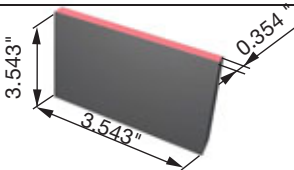
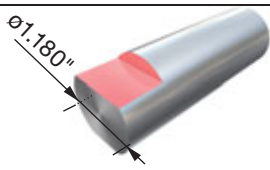
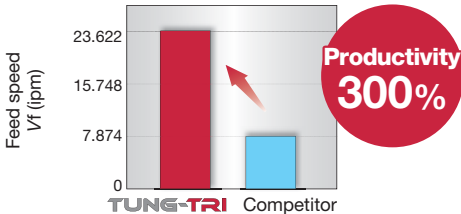
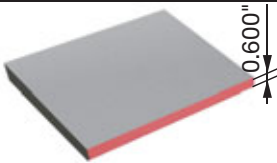
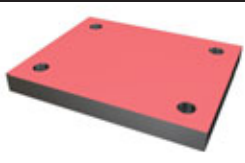
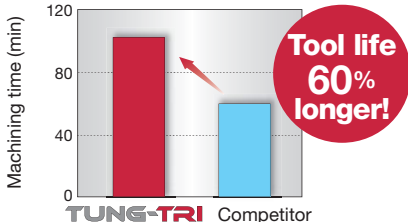
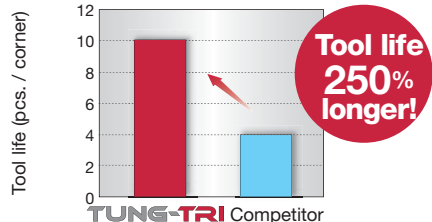


PRACTICAL EXAMPLES

Workpiece type		Plate	Machine part									
Cutter		EPA06R075U0075-03N (ø0.750", z = 3)	EPA10R125U0125W03N (ø1.250", z = 3)									
Insert		TOMT060304PDER-MJ	TOMT100404PDER-MJ									
Grade		AH3135	AH3135									
Workpiece material		304	1045									
		 M	 P									
Cutting conditions	Cutting speed: V_c (sfm)	410	150									
	Feed per tooth: f_z (ipt)	0.003	0.19									
	Feed speed: V_f (ipm)	23.6	836									
	Depth of cut : a_p (in)	0.06	1									
	Width of cut : a_e (in)	0.354	5									
	Machining	Shoulder milling	Shoulder milling									
Coolant	Dry	External air										
Machine	CAT40	Turn-Mill center										
Results		 <p>Uniquely designed cutting edge geometry delivers low cutting force and prevents chattering, resulting in highly efficient machining of steel sheet.</p>	<table><tr><th>Conditions</th><th>Burr</th><th>Wall surface finish</th></tr><tr><td>TUNG-TRI</td><td>Small</td><td>Better</td></tr><tr><td>Competitor</td><td>Big</td><td>Worse</td></tr></table> <p>Due to low cutting force, Tung-Tri leaves a smaller burr and better wall surface finish compared to the competitor.</p>	Conditions	Burr	Wall surface finish	TUNG-TRI	Small	Better	Competitor	Big	Worse
Conditions	Burr	Wall surface finish										
TUNG-TRI	Small	Better										
Competitor	Big	Worse										
Workpiece type		Base	Block									
Cutter		EPA10R125U0125W03N (ø1.250", z = 3)	TPA10R250U0075A06 (ø2.500", z = 6)									
Insert		TOMT100404PDER-MJ	TOMT100408PDER-MJ									
Grade		AH3135	T1215									
Workpiece material		1050	100-70-03									
		 P	 K									
Cutting conditions	Cutting speed: V_c (sfm)	430	643									
	Feed per tooth: f_z (ipt)	0.004	0.006									
	Feed speed: V_f (ipm)	15.4	35.433									
	Depth of cut : a_p (in)	0.060	0.098									
	Width of cut : a_e (in)	1.00	2.146									
	Machining	Shoulder milling	Face milling									
Coolant	External air	Dry										
Machine	Vertical M/C	CAT40										
Results		 <p>Due to strong wear resistance of AH3135 grade, tool life is increased by 60%.</p>	 <p>T1215 exhibited a superior wear resistance, extending the tool life well over to 250%.</p>									