

Werkstoff	Material	Werkstoff-Nr. Material No.	DIN Bezeichnung Alt DIN Description Old	R _m /UTS (N/mm ²)	DIN Bezeichnung Neu DIN Description New	Schnittdaten										
						a _e	f _z	v _c	f _z	f _z						
P Unlegierter Baustahl + Automatenstahl	Plain carbon steel + free cutting steel	1.0570	S152-3	~700	S355J2G3	160-180	160-180	160-180			d : 4,00 f _z max 0,25	d : 4,00 f _z max 0,35	d : 4,00 f _z max 0,40	d : 4,00 f _z max 0,45	d : 4,00 f _z max 0,50	d x 0,1-0,12
		1.1730	C45	~800	C45U											
		1.0715	9SMn28	~700	11SMn30											
	1.1191	Ck45	500-950	C45E												
	1.7219	26CrMo4		26CrMo4-2												
	1.7225	42CrMo4	500-950	42CrMo4												
	1.8159	51CrV4		51CrV4												
	1.0416	GS40	~950	GS40												
	1.7131	16MnCr5	~950	16MnCr5												
	1.4006	X12Cr13	500-950	X12Cr13												
1.4104	X12CrMoS17		X14CrMoS17													
1.4122	X35CrMo17		X39CrMo17-1													
1.7225	42CrMo4	950-1400	42CrMo4													
1.6580	30CrNiMo8		30CrNiMo8													
1.8504	34CrAl6	950-1400	34CrAl6													
1.2344	X40CrMoV5.1	~900	X40CrMoV5-1													
1.2343	X38CrMoV5.1	950-1400	X37CrMoV5-1													
1.2379	X155CrMoV12.1	~950	X153CrMoV12-1													
1.2358	60CrMoV18-5	850-1000	60CrMoV18-5													
1.2080	X210Cr12	950-1400	X210Cr12													
1.2714	55NiCrMoV7	1100-1350	55NiCrMoV7													
1.2311	40CrMnMo7	~1100	40CrMnMo7													
1.2312	40CrMnNiMoS8.6	~1150	40CrMnNiMoS8-6													
1.2316	X38CrMo16	~1100	X38CrMo16													
1.2738	45CrMnNiMo8.6.4	950-1150	45CrMnNiMo8-6-4													
1.4301	X2CrNiMo17-12-2	500-950	X5CrNiMo18-10													
1.4404	X6CrNiMoTi17-12-2		X2CrNiMo17-12-2													
1.4571	X10CrNiMoTi18		X10CrNiMoTi18													
1.2709	X3NiCoMoTi18-9-5	800-1000	X3NiCoMoTi18-9-5													
1.4542	X5CrNiCuNb16-4		X5CrNiCuNb16-4													
1.4568	X7CrNiAl17-7		X7CrNiAl17-7													
0.6025	GG25	100-400 (120-260 HB)	EN-GJL-250													
0.6678	GGL-NiCr35 2	150-250 (160-230 HB)	EN-GJLA-XNiCr35-2													
0.7060	GGG60	400-800	EN-GJS-600-3													
0.7070	GGG70L	(120-310 HB)	EN-GJS-700-2U													
0.8155	GTS55	350-700 (150-280 HB)	EN-GJMB-550-4													
3.2581	G-AISI12	~400	G-IGK-AISI12													
3.3535	AlMg3	~550	AlMg3													
3.4365	AlZnMgCu1,5		AlZnMgCu1,5													
2.0402	MS58	~500	CuZn40Pb2													
2.0320	MS68	300-500	CuZn37													
2.0975	CuAl10Ni		CuAl10Fe5Ni5-C													
	PVC	40-70	PVC													
	Bakelit, Melamin	20-40	Bakelit, Melamin													
	Graphit															
	Zirkonoxidkeramik															
3.7115	TiAl5Sn2,5	~950	TiAl5Sn2-5													
3.7164	TiAl6V4		Ti6AlV4													
3.7174	TiAl6Sn2	900-1400	TiAl6V6Sn2													
2.4670	NiCr12Al6MoNb	~950	NiCr12Al6MoNb													
2.4668	NiCr19Fe19NbMo	900-1400	Inconel 718 NiCr19Fe19Nb5Mo3													
	Ni-hard, Ampco	300-600 HB	Ni-hard, Ampco													
		45-52 HRC														
		53-59 HRC														
		60-65 HRC														

Die angegebenen Schnittwerte sind Startwerte und müssen auf die vorhandenen Bedingungen abgestimmt werden.

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						WPR-AR LCPK30M	WPR-AR LCHK30M	WPR-AS LWNS30M	WRT LCP40M	WRT LCPK10M	Ø					
											Ø 12	Ø 16	Ø 20	Ø 25		Ø 32
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The cutting data indicated are starting values and must be adjusted to the prevailing conditions.