

## Technical information

Art.-Nr. 315 / 1 - example hardened steel

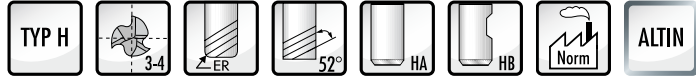


### VHM - Schafffräser Hardmax ER

Art.-Nr. **315** Flutes **3, 4**



#### Tool data



#### Tool recommendation



#### Capabilities



## Areas of application and special features

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

## Competitive advantages and profitability

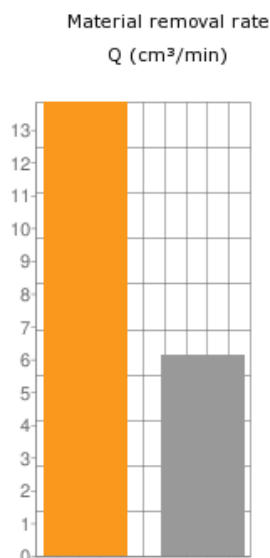
competition to Hitachi Epoch

## Example application

Art.-Nr.: **315.101.10**  
Material: **Tempered steels 45-55 HRC (1400-2000 N/mm<sup>2</sup>)**

Competitor: **Inovatools**  
Art.-Nr.: **315.101.10**

Inovatools – Finishing			
D1	10,00	mm	Diameter
z	4		Flutes
ae	5,000	mm	Row pitch
ap	10,000	mm	Cutting depth
vc	68,00	m/min	Cutting speed
n	2165	U/min	Rotation speed
fz	0,03200	mm	Feed per tooth
vf	277,06	mm/min	Feed rate
Q	13,85284625	cm <sup>3</sup> /min	Material removal rate
hm	0,02037	mm	Middle chipping thickness
K/M		€/std	Machine hourly cost
K/W		€	Tool cost
T		min	Tool life
V	240	cm <sup>3</sup>	Processing volume
Tb	17,32	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 <sup>3</sup> /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 <sup>3</sup>	Processing volume
Tb	29,83	min	Process time
€/Ws		€	Cost workpiece

