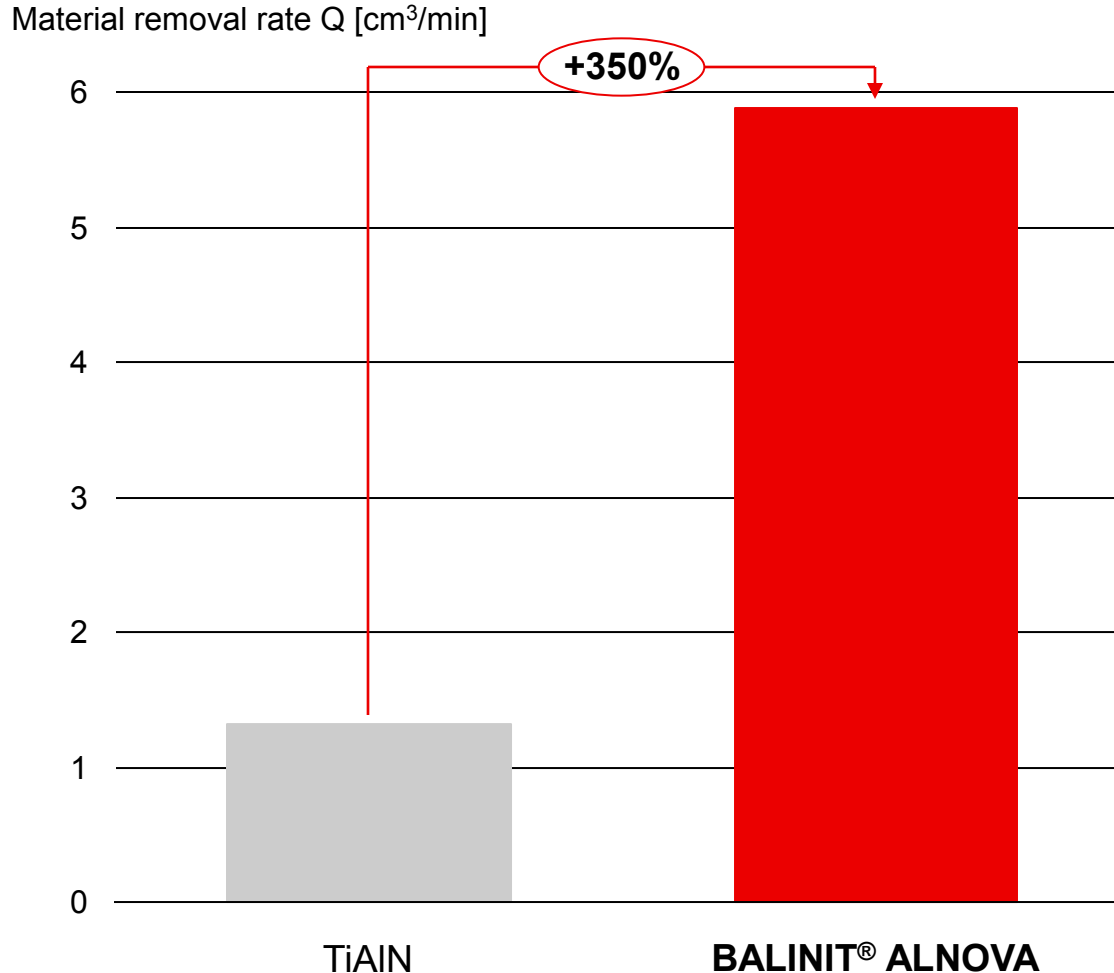


# Increase of material removal rate when milling stainless steel



## Tool

Carbide endmill Z4

## Workpiece

Stainless steel > 700 N/mm<sup>2</sup>  
1.4571 (SUS 316Ti, AISI 316Ti)

## Cutting parameters

Coating 1 (TiAlN):

$v_c = 65$  m/min

$f_t = 0,03$  mm

Coating 2 (BALINIT® ALNOVA):

$v_c = 120$  m/min

$f_t = 0,07$  mm

$a_p = 8$  mm;  $a_e = 0,8$  mm  
wet

## Source

Tool manufacturer Germany