	Werkstoff	Material	Werkstoff-Nr. Material No.	DIN Bezeichnung Alt DIN Description Old	Rm/UTS (N/mm²)	DIN Bezeichnung Neu DIN Description New
P	Unlegierter Baustahl + Automatenstahl	Plain carbon steel + free cutting steel	1.0570	St52-3	–700	S355J2G3
			1.1730	C45	–800	C45U
			1.0715	9SMn28	–700	11SMn30
			1.1191	Ck45	500–950	C45E
			1.7219	26CrMo4		26CrMo4-2
	Vergütungsstahl, mittelfest	Heat-treatment steel, medium strength	1.7225	42CrMo4	500–950	42CrMo4
			1.8159	51CrV4		51CrV4
	Stahlguss	Cast steel	1.0416	GS40	–950	GS40
	Einsatzstahl	Case hardening steel	1.7131	16MnCr5	–950	16MnCr5
	Rost- und säurebeständiger Stahl, ferritisch, martensitisch	Stainless steel, ferritic, martensitic	1.4006	X10Cr13	500–950	X12Cr13
			1.4104	X12CrMoS17		X14CrMoS17
			1.4122	X35CrMo17		X39CrMo17-1
	Vergütungsstahl, hochfest	Heat-treatment steel, high strength	1.7225	42CrMo4	950–1400	42CrMo4
			1.6580	30CrNiMo8		30CrNiMo8
	Nitrierstahl, vergütet	Nitriding steel, heat treated	1.8504	34CrAl6	950–1400	34CrAl6
			1.2344	X40CrMoV5.1	–900	X40CrMoV5-1
	Werkzeugstahl	Tool steel	1.2311	40CrMnMo7	–1100	40CrMnMo7
			1.2312	40CrMnNiMoS8.6	–1150	40CrMnNiMoS8-6
			1.2316	X38CrMo16	–1100	X38CrMo16
			1.2738	45CrMnNiMo8.6.4	950–1150	45CrMnNiMo8-6-4
			1.2343	X38CrMoV5 1	950–1400	X37CrMoV5-1
			1.2379	X155CrVMo12 1	–950	X153CrMoV12-1
			1.2358	60CrMoV18-5	850–1000	60CrMoV18-5
			1.2080	X210Cr12	950–1400	X210Cr12
			1.2714	55NiCrMoV7	1100–1350	55NiCrMoV7
M	Rost- und säurebeständiger Stahl, austenitisch	Stainless steel, austenitic	1.4301	X2CrNiMo17-12-2	500–950	X5CrNiMo18-10
			1.4404	X6CrNiMoTi17-12-2		X2CrNiMo17-12-2
			1.4571	X10CrNiMoTi18		X10CrNiMoTi18
	Rost- und säurebeständiger Stahl, martensitisch aushärtbar	Stainless steel, martensitic steel	1.2709	X3NiCoMoTi18-9-5	800–1000	X3NiCoMoTi18-9-5
			1.4542	X5CrNrCuNb16-4		X5CrNrCuNb16-4
			1.4568	X7CrNiAl17-7		X7CrNiAl17-7
K	Grauguss	Grey cast iron	0.6025	GG25	100–400 120–260 HB)	EN-GJI-250
	Legierter Grauguss	Alloyed grey cast iron	0.6678	GGL-NiCr35 2	150–250 160–230 HB)	EN-GJLA-XNICr35-2
	Sphäroguss	Nodular cast iron	0.7060	GGG60	400–800 120–310 HB)	EN-GJS-600-3
			0.7070	GGG70L		EN-GJS-700-2U
	Temperguss	Malleable cast iron	0.8155	GTS55	350–700 150–280 HB)	EN-GJMB-550-4
N	Aluminium-Legierungen, kurzspanend	Aluminium alloys, short chipping	3.2581	G-AlSi12	–400	G-IGK-AlSi12
	Aluminium-Legierungen, langspanend	Aluminium alloys, long chipping	3.3535	AlMg3	–550	AlMg3
			3.4365	AlZnMgCu1,5		AlZnMgCu1,5
	Kupfer-Legierungen, kurzspanend	Copper alloys, short chipping	2.0402	MS58	–500	CuZn40Pb2
	Kupfer-Legierungen, langspanend	Copper alloys, long chipping	2.0320	MS63	300–500	CuZn37
			2.0975	CuAl10Ni		CuAl10Fe5Ni5-C
	Thermoplaste	Thermoplastics		PVC	40–70	PVC
	Duroplaste	Duroplastics		Bakelit, Melamin	20–40	Bakelit, Melamin
S	Titan-Legierungen, mittelfest	Titanium alloys, medium strength	3.7115	TiAl5Sn2,5	–950	TiAl5Sn2-5
			3.7164	TiAl6V4		Ti6AlV4
	Titan-Legierungen, hochfest	Titanium alloys, high strength	3.7174	TiAl6Sn2	900–1400	TiAl6V6Sn2
	Nickelbasis-Legierungen, mittelfest	Nickel based alloys, medium strength	2.4670	NiCr12Al6MoNb	–950	NiCr12Al6MoNb
	Nickelbasis-Legierungen, hochwarmfest	Heat resistant nickel based alloys, high strength	2.4668	NiCr19Fe19NbMo	900–1400	Inconel 718 NiCr19Fe19Nb5Mo3

