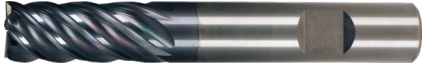


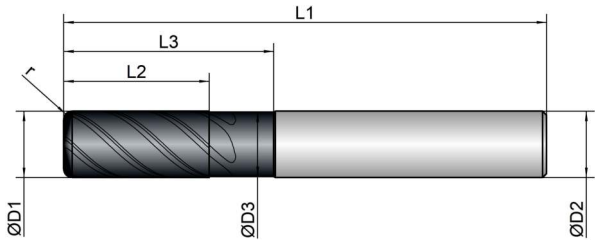
Cooling	 
Tolerance	e8
Coating	TiSiN- α

HBETCMTC≠


Expert



HB K201789



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	
	185	175					115									

	D1  mm ø	D3  mm ø	L2  mm	L3  mm	L1  mm	D2  mm ø	z  #	r  mm	 °
K201789									
6/0,2	6.0	5.8	13.0	20.0	58.0	6.0	5	0.20	42.5
8/0,3	8.0	7.7	19.0	25.0	63.0	8.0	5	0.30	42.5
10/0,3	10.0	9.7	22.0	32.0	73.0	10.0	5	0.30	42.5
12/0,3	12.0	11.6	26.0	38.0	84.0	12.0	5	0.30	42.5
16/0,5	16.0	15.5	32.0	44.0	92.0	16.0	5	0.50	42.5
20/0,5	20.0	19.5	38.0	54.0	104.0	20.0	5	0.50	42.5
25/0,5	25.0	24.5	45.0	65.0	125.0	25.0	5	0.50	42.5

Kühlung



Toleranz

e8

Beschichtung

TiSiN-α

HB

ETC

MTC

≠











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= 0,3xD	ae= 1xD	ae= 0,3xD	ae= 1xD	ae= 0,3xD	ae= 1xD	ae= 0,3xD	ae= 1xD	ae= 0,3xD	ae= 1xD	ae= 0,3xD	ae= 1xD	ae= 0,3xD	ae= 1xD	ae= 0,3xD	ae= 1xD	ae= 0,3xD
				ap= 1xD	ap= 1xD	ap= 1xD	ap= 1xD	ap= 1xD	ap= 1xD	ap= 1xD	ap= 1xD	ap= 1xD	ap= 1xD	ap= 1xD	ap= 1xD	ap= 1xD	ap= 1xD	ap= 1xD	ap= 1xD	ap= 1xD	ap= 1xD
				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		185								0,045		0,055		0,065		0,075		0,085		0,095
Stahl / Steel	< 1400		175								0,04		0,05		0,06		0,07		0,08		0,09
Gehärteter Stahl / Hardness Steel	< 55HRC																				
Gehärteter Stahl / Hardness Steel	< 60HRC																				
Gehärteter Stahl / Hardness Steel	< 67HRC																				
Gehärteter Stahl / Hardness Steel	≤ 70HRC																				
INOX	< 700		100								0,04		0,05		0,06		0,07		0,08		0,09
INOX	< 850		95								0,04		0,05		0,06		0,07		0,08		0,09
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!