







## milling machines black lead electrode, diamond (how should be PCD) cutting tool chosen?aa

The treatment means of the goods such as electrode of blacklead mould, black lead basically is given priority to with turning, milling, bore, and black lead product is simple firm and fragile, if, be in in treatment process cutting tool (PCD cutting tool) the choice is incorrect, produce collapse caustic phenomenon very easily, the author joins real case today, how should the PCD cutting tool that will machine black lead a little choose ~

One, the cutting tool material that processes black lead product chooses character

Cutting tool material is the prime factor that decides function of cutting tool cutting character, to machining efficiency, treatment quality, finished cost and cutting tool durability have very big effect. But because black lead makes character firm and fragile, so cutting tool needs to have tall hardness and tall wearability, enough strength and concussion tenacity, the function such as good machinability, commonly used cutting tool material is at present qualitative main with diamond (PCD) give priority to.

Diamond (PCD) cutting tool has a lot of kinds of structures, belike PCD milling cutter, PCD reamer, PCD broach, PCD lathe tool, cutting tool of CVD diamond coating, but in domain of blacklead goods, basically give priority to with PCD lathe tool and diamond coating milling cutter, at present commonly used PCD lathe tool has CDW302 material to pledge with CDW010 material pledges, treatment efficiency is tall, milling cutter of CVD diamond coating with HPD black lead special milling cutter is given priority to.



Diamond (PCD) cutting tool graphic representation

2, the cutting parameter choice of cutting tool of black lead treatment

Parameter of so called cutting is cutting speed, feed and deepness of penetration of a cutting tool 3

