

RT 100 VA

Selected machining results RT 100 VA

Guhring no.	8510	8511	8511	8611
Diameter	10.6	8.0	15.0	6.8
Coating	TiAlN nanoA	TiAlN nanoA	TiAlN nanoA	TiAlN nanoA
Material group	stainless steel	stainless steel	stainless steel	stainless steel
Material description	X10CrNiS18-9 1.4305	X5CrNi18 10 1.4301	X6CrNiMoTi17-12-2 1.4571	X6CrNiTi1810 1.4541
Drilling depth [mm]	9	34	58	28
Hole type	blind hole	through hole	blind hole	blind hole
Cooling	internal	internal	internal	internal
Lubricant	oil	soluble oil	soluble oil	soluble oil
Machine type	rotary transfer machine	machining centre	machining centre	machining centre
v_c [mm/min]	40	50	90	60
f [mm/rev.]	0.16	0.2	0.14	0.1
Tool life [m]	1800	190	63	150

Wear development

The RT 100 VA has demonstrated low wear in various applications against competitor tools. The graphic below shows the development of the wear land following 100 m tool life for the machining of a heat exchanger plate in stainless steel X6CrNiMoTi17-12-2 (1.4571). While Guhring's RT 100 VA shows the lowest corner wear and no wear at the point, the wear values of the competitor tools were considerably higher. In addition, they showed considerable wear at the point. A further competitor tool didn't achieve the required tool life, it failed through premature tool breakage.

