



FLUTING WHEELS



CASE STUDY ENDMILL, 4 FLUTES SIDE, DOUBLE ENDED

WORKPIECE: Endmill, 4 Flutes
Side, Double Ended


DIMENSIONS: .5" Diameter

FLUTE LENGTH: 1.25"

DEPTH OF CUT: .080"

MATERIAL: Carbide

MACHINE: ROLLOMATIC 620XS

| | COMPETITOR WHEEL |  |
|--|-------------------------------------|--|
| PRODUCT | D240 OR D320 | 1A1 6 X 10MM X 50MM D320 |
| PARAMETERS | 180 MM/MIN (W/ 20% SPINDLE LOAD) | 220 MM/MIN (W/ 14% SPINDLE LOAD) |
| STICK DRESSING | EVERY 75 TOOLS | EVERY 250 TOOLS |
| Q' = (DOC MM x Feed Rate (VT) in MM/min)/60 | 6.1 | 7.5 |



SUCCESSSES

Feed **INCREASED** from 180 to 220 mm/min.

MINIMAL STICK DRESSING with free cutting wheel.

NO MEASURED WHEEL WEAR after 250 tools (2000 flutes).

