

7° POSITIVE WSP

Material	Härte	Schnittmodus	Priorität	Spanbrecher	Sorte	Schnittgeschw. (m/min)	Vorschub (mm/U.)	Schnittiefe (mm)	
Allg. Baustahl (St37-2, Ck10)	≤180HB	●	F	1	FP	NX2525	225–320	0.04–0.20	0.20–0.90
		●	F	2	FV	NX2525	225–320	0.04–0.20	0.20–0.90
		●	F	3	R/L-F	MP3025	230–355	0.05–0.12	0.10–0.50
		●	L	1	LP	NX2525	225–320	0.06–0.25	0.20–1.00
		●	L	2	Std	UE6110	210–355	0.08–0.30	0.30–2.00
		●	L	3	MV	MP3025	190–295	0.08–0.30	0.30–2.00
		●	L	4	Std	MP3025	190–295	0.08–0.30	0.30–2.00
		●	M	1	MP	NX2525	185–270	0.08–0.30	0.30–2.00
		●	F	1	FP	MC6015	250–425	0.04–0.20	0.20–0.90
		●	F	2	FP	UE6110	250–425	0.04–0.20	0.20–0.90
		●	F	3	FP	MP3025	230–355	0.04–0.20	0.20–0.90
		●	F	4	FV	MP3025	230–355	0.04–0.20	0.20–0.90
		●	F	5	FV	NX3035	220–310	0.04–0.20	0.20–0.90
		●	L	1	LP	MC6015	250–425	0.06–0.25	0.20–1.00
		●	L	2	LP	UE6110	250–425	0.06–0.25	0.20–1.00
		●	L	3	LP	MP3025	230–355	0.06–0.25	0.20–1.00
		●	L	4	Std	UE6110	210–355	0.08–0.30	0.30–2.00
		●	L	5	SW	MC6015	250–425	0.06–0.24	0.20–1.50
		●	L	6	SW	MP3025	230–355	0.06–0.24	0.20–1.50
		●	M	1	MP	MC6015	210–355	0.08–0.30	0.30–2.00
		●	M	2	MP	UE6110	210–355	0.08–0.30	0.30–2.00
		●	M	3	MP	MP3025	190–295	0.08–0.30	0.30–2.00
		●	M	4	MW	MC6015	210–355	0.10–0.35	0.80–2.50
		●	F	1	FP	MC6025	250–405	0.04–0.20	0.20–0.90
		●	L	1	LP	MC6025	250–405	0.06–0.25	0.20–1.00
		●	L	2	SV	MC6025	250–405	0.06–0.25	0.20–1.00
		●	L	3	SW	MC6025	250–405	0.06–0.24	0.20–1.50
		●	M	1	MP	MC6025	210–340	0.08–0.30	0.30–2.00
		●	M	2	MW	MC6025	210–340	0.10–0.35	0.80–2.50
		C-Stahl Leg. Stahl (Ck45, 42CrMo4)	180 280HB	●	F	1	FP	NX2525	165–240
●	F			2	FV	NX2525	165–240	0.04–0.20	0.20–0.90
●	F			3	R/L-F	MP3025	170–260	0.05–0.12	0.10–0.50
●	L			1	LP	NX2525	165–240	0.06–0.25	0.20–1.00
●	L			2	Std	UE6110	155–260	0.08–0.30	0.30–2.00
●	L			3	MV	MP3025	140–220	0.08–0.30	0.30–2.00
●	L			4	Std	MP3025	140–220	0.08–0.30	0.30–2.00
●	L			5	SV	MP3025	170–260	0.06–0.25	0.20–1.00
●	L			6	SW	MP3025	170–260	0.06–0.24	0.20–1.50
●	M			1	MP	NX2525	140–200	0.08–0.30	0.30–2.00
●	M			2	MW	MP3025	140–220	0.10–0.35	0.80–2.50
●	F			1	FP	MC6015	185–315	0.04–0.20	0.20–0.90
●	F			2	FP	UE6110	185–315	0.04–0.20	0.20–0.90
●	F			3	FP	MP3025	170–260	0.04–0.20	0.20–0.90
●	F			4	FV	MP3025	170–260	0.04–0.20	0.20–0.90
●	F			5	FV	NX3035	160–230	0.04–0.20	0.20–0.90
●	L			1	LP	MC6015	185–315	0.06–0.25	0.20–1.00

