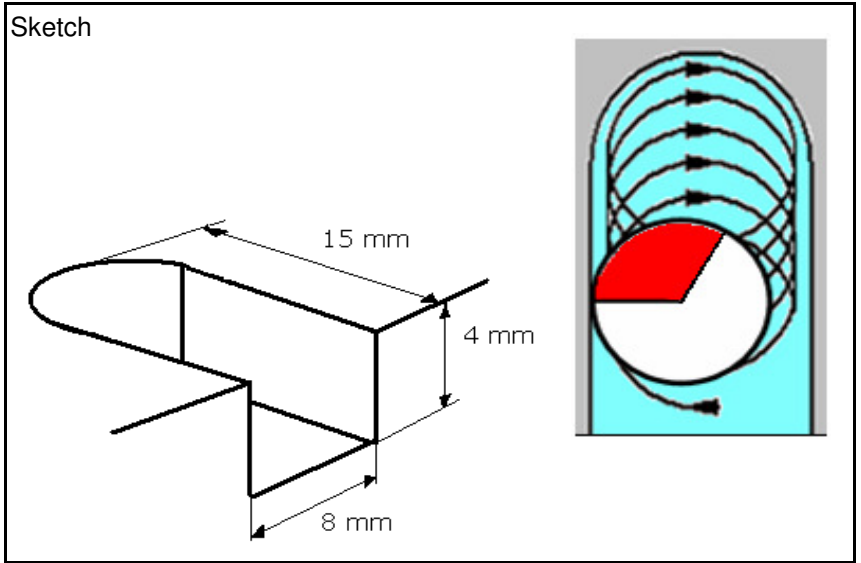


Machine	DMG 80T	
Spindle type		
Max RPM	12.000	
Power Kw		
Cutter holder	Shrink Holder	
Workpiece material	1.2379 Sverker21	
Hardness	62 HRc	
Application		
Side milling	<input checked="" type="checkbox"/>	Up-milling <input type="checkbox"/>
Slotting	<input type="checkbox"/>	Down-milling <input type="checkbox"/>
Profiling	<input type="checkbox"/>	Ramping <input type="checkbox"/>
Plunging	<input type="checkbox"/>	Circular <input type="checkbox"/>



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>
VHPM 6 040 064 06 40	
4	4
6	4
40	TiAlN coated

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 <sup>3</sup> /min
Coolant type	
Coolant pressure	Bar
Cutting time / comp	$T_{comp}$ min
Toollife	$T_{total}$ min
Power consumption	P Kw
Edge wear	$V_b$ mm

101	101
8.000	8.000
0,021 - 0,031	0,023 - 0,031
1000 - 1500	750 - 1000
4	0,2
0,1	4
0,4 - 0,6	0,6 - 0,8
dry / air / minimum lub. / emulsion	dry / air / minimum lub. / emulsion
Internal External	Internal External
1M 32S	4M 44S
not visible	

Remarks

Test 1: Started with coolant air, but due to uneffective coolant, second pocket made with emulsion  
 No wear visible on endmill. **3 Times faster due to different strategy.**