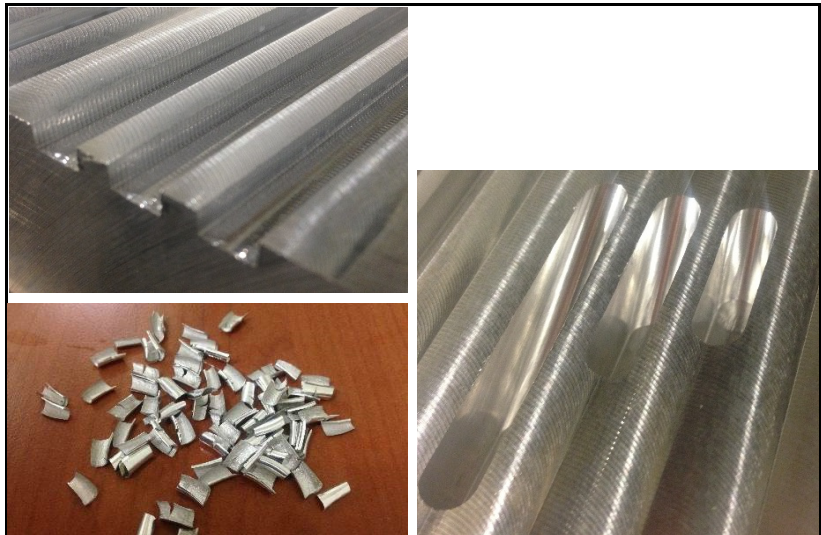


Test report no: 015-15

Machine	Mikron VCP 600		
Spindle type	Step-Tec		
Max RPM	20.000		
Power Kw	18 KW		
Cutter holder	Collet Chuck		
Workpiece material	Aluminium 3.2315		
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"/>



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	
VHAE1 060 050 06 10		VHAE1 060 050 06 11	
6		6	
1		1	

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
Successful	

360	360
19.099	19.099
0,600	0,160
11.459	3.056
6	12
6	6
250	30
412,52	220,03
0,59998	0,16001
dry / air / minimum lub. / emulsion	dry / air / minimum lub. / emulsion
Internal External	Internal External
Yes / Average / No	Yes / Average / No

Remarks

Test 1;
Full slotting 1xD with a Fz of 0,6mm! Excellent Chipflow!

Test 2;
Ramping with a angle of 20°, 40° and 60° 2xD cutting dept. Excelent chipflow and surface quality!