Einsatzempfehlung

| Material | Stahl N/mm² | | | | Rostfreie Stähle | | Guss | | NE-Metalle | | | Superleg. | | Stahl gehärtet | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| Zugfestigkeit | <500 | <800 | <1200 (<HRC38) | <1800 (<HRC48) | <800 | <1200 | GG | GGG | Al Knetleg. | Al Si<10% | Cu,Ms | TiAl6V4 <900 | 900-1500 | HRC 48-57 | HRC 58-63 |
| 2000 867 687 - Vc (m/min) | 12 | 10 | | | 4 | | | 6 | 20 | | | | | | |
| Kühlung | Emulsion/Öl | Emulsion/Öl | | | Emulsion/Öl | | | Emulsion/Öl | Emulsion/Öl | | | | | | |