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SCHNITTDATENEMPFEHLUNGEN

■ 7° POSITIVE WSP

Spanbrecher : Std : Standard Flat : Glatt

Material	Härte	Schnittmodus	Priorität	Spanbrecher	Sorte	Schnittgeschw. (m/min)	Vorschub (mm/U.)	Schnitttiefe (mm)	
C-Stahl Leg. Stahl (Ck45, 42CrMo4)	180 280HB	●	L	2	LP	UE6110	185–315	0.06–0.25	0.20–1.00
		●	L	3	LP	MP3025	170–260	0.06–0.25	0.20–1.00
		●	L	4	Std	UE6110	155–260	0.08–0.30	0.30–2.00
		●	L	5	SW	MC6015	185–315	0.06–0.24	0.20–1.50
		●	L	6	SW	MP3025	170–260	0.06–0.24	0.20–1.50
		●	M	1	MP	MC6015	155–260	0.08–0.30	0.30–2.00
		●	M	2	MP	UE6110	155–260	0.08–0.30	0.30–2.00
		●	M	3	MP	MP3025	140–220	0.08–0.30	0.30–2.00
		●	M	4	MW	MC6015	155–260	0.10–0.35	0.80–2.50
		✚	F	1	FP	MC6025	185–300	0.04–0.20	0.20–0.90
		✚	L	1	LP	MC6025	185–300	0.06–0.25	0.20–1.00
		✚	L	2	SV	MC6025	185–300	0.06–0.25	0.20–1.00
		✚	L	3	SW	MC6025	185–300	0.06–0.24	0.20–1.50
		✚	M	1	MP	MC6025	155–250	0.08–0.30	0.30–2.00
		✚	M	2	MW	MC6025	155–250	0.10–0.35	0.80–2.50
C-Stahl Leg. Stahl (40CrNiMoA)	280 350HB	●	M	1	MP	NX2525	95–140	0.08–0.30	0.30–2.00
		●	M	1	MP	MC6015	110–185	0.08–0.30	0.30–2.00
		●	M	2	MP	UE6110	110–185	0.08–0.30	0.30–2.00
		●	M	3	MP	MP3025	100–155	0.08–0.30	0.30–2.00
		✚	M	1	MP	MC6025	110–175	0.08–0.30	0.30–2.00

SCHNITTDATENEMPFEHLUNGEN : ● : Stabile Bearbeitung ● : Allgemeine Bearbeitung ✚ : Instabile Bearbeitung

ANWENDUNGSBEREICH : F : Schlichtzerspannung L : Leichtzerspannung M : Mittlere Zerspannung R : Schrappzerspannung H : Schwerzerspannung

