KIENINGER
Ein Unternehmen
der LMT-Gruppe

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:	9500 mm/min
feed / tooth fz:	0,6 mm
number of teeth z:	2
cutting depth ap:	5-20 mm
step over ae:	5 mm

ebalta - material

ebazell 80

tool for finishing

GWR 16 HM
WPR 16 with chin-breaker

Ø tool:	16 mm
cutting speed Vc:	502 m/min
revolutions n:	10000 1/min
feed Vf:	10000 mm
feed / tooth fz:	0,5 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 : $n = \frac{Vc \bullet 1000}{d \bullet \pi}$ U/min

If the number of revolutions are not available (*too high for available maschines*), please correct the feed-rate (Vf) :

$Vf = fz \bullet z \bullet n$ mm/min

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