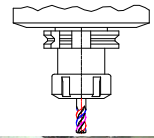


Test report no: 031-11

Machine			
Spindle type			
Max RPM	12.000		
Power Kw			
Cutter holder	Collet Chuck		
Workpiece material	1.1186		
Hardness	C40		
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	van Hoorn Carbide
	HAMF 8 200 102 20 03 050	HAMF 8 200 102 20 03 050
	20	20
	8	8
	03	03

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	Hm 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

	170	377
	2.700	6.000
	0,110	0,056
	2.370	2.700
	35,5	35,5
	0,2	0,05
	16,83	4,79
	0,01097	0,00281
	dry / air / minimum lub. / emulsion	dry / air / minimum lub. / emulsion
	Internal External	Internal External

Remarks

Test 1. Semi-finish of wall.

Test 2. Finishing of wall with same tool. Ra < 0,5. Straightness of wall is within 0,001mm.