

Cavity Milling in UDDEHOLM MIRRAX ESR (50HRC)

Milling Cutter		vc	fz	vf	ap	ae	Tool Life (min)	Q tot (cm ³)	Comments
Fraisa	D5100450 Ø10 (ballnose)	100	0.2	3248	0.4	2.5	58.0	188.4	
Prototyp	Flash 50 Ø10 (high feed)	40	0.25	1273	0.3	4.0	100.0	152.8	
Hitachi	HGOR 4080-03-TH Ø8, z=4	40	0.03	191	2.0	6.0	66.4	152.2	coolant
	HGOR 4080-03-TH Ø8, z=4	40	0.03	191	2.0	6.0	128.1	293.6	same as above but dry
	HGOR 4080-03-TH Ø8, z=4	40	0.03	191	4.0	8.0	46.2	282.4	bigger ap
Union Tool	CZS 4080-1200 Ø8, z=4	40	0.03	191	2.0	6.0	49.0	112.3	
	CZS 4080-1200 Ø8, z=4	40	0.03	191	0.5	6.0	49.0	28.1	two edge corner broken
Franken/Emuge	Top Cut K3-15FH r0,5, Ø8 z=4	40	0.03	191	2.0	6.0	90.0	206.3	VB=0,17
		40	0.03	191	0.5	6.0	339.0	194.2	worn out



Prototyp Flash 50
High Feed Geometry

