

# MiM & MiM-Like

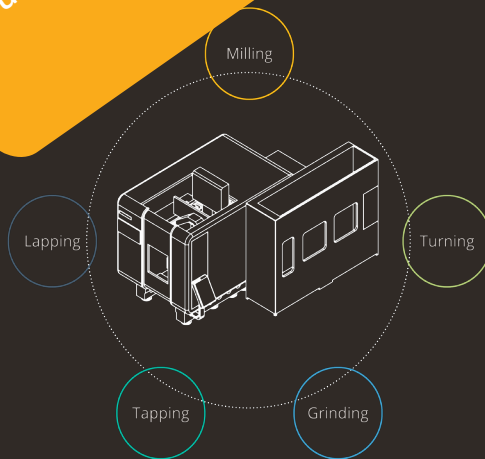
## Machining operations

In many cases MiM & MiM-Like are a near final process, with final details added via secondary operations.

Machining operations are used to finish parts that can be done on the green part. For these green parts it is important to use hard and abrasive materials (e.g. carbide, diamond, etc.).

It is also important to consider presintering on parts that will be machined. Features will depend of the part and eventually sized.

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MiM & MiM-Like parts can accept a wide range of machining finishing treatment for instance, broaching, sizing, burnishing, grinding, deforming, deburring, abrading, etc.

The machinability of a mechanical component, independently of being wrought or derived from powder metallurgy, is mainly influenced by, the workpiece itself, the tool and the machining conditions.

The primary factors influencing the machinability of powder materials, being also responsible for the sintering, are divided into the following categories:

- Manufacturing process: cold-chamber die casting, hot-chamber die casting, sintering, etc.
- Material: metal, ceramic, composite, etc.
- Alloy composition: binder/powder ratio, etc.
- Allowance: grain size, microstructure, mechanical properties, and porosity, distribution of pores and of non-metallic inclusions, etc.

In some cases, to improve the machinability of MiM & MiM-Like parts they are impregnated with oils by submerging parts in a heated oil bath for several hours.

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