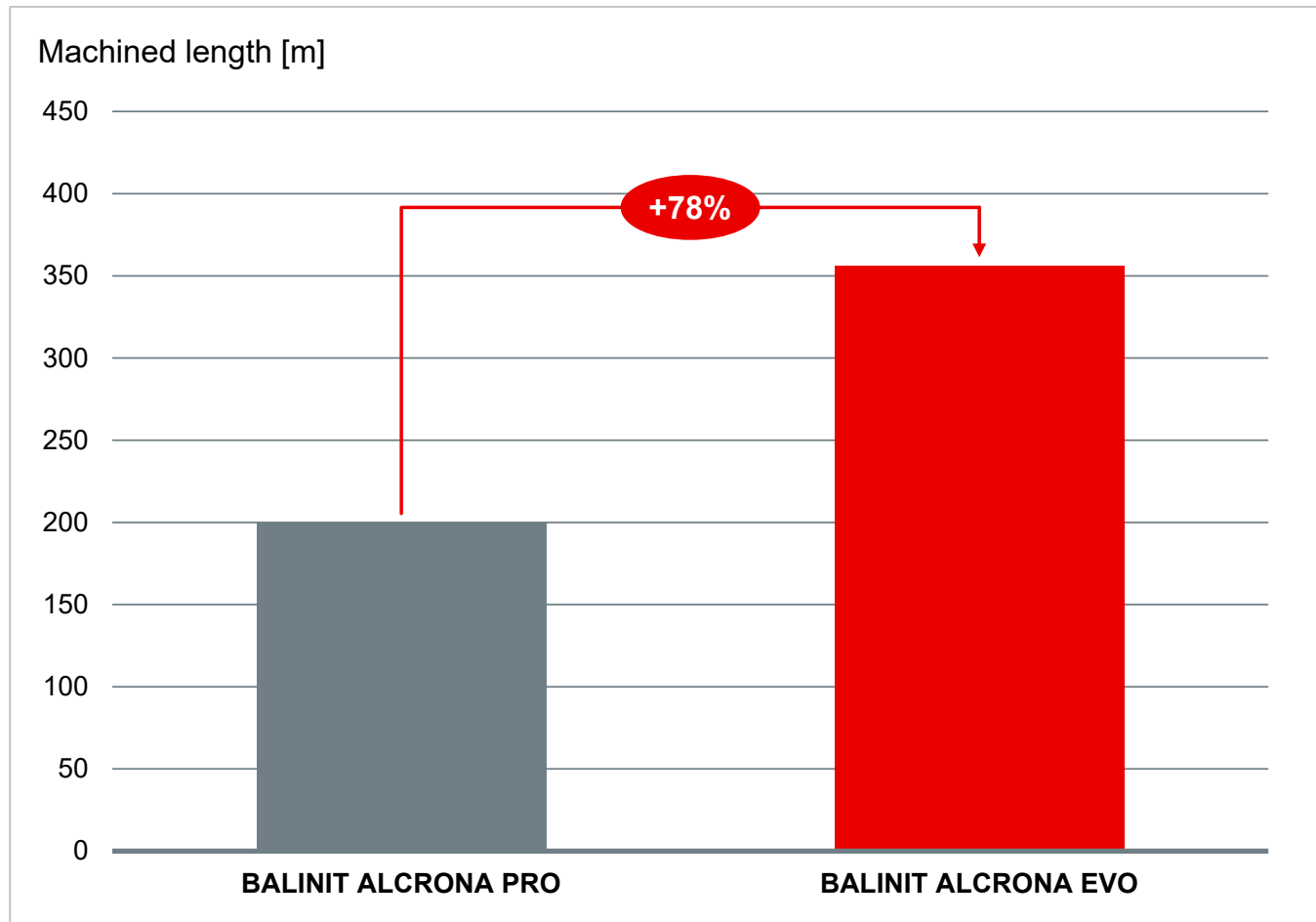


BALINIT ALCRONA EVO

Milling – Wet finishing in 45 HRC material

oerlikon



Tool:

Carbide P15
4 teeth
D = 10 mm

Workpiece:

X40CrMoV5-1 /
1.2344 (45 HRC)

Cutting data:

Wet machining
 $v_c = 220$ m/min
 $f_z = 0.1$ mm
 $a_p = 10$ mm
 $a_e = 0.5$ mm
 $VB_{max} = 0.1$ mm

Source:

Oerlikon Balzers cutting lab