

Cooling	   
Tolerance	e8
Coating	TiSiN- α

HB

ETC

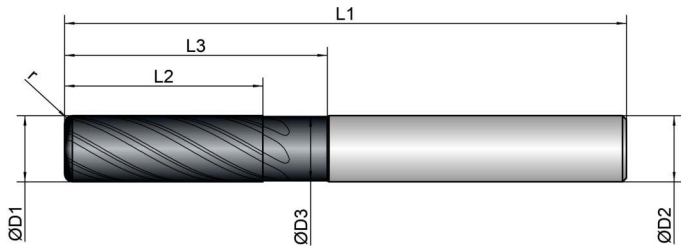
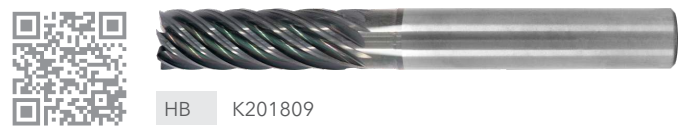
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3xD



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	
	240	210					220									

	D1	D3	L2	L3	L1	D2	z	r	
									
K201809	mm ø	mm ø	mm	mm	mm	mm ø	#	mm	°
6/0,15	6.0	5.8	18.0	25.0	65.0	6.0	7	0.15	42.5
8/0,15	8.0	7.7	24.0	32.0	70.0	8.0	7	0.15	42.5
10/0,2	10.0	9.7	30.0	40.0	85.0	10.0	7	0.20	42.5
12/0,2	12.0	11.6	36.0	46.0	100.0	12.0	7	0.20	42.5
16/0,3	16.0	15.5	48.0	58.0	110.0	16.0	7	0.30	42.5
20/0,3	20.0	19.5	60.0	70.0	125.0	20.0	7	0.30	42.5

Kühlung

Toleranz

e8

Beschichtung

TiSiN- α

HB

ETC

$\neq$

3xD

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=0,07xD	ae=1xD	ae=0,07xD	ae=1xD	ae=0,07xD	ae=1xD	ae=0,07xD	ae=1xD	ae=0,07xD	ae=1xD	ae=0,07xD	ae=1xD	ae=0,07xD	ae=1xD	ae=0,07xD	ae=1xD	ae=0,07xD
				ap=1xD	ap=3xD	ap=1xD	ap=3xD	ap=1xD	ap=3xD	ap=1xD	ap=3xD	ap=1xD	ap=3xD	ap=1xD	ap=3xD	ap=1xD	ap=3xD	ap=1xD	ap=3xD	ap=1xD	ap=3xD
				fz	fz	fz	fz	fz	fz	fz	fz	fz	fz	fz	fz	fz	fz	fz	fz	fz	fz
				(mm/Z)	(mm/Z)	(mm/Z)	(mm/Z)	(mm/Z)	(mm/Z)	(mm/Z)	(mm/Z)	(mm/Z)	(mm/Z)	(mm/Z)	(mm/Z)	(mm/Z)	(mm/Z)	(mm/Z)	(mm/Z)	(mm/Z)	(mm/Z)
Stahl / Steel	< 850																				
Stahl / Steel	< 1100		240							0,07		0,08		0,09		0,1		0,11		0,13	
Stahl / Steel	< 1400		210							0,05		0,06		0,07		0,08		0,09		0,11	
Gehärteter Stahl / Hardness Steel	< 55HRC																				
Gehärteter Stahl / Hardness Steel	< 60HRC																				
Gehärteter Stahl / Hardness Steel	< 67HRC																				
Gehärteter Stahl / Hardness Steel	≤ 70HRC																				
INOX	< 700		220							0,05		0,06		0,07		0,08		0,09		0,11	
INOX	< 850		210							0,05		0,06		0,07		0,08		0,09		0,11	
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!