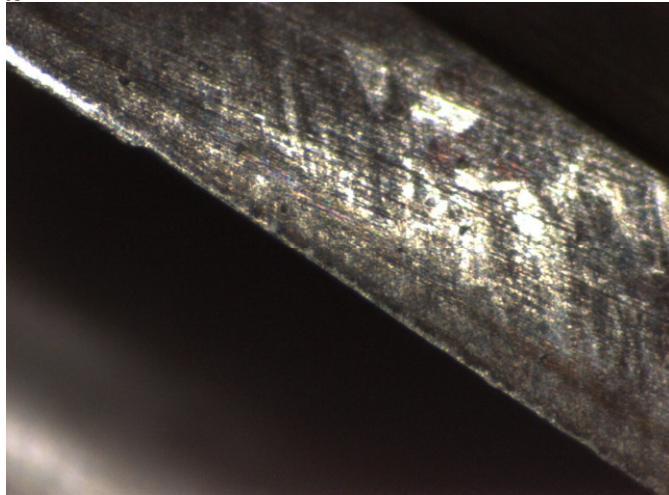


# Test report no: 018-15

Machine	Mikron VCP 600
Spindle type	Step-Tec
Max RPM	20.000
Power Kw	18 KW
Cutter holder	Weldon
Workpiece material	Titaan grade 2
Hardness	
Application	
Side milling	<input checked="" type="checkbox"/> Conventional <input type="checkbox"/>
Slotting	<input type="checkbox"/> Climb - milling <input checked="" 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
<b>van Hoorn Carbide</b>	
VHTR 5 080 063 08 03	
8	
5	

Cutting conditions	
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
Chip thickness	H <sub>m</sub> mm
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
Successful	

99	
3.939	
0,072	
1.418	
16	
0,96	
160	
21,78	
0,02494	
dry / air / minimum lub. / emulsion	dry / air / minimum lub. / emulsion
Internal External	Internal External
32	
<b>0,019</b>	
Yes / Average / No	Yes / Average / No

Remarks  
Trochoïdaal verspanen van Titaan grade 2  
Na 32 min. lichte slijtage en verkleving