

To
peça acopladora

Subject: **monociclo**

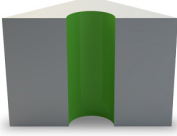
fresamento furo 12mm

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

12 mm

Tolerance class

Depth

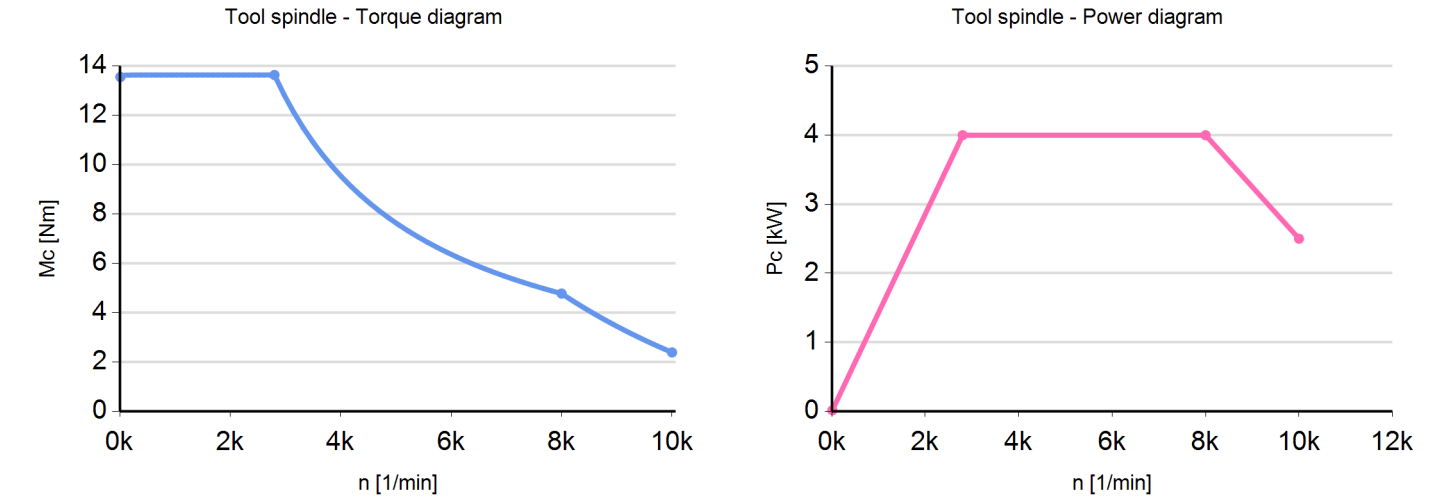
10 mm

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	00:02.928		



Tool

MC232-10.0W3BC-WJ30ED

Type

Body

No. of pieces

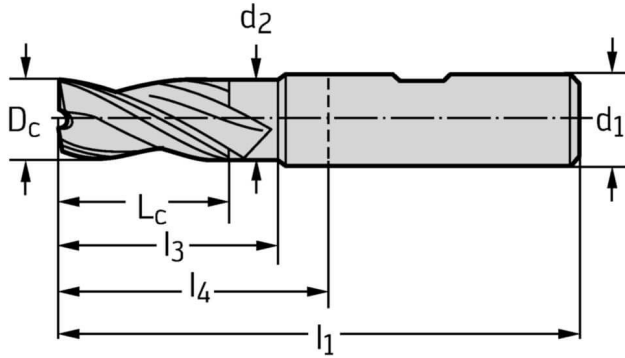
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Description

Perform

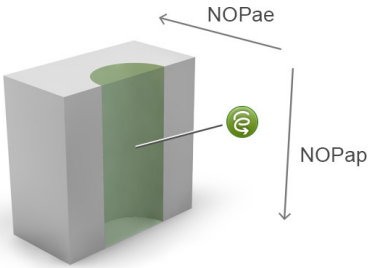
Image similar

MC232-10.0W3BC-WJ30ED



Product name	Perform
Standard	DIN 6527 L
Body material	Carbide
Grade	WJ30ED
Center cutting capability	true
Helix angle	35 °
Cutting edge diameter (Dc)	10 mm
Cutting edge diameter tolerance class	h12
Corner chamfer width (l11)	0.1 mm
Corner chamfer	45 °
Max. depth of cut (Lc)	19 mm
Usable length (l3)	30 mm
Neck diameter (d2)	9.5 mm
Overall length (l1)	72 mm
Maximum overhang (l4)	32 mm
Drive size (d1)	10
Shank diameter tolerance	h6
Peripheral effective cutting edge count (Z)	3
Calculated regrinds	3
Price	77.10 €

Cutting data



Legend



Working engagement (ar)	6	mm
Depth of cut (ap)	2	mm
Number of passes in AE direction (NOPae)	1	NOPae
Number of passes in AP direction (NOPap)	5	NOPap
Start diameter (Dms)	12	mm
Effective ramping angle (RMPangle)	17.7	°
Cutting speed (vc)	314	m/min
Spindle speed (n)	10000	1/min
Feed per tooth (fz)	0.129	mm
Feed speed at the contour (vfe)	3860	mm/min
Feed speed in the tool centre (vri)	643	mm/min
Cutting power (Pc)	0.487	kW
Cutting torque (Mc)	0.465	Nm
Maximum chip thickness (hex)	0.129	mm
Material removal rate (Q)	7.72	cm3/min
Total cutting time (Tc tot)	00:02.928	min:s
Tool life length (LifeLength)	891.76	m
Tool life time (LifeTime)	230	min

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