

Anwendungsempfehlung

Werkstoff Désignation	Härte Dureté N/mm ²	Werkstoff Matière	DIN	Spiralbohrer Mèches	Spitzenwinkel Angle de pointe	Schnitt-geschw. Vitesse de coupe	Vorschub pro Umdrehung (mm/U) nach Durchmesser Avance par tour (mm/U) selon diamètre				
							2	5	10	15	25
Unlegierter und Leichtleg. Stahl Acier non- ou faiblement allié Code: A	200-400	1.0037	aSt37-2		118°	26-32	0.04-0.06	0.08-0.12	0.20-0.30	0.30-0.40	0.35-0.46
		1.0401	C15	180,150,185,180L,							
		1.0402	C22	TZX,T2X,185Altais,187							
		1.0715	9SMn28	170,175X-E,177X-E							
		1.0718	9SMnPb28	170X-N,							
		1.0722	10SPb20	157,222,TPX,153							
		1.0736	9SMn36	160,160G,165,							
		1.0737	9SMnPb36	160X							
		1.1141	Ck15								
		1.1158	Ck25								
Vergütungsstahl Acier pour traitement thermique Code: B	400-700	1.0050	St50.2		118°	20-28	0.04-0.06	0.08-0.12	0.20-0.30	0.30-0.40	0.35-0.46
		1.0501	C35	180,150,185,180L,							
		1.0503	C45	TZX,T2X,185Altais,187							
		1.0726	35S20	170,175X-E,177X-E							
		1.1157	40 Mn 4	170X-N,							
		1.1167	36 Mn 5	151,157,222,TPX,153							
		1.1170	28 Mn 6	160,160G,165,							
		1.1181	Ck35	160X							
		1.1191	Ck45	190Z,195Z-TiN							
		1.1213	Cf 53								
Vergütungsstahl Acier pour traitement thermique Code: C	700-950	1.1203	Ck55		118°	12-20	0.02-0.03	0.05-0.07	0.12-0.18	0.18-0.24	0.22-0.28
		1.1274	Ck101								
		1.1663	C 125 W								
		1.2363	X100CrMoV51	180,150,185,180L,							
		1.3343	S 6-5-2	TZX,185Altais,187							
		1.5710	36 Ni Cr 6	170,175X-E,177X-E							
		1.5752	14 NiCr 14	159,170X-N,170X-TS							
		1.6511	36 CrNiMo 4	151,157,222,							
		1.6523	21 NiCrMo 2	160,160G,165,							
		1.6546	40 NiCrMo 22	160X							
		1.7225	42 CrMo 4	190Z,195Z-TiN							
		1.7335	13 CrMo 4 4								
		1.7361	32 CrMo 12								
1.7380	10 CrMo 9 10										
Vergütungsstahl Acier pour traitement thermique Code: D	950-1200	1.3207	S12-1-4-5	180,150,185,180L,							
		1.3243	S6-5-2-5	TZX,185Altais,187							
		1.3247	S2-10-1-8	170,175X-E,177X-E							
		1.3255	S18-1-2-5	159,170X-N,170X-TS							
		1.6655	30NiCrMo16 6	157,222,							
		1.7361	32CrMo	160,160G,165,160X							
Vergütungsstahl Acier pour traitement thermique Code: E	>1200	1.0908	60SiMn	Siehe Code: D							
		1.2713	55nlcRmOv6	voir Code: D							
		1.8161	58CrV5								
Rostfreier Stahl Ferritisch Acier inoxydable ferritique Code: F	400-640	1.4000	X 6Cr 13	TBX,181,187	130°	14-16	0.02-0.04	0.07-0.09	0.15-0.21	0.20-0.28	0.25-0.33
		1.4002	X 6 CrAl 13	190Z,195Z-TiN							
		1.4016	X 6 Cr 17	175X-E,177X-E							
		1.4113	X 6 CrMo 17 1	170X-TS							
		1.4512	X 6 CrTi 12	151							
Rostfreier Stahl Martensitisch Acier inoxydable martensitique Code: G	730-1150	1.4021	X20 Cr 13	Siehe Code: F	130°	10-14	0.01-0.03	0.05-0.07	0.14-0.18	0.20-0.24	0.22-0.28
		1.4057	X20 CrNi 17 2	voir Code: F							
		1.4125	X 105 CrMo 17								
Rostfreier Stahl Austenitisch Acier inoxydable austénitique Code: H	440-780	1.3401	X 5 CrNi 18 10		130°	8-12	0.02-0.04	0.05-0.09	0.18-0.21	0.20-0.28	0.25-0.33
		1.4306	X 2 CrNi 19 11	TBX,181,187							
		1.4310	X 12 CrNi 17 7	190Z,195Z-TiN							
		1.4319	X 5 CrNi 18-7	185Altais,							
		1.4436	X 5 CrMo 17 13 3	175X-E,177X-E							
		1.4449	X 5 CrNiMo 17 13	170X-TS							
		1.4541	X 6 CrNiTi 18 10	151							
		1.4550	X 6 CrNiNb 18 10								
Grauguss Fonte grise Code: I	100-400	0.6030	GG10	180,150,185,180L,	118°	25-30	0.04-0.06	0.08-0.12	0.20-0.30	0.30-0.40	0.35-0.46
			4694	185Altais,							
			GGL	170,175X-E,177X-E							
Sphäroguss Fonte GS Code: J	370-800	0.7040	GGG40	151,157,222,	130°	12-16	0.02-0.04	0.05-0.09	0.18-0.21	0.20-0.28	0.25-0.33
			GGG40.3	160,160G,165,							
		0.7060	GGG60	160X							
Reinaluminium Alliage d'aluminium gras Code: K	140-360	3.3547	AlMg4.5Mn	180B,170B-XE, 175X-E,177X-E 160B,165,187	135°	50-60	0.02-0.04	0.05-0.09	0.18-0.21	0.20-0.28	0.25-0.33
Alu Legierung Silizium <10% Alliage alu silicium <10% Code: L	250-610	3.4365	AlZn6MgCu1.5	180B,170B-XE, 175X-E,177X-E 160B,165	135°	50-60	0.02-0.04	0.05-0.09	0.18-0.21	0.20-0.28	0.25-0.33
Alu Legierung Silizium >10% Alliage alu silicium >10% Code: M	160-420	3.2525	SAISI12	180B,170B-XE,175X-E 177X-E,190Z,195Z-TiN 165,160B,151	135°	30-40	0.02-0.04	0.05-0.09	0.18-0.21	0.20-0.28	0.25-0.33
Messing / Laiton Code: N	300-400	2.0360	MS60	180C,185Altais,187	118°	40-60	0.03-0.05	0.08-0.10	0.18-0.24	0.25-0.32	0.30-0.37
Bronze / Bronze Code: O	400-500	-	CuSn8	180C,185Altais,187	118°	40-60	0.02-0.04	0.05-0.09	0.18-0.21	0.20-0.28	0.25-0.33
		2.1090	G-CuSn7ZnPb								
Titan und Titanlegierung Alliage de titane Code: Ti	<1100	3.7034	Ti99.7	180Co,156Co							
		3.7124	TiCo2.5								
		3.7164	TiAl6V4								