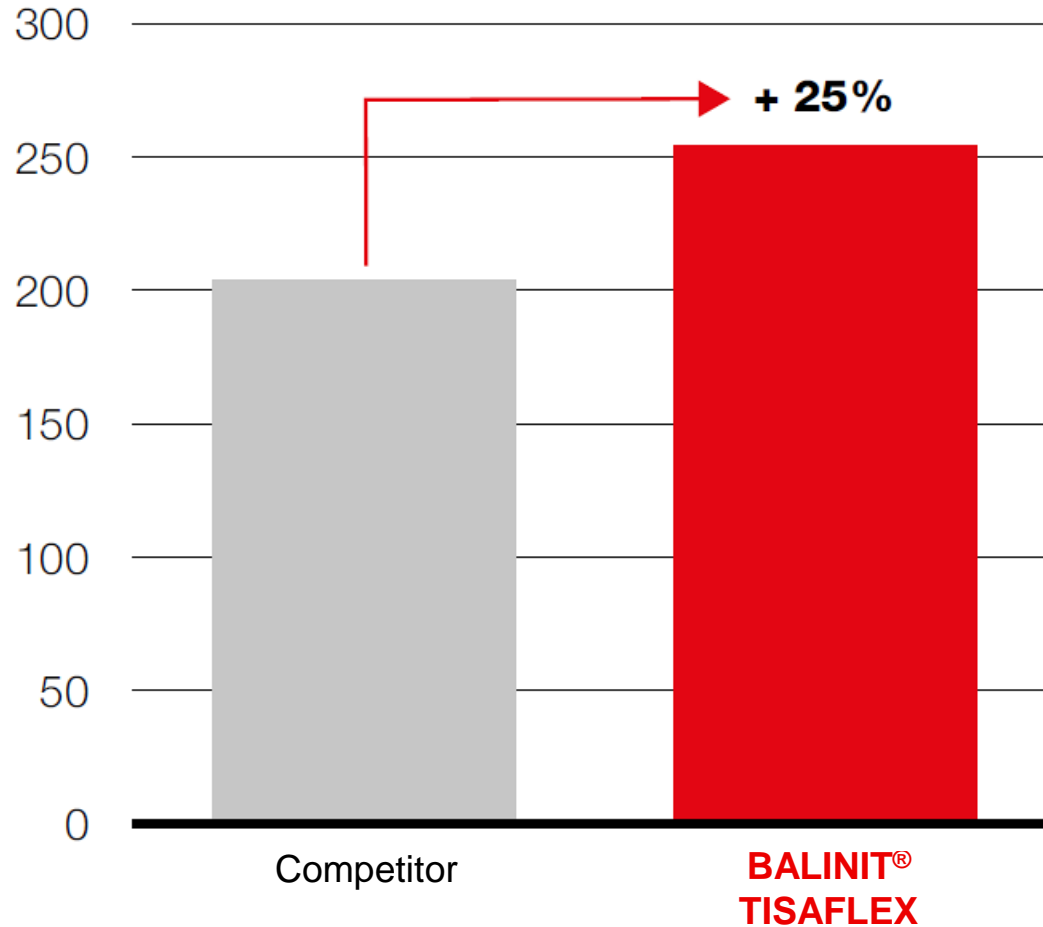


# BALINIT TISAFLEX

## Milling hardened steel

Tool life [number of parts]



### Tool

End mill Ø 10 mm

### Workpiece

Steel 1.2344, X40CrMoV5-1  
(AISI H13, JIS SKD61)  
45 HRC

### Cutting parameters

$v_c = 220$  m/min  
 $f_t = 0.10$  mm/tooth  
 $a_p = 10.0$  mm  
 $a_e = 0.5$  mm  
Wet

### Source/Customer

Oerlikon Balzers cutting  
laboratory