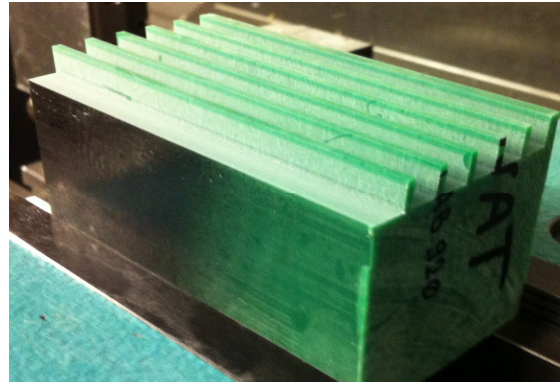


Test report no: 034-11

Machine	Mikron VCP600
Spindle type	Step-Tec
Max RPM	20.000
Power Kw	
Cutter holder	Collet Chuck
Workpiece material	Lab 920
Hardness	Synthetic Material
Application	
Side milling	<input checked="" 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
VHDT2060078R05	VHDT2060078R05
6	6
2	2
Diamond Insert	Diamond Insert

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

300	300
15.915	15.915
0,200	0,200
6.366	6.366
6	6
3	6
114,59	229,18
0,14142	0,20000
dry air / minimum lub. / emulsion	dry air / minimum lub. / emulsion
Internal External	Internal External

Remarks

Side milling and Slot milling with same endmill.
Surface finish very smooth. No burrs on product.