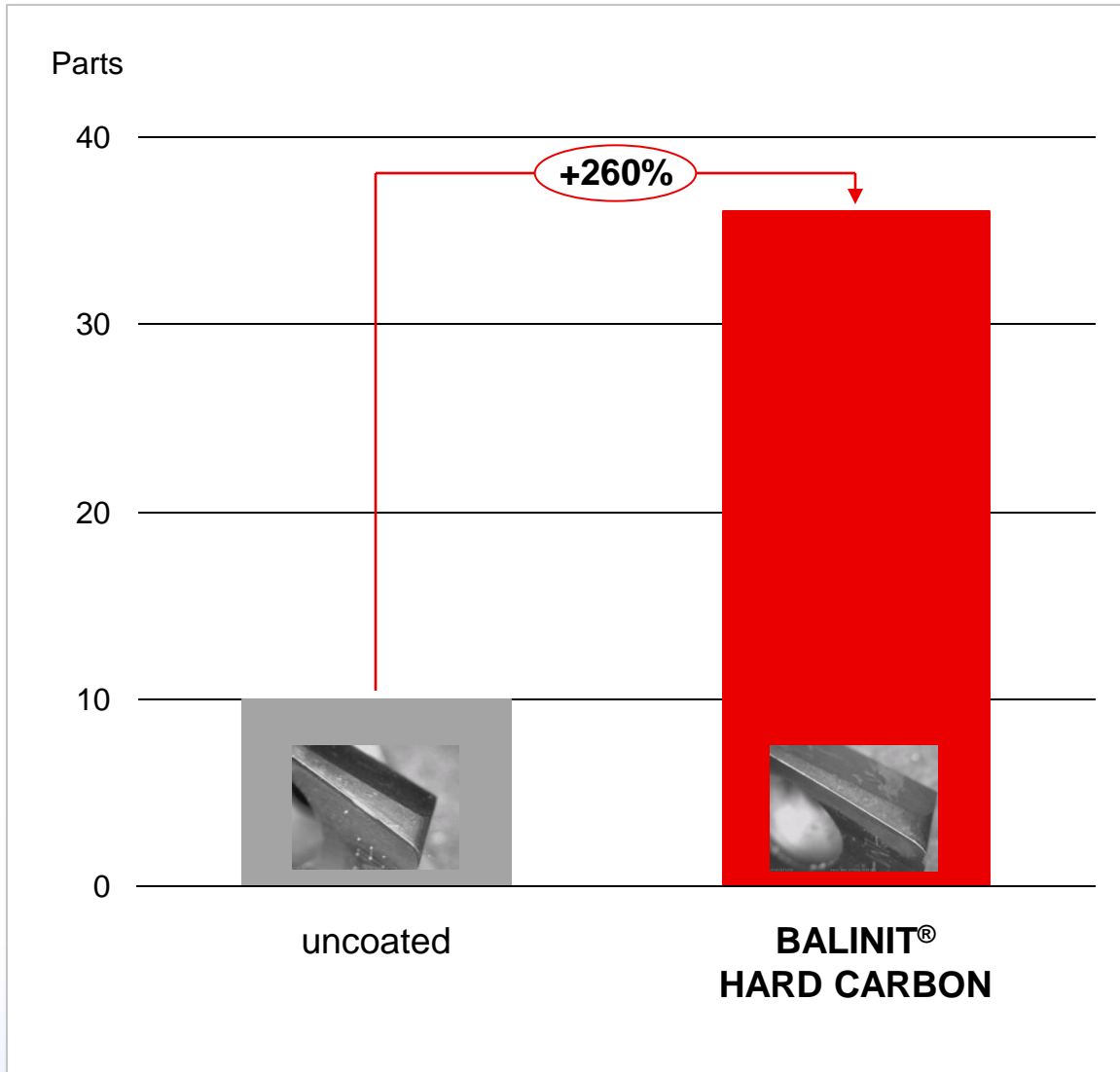


# CC insert coated with BALINIT HARD CARBON, angle milling 90°

**oerlikon**  
balzers



## Tool

Insert CC / AOFT15-531  
Ø40AO15 1311.0460  
 $a_p = 10\text{mm}$ ,  $a_e = 10\text{mm}$

## Workpiece

Alu cast iron 12% Si

## Cutting data

Emulsion 8%-10%

$v_c = 1,570\text{m/min}$   
 $n = 12,495\text{ U/Min}$   
 $f_t = 0.2\text{mm}$   
 $hm = 0.096\text{mm}$

## Source

Tool manufacturer  
Switzerland

