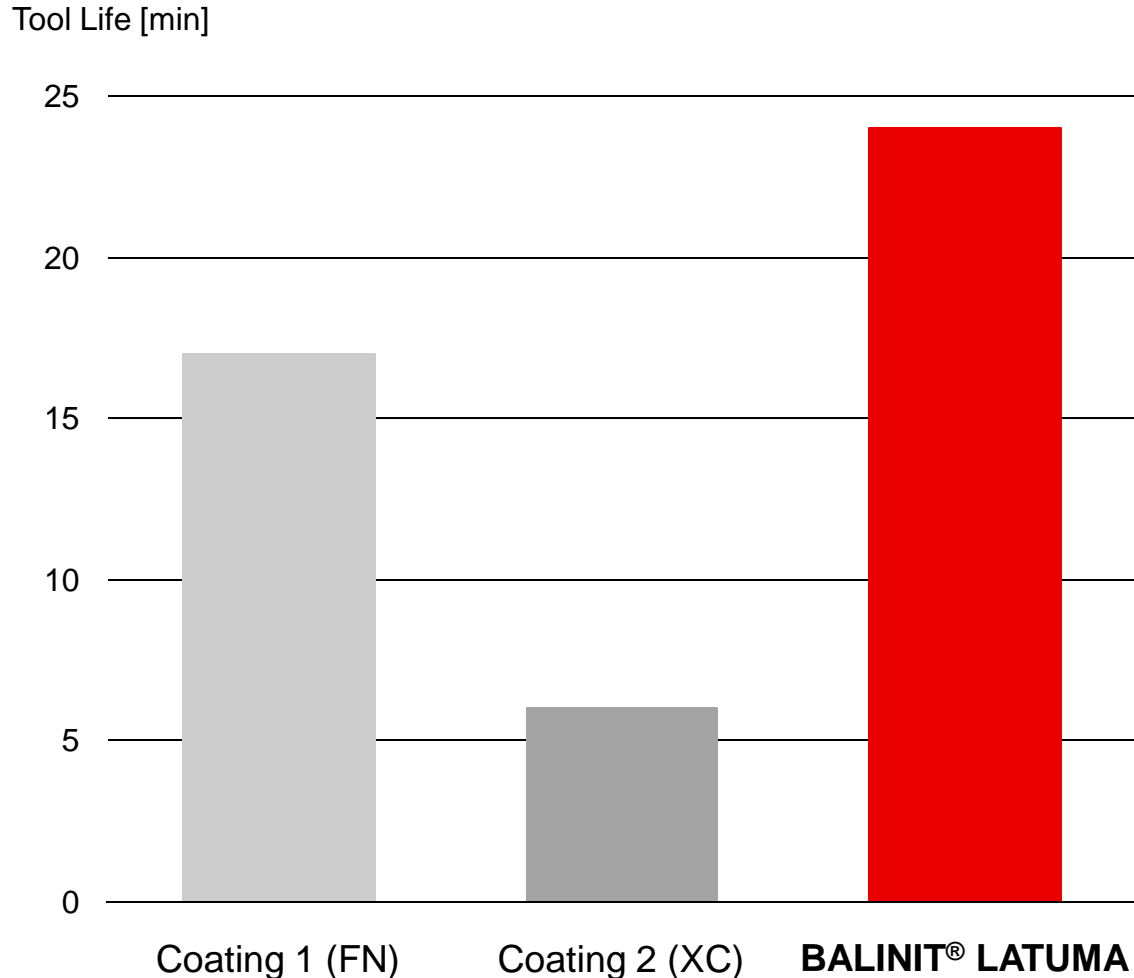


Carbide inserts: Wet turning of stainless steel



Tool

Carbide insert, CNMG432

Workpiece

Steel 1.4571 (AISI 316Ti,
SUS316Ti)

Cutting parameters

$v_c = 180$ m/min
 $f_t = 0.25$ mm/rev
 $a_p = 2$ mm
VB = 0.25 mm
wet

Source

Oerlikon Balzers
Cutting Laboratory