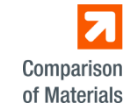


WM-Satz-4S(Nr.1"Z",Nr.1,Nr.2,F)-TIN

tool maker set



applications - materials		cutting speed vc in m/min		
		min.	recommended	max.
P1.1 Construction steels, Free-cutting steels, etc.	<= 600 N/mm ²	1	2	3
P2.1 Construction steels, Cementation steels, Steel castings, etc.	<= 800 N/mm ²	1	2	3
P3.1 Cementation steels, Heat-treatable steels, Cold work steels, etc.	<= 1000 N/mm ²	1	2	3
P4.1 Heat-treatable steels, Cold work steels, Nitriding steels, etc.	<= 1200 N/mm ²	1	2	3
P5.1 High-alloyed steels, Cold work steels, Hot work steels, etc.	<= 1400 N/mm ²	1	2	3
M1.1 Ferritic, martensitic	<= 950 N/mm ²	1	2	3
M2.1 Austenitic	<= 950 N/mm ²	1	2	3
M3.1 Austenitic-ferritic (Duplex)	<= 1100 N/mm ²	1	2	3
M4.1 Austenitic-ferritic heat-resistant (Super Duplex)	<= 1250 N/mm ²	1	2	3
K1.1 Cast iron with lamellar graphite (GJL)	100-250 N/mm ²	1	2	3
K1.2 Cast iron with lamellar graphite (GJL)	250-450 N/mm ²	1	2	3
K2.1 Cast iron with nodular graphite (GJS)	350-500 N/mm ²	1	2	3
K2.2 Cast iron with nodular graphite (GJS)	500-900 N/mm ²	1	2	3
K3.1 Cast iron with vermicular graphite (GJV)	300-400 N/mm ²	1	2	3
K3.2 Cast iron with vermicular graphite (GJV)	400-500 N/mm ²	1	2	3
K4.1 Malleable cast iron (GTMW, GTMB)	250-500 N/mm ²	1	2	3
K4.2 Malleable cast iron (GTMW, GTMB)	500-800 N/mm ²	1	2	3

WM-Satz-4S(Nr.1"Z",Nr.1,Nr.2,F)-TIN

tool maker set



applications - materials		cutting speed vc in m/min		
		min.	recommended	max.
N1.1 Aluminium wrought alloys	$\leq 200 \text{ N/mm}^2$	1	2	3
N1.2 Aluminium wrought alloys	$\leq 350 \text{ N/mm}^2$	1	2	3
N1.3 Aluminium wrought alloys	$\leq 550 \text{ N/mm}^2$	1	2	3
N1.4 Aluminium cast alloys	Si $\leq 7\%$	1	2	3
N1.5 Aluminium cast alloys	$7\% < \text{Si} \leq 12\%$	1	2	3
N1.6 Aluminium cast alloys	$12\% < \text{Si} \leq 17\%$	1	2	3
N2.1 Pure copper, low-alloyed copper	$\leq 400 \text{ N/mm}^2$	1	2	3
N2.2 Copper-zinc alloys (brass, long-chipping)	$\leq 550 \text{ N/mm}^2$	1	2	3
N2.3 Copper-zinc alloys (brass, short-chipping)	$\leq 550 \text{ N/mm}^2$	1	2	3
N2.4 Copper-aluminium alloys (alu bronze, long-chipping)	$\leq 800 \text{ N/mm}^2$	1	2	3
N2.5 Copper-tin alloys (tin bronze, long-chipping)	$\leq 700 \text{ N/mm}^2$	1	2	3
N2.6 Copper-tin alloys (tin bronze, short-chipping)	$\leq 400 \text{ N/mm}^2$	1	2	3
N2.7 Special copper alloys	$\leq 600 \text{ N/mm}^2$	1	2	3
S2.1 Pure nickel	$\leq 600 \text{ N/mm}^2$	1	2	3
S2.2 Nickel-base alloys	$\leq 1000 \text{ N/mm}^2$	1	2	3
S2.3 Nickel-base alloys	$\leq 1600 \text{ N/mm}^2$	1	2	3
S2.4 Cobalt-base alloys	$\leq 1000 \text{ N/mm}^2$	1	2	3
S2.5 Cobalt-base alloys	$\leq 1600 \text{ N/mm}^2$	1	2	3
S2.6 Iron-base alloys	$\leq 1500 \text{ N/mm}^2$	1	2	3