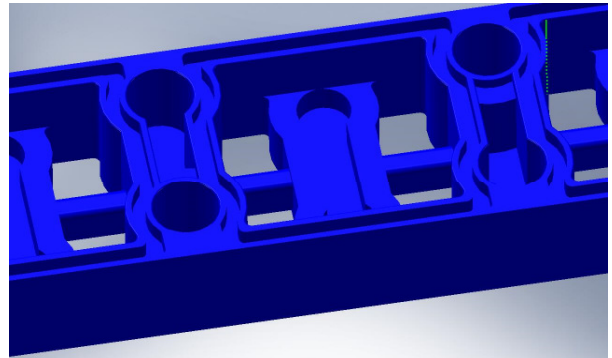


Machine	Röders RFM600	
Spindle type	Fisher	
Max RPM	40.000	
Power Kw		
Cutter holder	Shrink Holder	
Workpiece material	IXEF with 50%glass	
Hardness	-	
Application		
Side milling	<input checked="" type="checkbox"/>	Up-milling <input type="checkbox"/>
Slotting	<input type="checkbox"/>	Down-milling <input 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	
	VHMG20100640602L15	
	1	
	2	
	02	

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

94	
30.000	
0,015	
900	
0,1	
0,5	
0,05	
0.01061	
dry / air / <u>minimum lub</u> / emulsion	dry / air / minimum lub. / emulsion
Internal <u>External</u>	Internal External

Remarks

Finishing of product.
No vibration visible on product.