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|------------------------------|--|-------------------|
| Halle / Hall: | 3 | Uhrzeit / Time |
| Maschine / Machine: | VCC 50 / 3-Achs-Bearbeitungszentrum / 3-axis machining center / SK50 | 10:00 - 10:30 Uhr |
| Industrie / Industry: | Vorführbauteil / Demo part | 11:30 - 12:00 Uhr |
| Bauteil / Workpiece: | Messebauteil / Exhibition part (200 x 100 x 60 mm) | 13:00 - 13:30 Uhr |
| Material / Material: | Hardox 400 | 14:30 - 15:00 Uhr |
| CAM / CNC control: | Siemens 840D sl | 16:00 - 16:30 Uhr |
| Spannmittel / Clamping tool: | Universalspanner von Kesel / Universal clamping device by Kesel | |

| Nr. / No. | Bearbeitung / Machining | Werkzeug / Tool | Ø | z | Vc [mm/min] | fz [mm] | n [U/min] | vf [mm/min] | ae [mm] | ap [mm] | Q [cm ³ /min] | P [kW] | Wendeplatte / Insert | Qualität / Grade |
|-----------|-------------------------|------------------|----|---|-------------|---------|-----------|-------------|---------|---------|--------------------------|--------|----------------------|------------------|
| 1 | Planfräsen / Roughing | DN6H080R00 | 80 | 7 | 80 | 0,2 | 320 | 450 | 55 | 5 | 123 | 5,5 | SNGU1205ENN | IN4030 |
| 2 | Besäumen / Roughing | 22J3R050046Z4R00 | 50 | 4 | 80 | 0,17 | 510 | 350 | 15 | 40 | 210 | 9,5 | ZOMT130404R | IN2530 |
| 3 | Besäumen / Finishing | 47C20042T4RQ060 | 20 | 4 | 180 | 0,16 | 2860 | 1800 | 1 | 40 | - | - | VHM | IN2005 |
| 4 | Vollspur / Roughing | 47C20026W4RQ040 | 20 | 4 | 120 | 0,075 | 1900 | 570 | 20 | 20 | 228 | 10,5 | VHM | IN2005 |
| 5 | Bohren / Boring | QR0400080JGR00 | 40 | 1 | 80 | 0,17 | 650 | 110 | 40 | 20 | 138 | 6,28 | SOMT130408SK | IN2505 |
| 6 | Fasen / Chamfering | 15N1D017045T3R00 | 17 | 4 | 160 | 0,1 | 3000 | 1200 | 1 | 1 | - | - | SDMT050204N | IN2505 |
| 7 | Schlichten / Finishing | 6F2B063R00 | 63 | 3 | 180 | 0,7 | 909 | 640 | 55 | 0,1 | - | - | YDA323 | IN2010 |

BEARBEITUNGSSCHRITTE MACHINING STEPS

