

# Werkstoffe / Werkzeugauswahl work-materials / choice of tools



- ▶ ● ■ blind hole less than 3xØ
- ▶ ● ■■■■ blind hole deeper than 3xØ
- ▶ ○ ■ through hole less than 3xØ
- ▶ ○ ■■■■ through hole deeper than 3xØ
  
- uncoated
- ▣ TIN-Beschichtung  
TIN-coating
- TIALN-Beschichtung  
TIALN-coating
- Sonder-Beschichtung  
special-coating

- sehr gut - very good
- gut - good
- weniger gut - not so good
- schlecht - bad

- Innere Kühlung - internal cooling
- empfohlen - recommended
- notwendig - necessary

Werkstoff - material	Werkzeug								tool
	SDG	SXG	SDH	SDI	SXI	SDK	SDM	SDO	
Aluminium aluminium	▶ ● ■								
	▶ ● ■■■■								
	▶ ○ ■								
	▶ ○ ■■■■								
Messing brass	▶ ● ■								
	▶ ● ■■■■								
	▶ ○ ■								
	▶ ○ ■■■■								
Titan titanium	▶ ● ■								
	▶ ● ■■■■								
	▶ ○ ■								
	▶ ○ ■■■■								
Gold gold	▶ ● ■								
	▶ ● ■■■■								
	▶ ○ ■								
	▶ ○ ■■■■								
Stahl steel < 800Nm/mm <sup>2</sup>	▶ ● ■								
	▶ ● ■■■■								
	▶ ○ ■								
	▶ ○ ■■■■								
Stahl steel < 1200 Nm/mm <sup>2</sup>	▶ ● ■								
	▶ ● ■■■■								
	▶ ○ ■								
	▶ ○ ■■■■								
Stahl steel (rostfrei - inox) >1200 Nm/mm <sup>2</sup>	▶ ● ■								
	▶ ● ■■■■								
	▶ ○ ■								
	▶ ○ ■■■■								
Kunststoffe plastics	▶ ● ■								
	▶ ● ■■■■								
	▶ ○ ■								
	▶ ○ ■■■■								



