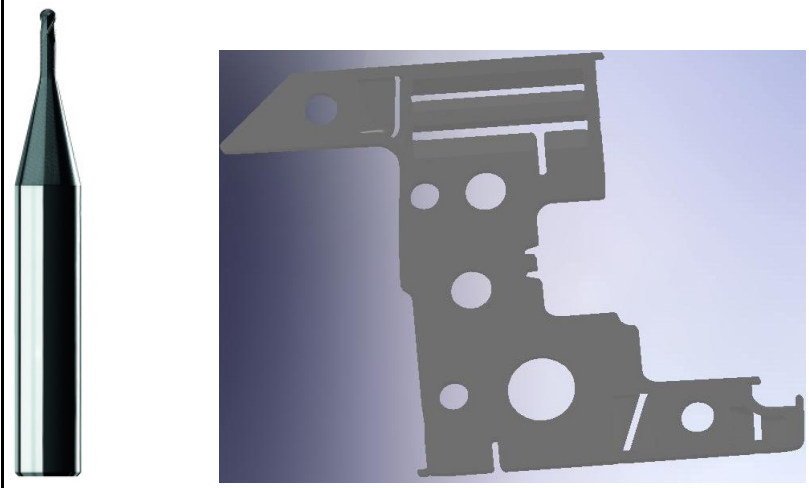


Machine	Mikron UCP600
Spindle type	HSK63
Max RPM	24.000
Power Kw	
Cutter holder	Shrink Holder
Workpiece material	1.2312
Hardness	Holdax
Application	
Side milling	<input checked="" type="checkbox"/> Up-milling <input type="checkbox"/>
Slotting	<input checked="" type="checkbox"/> Down-milling <input type="checkbox"/>
Profiling	<input type="checkbox"/> Ramping <input type="checkbox"/>
Plunging	<input type="checkbox"/> Circular <input type="checkbox"/>

Sketch



Cutter supplier	
Cutter description	
Cutter diameter eff.	Ød mm
Number of teeth	z
Carbide grade	

Test 1	Test 2
van Hoorn Carbide	van Hoorn Carbide
VHMSK20250640603L100	VHMSK20250640603L250
2,5	2,5
2	2
03	03

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

185	185
23.500	23.500
0,020	0,020
940	940
0,25	0,25
0,25	0,25
0,059	0,059
0,00632	0,00632
dry / air / minimum lub. / emulsion	dry / air / minimum lub. / emulsion
Internal External	Internal External
50 Min.	160 Min.

Remarks

Roughing of material with two tools. Total depth of the cavity is 25mm.
Endmill has no wear visible.