométrie						
S	Alliage réfractaire, Alliage titane	● ● ● ● ●		Classe	Honing							
H	Matériaux durs	● ● ● ● ●		Revêtu	Carbure							
Forme	Référence	Classe	Honing	F7030	VP15TF	VP20M	VP10H	VP05HT	UTi20T	IC	S	Géométrie
	RDHX0501M0E	H	E	●	●	●	●	●		5	1.5	
	RDHX0501M0S	H	S	●	●	●	●	●	●	5	1.5	
	RDHX07T1M0E	H	E	●	●	●	●	●		7	1.98	
	RDHX07T1M0S	H	S	●	●	●	●	●	□	7	1.98	
	RDHX0702M0E	H	E	●	●	●	●	●		7	2.38	
	RDHX0702M0S	H	S	●	●	●	●	●	□	7	2.38	
	RDHX1003M0E	H	E	●	●	●	●	●		10	3.18	
	RDHX1003M0S	H	S	●	●	●	●	●	□	10	3.18	
	RDHX12T3M0E	H	E	●	●	●	●	●		12	3.97	
	RDHX12T3M0S	H	S	●	●	●	●	●	□	12	3.97	
	RDHX1604M0E	H	E	●	●	●	●	●		16	4.76	
	RDHX1604M0S	H	S	●	●	●	●	●	□	16	4.76	
IC: ±0.013 mm S: ±0.013 mm												
	RDMX07T1M0E	M	E					●		7	1.98	
	RDMX07T1M0T	M	T	●	●	●	●	●	□	7	1.98	
	RDMX0702M0E	M	E					●		7	2.38	
	RDMX0702M0T	M	T	●	●	●	●	●	□	7	2.38	
	RDMX1003M0E	M	E					●		10	3.18	
	RDMX1003M0S	M	S	●	●	●	●	●		10	3.18	
	RDMX1003M0T	M	T	●	●	●	●	●	●	10	3.18	
	RDMX12T3M0E	M	E					●		12	3.97	
	RDMX12T3M0S	M	S	●	●	●	●	●		12	3.97	
	RDMX12T3M0T	M	T	●	●	●	●	●	●	12	3.97	
	RDMX1604M0E	M	E					●		16	4.76	
	RDMX1604M0S	M	S	●	●	●	●	●		16	4.76	
RDMX1604M0T	M	T	●	●	●	●	●	●	16	4.76		
IC: ±0.080 mm S: ±0.080 mm												
	RDZX0501M0E	Z	E	●						5	1.50	
	RDZX0501M0S	Z	S	●						5	1.50	
	RDZX07T1M0E	Z	E	●						7	1.98	
	RDZX07T1M0S	Z	S	●						7	1.98	
	RDZX0702M0E	Z	E	●						7	2.38	
	RDZX0702M0S	Z	S	●						7	2.38	
	RDZX1003M0E	Z	E	●						10	3.18	
	RDZX1003M0S	Z	S	●	●					10	3.18	
	RDZX12T3M0E	Z	E	●						12	3.97	
	RDZX12T3M0S	Z	S	●	●					12	3.97	
	RDZX1604M0E	Z	E	●						16	4.76	
	RDZX1604M0S	Z	S	●	●					16	4.76	
IC: ±0.025 mm S: ±0.025 mm												

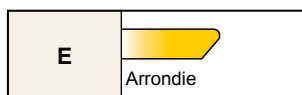
Configuration de l'arête



Pour l'ébauche



Pour ébauche et finition



Pour la finition

● : article stocké. □ : produit sur commande uniquement.

FRAISES MULTI FONCTIONS

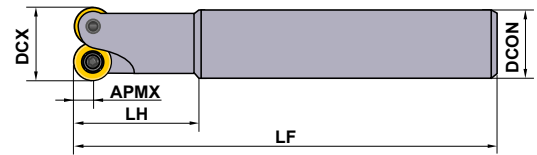
RRD



Ébauche



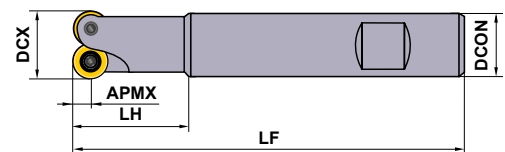
P M K N S H



FRAISE À QUEUE CYLINDRIQUE

Porte-outil à droite uniquement.

