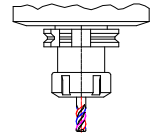


Machine	MDSI		
Spindle type			
Max RPM	40.000		
Power Kw			
Cutter holder	Collet Chuck		
Workpiece material	PolyCarbonat		
Hardness			
Application			
Side milling	<input type="checkbox"/>	Up-milling	<input type="checkbox"/>
Slotting	<input checked="" type="checkbox"/>	Down-milling	<input type="checkbox"/>
Profiling	<input type="checkbox"/>	Ramping	<input checked="" 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
VH LA 3 100 70 10 15	VH LA 3 100 70 10 15
10	10
3	3
15	15

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

754	754
24.000	24.000
0,104	0,104
7.500	7.500
5-10-15-20	3
10	10
375 - 750 - 1125 - 1500	225,0
0,10417	0,10417
dry / air / minimum lub. / emulsion	dry / air / minimum lub. / emulsion
Internal External	Internal External
60 min	60 min

Remarks

Machine is a portal machine.
 Test 1: Testing maximum depth of cut and maximum table feed, surface finish is very good
 Test 2: Different product, material is 3mm thick. Surface finish very good.
 After 60 no wear on tool visible.