

### 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 |
| 40 00 862 431 -<br>Vc (m/min) | 15-35                   | 10-28        | 10-14          |                  | 10-14        | 5-7   | 28-36        | 22-30        | 90          | 55-70        | 18-45        | 10            | 6              |           |           |
| 40 00 862 525 -<br>Vc max.    | <b>20-40</b>            | <b>15-35</b> | 12-15          |                  | <b>12-18</b> | 6-8   | <b>36-45</b> | <b>28-40</b> | <b>70</b>   | <b>70-85</b> | <b>28-63</b> | 10            | 6              |           |           |
| Kühlung                       | Emulsion                | Emulsion/Öl  | Emulsion/Öl    |                  | Öl           | Öl    | Emulsion     | Emulsion     | Emulsion    | Emulsion     | Emulsion/Öl  | Öl            | Emulsion/Öl    |           |           |