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# LSE445

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FRAISES À PLAQUETTES POUR LA MÉCANIQUE GÉNÉRALE  
PLAQUETTES POSITIVES À 20°

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*M*plus...

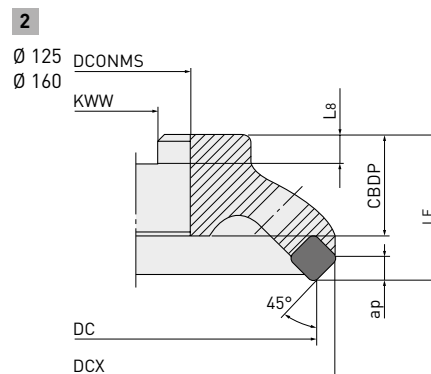
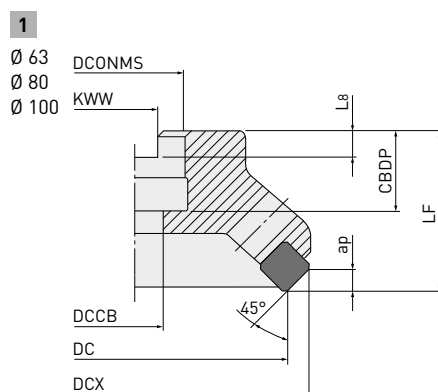
# LSE445



## FRAISE À SURFACER



CH: 45°  
A.R: +19°      T: +13°  
RR: -2°      I: +15°



### ATTACHEMENT PAR ALÉSAGE

Référence	Stock		ZEFP	DC	DCX	LF	DCONMS	CBDP	DCCB	KWW	L8	WT	APMX		Type
	R	L													
LSE445-063A05R/L-E	●	□	5	63	76.5	40	22	20	11	10.4	6.4	0.8	5.5	—	1
LSE445-080A06R/L-E	●	□	6	80	93.5	50	27	22	13.5	12.4	7.0	1.0	5.5	—	1
LSE445-100A07R/L-E	●	□	7	100	113.5	50	32	25	17.5	14.4	8.0	1.4	5.5	—	1
LSE445-125B09R/L-E	□	□	9	125	138.5	50	40	32	—	16.4	9.0	2.0	5.5	—	2
LSE445-160B11R/L-E	□	□	11	160	173.5	50	40	32	—	16.4	9.0	3.0	5.5	—	2

1/1



## PIÈCES DÉTACHÉES

Référence porte-outil	*1					
	Assise	Vis d'assise	Coin	Vis de serrage	Clé	Clé
LSE445 -063A05R/L-E				LS10T		
LSE445 -080A04R/L-E						
LSE445-100A07R/L-E	STBE445NF	CS300890T	CWSE445TR	LS15T	TKY25T	TKY08F
LSE445-125B09R/L-E						
LSE445 -160B11R/L-E						

\*1 Couple de serrage (N • m) : LS10T= 8.5. LS15T= 8.5. CS300890T= 1.0



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## CONDITIONS DE COUPE RECOMMANDÉES

Matière	Dureté	Nuance	Vc	fz
P Acier doux	<180HB	F7030	300 (200 – 360)	0.2 (0.1 – 0.3)
		NX4545		
		UTi20T	240 (170 – 300)	
		UP20M		
Acier carbone Acier allié	180 – 280HB	F7030	250 (170 – 300)	0.2 (0.1 – 0.3)
		NX4545		
		UTi20T	200 (140 – 240)	
		UP20M		
M Acier inoxydable	<200HB	UTi20T	140 (100 – 170)	0.15 (0.1 – 0.2)
		UP20M		
K Fonte	Résistance à la traction <450MPa	MC5020	200 (130 – 240)	0.2 (0.1 – 0.3)
		F5010		
		F5020	160 (110 – 190)	
		UTi20T		
N Alliage aluminium	—	MD220	1000 (200 – 1500)	0.15 (0.05 – 0.25)
		HTi10	1000 (700 – 1200)	0.12 (0.05 – 0.2)

1/1

1. Régime ( $\text{min}^{-1}$ ) =  $(1000 \times \text{Vitesse de coupe}) \div (3.14 \times \text{ØD1})$ .

2. Avance table ( $\text{mm}/\text{min}$ ) = Avance par dent  $\times$  Nombre de dents  $\times$  Régime.











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