

Machine	CMS	
Spindle type		
Max RPM	10.000	
Power Kw		
Cutter holder	Shrink Holder	
Workpiece material	Hextool ©	
Hardness	83 HB	
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	
VHDB 2 100 078	
10	
2	
Diamond	

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

314	
10.000	
0,150	
3.000	
0,35	
0,35	
0,37	
0,02806	
dry / air / minimum lub. / emulsion	dry / air / minimum lub. / emulsion
Internal External	Internal External
14 H 10 M	

Remarks

Finishing application with VHDB endmill, on Aerospace composite material
 After 14 H 10 M continuously cut, there was very less wear visible.
 (V_b > 0,08mm)