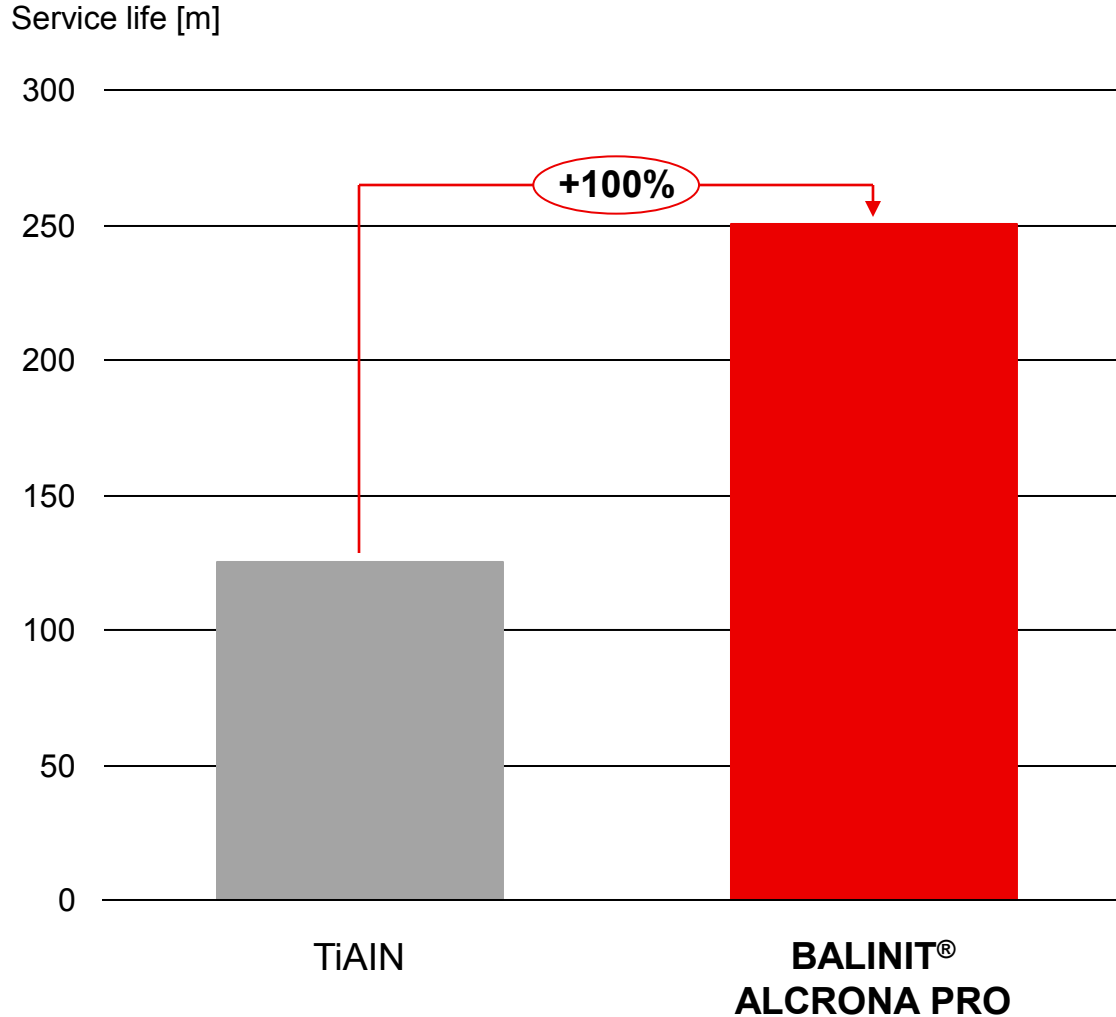


100% service life increase in finish milling, dry



Tool

Carbide end mill
Ø 10 mm, Z = 4

Workpiece

Steel 1.2344 (~ AISI H13)
HRC 45

Cutting parameters

$v_c = 250$ m/min
 $f_z = 0.12$ mm
 $a_e = 0,5$ mm, $a_p = 10$ mm
 $VB_{max} = 0.12$ mm
Dry

Source

Cutting Laboratory,
Oerlikon Balzers