

| Material | Kohlenstoffstähle carbon steels | | | | legierte Stähle / vorvergütete Stähle alloy steels / prehardened steels | | | | gehärtete Stähle hardened steels | | | |
|----------|------------------------------------|------------------|------------------------------|---------|--|------------------|------------------------------|---------|-------------------------------------|------------------|------------------------------|---------|
| | S50C | | | | SKD / HPM / NAK | | | | STAVAX / SKD61 (~52HRC) | | | |
| Radius | Drehzahl rpm | Vorschub feed | Schnitttiefe depth of cut | | Drehzahl rpm | Vorschub feed | Schnitttiefe depth of cut | | Drehzahl rpm | Vorschub feed | Schnitttiefe depth of cut | |
| | min ⁻¹ | mm / min | Ap (mm) | Ae (mm) | min ⁻¹ | mm / min | Ap (mm) | Ae (mm) | min ⁻¹ | mm / min | Ap (mm) | Ae (mm) |
| 0,50 | 40.000 | 4000 | 0,100 | 0,300 | 40.000 | 3500 | 0,100 | 0,300 | 30.000 | 2500 | 0,100 | 0,300 |
| 1,00 | 30.000 | 4500 | 0,200 | 0,600 | 30.000 | 4000 | 0,200 | 0,600 | 20.000 | 3000 | 0,200 | 0,600 |
| 1,50 | 24.000 | 4500 | 0,300 | 1,000 | 24.000 | 4000 | 0,300 | 1,000 | 18.000 | 3000 | 0,200 | 1,000 |
| 2,00 | 20.000 | 4500 | 0,400 | 1,500 | 20.000 | 4000 | 0,400 | 1,500 | 15.000 | 3000 | 0,300 | 1,500 |
| 2,50 | 16.000 | 4500 | 0,500 | 1,700 | 16.000 | 4000 | 0,500 | 1,700 | 12.000 | 3000 | 0,300 | 2,000 |
| 3,00 | 10.000 | 4500 | 0,600 | 2,000 | 10.000 | 4000 | 0,600 | 2,000 | 9.000 | 3000 | 0,400 | 2,000 |
| 4,00 | 8.000 | 4500 | 0,800 | 2,500 | 8.000 | 4000 | 0,800 | 2,500 | 7.000 | 3000 | 0,500 | 2,000 |
| 5,00 | 6.500 | 4500 | 1,200 | 3,000 | 6.500 | 4000 | 1,200 | 3,000 | 5.500 | 3000 | 0,700 | 2,500 |
| 6,00 | 5.000 | 4500 | 1,500 | 4,000 | 5.000 | 4000 | 1,500 | 4,000 | 4.000 | 3000 | 1,000 | 3,000 |