

Machining examples

Workpiece:	Carbon steel plate (193 HB)
Cutter:	32A3R040B32-STD17D-C
Insert:	TDET 170408SR-M:M8330
Material:	1.1191/C45
Coolant:	Compressed air

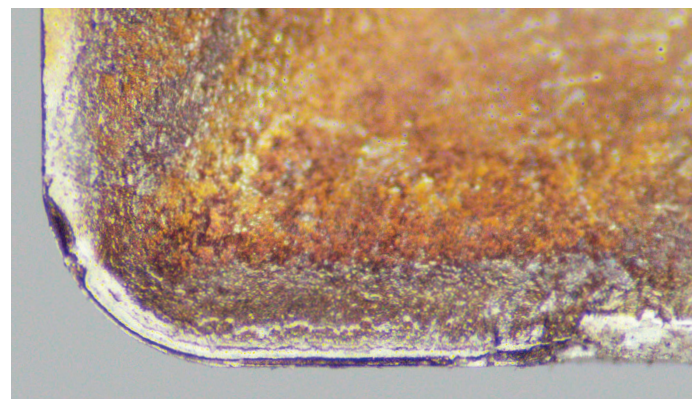
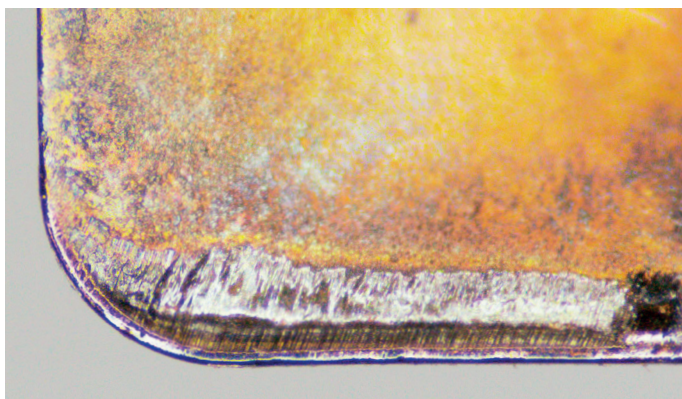
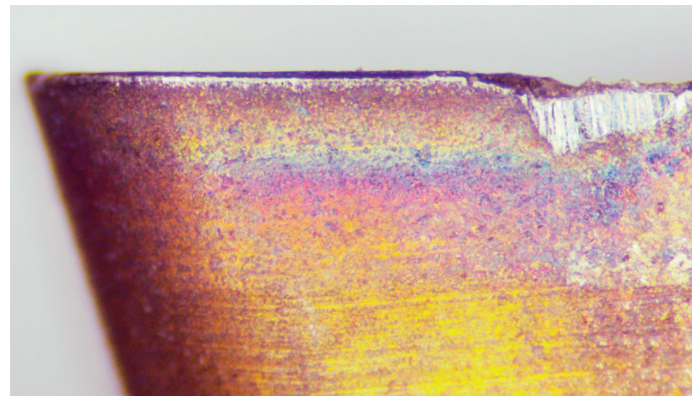
Workpiece:	Stainless steel plate (141 HB)
Cutter:	32A3R040B32-STD17D-C
Insert:	TDET 170408SR-MM:M6330
Material:	1.4404 / 316L
Coolant:	Compressed air

Machining data:				
v_c	f_z	a_p	a_e	Tool life (min)
270	0.20	2.50	24	36

Machining data:				
v_c	f_z	a_p	a_e	Tool life (min)
170	0.15	2.50	24	33

WMG P2.2

WMG M3.1



Photos from TDET 170408SR-M:M8330, taken after 36 minutes.

Photos from TDET 170408SR-MM:M6330, taken after 33 minutes.

