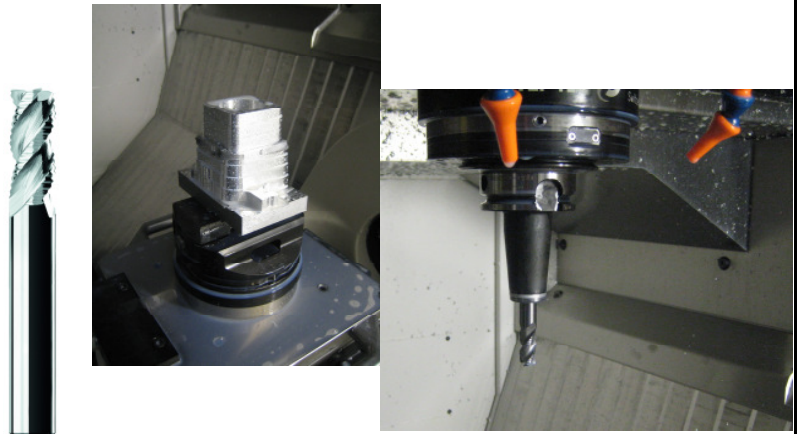


Machine	Mikron HSM600U
Spindle type	Step-Tec
Max RPM	24.000
Power Kw	
Cutter holder	Shrink Holder
Workpiece material	Alu 51 ST
Hardness	-
Application	
Side milling	<input checked="" type="checkbox"/> Up-milling <input type="checkbox"/>
Slotting	<input type="checkbox"/> Down-milling <input type="checkbox"/>
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	Competitor
VHRAW 3120 078 12 15	
12	12
3	2
15	Uncoated

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	H _m 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

829	829
22.000	22.000
0,067	0,100
4.400	4.400
12	3
5,5	9
290,40	118,80
0,04513	0,08660
dry / air / minimum lub. <u>emulsion</u>	dry / air / minimum lub. <u>emulsion</u>
Internal <u>External</u>	Internal <u>External</u>
5 M 32 S	9 M 22 S

Remarks