

SPINNER

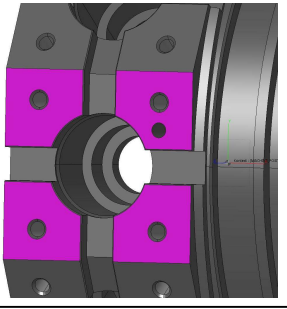
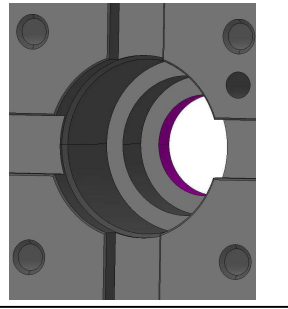
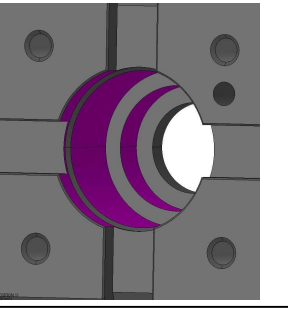
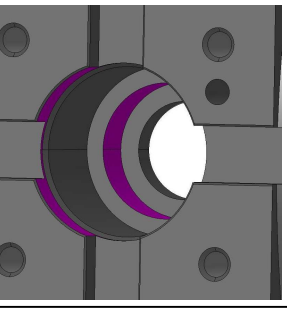
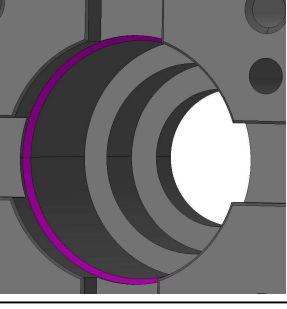
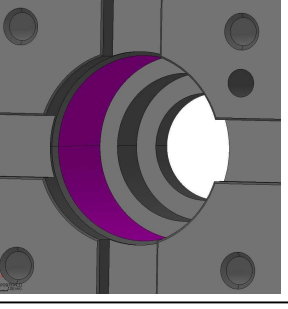
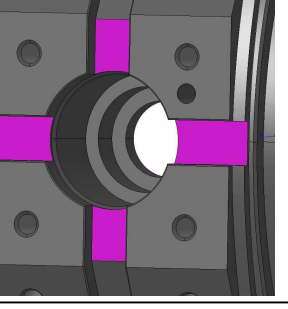
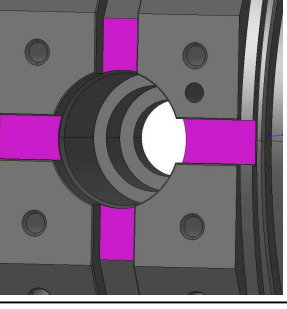
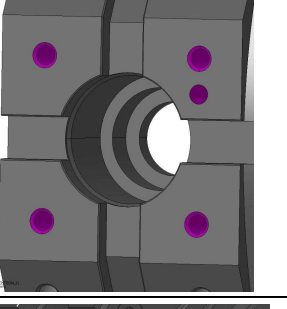
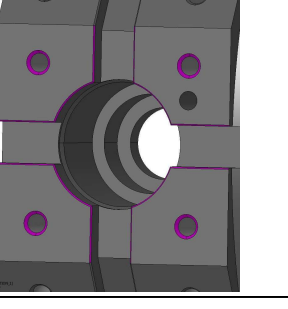
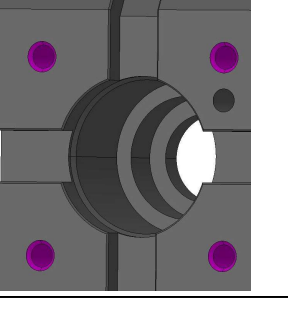
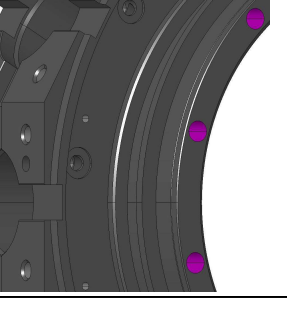
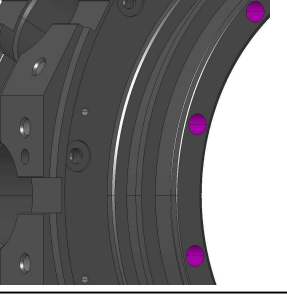


Halle / Hall	1
Maschine / Machine	Spinner U1530 / 5-Achs-Bearbeitungszentrum / 5-axis machining center / SK 40
Industrie / Industry	Maschinenbau
Bauteil / Workpiece	Revolverscheibe
Material / Material	42CrMoS4 / 1.7225
CAM / CNC control	Heidenhain TNC640
Spannmittel / Clamping tool	Adapter / Schunk RotaFlex 550

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	Planfräsen Anschraubfläche Face milling connecting face	DM5E040R00	40	8	220	0,2	1750	2800	30	1,5	PNMU0503GNTR	IN2505
2	Bohren Ø26 drilling	QR026078JFR00	26	1eff.	180	Fu 0,12	2205	265	-	-	SOMT08T306SK	IN2505
3	Schruppen bohrzirkular Roughing circular drill	15G4D025035X7R00	25	4	220	0,7	2800	7840	10	0,5	WCNW060205TR	IN2505
4	Schlichten Ø36/47 finishing	48J16032T3RD620	16	6	220	0,05	4380	1315	0,2	30	---	IN2005
5	Schräge 30° bevel	12M1D008025T1R00	13,7	2	220	0,1	5115	1025	1	2	AOMT060202R	IN2505
6	Spindeln Ø45 finish boring	TRE32 / SFCC32	45	1	160	0,09	1130	102	0,2	-	CCMT060202	DP300
7	Nuten schrappen Roughing slots	47C12016W2RQ024	12	4	140 / 250	0,04 / 0,1	3715 / 6635	600 / 2655	12 / 1,3	7	---	IN2005
8	Nuten schlichten Finishing slots	S012T08CA078	12	5	220	0,05	5840	1460	0,2	7	47D12009T8RP0201	IN2005
9	Kernloch für M8 Center bore	FR0680043T0R01	6,8	3	100	Fu 0,3	4680	1400	-	-	---	IN2205
10	Entgraten / Anfassen Deburring / chamfering	S010T06CA064	10	4	300	0,1	9550	3820	0,2	0,2	47N10004T6RA45	IN2005
11	Gewinde M8 fräsen Thread milling M8	MTECB 0606C14 1.25ISO	6	3	140	0,02	7430	445	0,6	-	---	IN2005
12	Vorbohren Ø10H7 Pre-drilling	TD0950029JCR00	9,8	2	100	Fu 0,13	3250	420	-	-	TPA0980R01	IN2505
13	Reiben Ø10H7 reaming	XS2100055T2RB1	10	6	80	0,06	2545	900	-	-	XSA10000R71	IN2005

BEARBEITUNGSSCHRITTE MACHINING STEPS

1		2		3		4	
5		6		7		8	
9		10		11		12	
13							

BEARBEITUNGSSCHRITTE

MACHINING STEPS

<p>1</p> 	<p>2</p> 	<p>3</p> 	<p>4</p> 
<p>5</p> 	<p>6</p> 	<p>7</p> 	<p>8</p> 
<p>9</p> 	<p>10</p> 	<p>11</p> 	<p>12</p> 
<p>13</p> 			