

## Technical information

Art.-Nr. 833 / 1 - example tempering steel



### VHM - Schafffräser Starmax 3G

Art.-Nr. **833** Flutes **4**



#### Tool data



#### Tool recommendation



#### Capabilities



## Areas of application and special features

Highend HPC mill for higher alloyed steel, maximum removal rate and stability. Optimal machine parameters and cutting data required. We recommend DIN6535HB chucking. Uneven partition, uneven helix, profile flute for better chip outlet, stronger core, polished highend coating and plated shank for higher holding force. Next generation of article 731,732,733.

## Competitive advantages and profitability

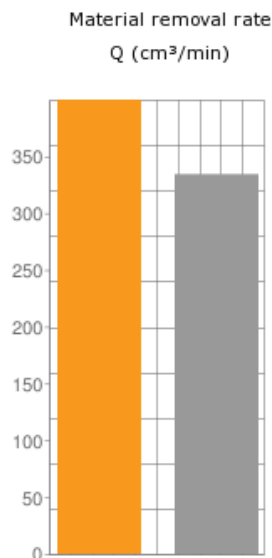
No competitors are known.

## Example application

Art.-Nr.: **833.160.10**  
Material: **Tempering steel <850 N/mm<sup>2</sup> (<25 HRC)**

Competitor: **Inovatools**  
Art.-Nr.: **833.160.10**

Inovatools – Roughing			
D1	16,00	mm	Diameter
z	4		Flutes
ae	16,000	mm	Row pitch
ap	16,000	mm	Cutting depth
vc	155,56	m/min	Cutting speed
n	3095	U/min	Rotation speed
fz	0,12613	mm	Feed per tooth
vf	1561,46	mm/min	Feed rate
Q	399,73442000	cm <sup>3</sup> /min	Material removal rate
hm	0,08030	mm	Middle chipping thickness
K/M		€/std	Machine hourly cost
K/W		€	Tool cost
T		min	Tool life
V		cm <sup>3</sup>	Processing volume
Tb		min	Process time
€/Ws		€	Cost workpiece



Calculator			
D1	16,00	mm	Diameter
z	4		Flutes
ae	8	mm	Row pitch
ap	16	mm	Cutting depth
vc	220	m/min	Cutting speed
n	4377	U/min	Rotation speed
fz	0,15	mm	Feed per tooth
vf	2626,06	mm/min	Feed rate
Q	336,13523981	cm <sup>3</sup> /min	Material removal rate
hm	0,09549	mm	Middle chipping thickness
K/M		€/std	Machine hourly cost
K/W		€	Tool cost
T		min	Tool life
V		cm <sup>3</sup>	Processing volume
Tb		min	Process time
€/Ws		€	Cost workpiece

