

Test report no: 017-16

Machine	Victor	
Spindle type		
Max RPM		
Power Kw		
Cutter holder	Collet	
Workpiece material	430F	
Hardness		
Application		
Side milling	<input checked="" 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	
VHRS 120 078 12 03 050	
12	
4	

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	

120	0
3.183	
0,100	#DEEL/0!
1.273	
24	
3	
91,66	0,00
0,04999	#DEEL/0!
dry / air / minimum lub. / emulsion	dry / air / minimum lub. / emulsion
Internal External	Internal External
600 products	
Yes / Average / No	Yes / Average / No

Remarks
 Succesfull test with the VHRS in 430F.

C 0,10 - 0,17 **Cr** 15,50 - 17,50 **Mo** 0,20 - 0,60 **S** 0,15 - 0,35