Material	Härte	Schnittmodus		Priorität	Spanbrecher	Sorte	Schnittgeschw. (m/min)	Vorschub (mm/U.)	Schnitttiefe (mm)
Rostfreier Stahl (austenitisch) (X5CrNi189, X5CrNiMo1810)	≤200HB	●	F	1	FM	VP15TF	75–125	0.04–0.20	0.20–0.90
		●	F	2	Std	US735	70–135	0.08–0.30	0.30–2.00
		●	L	1	LM	MC7025	140–190	0.06–0.25	0.20–1.00
		●	L	2	Std	US735	70–135	0.08–0.30	0.30–2.00
		●	M	1	MM	MC7025	120–160	0.08–0.30	0.30–2.00
		●	F	1	FM	VP15TF	75–125	0.04–0.20	0.20–0.90
		●	F	2	Std	US735	70–135	0.08–0.30	0.30–2.00
		●	L	1	LM	MC7025	140–190	0.06–0.25	0.20–1.00
		●	L	2	Std	US735	70–135	0.08–0.30	0.30–2.00
		●	M	1	MM	MC7025	120–160	0.08–0.30	0.30–2.00
		⊕	F	1	FM	VP15TF	75–125	0.04–0.20	0.20–0.90
		⊕	F	2	Std	US735	70–135	0.08–0.30	0.30–2.00
		⊕	L	1	LM	MP7035	85–135	0.06–0.25	0.20–1.00
		⊕	L	2	LM	VP15TF	75–125	0.06–0.25	0.20–1.00
		⊕	L	3	Std	US735	70–135	0.08–0.30	0.30–2.00
		⊕	M	1	MM	MP7035	70–115	0.08–0.30	0.30–2.00
⊕	M	2	MM	VP15TF	60–105	0.08–0.30	0.30–2.00		
Rostfreier Stahl (austenitisch) (X2CrNiN1810, X2CrNiMoN1813)	>200HB	●	F	1	FM	VP15TF	60–105	0.04–0.20	0.20–0.90
		●	F	2	Std	US735	60–110	0.08–0.30	0.30–2.00
		●	L	1	LM	MC7025	120–160	0.06–0.25	0.20–1.00
		●	L	2	Std	US735	60–110	0.08–0.30	0.30–2.00
		●	M	1	MM	MC7025	100–130	0.08–0.30	0.30–2.00
		●	F	1	FM	VP15TF	60–105	0.04–0.20	0.20–0.90
		●	F	2	Std	US735	60–110	0.08–0.30	0.30–2.00
		●	L	1	LM	MC7025	120–160	0.06–0.25	0.20–1.00
		●	L	2	Std	US735	60–110	0.08–0.30	0.30–2.00
		●	M	1	MM	MC7025	100–130	0.08–0.30	0.30–2.00
		⊕	F	1	FM	VP15TF	60–105	0.04–0.20	0.20–0.90
		⊕	F	2	Std	US735	60–110	0.08–0.30	0.30–2.00
		⊕	L	1	LM	MP7035	70–115	0.06–0.25	0.20–1.00
		⊕	L	2	LM	VP15TF	60–105	0.06–0.25	0.20–1.00
		⊕	L	3	Std	US735	60–110	0.08–0.30	0.30–2.00
		⊕	M	1	MM	MP7035	60–95	0.08–0.30	0.30–2.00
⊕	M	2	MM	VP15TF	50–90	0.08–0.30	0.30–2.00		
Duplex, rostfreier Stahl (X3CrNiCu1894)	≤280HB	●	F	1	FM	VP15TF	50–85	0.04–0.20	0.20–0.90
		●	F	2	Std	US735	45–90	0.08–0.30	0.30–2.00
		●	L	1	LM	MC7025	95–130	0.06–0.25	0.20–1.00
		●	L	2	Std	US735	45–90	0.08–0.30	0.30–2.00
		●	M	1	MM	MC7025	80–105	0.08–0.30	0.30–2.00
		●	F	1	FM	VP15TF	50–85	0.04–0.20	0.20–0.90
		●	F	2	Std	US735	45–90	0.08–0.30	0.30–2.00
		●	L	1	LM	MC7025	95–130	0.06–0.25	0.20–1.00
		●	L	2	Std	US735	45–90	0.08–0.30	0.30–2.00
		●	M	1	MM	MC7025	80–105	0.08–0.30	0.30–2.00
		⊕	F	1	FM	VP15TF	50–85	0.04–0.20	0.20–0.90
		⊕	F	2	Std	US735	45–90	0.08–0.30	0.30–2.00
		⊕	L	1	LM	MP7035	55–90	0.06–0.25	0.20–1.00
		⊕	L	2	LM	VP15TF	50–85	0.06–0.25	0.20–1.00

SCHNITTDATENEMPFEHLUNGEN

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Spanbrecher : Std : Standard Flat : Glatt

