DENITOOL-DATA

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NEW

Achtung: Allgemeine Sicherheitsbestimmungen sowie Vorschriften der Maschinenhersteller unbedingt beachten!
Caution: General safety regulations and directions of machine manufacturers must be observed at any time!
Attention: Impératif de tenir compte des instructions générales de sécurité et des recommandations du fabricant de la machine!

	Werkstoff-Bezeichnung Material description Designation matière	Nr.	DIN	Zugfestigkeit Tensile strength Rés. à la traction	Härte Hardness Dureté
				Rm (N/mm²)	HB
1	Unlegierter Kohlenstoffstahl Low Carbon Steel Acier carbone	1.0035 1.0038 1.0401 1.0050	St 33 RSt 37-2 C 15 St 50-2	- 500	- 160
2	Vergütungsstahl - Einsatzstahl Alloy Steel Acier d'amélioration - de cémentation	1.0501 1.1141 1.5732 1.7225	Ck 35 V Ck 15 14 NiCr 14 42 CrMo 4 G	500 - 700	140 - 200
3	Vergütungsstahl - Werkzeugstahl Tool Steel Acier d'amélioration - à outils	1.1221 1.3505 1.7225 1.5141	Ck 60 100 Cr 6 42 CrMo 4 53 MnSi 4	900 - 1'100	170 - 275
4	Hochlegierter Werkzeugstahl - Stahlguss Alloy Tool Steel Acier à outils fortement allié - Acier coulé	1.1191 1.7225 1.2080 1.7220	Ck 45 V 42 CrMo 4 X 210 Cr 12 GS-34 CrMo 4	700 - 900	250 - 325
5	Hochlegierter Stahlguss Alloy Cast Steel Acier coulé fortement allié	1.6582 1.8159 1.2367 1.7361	34 CrNiMo 6 50 CrV 4 X 38 CrMoV 5 3 32 CrMo 12	1'100 - 1'500 800 - 1'000	325 - 450 250 - 390
6	Rostfreier Stahl Stainless Steel Acier inoxydable	1.4006 1.4057 1.4034 1.4005	X 10 Cr 13 X 22 CrNi 12 X 40 Cr 13 X 12 CrS 13	- 800	- 250
7	Rostfreier Stahl, austenitisch, martensitisch Stainless Steel - Austenitic, Martensitic Acier inoxydable, austénitique, martensitique	1.4300 1.4301 1.4435 1.4573	X 12 CrNi 18 8 X 5 CrNi 18 9 X 2 CrNiMo 18 12 X 10 CrNiMoTi 18 12	500 - 1100	200 - 325
8	Grauguss Grey Cast Iron Fonte grise	0.6010 0.6015 0.6020	GG-10 GG-15 GG-20	- 250	- 200
9	Grauguss - Temperguss Cast Iron Malleable Fonte grise - Fonte trempée	0.6025 0.8135 0.8140 0.7050	GG-25 GTS-35 GTS-40 GGG-50	250 - 350	200 - 250
10	Kupfer-Legierungen Copper Alloys Alliages cuivre	2.0331 2.0401 2.1030 2.0920	CuZn 36 Pb 1.5 CuZn 36 Pb 3 CuSn 8 CuAl 8	450 - 650	120 - 180
11	Aluminium-Legierungen Aluminium Alloys Alliages d'aluminium	3.2582.05 3.3541.01 3.2315 3.0205	GD-AlSi 12 G-AlMg 3 AlMgSi 1 Al 99	250 - 350	200 - 300

DCGT 04.. -20		GCGT 04.. FL / FR	GCGT 04.. -20	GCGW 04T00...		VCGT 05.. FL / FR	VCGT 05.. -20	VCGW 05..	Hartmetall / Carbide / Carbure: unbeschichtet uncoated non revêtu – DX2		beschichtet coated revêtu – DX32	DX70
f (mm/U) *)									Vc (m/min)			
0.01 ÷ 0.10		0.01 ÷ 0.04	0.01 ÷ 0.10	0.01 ÷ 0.10		0.01 ÷ 0.04	0.01 ÷ 0.10	0.01 ÷ 0.10			300	300
0.01 ÷ 0.10		0.01 ÷ 0.04	0.01 ÷ 0.10	0.01 ÷ 0.10		0.01 ÷ 0.04	0.01 ÷ 0.10	0.01 ÷ 0.10			250	250
0.01 ÷ 0.10		0.01 ÷ 0.04	0.01 ÷ 0.10	0.01 ÷ 0.07		0.01 ÷ 0.04	0.01 ÷ 0.10	0.01 ÷ 0.07			220	220
0.01 ÷ 0.07		0.01 ÷ 0.04	0.01 ÷ 0.07	0.01 ÷ 0.07		0.01 ÷ 0.04	0.01 ÷ 0.07	0.01 ÷ 0.07			180	180
0.01 ÷ 0.07		0.01 ÷ 0.04	0.01 ÷ 0.07	0.01 ÷ 0.05		0.01 ÷ 0.04	0.01 ÷ 0.07	0.01 ÷ 0.05			140	140
0.01 ÷ 0.10		0.01 ÷ 0.04	0.01 ÷ 0.10			0.01 ÷ 0.04	0.01 ÷ 0.10				200	200
0.01 ÷ 0.08		0.01 ÷ 0.04	0.01 ÷ 0.08			0.01 ÷ 0.04	0.01 ÷ 0.08				150	150
0.01 ÷ 0.10		0.01 ÷ 0.04	0.01 ÷ 0.10	0.01 ÷ 0.15		0.01 ÷ 0.04	0.01 ÷ 0.10	0.01 ÷ 0.15	90		210	210
0.01 ÷ 0.10		0.01 ÷ 0.04	0.01 ÷ 0.10	0.01 ÷ 0.10		0.01 ÷ 0.04	0.01 ÷ 0.10	0.01 ÷ 0.10	80		160	160
0.01 ÷ 0.20		0.01 ÷ 0.10	0.01 ÷ 0.20	0.01 ÷ 0.20		0.01 ÷ 0.10	0.01 ÷ 0.20	0.01 ÷ 0.20	200		>300	>300
0.01 ÷ 0.15		0.01 ÷ 0.04	0.01 ÷ 0.15			0.01 ÷ 0.04	0.01 ÷ 0.15				>1000	>1000

*) abhängig von Werkzeug- & Werkstückstabilität / in function of stability of tool & workpiece / en fonction de la stabilité de l'outil et de la pièce

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