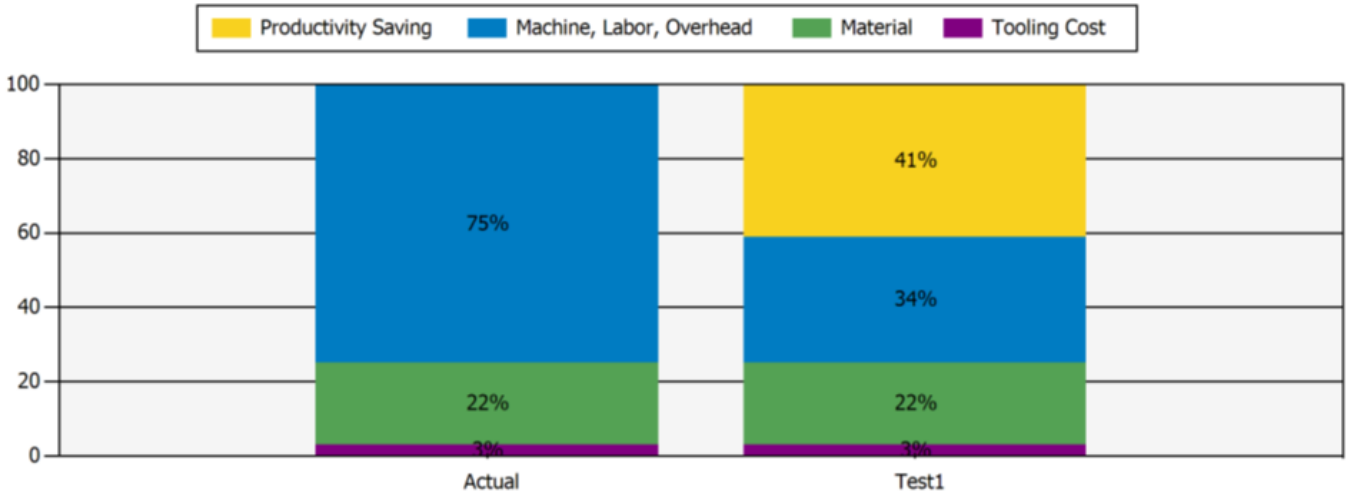
Test Report Summary - Copy Milling

Colibri's TJS 20K-HSK A63 Jet Spindle model

Test Date	Dec, 2015
Country	Germany
Industry	General machining
Application	Copy milling
Material Group	Aluminum - wrought alloy
Material No.	DIN AlZnMgCuO,5

Test Data	Actual	Test
Cutting Tool	Iscar: EC-A2 020-030/12C4M45903	
Spindle Type	Machine Spindle	TJS 20K-HSK A63
Diameter (mm)	2	2
No. of Flutes	2	2
Overhang (mm)	12	12
Cutting Speed (m/min)	107	232
Spindle Speed (rpm)	17,030	36,924
Depth of Cut (mm)	0.5	0.5
Width of Cut (mm)	1.5	1.5
Feed per Tooth (mm/t)	0.026	0.026
Table Feed (mm/min)	886	1,920
Surface Quality	Good	Good
Metal Removal Rate (cm3/min)	0.66	1.44

Time/Cost Evaluation	Actual	Test
Cutting Time/Part (sec)	1,084.1	500
Cost Savings Per Part	-	18.8%

Productivity Saving