

Application examples

Milling cutters



Milling of sealing surface

Workpiece	Gearbox case
Material	Al Si 9
Tool	Face milling cutter (Monobloc milling cutter) Standard H 6120-8000 8063 R Ø 80
Number of teeth	$z = 11$, all adjustable
Insert	W 6120-0418 0000 N
Cutting grade	PCD
Cutting speed	$V_C = 2.011$ m/min
Number of revolutions	$n = 8.000$ 1/min (max. nr. of spindle revolutions)
Feed rate	$V_f = 14.344$ mm/min
Feed rate per tooth	$f_z = 0.163$ mm
Internal coolant	yes, 70 bar above the coolant distribution screw
Surface requirement	$R_z = 12 - 25$



Milling on pump housing

Workpiece	Pump housing
Material	Al Si 1
Tool	Face milling cutter (Put-on milling cutter) Standard H 6120-6300 8063 R Ø 63
Number of teeth	$z = 8$, all adjustable
Insert	W 6127-0318 0045 R
Cutting grade	PCD
Cutting speed	$V_C = 3.560$ m/min
Number of revolutions	$n = 18.000$ 1/min
Feed rate	$V_f = 20.000$ mm/min
Feed rate per tooth	$f_z = 0.14$ mm
Internal coolant	yes, 50 bar above the coolant distribution screw

