



Cutting data for milling

RAKU[®] TOOL WB-0890



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formula for calculating speed (spindle)

$$n = \frac{V_c \times 1000}{D_c \times \pi}$$

14968 [rpm] = $\frac{940 \text{ [m/min]} \times 1000}{20,0 \text{ [mm]} \times 3,14}$

formula for calculating axis feed rate

$$V_f = n \times f_z \times z_n$$

6900 [mm/min] = 15000 [rpm] x 0,230 [mm] x 2 [number]

recommended cutting data for roughing

parameter	symbol	unit
radial infeed:	a_e	[mm]
axial infeed:	a_p	[mm]
number of teeth:	z_n	[number]

roughing recommendation		
min.	ideal	max.
- x D_c	0,50 x D_c	0,50 x D_c
0,10 x D_c	1,00 x D_c	1,00 x D_c
2	2	2

recommended cutting data for finishing

parameter	symbol	unit
radial infeed:	a_e	[mm]
axial infeed:	a_p	[mm]
number of teeth:	z_n	[number]

finishing recommendation		
min.	ideal	max.
- x D_c	0,01 x D_c	0,05 x D_c
0,01 x D_c	0,10 x D_c	0,20 x D_c
2	2	2

validated cutting data for roughing

Type	D_c [mm]	z_n [number]	V_c [m/min]	f_z [mm]	n [rpm]	V_f [mm/min]	a_e [mm]	a_p [mm]	L_1 [mm]	L_2 [mm]
torus	20,0	2	940	0,230	14.968	6.885	10,00	20,00	87,0	20,0
torus	12,0	2	560	0,210	14.862	6.242	6,00	12,00	55,0	16,0
torus	6,0	2	280	0,200	14.862	5.945	3,00	6,00	23,0	8,0

validated cutting data for finishing

Type	D_c [mm]	z_n [number]	V_c [m/min]	f_z [mm]	n [rpm]	V_f [mm/min]	a_e [mm]	a_p [mm]	L_1 [mm]	L_2 [mm]
ball	20,0	2	940	0,510	14.968	15.268	0,20	2,00	67,0	17,0
ball	12,0	2	560	0,510	14.862	15.159	0,12	1,20	52,0	10,5
ball	6,0	2	280	0,510	14.862	15.159	0,06	0,60	23,0	10,0

parameter	symbol	unit
cutting speed:	V_c	[m/min]
feed/tooth:	f_z	[mm]

user specifications	
selection in the diagram	
selection in the diagram	

speed (spindle):	n	[rpm]
axis feed rate:	V_f	[mm/min]

calculation by user	
calculation by user	

cutting diameter:	D_c	[mm]
tool total length:	L_0	[mm]
tool unclamping length:	L_1	[mm]
tool cutting length:	L_2	[mm]

processing specific	
processing specific	
processing specific	
processing specific	

RAMPF Advanced Polymers GmbH & Co. KG

Robert-Bosch-Str. 8 -10 | 72661 Grafenberg | Germany
T +49.7123.9342-0
E advanced.polymers@rampf-group.com

Our recommendations on the use of the material are based on many years of experience and current scientific and practical knowledge. They are, however, provided without any obligation on our part and do not relieve the buyer of the need for suitability tests. They do not constitute a legal relationship, nor are any protected third party rights what's ever affected thereby.

