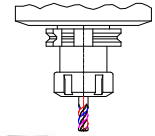
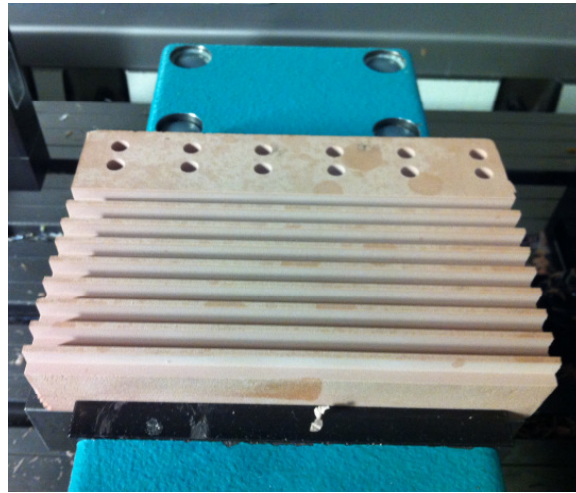


Test report no: 035-11

Machine	Mikron VCP600
Spindle type	Step-Tec
Max RPM	20.000
Power Kw	23
Cutter holder	Collet Chuck
Workpiece material	Prolab 65
Hardness	Synthetic Material
Application	
Side milling	<input checked="" type="checkbox"/> Up-milling <input type="checkbox"/>
Slotting	<input checked="" 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
VHDT2060078R05	VHDT2060078R05
6	6
2	2
Diamond Insert	Diamond Insert

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

300	300
15.915	15.915
0,100	0,100
3.183	3.183
6	6
3	6
57,29	114,59
0,07071	0,10000
dry / air / minimum lub. / emulsion	dry / air / minimum lub. / emulsion
Internal External	Internal External

Remarks

Sidemilling and Slotting with same tool.
Excellent surface finish, no wear on the tool.