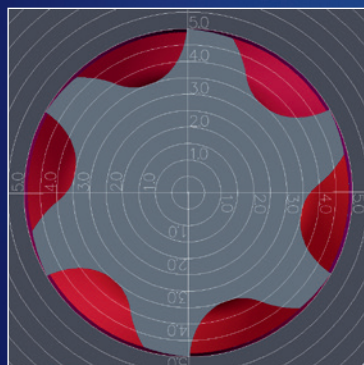


Material group	TSR (N/mm ²)	Hardness	Cutting speed Vc m/min	Coolant
H2.2		50-55 HRc	110 - 170	min.lub.
H2.3		55-70 HRc	80 - 140	min.lub.

Negative rake angle Negativer Spanwinkel

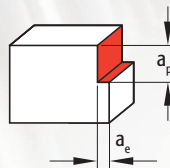


Workpiece Material: 1.2379
Hardness: 60HrC

	Van Hoorn	Competitor
v_c	101 m/min	101 m/min
n	3200 rpm	3200 rpm
F_z	0,052 mm/t	0,04 mm/t
Z	6	4
v_f	1000 mm/min	512 mm/min
a_p	18 mm	18 mm
a_e	0,1 mm	0,1 mm
Coolant	air	air
Q	1,8 cm³/min	0,9 cm³/min

For an extra charge we offer an inspection report of the tool geometry.

Auf Wunsch erhalten Sie zu jedem Werkzeug ein separates Prüfprotokoll (aufpreispflichtig).



Hardened material
Gehärtete Werkstoffe

a_p up to 2,00 x d
a_e up to 0,02 x d

Shoulder milling / Eckfräsen

Ød (mm)	a _p max. (mm)	a _e max. (mm)	f _z (mm/tooth)
3,0	< 3,0	< 0,03	0,020 - 0,035
4,0	< 6,0	< 0,05	0,030 - 0,045
5,0	< 7,5	< 0,07	0,035 - 0,055
6,0	< 12,0	< 0,10	0,045 - 0,065
8,0	< 16,0	< 0,13	0,060 - 0,080
10,0	< 20,0	< 0,17	0,070 - 0,095
12,0	< 24,0	< 0,21	0,085 - 0,110
16,0	< 32,0	< 0,28	0,095 - 0,125
20,0	< 40,0	< 0,35	0,105 - 0,140