

## Technical information

Art.-Nr. 247 / 1 - high speed machining



### VHM - Schaftfräser

Art.-Nr.  
**247**

Flutes  
**3**



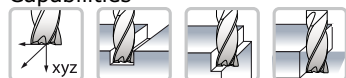
#### Tool data



#### Tool recommendation



#### Capabilities



## Areas of application and special features

HPC top product with internal cooling especially for aluminium and non-ferrous materials.  
Uneven partition, uneven helix and roughing flute.  
cutting edge and coating are polished.

## Competitive advantages and profitability

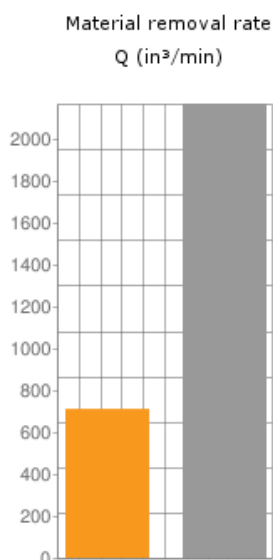
competition to Hoffmann, GW and Ceratizit

## Example application

Art.-Nr.: **247.160.10**  
Material: **Aluminium short-chipping**

Competitor: **höchste Zerspanungsleistung**  
Art.-Nr.: **247.160.10**

Inovatools			
D1	16,00	mm	Diameter
z	3		Flutes
ae	12,500	mm	Row pitch
ap	25,000	mm	Cutting depth
vc	371,20	m/min	Cutting speed
n	7385	U/min	Rotation speed
fz	0,10400	mm	Feed per tooth
vf	2304,05	mm/min	Feed rate
Q	720,01696255	cm³/min	Material removal rate
hm	0,07495	mm	Middle chipping thickness
K/M		€/std	Machine hourly cost
K/W		€	Tool cost
T		min	Tool life
V		cm³	Processing volume
Tb		min	Process time
€/Ws		€	Cost workpiece



Calculator			
D1	16,00	mm	Diameter
z	3		Flutes
ae	12,5	mm	Row pitch
ap	25	mm	Cutting depth
vc	750	m/min	Cutting speed
n	14921	U/min	Rotation speed
fz	0,155	mm	Feed per tooth
vf	6938,16	mm/min	Feed rate
Q	2.168,17525013	cm³/min	Material removal rate
hm	0,11170	mm	Middle chipping thickness
K/M		€/std	Machine hourly cost
K/W		€	Tool cost
T		min	Tool life
V		cm³	Processing volume
Tb		min	Process time
€/Ws		€	Cost workpiece

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