

Einsatzempfehlung

| Material                   | Stahl N/mm² |          |                |                | Rostfreie Stähle |       | Guss     |          | NE-Metalle  |           |          | Superleg.     |          | Stahl gehärtet |           |
|----------------------------|-------------|----------|----------------|----------------|------------------|-------|----------|----------|-------------|-----------|----------|---------------|----------|----------------|-----------|
| Zugfestigkeit              | <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 |
| 41 14 364 020 - Vc (m/min) | 56          | 35       | 21             | 10             | 15               | 11    | 56       | 28       | 56          | 35        | 56       |               |          |                |           |
| Kühlung                    | Emulsion    | Emulsion | Emulsion       | Öl             | Öl               | Öl    | Emulsion | Emulsion | Emulsion    | Emulsion  | Emulsion |               |          |                |           |