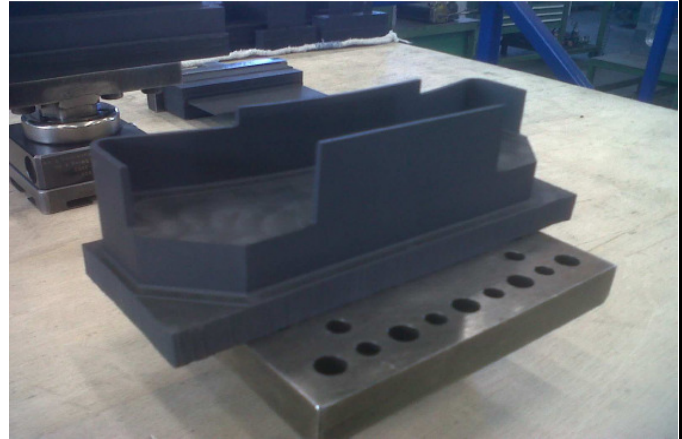


Machine	Parpas FA Speed 2	
Spindle type		
Max RPM	30.000	
Power Kw		
Cutter holder	Shrink Holder	
Workpiece material	Graphite	
Hardness	TME-103	
Application		
Side milling	<input checked="" type="checkbox"/>	Up-milling <input type="checkbox"/>
Slotting	<input type="checkbox"/>	Down-milling <input type="checkbox"/>
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
<b>van Hoorn Carbide</b>	<b>Competitor</b>
VHGTF 4 080 064 08 02S	
8	8
4	4
02	Diamond

Cutting conditions	
Cutting speed	V <sub>c</sub> m/min
Revolution	n rpm
Feed per tooth	f <sub>z</sub> mm
Table feed	V <sub>f</sub> mm/min
Depth of cut	a <sub>p</sub> mm
Width of cut	a <sub>e</sub> mm
Length of cut	L mm
Chip removal rate	Q cm <sup>3</sup> /min
Chip thickness	Hm mm
Coolant type	
Coolant pressure	Bar
Cutting time / comp	T <sub>comp</sub> min
Toollife	T <sub>total</sub> min
Power consumption	P Kw
Edge wear	V <sub>b</sub> mm

578	578
23.000	23.000
0,057	0,051
5.200	4.700
0,2	0,2
0,2	0,2
0,208	0,188
0,00894	0,00808
dry / <u>air</u> / minimum lub. / emulsion	dry / <u>air</u> / minimum lub. / emulsion
Internal <u>External</u>	Internal <u>External</u>
40 Min	45 Min

Remarks

Test against competitor; advantages for Van Hoorn tool;  
 Approx. 5 hours longer toollife, less vibration and higher feedrate.  
 Better surface finish and smaller dimensions on the product.