Material	Härte	Schnittmodus		Priorität	Spanbrecher	Sorte	Schnittgeschw. (m/min)	Vorschub (mm/U.)	Schnitttiefe (mm)
Duplex, rostfreier Stahl (X3CrNiCu1894)	≤280HB	✚	L	3	Std	US735	45–90	0.08–0.30	0.30–2.00
		✚	M	1	MM	MP7035	45–75	0.08–0.30	0.30–2.00
		✚	M	2	MM	VP15TF	40–70	0.08–0.30	0.30–2.00
Rostfreie Stähle, austenitisch und martensitisch (X10Cr13, X8Cr17)	≤200HB	●	F	1	FM	VP15TF	75–125	0.04–0.20	0.20–0.90
		●	F	2	Std	US735	70–135	0.08–0.30	0.30–2.00
		●	L	1	LM	MC7025	140–190	0.06–0.25	0.20–1.00
		●	L	2	Std	US735	70–135	0.08–0.30	0.30–2.00
		●	M	1	MM	MC7025	120–160	0.08–0.30	0.30–2.00
		●	F	1	FM	VP15TF	75–125	0.04–0.20	0.20–0.90
		●	F	2	Std	US735	70–135	0.08–0.30	0.30–2.00
		●	L	1	LM	MC7025	140–190	0.06–0.25	0.20–1.00
		●	L	2	Std	US735	70–135	0.08–0.30	0.30–2.00
		●	M	1	MM	MC7025	120–160	0.08–0.30	0.30–2.00
		✚	F	1	FM	VP15TF	75–125	0.04–0.20	0.20–0.90
		✚	F	2	Std	US735	70–135	0.08–0.30	0.30–2.00
		✚	L	1	LM	MP7035	85–135	0.06–0.25	0.20–1.00
		✚	L	2	LM	VP15TF	75–125	0.06–0.25	0.20–1.00
		✚	L	3	Std	US735	70–135	0.08–0.30	0.30–2.00
		✚	M	1	MM	MP7035	70–115	0.08–0.30	0.30–2.00
✚	M	2	MM	VP15TF	60–105	0.08–0.30	0.30–2.00		
Rostfreie Stähle, austenitisch und martensitisch (X17CrNi162, X30Cr13)	>200HB	●	F	1	FM	VP15TF	60–105	0.04–0.20	0.20–0.90
		●	F	2	Std	US735	60–110	0.08–0.30	0.30–2.00
		●	L	1	LM	MC7025	120–160	0.06–0.25	0.20–1.00
		●	L	2	Std	US735	60–110	0.08–0.30	0.30–2.00
		●	M	1	MM	MC7025	100–130	0.08–0.30	0.30–2.00
		●	F	1	FM	VP15TF	60–105	0.04–0.20	0.20–0.90
		●	F	2	Std	US735	60–110	0.08–0.30	0.30–2.00
		●	L	1	LM	MC7025	120–160	0.06–0.25	0.20–1.00
		●	L	2	Std	US735	60–110	0.08–0.30	0.30–2.00
		●	M	1	MM	MC7025	100–130	0.08–0.30	0.30–2.00
		✚	F	1	FM	VP15TF	60–105	0.04–0.20	0.20–0.90
		✚	F	2	Std	US735	60–110	0.08–0.30	0.30–2.00
		✚	L	1	LM	MP7035	70–115	0.06–0.25	0.20–1.00
		✚	L	2	LM	VP15TF	60–105	0.06–0.25	0.20–1.00
		✚	L	3	Std	US735	60–110	0.08–0.30	0.30–2.00
		✚	M	1	MM	MP7035	60–95	0.08–0.30	0.30–2.00
✚	M	2	MM	VP15TF	50–90	0.08–0.30	0.30–2.00		
Gehärtete rostfreie PH-Stähle (X5CrNiCuNb16-4, X7CrNiAl17-7)	<450HB	●	F	1	FM	VP15TF	40–70	0.04–0.20	0.20–0.90
		●	F	2	FS	MP9005	110–150	0.04–0.12	0.20–1.40
		●	F	3	Std	US735	40–75	0.08–0.25	0.30–2.00
		●	L	1	LM	MC7025	75–95	0.06–0.20	0.20–1.00
		●	L	2	LS(G)	MP9015	105–140	0.04–0.15	0.30–3.00
		●	L	3	LS(M)	MP9015	105–140	0.06–0.20	0.20–1.00
		●	L	4	Std	US735	40–75	0.08–0.25	0.30–2.00
		●	M	1	MM	MC7025	60–80	0.08–0.25	0.30–2.00
		●	M	2	MS	MP9015	85–120	0.08–0.25	0.30–2.00
		●	M	3	RCMT-Std	MP9015	85–120	0.25–0.45	1.50–3.00
●	F	1	FM	VP15TF	40–70	0.04–0.20	0.20–0.90		

