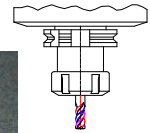
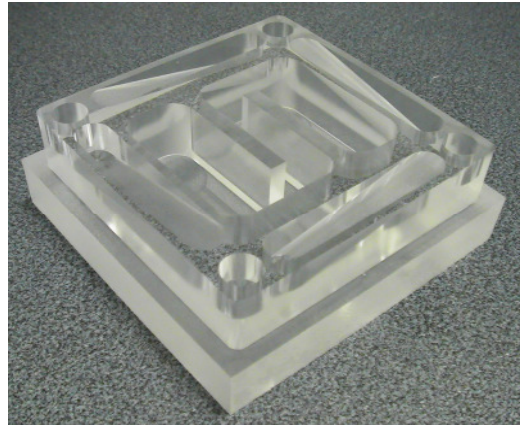


Machine	Mikron VCP600	
Spindle type		
Max RPM	20.000	
Power Kw		
Cutter holder	Collet Chuck	
Workpiece material	PMMA	
Hardness	Acrylic	
Application		
Side milling	<input checked="" type="checkbox"/>	Up-milling <input type="checkbox"/>
Slotting	<input checked="" type="checkbox"/>	Down-milling <input type="checkbox"/>
Profiling	<input type="checkbox"/>	Ramping <input type="checkbox"/>
Plunging	<input type="checkbox"/>	Circular <input type="checkbox"/>

Sketch



Cutter supplier	
Cutter description	
Cutter diameter eff.	Ød mm
Number of teeth	z
Carbide grade	

Test 1	Test 2
van Hoorn Carbide	van Hoorn Carbide
VHKE 1 100 070 10 10 L220	VHKE 1 100 070 10 10 L220
10	10
1	1
10	10

Cutting conditions	
Cutting speed	V _c m/min
Revolution	n rpm
Feed per tooth	f _z mm
Table feed	V _f mm/min
Depth of cut	a _p mm
Width of cut	a _e mm
Length of cut	L mm
Chip removal rate	Q cm ³ /min
Chip thickness	H _m mm
Coolant type	
Coolant pressure	Bar
Cutting time / comp	T _{comp} min
Toollife	T _{total} min
Power consumption	P Kw
Edge wear	V _b mm
Successful	

600	600
19.099	19.099
0,150	0,150
2.865	2.865
20	20
5	10
286,50	573,00
0,10607	0,15001
dry / air / minimum lub. / emulsion	dry / air / minimum lub. / emulsion
Internal External	Internal External
Yes / Average / No	Yes / Average / No

Remarks

Drilling 1 x D, Fz = 0,1mm/t
 Ramping 11,5°, Fz = 0,15mm/t
 Pockets as Sidemilling and Slotting