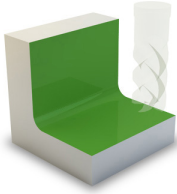


Summary of cutting data for Shoulder

Material details

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

Task details



Shoulder

Operation type	Pre-machining
Workpiece surface condition	Pre-machined
System stability	Excellent stability
Right angle demand	Right angle required
Axis position	vertical spindle position
Depth	10 mm
Width	38.1 mm
Length	38.1 mm
Corner radius	0 mm
Cutting edge diameter	16 mm

Recommended solution

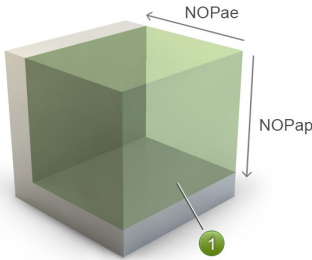
Machining	Type of cooling	Description	Grade	T _{mf} [min:s]			
Shoulder Milling	Dry	Perform	WJ30ED	00:14.340			



Tool	MC232-16.0W3BC-WJ30ED
Type	Body
No. of pieces	1
Description	Perform

Image similar

Cutting data



Legend

1 Premachining

1

Working engagement (ae)	9.52	mm
Depth of cut (ap)	10	mm
Number of passes in AE direction (NOPae)	4	
Number of passes in AP direction (NOPap)	1	
Cutting speed (vc)	164	m/min
Spindle speed (n)	3250	1/min
Feed per tooth (fz)	0.08	mm
Feed speed at the contour (vfe)	781	mm/min
Cutting power (Pc)	2.53	kW
Cutting torque (Mc)	7.44	Nm
Maximum chip thickness (hex)	0.08	mm
Material removal rate (Q)	74.4	cm3/min
Total cutting time (Tc tot)	00:14.160	min:s
Total non-cutting time (Tnc tot)	00:00.154	min:s
Tool life length (LifeLength)	55.61	m
Tool life time (LifeTime)	71	min

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