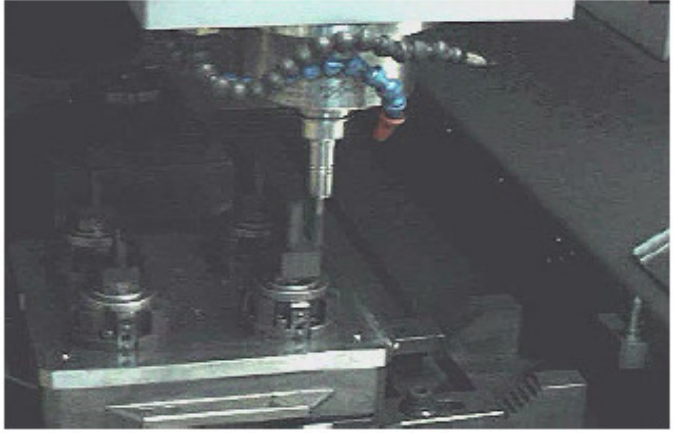


Machine	Röders RFM 760		
Spindle type	Fisher		
Max RPM	42.000		
Power Kw			
Cutter holder	Hydrolic Holder		
Workpiece material	SGL Graphite		
Hardness	R8500		
<b>Application</b>			
Side milling	<input type="checkbox"/>	Up-milling	<input type="checkbox"/>
Slotting	<input type="checkbox"/>	Down-milling	<input type="checkbox"/>
Profiling	<input checked="" type="checkbox"/>	Circular	<input type="checkbox"/>
Plunging	<input type="checkbox"/>		

Sketch



Workpiece; 60 x 45 x 70 mm

Cutter supplier	
Cutter description	
Cutter diameter eff.	Ød mm
Number of teeth	z
Carbide grade	
<b>Cutting conditions</b>	
Cutting speed	V <sub>c</sub> m/min
Revolution	n rpm
Feed per tooth	f <sub>z</sub> mm
Table feed	V <sub>f</sub> mm/min
Depth of cut	a <sub>p</sub> mm
Width of cut	a <sub>e</sub> mm
Length of cut	L mm
Chip removal rate	Q cm <sup>3</sup> /min
Coolant type	
Coolant pressure	Bar
Cutting time / comp	T <sub>comp</sub> min
Toollife	T <sub>total</sub> min
Power consumption	P Kw
Edge wear	V <sub>b</sub> mm

Test 1	Test 2
<b>van Hoorn Carbide</b>	<b>Competitor</b>
VHGTF 3 060 078 06 02	
6	6
3	2
02	Diamond coated

452	565
24.000	30.000
**	0,042
7.200	2.500
0,1	0,1
2	2
1,44	0,50
dry / air minimum lub. / emulsion	dry / air minimum lub. / emulsion
Internal External	Internal External
7M 08 Sec	16M 58 Sec

Remarks

Finishing of complete product. Surface finish is very smooth.  
Cutting time is more than half with Van Hoorn Endmill.