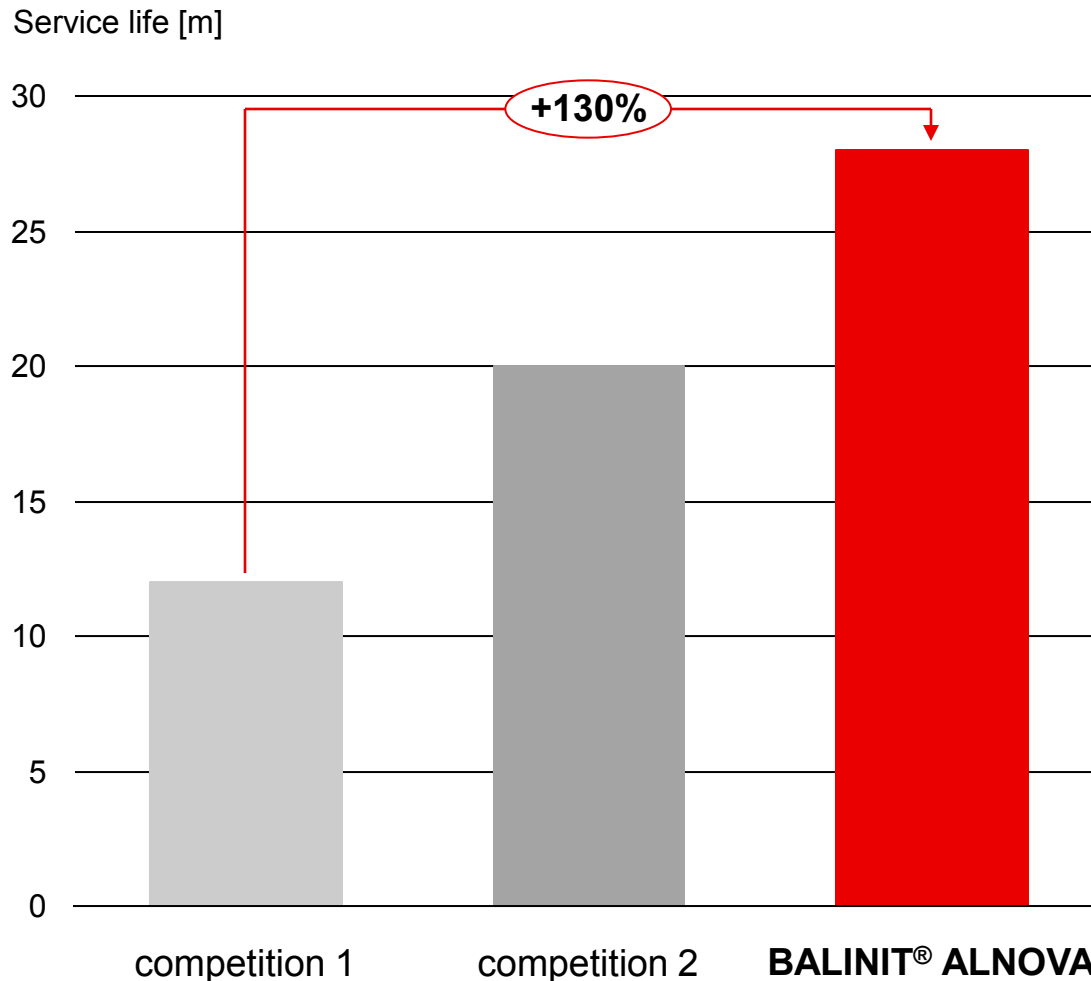


# Rough milling of high-strength steel



## Tool

Carbide end mill  
D = 10 mm, Z = 4

## Workpiece

Steel 1.2344 (~ AISI H13,  
SKD61)  
1200 N/mm<sup>2</sup>

## Cutting data

$v_c = 150$  m/min  
 $a_e = 4$  mm,  $a_p = 8$  mm  
 $f_t = 0.06$  mm  
Emulsion 5%

## Source

Tool manufacturer, Germany