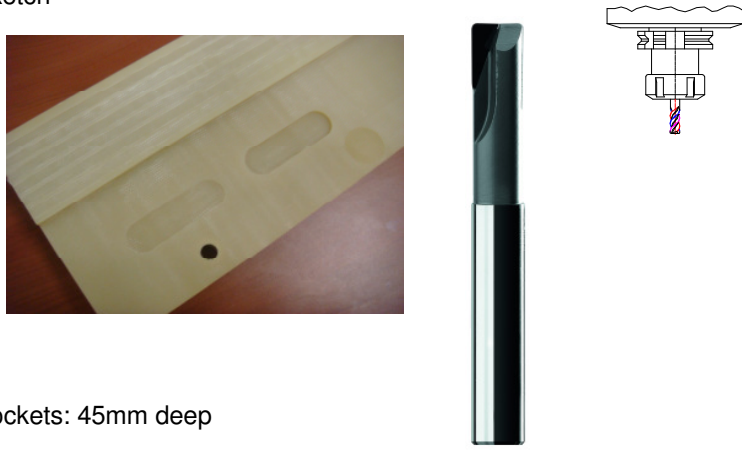


Machine	Dahli		
Spindle type	BT40		
Max RPM	8.000		
Power Kw			
Cutter holder	Collet Chuck		
Workpiece material	Nylon		
Hardness	with Glass Fibre		
Application			
Side milling	<input checked="" type="checkbox"/>	Up-milling	<input type="checkbox"/>
Slotting	<input checked="" type="checkbox"/>	Down-milling	<input type="checkbox"/>
Profiling	<input type="checkbox"/>	Ramping	<input type="checkbox"/>
Plunging	<input type="checkbox"/>	Circular	<input type="checkbox"/>

Sketch



Pockets: 45mm deep

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

Test 1	Test 2
van Hoorn Carbide	Competitor
VHDT 2 100 078 R10	
10	16
2	2
Diamond	Uncoated

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	H <sub>m</sub> 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

251	402
8.000	8.000
0,188	0,025
3.000	400
1,2	4,5
10	16
36,00	28,8
0,18750	0,02500
dry / air / minimum lub. / emulsion	dry (air) minimum lub. / emulsion
Internal External	Internal External
Still running	
	20 - 25 pockets
	worn out

Remarks

Normal the test is done with uncoated endmills, because of the glass very less toollife.  
 Test with VHDT is still running.