



## Milling-parameter ebaboard L-1



$$vc = \frac{n \cdot \pi \cdot d}{1000} \quad [\text{m/min}]$$

$$fz = \frac{vf}{z \cdot n} \quad [\text{mm}]$$

$$n = \frac{vc \cdot 1000}{d \cdot \pi} \quad [1/\text{min}]$$

$$vf = n \cdot fz \cdot z \quad [\text{mm/min}]$$

Technical datas	Machining 1	Machining 2	Machining 3	Machining 4	Machining 5	Machining 6	Machining 7
Strategie		Profile roughing	Roughing Pocket	Roughing Residual material Z - constant	Finishing face milling	Finishing Z - constant	Engraving
Type of milling cutter	EMZ90 V22.042TH050 (1043249)	EBG T25.025AN190 (6121224)	Airline end mill (1110912)	EBG V12.012AN120-C (6128023)	EBG V10.010AN120-C (6130578)	EBG R08.008AP100-C (9148824)	Airline ball (1121894)
indexable inserts	VCGT 220530-ALM (1069759)	WPR 25 AS (9120404)	-	WPB 12 CF 20 (6128107)	WPB 10 CF 10 (6129238)	WPR 08 DN (6131629)	-
Cutting diameter [mm]	42	25	12	12	10	8	2
Number of tool cutting edges	3	2	3	2	2	2	2
Radius [mm]	3	12,5	1	2	1	4	1
Cutting speed <b>vc</b> [m/min]	660	750	500	500	450	450	113
Revolutions <b>n</b> [1/min]	5000	9500	13262	13262	14323	18000	18000
feed per tooth <b>fz</b> [mm]	0,73	0,52	0,2	0,3	0,15	0,1	0,1
Feed rate <b>vf</b> [mm/min]	11000	10000	7957	7957	4297	3600	3600
Axial depth of cut <b>ap</b> [mm]	5	2,5	10	2	0,5	0,2	0,5
Radial depth of cut <b>ae</b> [mm]	30	3	6	8	6	0,5	0
Run time [min]	6	10	1	4	3,5	80	2
Dustformation	low	low	none	none	none	none	none