

parameters for milling of
 ebalta special resins with milling tools
 from KIENINGER

tool for roughing

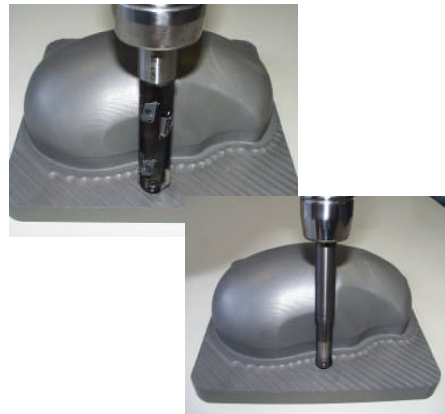
GRT 25

WRS25 / WPS -A-

Ø tool:	25 mm
cutting speed Vc:	628 m/min
revolutions n:	8000 1/min
feed Vf:	7500 mm
feed / tooth fz:	0,46 mm
number of teeth z:	2
cutting depth ap:	5-20 mm
step over ae:	5 mm

ebalta - material

ebazell 160



tool for finishing

GWR 16 HM

WPR 16 with chin-breaker

Ø tool:	16 mm
cutting speed Vc:	603 m/min
revolutions n:	12000 1/min
feed Vf:	7500 mm
feed / tooth fz:	0,31 mm
number of teeth z:	2
cutting depth ap:	0,5 mm
step over ae:	0,3 mm

Attention! Please note that the feed per tooth (**fz**) should be chosen from the recommended parameters (parameters should not be changed).

If an other diameter is used, the number of revolutions must be corrected : $n = \frac{Vc \cdot 1000}{d \cdot \pi}$ U/min

If the number of revolutions are not available (*too high for available machines*), please correct the feed-rate (Vf) :
 $Vf = fz \cdot z \cdot n$ mm/min