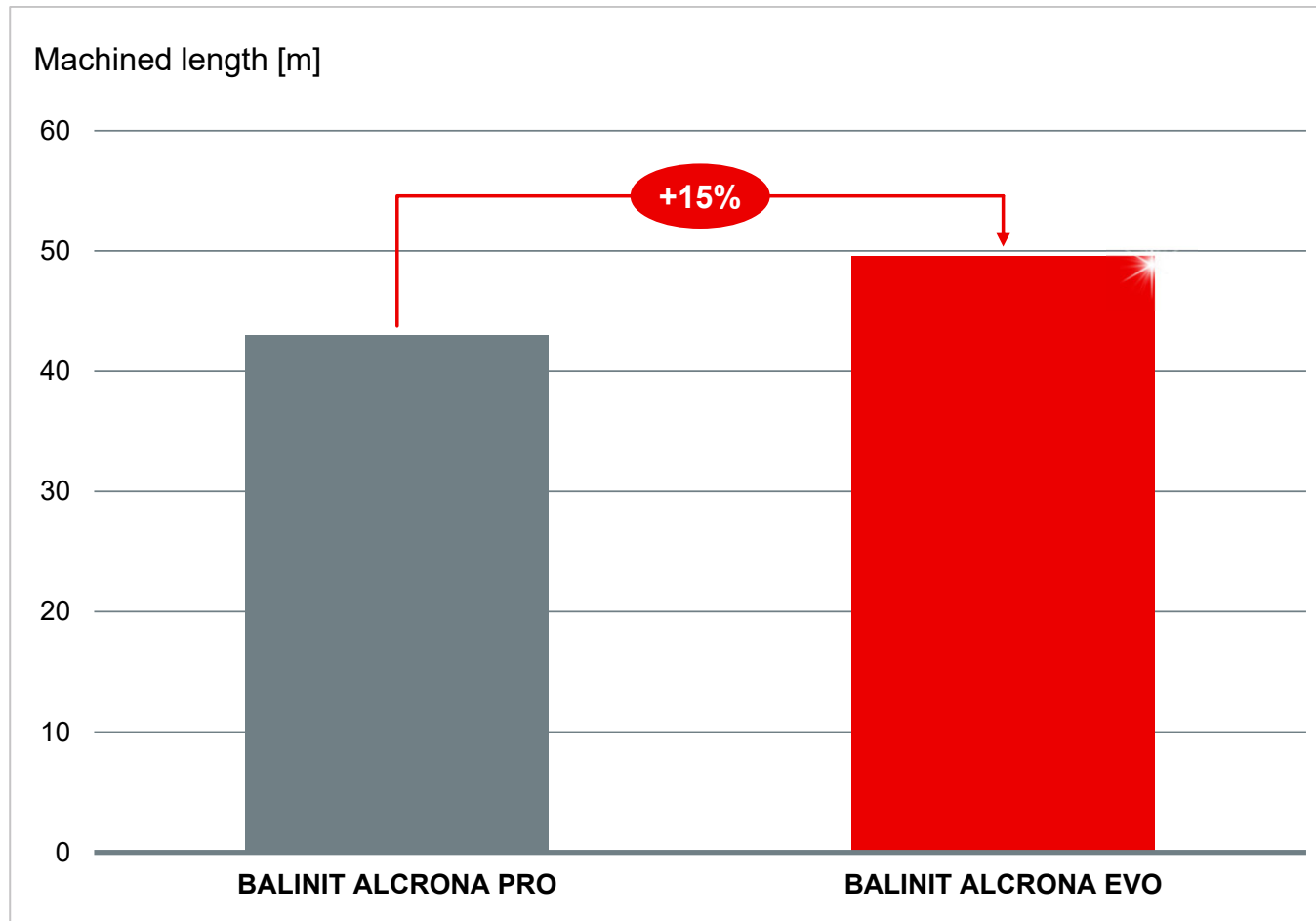


BALINIT ALCRONA EVO

Milling – Wet roughing of stainless steel

oerlikon



Tool:

Carbide P15
4 teeth
D = 10 mm

Workpiece:

X6CrNiMoTi17-12-2
1.4571

Cutting data:

Wet machining
 $v_c = 110$ m/min
 $f_z = 0.04$ mm
 $a_p = 8$ mm
 $a_e = 4$ mm
 $VB_{max} = 0.1$ mm

Source:

Oerlikon Balzers cutting lab