

## Application values

Solid carbide TiAlN high-performance reamer (Art. no. 1013523 101-117)



Material groups for cutting values	Strength Class [N/mm <sup>2</sup> ]	Description regarding DIN	Vc [m/min]	1-5	5-8	8-12	12-16	16-20
<b>1. Steels</b>								
1.1 Free machining steel	< 900	9 S 20						
1.2 Structural steel	<500	ST 37-2						
1.3 Structural steel	> 500	ST 60-2						
1.4 Heat-treated steel	<1000	42 CrMo 4						
1.5 Cast iron	<1000	GS-45						
1.6 Case-hardened steel	<1200	16 MnCr 5						
1.7 Ferritic/martensitic stainless steel	<1100	X 10 Cr 13	20-60	0.1-0.15	0.15-0.3	0.3-0.4	0.4-0.5	0.5-0.6
1.8 Heat-treated steel	>1000	43 CrMo 4						
1.9 Nitriding steel	<1300	31 CrMoV 9						
1.10 Tool steel	<1300	X 38 CrMoV 5 1						
<b>2. Stainless steels</b>								
2.1 Austenitic stainless steel	<1100	G-X 2 CrNiMo 18 15	20-40	0.1-0.15	0.15-0.3	0.3-0.4	0.4-0.5	0.5-0.6



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