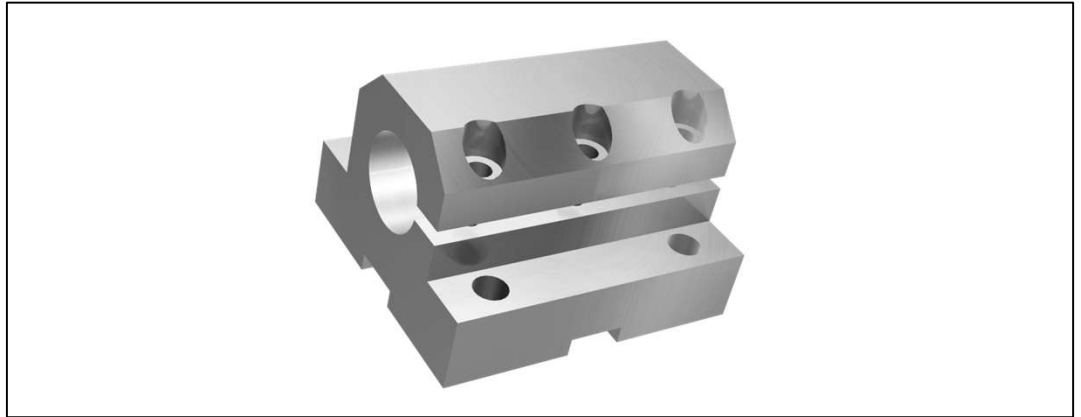


**SPINNER**



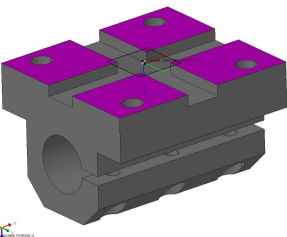
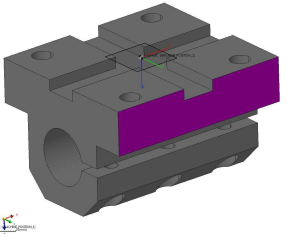
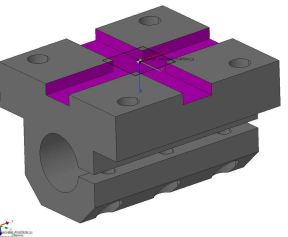
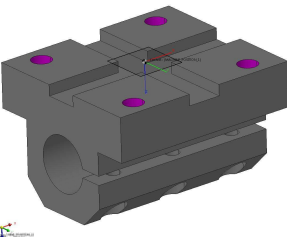
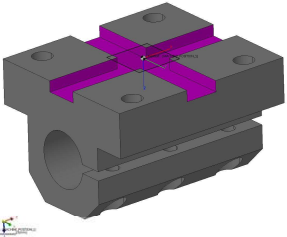
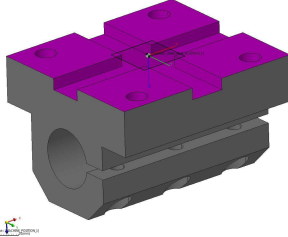
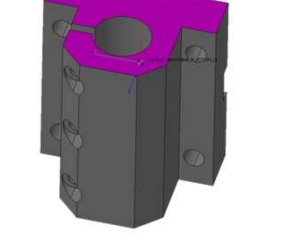
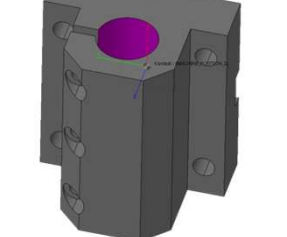
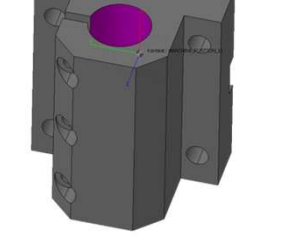
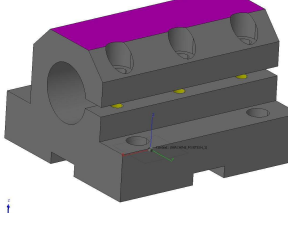
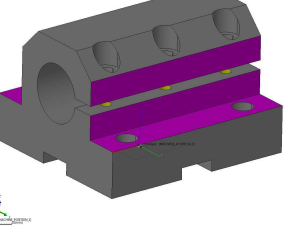
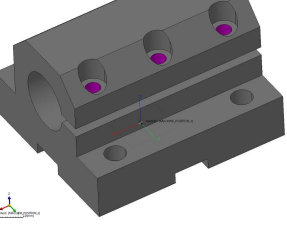
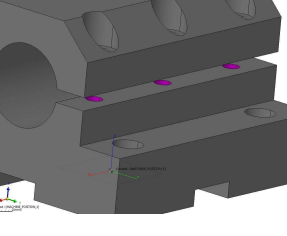
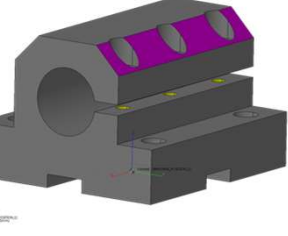
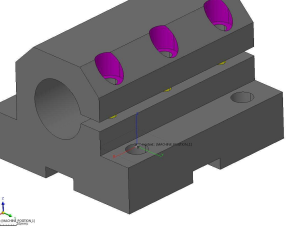
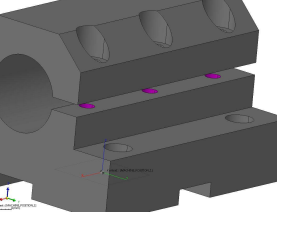
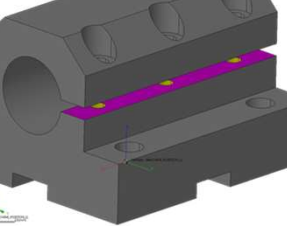
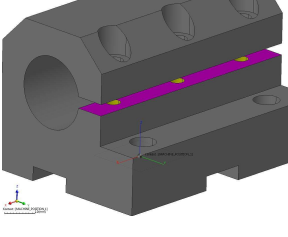
Halle / Hall	1
Maschine / Machine	Spinner VC1150/ 3-Achs-Bearbeitungszentrum / 3-axis machining center / SK 40
Industrie / Industry	Maschinen- und Anlagenbau / Mechanical and plant engineering
Bauteil / Workpiece	Bohrstangenhalter BMT45 / Boring bar holder BMT45
Material / Material	42CrMoS4 / 1.7225
CAM / CNC control	Heidenhain TNC620
Spannmittel / Clamping tool	Allmatic Titan SC 125

