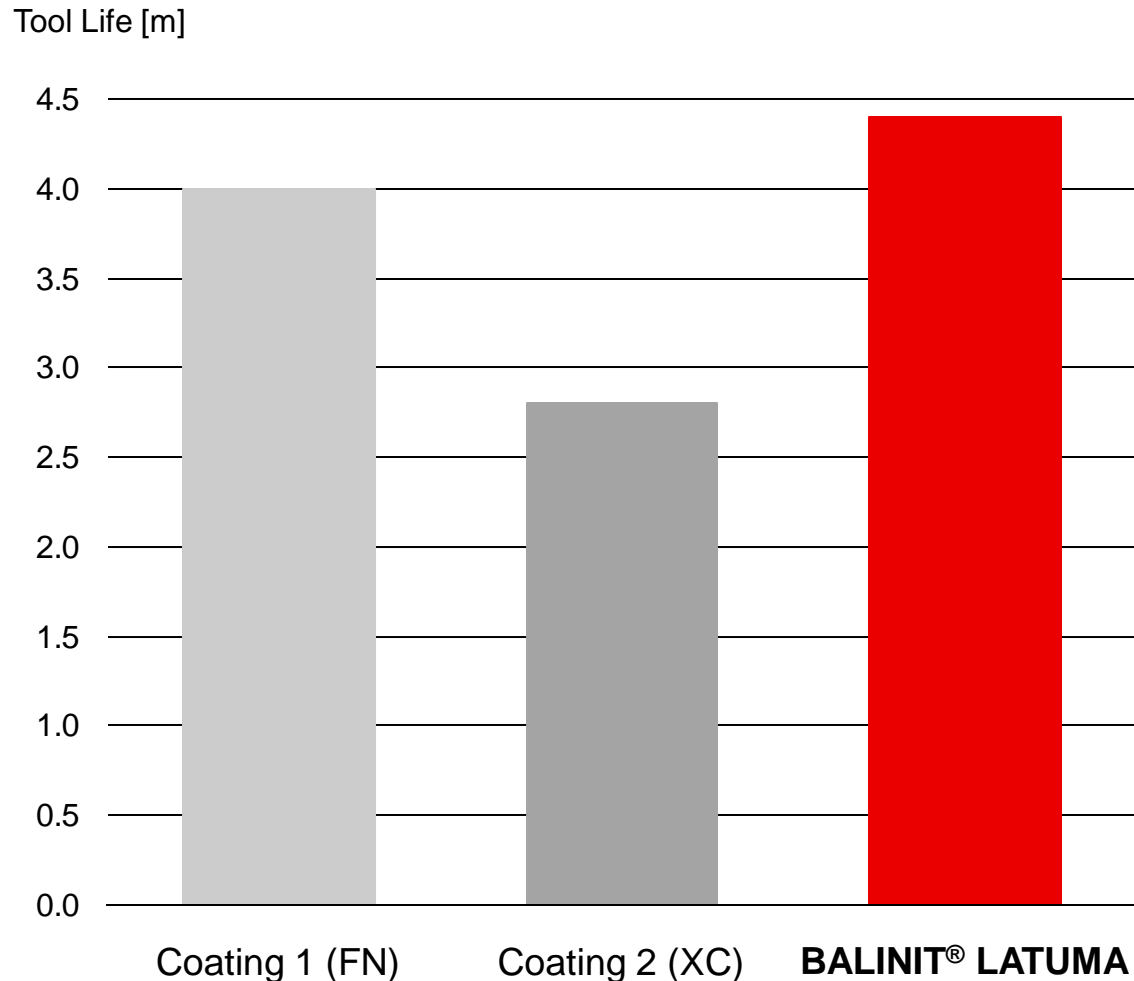


Carbide inserts: Face milling of steel



Tool

Carbide insert, ADMT

Workpiece

Steel 1.7225 (AISI 4140,
SCM440)
900 N/mm²

Cutting parameters

$v_c = 185$ m/min
 $f_t = 0.2$ mm/rev
 $a_p = 3$ mm
 $a_e = 70\%$
VB = 0.15 mm
dry

Source

Oerlikon Balzers
Cutting Laboratory