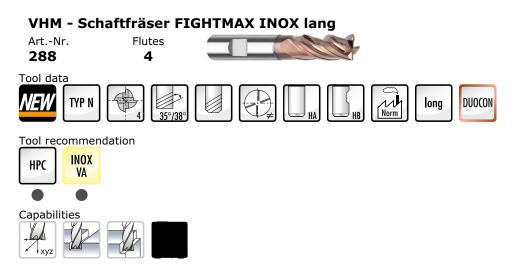


Technical information

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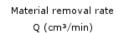
HPC-tool with the latest micro geometry for INOX machining, unequal divided, with an unequal helix and additional defined cutting edge rounding.

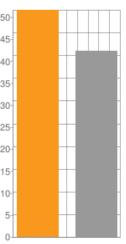
Competitive advantages and profitability

Highest tool life with moderate cutting data.

Example application

ArtN Mater			onstant steels <700 N/I	nm² (<2	05 HB)
		Inovato	ols –		
D1	12,00	mm	Diameter		Material
z	4		Flutes		Q (c
ae	6,000	mm	Row pitch	50-	
ар	12,000	mm	Cutting depth	45-	_
vc	130,00	m/min	Cutting speed		
n	3448	U/min	Rotation speed	40-	
fz	0,05200	mm	Feed per tooth	35-	
vf	717,26	mm/min	Feed rate	30-	
Q	51,64259593	cm³/min	Material removal rate	25-	
hm	0,03310	mm	Middle chipping thickness	20-	
K/M		€/std	Machine hourly cost	15-	
K/W		€	Tool cost	10-	
т		min	Tool life	5	
v		cm³	Processing volume	0	
Тb		min	Process time		
€/Ws		€	Cost workpiece	-	





Comp ArtN		Wettbewerber Europa								
	Calculator									
D1	12,00	mm	Diameter							
z	4		Flutes							
ae	6	mm	Row pitch							
ар	12	mm	Cutting depth							
vc	110,01	m/min	Cutting speed							
n	2918	U/min	Rotation speed							
fz	0,05000	mm	Feed per tooth							
vf	583,62	mm/min	Feed rate							
Q	42,02064000	cm³/min	Material removal rate							
hm	0,03183	mm	Middle chipping thickness							
K/M		€/std	Machine hourly cost							
K/W		€	Tool cost							
Т		min	Tool life							
v		cm³	Processing volume							
Тb		min	Process time							
€/Ws		€	Cost workpiece							



Cutting data and application recommendations

Art.-Nr. 288 / 1 - Fightmax INOX

	Caption: Ideal Good Applicable Limited applicable		D1	D1	D1 10,00	D1 12,00	D1 16,00	D1								
ap: 1,00 G ae: 1,00 A			6,00	8,00				20,00								
Material	vc m/mir	φ Grad	fz mm	fz mm	fz mm	fz mm	fz mm	fz mm	fz mm	fz mm	fz mm	fz mm	fz mm	fz mm	fz mm	fz mm
General steels <500 N/mm² (<150 HB)																
General steels <700 N/mm² (<205 HB)																
Tempering steel <850 N/mm² (<25 HRC))															
Tempering steel <1000 N/mm² (<32 HR)	C)															
Tempering steel <1400 N/mm² (<44 HR)	C)															
Hardened steel 45-55 HRC (1400-2000	N/mmª															
Hardened steel 55-60 HRC (>2000 N/mm	n²)															
Hardened steel 60-65 HRC																
Cast iron <180HB																
Malleable cast iron																
Cast iron with nodular graphite																
Aluminium long-chipping																
Aluminium short-chipping																
Aluminium alloyed over >8% S																
Copper, brass, bronze, red brass																
Plastics - thermoplast																
Plastics - duroplast																
GFK/CFK (fibreglass/carbon fibre plastics)															
Graphite																
Rust and acid constant steels <700 N/mm	n² (<2(110	50	0,021	0,027	0,034	0,044	0,063	0,084								
Rust and acid constant steels >700 N/mm	n² (>2(81	30	0,017	0,022	0,027	0,035	0,050	0,067								
Inconel, Hastelloy, Nimonic, Monel																
Titanium																

	Caption: deal		D1	D1	D1	D1	D1	D1	D1	D1	D1	D1	D1	D1	D1	D1
ap: 1,00 G ae:0,50 A	Good Applicable .imited applic			8,00 fz mm	10,00 fz mm	12,00 fz mm	16,00 fz mm	20,00 fz mm	fz mm	fz	fz mm	fz	fz mm	fz mm	fz mm	fz
Material vc m/min		φ n Grad	fz mm													
General steels <500 N/mm² (<150 HB)																
General steels <700 N/mm² (<205 HB)																
Tempering steel <850 N/mm² (<25 HRC	:)															
Tempering steel <1000 N/mm² (<32 HR	C)															
Tempering steel <1400 N/mm² (<44 HR	C)															
Hardened steel 45-55 HRC (1400-2000	N/mm²															
Hardened steel 55-60 HRC (>2000 N/m	m²)															
Hardened steel 60-65 HRC																
Cast iron <180HB																
Malleable cast iron																
Cast iron with nodular graphite																
Aluminium long-chipping																
Aluminium short-chipping																
Aluminium alloyed over >8% S																
Copper, brass, bronze, red brass																
Plastics - thermoplast																
Plastics - duroplast																
GFK/CFK (fibreglass/carbon fibre plastics)																
Graphite																
Rust and acid constant steels <700 N/mm ² (<2(155 50		0,025	0,032	0,040	0,052	0,075	0,100									
Rust and acid constant steels >700 N/m	Rust and acid constant steels >700 N/mm ² (>2(115 30		0,020	0,026	0,032	0,042	0,060	0,080								
Inconel, Hastelloy, Nimonic, Monel																
Titanium																