

cutting oil-Nr.3+EMULSION

coolant lubricants


Comparison
of Materials



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