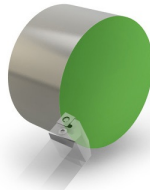


Summary of cutting data for Ext. plain face

Material details



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

Task details

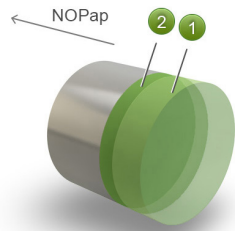


Ext. plain face

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 _{mf} [min:s]	Adaption type									
Turning external only facing	External	Emulsion 10%	WALTER-Turn	WSM10S	00:07.080	Rectangular shank -metric: 20 x 20									
<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>				Tool	VCGT160408-FM2 WSM10S	Type	Insert	No. of pieces	1						
Tool	VCGT160408-FM2 WSM10S														
Type	Insert														
No. of pieces	1														
<div>Image similar</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>				Tool	PVHBR2020K16	Type	Body	No. of pieces	1	Description	WALTER-Turn				
Tool	PVHBR2020K16														
Type	Body														
No. of pieces	1														
Description	WALTER-Turn														
<div>Image similar</div>															

Cutting data



- Legend
- 1 Premachining
 - 2 Finishing

1 2

	1	2	
Number of passes in AP direction (NOPap)	2	1	
Start diameter (D _{ms})	38.1	38.1	mm
Depth of cut (a _p)	0.667	0.666	mm
Cutting speed (v _c)	165	165	m/min
Feed per revolution (f _n)	0.197	0.197	mm
Rotational speed maximum (rpm _{max})	6000	6000	1/min
Max. cutting power (P _{c max})	0.901	0.901	kW
Max. cutting torque (M _{c max})	6.22	6.22	Nm
Tool life time (Life _{Time})	19	19	min