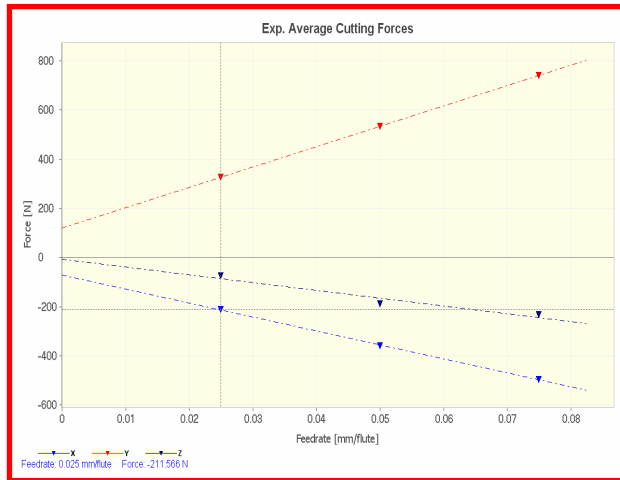




ST-52 D16_DOE16



Cutting Forces

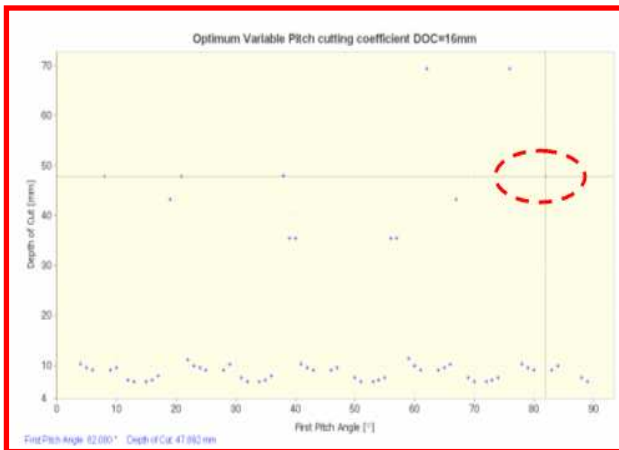
Material	Treatment/ Alloy	V _s (m/min)	Feed rate per tooth (f _t) in mm			
			ø 4-5 mm	ø 6,8 mm	ø 10-12 mm	ø 16-20 mm
Unalloyed steel / Structural steel	annealed 0,15 - 0,45% C HB 125 - 250	150 (140-180)	0,03 (0,01-0,04)	0,04 (0,03-0,06)	0,08 (0,06-0,14)	0,1 (0,08-0,15)

VHM-473W T35

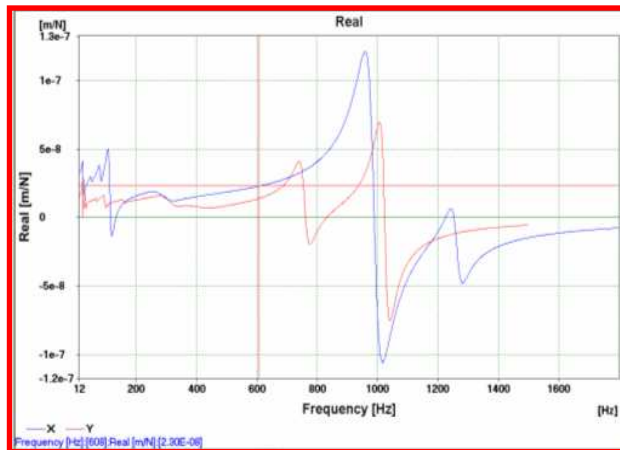
Tool angle

- Helix Angle [°]: 38
- Relief Angle [°]: 3
- Rake Angle [°]: 8

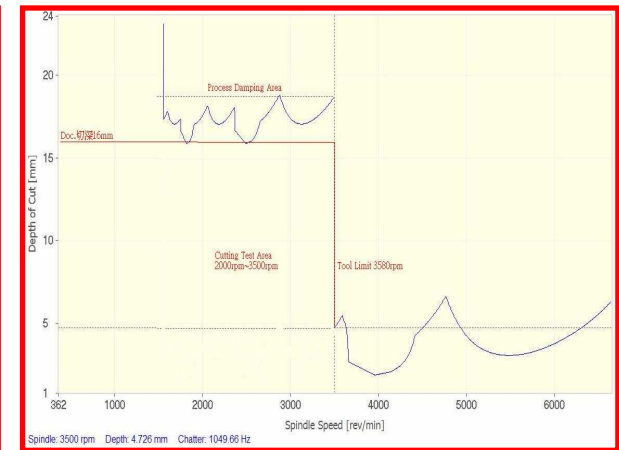
Tool



Optimize Variable Pitch



Dynamic Parameters



Stability Lobes