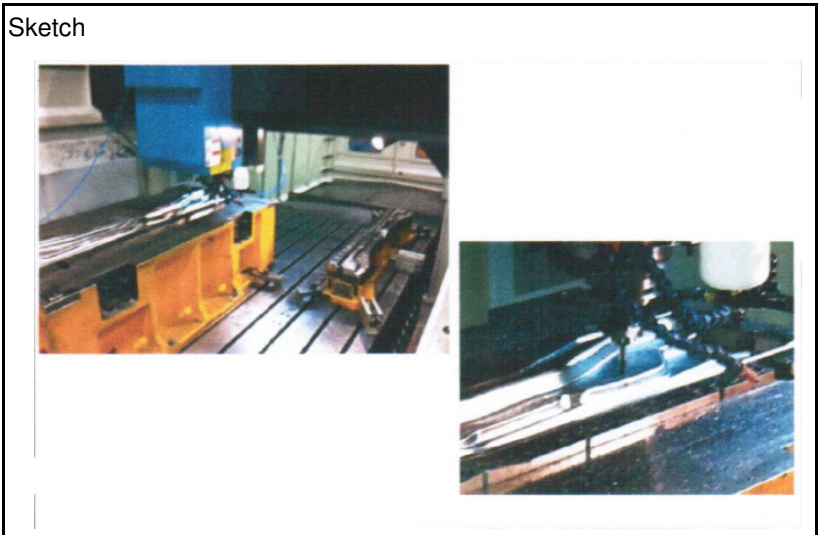


Test report no: 018-12

Machine	VTEC VMC		
Spindle type	BT50		
Max RPM	6.000		
Power Kw			
Cutter holder	Collet Chuck		
Workpiece material	1.2379		
Hardness	62 HRc		
Application			
Side milling	<input type="checkbox"/>	Up-milling	<input type="checkbox"/>
Slotting	<input type="checkbox"/>	Down-milling	<input type="checkbox"/>
Profiling	<input checked="" 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		Competitor	
VHPK 2 100 078 10 L120			
10		10	
2		2	
10			

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
Successful	

182	182
5.800	5.800
0,103	0,103
1.200	1.200
0,15	0,15
0,15	0,15
0,027	0,027
0,01267	0,01267
dry / air / minimum lub. / emulsion	dry / air / minimum lub. / emulsion
Internal External	Internal External
Yes / Average / No	Yes / Average / No

Remarks

Roughness of the surface is better compared against competitor.
Less time needed for polishing.