

**Einsatzempfehlung**

Material	Stahl N/mm <sup>2</sup>				Rostfreie Stähle		Guss		NE-Metalle			Superleg.		Stahl gehärtet	
	<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
4000 601 960 - Vc (m/min)	16	14	5		5	5	16	10	20	16	16	5	3		
Kühlung	Emulsi- on/Öl	Emulsi- on/Öl	Emulsion/Öl		Emulsi- on/Öl	Emulsi- on/Öl	Emulsi- on/Öl	Emulsi- on/Öl	Emulsi- on/Öl	Emulsion/Öl	Emulsion/Öl	Emulsion/Öl	Emulsion/Öl		