



Cutting Test

Nr. 08w/01 del 30/04/2008



The Test

The end user produces glass and crystal's moulds in the material AISI431 steel, with maximum hardness of 30 HRC.

The test is a finishing operation on a clad part which was covered with STELLITE, using a HM08W \varnothing mm 12 coated in Balinit X.Ceed.

The Parameters

Code: **HMC08w12**

Material: STELLITE

Refrigerant: DRY

$a_p = 0,2$ mm

$a_e = 3,0$ mm

$V_c = 105$ m/min

$n = 2800$ rpm

$f_z = 0,45$ mm/z

$F = 5000$ mm/min

The final outcome

The cutter has worked perfectly. The client has been very satisfied as he could increase the feed from 3000mm/min with an indexable inserts end mill to 5000mm/min with the carbide SILMAX cutter.

