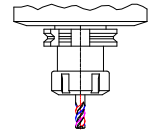


Machine	Fehlmann Versa	
Spindle type		
Max RPM	24.000	
Power Kw		
Cutter holder	Collet Chuck	
Workpiece material	2.4668	
Hardness	Inconel 718	
Application		
Side milling	<input checked="" type="checkbox"/>	Up-milling <input type="checkbox"/>
Slotting	<input type="checkbox"/>	Down-milling <input type="checkbox"/>
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	Competitor
VHVTR 4 080 064 08 03	
8	8
4	4
03	TiAlN

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
Successful	

50	50
1.990	1.990
0,050	0,050
400	400
3	3
1	1
1,20	1,20
0,01777	0,01777
dry / air / minimum lub. / emulsion	dry / air / minimum lub. / emulsion
Internal External	Internal External
90M	70M
Yes / Average / No	Yes / Average / No

Remarks