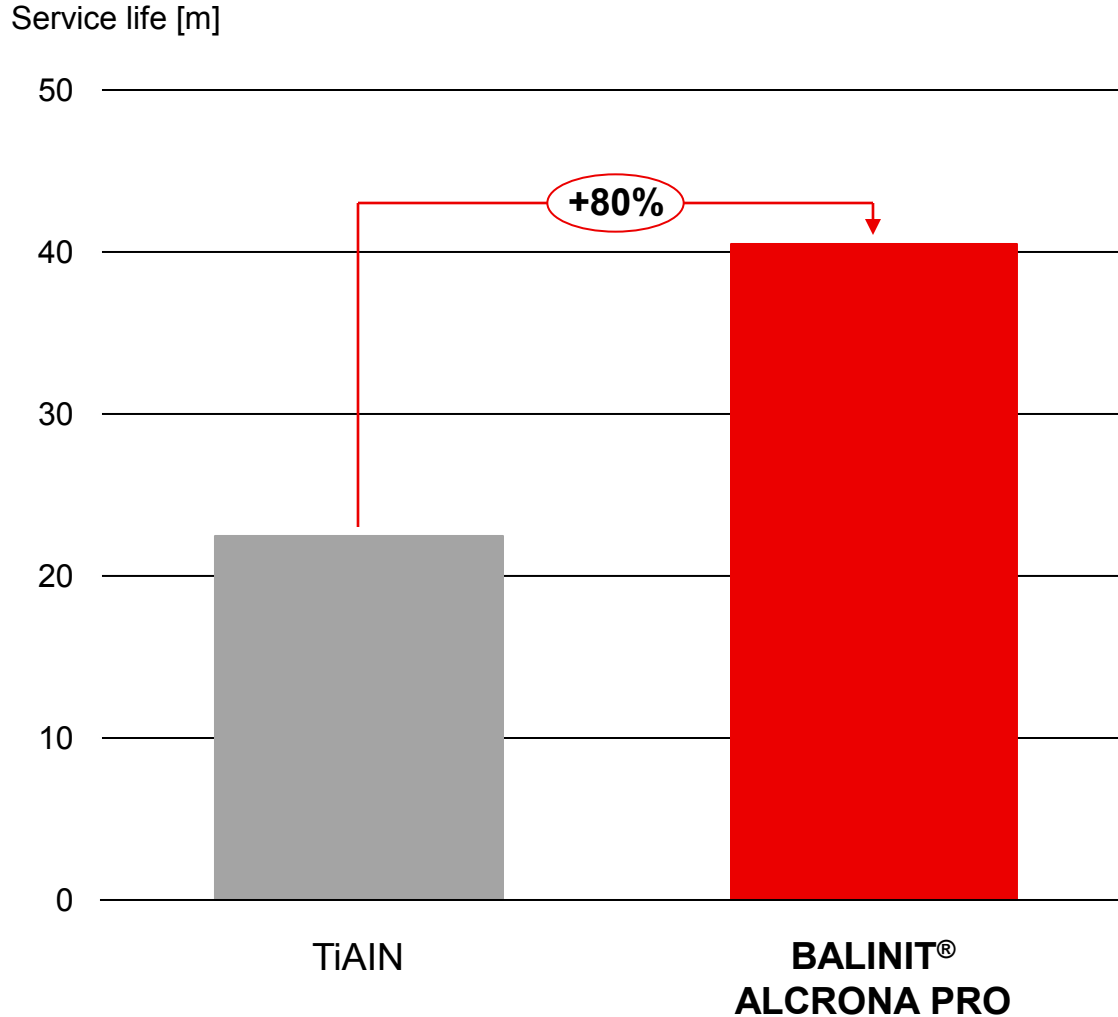


80% service life increase in rough milling, wet



Tool

Carbide end mill
Ø 10 mm, Z = 4

Workpiece

Steel 1.2344 (~ AISI H13)
HRC 38 / 1200 N/mm²

Cutting parameters

$v_c = 175$ m/min
 $f_z = 0.05$ mm
 $a_e = 4$ mm, $a_p = 8$ mm
Emulsion 6%

Source

Cutting Laboratory,
Oerlikon Balzers