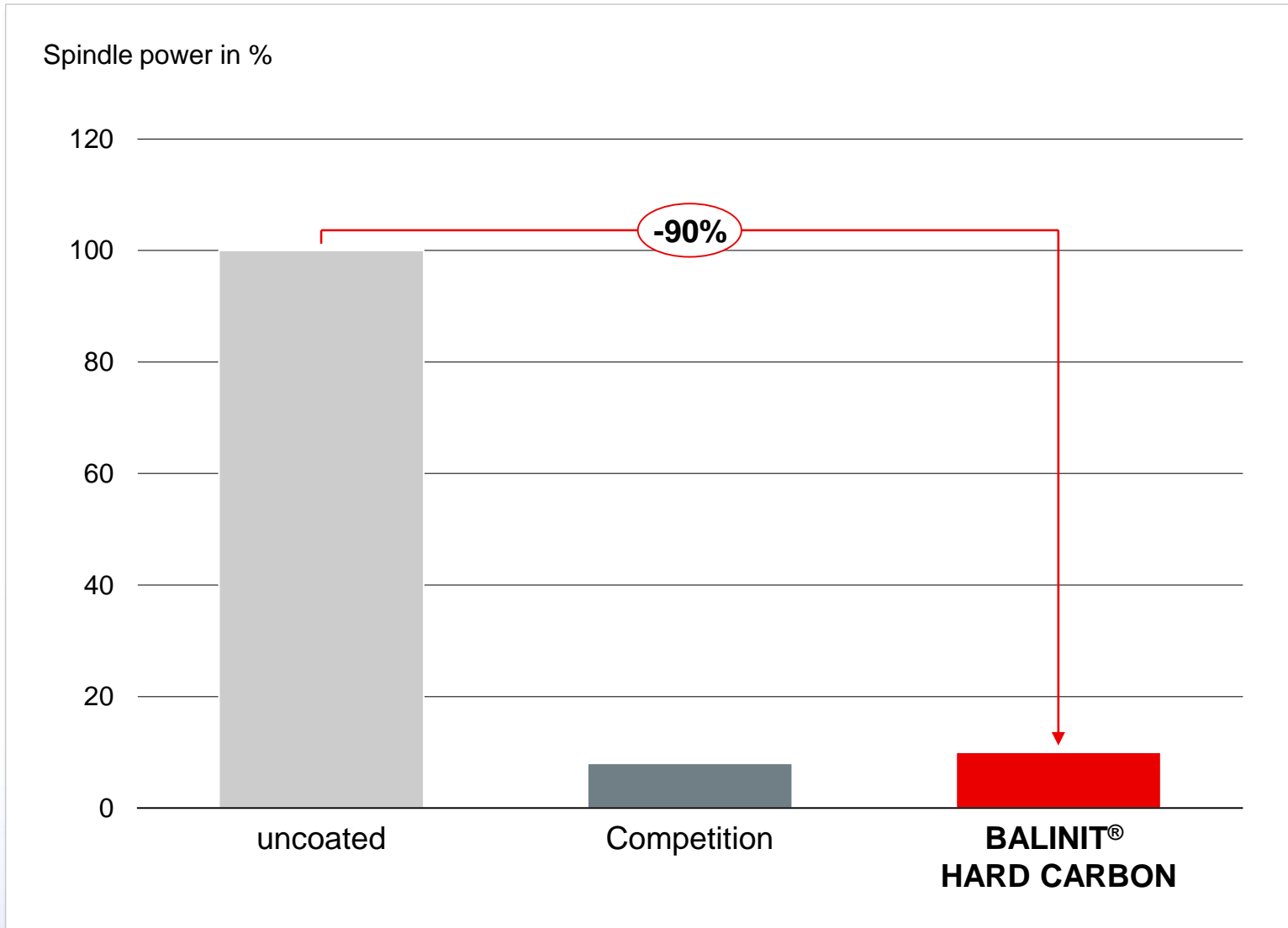


# BALINIT HARD CARBON

## Dry machining of aluminum during a aluminum slotting test



### Tool:

End mill Ø 12 teeth 3  
Slotting milling

### Workpiece:

Plate 300x300x40mm  
AlSi7Mg (6.5-7.5% Si)

### Cutting data:

Toolholder HydroChuck  
 $v_c = 280\text{m/min}$ ,  $f_t = 0,06\text{mm}$   
 $v_f = 1.337\text{mm/min}$   
 $a_p = 12\text{mm}$ ;  $a_e = 12\text{mm}$

### Benefit:

Improved surface quality  
High reduction of spindle power due to full benefit of decrease of friction

### Source/Customer:

German tool manufacturer