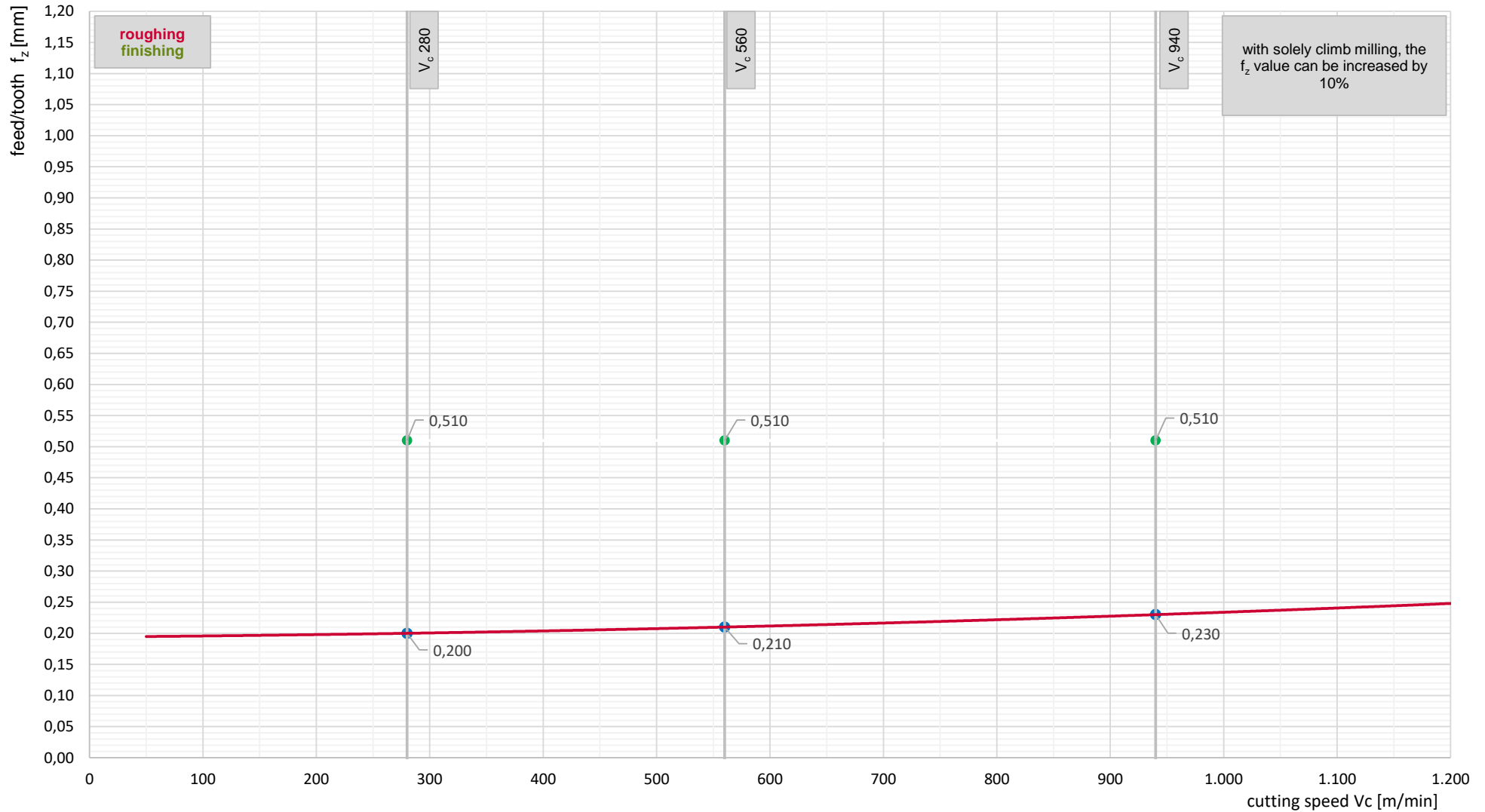
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Cutting data diagram for milling RAKU[®] TOOL WB-0890



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Practical application of the cutting data

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cutting data used on the demonstrator

sequence of processing	processing strategy	a_e	a_p	offset	f_z	V_c
roughing torus D6	vol. roughing following contour	3,00	6,00	0,60	0,20	280
roughing torus D12	vol. roughing following contour	6,00	12,00	0,12	0,21	560
roughing torus D20	vol. roughing following contour	10,00	20,00	2,00	0,23	940
finishing ball D6	zigzag stroke milling	0,06	0,60	0,00	0,51	280
finishing ball D12	zigzag stroke milling	0,12	1,20	0,00	0,51	560
finishing ball D20	zigzag stroke milling	0,20	2,00	0,00	0,51	940

tools used on the demonstrator

tool manufacturer	tool type	D_c	L_0	L_1	L_2	Z_n
hufschmied-tools.com/de/	PROTO-LINE / Torus	6,0	60,0	23,0	8,0	2
hufschmied-tools.com/de/	PROTO-LINE / Torus	12,0	100,0	55,0	16,0	2
hufschmied-tools.com/de/	PROTO-LINE / Torus	20,0	0,0	87,0	20,0	2
hufschmied-tools.com/de/	PROTO-LINE / Kugel	6,0	60,0	23,0	10,0	2
hufschmied-tools.com/de/	PROTO-LINE / Kugel	12,0	83,0	52,0	10,5	2
hufschmied-tools.com/de/	PROTO-LINE / Kugel	20,0	104,0	67,0	17,0	2



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