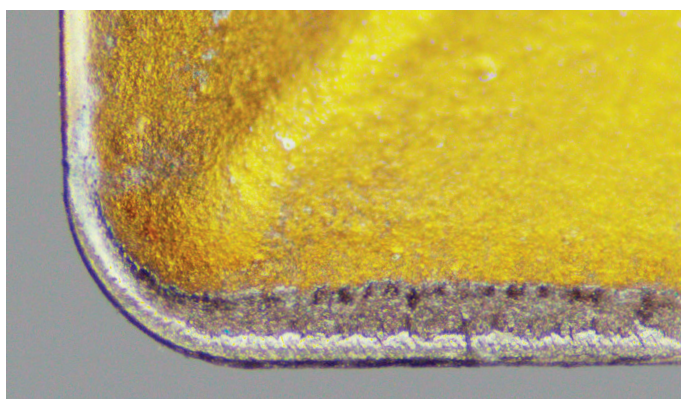
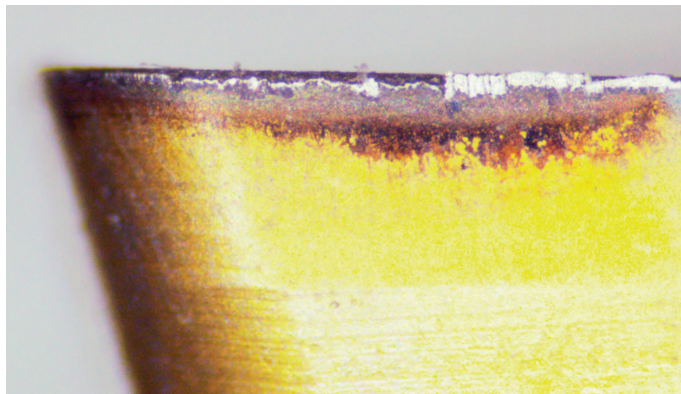
v_c = cutting speed (m/min), f_z = feed per tooth (mm), a_p = axial depth of cut (mm), a_e = radial depth of cut (mm)

Machining examples

Workpiece:	Stainless steel plate (147 HB)
Cutter:	32A3R040B32-STD17D-C
Insert:	TDET 170408SR-MM:M6330
Material:	1.4404/316L
Coolant:	Soluble oil emulsion (10%)

Machining data:				
v_c	f_z	a_p	a_e	Tool life (min)
90	0.12	2.5	24	46

WMG M3.1

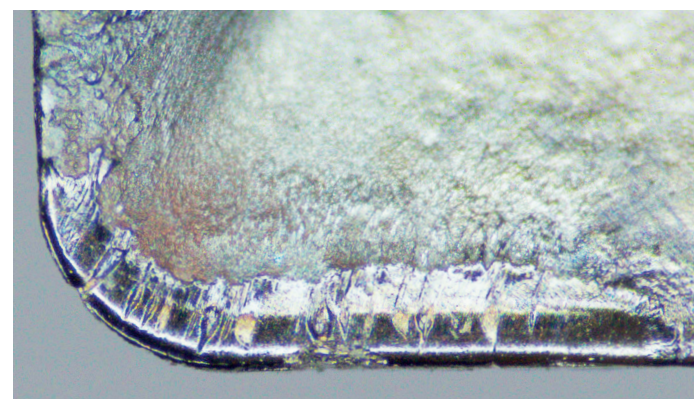
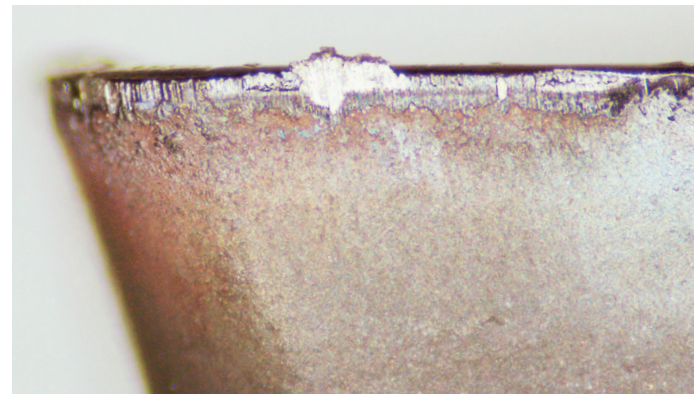


Photos from TDET 170408SR-MM:M6330, taken after 46 minutes.

Workpiece:	Cast iron plate (219 HB)
Cutter:	50A05R-S90TD17D-C
Insert:	TDET 170408PR-R:M5315
Material:	GG25/FC250
Coolant:	Soluble oil emulsion (10%)

Machining data:				
v_c	f_z	a_p	a_e	Tool life (min)
340	0.25	2.5	40	55

WMG K1.2



Photos from TDET 170408PR-R:M5315, taken after 55 minutes.

v_c = cutting speed (m/min), f_z = feed per tooth (mm), a_p = axial depth of cut (mm), a_e = radial depth of cut (mm)