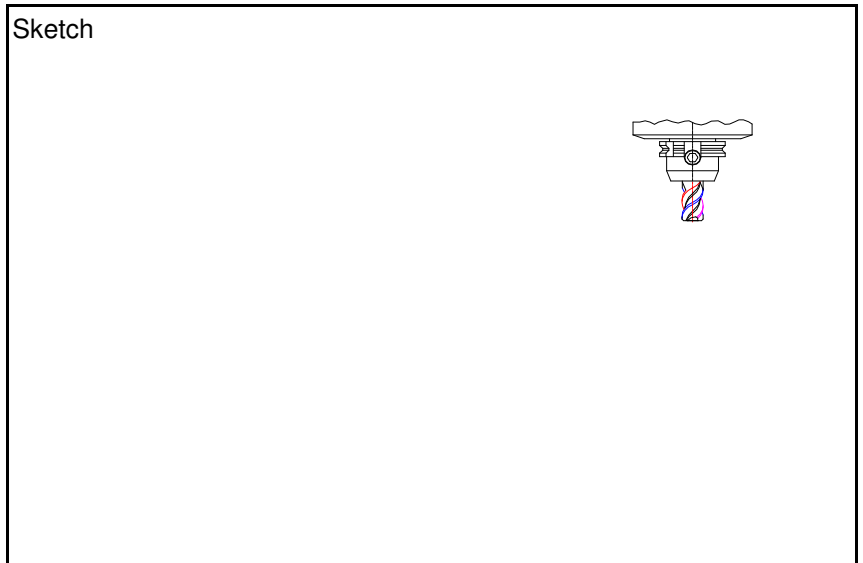


# Test report no: 002-02

Machine	Hermle		
Spindle type			
Max RPM			
Power Kw	15		
Cutter holder	Weldon Holder		
Workpiece material	1.2363		
Hardness	not tempered		
Application			
Side milling	<input checked="" type="checkbox"/>		
Slotting	<input checked="" type="checkbox"/>	Up-milling	<input type="checkbox"/>
Profiling	<input type="checkbox"/>	Down-milling	<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	Competitor
VH RFF W 3 120 078 12 03 050	
12	12
3	3
03	03

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 <sup>3</sup> /min
Coolant type	
Coolant pressure	Bar
Cutting time / comp	$T_{comp}$ min
Toollife	$T_{total}$ min
Power consumption	P Kw
Edge wear	$V_b$ mm

125	125
3.315	3.315
0,075	0,075
750	750
15,85	15,85
12	12
142,7	142,7
dry / air / minimum lub. / emulsion	dry / air / minimum lub. / emulsion
Internal External	Internal External

Remarks

Test 1; Endmill is more stable and gives less noise. Toollife is better compared to competitor.