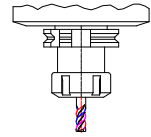


Test report no: 039-11

Machine			
Spindle type			
Max RPM	36.000		
Power Kw	6		
Cutter holder	Collet Chuck		
Workpiece material	Bakelite		
Hardness			
Application			
Side milling	<input 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



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
VHAE 1 030 038 03 10	VHAE 1 030 038 03 10
3	3
1	1
10	10

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	H _m 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

292	339
31.000	36.000
0,039	0,056
1.200	2.000
1	10
3	3
3,60	60,00
0,03871	0,05556
dry / air / minimum lub. / emulsion	dry / air / minimum lub. / emulsion
Internal External	Internal External

Remarks

Started with 1mm depth of cut, going to 2mm, 3mm, 5mm and 10mm.
 Good surface finish, no burrs.
 Current production Ap 0,5mm (max. of tool) with competitors tool.
 Almost 20 times faster.