SCHNITTDATENEMPFEHLUNGEN : ● : Stabile Bearbeitung ● : Allgemeine Bearbeitung ✚ : Instabile Bearbeitung

ANWENDUNGSBEREICH : F : Schlichtzerspannung L : Leichtzerspannung M : Mittlere Zerspannung R : Schrappzerspannung H : Schwerzerspannung

Material	Härte	Schnittmodus		Priorität	Spanbrecher	Sorte	Schnittgeschw. (m/min)	Vorschub (mm/U.)	Schnitttiefe (mm)
M Gehärtete rostfreie PH-Stähle (X5CrNiCuNb16-4, X7CrNiAl17-7)	<450HB	☉	F	2	FS	MP9015	105–140	0.04–0.12	0.20–1.40
		☉	F	3	Std	US735	40–75	0.08–0.25	0.30–2.00
		☉	L	1	LM	MC7025	75–95	0.06–0.20	0.20–1.00
		☉	L	2	LS(G)	MP9015	105–140	0.04–0.15	0.30–3.00
		☉	L	3	LS(M)	MP9015	105–140	0.06–0.20	0.20–1.00
		☉	L	4	Std	US735	40–75	0.08–0.25	0.30–2.00
		☉	M	1	MM	MC7025	60–80	0.08–0.25	0.30–2.00
		☉	M	2	MS	MP9015	85–120	0.08–0.25	0.30–2.00
		☉	M	3	RCMT-Std	MP9015	85–120	0.25–0.45	1.50–3.00
		☼	F	1	FM	VP15TF	40–70	0.04–0.20	0.20–0.90
		☼	F	2	Std	US735	40–75	0.08–0.25	0.30–2.00
		☼	L	1	LM	MP7035	45–75	0.06–0.20	0.20–1.00
		☼	L	2	LS(M)	MP9025	70–85	0.06–0.20	0.20–1.00
		☼	L	3	LM	VP15TF	40–70	0.06–0.20	0.20–1.00
		☼	L	4	Std	US735	40–75	0.08–0.25	0.30–2.00
		☼	M	1	MM	MP7035	40–60	0.08–0.25	0.30–2.00
		☼	M	2	MS	MP9025	60–70	0.08–0.25	0.30–2.00
		☼	M	3	MM	VP15TF	35–60	0.08–0.25	0.30–2.00
		☼	M	4	RCMT-Std	MP9025	60–70	0.25–0.45	1.50–3.00

