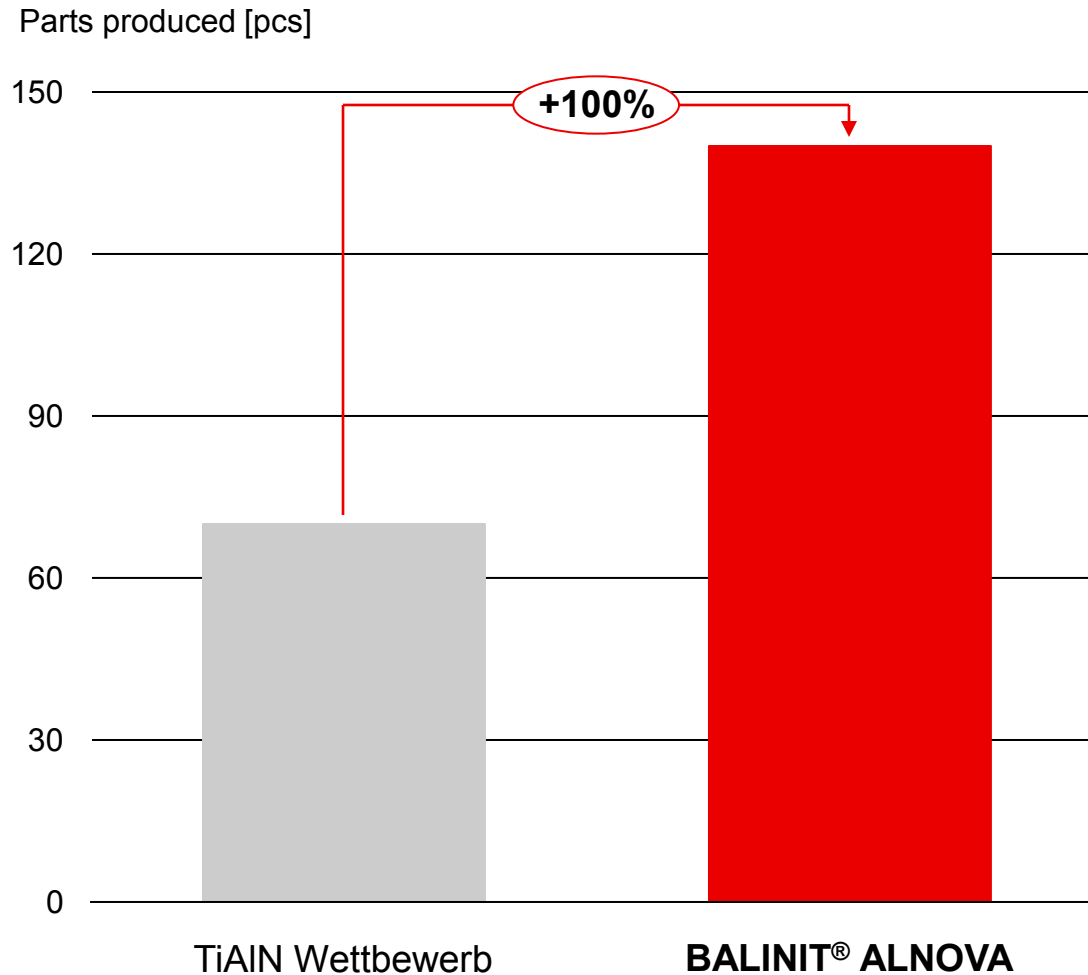


Number of parts doubled when roughing steel, wet



Tool

Carbide end mill,
Ø 16 mm

Workpiece

Steel 1.7131 (~ AISI 5115)

Cutting parameters

$v_c = 181$ m/min

$f_z = 0.03$ mm

Cooling: Emulsion 5%

Source

German tool manufacturer