

### Einsatzempfehlung

| Material                   | Stahl N/mm <sup>2</sup> |          |                | 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 14 607 205 - 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             |           |           |