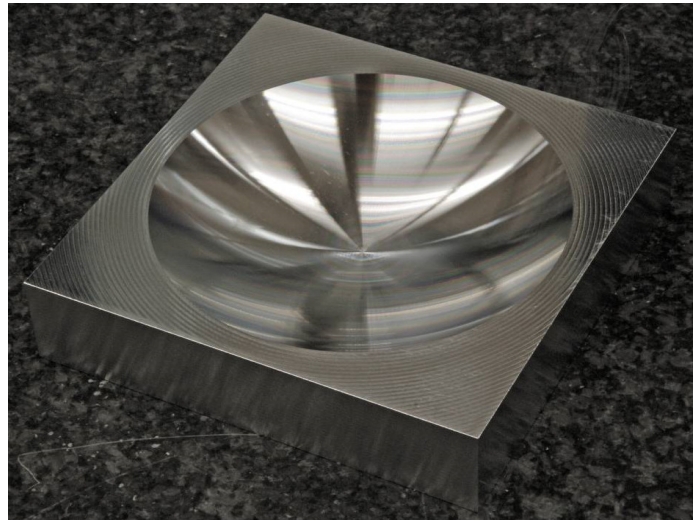


Test report no: 019-11

Machine	Hembrug NF 425	
Spindle type		
Max RPM	32.000	
Power Kw		
Cutter holder	Shrink Holder	
Workpiece material	3.2315	
Hardness	Alu 51 ST	
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	
VHDT 2 060 078 R10	
6	
2	
Diamond	

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

584	
31.000	
0,016	
1.000	
0,5	
0,5	
0,25	
0,00466	
dry / air / minimum lub. / emulsion	dry / air / minimum lub. / emulsion
Internal External	Internal External
2H 28M	

Remarks

No wear visible after 11 products
Finishing of Product