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