

### 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 11 651 050 - Vc (m/min) | 40                      | 30          | 10             |                  |      |       | 25          | 25          | 45          |           | 80          |               |                |           |           |
| Kühlung                    | Emulsion/Öl             | Emulsion/Öl | Emulsion/Öl    |                  |      |       | Emulsion/Öl | Emulsion/Öl | Emulsion/Öl |           | Emulsion/Öl |               |                |           |           |