

Test Sheet parting off, cutting grooving and turning

Company: Techn. adviser: Behninger/Starke Date: 09.10.2017 Test No. 384

Machine Brand	Traub AUB TNC 65	Machine output	
Machine type	CNC	Machine condition	poor
Cooling	emulsion	Concentration	7
Cooling Procedure	external cooling supply		
Material	42 CrMo4	Material code no.	1.7225
Material Type	steel		

Machining operation	parting_off	Tool position	external
Max. diameter	30	Min. diameter	0
Interrupted cutting	none		

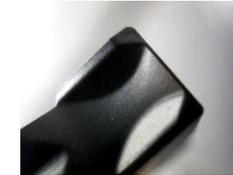
Picture/Drawing



Insert Kemmer



Insert Competitor



Chip Kemmer



Wear Kemmer



Chip Competitor



Wear Competitor



Competitor	Is	Actual annual consumptio	
Tool holder	XXDGFHR 32T33-3		
Insert	XXDGN 3102C		
Vc [m/min]	80	Coating	XXIC907
Initial feed f [mm/rev]	0,03	Revolutions [RPM]	
Main feed f [mm/rev]	0,06	1. From Ø -> Ø	30mm - 24mm
Run out feed f [mm/rev]	0,03	2. From Ø -> Ø	24mm - 4mm
Longitudinal turning feed f [mm/rev]		3. From Ø -> Ø	4mm - 0,5 mm
Length of turning operation [mm]		Cutting depth	15
Pieces/insert	50	No. of passes	1
Chip control	medium	Tool life	
		Wear type	pitting

Manufacturer	Annual consumption NEW based on test insert pcs		
Tool holder	P92 CXCBL 3208 30 R65		
Insert	CTD 3 KM		
Vc [m/min]	80	Coating	Hardlox 2
Initial feed f [mm/rev]	0,03	Revolutions [RPM]	
Main feed f [mm/rev]	0,06	1. From Ø -> Ø	30mm - 24mm
Run out feed f [mm/rev]	0,03	2. From Ø -> Ø	24mm - 4mm
Longitudinal turning feed f [mm/rev]		3. From Ø -> Ø	4mm - (-0,5mm)
Length of turning operation [mm]		Cutting depth	15
Pieces/insert	78	No. of passes	1
Chip control	medium	Tool life	
		Wear type	pitting