

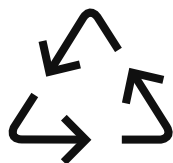
CoroMill® Plura à bout sphérique Gamme et application



Offre de services



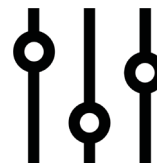
Réaffûtage
DC ≥ 6 mm (0.236 po)



Recyclage



CoroPlus® Tool
Guide



Tailor Made™



Outils spéciaux
avancés

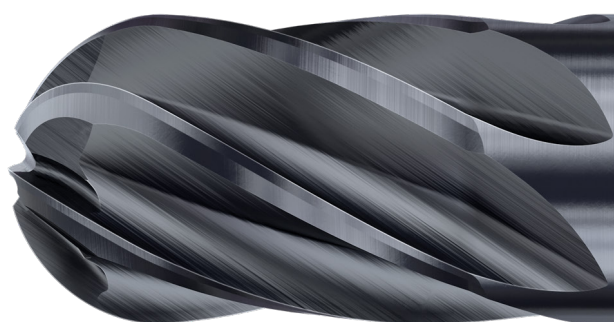
Usinage de SAR (matériau secondaire : ISO H)

S2 H

Programme standard

Code	Nuance	DC	DCON	APMX	RE	LU	LB1	Collet	ZEFP	OHX	LF	Queue
2B255-0300-RA R2AH (mm)	R2AH	3	6	4.5	1.5	4.5	10.5	Non	5	21	57	Cylindrique
2B256-0400-RA R2AH (mm)	R2AH	4	6	6	2	6	13	Non	6	21	57	Cylindrique
2B256-0500-RA R2AH (mm)	R2AH	5	6	7.5	2.5	7.5	16	Non	6	21	57	Cylindrique
2B256-0600-RA R2AH (mm)	R2AH	6	6	9	3	9	-	Non	6	21	57	Cylindrique
2B256-0800-RA R2AH (mm)	R2AH	8	8	12	4	12	-	Non	6	27	63	Cylindrique
2B256-1000-RA R2AH (mm)	R2AH	10	10	15	5	15	-	Non	6	32	72	Cylindrique
2B256-1200-RA R2AH (mm)	R2AH	12	12	18	6	18	-	Non	6	38	83	Cylindrique
2B256-1600-RA R2AH (mm)	R2AH	16	16	24	8	24	-	Non	6	44	92	Cylindrique
2B256-2000-RA R2AH (mm)	R2AH	20	20	30	10	30	-	Non	6	54	104	Cylindrique
2B255-0318-RA R2AH (po)	R2AH	0.125	0.25	0.1875	0.0625	0.1875	0.4375	Non	5	0.8327	2.25	Cylindrique
2B256-0476-RA R2AH (po)	R2AH	0.1875	0.25	0.2813	0.0938	0.2813	0.625	Non	6	0.8327	2.25	Cylindrique
2B256-0635-RA R2AH (po)	R2AH	0.25	0.25	0.375	0.125	0.375	-	Non	6	0.8327	2.25	Cylindrique
2B256-0794-RA R2AH (po)	R2AH	0.3125	0.3125	0.4688	0.1563	0.4688	-	Non	6	1.0827	2.5	Cylindrique
2B256-0953-RA R2AH (po)	R2AH	0.375	0.375	0.5625	0.1875	0.5625	-	Non	6	1.4370	3	Cylindrique
2B256-1270-RA R2AH (po)	R2AH	0.5	0.5	0.75	0.25	0.75	-	Non	6	1.7165	3.5	Cylindrique
2B256-1588-RA R2AH (po)	R2AH	0.625	0.625	0.9375	0.3125	0.9375	-	Non	6	1.5945	3.5	Cylindrique
2B256-1905-RA R2AH (po)	R2AH	0.75	0.75	1.125	0.375	1.125	-	Non	6	1.9685	4	Cylindrique

