

Machine	Röders RFM 760		
Spindle type	Fisher		
Max RPM	42.000		
Power Kw			
Cutter holder	Hydrolic Holder		
Workpiece material	SGL Graphite		
Hardness	R8500		
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"/>	Circular	<input type="checkbox"/>
Plunging	<input type="checkbox"/>		

Sketch

Workpiece; 60 x 45 x 70 mm

Cutter supplier	
Cutter description	
Cutter diameter eff.	Ød mm
Number of teeth	z
Carbide grade	
<b>Cutting conditions</b>	
Cutting speed	V <sub>c</sub> m/min
Revolution	n rpm
Feed per tooth	f <sub>z</sub> mm
Table feed	V <sub>f</sub> mm/min
Depth of cut	a <sub>p</sub> mm
Width of cut	a <sub>e</sub> mm
Length of cut	L mm
Chip removal rate	Q cm <sup>3</sup> /min
Coolant type	
Coolant pressure	Bar
Cutting time / comp	T <sub>comp</sub> min
Toollife	T <sub>total</sub> min
Power consumption	P Kw
Edge wear	V <sub>b</sub> mm

Test 1	Test 2
<b>van Hoorn Carbide</b>	<b>Competitor</b>
VHGR 2 080 078 08 02	
8	12
**	3
02	TIAIN coated

503	302
20.000	8.000
**	0,167
4.500	4.000
8	1,5
8	12
288,00	72,00
dry / air minimum lub. / emulsion	dry / air minimum lub. / emulsion
Internal External	Internal External
40 Sec	2M 37 Sec

Remarks

Roughing of workpiece. Total depth of cut is 45mm.  
 Product is clamped in easy clamping system.  
 Difference in Cutting time is high because of the cutting depth.