

cutting paste-Nr.6+PASTE

coolant lubricants



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)	$\leq 1250 \text{ N/mm}^2$
S1.1 Pure titanium	$\leq 450 \text{ N/mm}^2$
S1.2 Titanium alloys	$\leq 900 \text{ N/mm}^2$
S1.3 Titanium alloys	$\leq 1250 \text{ N/mm}^2$
S2.1 Pure nickel	$\leq 600 \text{ N/mm}^2$
S2.2 Nickel-base alloys	$\leq 1000 \text{ N/mm}^2$
S2.3 Nickel-base alloys	$\leq 1600 \text{ N/mm}^2$
S2.4 Cobalt-base alloys	$\leq 1000 \text{ N/mm}^2$
S2.5 Cobalt-base alloys	$\leq 1600 \text{ N/mm}^2$
S2.6 Iron-base alloys	$\leq 1500 \text{ N/mm}^2$
H1.1 High strength steels, hardened steels, hard castings	44 – 50 HRC
H1.2 High strength steels, hardened steels, hard castings	50 – 55 HRC
H1.3 High strength steels, hardened steels, hard castings	55 – 60 HRC
H1.4 High strength steels, hardened steels, hard castings	60 – 63 HRC
H1.5 High strength steels, hardened steels, hard castings	63 – 66 HRC