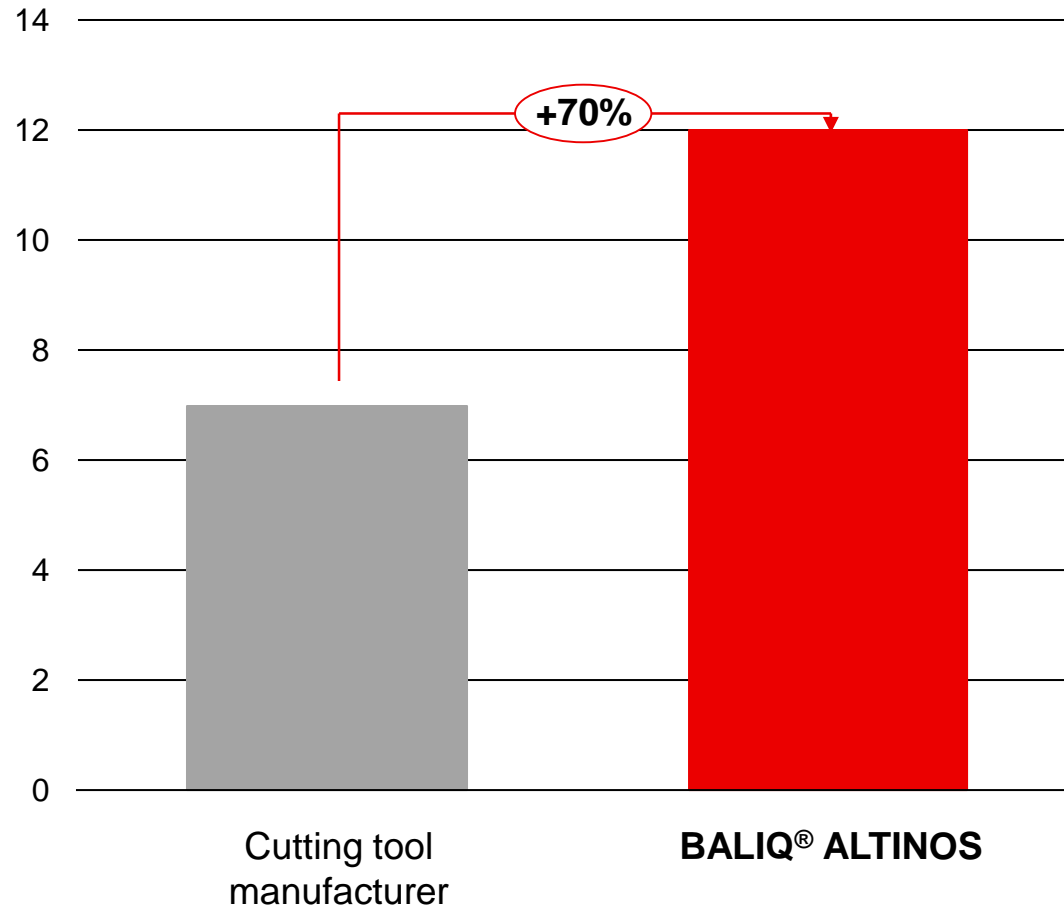


BALIQ ALTINOS

Steel turning with CBN inserts

Tool life [minutes]



Tool:

PCBN insert (CNMA 120408)

Workpiece:

Steel 1.7262, 15CrMo5
(SCM 415)
60~63 HRC

Cutting data:

$v_c = 220\text{m/min}$
 $f = 0.15\text{mm}$
 $a_e = 0.10\text{mm}$
wet
Interrupted cutting

Benefit:

+70% tool life

Source/Customer:

Tool manufacturer