

SECO

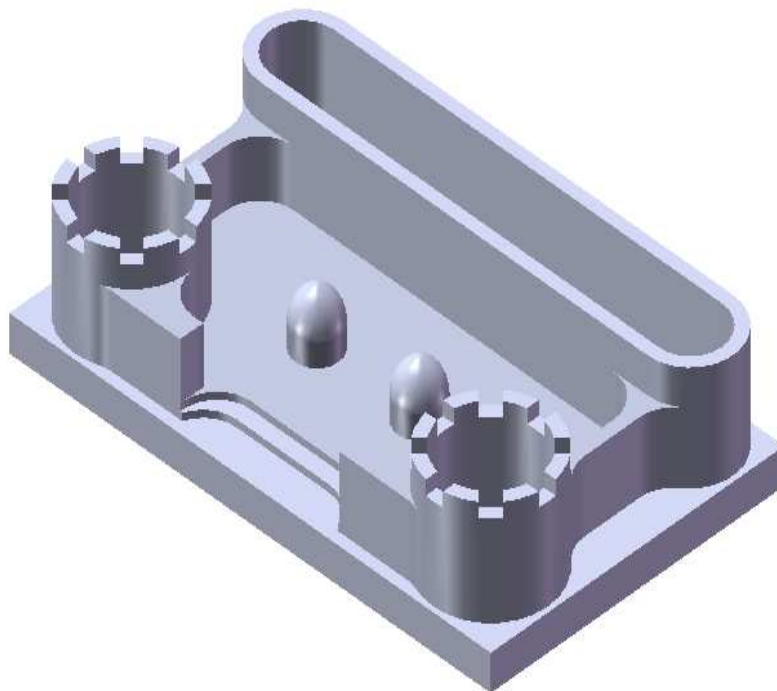
MILLING DEMO

MACCHINA: WICKER DM-1160 ISO40 Din69871

PEZZO: CASTELLO

DIMENSIONI: 170mm x 100mm x 40mm

MATERIALE: C45



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Reg. N. 1192-A
UNI EN ISO 9001:2008

Op. 1: Spianatura sgr.

Attacco : E3469 5525 2235

Fresa : R220.24-0050-12-5A

Inserto: ROHT1204M0-M12 MS2500

vc = 400 m/min

n = 2900 rpm

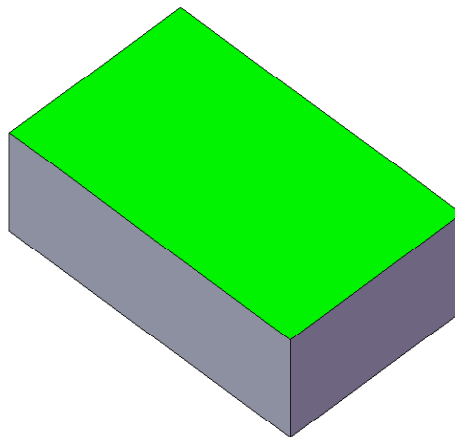
fz = 0,45 mm/z

vf = 6700 mm/r

ap = 0,8 mm

ae = 35 mm

Refrigerante: aria



Op. 2: Cava

Attacco : E3469 5525 2235

Fresa : R220.24-0050-12-5A

Inserto: ROHT1204M0-M12 MS2500

vc = 400 m/min

n = 2850 rpm

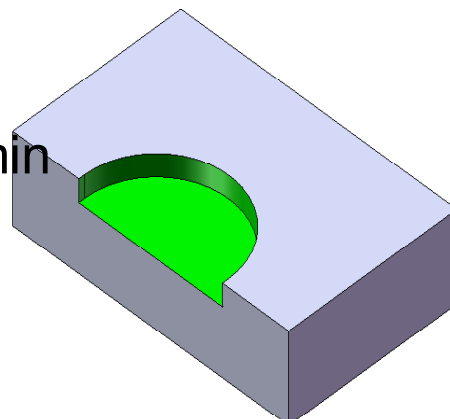
fz = 0,33 mm/z

vf = 4700 mm/min

ap = 1 mm

ae = 35 mm

Refrigerante: aria



Op. 3: Spianatura fin.

