

„VITA VIONIC® DENT DISC multiColor“

Information for CNC machines

Machining mode : MILLING

- Tools
 - Parameters
-

VITA

Material

„VITA VIONIC® DENT DISC multiColor“

Cooling

„VITA VIONIC® DENT DISC multiColor“ can be milled dry with air cooling or wet.

Recommended tools

Diamond coated ball nose end mills (synonym: carbon or DLC-coating) are necessary. It is recommended to use the same diamond coated tools as used for milling zirconium dioxide.

We recommend appropriate dental tools from:

www.zecha.de

www.emuge-franken.de

www.imes-core.com

Recommended milling parameters:

Roughing	
tool	Ø 2,5mm
tool speed [U/min]	18000
tool feed X Y [mm/min]	2000
tool feed Z [mm/min]	1500
stepover XY [mm]	1,875 (75% of tool diameter)
stepover Z [mm]	1,25

Finishing		
tool	Ø 2,5mm	Ø 1mm
tool speed [U/min]	18000	45000
tool feed XY [mm/min]	2000	1000 - 1500
tool feed Z [mm/min]	1500	500 - 1000
stepover XY [mm]	0,25 - 0,5	0,1 - 0,15