

# SE-B-gel-VA

## 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
M1.1 Ferritic, martensitic	$\leq 950 \text{ N/mm}^2$	1	2	4
M2.1 Austenitic	$\leq 950 \text{ N/mm}^2$	1	2	4
N1.1 Aluminium wrought alloys	$\leq 200 \text{ N/mm}^2$	10	15	20
N1.2 Aluminium wrought alloys	$\leq 350 \text{ N/mm}^2$	10	15	20
N1.3 Aluminium wrought alloys	$\leq 550 \text{ N/mm}^2$	10	15	20
N1.4 Aluminium cast alloys	Si $\leq 7\%$	10	15	20
N2.1 Pure copper, low-alloyed copper	$\leq 400 \text{ N/mm}^2$	10	15	20
N2.2 Copper-zinc alloys (brass, long-chipping)	$\leq 550 \text{ N/mm}^2$	10	15	20
N2.4 Copper-aluminium alloys (alu bronze, long-chipping)	$\leq 800 \text{ N/mm}^2$	1	5	8
N4.2 Thermoplastics (long-chipping)		1	5	8