

Technical information

Art.-Nr. 233 / 1 - Fightmax STEEL - example Toolox

33

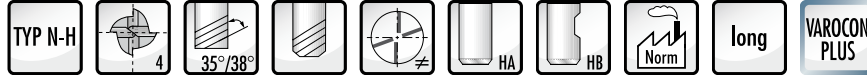


VHM - Schafffräser Fightmax

Art.-Nr. **233** Flutes **4**



Tool data



Tool recommendation



Capabilities



Areas of application and special features

High-quality HPC multi-twist cutter with micro geometry, new solid carbide and polished high performance coating Varacon Plus especially for steel. The Fightmax uses a new milling cutter front for better dipping and ramp cutting.

Competitive advantages and profitability

The durability was increased by a special edge finishing and better production tolerances. Best results in 16MnCr5, 42CrMo4 and Toolox 33.

Competition to Hoffmann, Hanita, Maier

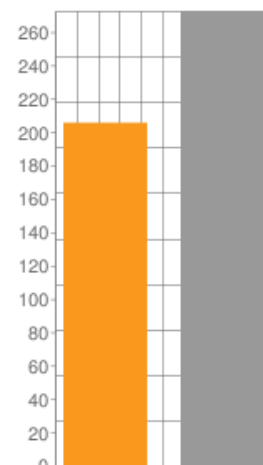
Example application

Art.-Nr.: **23312010**
Material: **Tempering steel < 1000 N/mm² (< 32 HRC)**

Competitor: **Deutschland**
Art.-Nr.:

Inovatools			
D1	12,00	mm	Diameter
z	4		Flutes
ae	11,000	mm	Row pitch
ap	12,000	mm	Cutting depth
vc	184,64	m/min	Cutting speed
n	4898	U/min	Rotation speed
fz	0,06016	mm	Feed per tooth
vf	1178,52	mm/min	Feed rate
Q	155,56424172	cm ³ /min	Material removal rate
hm	0,04315	mm	Middle chipping thickness
K/M	120	€/std	Machine hourly cost
K/W	85	€	Tool cost
T	54,87	min	Tool life
V	9072	cm ³	Processing volume
Tb	58,32	min	Process time
€/Ws	206,98	€	Cost workpiece

Efficiency
€/Ws (€/Workpiece)



Calculator			
D1	12,00	mm	Diameter
z	4		Flutes
ae	11	mm	Row pitch
ap	12	mm	Cutting depth
vc	180,01	m/min	Cutting speed
n	4775	U/min	Rotation speed
fz	0,06000	mm	Feed per tooth
vf	1145,98	mm/min	Feed rate
Q	151,26926130	cm ³ /min	Material removal rate
hm	0,04304	mm	Middle chipping thickness
K/M	120	€/std	Machine hourly cost
K/W	81,6	€	Tool cost
T	32,06	min	Tool life
V	9072	cm ³	Processing volume
Tb	59,97	min	Process time
€/Ws	272,58	€	Cost workpiece

