

Feeds and speeds - Speeds

Från Jens			Converted to Verket 24k RPM				
Material	POM		POM				
Bit	Upcut single flute		Upcut single flute	Rpm factor	Time factor		
Dia	3 mm		3 mm				
RPM	18000 rmp		24000 rmp	1,333333333	60		
Feed	18 mm/s		1440 mm/min	1,333333333	60		
Plunge	12 mm/s		960 mm/min	1,333333333	60		
ramp angle	18 deg		18 deg	1	1		
Pass depth	4 mm		3 mm	1	1		
Material	Alu		Alu				
Bit	Upcut single flute		Upcut single flute	Rpm factor	Time factor	Weak machine factor	
Dia	2 mm		2 mm				
RPM	18000 rmp		24000 rmp	1,333333333	60		
Feed	8 mm/s		640 mm/min	1,333333333	60		
Plunge	5 mm/s		400 mm/min	1,333333333	60		
ramp angle	12 deg		12 deg	1	1		
Pass depth	0,7 mm		0,5 mm	1	1	0,7142857143	
Direction	Climb		climb				
Material	Alu		Alu				
Bit	Upcut single flute		Upcut single flute	Rpm factor	Time factor	Weak machine factor	
Dia	3 mm		3 mm				
RPM	18000 rmp		24000 rmp	1,333333333	60		
Feed	9 mm/s		720 mm/min	1,333333333	60		
Plunge	6 mm/s		480 mm/min	1,333333333	60		
ramp angle	12 deg		12 deg	1	1		
Pass depth	1,2 mm		0,6 mm	1	1	0,5	
Direction	Climb		climb				

Feeds and speeds - Speeds

Material	Alu		Alu				
Bit	Upcut single flute		Upcut single flute		Rpm factor	Time factor	Weak machine factor
Dia	6 mm		6 mm				
RPM	18000 rmp		24000 rmp		1,333333333	60	
Feed	11 mm/s		880 mm/min		1,333333333	60	
Plunge	8 mm/s		640 mm/min		1,333333333	60	
ramp angle	12 deg		12 deg		1	1	
Pass depth	2,5 mm		1,25 mm		1	1	0,5
Direction	Climb		climb				
Material	Alu		Alu				
Bit	V bit two flute		V bit two flute		Rpm factor	Time factor	Weak machine factor
Dia	30 mm		32 mm				
RPM	18000 rmp		24000 rmp		1,333333333	60	
Feed	40 mm/s		3200 mm/min		1,333333333	60	
Plunge	6 mm/s		480 mm/min		1,333333333	60	
ramp angle	12 deg		12 deg		1	1	
Pass depth	0,5 mm		0,25 mm		1	1	0,5
Direction	Climb		climb				
Material	Alu		Alu				
Bit	BALL Upcut single flute		BALL Upcut single flute		Rpm factor	Time factor	Weak machine factor
Dia	6 mm		6 mm				
RPM	18000 rmp		24000 rmp		1,333333333	60	
Feed	31 mm/s		2480 mm/min		1,333333333	60	
Plunge	8 mm/s		640 mm/min		1,333333333	60	
ramp angle	12 deg		12 deg		1	1	
Pass depth	2,5 mm		1,25 mm		1	1	0,5
Direction	Climb		climb				