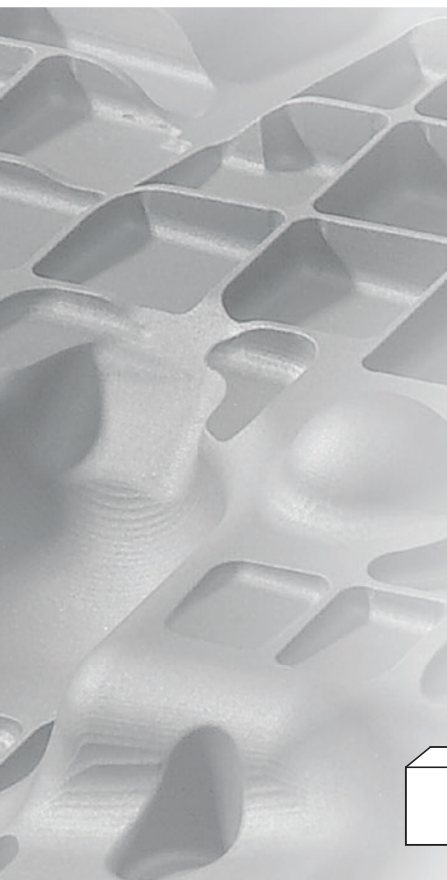


Material group	TSR (N/mm ²)	Hardness HB	Cutting speed Vc m/min	Coolant
N5.1	< 500	< 150	350 - 650	emulsion / air
N5.2	< 400	< 120	200 - 500	emulsion / air
N5.3	< 350	< 100	350 - 500	emulsion / air
N5.4			400 - 1000	emulsion / air
N5.5			400 - 1000	emulsion / air
N5.6			< 700	emulsion / air



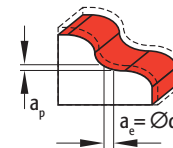
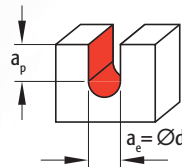
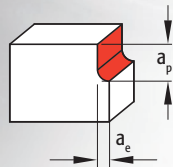
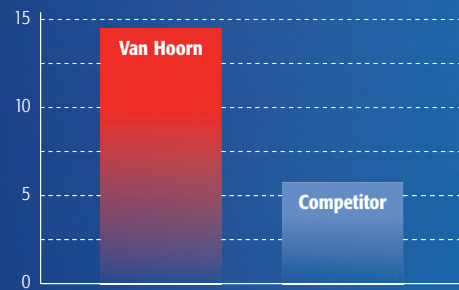
VHDB2100078

Workpiece Material: Hextool

Hardness: Aerospace Material

	Van Hoorn	Competitor
v_c	314 m/min	377 m/min
n	10000 rpm	10000 rpm
F_z	0,15 mm/t	0,10 mm/t
v_f	3000 mm/min	2600 mm/min
a_p	0,35 mm	0,35 mm
a_e	0,35 mm	0,35 mm
Coolant	dry	dry
Q	0,37 mm³/min	0,32 mm³/min
Toollife	14 h 10 min	5 h 33 min

Tool life Lebensdauer



Ød (mm)	Shoulder milling / Stirnfräsen			Slot milling / Nutenfräsen			Profile milling / Profilfräsen		
	a _p max. (mm)	a _e max. (mm)	f _t (mm/tooth)	a _p max. (mm)	a _e max. (mm)	f _t (mm/tooth)	a _p max. (mm)	a _e max. (mm)	f _t (mm/tooth)
3,0	< 1,95	< 1,2	0,020 - 0,030	< 0,6	3,0	0,010 - 0,020	< 0,6	< 0,3	0,020 - 0,030
4,0	< 2,60	< 1,6	0,030 - 0,045	< 0,8	4,0	0,020 - 0,040	< 0,8	< 0,4	0,030 - 0,045
5,0	< 3,25	< 2,0	0,040 - 0,060	< 1,0	5,0	0,030 - 0,045	< 1,0	< 0,5	0,040 - 0,060
6,0	< 3,90	< 2,4	0,050 - 0,070	< 1,2	6,0	0,040 - 0,060	< 1,2	< 0,6	0,050 - 0,070
8,0	< 5,20	< 3,2	0,060 - 0,080	< 1,6	8,0	0,050 - 0,070	< 1,6	< 0,8	0,060 - 0,080
10,0	< 6,50	< 4,0	0,070 - 0,100	< 2,0	10,0	0,060 - 0,080	< 2,0	< 1,0	0,070 - 0,100
12,0	< 7,80	< 4,8	0,090 - 0,120	< 2,4	12,0	0,080 - 0,100	< 2,4	< 1,2	0,080 - 0,120