R (mm)	Référence	Stock	Nombre de dents	Dimensions (mm)					Vis de fixation	Clé	Plaquette
				DCX	DCON	LF	LH	APMX			
2.5	RRD025R102S10Z-B20	●	2	10	10	75	23	2.5	B-TS20	TKY06F	RDH/Z 0501M0
	RRD025R123S12Z-B20	●	3	12	12	75	23	2.5	B-TS20	TKY06F	
	RRD025R154S16Z-B20	●	4	15	16	80	23	2.5	B-TS20	TKY06F	
3.5	RRD035R122S10Z	●	2	12	10	75	23	3.5	B-TS253	TKY07F	RDH/M/Z 07T1M0
	RRD035R122S12Z	●	2	12	12	75	23	3.5	B-TS253	TKY07F	
	RRD035R122S16Z	●	2	12	16	88	15	3.5	B-TS253	TKY07F	
	RRD035R122S16ZL	●	2	12	16	128	15	3.5	B-TS253	TKY07F	
	RRD035R122S16ZM	●	2	12	16	108	15	3.5	B-TS253	TKY07F	
3.5	RRD035R152S16Z	●	2	15	16	88	18	3.5	TS25	TKY08F	RDH/M/Z 0702M0
	RRD035R152S16ZM	●	2	15	16	108	18	3.5	TS25	TKY08F	
	RRD035R152S20Z	●	2	15	20	130	20	3.5	TS25	TKY08F	
	RRD035R152S20ZM	●	2	15	20	150	20	3.5	TS25	TKY08F	
	RRD035R152S25Z	●	2	15	25	176	20	3.5	TS25	TKY08F	
3.5	RRD035R153S12Z	●	3	15	12	75	17	3.5	TS253	TKY08F	RDH/M/Z 07T1M0
	RRD035R153S16Z	●	3	15	16	78	30	3.5	TS253	TKY08F	
5	RRD050R202S20Z	●	2	20	20	90	31	5.0	B-TS35	TKY15F	RDH/M/Z 1003M0
	RRD050R202S20ZM	●	2	20	20	110	51	5.0	B-TS35	TKY15F	
	RRD050R202S25Z	●	2	20	25	136	72	5.0	B-TS35	TKY15F	
	RRD050R202S25ZL	●	2	20	25	176	112	5.0	B-TS35	TKY15F	
	RRD050R202S25ZM	●	2	20	25	156	92	5.0	B-TS35	TKY15F	



ATTACHEMENT WELDON

Porte-outil à droite uniquement.

R (mm)	Référence	Stock	Nombre de dents	Dimensions (mm)					Vis de fixation	Clé	Plaquette
				DCX	DCON	LF	LH	APMX			
3.5	RRD035R122S16W	●	2	12	16	88	15	3.5	B-TS253	TKY07F	RDH/M/Z 07T1M0
	RRD035R122S16WL	●	2	12	16	128	15	3.5	B-TS253	TKY07F	
	RRD035R122S16WM	●	2	12	16	108	15	3.5	B-TS253	TKY07F	
3.5	RRD035R152S16W	●	2	15	16	88	18	3.5	TS25	TKY08F	RDH/M/Z 0702M0
	RRD035R152S16WM	●	2	15	16	108	18	3.5	TS25	TKY08F	
	RRD035R152S20W	●	2	15	20	130	20	3.5	TS25	TKY08F	
	RRD035R152S20WM	●	2	15	20	150	20	3.5	TS25	TKY08F	
	RRD035R152S25W	●	2	15	25	176	20	3.5	TS25	TKY08F	
3.5	RRD035R153S16W	●	3	15	16	78	30	3.5	TS253	TKY08F	RDH/M/Z 07T1M0
5	RRD050R202S20W	●	2	20	20	90	31	5.0	B-TS35	TKY15F	RDH/M/Z 1003M0
	RRD050R202S20WM	●	2	20	20	110	51	5.0	B-TS35	TKY15F	
	RRD050R202S25W	●	2	20	25	135	72	5.0	B-TS35	TKY15F	
	RRD050R202S25WL	●	2	20	25	176	112	5.0	B-TS35	TKY15F	
	RRD050R202S25WM	●	2	20	25	156	92	5.0	B-TS35	TKY15F	

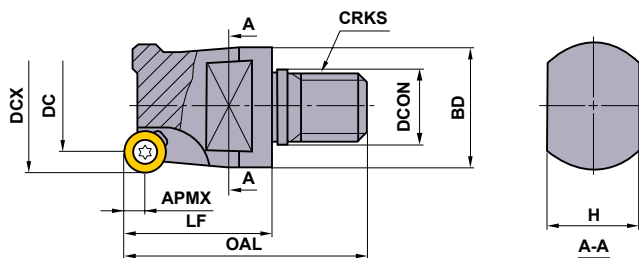
● : Article stocké.

