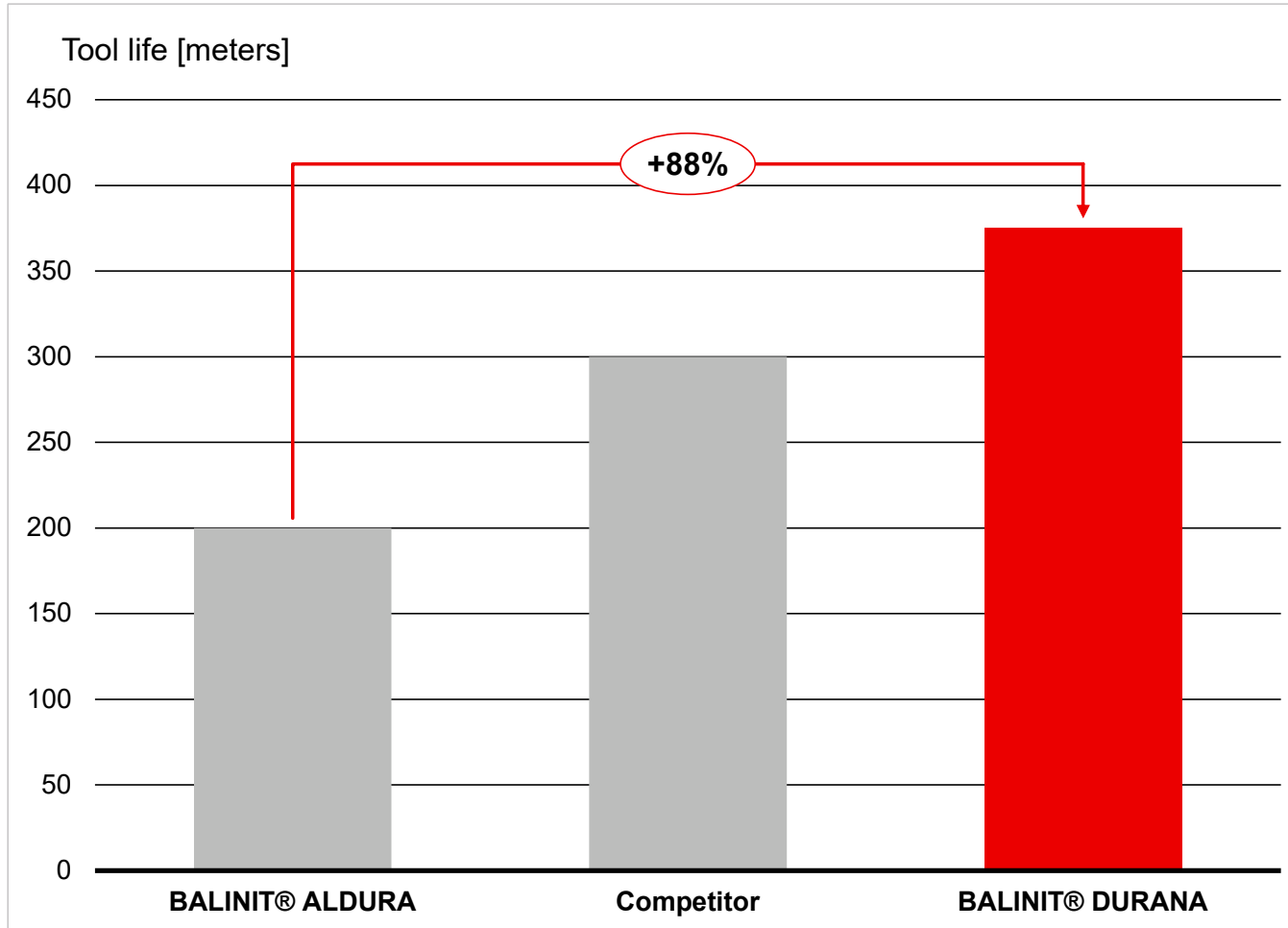


BALINIT DURANA

Milling of tool steel 62 HRC (1.2379)

oerlikon
balzers



Tool

Endmill Ø 12.0 mm

Workpiece

Steel 1.2379, X155CrVMo121
(AISI D2, JIS SKD11)
62 HRC

Cutting parameters

$v_c = 150$ m/min
 $f_z = 0.12$ mm/tooth
 $a_p = 0.24$ mm
 $a_e = 0.30$ mm
Dry

Benefit

Increased tool life

Source/Customer

Oerlikon Balzers
Cutting Laboratory

