

Technical questionnaire: Milling

Company: **Hi Con Technocast**
Metoda, Rajkot

Contact: **Yogeshbhai**

Phone: **7567599469**

Fax:
 E-mail:

Size: **16 mm**

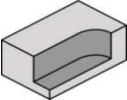
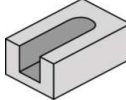
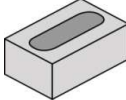
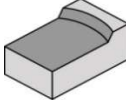
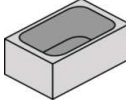
Design: **Top Cut Endmill**

Article no.: **EFI20001.016**

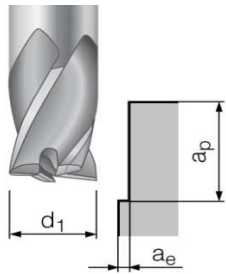
Project: **Batch**

Workpiece description: **Connection Plate**

Application case – please tick off


 
 
 
 
 (customer's own sketch)

Cutting data:



d1: **16 mm** mm
 ap: **0.1 - 0.2 mm** mm
 ae: **16 mm** mm
 n: **2000** min-1
 vc: **1000** m/min
 vf: **350** mm/min
 fz:
 mm

Application situation:

finishing down-milling horizontal
 roughing up-milling vertical
 with drilling work

Coolant-lubricant:

Oil Emulsion % pressurized air
 MQL Others:

Coolant-lubricant supply:

External Internal others:

Machine:

Manufacturer: **HASS - VF2**

Type: **VMC**

Machine power:
 kW

Max. speed:
 min-1

Workpiece material:

Designation/Mat. no.: **SS-304**

Condition during work: **Long Chipping**

Tensile strength/hardness: **20-25 HRC**

Stability: good medium unstable

Machine: good medium unstable
 Clamping/workpiece: good medium unstable

Special notes:

(Reason for return, tool used until now, etc.)

Spindle adaptation:

SK/ISO taper DIN 2080 / 69871
 HSK DIN 69893
 MT DIN 228 A / B

Size: **BT 30**

Others: **BT30**

Tool holder:

Holder for DIN 1835 B / DIN 6535 HB Collet

Shrink-fit holder powRgrip®

Others: **Shrink Fit Holders**

Tool life (m, min, etc.):

New condition: **25 Component**
 Reground condition:

Filled in by: **Vishwajit Mori**

Date/signature: **14-08-2021**

Finishing Application in Connection Plate of SS 304 M
Need to remove stock of 0.1 mm from Face, OD and I
They were using Shining and Blood Endmill currently
Need to beat life of 25 Components
Will use in Shrink Fit Holder