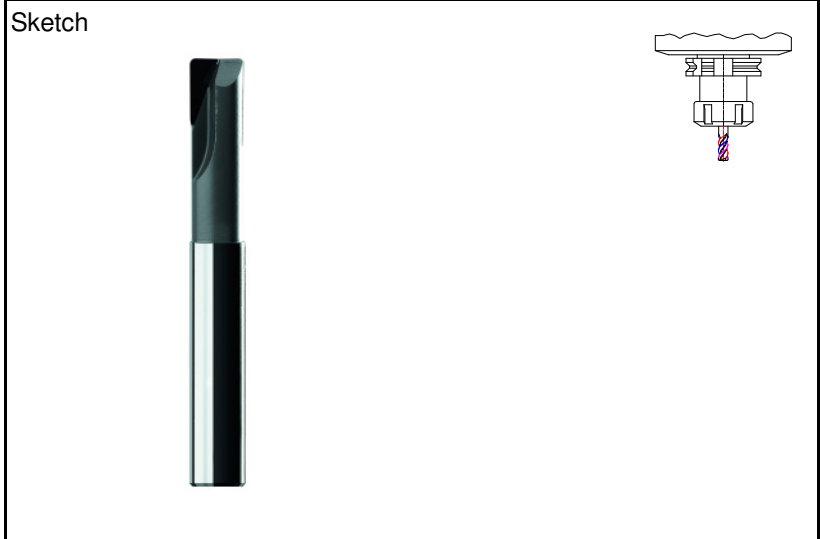


Test report no: 051-09

Machine	Hembrug NF 425	
Spindle type		
Max RPM	32.000	
Power Kw		
Cutter holder	Collet Chuck	
Workpiece material	51 ST	
Hardness	3.2315	
Application		
Side milling	<input checked="" type="checkbox"/>	Up-milling <input type="checkbox"/>
Slotting	<input type="checkbox"/>	Down-milling <input type="checkbox"/>
Profiling	<input checked="" type="checkbox"/>	Ramping <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	
VHDT 2 060 078 R10	
5	
2	
Diamond	

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	Hm 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

487	
31.000	
0,015	
930	
0,1	
0,1	
0,01	
0,00212	
dry / air / <u>minimum lub</u> / emulsion	dry / air / minimum lub. / emulsion
Internal <u>External</u>	Internal External
Not visible	

Remarks

Surface finish with this tool and cutting conditions is less than < 0,1 Ra
Toollife to be examined.