

Success Story 03/2019

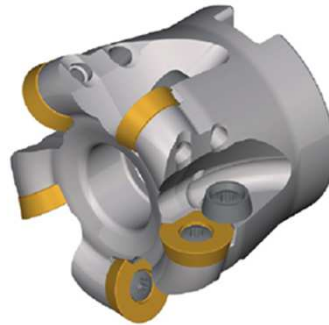
3D milling - ISO 00P with BCH30M



Application

Country Austria
Material 1.4543
Coolant dry

Solution



Customer's benefit

Through the usage of a completely different cutting system, tool life was increased from 16 pieces up to 404 pieces

Competitor:

Cutter Ø 40 mm with 6 teeth
SDMT090308 VU10

Cutting data:

$v_c = 70 / 90$ m/min
 $f_z = 0.36 / 0.32$ mm
 $a_p = 0.4 / 0.2$ mm

Result:

8 - 16 pieces

Boehlerit:

BF00 RD10.042 Z05
RDKW 1003MOS-RH BCH30M

Cutting data:

$v_c = 70 / 90$ m/min
 $f_z = 0.44 / 0.38$ mm
 $a_p = 0.4 / 0.2$ mm

Result:

404 pieces

Tool life

