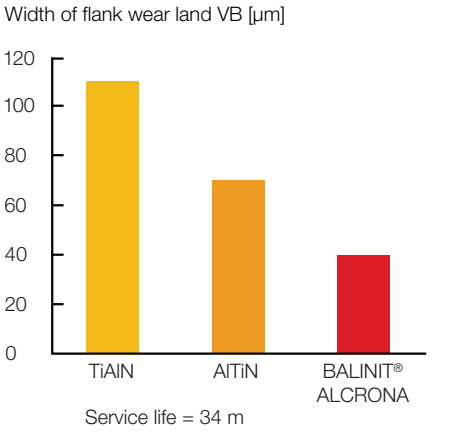
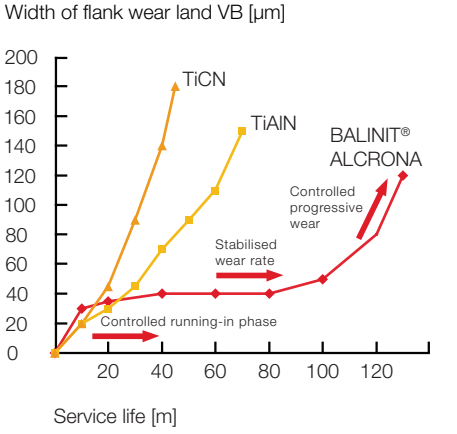
BALINIT® ALCRONA establishes a new benchmark in milling

Roughing



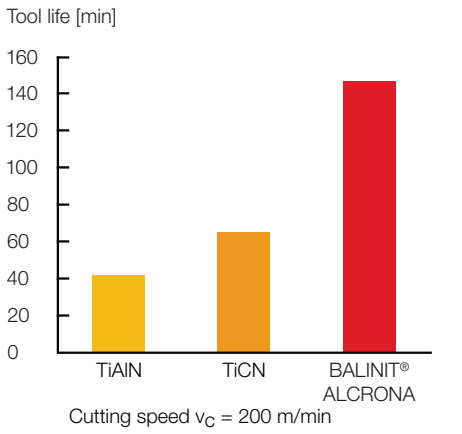
Tool:	Carbide end mill, D = 10 mm
Workpiece:	Steel 52 HRC
Machining mode:	Dry
Source:	Oerlikon Balzers Coating cutting laboratory

Finishing



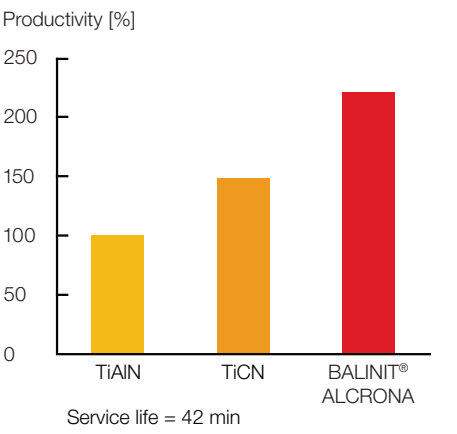
Tool:	Carbide end mill, D = 8 mm
Workpiece:	Steel DIN 1.1191 (~AISI 1045)
Cutting speed:	v_c = 400 m/min
	Cooled
Source:	Oerlikon Balzers Coating cutting laboratory

Finishing



Tool:	Carbide end mill, D = 8 mm
Workpiece:	Steel DIN 1.1191 (~AISI 1045)
Cutting parameters:	f_t = 0.1 mm
	a_e = 0.5 mm
	a_p = 10 mm
	Climb milling
	Emulsion 5%
	VB_{max} = 0.12 mm
Source:	Oerlikon Balzers Coating cutting laboratory

Finishing



Tool:	Carbide end mill, D = 8 mm
Workpiece:	Steel DIN 1.1191 (~AISI 1045)
Cutting parameters:	f_t = 0.1 mm
	a_e = 0.5 mm
	a_p = 10 mm
	Climb milling
	Emulsion 5%
	VB_{max} = 0.12 mm
Source:	Oerlikon Balzers Coating cutting laboratory