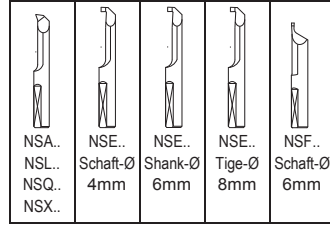


DENITTOOL-DATA

MicroTurn A/S

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/mm ²)	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-AISi 12 G-ALMg 3 AlMgSi 1 Al 99	250 - 350	200 - 300



DENALLOY®			
unbeschichtet uncoated non revêtu	beschichtet coated revêtu		
	PVD		

f (mm/U) *)					(mm) **)
0.01	0.005	0.005	0.005	0.005	0.005
+	+	+	+	+	+
0.06	0.030	0.040	0.060	0.040	0.040
0.01	0.005	0.005	0.005	0.005	0.005
+	+	+	+	+	+
0.06	0.030	0.040	0.060	0.040	0.040
0.01	0.005	0.005	0.005	0.005	0.005
+	+	+	+	+	+
0.06	0.030	0.040	0.060	0.040	0.040
0.01	0.005	0.005	0.005	0.005	0.005
+	+	+	+	+	+
0.04	0.020	0.030	0.030	0.030	0.030
0.01	0.005	0.005	0.005	0.005	0.005
+	+	+	+	+	+
0.04	0.020	0.030	0.030	0.030	0.030
0.01	0.005	0.005	0.005	0.005	0.005
+	+	+	+	+	+
0.06	0.030	0.040	0.060	0.040	0.040
0.01	0.005	0.005	0.005	0.005	0.005
+	+	+	+	+	+
0.04	0.020	0.030	0.030	0.030	0.030
0.01	0.005	0.005	0.005	0.005	0.005
+	+	+	+	+	+
0.06	0.030	0.040	0.060	0.040	0.040
0.01	0.005	0.005	0.005	0.005	0.005
+	+	+	+	+	+
0.04	0.020	0.030	0.030	0.030	0.030
0.03	0.015	0.015	0.015	0.015	0.015
+	+	+	+	+	+
0.10	0.050	0.070	0.090	0.070	0.070
0.03	0.010	0.015	0.015	0.015	0.015
+	+	+	+	+	+
0.10	0.040	0.050	0.060	0.050	0.050
0.01	0.015	0.015	0.015	0.015	0.015
+	+	+	+	+	+
0.10	0.060	0.080	0.120	0.080	0.080
0.01	0.015	0.015	0.015	0.015	0.015
+	+	+	+	+	+
0.10	0.050	0.100	0.120	0.100	0.100

Vc (m/min)					
		50			
		43			
		36			
		25			
		20			
		35			
		28			
		30			
		25			
		160			
		300			

*) tiefe Werte für Werkzeuge mit langem Schaft / low data for tool w. long shank / petites valeurs pour outils longs
 höhere Werte für Werkzeuge mit kurzem Schaft / high data for tool w. short shank / hautes valeurs pour outils courts

***) Spandicke / chip thickness / épaisseur de copeau