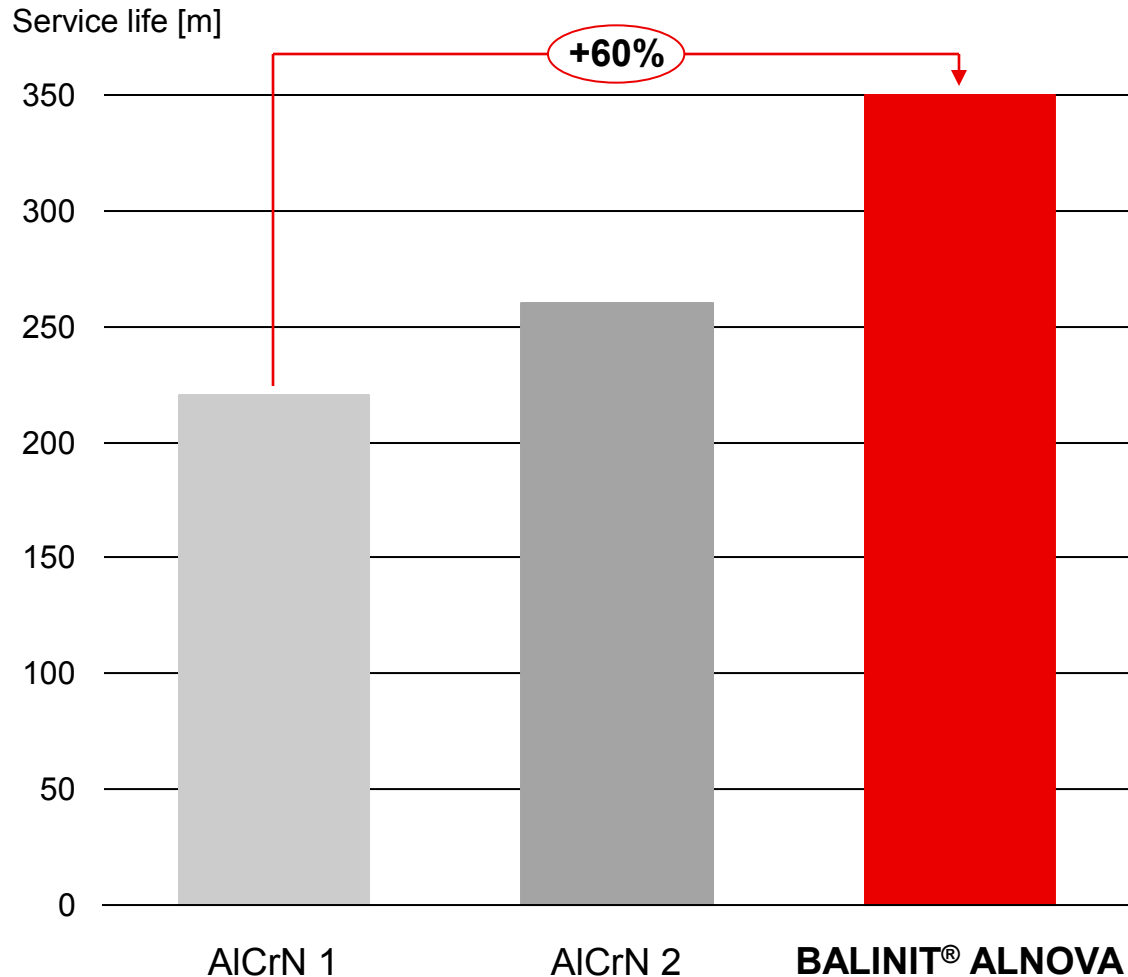


Dry milling of hot work steel



Tool

Carbide end mill
D = 10 mm, Z = 4

Workpiece

Steel 1.2344 (~ AISI H13,
SKD61)
45 HRC

Cutting data

$v_c = 250$ m/min
 $f_t = 0.12$ mm
 $a_e = 0.5$ mm, $a_p = 10$ mm
 $VB_{max} = 0.12$ mm
dry

Source

Oerlikon Balzers