FRAISES MULTI FONCTIONS

RRD



Ébauche



FRAISE À EMBOUT FILETÉ

Porte-outil à droite uniquement.

R (mm)	Référence	Stock	Nombre de dents	Dimensions (mm)								Vis de fixation	Vis de fixation	Clé	Plaquette	
				DCX	DC	OAL	LF	DCON	BD	CRKS	APMX					H
2.5	RRD025R102M5-B20	●	2	10	5	35	20	5.5	9.9	M5	2.5	6	B-TS20	—	TKY06F	RDH/Z 0501M0
	RRD025R123M8-B20	●	3	12	7	38	20	8.5	13.5	M8	2.5	9	B-TS20	—	TKY06F	
	RRD025R154M8-B20	●	4	15	10	38	20	8.5	13.5	M8	2.5	10	B-TS20	—	TKY06F	
	RRD025R205M10-B20	●	5	20	15	44	25	10.5	18	M10	2.5	15	B-TS20	—	TKY06F	
3.5	RRD035R122M8	●	2	12	5	46	28	8.5	13.5	M8	3.5	9	B-TS253	—	TKY07F	RDH/M/Z 07T1M0
	RRD035R153M8	●	3	15	8	46	28	8.5	13.5	M8	3.5	10	TS253	—	TKY08F	
	RRD035R204M10	●	4	20	13	47	28	10.5	18	M10	3.5	15	TS253	—	TKY08F	
	RRD035R255M12	●	5	25	18	50	28	12.5	21	M12	3.5	17	TS253	—	TKY08F	
	RRD035R306M16	●	6	30	23	51	28	17	29	M16	3.5	22	TS253	—	TKY08F	
	RRD035R357M16	●	7	35	28	51	28	17	29	M16	3.5	22	TS253	—	TKY08F	
3.5	RRD035R152M8	●	2	15	8	46	28	8.5	13.5	M8	3.5	10	TS25	—	TKY08F	RDH/M/Z 0702M0
	RRD035R153M8X	●	3	15	8	43	28	8.5	13.5	M8	3.5	10	TS25	—	TKY08F	
5	RRD050R202M10	●	2	20	10	47	28	10.5	18	M10	5.0	15	B-TS35	—	TKY15F	RDH/M/Z 1003M0
	RRD050R252M12	●	2	25	15	54	32	12.5	21	M12	5.0	17	B-TS35	—	TKY15F	
	RRD050R253M12	●	3	25	15	54	32	12.5	21	M12	5.0	17	B-TS35	—	TKY15F	
	RRD050R304M12	●	4	30	20	54	32	12.5	21	M12	5.0	17	B-TS35	—	TKY15F	
	RRD050R304M16	●	4	30	20	55	32	17	29	M16	5.0	22	B-TS35	—	TKY15F	
	RRD050R355M16	●	5	35	25	65	42	17	29	M16	5.0	22	B-TS35	—	TKY15F	
	RRD050R426M16	●	6	42	32	65	42	17	29	M16	5.0	22	B-TS35	—	TKY15F	
6	RRD060R242M12	●	2	24	12	54	32	12.5	21	M12	6.0	17	B-TS35	—	TKY15F	RDH/M/Z 12T3M0
	RRD060R353M16	●	3	35	23	65	42	17	29	M16	6.0	22	B-TS35	TS1001	TKY15F	
	RRD060R354M16	●	4	35	23	65	42	17	29	M16	6.0	22	B-TS35	TS1001	TKY15F	
	RRD060R424M16	●	4	42	30	55	32	17	29	M16	6.0	24	B-TS35	TS1001	TKY15F	
	RRD060R425M16	●	5	42	30	65	42	17	29	M16	6.0	22	B-TS35	TS1001	TKY15F	
8	RRD080R322M16	●	2	32	16	65	42	17	29	M16	8.0	22	214	—	TKY20F	RDH/M/Z 1604M0

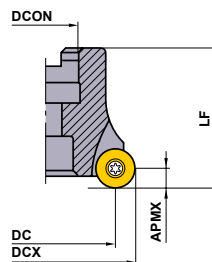
(Remarque) Pour les arbres vissables, veuillez vous référer à la page K144–K145.