HM-Sorte Carbide grade	Vorschub pro Zahn Feed per tooth f_z (mm/min) — Schruppen Roughing: v_c (m/min)	f_z (mm/z)	a_p SE max 6 | OE max 4	Schlichten Finishing: v_c (m/min)	f_z (mm/z.)	a_p
LCP40M LCPK30M	150–250 180–280	0,20–0,40 0,15–0,30	3,0–6,0	180–300 200–320	0,08–0,20 0,08–0,15	0,2–2,0
LCP40M LCPK30M	150–250 180–280	0,20–0,40 0,15–0,30	3,0–6,0	100–250 130-280	0,08–0,15 0,08–0,10	0,2–2,0
LCP40M	150–250	0,20–0,40	3,0–6,0	180–300	0,08–0,20	0,2–2,0
LCP40M	100–200	0,20–0,40	3,0–6,0	180–300	0,08–0,15	0,2–2,0
LCP40M LCPK30M	100–200 130–220	0,20–0,40 0,15–0,30	3,0–6,0	150–250 180-300	0,08–0,15 0,08–0,10	0,2–2,0
LCP40M LCPK30M	100–200 130–220	0,20–0,40 0,15–0,30	3,0–6,0	150–250 180–300	0,08–0,15 0,08–0,10	0,2–2,0
LCP40M LCPK30M	100–200 130–220	0,20–0,40 0,15–0,30	3,0–6,0	150–250 180–300	0,08–0,15 0,08–0,10	0,2–2,0
LCP40M LCPK30M	100–200 130–220	0,15–0,35 0,15–0,30	3,0–6,0	150–250 180–300	0,08–0,15 0,08–0,10	0,2–2,0
LCM45M LCMS35M	80–120 160–220	0,15–0,25	1,0–3,0	80–120 160–240	0,05–0,15	0,2–1,0
LCM45M LCMS35M	60–100 160–220	0,20–0,40	1,0–3,0	60–100 160–240	0,05–0,15	0,2–1,0
LCKP10M	100–240	0,10–0,35	3,0–6,0	200–260	0,10–0,20	0,2–2,0
LCKP10M	100–180	0,10–0,35	3,0–6,0	160–200	0,10–0,20	0,2–2,0
LCKP10M	100–160	0,10–0,35	3,0–6,0	140–180	0,10–0,20	0,2–2,0
LCKP10M	100–200	0,10–0,35	3,0–6,0	160–220	0,10–0,20	0,2–2,0
LCN10M	400	0,30–0,40	3,0–6,0	400	0,10–0,20	0,2–2,0
LWN10M	500–1000	0,30–0,40	3,0–6,0	500–1000	0,10–0,20	0,2–2,0
LWN10M LCN10M	150–300	0,30–0,40	3,0–6,0	200–350	0,10–0,20	0,2–2,0
LWN10M LCN10M	250–500	0,30–0,40	3,0–6,0	300–500	0,10–0,20	0,2–2,0
LWN10M	180–300	0,30–0,40	3,0–6,0	200–400	0,10–0,20	0,2–2,0
LWN10M	200–250	0,30–0,40	3,0–6,0	200–250	0,10–0,20	0,2–2,0
LCMS35M	40–80	0,05–0,15	1,0–2,5	40–80	0,05–0,10	0,2–1,0
LCMS35M	20–60	0,05–0,15	0,5–2,0	30–60	0,05–0,10	0,2–1,0
LCMS35M	30–80	0,05–0,15	1,0–2,5	40–80	0,05–0,10	0,2–1,0
LCMS35M	30–80	0,05–0,15	1,0–2,5	40–80	0,05–0,10	0,2–1,0

Die angegebenen Schnittwerte sind Startwerte und müssen auf die vorhandenen Bedingungen abgestimmt werden.
The cutting data indicated are starting values and must be adjusted to the prevailing conditions.

Nassbearbeitung, auf ausreichende Emulsionszuführung achten
Wet machining, sufficient emulsion volume required

Trockenbearbeitung, Pressluftkühlung ist vorteilhaft
Dry machining, air-blast cooling is avantageous