



## TURNING DEMO

**MACCHINA:** Tornio GOODWAY GS280M

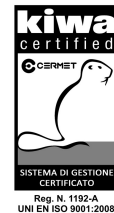
**PEZZO:** Regina

**DIMENSIONI:** Ø 50mm x 100mm

**MATERIALE:** C45



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e-mail: [info@utensileria-lughese.it](mailto:info@utensileria-lughese.it)  
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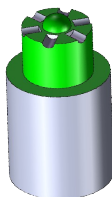
### Op. 1: Intestatura e preparazione diametro.

Stelo: DDJNL2525M15-M

Inserto: DNMG150608-M3 TP2500

vc = 250 m/min  
fz = 0,25- 0,15 mm/giro  
ap = 2,5 mm  
ae = 36 mm

Refrigerante: Emulsione



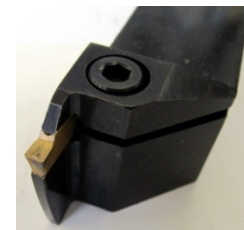
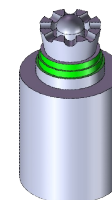
### Op. 4: Finitura frontale e smussi

Stelo: CFIL2525-M03

Inserto: LCMF160304-0300-FT CP500

vc = 180 m/min  
fz = 0,2 mm/giro  
ae = 3 mm

Refrigerante: Emulsione



### Op. 2: Scanalatura assiale e finitura sfera

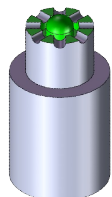
Stelo: GL2525H-V21

Modulo: V21-CJR1303L030017

Inserto: LCMF1303M0-0300-MP CP500

vc = 120 m/min  
n = 1900 rpm  
fz = 0,05 mm/giro  
ap = 3 mm  
ae = 5 mm

Refrigerante: Emulsione



### Op.5: Sgrossatura cono e base

Stelo: DDJNL2525M15-M

Inserto: DNMG150608-M3 TP2500

vc = 250 m/min  
fz = 0,25 mm/giro  
ap = 2,5 mm  
ae = 25 mm

Refrigerante: Emulsione



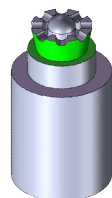
### Op. 3: Tornitura conica frontale

Stelo: DDJNL2525M15-M

Inserto: DNMG150608-M3 TP2500

vc = 250 m/min  
fz = 0,25 mm/giro  
ap = 1,5 mm  
ae = 15 mm

Refrigerante: Emulsione



### Op. 6: Finitura cono: Penetrazione radiale e profilatura

Stelo: CIFL2525M03

Inserto: LCMF1603M0-0300-MP CP500

vc = 150 m/min  
fz = 0,25 mm/giro  
ap = 1 mm (variabile)

Refrigerante: Emulsione



**Op. 7: Profilatura posteriore  
Sgrossatura cava 8x2.**

*Stelo:* CFSL2020M1902JET

*Inserto:* LCMF1902M0-0200-MP CP500

vc = **150** m/min

fz = **0,08** mm/giro

ap = **1** mm

Refrigerante: **Emulsione**



**Op. 8: Eliminazione raggi e finitura cava 8x2  
Esecuzione cava 2x15  
Troncatura**

*Stelo:* CFZL2525M2802RBJET

*Inserto:* LCMF280202-0200 -FT CP500

vc = **150** m/min

fz = **0,06** mm/giro

ap = **0,5** mm tornitura

Refrigerante: **Emulsione**

