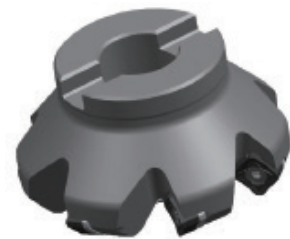
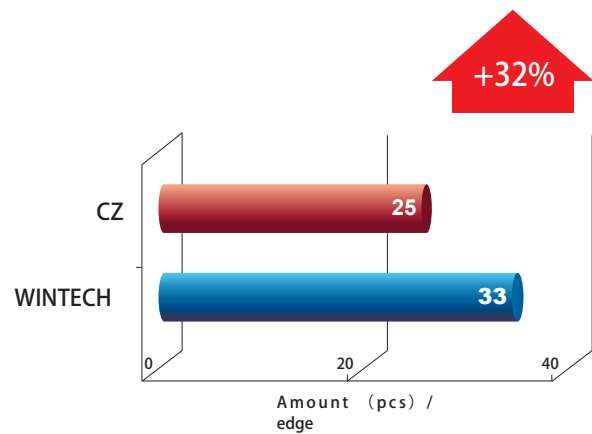


SNEU1206ANEN FACE MILLING CASE STUDIES CUTTERS MFB145/MFB245

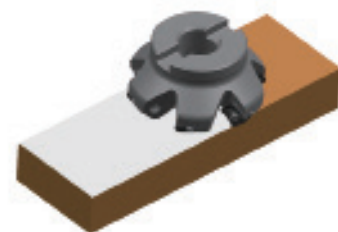
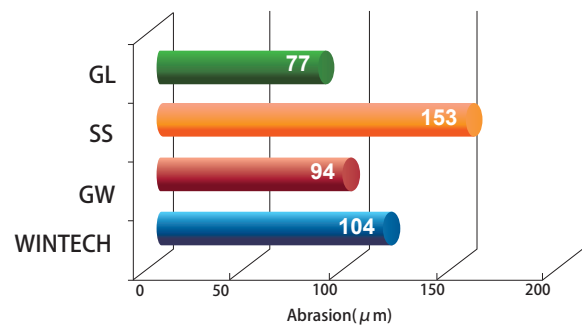
Case 1

Workpiece Material	HT300 (HB230)
Processing Way	Face milling, dry cutting
Cutting Parameters	Vc=200 m/min, fz=0.15 mm/t ap=3.5mm, ae=50mm
Inserts and Cutter	SNEU1206ANEN-GM-K2115 MFB145-080R07A27-SN12



Case 2

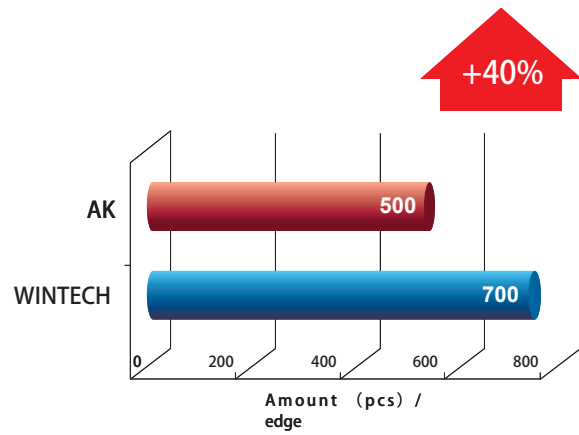
Workpiece Material	45# (HRC22)
Processing Way	Face milling, dry cutting
Cutting Parameters	Vc=250 m/min, fz=0.2 mm/t, ap=2mm, ae=25mm
Inserts and Cutter	SNEU1206ANEN-GM-A4230 MFB145-063R06A22-SN12
Remark	The tool life target is 35 minutes.



