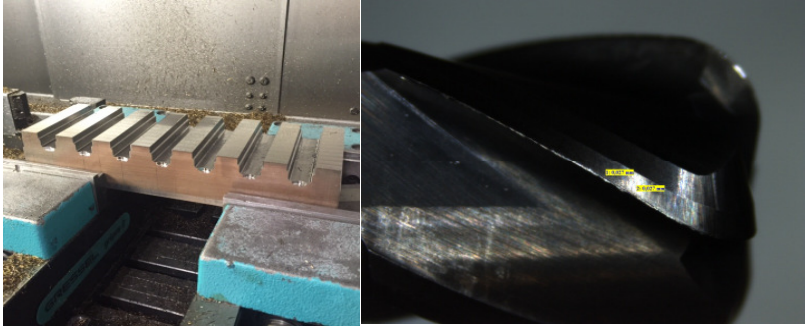


Machine	Mikron VCP 600	Sketch 			
Spindle type	Step-Tec				
Max RPM	20.000				
Power Kw	18 KW				
Cutter holder	Collet				
Workpiece material	1,2083				
Hardness	50 Hrc				
Application					
Side milling	<input checked="" type="checkbox"/> Conventional <input type="checkbox"/>				
Slotting	<input type="checkbox"/> Climb - Milling <input checked="" type="checkbox"/>				
Profiling	<input type="checkbox"/> Ramping <input type="checkbox"/>				
Plunging	<input type="checkbox"/> Circular <input type="checkbox"/>				
Cutter supplier			Test 1	Test 2	
Cutter description			van Hoorn Carbide	van Hoorn Carbide	
Cutter diameter eff.	Ød mm		VHTF 4 080 064 08 03 200	VHKF 2 080 064 08 03	
Number of teeth	z		8	8	
Carbide grade			4	2	
Cutting conditions					
Cutting speed	V _c m/min		180	180	
Revolution	n rpm		7.162	7.162	
Feed per tooth	f _z mm	0,080	0,080		
Table feed	V _f mm/min	2.292	1.146		
Depth of cut	a _p mm	8	0,2		
Width of cut	a _e mm	0,15	0,1		
Length of cut	L mm				
Chip removal rate	Q cm ³ /min	2,75	0,02		
Chip thickness	Hm mm	0,01095	0,00894		
Coolant type		dry / air / minimum lub / emulsion	dry / air / minimum lub / emulsion		
Coolant pressure	Bar	Internal External	Internal External		
Cutting time / comp	T _{comp} min	3h 15min	16h		
Toollife	T _{total} min				
Power consumption	P Kw				
Edge wear	V _b mm	0,027mm	0,097mm		
Successful		Yes / Average / No	Yes / Average / No		
Remarks					
Roughing and finishing with the VHTF and VHKF					