

WIRBALIT®-ALLOYS

Processing guidelines

	Drill		Rotation		Threading	Saw
Tool	HSS		Hard metal		HSS	HSS*
Clearance angle in °	12 - 15		5 - 10		12 - 30	10 - 15
Rake angle in °			8 - 16			20 - 25
Other angles in °	Spiral angle 30 - 45	Acute angle 100 - 110	Tilt angle -4 bis -8		Broached angle 20 - 40	
Cutting speed in m/min	25 - 75		Preturning 100 - 350	Finishing 150 - 420	15 - 30	80 - 200
Feed in 1/mm	∅ in mm < 10 10 - 25 > 25"	% of ∅ 2 1,5 1	Preturning 0,1 - 0,8	Finishing 0,04 - 0,1		30 - 50 mm/min

* Saw blades must run freely enough laterally

The machining properties of WIRBALIT® alloys are very similar to those of pure copper. The formation of built-up edges can be counteracted by increasing of the cutting speed and by using carbide tools.

As a coolant, the use of mineral oils with a 5-15% addition of fatty oils is recommended.

The shown processing guidelines are for information only.

The optimum values are to be determined by tests.