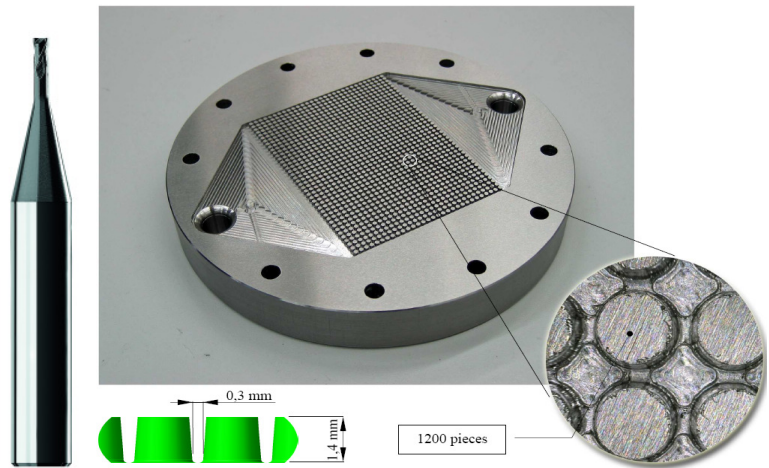


Machine	Hembrug NF 425	
Spindle type		
Max RPM	36.000	
Power Kw		
Cutter holder	Shrink Holder	
Workpiece material	1.4104	
Hardness	Stainless 430F	
Application		
Side milling	<input type="checkbox"/>	Up-milling <input type="checkbox"/>
Slotting	<input checked="" type="checkbox"/>	Down-milling <input type="checkbox"/>
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	Van Hoorn Carbide
	VHMSR2004Z640603L020	VHMSR2003Z640603L015
	0,4	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
Cutting time / comp	T_{comp} min
Toollife	T_{total} min
Power consumption	P Kw
Edge wear	V_b mm

	45	34
	36.000	36.000
	0,008	0,006
	575	430
	0,05	0,03
	0,4	0,3
	0,0115	0,00387
	0,00799	0,00597
	dry / air <u>minimum lub.</u> / emulsion	dry / air <u>minimum lub.</u> / emulsion
	Internal <u>External</u>	Internal <u>External</u>
	2H 51 M	4H 36 M

Remarks

Test 1. Semi-finishinf of material
 Test 2. Finishing of material

Total production time complete product 47 Hours