

Technical information

Art.-Nr. 734 / 1 - example tempering steel



VHM - Schafffräser Starmax ER

Art.-Nr. **734** Flutes **4**



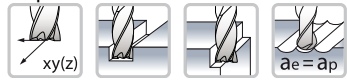
Tool data



Tool recommendation



Capabilities



Areas of application and special features

HPC bestseller in tempering steel <32 HRC
Uneven partition and uneven helix.

Competitive advantages and profitability

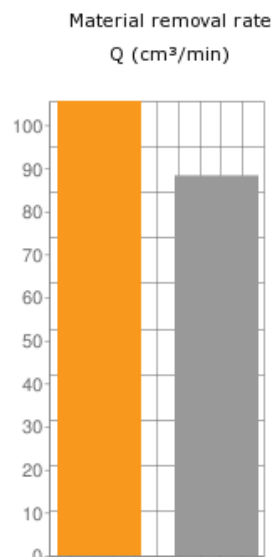
competition to Gühring, Hoffmann, WNT, Precitool, SGS and Widia

Example application

Art.-Nr.: **734.120.00**
Material: **Tempering steel <850 N/mm² (<25 HRC)**

Competitor: **Inovatools**
Art.-Nr.: **734.120.00**

Inovatools – Roughing			
D1	12,00	mm	Diameter
z	4		Flutes
ae	12,000	mm	Row pitch
ap	12,000	mm	Cutting depth
vc	109,60	m/min	Cutting speed
n	2907	U/min	Rotation speed
fz	0,06307	mm	Feed per tooth
vf	733,41	mm/min	Feed rate
Q	105,61165000	cm ³ /min	Material removal rate
hm	0,04015	mm	Middle chipping thickness
K/M		€/std	Machine hourly cost
K/W		€	Tool cost
T		min	Tool life
V	1056,12	cm ³	Processing volume
Tb	10	min	Process time
€/Ws		€	Cost workpiece



Calculator			
D1	12,00	mm	Diameter
z	4		Flutes
ae	6	mm	Row pitch
ap	12	mm	Cutting depth
vc	155	m/min	Cutting speed
n	4112	U/min	Rotation speed
fz	0,075	mm	Feed per tooth
vf	1233,45	mm/min	Feed rate
Q	88,80845825	cm ³ /min	Material removal rate
hm	0,04775	mm	Middle chipping thickness
K/M		€/std	Machine hourly cost
K/W		€	Tool cost
T		min	Tool life
V	3552,34	cm ³	Processing volume
Tb	40	min	Process time
€/Ws		€	Cost workpiece

