

Material	Stahl N/mm²				Rostfreie Stähle		Guss		NE-Metalle			Superleg.		Einsatzempfehlung	
	<500	<800	<1200 (<HRC38)	<1600 (<HRC48)	<800	<1200	GG	GGG	Al Knetleg.	Al SI<10%	Cu,Ms	Ti/Ni/Co <900	900-1500	HRC 48-57	HRC 58-63
Zugfestigkeit															
80 00 604 751 - Vc (m/min)	12-16	7-10	4-6	2-3	2-4	1-2	10-16	5-9	8-16	12-16	18-25	2	2		
80 00 604 741 - Vc (m/min)	26-37	16-23	10-14	5-7	5-8	3-5	14-30	10-18	8-26	16-25	25-40	2	4		
Kühlung	Emulsion	Emulsion	Emulsion	Emulsion/Öl	Emulsion/Öl	Emulsion/Öl	Emulsion/Öl	Emulsion/Öl	Emulsion/Öl	Emulsion/Öl	Emulsion/Öl	Emulsion/Öl	Emulsion/Öl		

Fortsetzung >