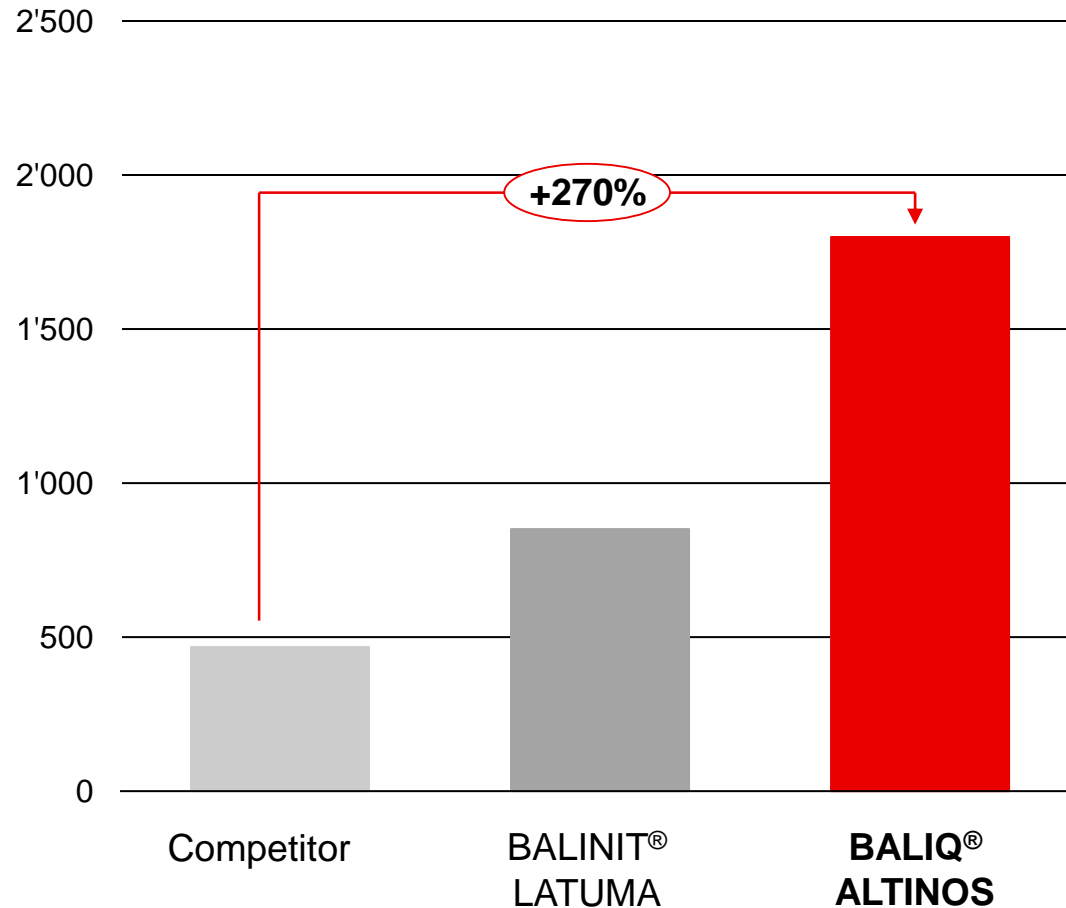


BALIQ ALTINOS

Steel grooving

Tool life [number of cuts]



Tool

Carbide insert (grooving)

Workpiece

Steel 1.7225, 42CrMo4
(AISI 1040, SCM 440)

Cutting parameters

$v_c = 220$ m/min
 $a_e = 2$ mm
 $a_p = 4$ mm
wet

Source

Oerlikon Balzers
Cutting laboratory