

Test report no: 063-04

| | | |
|--------------------|-------------------------------------|---------------------------------------|
| Machine | Supermax 102A | |
| Spindle type | BT 40 | |
| Max RPM | 10.000 | |
| Power Kw | 7,5 | |
| Endmill holder | Collet Chuck | |
| Workpiece material | 1.2379 | |
| Hardness | 54 HRc | |
| Application | Up-milling | <input type="checkbox"/> |
| Side milling | <input type="checkbox"/> | Down-milling <input type="checkbox"/> |
| Slotting | <input type="checkbox"/> | Circular <input type="checkbox"/> |
| Profiling | <input checked="" type="checkbox"/> | Pulling <input type="checkbox"/> |
| Plunging | <input type="checkbox"/> | Pushing <input type="checkbox"/> |

Sketch



Final component after finishing with ballnose endmill. size 170 x 100 x 50 mm

| | |
|---------------------------|------------------------|
| Endmill supplier | |
| Endmill description | |
| Endmill diameter | Ød mm |
| Number of teeth | z |
| Carbide grade | |
| 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 |
| Coolant type | |
| Coolant pressure | Bar |
| Cutting time / comp | T_{comp} min |
| Toollife | T_{total} min |
| Power consumption | P Kw |
| Edge wear | V_b mm |

| Test 1 | Test 2 |
|--------------------------|--------------------------|
| van Hoorn Carbide | van Hoorn Carbide |
| VHTF 2 060 078 06 03 | VHTF 2 060 078 06 03 |
| 6 | 6 |
| 2 | 2 |
| 03 | 03 |

| | |
|-------------------------------------|-------------------------------------|
| 220 | 220 |
| 10.000 | 10.000 |
| 0,100 | 0,100 |
| 2.000 | 2.000 |
| 0,25 | 0,15 |
| 3,0 | 0,15 |
| 1,5 | 0,045 |
| dry / air / minimum lub. / emulsion | dry / air / minimum lub. / emulsion |
| Internal External | Internal External |
| | |
| | |
| | |

Remarks

Test 1: Semi-finishing application

Test 2: Finishing application