

PS7KAST – Machining Tips

All engineering materials have their 'sweet spot' when it comes to machining, but as always, it's not black & white ... so here're some guidelines to help you with machining PS7KAST.

Turning:

- High positive rake cermet or fine grain carbide.
- Any kind of negative rake tooling is not good.
- Tools used for aluminium are a good start.
- On CNC run fast, 200 m/min plus.
- On Manual, depending on safety, fast; at least 70m/min.
- Feed rate 0.15 to 0.25 mm/ rev and up to 0.5 for roughing.

Milling:

- Similar approach to turning.
- Sharp with geometry to suit aluminium.
- 2 and 3 flute slot drills work well as they have an open flute.
- The standard end mill, e.g. Sutton 4 flute, used on steel won't work.
- Chip per tooth should be in the range 0.05 to 0.15.

Drilling:

- Most drills work fine only if they are very sharp.
- Parabolic open flute form is best.
- Peck to reduce swarf wrapping around drill.
- Use coolant were possible.
- Mid-range RPM, not so critical but vary to suit the job at hand.

If you need more assistance, please contact the office.