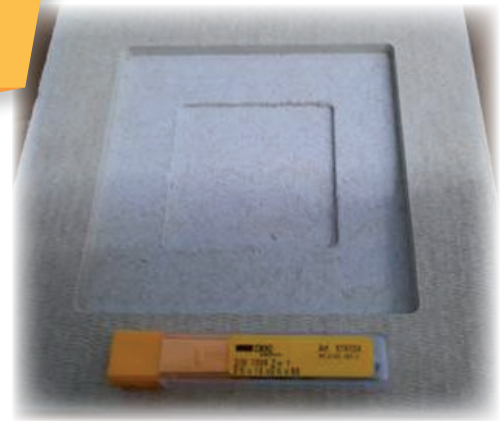




APPLICATION EXAMPLE

PANEL RECYCLED MATERIAL MILLING

APPLICATION FIELD :
Indoor furniture



MACHINING

Tools	SINGLE FLUTE END MILL DIXI 7306 Ø 3 x 15 x Ø 4 x 50 Z = 1
	
	ROUTER FOR COMPOSITES DIXI 7112 Ø 5 x 20 x 5 x 75 Z = 2
	

MACHINING CONDITIONS

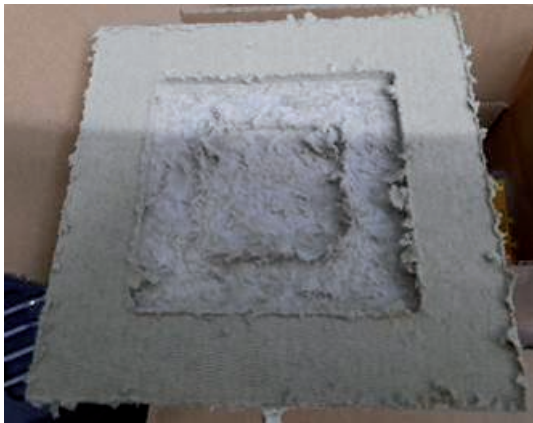
Material	HONEXT® environmentally friendly chipboard made from recycled material
Machining operation	Groove and pocket milling
Machine	Gantry milling machine
Attachment	ER Clamp
Lubricant	Vacuum only
Cutting conditions	Vc = 190 m/min n = 20'000 rpm fz = 0.05 mm/tooth (Z = 1) Vf = 1'000 mm/min ap = 4.25 mm ae = 5 mm ap = 0.2 mm finished with DIXI 7112 ae = 0.2 mm finished with DIXI 7112

MACHINING PROCESS

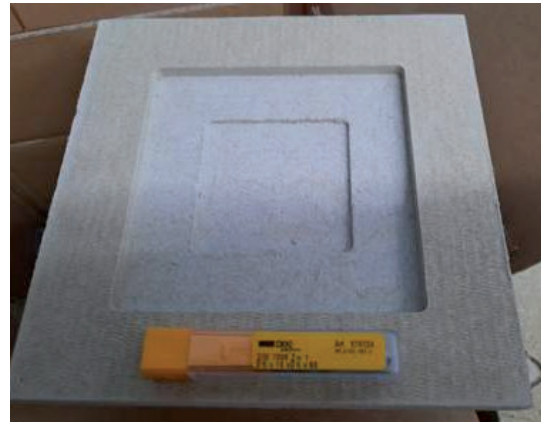
Honext is an environmentally friendly product using cellulose found in waste paper and cardboard. The material is easy to machine but sharp tools are needed to prevent the material from fraying.

RESULTS

Machining this material with our DIXI 7306 1 one flute cutters allows for optimal chip evacuation when grooving. The exceptional sharpness of these tools favours perfect cutting of this material without burrs. A finishing operation with the DIXI 7112 cutters is recommended for a better result.



**MILLING OF POCKETS WITH
A CONVENTIONAL MILLING CUTTER**



**MILLING OF POCKETS WITH OUR DIXI 7306
MILLING CUTTERS AND 7112 FINISHERS**



**GROOVING WITH A
CONVENTIONAL MILLING CUTTER**



**GROOVING WITH OUR CUTTERS
DIXI 7306**

CONCLUSION

The manufacturer HONEXT® recommends DIXI tools for machining this material.

<https://honextmaterial.com/>