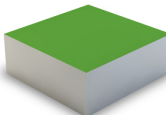



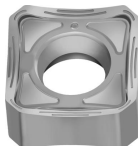
Summary of cutting data for Plain surface

Material details
JIS, A5052, Hardness: 55 HB, Material group:N1.2.Z.UT

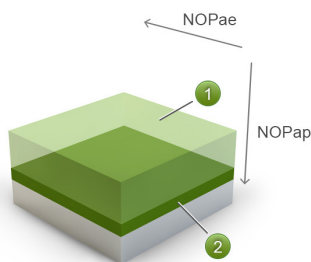
Task details



Plain surface	
Operation type	Pre-machining and finishing
System stability	Excellent stability
Depth	3 mm
Width	50.8 mm
Length	50.8 mm
Ra bottom	3.2 μm
Cutting edge diameter	64 mm

Recommended solution															
Machining	Type of cooling	Coolant	Description	Grade	T _{mf} [min:s]										
Face Milling	External	Emulsion 10%	Xtratec XT	WK10	00:20.400										
<div><div></div><div><table><tr><td>Tool</td><td>M5009-050-B22-04-06-AP</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>Xtratec XT</td></tr></table></div></div> <p>Image similar</p>				Tool	M5009-050-B22-04-06-AP	Type	Body	No. of pieces	1	Description	Xtratec XT				
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Type	Body														
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<div><div></div><div><table><tr><td>Tool</td><td>SNHX1205ANN-K88 WK10</td></tr><tr><td>Type</td><td>Insert periphery (A) INS_A</td></tr><tr><td>No. of pieces</td><td>4</td></tr></table></div></div> <p>Image similar</p>				Tool	SNHX1205ANN-K88 WK10	Type	Insert periphery (A) INS_A	No. of pieces	4						
Tool	SNHX1205ANN-K88 WK10														
Type	Insert periphery (A) INS_A														
No. of pieces	4														

Cutting data



Legend

- 1 Premachining
- 2 Finishing

	1	2	
Working engagement (a_r)	10.16	16.93	mm
Depth of cut (a_p)	0.5	0.5	mm
Number of passes in AE direction (NOPae)	5	3	
Number of passes in AP direction (NOPap)	5	1	
Cutting speed (v_c)	1080	1080	m/min
Spindle speed (n)	6650	6650	1/min
Feed per tooth (f_z)	0.291	0.197	mm
Feed speed at the contour (v_{fe})	7750	5240	mm/min
Cutting power (P_c)	0.677	0.7	kW
Cutting torque (M_c)	0.971	1	Nm
Maximum chip thickness (h_{ex})	0.164	0.131	mm
Material removal rate (Q)	39.3	44.4	cm ³ /min
Total cutting time ($T_{c\ tot}$)	00:14.700	00:03.462	min:s
Total non-cutting time ($T_{nc\ tot}$)	00:02.022	00:00.224	min:s
Tool life length (LifeLength)	3954.61	2001.74	m
Tool life time (LifeTime)	510	380	min

DECLARATION OF EXCLUSION

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