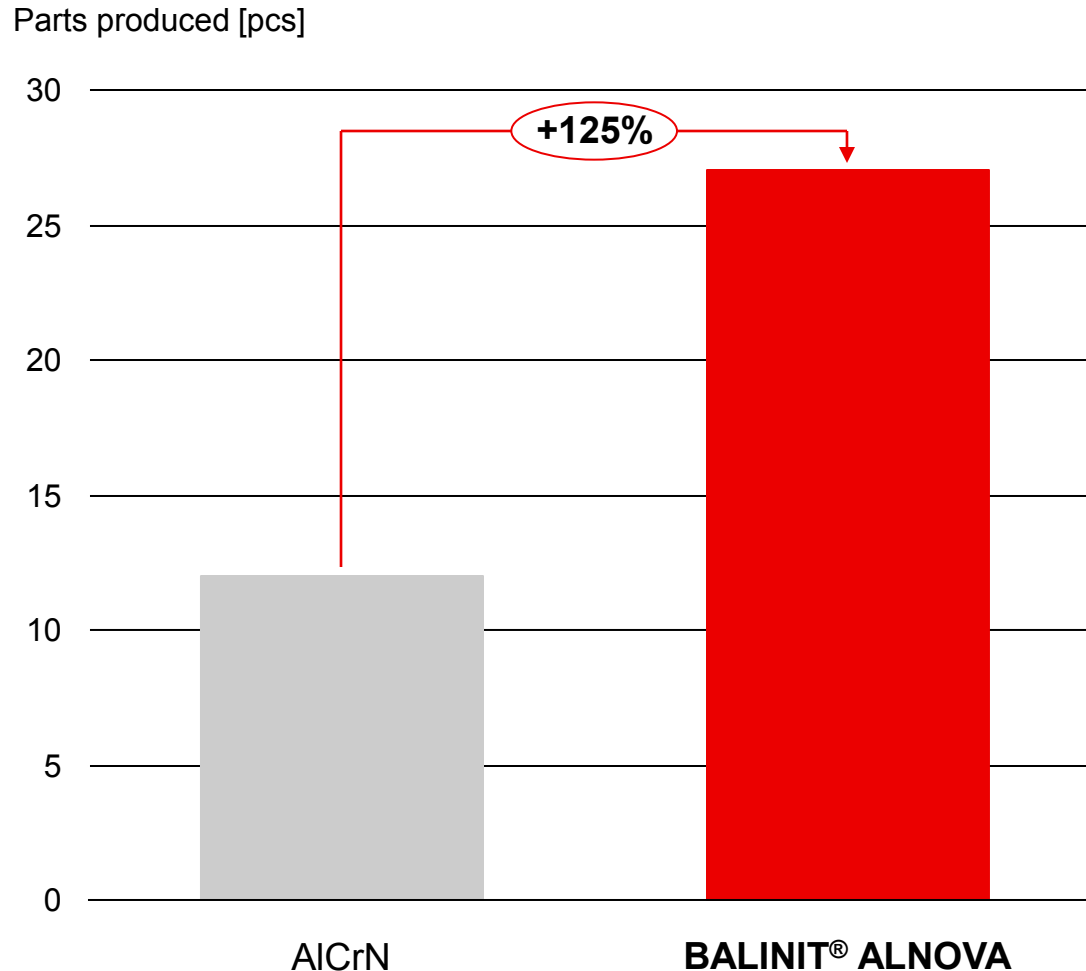


125% more tool life when roughing titanium



Tool
Endmill

Workpiece
3.7165 (TiAl6V4)

Cutting parameters
 $v_c = 70$ m/min
 $a_p = 25$ mm
 $a_e = 7.5$ mm
Cooling: Emulsion 8%

Source
Oerlikon Balzers France