

Please send this form to your contact person.

Cutting protocol milling

Company:

Contact name:

Street:

City:

Administrator:

Machine:

P:

[HP]

Model:

RPM max:

[min-1]

Machine

Feedrate

Taper:

max:

[inch/min] CNC controller

Part-No.:

Date:

Material:

Analysis [%]:

C	Si	Mn	P	S	Cr	Ni	Mo	V	W		
N/mm ²		HB		HV		HRC					

Test	Current situation	Test 1	Test 2	Test 3
Tool				

Machining conditions:

Manufacturer:

Part number:

Arbor – Holder type:

Tool gauge length:

Coolant / Air:

Cutting material

Manufacturer:

Part number:

Cutting material designation:

Coating:

Cutting data

SFM [ft/min]:

Feedrate [inch/min]:

RPM [min⁻¹]:

Tool diameter [inch]:

IPT Inches per tooth [inch]:

DOC Depth of cut [inch]:

Stepover/WOC Width of cut [inch]:

Machining time [min]:

Results

Number of parts:

Tool life [min]:

Tool life [feed]:

Chip volume [in³/min]:

Power consumption [HP]:

Assessment*:

1	2	3	4	5	6	7	8	9	10	1	2	3	4	5	6	7	8	9	10	1	2	3	4	5	6	7	8	9	10
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Sketch/comment:

*1 = very poor, 5 = satisfactory, 10 = very good