HNEX0905 FACE MILLING CASE STUDIES CUTTERS MFB160

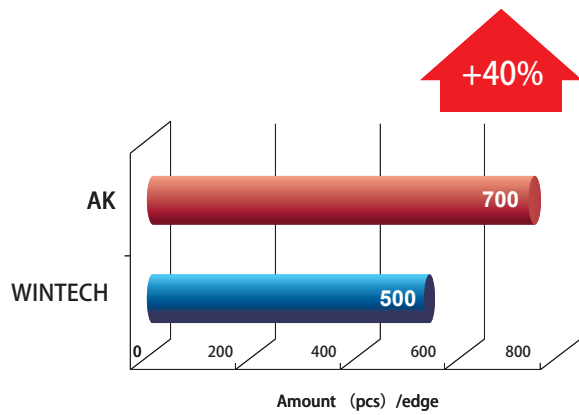
Case 1

Workpiece Material	HT250 (HB180-230)
Processing Way	Face milling, medium-finishing, wet cutting
Cutting Parameters	$V_c=180$ m/min, $f_z=0.4$ mm/t, $a_p=0.35$ mm
Inserts and Cutter	HNEX090516-KR-K4125 HNEX090502-WC-K4125



Case 2

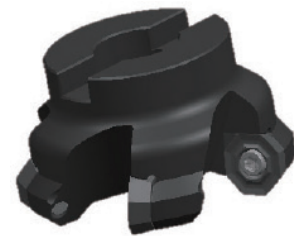
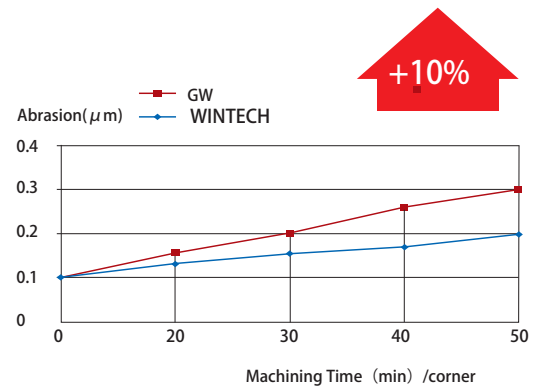
Workpiece Material	HT250 (HB180-230)
Processing Way	Face milling, finishing, wet cutting
Cutting Parameters	$V_c=160$ m/min, $f_z=0.32$ mm/t, $a_p=0.32$ mm
Inserts and Cutter	HNEX090520-KF-K4125 HNEX090502-WC-K4125



ODKT060508 FACE MILLING CASE STUDIES CUTTERS MFA143

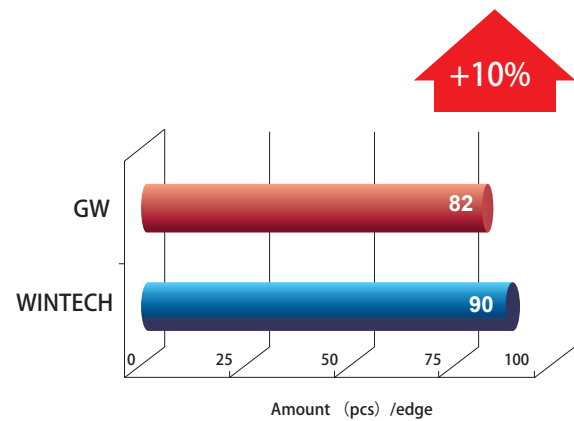
Case 1

Workpiece Material	HT250 (HB210)
Processing Way	Face milling, dry cutting
Cutting Parameters	Vc=180m/min, fz=0.2 mm/t, ap = 1mm
Inserts and Cutter	ODKT060508-GM-K4125 MFA143-063R05A27-OD06