Attacco : E3469 5525 2235

Fresa : R220.96-0050-08-5A

Inserto: XNEX080608TR-M13 MP3000

Inserto: XNEX080608ZZR-M11 MP3000

vc = 300 m/min

n = 1910 rpm

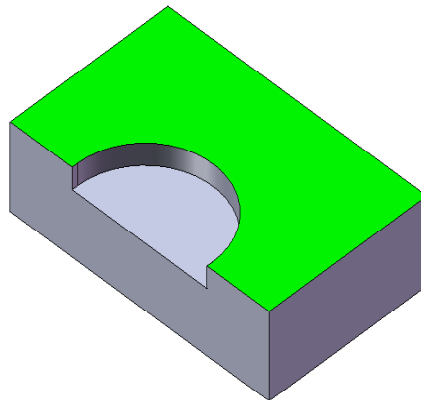
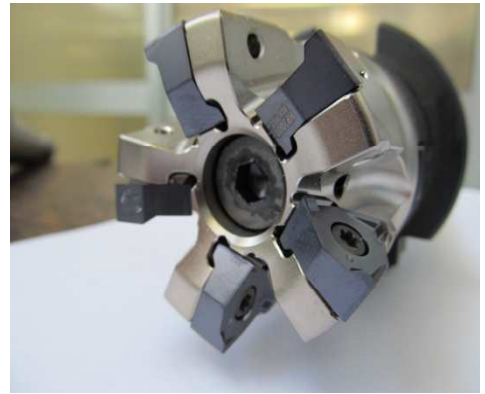
fz = 0,25 mm/z

vf = 2390 mm/n

ap = 0,2 mm

ae = 35 mm

Refrigerante: aria



Op. 4: Contornatura

Attacco : E3476 5820 1240

Fresa : R220.69-0050-10-7A

Inserto: XOMX10T308TR-M09 MP2500

vc = 450 m/min

n = 2850 rpm

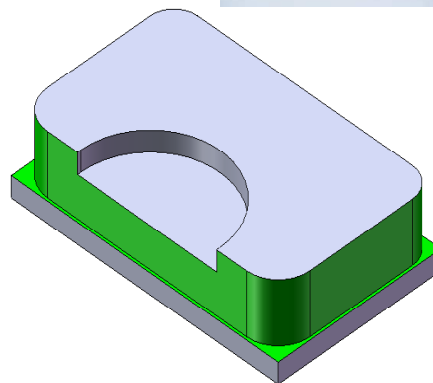
fz = 0,4 mm/z

vf = 8000 mm/min

ap = 5 mm

ae = 1 mm

Refrigerante: aria



Op. 5: Penetrazione assiale

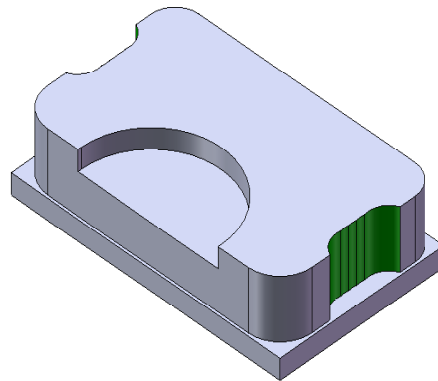
Attacco : E4469 584 25100

Codolo : R217.96-2525.3-04-5A

Testina: XNEX040308TR-M08 MP3000

vc = 200 m/min
n = 2550 rpm
fz = 0,13 mm/z
vf = 1650 mm/min
ap = 3 mm
ae = 25 mm

Refrigerante: aria



Op. 6: Cava dal pieno

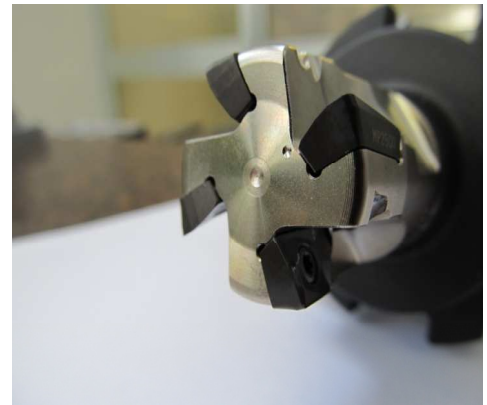
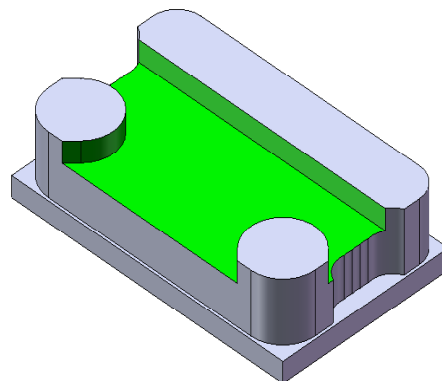
Attacco : E3476 5820 1240

