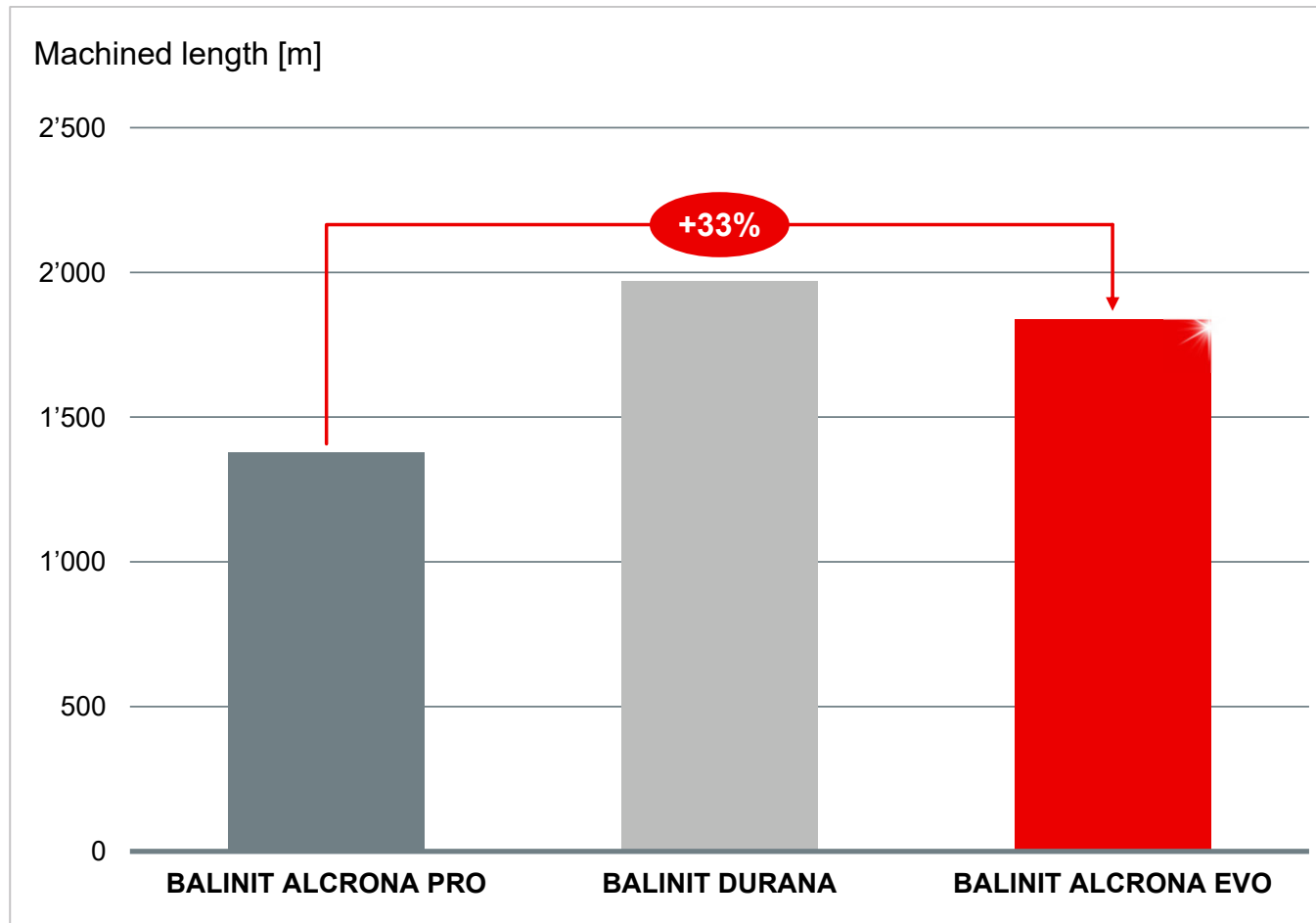


BALINIT ALCRONA EVO

Milling – Dry finishing in 52 HRC material

oerlikon



Tool:

Carbide ball nose endmill
D = 10mm

Workpiece:

X153CrMoV12
1.2379 52 HRC

Cutting data:

Wet machining
 $v_c = 320$ m/min
 $f_z = 0.12$ mm
 $a_p = 0.3$ mm
 $a_e = 0.3$ mm
 $VB_{max} = 0.13$ mm

Source:

Oerlikon Balzers cutting lab