# ebablock® P 185

milling-parameters

n = revolutions
z = number of teeh
d = diameter
vf = feed rate

$$n = \frac{vc \cdot 1000}{d \cdot \pi} \quad [1/min]$$

$$vf = n \cdot fz \cdot z \quad [mm/min]$$

$$fz = \frac{vf}{z \cdot n} \quad [mm]$$

$$vc = -$$

*The specified tools and cutting parameters are for reference only. They may vary depending on the machine tool and part size*

| Technical Datas | Machining 1 | Machining 2 | Machining 3 | Machining 4 | Machining 5 | Machining 6 | Machining 7 |
|---|---|---|---|---|---|---|---|
| **Strategy** | **Roughing Z-Constant** | **Profile Roughing** | **Roughing Pocket** | **Roughing Residual Material Z-Constant** | **Finishing Face Milling** | **Finishing Z-Constant** | **Engraving** |
| **Type of milling cutter** | EMZ90 V22.042TH050 (1043249) | EBG V16.016AN140 | DHC Ø12 INOX | EBG V12.012AN120-C (6128023) | EBG V10.010AN120-C (6130578) | EBG R08.008AP100-C (9148824) | Airline Kugel (1121894) |
| **indexable inserts** | VCGT 220530-ALM (1069759) | WPB 16 AF 30 | - | WPB 12 CF 20 (6128107) | WPB 10 CF 10 (6129238) | WPR 08 DN (6131629) | - |
| **cutting diameter** [mm] | 42 | 16 | 12 | 12 | 10 | 8 | 2 |
| **number of tool cutting edges** | 3 | 2 | 4 | 2 | 2 | 2 | 2 |
| **Radius** [mm] | 3 | 3 | 0 | 2 | 1 | 4 | 1 |
| **Cutting Speed vc** [m/min] | 570 | 320 | 340 | 500 | 450 | 377 | 100 |
| **Revolutions n** [1/min] | 4320 | 6366 | 9000 | 13262 | 14323 | 15000 | 15900 |
| **Feed per Tooth fz** [mm] | 0,2 | 0,4 | 0,15 | 0,2 | 0,10 | 0,1 | 0,1 |
| **Feed Rate vf** [mm/min] | 3000 | 5100 | 5304 | 5100 | 2865 | 3000 | 3000 |
| **Axial Depth of Cut ap** [mm] | 5 | 2,5 | 10 | 2 | 0,2 | 0,2 | 0,3 |
| **Radial Depth of Cut ae** [mm] | 30 | 3 | 6 | 8 | 6 | 0,5 | 0 |
| **Runtime [min]** | 10 | 14 | 1 | 1 | 12,0 | 180 | 1 |
| **Dust Formation** | high | middle | low | low | low | none | none |



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