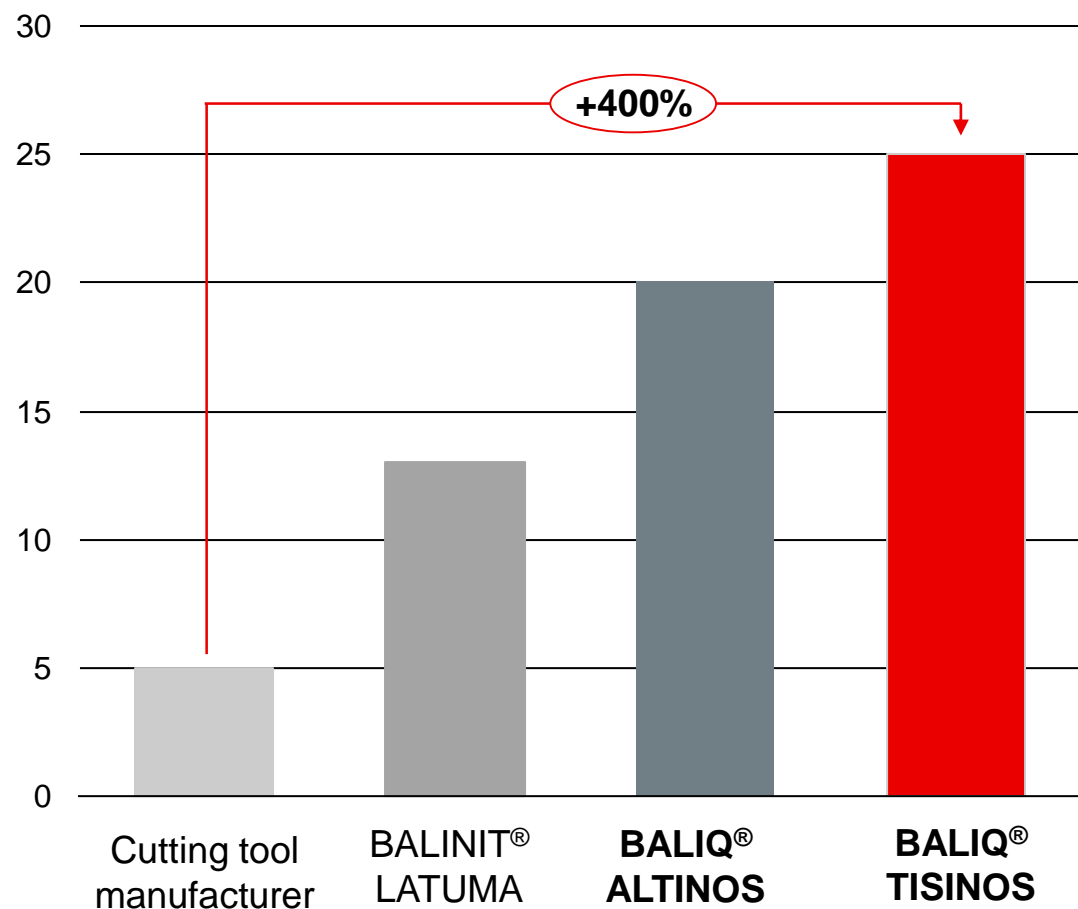


# BALIQ TISINOS

## Milling titanium alloy

Tool life [number of pass]



### Tool:

Carbide insert RPHT

### Workpiece:

Titanium 3.7165, TiAl6V4  
(AISI TAP6400H, SUS  
R56400)

### Cutting data:

$v_c = 50$  m/min  
 $f_z = 0.3$  mm / tooth  
 $a_p = 2.0$  mm,  $a_e = 37$  mm  
wet

### Benefit:

+ 400% in tool life

### Source/Customer:

Japanese tool manufacturer /  
Oerlikon Balzers