Carbide endmill coated with BALINIT HARD CARBON

**Tool**
- Carbide endmill
  - Ø 8mm

**Workpiece**
- Interior high-end car
  - Al-ABS-Pc
  - GF 20 Sandwich

**Cutting data**
- $n = 40,000$ U/min
- $v_f = 2.4$ m/min

**Benefit**
- Significantly reduced tool costs
  - PCD Endmill: ~ 180€
  - HARD CARBON: ~ 23€

**Source**
- Tool Manufacturer
  - Germany

**Tool costs per part**
- PCD: 1.20 €
- BALINIT HARD CARBON: 0.19 €

**Savings**
- 85% savings