Code	Nuance	DC	DCON	APMX	RE	LU	LB1	Collet	ZEFP	OHX	LF	Queue
2B285-0300-RA R2AH (mm)	R2AH	3	6	4.5	1.5	4.5	15	Non	5	34	70	Cylindrique
2B286-0400-RA R2AH (mm)	R2AH	4	6	6	2	6	20	Non	6	34	70	Cylindrique
2B286-0500-RA R2AH (mm)	R2AH	5	6	7.5	2.5	7.5	25	Non	6	44	80	Cylindrique
2B286-0600-RA R2AH (mm)	R2AH	6	6	9	3	9	-	Non	6	44	80	Cylindrique
2B286-0800-RA R2AH (mm)	R2AH	8	8	12	4	12	-	Non	6	44	80	Cylindrique
2B286-1000-RA R2AH (mm)	R2AH	10	10	15	5	15	-	Non	6	60	100	Cylindrique
2B286-1200-RA R2AH (mm)	R2AH	12	12	18	6	18	-	Non	6	60	105	Cylindrique
2B286-1600-RA R2AH (mm)	R2AH	16	16	24	8	24	-	Non	6	77	125	Cylindrique
2B286-2000-RA R2AH (mm)	R2AH	20	20	30	10	30	-	Non	6	100	150	Cylindrique
2B285-0318-RA R2AH (po)	R2AH	0.125	0.25	0.1875	0.0625	0.1875	0.625	Non	5	1.5827	3	Cylindrique
2B286-0476-RA R2AH (po)	R2AH	0.1875	0.25	0.2813	0.0938	0.2813	1	Non	6	1.5827	3	Cylindrique
2B286-0635-RA R2AH (po)	R2AH	0.25	0.25	0.375	0.125	0.375	-	Non	6	1.5827	3	Cylindrique
2B286-0794-RA R2AH (po)	R2AH	0.3125	0.3125	0.4688	0.1563	0.4688	-	Non	6	2.0827	3.5	Cylindrique
2B286-0953-RA R2AH (po)	R2AH	0.375	0.375	0.5625	0.1875	0.5625	-	Non	6	2.4370	4	Cylindrique
2B286-1270-RA R2AH (po)	R2AH	0.5	0.5	0.75	0.25	0.75	-	Non	6	2.7165	4.5	Cylindrique
2B286-1588-RA R2AH (po)	R2AH	0.625	0.625	0.9375	0.3125	0.9375	-	Non	6	3.0945	5	Cylindrique
2B286-1905-RA R2AH (po)	R2AH	0.75	0.75	1.125	0.375	1.125	-	Non	6	3.4685	5.5	Cylindrique



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Usinage du titane (matériau secondaire : ISO M)

S4 M

Programme standard

Code	Nuance	DC	DCON	APMX	RE	LU	LB1	Collet	ZEFP	OHX	LF	Queue
2B255-0300-TA T2CH (mm)	T2CH	3	6	4.5	1.5	4.5	10.5	Non	5	21	57	Cylindrique
2B256-0400-TA T2CH (mm)	T2CH	4	6	6	2	6	13	Non	6	21	57	Cylindrique
2B256-0500-TA T2CH (mm)	T2CH	5	6	7.5	2.5	7.5	16	Non	6	21	57	Cylindrique
2B256-0600-TA T2CH (mm)	T2CH	6	6	9	3	9	-	Non	6	21	57	Cylindrique
2B256-0800-TA T2CH (mm)	T2CH	8	8	12	4	12	-	Non	6	27	63	Cylindrique
2B256-1000-TA T2CH (mm)	T2CH	10	10	15	5	15	-	Non	6	32	72	Cylindrique
2B256-1200-TA T2CH (mm)	T2CH	12	12	18	6	18	-	Non	6	38	83	Cylindrique
2B256-1600-TA T2CH (mm)	T2CH	16	16	24	8	24	-	Non	6	44	92	Cylindrique
2B256-2000-TA T2CH (mm)	T2CH	20	20	30	10	30	-	Non	6	54	104	Cylindrique
2B255-0318-TA T2CH (po)	T2CH	0.125	0.25	0.1875	0.0625	0.1875	0.4375	Non	5	0.8327	2.25	Cylindrique
2B256-0476-TA T2CH (po)	T2CH	0.1875	0.25	0.2813	0.0938	0.2813	0.625	Non	6	0.8327	2.25	Cylindrique
2B256-0635-TA T2CH (po)	T2CH	0.25	0.25	0.375	0.125	0.375	-	Non	6	0.8327	2.25	Cylindrique
2B256-0794-TA T2CH (po)	T2CH	0.3125	0.3125	0.4688	0.1563	0.4688	-	Non	6	1.0827	2.5	Cylindrique
2B256-0953-TA T2CH (po)	T2CH	0.375	0.375	0.5625	0.1875	0.5625	-	Non	6	1.4370	3	Cylindrique
2B256-1270-TA T2CH (po)	T2CH	0.5	0.5	0.75	0.25	0.75	-	Non	6	1.7165	3.5	Cylindrique
2B256-1588-TA T2CH (po)	T2CH	0.625	0.625	0.9375	0.3125	0.9375	-	Non	6	1.5945	3.5	Cylindrique
2B256-1905-TA T2CH (po)	T2CH	0.75	0.75	1.125	0.375	1.125	-	Non	6	1.9685	4	Cylindrique

