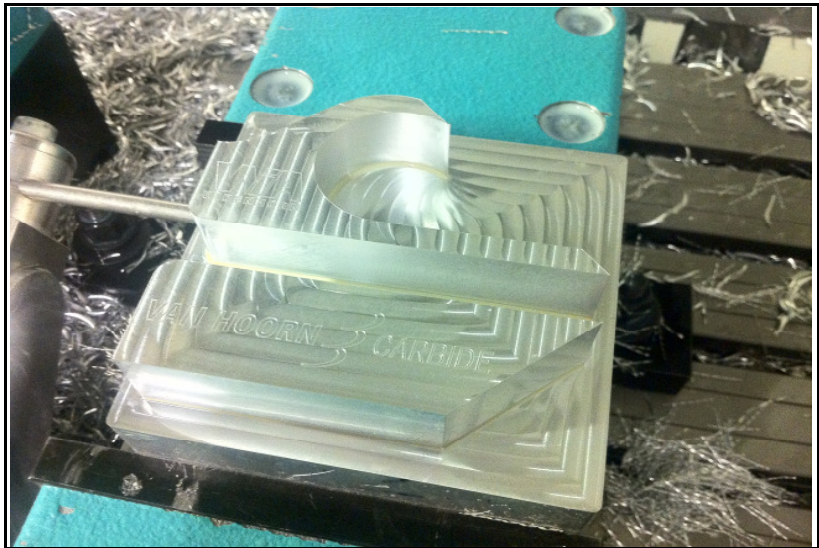


Test report no: 006-12

Machine	Mikron VCP 600
Spindle type	Step-Tec
Max RPM	20.000
Power Kw	18 Kw
Cutter holder	Weldon
Workpiece material	3.2315
Hardness	Alu 51 ST
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	
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

Test 1	
van Hoorn Carbide	
VHAD 3 100 072 10 10	
10	
3	

500	
15.915	
0,100	
4.774	
20	
4,5	
429,66	
0,06708	
dry / air / minimum lub. / emulsion	dry / air / minimum lub. / emulsion
Internal External	Internal External
~ 1,5 min.	

Remarks

Sidemilling on 2 x D depth of cut
 Large Material Removal Rate
 Slotting using the Wave-form Strategy