

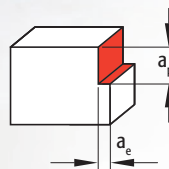
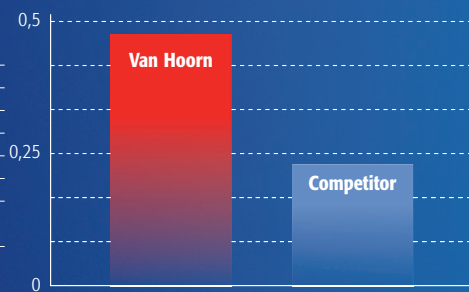
Material group	TSR (N/mm ²)	Hardness HB	Cutting speed	Coolant
			Vc m/min	
P1.1	< 750	< 250	130 - 180	emulsion
P1.2	< 1000	< 300	100 - 160	emulsion
P1.3	< 1400	< 400	90 - 140	emulsion
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H2.1		42-50 HRc	150 - 200	min.lub.
H2.2		50-55 HRc	120 - 180	min.lub.
H2.3		55-70 HRc	80 - 150	min.lub.



VHMF60600640603
Workpiece Material: 1.2343
Hardness: 52 HRC

Material removal rate Zerspanungsleistung

	Van Hoorn	Competitor
v_c	132 m/min	132 m/min
n	7000 rpm	7000 rpm
F_z	0,036 mm/t	0,029 mm/t
v_f	1500 mm/min	800 mm/min
a_p	0,1 mm	0,1 mm
a_e	3,0 mm	3,0 mm
Coolant	min. lubrication	min. lubrication
Q	0,45 mm³/min	0,24 mm³/min



Shoulder milling / Eckfräsen

Ød (mm)	P1.1 / P1.2 / P1.3		
	a _p max. (mm)	a _e max. (mm)	f _z (mm/tooth)
3,0	< 6,0	< 0,30	0,020 - 0,035
4,0	< 8,0	< 0,40	0,030 - 0,045
5,0	< 10,0	< 0,50	0,035 - 0,055
6,0	< 12,0	< 0,60	0,045 - 0,65
8,0	< 16,0	< 0,80	0,060 - 0,080
10,0	< 20,0	< 1,00	0,070 - 0,095
12,0	< 24,0	< 1,20	0,085 - 0,110
16,0	< 32,0	< 1,60	0,095 - 0,125
20,0	< 40,0	< 2,00	0,105 - 0,140

Shoulder milling / Eckfräsen

H2.1 / H2.2 / H2.3		
a _p max. (mm)	a _e max. (mm)	f _z (mm/tooth)
< 6,0	< 0,06	0,020 - 0,035
< 8,0	< 0,10	0,030 - 0,045
< 10,0	< 0,12	0,035 - 0,055
< 12,0	< 0,18	0,045 - 0,650
< 16,0	< 0,24	0,060 - 0,080
< 20,0	< 0,30	0,070 - 0,095
< 24,0	< 0,36	0,085 - 0,110
< 32,0	< 0,48	0,095 - 0,125
< 40,0	< 0,60	0,105 - 0,140