



FLUTING WHEELS



CASE STUDY ENDMILL, 4 FLUTES

WORKPIECE: Endmill, 4 Flutes


DIMENSIONS: 1" Diameter

FLUTE LENGTH: 2.35"

DEPTH OF CUT: .220"

MATERIAL: Carbide

MACHINE: ANCA TX7+

	COMPETITOR WHEEL	
PRODUCT	D240	1A1 6 X .5 X 1.25 D240
FEED RATE	1"/MIN (30% SPINDLE LOAD)	4"/MIN (44% SPINDLE LOAD)
STICK DRESSING	EVERY 2 TOOLS	EVERY 5 TOOLS
Q' = (DOC MM x Feed Rate (VT) in MM/min)/60	2.4	9.4

 **SUCCESSSES**

FREE CUTTING WHEEL
for heavy DOC, while retaining shape.

NO MEASURABLE WHEEL WEAR after 6 tools.