Fresa : R217.69-1225.RE-10-4A

Inserto: XOMX10T308TR-M09 MP2500

vc = 250 m/min
n = 3180 rpm
fz = 0,14 mm/z
vf = 1530 mm/min
ap = 3,3 mm
ae = 25 mm

Refrigerante: aria



Op. 7: Interpolazione elicoidale+cava

Attacco : E3476 5820 1060

Fresa : R217.21-1020.RE-LP06-3A

Inserto: LPHT060310TR-M06 MP2500

vc = 250 m/min

n = 4000 rpm

fz = 0,6 mm/z

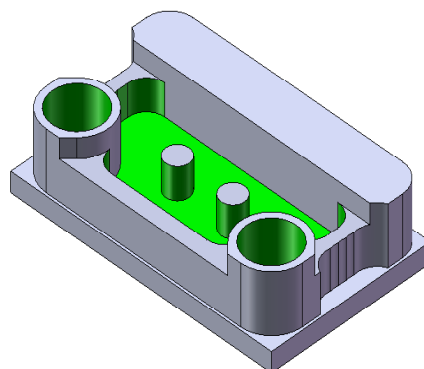
vf = 2700/8000

mm/min

ap = 0,6 mm

ae = 20 mm

Refrigerante: aria



Op. 8: Interpolazione elicoidale

Attacco : E3476 5820 0860

Fresa : R217.21-0816.RE-LP06.2A

Inserto: LPHT060310TR-M06 MP2500

vc = 250 m/min

n = 4970 rpm

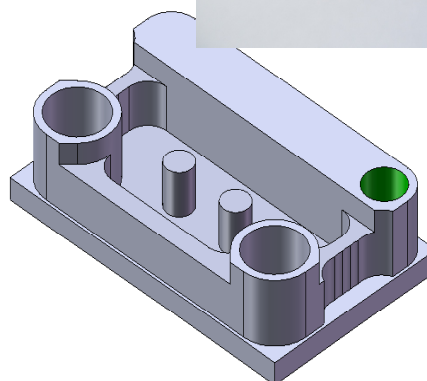
fz = 0,6 mm/z

vf = 1630 mm/min

ap = 0,5 mm

ae = 16 mm

Refrigerante: aria



Op. 9: Cava

Attacco : E3476 5820 1240

Fresa : R217.69-1225.RE-10-4A

Inserto: XOMX10T308TR-M09 MP2500

vc = 250 m/min

n = 3180 rpm

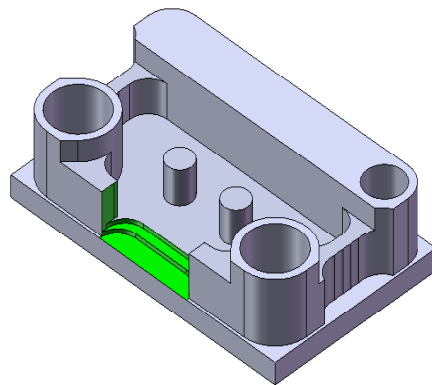
fz = 0,14 mm/z

vf = 1780 mm/min

ap = 3 mm

ae = 25 mm

Refrigerante: aria



Op. 10: Trocoidale+semifinit.

