

To
peça acopladora

Subject: **monociclo**

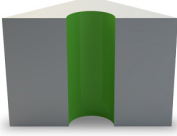
fresamento do rebaixo 6xm3

Summary of cutting data for Hole on solid material

Material details

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

Task details



Hole on solid material

Applicability for through hole

Yes

Diameter

6.5 mm

Tolerance class

Depth

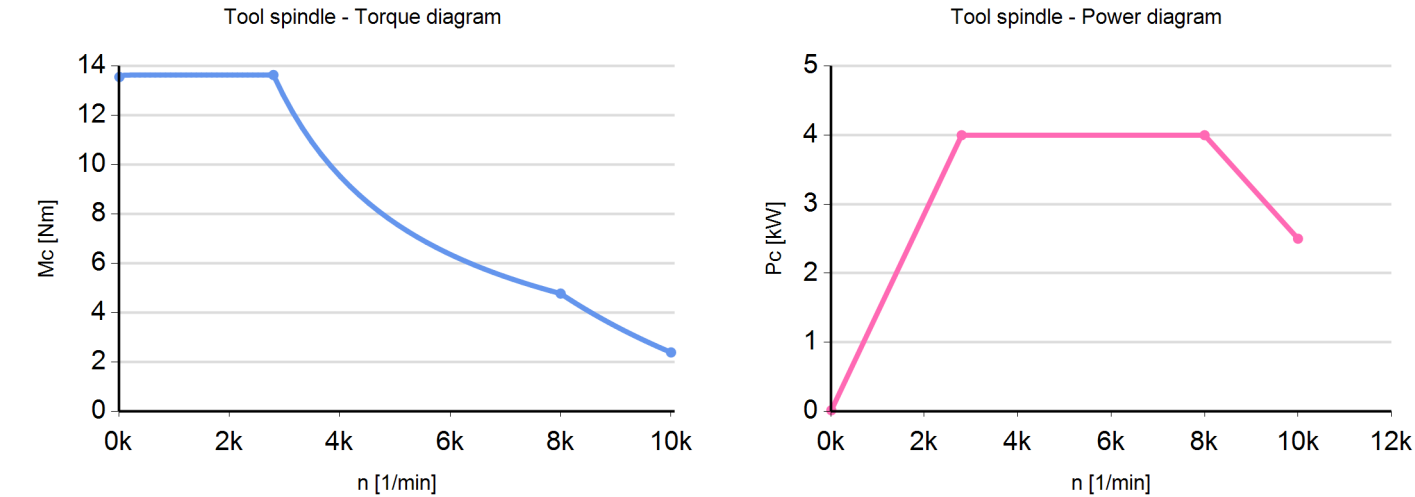
3.5 mm

System stability


Excellent stability

Machine

FANUC RoboDRILL α-21MiB (High Torque)



Recommended solution							
Machining	Type of cooling	Coolant	Description	Grade	Tmf [min:s]		
Pocket milling	External	Emulsion 10%	Perform	WJ30ED	00:01.860		



Tool

MC232-04.0A3B-WJ30ED

Type

Body

No. of pieces

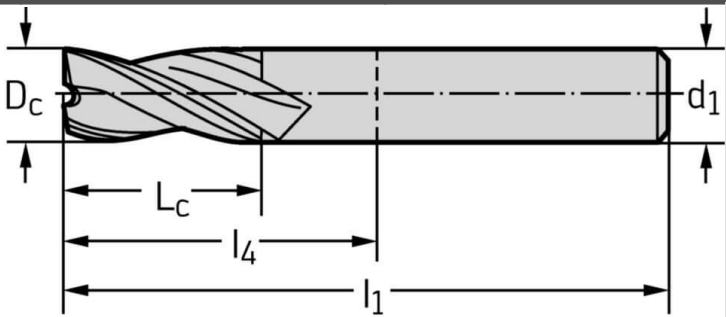
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Description

Perform

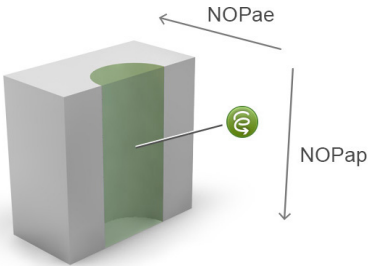
Image similar

MC232-04.0A3B-WJ30ED



Product name	Perform
Standard	DIN 6527 L
Body material	Carbide
Grade	WJ30ED
Center cutting capability	true
Helix angle	35 °
Cutting edge diameter (Dc)	4 mm
Cutting edge diameter tolerance class	h12
Max. depth of cut (Lc)	8 mm
Usable length (l3)	8 mm
Overall length (l1)	57 mm
Maximum overhang (l4)	29 mm
Drive size (d1)	4
Shank diameter tolerance	h6
Peripheral effective cutting edge count (Z)	3
Calculated regrinds	2
Price	38.90 €

Cutting data



Legend



Working engagement (ar)	3.25	mm
Depth of cut (ap)	1.75	mm
Number of passes in AE direction (NOPae)	1	NOPae
Number of passes in AP direction (NOPap)	2	NOPap
Start diameter (Dms)	6.5	mm
Effective ramping angle (RMPangle)	12.6	°
Cutting speed (vc)	120	m/min
Spindle speed (n)	9550	1/min
Feed per tooth (fz)	0.046	mm
Feed speed at the contour (vfe)	1320	mm/min
Feed speed in the tool centre (vri)	507	mm/min
Cutting power (Pc)	0.0886	kW
Cutting torque (Mc)	0.0886	Nm
Maximum chip thickness (hex)	0.046	mm
Material removal rate (Q)	2.88	cm3/min
Total cutting time (Tc tot)	00:01.860	min:s
Tool life length (LifeLength)	739.08	m
Tool life time (LifeTime)	560	min

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