

# SE-B-nor-STEEL

## round dies

applications - materials		cutting speed vc in m/min		
		min.	recommended	max.
P1.1 Construction steels, Free-cutting steels, etc.	$\leq 600 \text{ N/mm}^2$	1	5	8
P2.1 Construction steels, Cementation steels, Steel castings, etc.	$\leq 800 \text{ N/mm}^2$	1	3	5
P3.1 Cementation steels, Heat-treatable steels, Cold work steels, etc.	$\leq 1000 \text{ N/mm}^2$	1	2	3
K1.1 Cast iron with lamellar graphite (GJL)	100-250 N/mm <sup>2</sup>	2	5	10
K1.2 Cast iron with lamellar graphite (GJL)	250-450 N/mm <sup>2</sup>	2	5	10
K2.1 Cast iron with nodular graphite (GJS)	350-500 N/mm <sup>2</sup>	2	5	10
K2.2 Cast iron with nodular graphite (GJS)	500-900 N/mm <sup>2</sup>	2	5	10