FRAISES MULTI FONCTIONS

RRD N



Ebauche



TYPE À ALÉSAGE (neutre)

Porte-outil à droite uniquement.

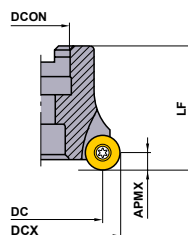
R (mm)	Référence	Stock		Dimensions (mm)					* WT (kg)	Accessoires					
		R	Nombre de dents	DCX	DC	LF	DCON	APMX		Assise	Vis assise	Vis de fixation	Vis de fixation	Clé	Plaquette
5	RRD050N-042A06R	●	6	42	32	44	16	5	0.26	—	—	B-TS35	—	TKY15F	RDH/M/Z
	RRD050N-052A07R	●	7	52	42	50	22	5	0.4	—	—	B-TS35	—	TKY15F	1003M0
6	RRD060N-042A05R	●	5	42	30	42	16	6	0.26	—	—	B-TS35	TS1001	TKY15F	RDH/M/Z 12T3M0
	RRD060N-050A05R	●	5	50	38	50	22	6	0.38	—	—	B-TS35	TS1001	TKY15F	
	RRD060N-052A05R	●	5	52	40	50	22	6	0.4	—	—	B-TS35	TS1001	TKY15F	
	RRD060N-063A06R	●	6	63	51	50	22	6	0.33	—	—	B-TS35	TS1001	TKY15F	
8	RRD080N-050A04R	●	4	50	34	50	22	8	0.4	KS-12	B-TS45	214	—	TKY20F	RDH/M/Z 1604M0
	RRD080N-052A04R	●	4	52	36	50	22	8	0.4	KS-12	B-TS45	214	—	TKY20F	
	RRD080N-052A05R	●	5	52	36	50	22	8	0.4	KS-12	B-TS45	214	—	TKY20F	
	RRD080N-063A05R	●	5	63	47	50	22	8	0.58	KS-12	B-TS45	214	—	TKY20F	
	RRD080N-066A05R	●	5	66	50	50	27	8	0.6	KS-12	B-TS45	214	—	TKY20F	
	RRD080N-080A06R	●	6	80	64	52	27	8	1	KS-12	B-TS45	214	—	TKY20F	
	RRD080N-100A07R	●	7	100	84	52	32	8	1.5	KS-12	B-TS45	214	—	TKY20F	
	RRD080N-125B08R	●	8	125	109	52	40	8	2.5	KS-12	B-TS45	214	—	TKY20F	
RRD080N-160C09R	●	9	160	144	52	40	8	3.5	KS-12	B-TS45	214	—	TKY20F		

* WT : Poids de l'outil

RRD P



Ebauche



TYPE À ALÉSAGE (plaquette positive)

Porte-outil à droite uniquement.

R (mm)	Référence	Stock		Dimensions (mm)					* WT (kg)	Accessoires					
		R	Nombre de dents	DCX	DC	LF	DCON	APMX		Assise	Vis assise	Vis de fixation	Vis de fixation	Clé	Plaquette
6	RRD060P-050A05R	●	5	50	38	50	22	6	0.33	—	—	B-TS35	TS1001	TKY15F	RDH/M/Z 12T3M0E
	RRD060P-052A05R	●	5	52	40	50	22	6	0.35	—	—	B-TS35	TS1001	TKY15F	
	RRD060P-063A06R	●	6	63	51	50	22	6	0.58	—	—	B-TS35	TS1001	TKY15F	
	RRD060P-066A06R	●	6	66	54	52	27	6	0.6	—	—	B-TS35	TS1001	TKY15F	
	RRD060P-080A07R	●	7	80	68	50	27	6	1.0	—	—	B-TS35	TS1001	TKY15F	
8	RRD080P-050A04R	●	4	50	34	50	22	8	0.33	KS-12	B-TS45	214	—	TKY20F	RDH/M/Z 1604M0
	RRD080P-063A05R	●	5	63	47	50	22	8	0.53	KS-12	B-TS45	214	—	TKY20F	
	RRD080P-066A05R	●	5	66	50	50	27	8	0.55	KS-12	B-TS45	214	—	TKY20F	
	RRD080P-080A06R	●	6	80	64	52	27	8	1.0	KS-12	B-TS45	214	—	TKY20F	
	RRD080P-100A07R	●	7	100	84	52	32	8	1.5	KS-12	B-TS45	214	—	TKY20F	
	RRD080P-125B08R	●	8	125	109	52	40	8	2.6	KS-12	B-TS45	214	—	TKY20F	
	RRD080P-160C09R	●	9	160	144	52	40	8	3.5	KS-12	B-TS45	214	—	TKY20F	

