



















| Ø foret (mm) | Gamme d'avance N° | | | | | | | | |
|--------------|-------------------|-------|-------|-------|-------|-------|-------|-------|-------|
| 0.50 | 0.004 | 0.006 | 0.007 | 0.008 | 0.010 | 0.012 | 0.014 | 0.016 | 0.019 |
| 1.00 | 0.006 | 0.008 | 0.012 | 0.014 | 0.016 | 0.018 | 0.020 | 0.023 | 0.025 |
| 2.00 | 0.020 | 0.025 | 0.032 | 0.040 | 0.050 | 0.063 | 0.080 | 0.100 | 0.125 |
| 2.50 | 0.025 | 0.032 | 0.040 | 0.050 | 0.063 | 0.080 | 0.100 | 0.125 | 0.160 |
| 3.15 | 0.032 | 0.040 | 0.050 | 0.063 | 0.080 | 0.100 | 0.125 | 0.160 | 0.160 |
| 4.00 | 0.040 | 0.050 | 0.063 | 0.080 | 0.100 | 0.125 | 0.160 | 0.200 | 0.200 |
| 5.00 | 0.040 | 0.050 | 0.063 | 0.080 | 0.100 | 0.125 | 0.160 | 0.200 | 0.250 |
| 6.30 | 0.050 | 0.063 | 0.080 | 0.100 | 0.125 | 0.160 | 0.200 | 0.250 | 0.315 |
| 8.00 | 0.063 | 0.080 | 0.100 | 0.125 | 0.160 | 0.200 | 0.250 | 0.315 | 0.315 |
| 10.00 | 0.080 | 0.100 | 0.125 | 0.160 | 0.200 | 0.250 | 0.315 | 0.400 | 0.400 |
| 12.50 | 0.080 | 0.100 | 0.125 | 0.160 | 0.200 | 0.250 | 0.315 | 0.400 | 0.500 |
| 16.00 | 0.100 | 0.125 | 0.160 | 0.200 | 0.250 | 0.315 | 0.400 | 0.500 | 0.630 |
| 20.00 | 0.125 | 0.160 | 0.200 | 0.250 | 0.315 | 0.400 | 0.500 | 0.630 | 0.630 |
| 25.00 | 0.160 | 0.200 | 0.250 | 0.315 | 0.400 | 0.500 | 0.630 | 0.800 | 0.800 |
| 31.50 | 0.160 | 0.200 | 0.250 | 0.315 | 0.400 | 0.500 | 0.630 | 0.800 | 1.000 |
| 40.00 | 0.200 | 0.250 | 0.315 | 0.400 | 0.500 | 0.630 | 0.800 | 1.000 | 1.250 |
| 50.00 | 0.250 | 0.310 | 0.400 | 0.500 | 0.630 | 0.800 | 1.000 | 1.250 | 1.250 |
| 63.00 | 0.315 | 0.400 | 0.500 | 0.630 | 0.800 | 1.000 | 1.250 | 1.600 | 1.600 |
| 80.00 | 0.400 | 0.500 | 0.630 | 0.800 | 1.000 | 1.250 | 1.600 | 1.600 | 2.000 |

-  Air
-  Huile soluble
-  Huile

| Matières | Résistance N/mm ² | VC m/mm | Gamme N° |
|-------------------------------------|---|---------|---|
| Aluminium et ses alliages | 3.0255 Al99,5, 3.2315 AlMgSi1, 3.3515 AlMg1 | <=400 |  350 9 |
| Alliages malléables d'Al | 3.0615 AlMgSiPb, 3.1325 AlCuMg1, 3.3245 AlMg3Si, 3.4365 AlZnMgCu1,5 | <=650 |  350 9 |
| Alliages d'Al d'inject. ≤ 10 % Si | 3.2131 G-AlSi5Cu1, 3.2153 G-AlSi7Cu3, 3.2573 G-AlSi9 | <=600 |  320 8 |
| ≤ 24 % Si | 3.2581 G-AlSi12, 3.2583 G-AlSi12Cu, - G-AlSi12CuNiMg | <=600 |  280 7 |
| Alliages de Magnésium | 3.5200 MgMn2, 3.5812.05 G-MgAl8Zn1, 3.5612.05 G-MgAl6Zn1 | <=400 |  320 7 |
| Cuivres, faiblement alliés | 2.0070 SE-Cu, 2.1020 CuSn6, 2.1096 G-CuSn5ZnPb | <=500 |  190 7 |
| Laiton à copeaux courts | 2.0380 CuZn39Pb2, 2.0401 CuZn39Pb3, 2.0410 CuZn43Pb2 | <=600 |  160 6 |
| à copeaux longs | 2.0250 CuZn20, 2.0280 CuZn33, 2.0332 CuZn37Pb0,5 | <=600 |  160 6 |
| Bronze, à copeaux courts | 2.1090 CuSn7ZnPb, 2.1170 CuPb5Sn5, 2.1176 CuPb10Sn | <=600 |   160 6 |
| | 2.0790 CuNi18Zn19Pb | <=850 |  160 6 |
| Bronze, à copeaux longs | 2.0916 CuAl5, 2.0960 CuAl9Mn, 2.1050 CuSn10 | <=850 |  150 6 |
| | 2.0980 CuAl11Ni, 2.1247 CuBe2 | <=1000 |  150 6 |
| Thermodurcissables | Résine époxy, Resopal, Pertinax, Moltopren | <=150 |  100 3 |
| Thermoplastiques | Plexiglas, Hostalen, Novodur, Makralon | <=100 |   100 3 |
| renf. de fibres d'aramides | Kevlar | <=1000 |  100 3 |
| renf. de fibres de verre ou carbone | GFK/CFK | <=1000 |  100 2 |