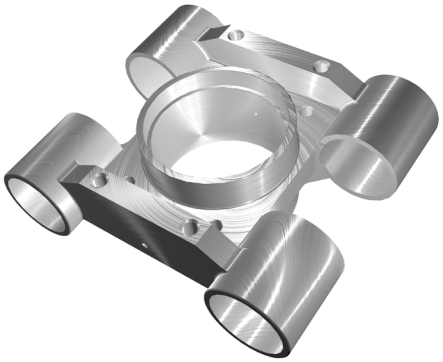
PRAKTISCHE ZERSPANUNG
MACHINING IN PRACTICE

InDays4 INNOVATIONSTAGE

röders TEC



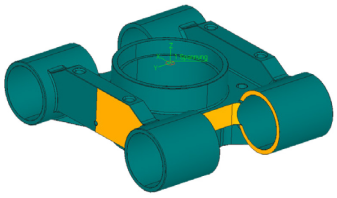
Halle / Hall	3
Maschine / Machine	RXP 601 DSH (mit Automation RCF150)
Industrie / Industry	Maschinenbau /Mechanical engineering
Bauteil / Workpiece	4-fach Säulenführung /Guide frame
Material / Material	40CrMnMoS8-6 / 1.2312
CAM / CNC control	Tebis / Röders
Spannmittel / Clamping tool	Schunk KSX 125 / Erowa UPC und ITS148

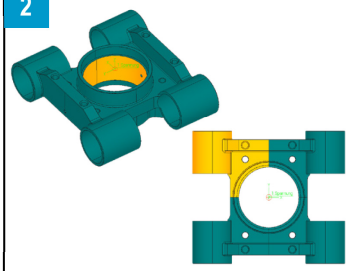
Uhrzeit / Time
11:00 - 11:30 Uhr
12:30 - 13:00 Uhr
14:00 - 14:30 Uhr
15:30 - 16:00 Uhr
17:00 - 17:30 Uhr

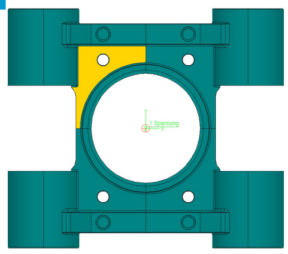
Nr. / No.	Bearbeitung / Machining	Werkzeug / Tool	Ø	z	Vc [m/min]	fz [mm]	n [U/min]	vf [mm/min]	ae [mm]	ap [mm]	Wendeplatte / Insert	Qualität / Grade
1	**Schruppen** / Roughing	47C12044W2RD020	12	5	225	0,12	5968	3580	0,7	40	---	IN2505
2	**Schruppen** / Roughing	1TG1B020023X6R00	20	5	200	0,6	3183	9549	14	0,25	UNLU0402MOTR	IN2505
3	**Schruppen** / Roughing	47C08021W0RQ160	8	4	200	0,09	7958	2865	0,9	18	---	IN2505
4	**Schruppen** / Roughing	INCOO080.200.024Z4	8	4	200	0,3	7958	9549	0,9	0,25	---	IN2006
5	**Vorschlichten** / Prefinishing	INRAP060.300.020Z4	6	4	220	0,05	11671	2334	0,3	0,25	---	IN2006
6	**Schruppen** / Roughing	1TG1B012017X4R00	12	3	200	0,6	5305	9550	12	0,25	UNLU0402MOTR	IN2505
7	**Schlichten** / Finishing	INRAP060.300.020Z4	6	4	220	0,1	11671	4500	0,25	0,2	---	IN2006
8	**Schlichten** / Finishing	47C08021W0RQ160	8	4	200	0,04	7960	1270	0,15	12	---	IN2505
9	**Schlichten** / Finishing	INRAP060.300.020Z4	6	4	220	0,05	11671	2334	0,15	0,2	---	IN2006
10	**Schlichten** / Finishing	46W10013T6RB020	10	2	220	0,05	7000	1050	0,1	1	---	IN2005

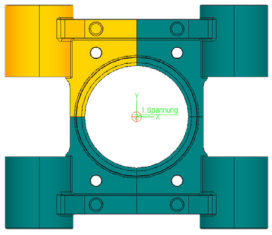
BEARBEITUNGSSCHRITTE

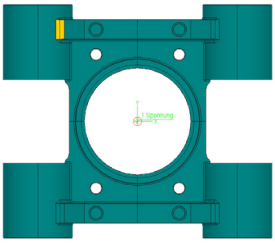
MACHINING STEPS

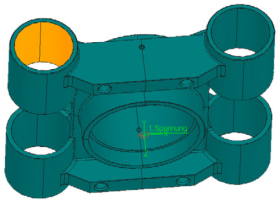
1


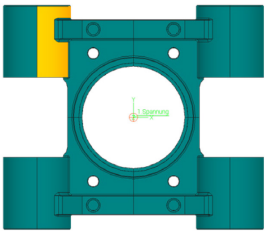
2


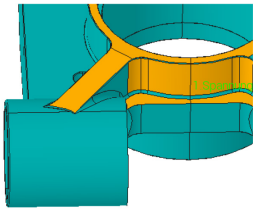
3


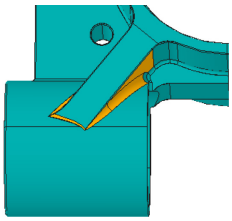
4


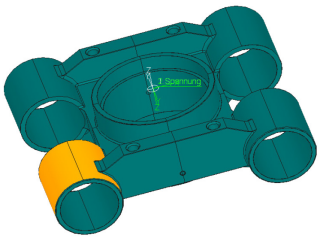
5


6


7


8


9


10


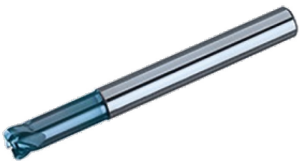
11

12

1

2

3

4


5

6

7

8

9

10

11

12