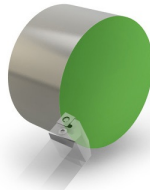


Summary of cutting data for Ext. plain face

Material details



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

Task details

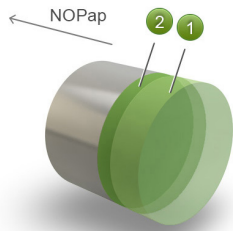


**Ext. plain face**

Operation type	Pre-machining and finishing
Workpiece surface condition	Pre-machined
Cutting condition	Continuous cut
Start diameter	38.1 mm
Width	2 mm
Ra facing	3.2 μm
System stability	Excellent stability

Recommended solution															
Machining	Type of cooling	Coolant	Description	Grade	T <sub>mf</sub> [min:s]	Adaption type									
Turning external only facing	External	Emulsion 10%	WALTER-Turn	WSM10S	00:13.800	Rectangular shank -metric: 20 x 20									
<div><div></div><div><table><tr><td>Tool</td><td>VCGT160408-FM2 WSM10S</td></tr><tr><td>Type</td><td>Insert</td></tr><tr><td>No. of pieces</td><td>1</td></tr></table></div></div> <p>Image similar</p>				Tool	VCGT160408-FM2 WSM10S	Type	Insert	No. of pieces	1						
Tool	VCGT160408-FM2 WSM10S														
Type	Insert														
No. of pieces	1														
<div><div></div><div><table><tr><td>Tool</td><td>PVHBR2020K16</td></tr><tr><td>Type</td><td>Body</td></tr><tr><td>No. of pieces</td><td>1</td></tr><tr><td>Description</td><td>WALTER-Turn</td></tr></table></div></div> <p>Image similar</p>				Tool	PVHBR2020K16	Type	Body	No. of pieces	1	Description	WALTER-Turn				
Tool	PVHBR2020K16														
Type	Body														
No. of pieces	1														
Description	WALTER-Turn														

Cutting data



- Legend
- 1 Premachining
  - 2 Finishing

1 2

Number of passes in AP direction (NOPap)	5	1	
Start diameter (D <sub>ms</sub> )	38.1	38.1	mm
Depth of cut (a <sub>p</sub> )	0.267	0.666	mm
Cutting speed (v <sub>c</sub> )	172	179	m/min
Feed per revolution (f <sub>n</sub> )	0.261	0.101	mm
Rotational speed maximum (rpm <sub>max</sub> )	4000	4000	1/min
Max. cutting power (P <sub>c max</sub> )	0.517	0.624	kW
Max. cutting torque (M <sub>c max</sub> )	3.44	3.98	Nm
Tool life time (Life <sub>Time</sub> )	19	19	min