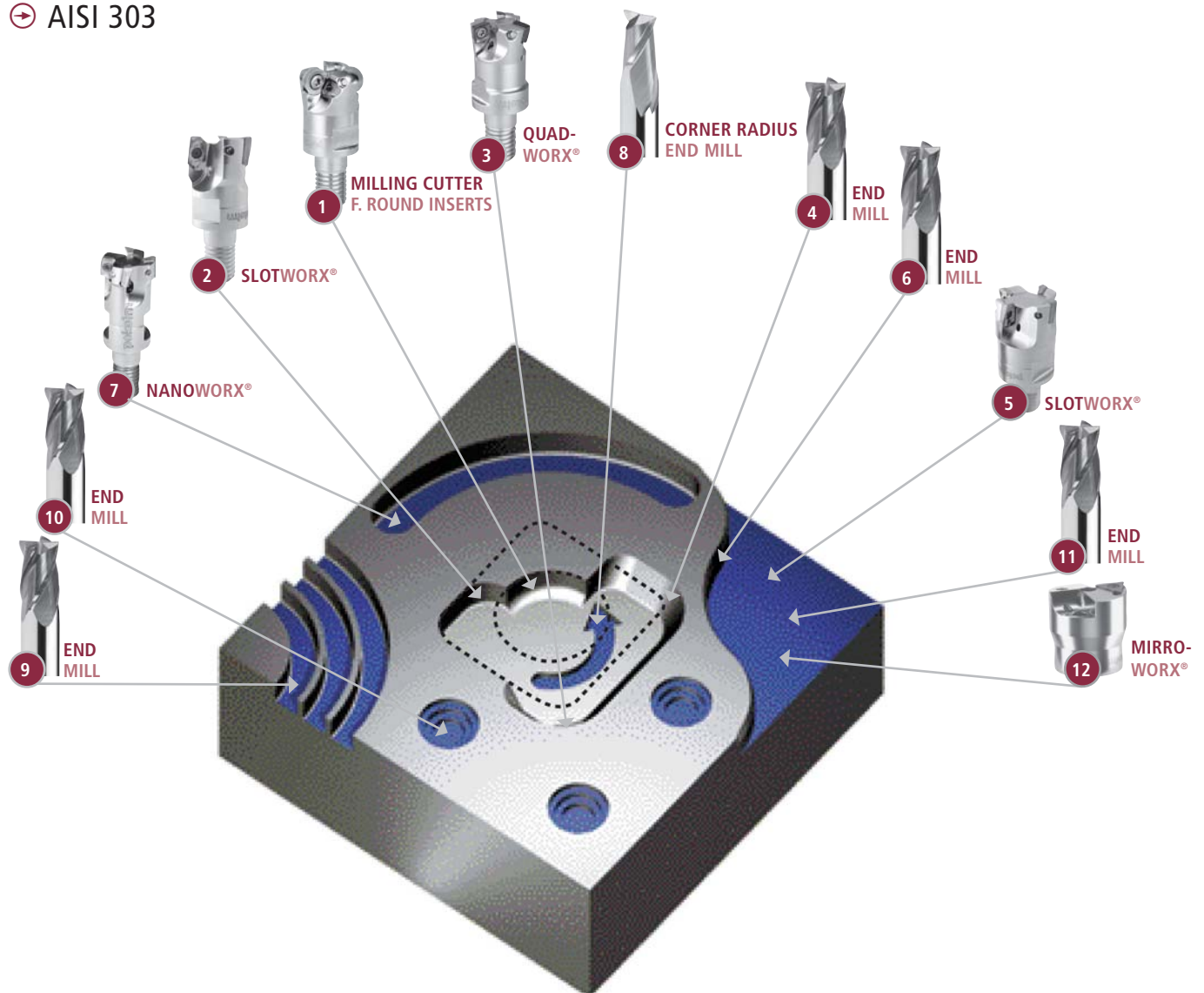


MACHINING STAINLESS STEELS: 1.4305

Milling a 2.5 x D model

Material

- ➔ 1.4305
- ➔ DIN X8CrNiS18-9
- ➔ AISI 303



➔ Operation data: see reverse page

MACHINING STAINLESS STEELS: 1.4305

Technical data

P-FRB-E-1107

	Step 1	Step 2	Step 3	Step 4	Step 5	Step 6
Strategy	Helix milling	Roughing pocket	Plunging	Finishing 5 axis	Roughing	Chamfering 5 axis
Milling cutter typ	Milling cutter for round inserts	Slotworx®	Quadworx® S	Solid carbide end mill	Slotworx®	Solid carbide end mill
Article number	3 25 200/7	3 25 267	3 20 247	0504 56 100	4 32 267	0504 56 100
inserts	02 10 897	04 67 896	02 47 896	—	04 67 896	—
Diameter d1	25	25	20	10	32	10
Number of teeth	3	3	3	4	4	4
Radius	5	1	Rp 1,3	0	1	0
V _c m/min	196	196	145	98	180	98
n 1/min	2.500	2.500	2.300	3.120	1.800	3.120
f _z mm	0,35	0,2	0,5	0,065	0,25	0,065
V _f mm/min	2.600	1.500	3.400	820	1.800	820
a _p mm	0,3	1	9	15	1	6
a _e mm	24	12,5 - 21	0,8	0,5	19,2	0,5
Time min	02:00	02:27	02:35	00:20	03:35	00:25

	Step 7	Step 8	Step 9	Step 10	Step 11	Step 12
Strategy	Roughing pocket	Engraving	Roughing slot bend	Vertical step milling	Trim by surface milling	Finishing parallel
Milling cutter typ	Nanoworx®	Solid carbide Corner radius end mill	Solid carbide End mill	Solid carbide End mill	Solid carbide End mill	Mirrorworx®
Article number	4 16 256	0462 43 015	0504 56 120	0504 56 080	0504 56 120	2 42 384
inserts	02 71 840 R08	—	—	—	—	04 84 835
Diameter d1	16	1,5	12	8	12	42
Number of teeth	4	2	4	4	4	2
Radius	0,8	0,2	0	0	0	0
V _c m/min	120	60	120	80	180	120
n 1/min	2.400	12.700	3.180	3.180	4.780	900
f _z mm	0,15	0,02	0,08	0,08	0,22	0,55
V _f mm/min	1.425	500	1.000	1.000	4.200	1.000
a _p mm	0,6	0,05	6	1	15	0,05
a _e mm	15	0,75	12	8	1	25,2
Time min	04:34	06:13	01:15	04:15	09:48	01:51

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