



Milling-parameter ebaboard 1220

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

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

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

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

| 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 V16.016AN140 | DHC Ø12 INOX | EBG V12.012AN120-C (6128023) | EBG V12.012AN120-C (6128023) | EBG R08.008AP100-C (9148824) | Airline ball (1121894) |
| indexable inserts | VCGT 220530-ALM (1069759) | WPB 16 AF 30 | - | WPB 12 CF 20 (6128107) | WPB 10 CF 10 (6129238) | WPR 08 DN (6131629) | - |
| Cutting diameter [mm] | 42 | 16 | 12 | 12 | 10 | 8 | 2 |
| Number of tool cutting edges | 3 | 2 | 4 | 2 | 2 | 2 | 2 |
| Radius [mm] | 3 | 3 | 0 | 2 | 1 | 4 | 1 |
| Cutting speed vc [m/min] | 500 | 500 | 340 | 500 | 408 | 327 | 100 |
| Revolutions n [1/min] | 3789 | 9947 | 9000 | 13262 | 13000 | 16000 | 16000 |
| feed per tooth fz [mm] | 0,5 | 0,4 | 0,15 | 0,3 | 0,18 | 0,13 | 0,1 |
| Feed rate vf [mm/min] | 5684 | 7957 | 5304 | 7957 | 4774 | 4160 | 3180 |
| Axial depth of cut ap [mm] | 5 | 2,5 | 10 | 2 | 0,5 | 0,2 | 0,3 |
| Radial depth of cut ae [mm] | 30 | 3 | 6 | 8 | 6 | 0,5 | 0 |
| Run time [min] | 7 | 10 | 1 | 0,5 | 8 | 110 | 1 |
| Dustformation | none | low | none | none | none | none | none |