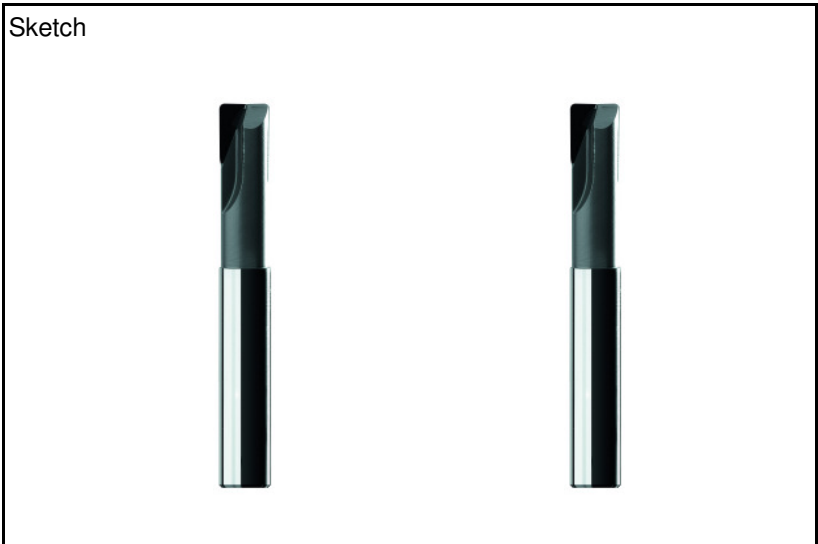


Machine	Ingersol OPS600	
Spindle type		
Max RPM	40.000	
Power Kw		
Cutter holder	HSK32 Shrink	
Workpiece material	Graphite	
Hardness	EDM 200	
Application		
Side milling	<input checked="" type="checkbox"/>	Up-milling <input checked="" type="checkbox"/>
Slotting	<input checked="" type="checkbox"/>	Down-milling <input checked="" type="checkbox"/>
Profiling	<input checked="" type="checkbox"/>	Ramping <input checked="" type="checkbox"/>
Plunging	<input checked="" 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	van Hoorn Carbide
VHDT2080078R10	VHDT2080078R10
8	8
2	2
**	**

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	H _m 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

1005	1005
40.000	40.000
0,150	0,059
12.000	4.700
0,5	0,2
6	0,3
36,00	0,282
0,12990	0,01138
dry / air minimum lub. / emulsion	dry / air minimum lub. / emulsion
Internal External	Internal External
155 min	270 min
Not visible	Not visible

Remarks

Test 1 and Test 2 with same endmill. No wear visible, test is still running.