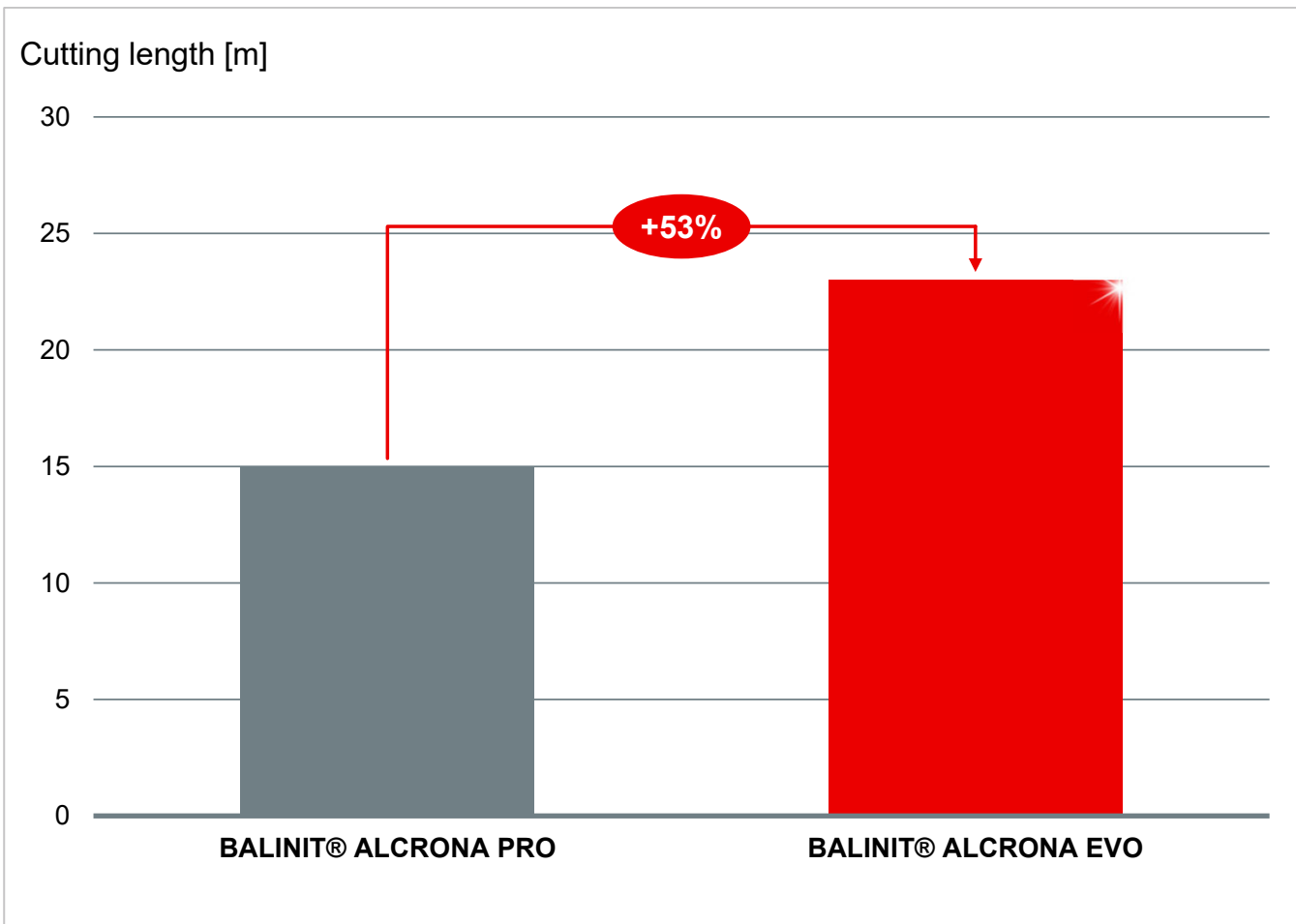


BALINIT ALCRONA EVO

Wet roughing in stainless steel 1.4301

oerlikon



Tool:

Carbide endmill
4 teeth
D = 10 mm

Workpiece:

X5CrNi18-10
1.4301
 $R_m = 600 \text{ N/mm}^2$

Cutting data:

Wet machining
 $v_c = 90 \text{ m/min}$
 $f_z = 0.16 \text{ mm}$
 $a_p = 10 \text{ mm}$
 $a_e = 10 \text{ mm}$
 $VB_{max} = 0.2 \text{ mm}$

Source/Customer:

Customer in Germany