Attacco : E3469 5875 3270

Pinza : 5880 3220

Codolo : MP16-20070-000.60

Testina: MP16-16019R04Z6-M04, MP3000

vc = 250 m/min

n = 6000 rpm

fz = 0,08 mm/z

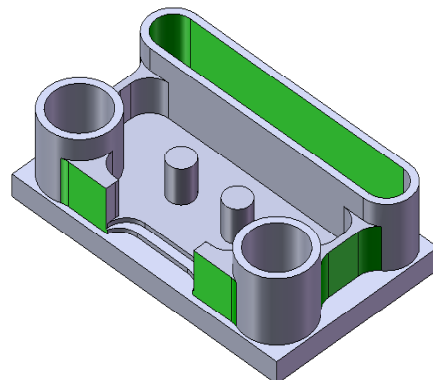
vf = 2000/3500

mm/min

ap = 18 mm

ae = 0,6 mm

Refrigerante: aria



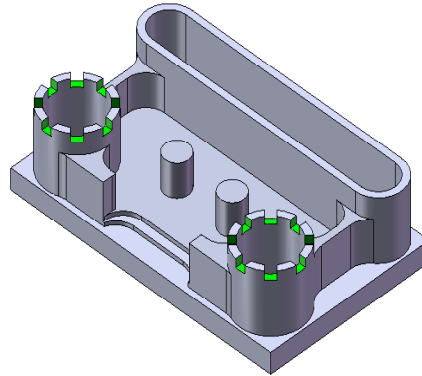
Op. 11: Cava

Attacco : E3476 5801 0680

Fresa : 553060R020Z3.0-SIRON-A

vc = 140 m/min
n = 7500 rpm
fz = 0,035 mm/z
vf = 750 mm/min
ap = 4 mm
ae = 6 mm

Refrigerante: aria



Op. 12: Finitura piani

Attacco : E3469 5875 3270

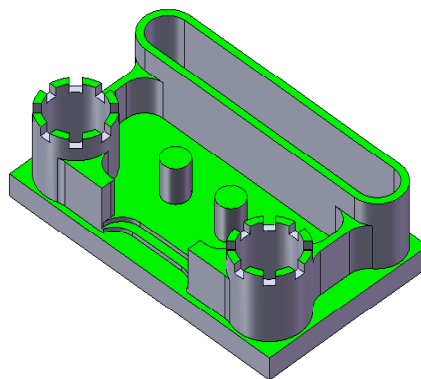
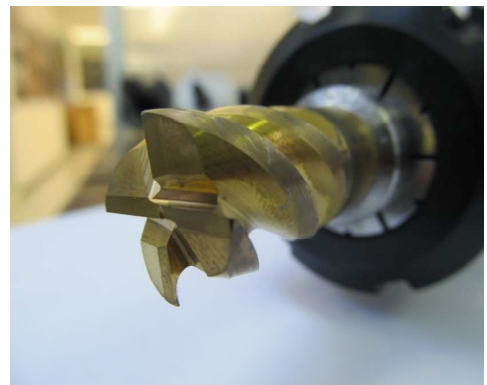
Pinza : 5880 3220

Codolo : MP16-20070-000.60

Testina:MP16-16019R04Z4-E04,F40M

vc = 250 m/min
n = 5000 rpm
fz = 0,08 mm/z
vf = 1600 mm/min
ap = 0,2 mm
ae = 16 mm

Refrigerante: aria



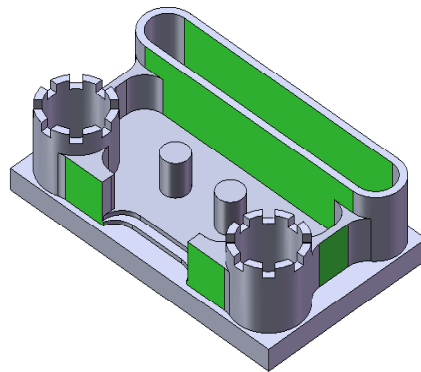
Op. 13: Finitura

Attacco : E3469 5803 1680

Fresa : JS520160D2S.0Z8-SIRA



vc = 250 m/min
n = 5000 rpm
fz = 0,08 mm/z
vf = 2400 mm/min
ap = 30 mm
ae = 0,3 mm
Refrigerante: aria



Op. 14: Copiatura

Attacco : E3469 5803 0880

Fresa : JS533080D1B.0Z3-SIRA



vc = 325 m/min
n = 13000 rpm
fz = 0,08 mm/z
vf = 3000 mm/min
ap = 15 mm
ae = 0,1 mm
Refrigerante: aria

