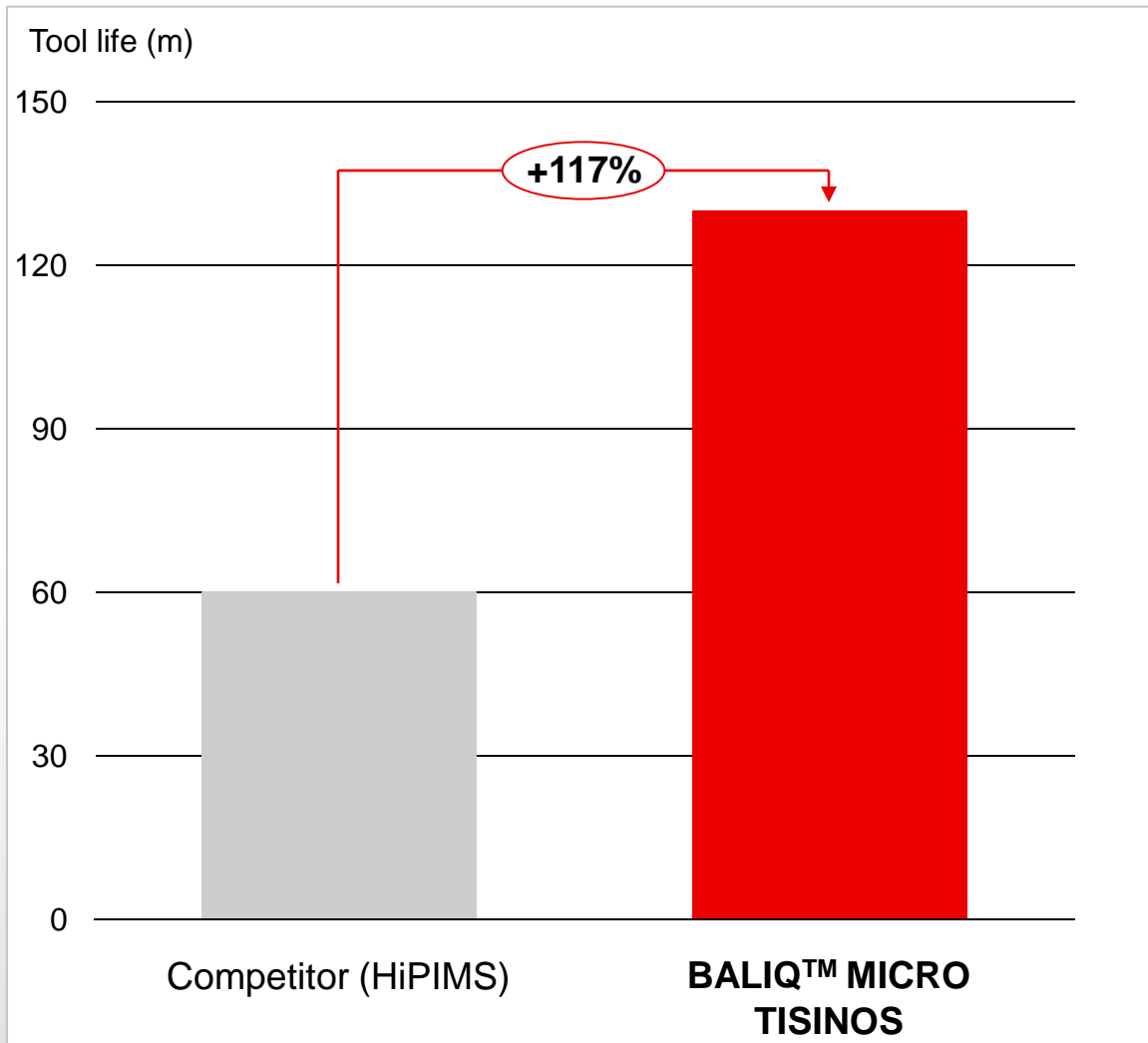


BALIQ MICRO TISINOS for high hardened steels



Tool

Ballnose endmill Ø 2.0 mm

Workpiece

Steel 1.2379 (AISI D2, SKD11),
HRC 62

Cutting parameters

$v_c = 130$ m/min

$f_t = 0.04$ mm

$a_e = 0.1$ mm, $a_p = 0.1$ mm

Dry cutting

Source

Oerlikon Balzers Cutting
Laboratory