Code	Nuance	DC	DCON	APMX	RE	LU	LB1	Collet	ZEFP	OHX	LF	Queue
2B285-0300-TA T2CH (mm)	T2CH	3	6	4.5	1.5	4.5	15	Non	5	34	70	Cylindrique
2B286-0400-TA T2CH (mm)	T2CH	4	6	6	2	6	20	Non	6	34	70	Cylindrique
2B286-0500-TA T2CH (mm)	T2CH	5	6	7.5	2.5	7.5	25	Non	6	44	80	Cylindrique
2B286-0600-TA T2CH (mm)	T2CH	6	6	9	3	9	-	Non	6	44	80	Cylindrique
2B286-0800-TA T2CH (mm)	T2CH	8	8	12	4	12	-	Non	6	44	80	Cylindrique
2B286-1000-TA T2CH (mm)	T2CH	10	10	15	5	15	-	Non	6	60	100	Cylindrique
2B286-1200-TA T2CH (mm)	T2CH	12	12	18	6	18	-	Non	6	60	105	Cylindrique
2B286-1600-TA T2CH (mm)	T2CH	16	16	24	8	24	-	Non	6	77	125	Cylindrique
2B286-2000-TA T2CH (mm)	T2CH	20	20	30	10	30	-	Non	6	100	150	Cylindrique
2B285-0318-TA T2CH (po)	T2CH	0.125	0.25	0.1875	0.0625	0.1875	0.625	Non	5	1.5827	3	Cylindrique
2B286-0476-TA T2CH (po)	T2CH	0.1875	0.25	0.2813	0.0938	0.2813	1	Non	6	1.5827	3	Cylindrique
2B286-0635-TA T2CH (po)	T2CH	0.25	0.25	0.375	0.125	0.375	-	Non	6	1.5827	3	Cylindrique
2B286-0794-TA T2CH (po)	T2CH	0.3125	0.3125	0.4688	0.1563	0.4688	-	Non	6	2.0827	3.5	Cylindrique
2B286-0953-TA T2CH (po)	T2CH	0.375	0.375	0.5625	0.1875	0.5625	-	Non	6	2.4370	4	Cylindrique
2B286-1270-TA T2CH (po)	T2CH	0.5	0.5	0.75	0.25	0.75	-	Non	6	2.7165	4.5	Cylindrique
2B286-1588-TA T2CH (po)	T2CH	0.625	0.625	0.9375	0.3125	0.9375	-	Non	6	3.0945	5	Cylindrique
2B286-1905-TA T2CH (po)	T2CH	0.75	0.75	1.125	0.375	1.125	-	Non	6	3.4685	5.5	Cylindrique

Usinage du titane (matériau secondaire : ISO M)