Case 2

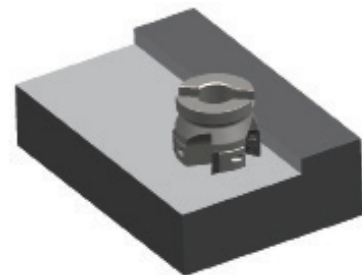
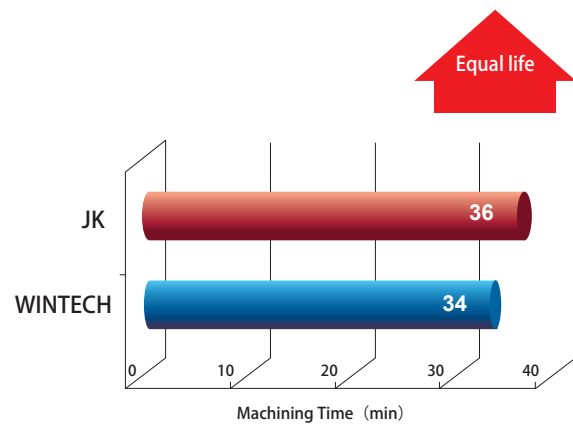
Workpiece Material	HT250 (HB210)
Processing Way	Face milling, Finishing wet cutting
Cutting Parameters	Vc=130m/min, fz=0.2mm/t, ap = 0.3mm
Inserts and Cutter	ODKT060508-NL-K0115 MFA143-063R05A27-OD06
说明 Remark	Tool life are both 6 h.



APMT SHOULDER MILLING CASE STUDIES CUTTERS MEA190

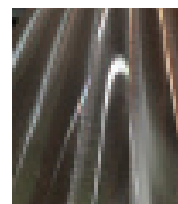
Case 1

Workpiece Material	Stainless steel (HB150)
Processing Way	Face milling, semi-finish milling, dry cutting
Cutting Parameters	$V_c=150\text{m/min}$, $f_z=0.15\text{mm/t}$, $a_p=1\text{mm}$
Inserts and Cutter	APMT1604PDER-PL GA4225 MEA190-050R04A22-AP16

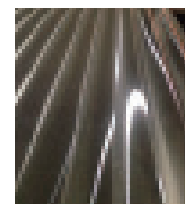


Case 2

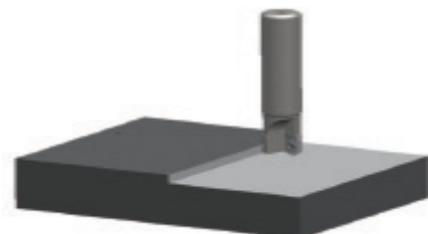
Workpiece Material	HB130) Aluminum Alloy
Processing Way	Face milling, Semi-finish, dry cutting
Cutting Parameters	$V_c=300\text{m/min}$, $f_z=0.15\text{mm/t}$, $a_p=1.5\text{mm}$ $a_p=0.32\text{mm}$
Inserts and Cutter	APGT1135PDFR-AL N9125 MEA190-025R03P25-AP11



JM Ra=0.41-0.46



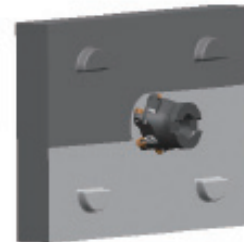
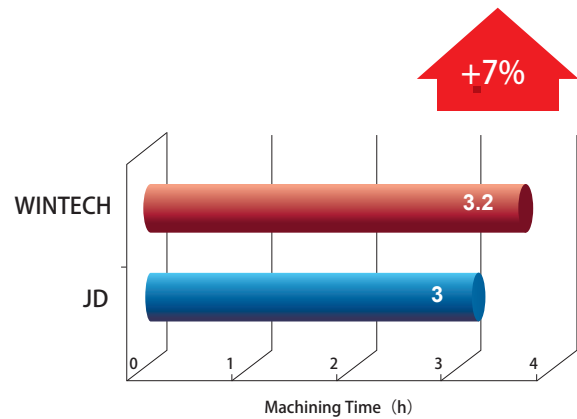
WINTECH Ra=0.34-0.39



