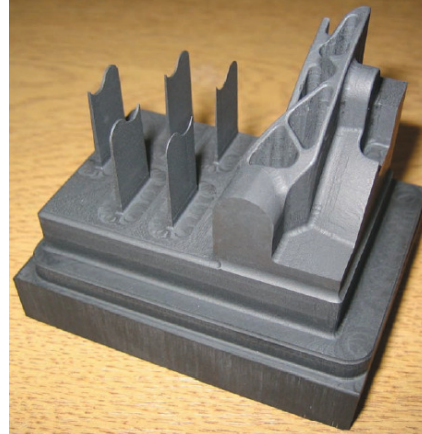


Machine	Mikron HSM700
Spindle type	Step-Tec
Max RPM	42.000
Power Kw	
Cutter holder	Shrink Holder
Workpiece material	Poco Graphite
Hardness	EDM-3
Application	
Side milling	<input checked="" type="checkbox"/> Up-milling <input type="checkbox"/>
Slotting	<input type="checkbox"/> Down-milling <input type="checkbox"/>
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	van Hoorn Carbide
VHGKF30400600402	VHGKF3020050302
4	2
3	3
02	02

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

440	251
35.000	40.000
0,080	0,046
8.400	5.520
0,18	0,13
0,18	0,13
0,27	0,09
0,01697	0,01173
dry / air minimum lub. / emulsion	dry / air minimum lub. / emulsion
Internal External	Internal External

Remarks

Test 1; Semi-Finish of Product
 Test 2; Finishing of Product