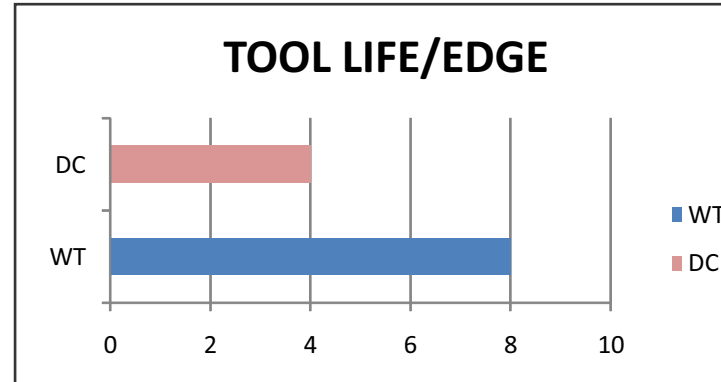


CASE 1	WINTECH	DC
WORKPIECE MATERIAL	MS PLATE	MS PLATE
COMPONENT NAME	RAIL FRAME 08	RAIL FRAME 08
WORKPIECE HARDNESS	35 HRC	35 HRC
PROCESS	SIDE MILLING - FINISHING	SIDE MILLING - FINISHING
COOLANT	DRY	DRY
CUTTING PARAMETERES	Vc = 157 m/min	Vc = 157 m/min
	f = 1200 mm (Fz=0.3)	f = 1000 mm (Fz=0.2)
	Ap = 7.50 mm (4 passes)	Ap = 7.50 mm (4 passes)
INSERT	ANKX160716R-GM-A4230	GNMU110605R-M-DC9800
CUTTER	MEB190-050R04A22-AN16	90F5-D50-22R-GN11




 WT tool life is 100%
 higher than DC

