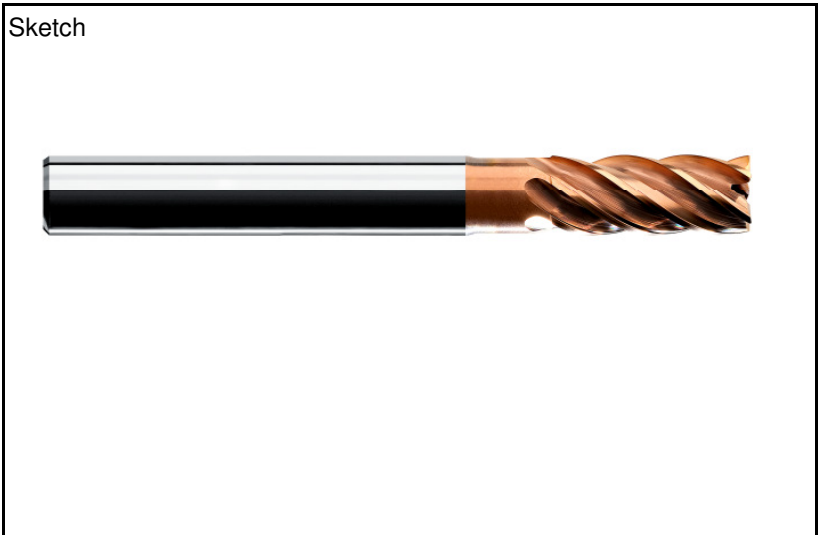


# Test report no: 013-16

Machine	Mikron HSM 600U		
Spindle type	Step-tec		
Max RPM			
Power Kw			
Cutter holder	Weldon		
Workpiece material	RVS 304		
Hardness			
Application			
Side milling	<input checked="" type="checkbox"/>	Up-milling	<input type="checkbox"/>
Slotting	<input type="checkbox"/>	Down-milling	<input checked="" type="checkbox"/>
Profiling	<input type="checkbox"/>	Ramping	<input type="checkbox"/>
Plunging	<input type="checkbox"/>	Circular	<input type="checkbox"/>



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	
VHVTR 4 080 064 08 03 030		VHVTR 5 080 064 08 03 030	
8		8	
4		5	

Cutting conditions	
Cutting speed	V <sub>c</sub> m/min
Revolution	n rpm
Feed per tooth	f <sub>z</sub> mm
Table feed	V <sub>f</sub> mm/min
Depth of cut	a <sub>p</sub> mm
Width of cut	a <sub>e</sub> mm
Length of cut	L mm
Chip removal rate	Q cm <sup>3</sup> /min
Chip thickness	Hm mm
Coolant type	
Coolant pressure	Bar
Cutting time / comp	T <sub>comp</sub> min
Toollife	T <sub>total</sub> min
Power consumption	P Kw
Edge wear	V <sub>b</sub> mm
Successful	

110	110
4.377	4.377
0,060	0,050
1.050	1.094
8	8
8	8
100	100
67,20	70,02
0,06000	0,05000
dry / air / minimum lub. / emulsion	dry / air / minimum lub. / emulsion
Internal External	Internal External
Yes Average / No	Yes Average / No

Remarks  
 Test Slotting with a 5 tooth endmill compared to a 4 tooth endmill.  
 The outcomming of this test is that you can slot with a 5 flute VHVTR, but our perference is the 4 flute!!