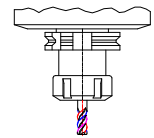
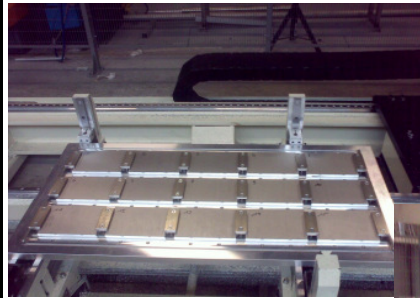


Machine	Mubea Systems		
Spindle type	HSK40		
Max RPM	22.000		
Power Kw	11		
Cutter holder	Collet Chuck		
Workpiece material	AlMgSi1		
Hardness	-		
Application			
Side milling	<input type="checkbox"/>	Up-milling	<input type="checkbox"/>
Slotting	<input checked="" type="checkbox"/>	Down-milling	<input 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
VHAE10300380310	
3	3
1	1
10	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

203	207
21.500	22.000
0,056	0,020
1.200	440
1,5	1,5
3	3
5,40	1,98
0,05581	0,02000
dry / air <u>minimum lub.</u> / emulsion	dry / air <u>minimum lub.</u> / emulsion
Internal <u>External</u>	Internal <u>External</u>

Remarks

At 22.000 rpm there is some vibration visible.
 Feedrate is more than doubled against competitor.
 No toolwear visible after testing.