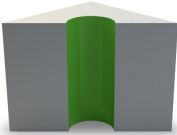



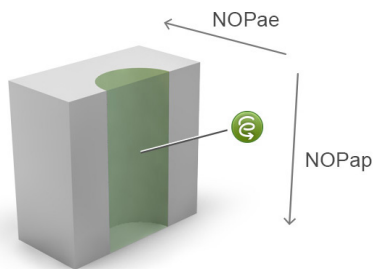
Summary of cutting data for Hole on solid material

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

Task details
<div></div> <div><div><div>Hole on solid material</div><div><div>Applicability for through hole</div><div>Yes</div></div><div><div>Diameter</div><div>22 mm</div></div><div><div>Tolerance class</div><div></div></div><div><div>Depth</div><div>8 mm</div></div><div><div>System stability</div><div>Excellent stability</div></div></div></div>

Recommended solution							
Machining	Type of cooling	Description	Grade	T <sub>mf</sub> [min:s]			
Pocket milling	Dry	Perform	WJ30ED	00:10.080			
<div><div></div><div><div>Tool</div><div>MC232-16.0W3BC-WJ30ED</div></div><div><div>Type</div><div>Body</div></div><div><div>No. of pieces</div><div>1</div></div><div><div>Description</div><div>Perform</div></div></div> <div>Image similar</div>							

# Cutting data



## Legend



Working engagement (ae)	11	mm
Depth of cut (ap)	4	mm
Number of passes in AE direction (NOPae)	1	
Number of passes in AP direction (NOPap)	2	
Start diameter (Dms)	22	mm
Effective ramping angle (RMPangle)	12	°
Cutting speed (vc)	169	m/min
Spindle speed (n)	3370	1/min
Feed per tooth (fz)	0.0815	mm
Feed speed at the contour (vfe)	824	mm/min
Feed speed in the tool centre (vri)	225	mm/min
Cutting power (Pc)	1.18	kW
Cutting torque (Mc)	3.35	Nm
Maximum chip thickness (hex)	0.0815	mm
Material removal rate (Q)	9.89	cm3/min
Total cutting time (Tc tot)	00:10.080	min:s
Tool life length (LifeLength)	50.31	m
Tool life time (LifeTime)	61	min

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