

Cooling









Tolerance

e8

Coating

TiSiN- α

HB

ETC

$\neq$



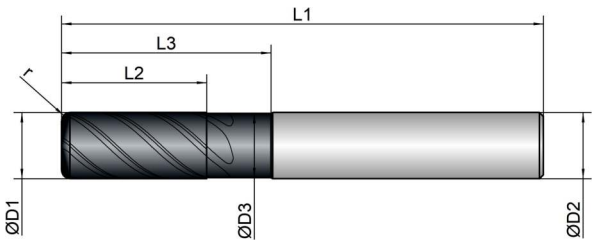
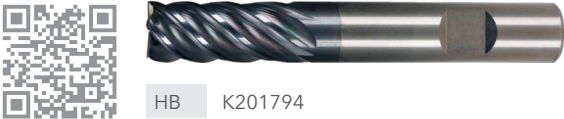


2xD





Expert



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	
	230	180					200									

	D1	D3	L2	L3	L1	D2	z	r	
K201794	 mm ø	 mm ø	 mm	 mm	 mm	 mm ø	 #	 mm	 °
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

Kühlung

Toleranz

e8

Beschichtung

TiSiN- α

HB

ETC

$\neq$

2xD

Expert

Werkstoff / Material	Festigkeit / strength (N/mm ²)		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 _{max} = 0,08xD	ae= 1xD	ae _{max} = 0,08xD	ae= 1xD	ae _{max} = 0,08xD	ae= 1xD	ae _{max} = 0,08xD	ae= 1xD	ae _{max} = 0,08xD	ae= 1xD	ae _{max} = 0,08xD	ae= 1xD	ae _{max} = 0,08xD	ae= 1xD	ae _{max} = 0,08xD	ae= 1xD	ae _{max} = 0,08xD
				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		230							0,04		0,06		0,075		0,09		0,11		0,14	
Stahl / Steel	< 1400		180							0,015		0,03		0,045		0,05		0,07		0,1	
Gehärteter Stahl / Hardness Steel	< 55HRC																				
Gehärteter Stahl / Hardness Steel	< 60HRC																				
Gehärteter Stahl / Hardness Steel	< 67HRC																				
Gehärteter Stahl / Hardness Steel	≤ 70HRC																				
INOX	< 700		200							0,04		0,06		0,075		0,09		0,11		0,14	
INOX	< 850		190							0,04		0,06		0,075		0,09		0,11		0,14	
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!