* WT : Poids de l'outil

● : Article stocké.

CONDITIONS DE COUPE RECOMMANDÉES

CONDITIONS DE COUPE POUR L'ÉBAUCHE (ae=50 % du Ø)

Matière	Dureté	Nuance	Vitesse de coupe (m/min)	Ø10-15mm		Ø20mm		Ø24-25mm		Ø30-42mm		Ø50-80mm		Ø100-160mm	
				ap (mm)	fz (mm)	ap (mm)	fz (mm)	ap (mm)	fz (mm)	ap (mm)	fz (mm)	ap (mm)	fz (mm)	ap (mm)	fz (mm)
P Acier doux	≤180HB	NX4545 F7030 VP15TF	(250-320)	-0.2	0.25	-0.5	0.45	-1.0	0.35	-1.0	0.40	-1.0	0.50	-1.5	0.60
			(240-300)	0.2-0.3	0.20	0.5-1.0	0.25	1.0-2.0	0.30	1.5-2.0	0.32	1.0-1.5	0.40	1.5-2.5	0.45
			(200-280)	0.3-0.5	0.12	1.0-1.5	0.15	2.0-2.5	0.20	2.0-3.0	0.25	1.5-3.0	0.35	2.5-5.0	0.35
Acier carbone Alliage acier	180-350HB	NX4545 F7030 VP15TF	(220-300)	-0.2	0.20	-0.5	0.40	-1.0	0.30	-1.0	0.40	-1.0	0.50	-1.5	0.55
			(200-290)	0.2-0.3	0.15	0.5-1.0	0.20	1.0-1.5	0.25	1.5-2.0	0.30	1.0-1.5	0.38	1.5-2.5	0.40
			(160-250)	0.3-0.5	0.10	1.0-1.5	0.10	1.5-2.0	0.22	2.0-3.0	0.22	1.5-3.0	0.30	2.5-4.5	0.32
M Acier inoxydable	≤270HB	F7030 VP20M	(180-240)	-0.1	0.15	-0.5	0.20	-1.0	0.20	-1.0	0.25	-1.0	0.25	-1.5	0.30
			(160-200)	0.1-0.2	0.15	0.5-1.0	0.15	1.0-2.0	0.18	1.5-2.0	0.20	1.0-1.5	0.22	1.5-2.5	0.25
			(140-180)	0.2-0.25	0.10	1.0-1.5	0.12	2.0-2.5	0.14	2.0-3.0	0.15	1.5-3.0	0.18	2.5-5.0	0.20
K Fonte	Résistance à la traction ≤450MPa	VP15TF VP20M VP10H	(200-250)	-0.1	0.15	-0.5	0.18	-1.0	0.20	-1.0	0.25	-1.0	0.30	-1.5	0.35
			(180-230)	0.1-0.2	0.10	0.5-1.0	0.10	1.0-1.5	0.15	1.5-2.0	0.18	1.0-1.5	0.25	1.5-2.5	0.22
			(160-200)	0.2-0.25	0.10	1.0-1.5	0.10	1.5-2.0	0.12	2.0-3.0	0.15	1.5-3.0	0.18	2.5-4.5	0.20
H Acier traité	-52HRC -58HRC -60HRC	VP15TF VP10H VP05HT	(140-200)	-0.1	0.12	-0.1	0.14	-0.1	0.15	-0.1	0.18	-0.1	0.18	-0.1	0.20
			(110-180)	0.1-0.15	0.10	0.1-0.20	0.12	0.1-0.30	0.12	0.1-0.30	0.14	0.1-0.30	0.14	0.1-0.30	0.15
			(100-170)	0.1-0.15	0.10	0.1-0.20	0.10	0.1-0.30	0.10	0.1-0.30	0.12	0.1-0.30	0.12	0.1-0.30	0.12

(Remarque 1) Lorsque vous utilisez une pleine largeur de coupe s'il vous plaît diminuer les conditions de coupe de 20%.

