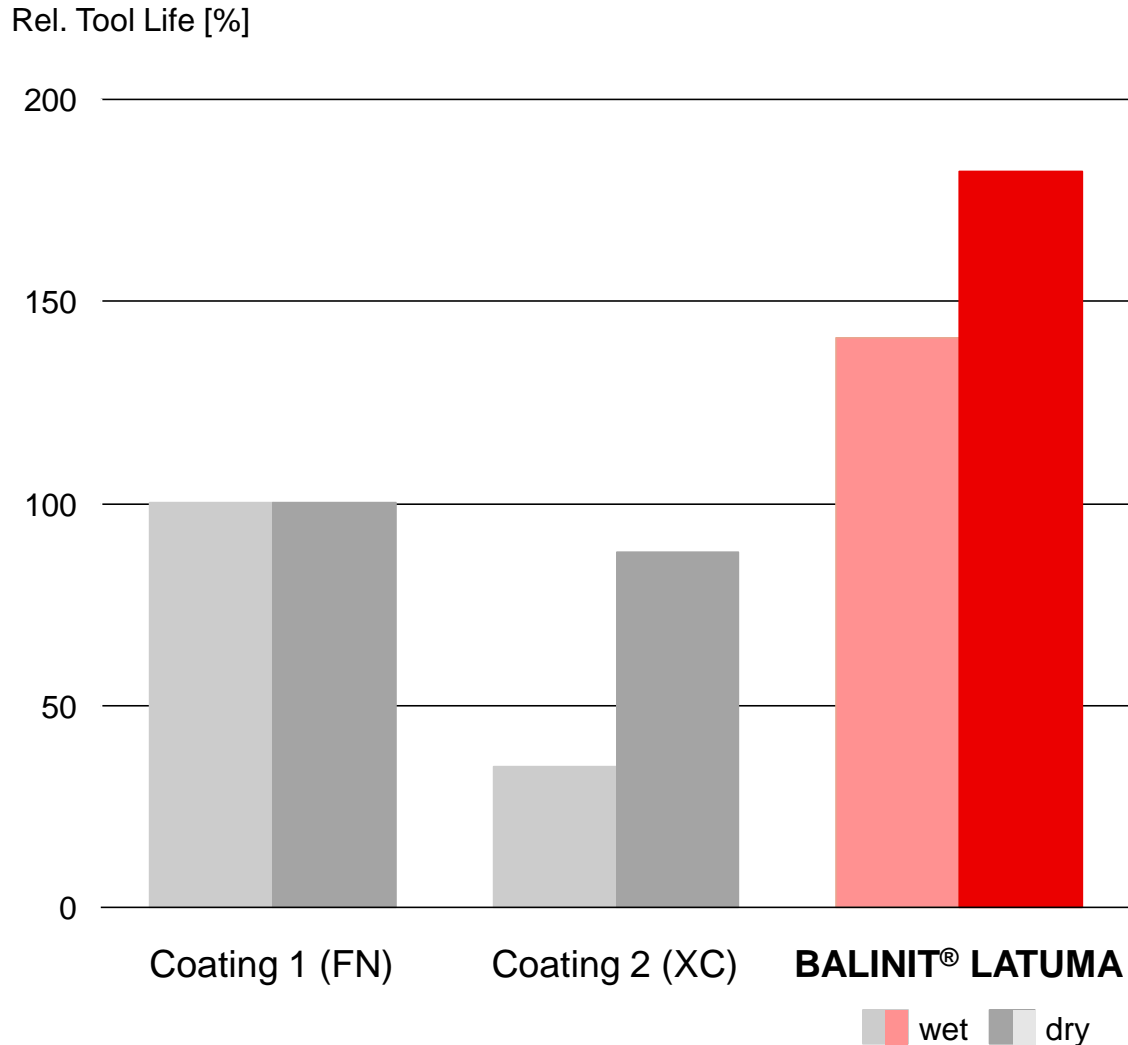


Carbide inserts: turning of stainless steel BALINIT® LATUMA outstanding in wet & dry



Tool

Carbide insert, CNMG432

Workpiece

Steel 1.4571 (AISI 316Ti,
SUS316Ti)

Cutting parameters

Wet:

$v_c = 180$ m/min

$f_t = 0.25$ mm/rev

$a_p = 2$ mm

VB = 0.25 mm

Dry:

$v_c = 120$ m/min

$f_t = 0.25$ mm/rev

$a_p = 2$ mm

VB = 0.30 mm

Source

Oerlikon Balzers
Cutting Laboratory