

Machine	DMV Evolution
Spindle type	HSK63
Max RPM	15.000
Power Kw	
Cutter holder	Shrink Holder
Workpiece material	PEEK 30
Hardness	
Application	
Side milling	<input checked="" type="checkbox"/> Up-milling <input type="checkbox"/>
Slotting	<input 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	Competitor
VHDT2100078R10	
10	8
2	2
Diamond	PKD

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

200	150
6.366	5.968
0,090	0,090
1.146	1.075
3,5	3,5
3 - 10	3 - 8
12,03 - 40,11	11,29 - 30,11
0,0493 - 0,090	0,0552 - 0,090
dry / air minimum lub. / emulsion	dry / air / minimum lub. / emulsion
Internal External	Internal External
1,5 Min	2,5 Min

Remarks

Surface with Van Hoorn tool is excellent
 ~ 30% time reduction against competitor