(Remarque 2) Lorsque vous utilisez un grand porte à faux s'il vous plaît réduire la vitesse d'avance de 20%.

CONDITIONS DE COUPE POUR LA FINITION (ae=50 % du Ø)

Matière	Dureté	Nuance	Vitesse de coupe (m/min)	Ø10-15mm		Ø20mm		Ø24-25mm		Ø30-42mm		Ø50-80mm		Ø100-160mm	
				ap (mm)	fz (mm)	ap (mm)	fz (mm)	ap (mm)	fz (mm)	ap (mm)	fz (mm)	ap (mm)	fz (mm)	ap (mm)	fz (mm)
P Acier doux	≤180HB	NX4545 F7030 VP15TF	(260-360)	-0.1	0.15	-0.15	0.20	-0.15	0.25	-0.15	0.30	-0.15	0.32	-0.3	0.35
			(240-320)	0.1-0.2	0.15	0.1-0.2	0.15	0.1-0.2	0.18	0.1-0.3	0.20	0.1-0.3	0.22	0.2-0.3	0.25
			(220-280)	0.2-0.24	0.10	0.1-0.30	0.15	0.1-0.30	0.18	0.1-0.30	0.20	0.2-0.30	0.20	0.3-0.40	0.20
Acier carbone Alliage acier	180-350HB	NX4545 F7030 VP15TF	(250-350)	-0.1	0.12	-0.1	0.15	-0.1	0.18	-0.1	0.25	-0.1	0.28	-0.15	0.30
			(230-310)	0.1-0.15	0.12	0.1-0.30	0.15	0.1-0.30	0.15	0.1-0.30	0.20	0.1-0.3	0.22	0.15-0.3	0.25
			(210-270)	0.15-0.2	0.10	0.15-0.30	0.12	0.15-0.30	0.15	0.15-0.30	0.15	0.2-0.3	0.18	0.2-0.3	0.18
M Acier inoxydable	≤270HB	F7030 VP20M	(180-240)	-0.1	0.12	-0.1	0.18	-0.1	0.20	-0.1	0.22	-0.1	0.25	-0.15	0.30
			(160-200)	0.1-0.2	0.10	0.1-0.30	0.12	0.1-0.3	0.15	0.1-0.3	0.18	0.1-0.3	0.20	0.15-0.3	0.22
			(140-180)	0.2-0.25	0.10	0.2-0.30	0.10	0.2-0.3	0.12	0.2-0.3	0.12	0.2-0.3	0.15	0.2-0.3	0.18
K Fonte	Résistance à la traction ≤450MPa	VP15TF VP20M VP10H	(200-300)	-0.1	0.15	-0.1	0.18	-0.1	0.20	-0.1	0.22	-0.1	0.25	-0.15	0.30
			(200-280)	0.1-0.2	0.10	0.1-0.30	0.10	0.1-0.3	0.15	0.1-0.3	0.15	0.1-0.3	0.20	0.15-0.3	0.22
			(180-240)	0.2-0.25	0.10	0.2-0.40	0.10	0.2-0.4	0.12	0.2-0.4	0.12	0.2-0.4	0.15	0.2-0.4	0.18
H Acier traité	-52HRC -58HRC -60HRC	VP15TF VP10H VP05HT	(150-200)	-0.1	0.15	-0.1	0.14	-0.1	0.15	-0.1	0.18	-0.1	0.18	-0.1	0.20
			(120-180)	0.1-0.15	0.10	0.1-0.20	0.12	0.1-0.30	0.12	0.1-0.30	0.14	0.1-0.30	0.14	0.1-0.30	0.15
			(100-180)	0.1-0.15	0.10	0.1-0.20	0.10	0.1-0.30	0.10	0.1-0.30	0.12	0.1-0.30	0.12	0.1-0.30	0.12

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(Remarque 2) Lorsque vous utilisez un grand porte à faux s'il vous plaît réduire la vitesse d'avance de 20%.



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