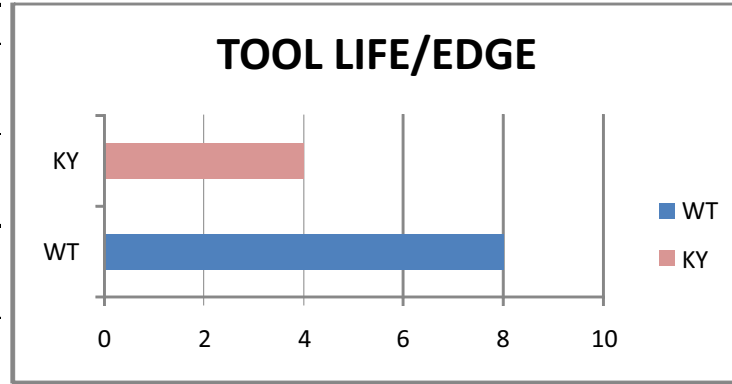
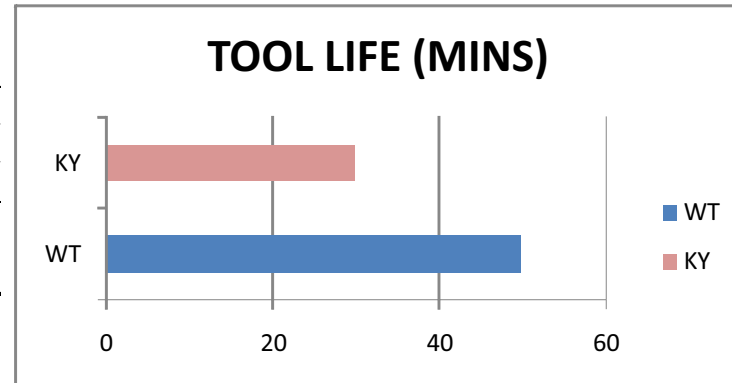




CASE 1	WINTECH	KY
WORKPIECE MATERIAL	MS PLATE	MS PLATE
COMPONENT NAME	RAIL FRAME 08	RAIL FRAME 08
WORKPIECE HARDNESS	35 HRC	35 HRC
PROCESS	SIDE MILLING - ROUGHING	SIDE MILLING - ROUGHING
COOLANT	DRY	DRY
CUTTING PARAMETERES	Vc = 204 m/min	Vc = 172 m/min
	f = 7200 mm (Fz=1.38)	f = 6000 mm (Fz=1.09)
	Ap = 0.7 mm	Ap = 0.7 mm
INSERT	SDMT120512-GM-A4230	WNMX09T316ZNN-PC5300
CUTTER	MKB113-050R04A22-SD12	HRMBCM0905HR-5



↑  
WT tool life is 100% higher than KY



↑  
67% higher carbide Abrasion resistance