125% more tool life when roughing titanium

Parts produced [pcs]

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+125%

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