RD** PROFFILE MILLING CASE STUDIES CUTTERS MPA100

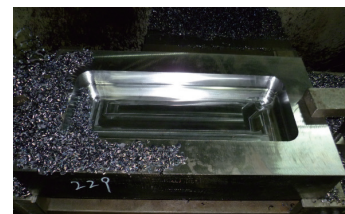
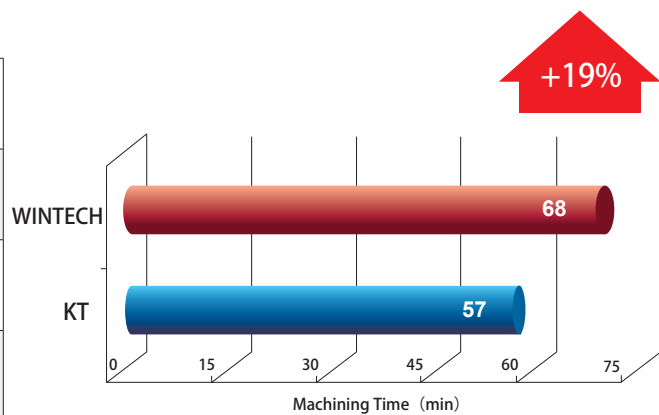
Case 1

Workpiece Material	718 (HRC30)
Processing Way	Profile milling, Roughing, dry cutting
Cutting Parameters	Vc=158m/min, fz=1.1mm/t, ap =0.7mm
Inserts and Cutter	RDEW1204M0T- A4230 MPA100-063R05A22-RD12



Case 2

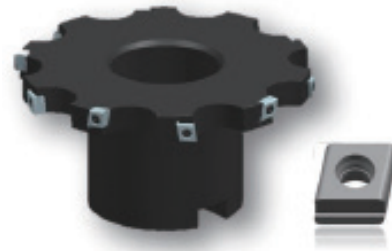
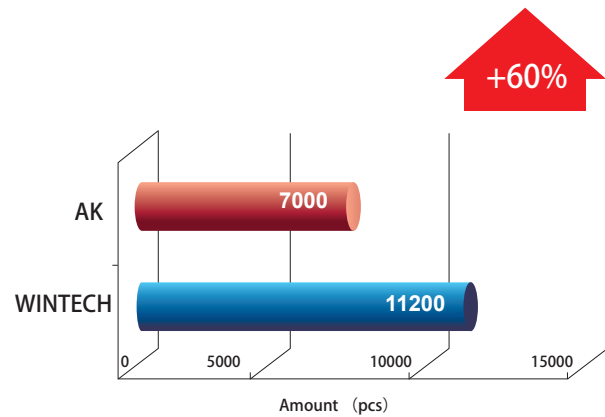
Workpiece Material	50# (30HRC)
Processing Way	Profile milling, Roughing, dry cutting
Cutting Parameters	Vc=259m/min, fz=0.2mm/t, ap =1.5mm
Inserts and Cutter	RDEW1204M0T- A4225 MPA100-050R04A22-RD12



CNEU SIDE AND FACE MILLING CASE STUDIES CUTTERS MSA110-113

Case 1

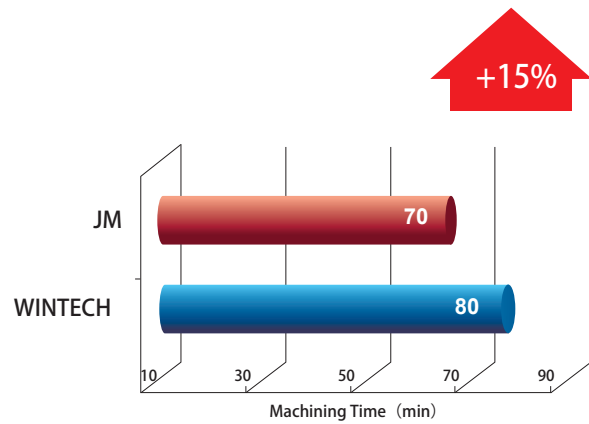
Workpiece Material	HT250 (HB180-230)
Processing Way	Parting, dry cutting
Cutting Parameters	$V_c=220\text{m/min}$, $f_z=0.15\text{mm/t}$, $a_p=15\text{mm}$
Inserts and Cutter	CNEU070508-KM K4125 MSA110-125R10B32-CN07



