

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

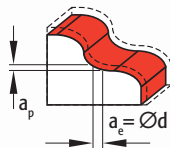
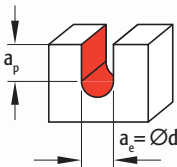
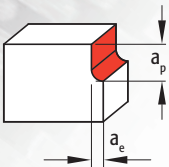
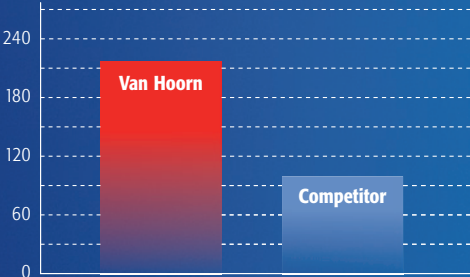
VHDT2060078R05

Workpiece Material: T800 M21

Hardness: Aerospace Material

	Van Hoorn	Competitor
v _c	283 m/min	283 m/min
n	15000 rpm	15000 rpm
F _z	0,10 mm/t	0,10 mm/t
v _f	3000 mm/min	3000 mm/min
a _p	4,0 mm	4,0 mm
a _e	6,0 mm	6,0 mm
Coolant	emulsion	emulsion
Q	72,0 mm ³ /min	72,0 mm ³ /min
Toollife	214 min	94 min

Tool life
Lebensdauer



Shoulder milling / Eckfräsen			
Ød (mm)	a _p max. (mm)	a _e max. (mm)	f _z (mm/tooth)
3,0	< 1,95	< 1,20	0,020 - 0,030
4,0	< 2,60	< 1,60	0,030 - 0,045
5,0	< 3,25	< 2,00	0,040 - 0,060
6,0	< 3,90	< 2,40	0,050 - 0,070
8,0	< 5,20	< 3,20	0,060 - 0,080
10,0	< 6,50	< 4,00	0,070 - 0,100
12,0	< 7,80	< 4,80	0,090 - 0,120

Slot milling / Nutenfräsen			
Ød (mm)	a _p max. (mm)	a _e max. (mm)	f _z (mm/tooth)
3,0	< 0,60	< 3,0	0,010 - 0,020
4,0	< 0,80	< 4,0	0,020 - 0,040
5,0	< 1,00	< 5,0	0,030 - 0,045
6,0	< 1,20	< 6,0	0,040 - 0,060
8,0	< 1,60	< 8,0	0,050 - 0,070
10,0	< 2,00	< 10,0	0,060 - 0,080
12,0	< 2,40	< 12,0	0,080 - 0,100

Profile milling / Profilfräsen			
Ød (mm)	a _p max. (mm)	a _e max. (mm)	f _z (mm/tooth)
3,0	< 0,60	< 0,30	0,020 - 0,030
4,0	< 0,80	< 0,40	0,030 - 0,045
5,0	< 1,00	< 0,50	0,040 - 0,060
6,0	< 1,20	< 0,60	0,050 - 0,070
8,0	< 1,60	< 0,80	0,060 - 0,080
10,0	< 2,00	< 1,00	0,070 - 0,100
12,0	< 2,40	< 12,0	0,080 - 0,120