SCHNITTDATENEMPFEHLUNGEN

■ 7° POSITIVE WSP

Spanbrecher : Std : Standard Flat : Glatt

Material	Zugfestigkeit	Schnittmodus		Priorität	Spanbrecher	Sorte	Schnittgeschw. (m/min)	Vorschub (mm/U.)	Schnitttiefe (mm)
Grauguss (GG30)	≤350MPa	●	F	1	MK	MC5005	165–265	0.08–0.30	0.30–2.00
		●	L	1	MK	MC5005	165–265	0.08–0.30	0.30–2.00
		●	M	1	Flat	MC5005	165–265	0.08–0.30	0.30–2.00
		●	F	1	MK	MC5015	150–240	0.08–0.30	0.30–2.00
		●	L	1	MK	MC5015	150–240	0.08–0.30	0.30–2.00
		●	M	1	Flat	MC5015	150–240	0.08–0.30	0.30–2.00
		✚	F	1	MK	MC5015	150–240	0.08–0.30	0.30–2.00
		✚	L	1	MK	MC5015	150–240	0.08–0.30	0.30–2.00
		✚	M	1	Flat	MC5015	150–240	0.08–0.30	0.30–2.00
Duktiler Guss (GGG40)	≤450MPa	●	F	1	MK	MC5005	155–250	0.08–0.30	0.30–2.00
		●	L	1	MK	MC5005	155–250	0.08–0.30	0.30–2.00
		●	M	1	Flat	MC5005	155–250	0.08–0.30	0.30–2.00
		●	F	1	MK	MC5015	140–230	0.08–0.30	0.30–2.00
		●	L	1	MK	MC5015	140–230	0.08–0.30	0.30–2.00
		●	M	1	Flat	MC5015	140–230	0.08–0.30	0.30–2.00
		✚	F	1	MK	MC5015	140–230	0.08–0.30	0.30–2.00
		✚	L	1	MK	MC5015	140–230	0.08–0.30	0.30–2.00
		✚	M	1	Flat	MC5015	140–230	0.08–0.30	0.30–2.00
Duktiler Guss (GGG70)	≤800MPa	●	F	1	MK	MC5005	140–225	0.08–0.30	0.30–2.00
		●	L	1	MK	MC5005	140–225	0.08–0.30	0.30–2.00
		●	M	1	Flat	MC5005	140–225	0.08–0.30	0.30–2.00
		●	F	1	MK	MC5015	125–205	0.08–0.30	0.30–2.00
		●	L	1	MK	MC5015	125–205	0.08–0.30	0.30–2.00
		●	M	1	Flat	MC5015	125–205	0.08–0.30	0.30–2.00
		✚	F	1	MK	MC5015	125–205	0.08–0.30	0.30–2.00
		✚	L	1	MK	MC5015	125–205	0.08–0.30	0.30–2.00
		✚	M	1	Flat	MC5015	125–205	0.08–0.30	0.30–2.00

SCHNITTDATENEMPFEHLUNGEN : ● : Stabile Bearbeitung ● : Allgemeine Bearbeitung ✚ : Instabile Bearbeitung

ANWENDUNGSBEREICH : F : Schlichtzerspannung L : Leichtzerspannung M : Mittlere Zerspannung R : Schrappzerspannung H : Schwerzerspannung

Material	Härte	Schnittmodus		Priorität	Spanbrecher	Sorte	Schnittgeschw. (m/min)	Vorschub (mm/U.)	Schnitttiefe (mm)	
N	Aluminiumlegierung (A6061, A7075)	Si<5%	●	F	1	AZ	HTi10	300–700	0.10–0.40	0.20–3.00
			◐	F	1	AZ	HTi10	300–700	0.10–0.40	0.20–3.00
			⊕	F	1	AZ	HTi10	300–700	0.10–0.40	0.20–3.00
	Aluminiumlegierung (AC4B)	5%≤Si≤10%	●	F	1	AZ	HTi10	300–700	0.10–0.40	0.20–3.00
			◐	F	1	AZ	HTi10	300–700	0.10–0.40	0.20–3.00
			⊕	F	1	AZ	HTi10	300–700	0.10–0.40	0.20–3.00
	Aluminiumlegierung (ADC12, A390)	Si>10%	●	F	1	AZ	HTi10	300–700	0.10–0.40	0.20–3.00
			◐	F	1	AZ	HTi10	300–700	0.10–0.40	0.20–3.00
			⊕	F	1	AZ	HTi10	300–700	0.10–0.40	0.20–3.00

