

HPC milling cutters

Application examples



Sealing surface milling

| | |
|---------------------------------|--|
| Workpiece | Gearbox - sealing surface |
| Material | GD-AISI9Cu3 |
| Tools | HPC milling cutter, dia. = 63 mm, no. of cutting edges = 12, HSK 63-A |
| Cutting speed | $vc = 2,970$ m/min |
| Revolution | $n = 15,000$ rev/min |
| Feed per tooth | 0.05 mm |
| Feed rate | 9,000 mm/min |
| Achieved surface finish quality | $Rz = 5$, $Pt = 7$, flatness = 0.025 |



Fire face milling on a cylinder head

| | |
|---------------------------------|---|
| Workpiece | Cylinder head – fire face |
| Material | G-AISI9 |
| Tools | HPC milling cutter, dia. = 125 mm, no. of cutting edges = 27, HSK 63-A |
| Cutting speed | $vc = 5,890$ m/min |
| Revolution | $n = 15,000$ rev/min |
| Feed per tooth | 0.15 mm |
| Feed rate | 60,000 mm/min |
| Achieved surface finish quality | $Rz = 2-4$ |

