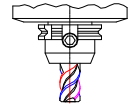


Test report no: 021-10

Machine	Caser		
Spindle type	ISO 50		
Max RPM	4.000		
Power Kw	50		
Cutter holder	Weldon		
Workpiece material	1.4462 Duplex		
Hardness	X2CRNiMON22-5-3		
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
VHVTRW52501202503	
25	40
5	3
03	Coated

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

50	63
636	500
0,100	0,080
318	120
36	36
1,8	1,8
20,61	7,78
0,02683	0,01697
dry / air / minimum lub. / emulsion	dry / air / minimum lub. / emulsion
Internal External	Internal External
1 M 45S	4 M 40S

Remarks

Almost 3 times faster compared then competitor.