SCHNITTDATENEMPFEHLUNGEN

7° POSITIVE WSP

Spanbrecher : Std : Standard Flat : Glatt

Material	Härte	Schnittmodus		Priorität	Spanbrecher	Sorte	Schnittgeschw. (m/min)	Vorschub (mm/U.)	Schnitttiefe (mm)
Titanlegierung (Ti-6Al-4V)	-	●	F	1	FS-P	MT9005	40-80	0.04-0.12	0.20-1.40
		●	F	2	FJ	RT9010	35-75	0.04-0.12	0.20-1.40
		●	L	1	LS-P	MT9005	40-80	0.04-0.15	0.30-3.00
		●	L	2	LS(M)	MT9005	40-80	0.06-0.20	0.20-1.00
		●	M	1	MS	MT9005	35-65	0.08-0.25	0.30-2.00
		●	M	2	RCMT-Std	MT9005	35-65	0.25-0.45	1.50-3.00
		●	F	1	FS-P	MT9005	40-80	0.04-0.12	0.20-1.40
		●	F	2	FJ	RT9010	35-75	0.04-0.12	0.20-1.40
		●	L	1	LS-P	MT9005	40-80	0.04-0.15	0.30-3.00
		●	L	2	LS(M)	MT9005	40-80	0.06-0.20	0.20-1.00
		●	M	1	MS	MT9005	35-65	0.08-0.25	0.30-2.00
		●	M	2	RCMT-Std	MT9005	35-65	0.25-0.45	1.50-3.00
		⊕	F	1	FS-P	MT9005	40-80	0.04-0.12	0.20-1.40
		⊕	F	2	FJ	RT9010	35-75	0.04-0.12	0.20-1.40
		⊕	L	1	LS-P	MT9005	40-80	0.04-0.15	0.30-3.00
		⊕	L	2	LS(M)	MT9005	40-80	0.06-0.20	0.20-1.00
		⊕	M	1	MS	MT9005	35-65	0.08-0.25	0.30-2.00
		⊕	M	2	RCMT-Std	MT9015	30-60	0.25-0.45	1.50-3.00
Hitzebeständiger Stahl (Inconel718)	-	●	F	1	FS	MP9005	25-95	0.04-0.12	0.20-1.40
		●	F	2	FJ	VP10RT	20-45	0.04-0.12	0.20-1.40
		●	L	1	LS(G)	MP9005	25-95	0.04-0.15	0.30-3.00
		●	L	2	LS(M)	MP9005	25-95	0.06-0.20	0.20-1.00
		●	M	1	MS	MP9005	20-80	0.08-0.25	0.30-2.00
		●	M	2	RCMT-Std	MP9005	20-80	0.25-0.45	1.50-3.00
		●	F	1	FS	MP9015	20-75	0.04-0.12	0.20-1.40
		●	F	2	FJ	VP10RT	20-45	0.04-0.12	0.20-1.40
		●	L	1	LS(G)	MP9015	20-75	0.04-0.15	0.30-3.00
		●	L	2	LS(M)	MP9015	20-75	0.06-0.20	0.20-1.00
		●	M	1	MS	MP9015	20-60	0.08-0.25	0.30-2.00
		●	M	2	RCMT-Std	MP9015	20-60	0.25-0.45	1.50-3.00
		⊕	F	1	FJ	VP10RT	20-45	0.04-0.12	0.20-1.40
		⊕	L	1	LS(M)	MP9025	15-25	0.06-0.20	0.20-1.00
		⊕	M	1	MS	MP9025	15-20	0.08-0.25	0.30-2.00
		⊕	M	2	RCMT-Std	MP9025	15-20	0.25-0.45	1.50-3.00

SCHNITTDATENEMPFEHLUNGEN : ● : Stabile Bearbeitung ● : Allgemeine Bearbeitung ⊕ : Instabile Bearbeitung

ANWENDUNGSBEREICH : F : Schlichtzerspannung L : Leichtzerspannung M : Mittlere Zerspannung R : Schrumpferspannung H : Schwerzerspannung