

Baffles

RPM 1000 RV=216 FV=180 Rough Feed .004 Rough Depth .008

Recommend inserts:

Roughing: MCLNR 2525 M12 ND8

Finishing: MDJNR 2525 M15 NB8

Blow and Blow Plungers

RPM = 1000 RV=180 FV=180 Rough Feed .004 Rough Depth .008

Recommend inserts:

Rough: MDCLNR 2525 M12 ND8

Finishing: MDJNR 2525 M15 NB8

Guide Plate

RPM = 700 RV=90 FV=180 Rough Feed .005 Rough Depth .080

Rough: MCLNR 2525 M12 ND8

Finish: MDJNR 2525 M15 NB8

The most important part is that we use PCBN (poly crystalline boron nitrate) for all finish machining. We normally allow .008 for finish cuts and really work the PCBN to load it up. We average between 100-150 parts per insert.