UD/UP HIGH FEED MILLING CASE STUDIES CUTTERS MKA110

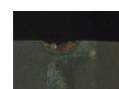
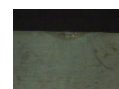
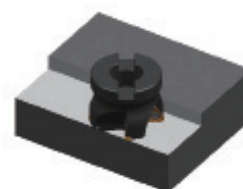
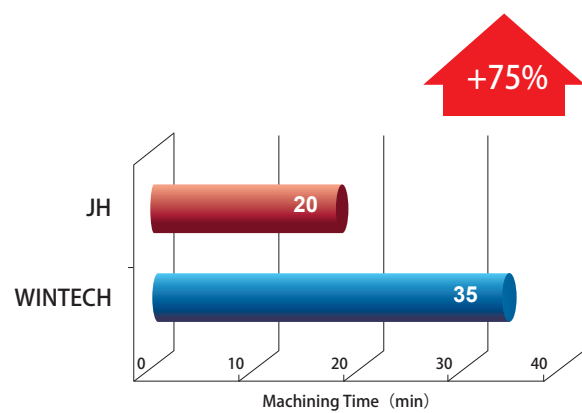
Case 1

Workpiece Material	P20 (HRC35)
Processing Way	Pocket milling, Roughing, dry cutting
Cutting Parameters	Vc140m/min, fz=1.6mm/t, ap=0.8mm
Inserts and Cutter	UPET170520-PM- A4225 MKA110-063R04A22-UP17
Remark	Abrasion value reaches to 0.3mm



Case 2

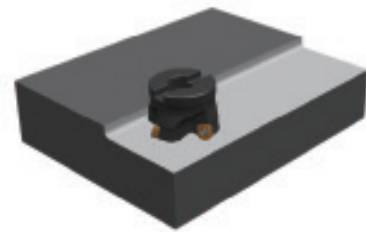
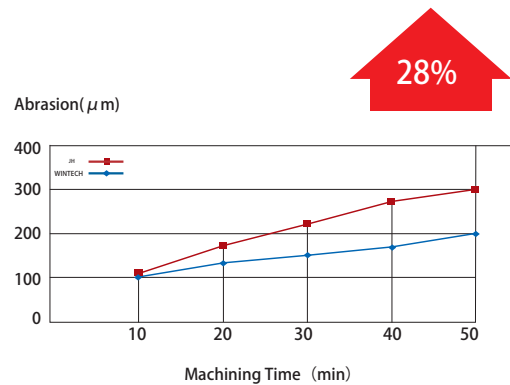
Workpiece Material	SKD61 (HRC45)
Processing Way	Face milling, Roughing, dry cutting
Cutting Parameters	Vc=160m/min, fz=1mm/t, ap=0.8mm
Inserts and Cutter	UDMT12T312T- MH-A4230 MKA110-050R04A22-UD12
Remark	Abrasion value reaches to 0.3mm



SDMT HIGH FEED MILLING CASE STUDIES CUTTERS MKB113

Case 1

Workpiece Material	P20 (HRC37)
Processing Way	Face milling、Roughing、dry cutting
Cutting Parameters	Vc=160m/min, fz=1.5mm/t, ap =1mm
Inserts and Cutter	SDMT120512-GM A4225 MKB113-063R04A22-SD12



Case 2

Workpiece Material	P20 (HRC35)
Processing way	Pocket milling and Profile milling Roughing、dry cutting
Cutting Parameters	Vc=138.5m/min, fz=1.6mm/t, ap =0.8mm
Inserts and cutter	SDMT120512-GM-A4230 MKB113-050R04A22-SD12
Remark	Tool life are both 3.5 h.

