

Machine	Mikron VCP600
Spindle type	Step-Tec
Max RPM	20.000
Power Kw	23
Cutter holder	Weldon
Workpiece material	PA 6
Hardness	Synthetic
Application	
Side milling	<input checked="" 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"/>



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>Van Hoorn Carbide</b>
VHLA 3 200 102 20 15	VHLA 3 200 102 20 15
20	20
3	3
15	15

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	H <sub>m</sub> 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

503	503
8.000	8.000
0,183	0,183
4.400	4.400
20	10
20	15
1760,00	660,0
0,18333	0,15877
<b>dry</b> / air / minimum lub. / emulsion	<b>dry</b> / air / minimum lub. / emulsion
Internal External	Internal External
0 - 15 %	0 - 5 %

Remarks

Milling of synthetic material PA 6. No problems with burrs or surface finish  
 Very high chip removal rate.