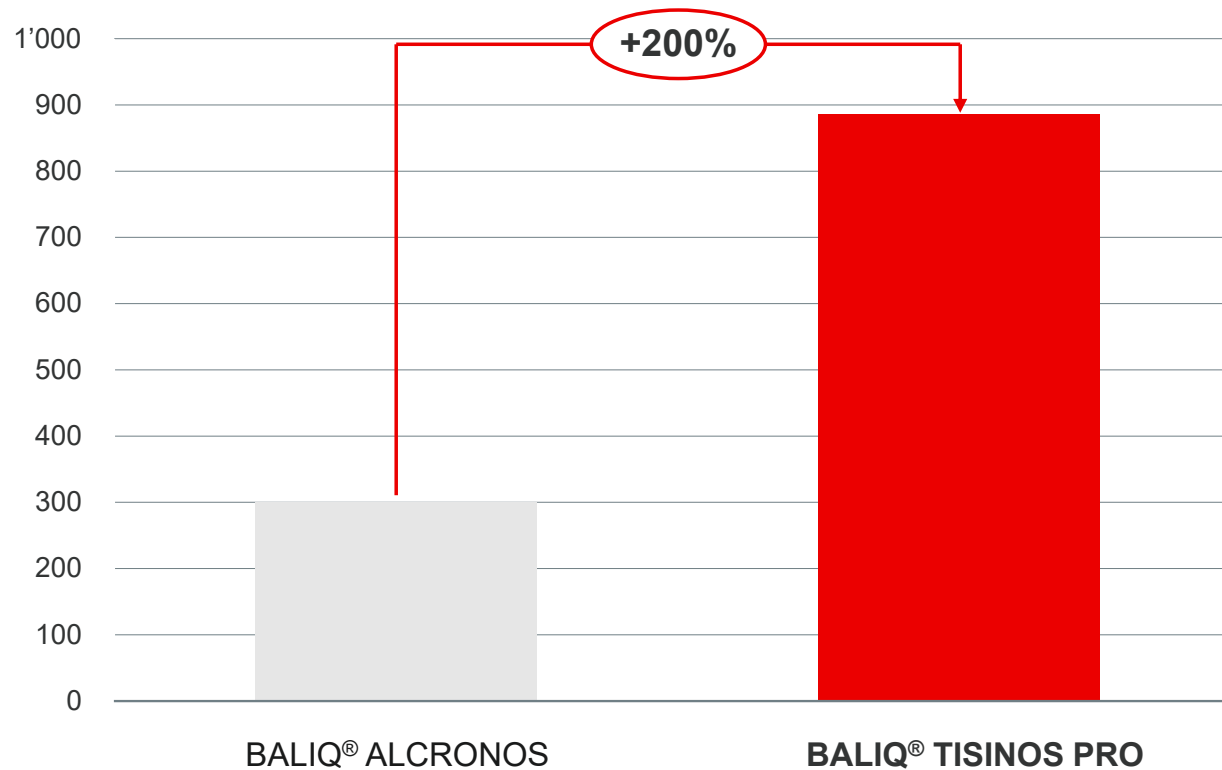


BALIQ TISINOS PRO

Milling martensitic stainless steel 44 HRC (1.4540)

oerlikon

Tool life [parts]



Tool

Square endmill Ø ½" (12.7 mm)

Workpiece

Martensitic Stainless 1.4540,
X4CrNiCuNb164 (15-5 PH, UNS
S15500)
44 HRC

Cutting parameters

$v_c = 160$ m/min
 $f_z = 0.023$ mm/tooth
 $a_p = 19$ mm
 $a_e = 0.76$ mm
Contouring
Wet

Benefit

Increased tool life

Source/Customer

Tool manufacturer