

Technical information

Art.-Nr. 310 / 1 - example hardened steel



VHM - Schafffräser Hardmax

Art.-Nr. **310** Flutes **3, 4**



Tool data



Tool recommendation



Capabilities



Areas of application and special features

stable HPC mill for steel <60HRC
1,5xD roughing flute and profile flute for highest stability.

Competitive advantages and profitability

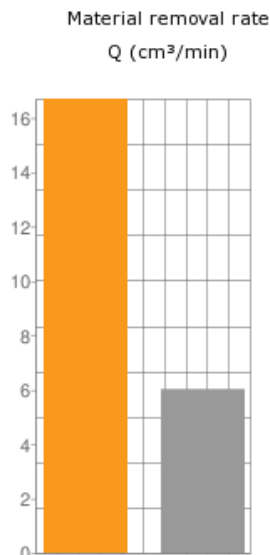
competition to Hitachi Epoch

Example application

Art.-Nr.: **310.100.10**
Material: **Tempered steels 45-55 HRC (1400-2000 N/mm²)**

Competitor:
Art.-Nr.:

Inovatools			
D1	10,00	mm	Diameter
z	4		Flutes
ae	10,000	mm	Row pitch
ap	4,000	mm	Cutting depth
vc	83,85	m/min	Cutting speed
n	2669	U/min	Rotation speed
fz	0,03912	mm	Feed per tooth
vf	417,69	mm/min	Feed rate
Q	16,70765917	cm ³ /min	Material removal rate
hm	0,02491	mm	Middle chipping thickness
K/M		€/std	Machine hourly cost
K/W		€	Tool cost
T		min	Tool life
V	240	cm ³	Processing volume
Tb	14,36	min	Process time
€/Ws		€	Cost workpiece



Calculator			
D1	10,00	mm	Diameter
z	4		Flutes
ae	1	mm	Row pitch
ap	12	mm	Cutting depth
vc	79	m/min	Cutting speed
n	2515	U/min	Rotation speed
fz	0,05	mm	Feed per tooth
vf	502,93	mm/min	Feed rate
Q	6,03515544	cm ³ /min	Material removal rate
hm	0,01554	mm	Middle chipping thickness
K/M		€/std	Machine hourly cost
K/W		€	Tool cost
T		min	Tool life
V	180	cm ³	Processing volume
Tb	29,83	min	Process time
€/Ws		€	Cost workpiece

