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|--------------|-----------------|
| Kühlung | |
| Toleranz | 0-0,01 |
| Beschichtung | TiSiN- α |



| Werkstoff / Material | Festigkeit / strength (N/mm ²) | Vc m/min | Ø 0,1 - 0,3 | | Ø 0,4 - 0,8 | | Ø 0,9 - 1,2 | | Ø 1,3 - 1,5 | | Ø 1,6 - 1,9 | | Ø 2 - 2,3 | | Ø 2,4 - 2,7 | | Ø 2,8 - 3,0 | | | |
|-----------------------------------|--|-------------|---------------------------|--------------|---------------------------|--------------|---------------------------|--------------|---------------------------|--------------|---------------------------|--------------|---------------------------|--------------|---------------------------|--------------|---------------------------|--------------|---------------------------|--------------|
| | | | | | | | | | | | | | | | | | | | | |
| | | | ae= 0,15xD | ae= 0,1xD | ae= 0,15xD | ae= 0,1xD | ae= 0,15xD | ae= 0,1xD | ae= 0,15xD | ae= 0,1xD | ae= 0,15xD | ae= 0,1xD | ae= 0,15xD | ae= 0,1xD | ae= 0,15xD | ae= 0,1xD | ae= 0,15xD | ae= 0,1xD | ae= 0,15xD | ae= 0,1xD |
| | | | ap= L ₂ max | ap= 0,1xD | ap= L ₂ max | ap= 0,1xD | ap= L ₂ max | ap= 0,1xD | ap= L ₂ max | ap= 0,1xD | ap= L ₂ max | ap= 0,1xD | ap= L ₂ max | ap= 0,1xD | ap= L ₂ max | ap= 0,1xD | ap= L ₂ max | ap= 0,1xD | ap= L ₂ max | ap= 0,1xD |
| | | | 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 | | | | | | | | | | | | | | | | | | | |
| Stahl / Steel | < 1400 | 200 | 0,009 | | 0,014 | | 0,018 | | 0,02 | | 0,022 | | 0,025 | | 0,028 | | 0,03 | | | |
| Gehärteter Stahl / Hardness Steel | < 55HRC | 150 | 0,009 | | 0,014 | | 0,018 | | 0,02 | | 0,022 | | 0,025 | | 0,028 | | 0,03 | | | |
| Gehärteter Stahl / Hardness Steel | < 60HRC | 100 | 0,008 | | 0,013 | | 0,017 | | 0,019 | | 0,021 | | 0,024 | | 0,027 | | 0,029 | | | |
| Gehärteter Stahl / Hardness Steel | < 67HRC | 60 | 0,007 | | 0,012 | | 0,016 | | 0,018 | | 0,02 | | 0,023 | | 0,026 | | 0,028 | | | |
| Gehärteter Stahl / Hardness Steel | ≤ 70HRC | 45 | 0,006 | | 0,011 | | 0,015 | | 0,017 | | 0,019 | | 0,022 | | 0,025 | | 0,027 | | | |
| INOX | < 700 | 90 | 0,009 | | 0,014 | | 0,018 | | 0,02 | | 0,022 | | 0,025 | | 0,028 | | 0,03 | | | |
| INOX | < 850 | 85 | 0,008 | | 0,013 | | 0,017 | | 0,019 | | 0,021 | | 0,024 | | 0,027 | | 0,029 | | | |
| Guss / Castings | | | | | | | | | | | | | | | | | | | | |
| Aluminium / Al | | | | | | | | | | | | | | | | | | | | |
| Kupfer / Cooper | | 145 | 0,009 | | 0,014 | | 0,018 | | 0,02 | | 0,022 | | 0,025 | | 0,028 | | 0,03 | | | |
| Kunststoffe / Plastics | | | | | | | | | | | | | | | | | | | | |
| Inconel | | | | | | | | | | | | | | | | | | | | |
| Titan / Titanium | | | | | | | | | | | | | | | | | | | | |
| Grafit / Graphite | | | | | | | | | | | | | | | | | | | | |
| GFK / CFK | | | | | | | | | | | | | | | | | | | | |

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

Hinweis:

Fz Angaben Tabelle ist für kurze Auskraglänge (L3), je länger, dementsprechen Fz prozentual verringern
Fz information at the table is for a short projection length (L3), the longer, accordingly reduce Fz as a percentage