S4 M

Programme standard

Code	Nuance	DC	DCON	APMX	RE	LU	LB1	Collet	ZEFP	OHX	LF	Queue
2B284-0300-TA T2CH (mm)	T2CH	3	6	4.5	1.5	4.5	15	Non	4	34	70	Cylindrique
2B284-0400-TA T2CH (mm)	T2CH	4	6	6	2	6	20	Non	4	34	70	Cylindrique
2B284-0500-TA T2CH (mm)	T2CH	5	6	7.5	2.5	7.5	25	Non	4	44	80	Cylindrique
2B284-0600-TA T2CH (mm)	T2CH	6	6	9	3	9	-	Non	4	44	80	Cylindrique
2B284-0800-TA T2CH (mm)	T2CH	8	8	12	4	12	-	Non	4	44	80	Cylindrique
2B284-1000-TA T2CH (mm)	T2CH	10	10	15	5	15	-	Non	4	60	100	Cylindrique
2B284-1200-TA T2CH (mm)	T2CH	12	12	18	6	18	-	Non	4	60	105	Cylindrique
2B284-1600-TA T2CH (mm)	T2CH	16	16	24	8	24	-	Non	4	77	125	Cylindrique
2B284-2000-TA T2CH (mm)	T2CH	20	20	30	10	30	-	Non	4	100	150	Cylindrique
2B284-0318-TA T2CH (po)	T2CH	0.125	0.25	0.1875	0.0625	0.1875	0.625	Non	4	1.5827	3	Cylindrique
2B284-0476-TA T2CH (po)	T2CH	0.1875	0.25	0.2813	0.0938	0.2813	1	Non	4	1.5827	3	Cylindrique
2B284-0635-TA T2CH (po)	T2CH	0.25	0.25	0.375	0.125	0.375	-	Non	4	1.5827	3	Cylindrique
2B284-0794-TA T2CH (po)	T2CH	0.3125	0.3125	0.4688	0.1563	0.4688	-	Non	4	2.0827	3.5	Cylindrique
2B284-0953-TA T2CH (po)	T2CH	0.375	0.375	0.5625	0.1875	0.5625	-	Non	4	2.4370	4	Cylindrique
2B284-1270-TA T2CH (po)	T2CH	0.5	0.5	0.75	0.25	0.75	-	Non	4	2.7165	4.5	Cylindrique
2B284-1588-TA T2CH (po)	T2CH	0.625	0.625	0.9375	0.3125	0.9375	-	Non	4	3.0945	5	Cylindrique
2B284-1905-TA T2CH (po)	T2CH	0.75	0.75	1.125	0.375	1.125	-	Non	4	3.4685	5.5	Cylindrique

Conditions de coupe recommandées

CoroMill® Plura Optimized à bout sphérique pour ISO S

ISO	Code MC	Description des matériaux	HB	Semi-finition ($a_e = 0.05 \times DC$)			Finition ($a_e = 0.01 \times DC$)			
				v_c m/min	v_c pieds/min	f_z	v_c m/min	v_c pieds/min	f_z mm	f_z po
S	S1.0.U.AG	Alliages à base fer	280	50	164	$0.004 \times DC$	70	230	0.05 - 0.03 - 0.01	0.002 - 0.0012 - 0.0004
	S2.0.Z.AN	Alliages à base nickel	250	50	164	$0.004 \times DC$	130	427		
	S2.0.Z.AG	Alliages à base nickel	350	65	213	$0.004 \times DC$	90	295		
	S4.3.Z.AN	Alliages à base titane	330	110	361	$0.005 \times DC$	200	656		
	S4.4.Z.AN	Alliages à base titane	410	55	180	$0.005 \times DC$	100	328		
M	P5.0.Z.AN	Aciers inoxydables ferritiques-martensitiques	200	90	295	$0.008 \times DC$	100	328		
	M1.0.Z.AQ	Aciers inoxydables austénitiques	200	110	361	$0.008 \times DC$	130	427		
	M3.2.Z.AQ	Aciers inoxydables duplex (austénitiques/ferritiques)	260	90	295	$0.008 \times DC$	100	328		
H	H1.1.Z.HA	Aciers - Niveau de dureté 50	50HRC	145	476	$0.003 \times DC$	175	574		
	H1.2.Z.HA	Aciers - Niveau de dureté 55	55HRC	145	476	$0.002 \times DC$	175	574		
	H1.3.Z.HA	Aciers - Niveau de dureté 60	60HRC	85	279	$0.002 \times DC$	100	328		

Pour des données de coupe optimisées, voir CoroPlus® Tool Guide.

Pour en savoir plus sur
CoroMill® Plura à bout sphérique :
[sandvik.coromant.com/
coromillpluraballnose](http://sandvik.coromant.com/coromillpluraballnose)



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