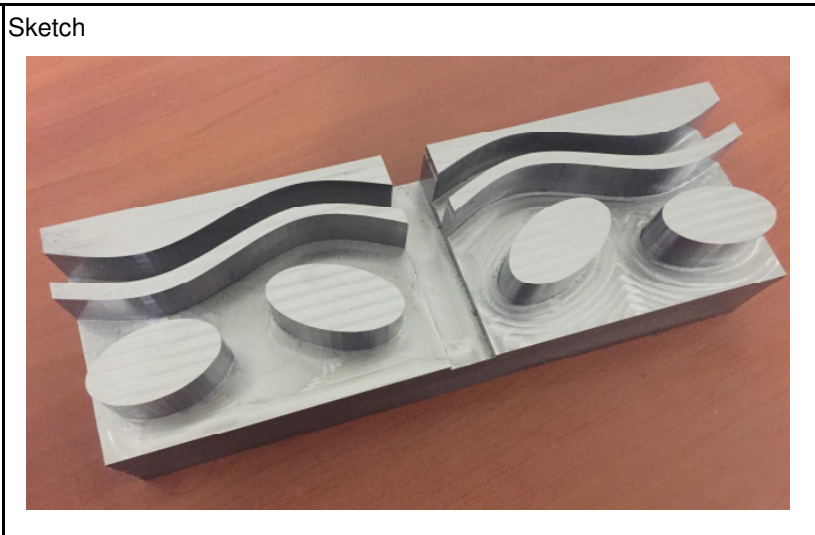


Machine	Mikron VCP 600
Spindle type	Step-Tec
Max RPM	20.000
Power Kw	18 KW
Cutter holder	Collet
Workpiece material	St37
Hardness	
Application	
Side milling	<input checked="" type="checkbox"/> Conventional <input type="checkbox"/>
Slotting	<input checked="" type="checkbox"/> Climb - Milling <input checked="" 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
VHTS 5 080 063 08 033	VHRS 4 080 064 08 03 030 L
8	8
5	4

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	Hm 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	

320	200
12.749	7.958
0,049	0,040
3.139	1.273
24	8
1,6	4 - 8
120,54	81,47
0,02191	0,02828
dry / air / <u>minimum lub.</u> / emulsion	dry / air / <u>minimum lub.</u> / emulsion
Internal / <u>External</u>	Internal / <u>External</u>
6 min	9 min
<u>Yes / Average / No</u>	<u>Yes / Average / No</u>

Remarks

Roughing with the trochoidal and classic strategy.