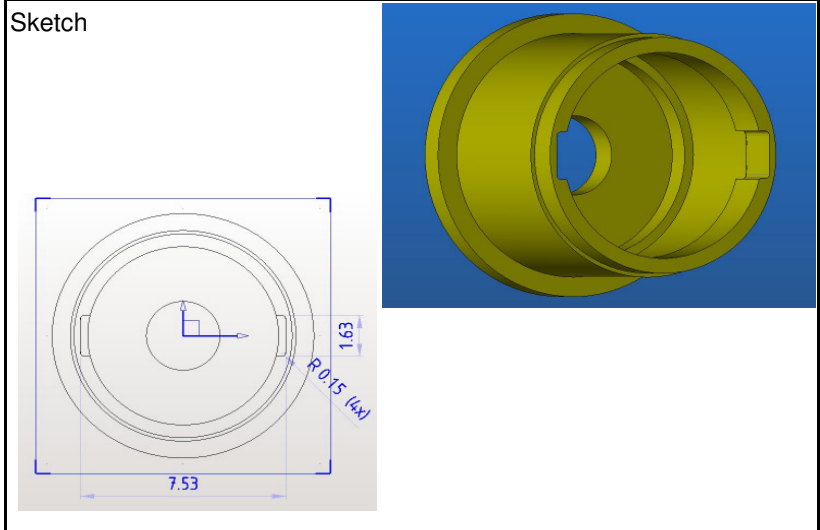


Test report no: 006-15

Machine	Hemtech NF	
Spindle type		
Max RPM	36.000	
Power Kw		
Cutter holder	Collet Chuck	
Workpiece material	1.4301	
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"/>



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

	Test 1	Test 2
	van Hoorn Carbide	
	VHMSR 2 006 Z64 06 03 L020	
	0,6	0,3
	2	2
	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 ³ /min
Chip thickness	Hm mm
Coolant type	
Coolant pressure	Bar 60
Cutting time / comp	T _{comp} min
Toollife	T _{total} min
Power consumption	P Kw
Edge wear	V _b mm
Successful	

	62	33
	32.892	35.014
	0,006	0,003
	395	210
	0,2	0,1
	0,02	0,01
	0,002	0,0002
	0,00110	0,00055
	dry / air / <u>minimum lub.</u> / emulsion	dry / air / <u>minimum lub.</u> / emulsion
	Internal <u>External</u>	Internal <u>External</u>
	2	8,5
	40	150
	Slightly visible	Visible
	<u>Yes</u> / Average / No	<u>Yes</u> / Average / No

Remarks

Test 1; Semi Finish of product
 Test 2; Finishing of product. Radius in the corner is R0.15