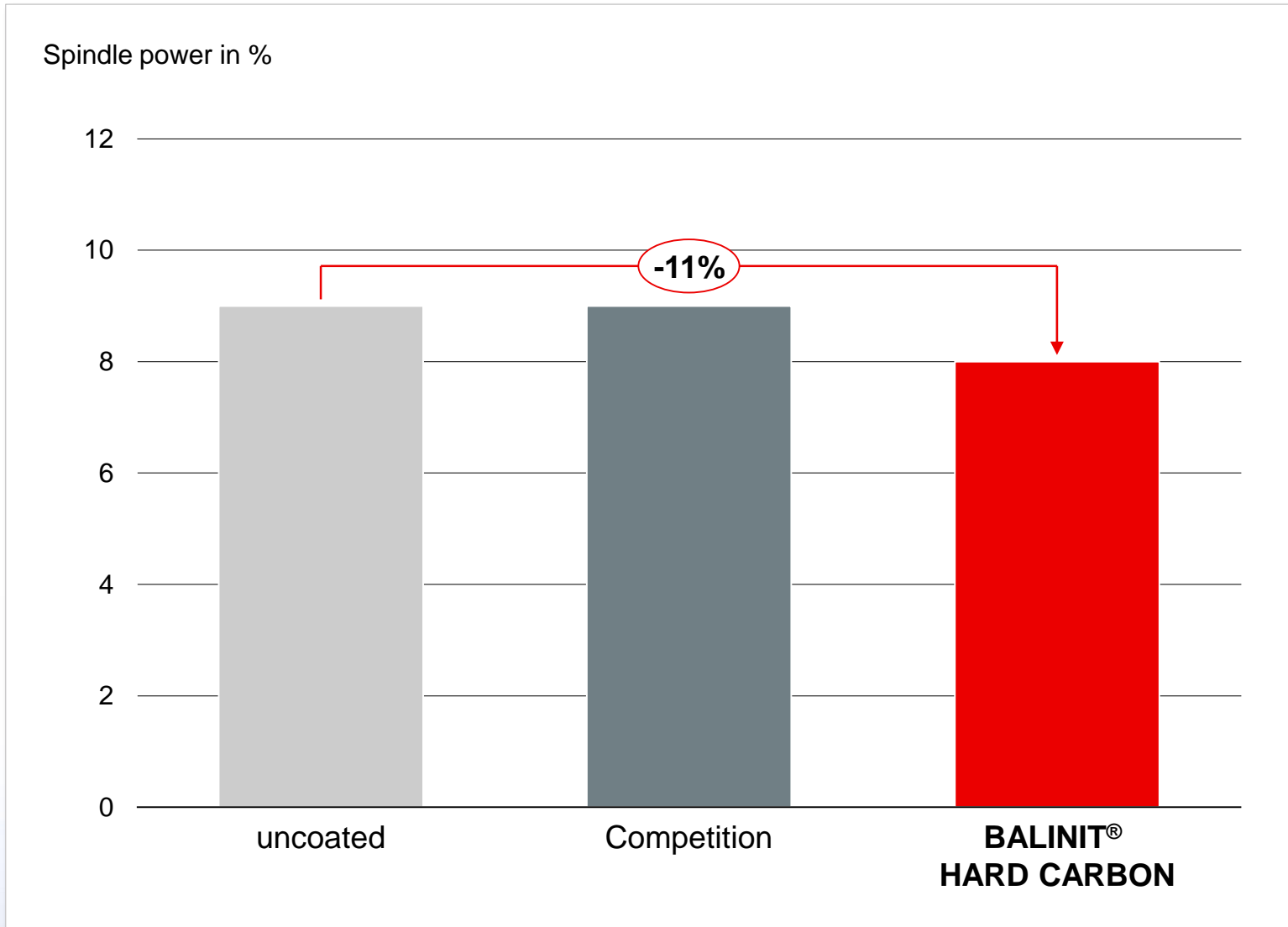


BALINIT HARD CARBON

Wet machining of aluminum during a 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
Slightly reduced spindle power due to
lubricant

Source/Customer:

German tool manufacturer