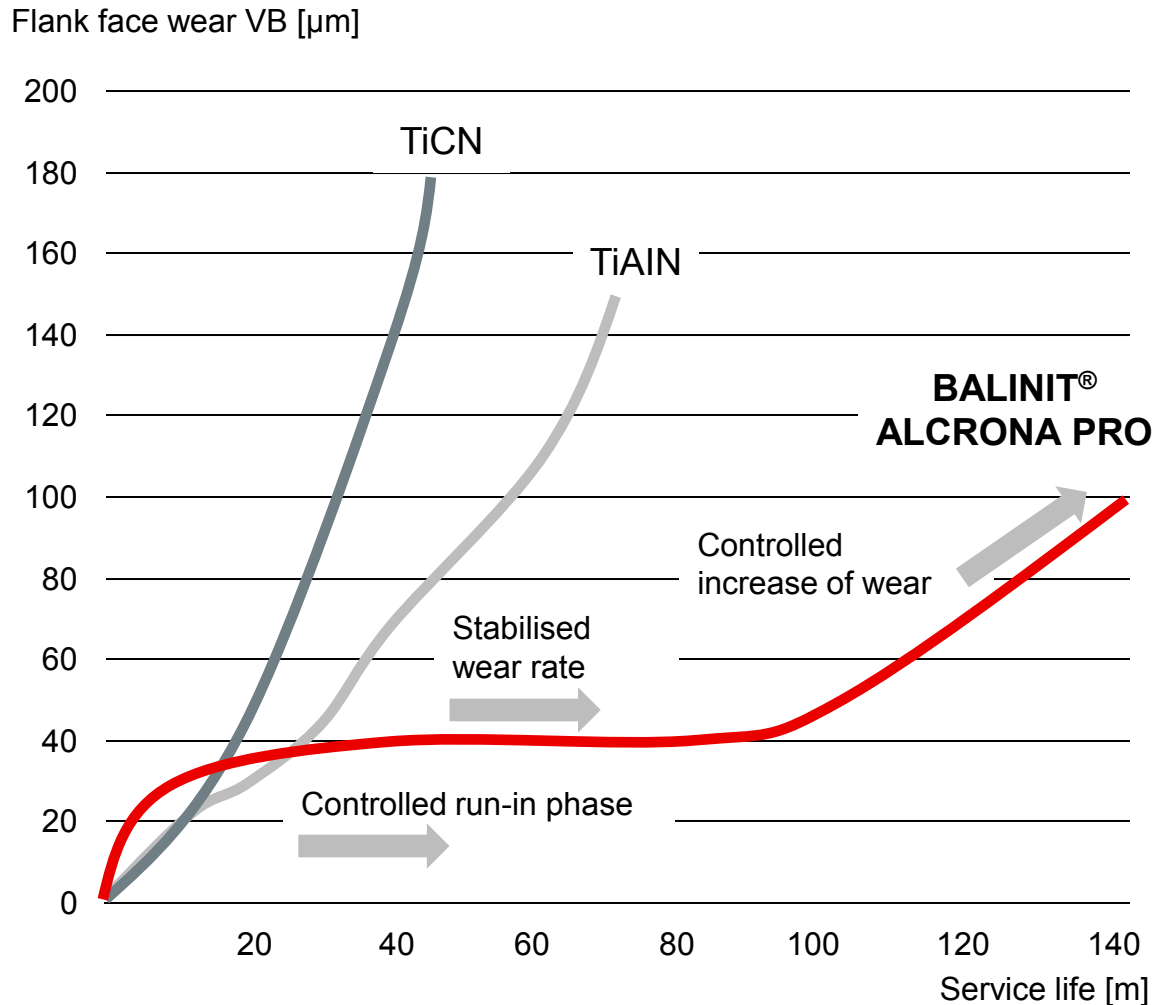


Reduced flank face wear and extended service life in finishing



Tool

Carbide end mill
 \varnothing 8 mm, Z = 3

Workpiece

Steel 1.1191 (~AISI 1045)

Cutting parameters

$v_t = 400$ m/min
 $f_t = 0.1$ mm
 $a_e = 0.5$ mm, $a_p = 10$ mm
 $VB_{\max} = 0.12$ mm
Emulsion 6%

Source

Cutting Laboratory,
Oerlikon Balzers