

LSE445

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



*M*plus...

LSE445

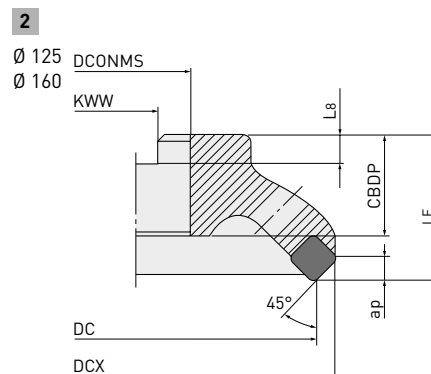
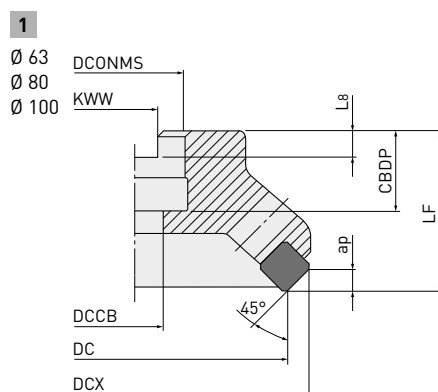
FRAISE À SURFACER



P M K N



C H: 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

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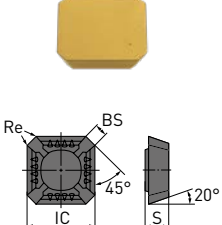
PIÈCES DÉTACHÉES

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						

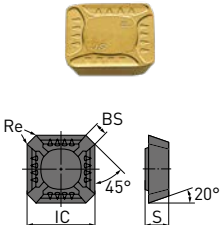
Couple de serrage (N • m) : LS10T= 8.5. LS15T= 8.5. CS300890T= 1.0

LSE445 – PLAQUETTES

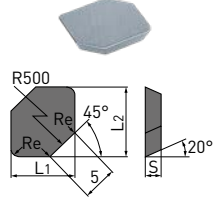
P	Acier	●	●	●	●	●	●	●	Conditions de coupe :
M	Acier Inoxydable	●	●	●	●	●	●	●	● : Coupe Stable ● : Coupe Générale ✖ : Coupe Instable
K	Fonte			●	✖	●		✖	Honing :
N	Non-ferreux								● E : Arrondie F : Vive S : Chanfrein + Rayon T : Chanfrein Z : Renfort

Référence	Classe	Honing	F7010	F7030	MC5020	VP15TF	NX2525	NX4545	UT120T	HT10	IC	S	BS	RE	Forme
SEEN1203AFFN1	E	F								●	12.7	3.18	1.4	1.0	
SEEN1203AFEN1	E	E				●					12.7	3.18	1.4	1.0	
SEEN1203AFTN1	E	T	●				●		●		12.7	3.18	1.4	1.0	
SEEN1203AFTN3	E	T	●					●	★		12.7	3.18	1.4	—	
SEEN1203AFSN1	E	S		●	●						12.7	3.18	1.4	1.0	
SEEN1203AFSN3	E	S		●							12.7	3.18	1.4	—	
SEEN1203AFZN1	E	Z					●				12.7	3.18	1.4	1.0	

Plaquettes avec brise-copeaux

SEER1203AFEN-JS	E	E	●	●	●	●					12.7	3.18	1.4	1.0	
SEER1204AFEN-JS	E	E	●								12.7	3.18	1.4	1.0	

Plaquettes de planage

WEC42AFTR5C	C	T					●				—	3.18	5	1.0	
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LSE445

CONDITIONS DE COUPE RECOMMANDÉES

Matière	Dureté	Nuance	Vc	fz
P	Acier doux	F7030	300 (200 – 360)	0.2 (0.1 – 0.3)
		NX4545		
		UTi20T	240 (170 – 300)	
		UP20M		
	Acier carbone Acier allié	F7030	250 (170 – 300)	0.2 (0.1 – 0.3)
		NX4545		
		UTi20T	200 (140 – 240)	
		UP20M		
280 – 350HB	UTi20T	140 (100 – 170)	0.15 (0.1 – 0.2)	
M	Acier inoxydable	UP20M	200 (140 – 240)	0.2 (0.1 – 0.3)
		UTi20T		
		K	Fonte	
F5010				
F5020				
HTi10	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)

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Régime (min⁻¹) = (1000 x Vitesse de coupe) ÷ (3.14 x ØD1).

Avance table (mm/min) = Avance par dent x Nombre de dents x Régime.



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