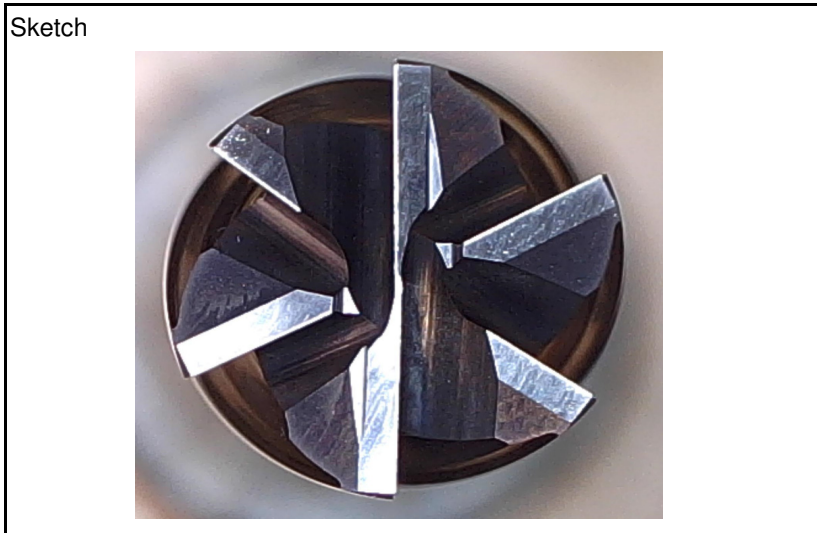


# Test report no: 018-16

Machine	DMG
Spindle type	
Max RPM	
Power Kw	
Cutter holder	Shrink
Workpiece material	1.2379
Hardness	Not Hardened
Application	
Side milling	Up-milling <input type="checkbox"/>
Slotting <input type="checkbox"/>	Down-milling <input checked="" type="checkbox"/>
Profiling <input type="checkbox"/>	Ramping <input checked="" type="checkbox"/>
Plunging <input type="checkbox"/>	Circular <input checked="" type="checkbox"/>



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

Test 1	Test 2
<b>van Hoorn Carbide</b>	
VHTS 6 120 083 12 03	
12	
6	

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
Successful	

120	0
3.182	
0,024	#DEEL/0!
458	
34	
12	
186,86	0,00
0,02399	#DEEL/0!
dry / air / minimum lub. / emulsion	dry / air / minimum lub. / emulsion
Internal External	Internal External
Yes / Average / No	Yes / Average / No

Remarks  
Helicoidal entering the material with a VHTS

**Up to 3xD deep!**