

Technical Test Report

CUSTOMER Hr.Pammer

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reich

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MACHINE Alzmetall GS1000/5-T Vertical Horizontal Spindle HSK63A

Rotation 24.000 rev/min Feed 60.000 mm/min Spindle 24 kW

Milling Emulsion Air

MATERIAL AlMn4,5Mg No. AW5083 Strength N/mm2 HRC

WORKPIECE Test workpiece

Roughing Finishing

pre finishing

smooth cut

interrupted cut

strong interrupted cut



Vorschub bis zu 25 m/min oder mehr!

PRODUCER

	M.A. FORD High Performance Cutting Tools	M.A. FORD High Performance Cutting Tools	M.A. FORD High Performance Cutting Tools	M.A. FORD High Performance Cutting Tools	
Tool No.	135 1200N	135 1200N	135 1200N	135 1200N	
Tool dia.	12	12	12	12	mm
Tool Holder	Collet holder	Collet holder	Collet holder	Collet holder	
No.of teeth	2	2	2	2	
Insert					
Grade					
Cutting Speed	Vc 904	904	904	904	m/min
Revolution	rev 24.000	24.000	24.000	24.000	rev/min
Feed/min.	Vf 10/12/14/16m	16/18/20/22m	22.000	40.000	mm/min
Feed/tooth	fth 0,2/0,25/0,3/0,33	0,33/0,37/0,41/0,46	0,46	0,83	mm/th
Feed/rev.	f/rev				mm/rev
Axial	ap 12	12	12	12	mm
Radial	ae 12	12	12	4	mm (%)
Total Depht-Cut					mm
Coolant	Wet	Wet	Wet	Air	
Overhang	OH				mm
Chip voloume	Q		3186	1920	cm ³ /min
Holes					Piece
Working Time					min
Toleranz					m
Tool life	T				min
Spindle Power					%

Video

Video

Video

Video

RESULT Maximum machine power of feed 22.000mm/min!!!

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