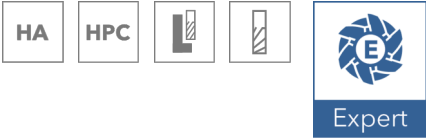
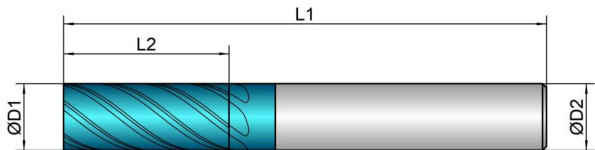


Cooling	 
Tolerance	e8
Coating	TiSiN- α



HA K201523



Steel			Hardened steel				Stainless steel (VA)	Castings	Non-ferrous materials				Inconel	Abrasive material		Titanium
< 850 N/mm	< 1100 N/mm	< 1400 N/mm	< 55 HRC	< 60 HRC	< 67 HRC	< 70 HRC			Al	Copper	Mg	Plastics		CFRP / GFRP	Graphite	
		180	175	150	105	90										

K201523	D1	L2	L1	D2	z	
	 mm ø	 mm	 mm	 mm ø	 #	 °
2X8	2.0	8.0	58.0	6.0	4	37.5
3X12	3.0	12.0	58.0	6.0	4	37.5
4X13	4.0	13.0	58.0	6.0	4	37.5
5X15	5.0	15.0	58.0	6.0	6	37.5
6X16	6.0	16.0	58.0	6.0	6	37.5
8X22	8.0	22.0	70.0	8.0	6	37.5
10X25	10.0	25.0	73.0	10.0	6	37.5
12X28	12.0	28.0	84.0	12.0	6	37.5
14X30	14.0	30.0	84.0	14.0	6	37.5
16X36	16.0	36.0	93.0	16.0	8	37.5
18X36	18.0	36.0	93.0	18.0	10	37.5
20X41	20.0	41.0	104.0	20.0	10	37.5

Kühlung

Toleranz

e8

Beschichtung

TiSiN-α

HA

HPC

Expert



Werkstoff / Material	Festigkeit / strength (N/mm²)		Vc m/min	Ø 0,1 - 2		Ø 3 - 4		Ø 5		Ø 6		Ø 8		Ø 10		Ø 12		Ø 16		Ø 20	
				ae= 1xD	ae= 0,05xD	ae= 1xD	ae= 0,05xD	ae= 1xD	ae= 0,05xD	ae= 1xD	ae= 0,05xD	ae= 1xD	ae= 0,05xD	ae= 1xD	ae= 0,05xD	ae= 1xD	ae= 0,05xD	ae= 1xD	ae= 0,05xD	ae= 1xD	ae= 0,05xD
				ap= 1xD	ap= L2 _{max}	ap= 1xD	ap= L2 _{max}	ap= 1xD	ap= L2 _{max}	ap= 1xD	ap= L2 _{max}	ap= 1xD	ap= L2 _{max}	ap= 1xD	ap= L2 _{max}	ap= 1xD	ap= L2 _{max}	ap= 1xD	ap= L2 _{max}	ap= 1xD	ap= L2 _{max}
				fz (mm/Z)	fz (mm/Z)	fz (mm/Z)	fz (mm/Z)	fz (mm/Z)	fz (mm/Z)	fz (mm/Z)	fz (mm/Z)	fz (mm/Z)	fz (mm/Z)	fz (mm/Z)	fz (mm/Z)	fz (mm/Z)	fz (mm/Z)	fz (mm/Z)	fz (mm/Z)	fz (mm/Z)	fz (mm/Z)
Stahl / Steel	< 850																				
Stahl / Steel	< 1100																				
Stahl / Steel	< 1400		180		0,018		0,02		0,022		0,025		0,028		0,03		0,035		0,04		0,045
Gehärteter Stahl / Hardness Steel	< 55HRC		175		0,018		0,02		0,022		0,025		0,028		0,03		0,035		0,04		0,045
Gehärteter Stahl / Hardness Steel	< 60HRC		150		0,018		0,02		0,022		0,025		0,028		0,03		0,035		0,04		0,045
Gehärteter Stahl / Hardness Steel	< 67HRC		105		0,015		0,018		0,02		0,022		0,025		0,027		0,032		0,037		0,042
Gehärteter Stahl / Hardness Steel	≤ 70HRC		90		0,012		0,015		0,017		0,019		0,022		0,024		0,029		0,034		0,039
INOX	< 700																				
INOX	< 850																				
Guss / Castings																					
Aluminium / Al																					
Kupfer / Cooper																					
Kunststoffe / Plastics																					
Inconel																					
Titan / Titanium																					
Grafit / Graphite																					
GFK / CFK																					

Bitte beachten, hierbei handelt es sich lediglich um Richtwerte! / Caution, these are only guide values!