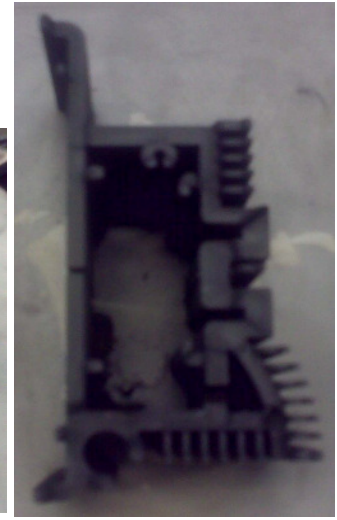


Test report no: 010-10

Machine	Bostomatic BMC12	
Spindle type	HSK40	
Max RPM	30.000	
Power Kw		
Cutter holder	Shrink Holder	
Workpiece material	Graphite	
Hardness		
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	Competitor
VHGTF30300500302	
3	3
3	4
02	Uncoated

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

278	264
29.500	28.000
0,008	0,004
720	400
0,1	0,1
0,2	0,2
0,014	0,008
0,00210	0,00092
dry / air / minimum lub. / emulsion	dry / air / minimum lub. / emulsion
Internal External	Internal External
420	80

Remarks

Almost doubled chip removal rate.
Toollife more than 5 times.