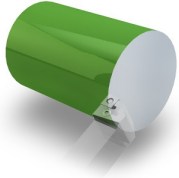


Summary of cutting data for Ext. cylindrical surface

Material details

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

Task details



Ext. cylindrical surface

Operation type	Pre-machining and finishing
Workpiece surface condition	Pre-machined
Cutting condition	Continuous cut
Start diameter	38.1 mm
End diameter	25 mm
Machined length	12 mm
Ra longitudinal	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 longitudinal	External	Emulsion 10%	WALTER-Turn	WSM10S	00:15.780	Rectangular shank -metric: 16 x 16	



Tool	VCGT160408-FM2 WSM10S
Type	Insert
No. of pieces	1

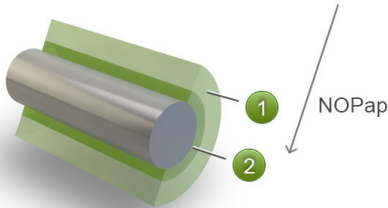
Image similar



Tool	PVJBR1616H16
Type	Body
No. of pieces	1
Description	WALTER-Turn

Image similar

Cutting data



- Legend
- 1 Premachining
 - 2 Finishing

	1	2	
Number of passes in AP direction (NOPap)	6	1	
Start diameter (D _{ms})	38.1	26.678	mm
End diameter (D _{me})	26.678	25	mm
Depth of cut (a _p)	0.952	0.839	mm
Cutting speed (v _c)	165	165	m/min
Feed per revolution (f _n)	0.194	0.194	mm
Rotational speed maximum (rpm _{max})	1970	2110	1/min
Max. cutting power (P _{c max})	1.22	1.09	kW
Max. cutting torque (M _{c max})	8.01	4.95	Nm
Tool life time (LifeTime)	19	19	min

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