

| Material                      | Stahl N/mm² |          |                |                | Rostfreie Stähle |           | Guss     |          | NE-Metalle  |           |          | Superleg.     |          | Einsatzempfehlung |           |
|-------------------------------|-------------|----------|----------------|----------------|------------------|-----------|----------|----------|-------------|-----------|----------|---------------|----------|-------------------|-----------|
|                               | <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 00 601 418 -<br>Vc (m/min) | 30          | 28       | 8              | 4              | 7                | 7         | 18       | 15       | 35          |           | 60       | 7             |          | 6                 |           |
| Kühlung                       | Emulsion    | Emulsion | Emulsion       | Schneidöl      | Schneidöl        | Schneidöl | Emulsion | Emulsion | Emulsion    |           | Emulsion | Schneidöl     |          | Schneidöl         |           |

Fortsetzung >