

## Einsatzempfehlung

| Material                     | Stahl N/mm² |          |                |                | Rostfreie Stähle |       | Guss     |          | NC-Metalle  |           |          | Titanleg.   |          | Stahl gehärtet |           |
|------------------------------|-------------|----------|----------------|----------------|------------------|-------|----------|----------|-------------|-----------|----------|-------------|----------|----------------|-----------|
| Zugfestigkeit                | <500        | <800     | <1200 (+HRC28) | <1600 (+HRC40) | <800             | <1200 | GG       | GGG      | Al Knetleg. | Al St<10% | Cu,Ms    | Ti90/Cu<10% | 800-1000 | HRC 48-57      | HRC 58-63 |
| 2000 967 493 -<br>Vc (m/min) | 16          | 14       | 5              |                | 5                | 5     | 16       | 10       | 20          | 16        | 16       | 5           | 3        |                |           |
| Kühlung                      | Emulsion    | Emulsion | Öl             |                | Öl               | Öl    | Emulsion | Emulsion | Emulsion    | Emulsion  | Emulsion | Öl          | Öl       |                |           |

