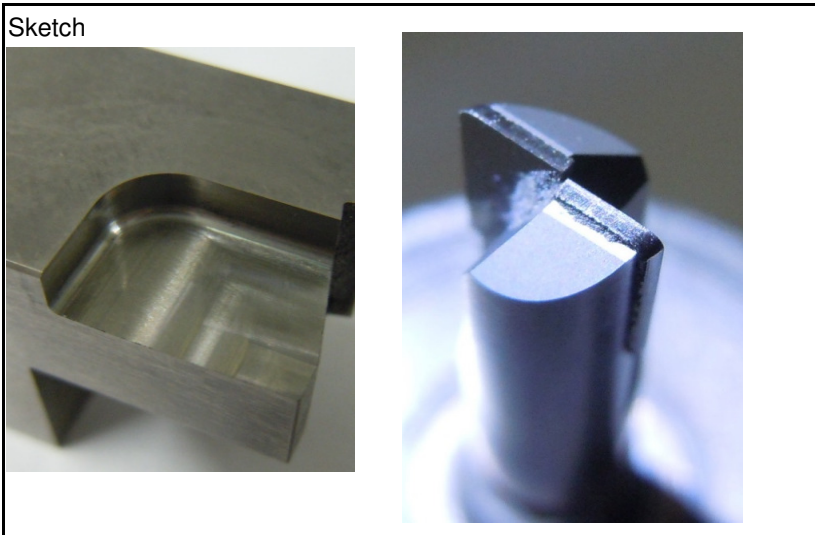


Test report no: 025-15

Machine	Hermle C800v		
Spindle type	Hsk 25		
Max RPM			
Power Kw			
Cutter holder	Hydrodeen		
Workpiece material	Carbide H40S		
Hardness			
Application			
Side milling	<input type="checkbox"/>	Up-milling	<input type="checkbox"/>
Slotting	<input type="checkbox"/>	Down-milling	<input checked="" type="checkbox"/>
Profiling	<input type="checkbox"/>	Ramping	<input 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	
VHDT 2 060 102 050 L18	
6	
2	
Diamond	

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
Successful	

100	
5.305	
0,025	
265	
0,01	
2,5	
0,01	
0,01612	
dry / air / <u>minimum lub.</u> / emulsion	dry / air / minimum lub. / emulsion
Internal <u>External</u>	Internal External
70 minutes	
<u>Yes</u> / Average / No	Yes / Average / No

Remarks
 After 1 product no wear visible

 Cutting conditions can be optimised, this needs to be tested further for optimal data.