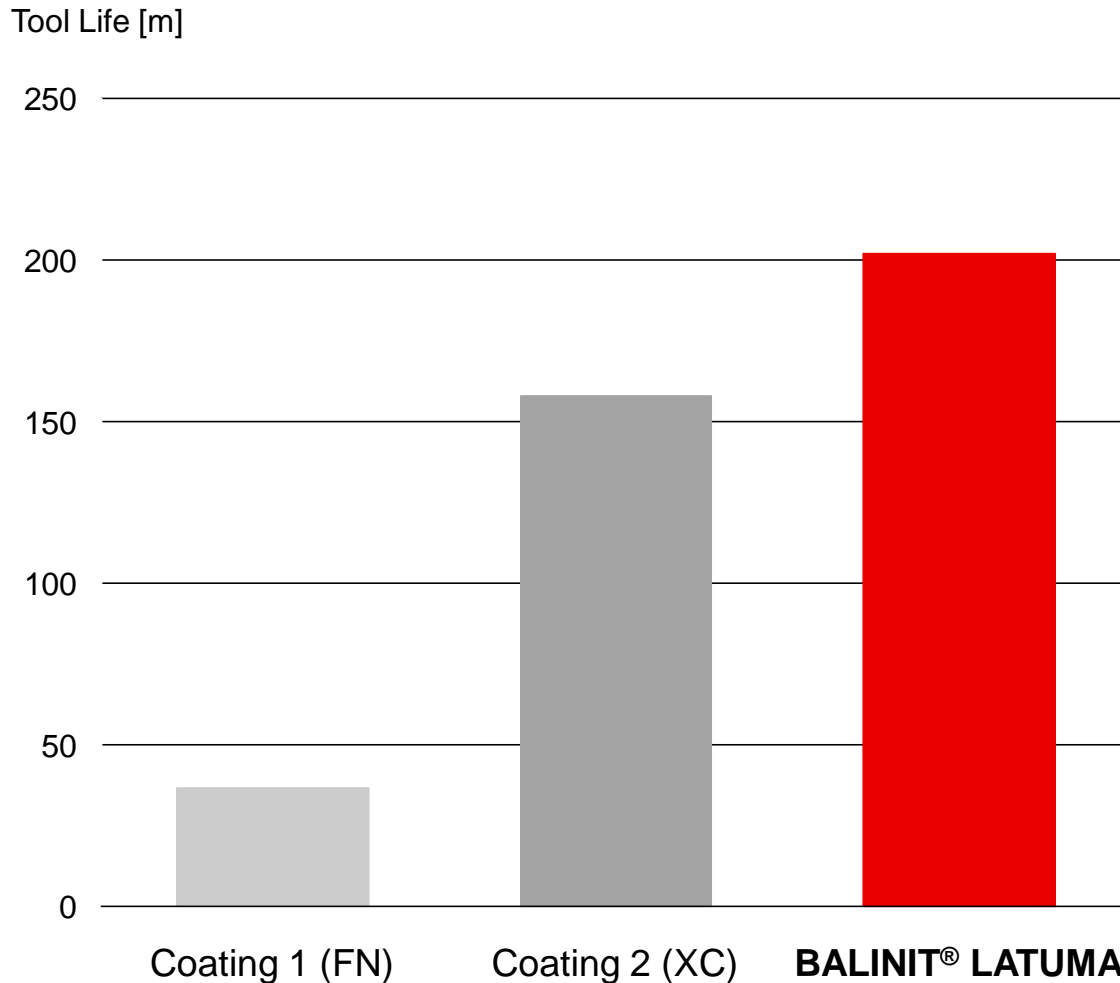


Endmills: Milling of hot work steel (1.2344)



Tool

Carbide endmill,
Ø 10 mm, Z=4

Workpiece

Steel 1.2344
(AISI H13, SKD61)
HRC 45

Cutting parameters

$v_c = 180$ m/min
 $f_t = 0.10$ mm/rev
 $a_p = 10$ mm
 $a_e = 0.5$ mm
VB = 0.1 mm
Emulsion

Source

Oerlikon Balzers
Cutting Laboratory