

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 14 338 201 -<br>Vc (m/min) | 16          | 14       | 5              |                |                  |       | 16       | 10       | 20          | 16        | 16       |               |          |                |           |
| Kühlung                       | Emulsion    | Emulsion | Öl             |                |                  |       | Emulsion | Emulsion | Emulsion    | Emulsion  | Emulsion |               |          |                |           |