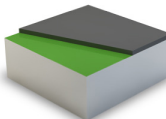


Summary of cutting data for Plain surface


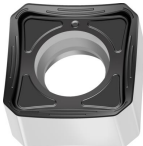
Material details
AISI/SAE, 1045, Hardness: 207 HB, Material group:P1.2.Z.AN

Task details

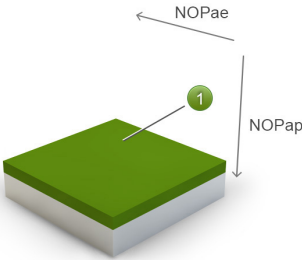


Plain surface

Operation type	Finishing
System stability	Excellent stability
Width	3.5 mm
Length	38.1 mm
Allowance depth of cut bottom	0.35 mm
Ra bottom	3.2 μm

Recommended solution									
Machining	Type of cooling	Description	Grade	T _{mf} [min:s]					
Face Milling	Dry	Xtratec XT	WKP35S	00:01.458					
<div></div> <div>Image similar</div>									
								Tool	M5009-040-T36-04-06-AP
								Type	Body
								No. of pieces	1
								Description	Xtratec XT
<div></div> <div>Image similar</div>									
								Tool	SNMX1205ANN-F27 WKP35S
								Type	Insert periphery (A) INS_A
								No. of pieces	4

Cutting data



Legend

1 Finishing

1

Working engagement (ae)	3.5	mm
Depth of cut (ap)	0.35	mm
Number of passes in AE direction (NOPae)	1	
Number of passes in AP direction (NOPap)	1	
Cutting speed (vc)	348	m/min
Spindle speed (n)	2680	1/min
Feed per tooth (fz)	0.3	mm
Feed speed at the contour (vfe)	3220	mm/min
Cutting power (Pc)	0.339	kW
Cutting torque (Mc)	1.21	Nm
Maximum chip thickness (hex)	0.0406	mm
Material removal rate (Q)	3.94	cm3/min
Total cutting time (Tc tot)	00:01.458	min:s
Tool life length (LifeLength)	148.28	m
Tool life time (LifeTime)	46	min

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