Of the fabricating characteristics ofstainless steel and millingcutter chooseaa

Which kinds of milling cutter does stainless steel treatment use?This is a problem that when CNC is machined, encounters viaregular meeting. The machinability of austenite stainless steel isonly 0.4, ferrite stainless steel is only 0.48, martensite stainlesssteel is only 0.55.

1, serious treatment is sclerotic

The treatment sclerosis of stainless steel is very serious. The firstkind of choice is the mixture of austenite and ferrite. The 1.4-2.2that sclerotic layer hardness is former matrix times, intensity R=1470-1960MPa. This kind of stainless steel has very bigplasticity and very big coefficient of intensification. In addition,austenite is not stable, easy below the action of cutting forcechange is martensite.

2, cutting muscularity

Stainless steel has very tall plasticity, especially 2.5 times thedeepness of austenite stainless steelis 45# steel. Millingmachine plasticity is out of shape big, cutting resistance is great,treatment is sclerotic and serious, hot intensity is high, not easyand curly and break off.

3, cutting temperature is high

The plasticity of stainless steel is out of shape big, attritionmuscularity, coefficient of thermal conductivity is relativelyinferior. Accordingly, below coequal condition, the temperature ofstainless steel milling machine is 200 degrees or so higher than45 steel.

4, cut is not easy

When processing stainless steel easily agglutinate and form the tumour that accumulate bits. The