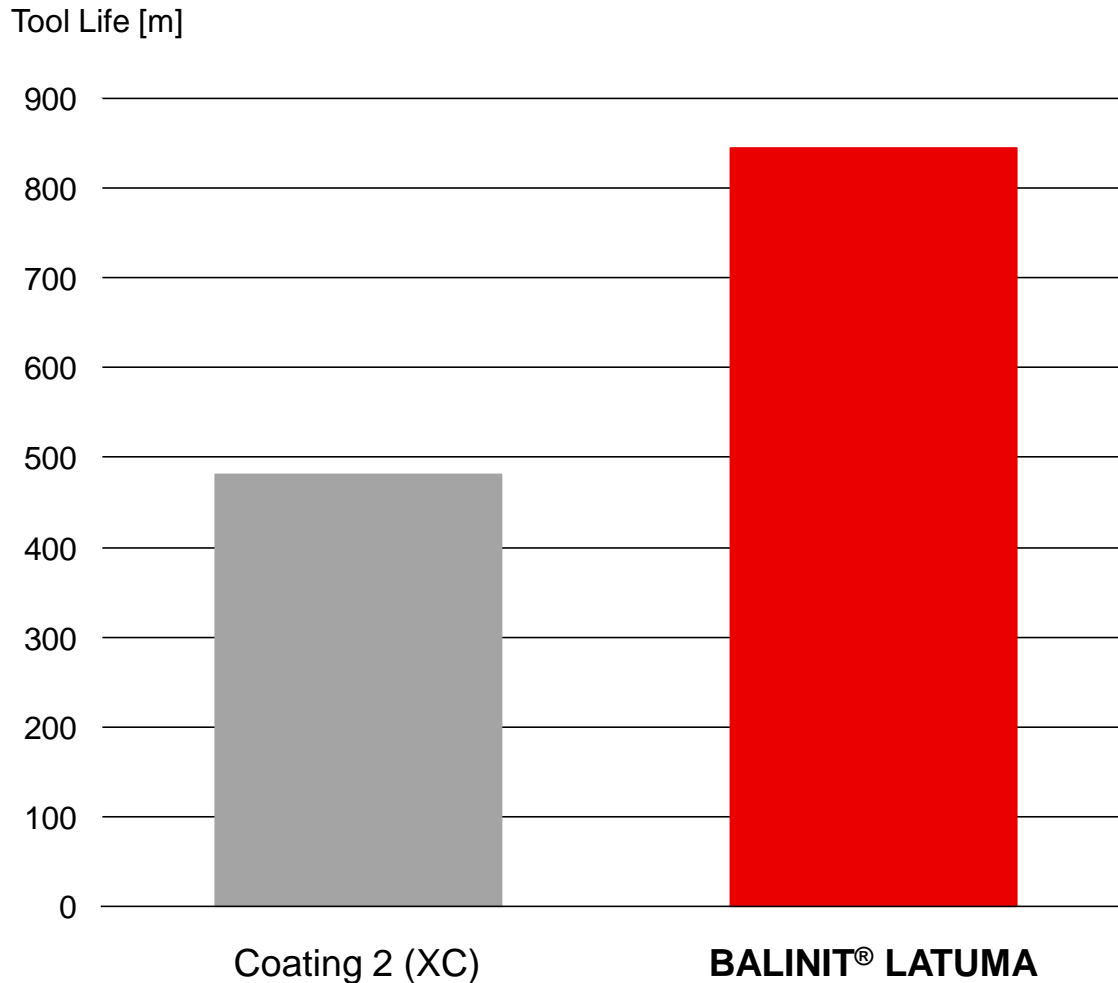


# Endmills: Milling of hot work steel (1.2344)



## Tool

Ballnose endmill,  
Ø 10 mm

## Workpiece

Steel 1.2344  
(AISI H13, SKD61)  
HRC 52

## Cutting parameters

$v_c = 320$  m/min  
 $f_t = 0.12$  mm/rev  
 $a_p = 0.3$  mm  
 $a_e = 0.3$  mm  
VB = 0.12 mm  
dry

## Source

Oerlikon Balzers