Uhrzeit / Time
10:00 - 10:30 Uhr
11:30 - 12:00 Uhr
13:00 - 13:30 Uhr
14:30 - 15:00 Uhr
16:00 - 16:30 Uhr

Nr. / No.	OP Nr. / OP 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	OP10 T1	Planfräsen Grundfläche Face milling base	DM5E050R00	50	9	220	0,2	1400	2520	40	1,5	PNMU0503GNTR	IN2505
2	OP10 T2	Besäumen Grundfläche Shouldering base	47C16022W3RQ032	16	4	300	0,1	5970	2390	2	21	---	IN2005
3	OP10 T3	Nuten schrumpfen Roughing slots	12J1A014012T2R00	14	4	220	0,5	5005	10010	14	0,35	UNKT0502TR-HF	IN2505
4	OP10 T4	Bohren Ø9 drilling	FR0900035T1R01	9	3	100	Fu 0,4	3540	1420	-	-	---	IN2205
5	OP10 T5	Nuten schlichten Finishing slots	S012T08CA078	12	5	220	0,05	5840	1460	0,25	5	47D12009T8RP0201	IN2005
6	OP10 T6	Entgraten deburring	S012T08CA078	12	4	300	0,1	7960	3180	0,2	0,2	47N12005T8RA45	
7	OP20 T1	Planfräsen Stirnseite Face milling front face	DM5E050R00	50	9	220	0,2	1400	2520	40	1,5	PNMU0503GNTR	IN2505
8	OP20 T7	Vorborenen Ø25H7 Pre-drilling	QR0245100JFR00	24,5	1 eff.	180	0,12	2340	280	-	-	SOMT08T306SK	IN2505
9	OP20 T8	Reiben Ø25H7 reaming	XS8200088T4R01	25	8	60	0,1	765	610	0,25	-	XLB25000T71	IN2005
10	OP30 T1	Planfräsen Höhe 55mm Face milling height 55mm	DM5E050R00	50	9	220	0,2	1400	2520	40	1,5	PNMU0503GNTR	IN2505
11	OP30 T9	Absätze fräsen trochoid Trochoid milling heels	47C16036W3RQ320	16	4	300	0,12	5970	2865	1,6	35	---	IN2005
12	OP30 T10	Bohren Ø6,5 drilling	FR0650024T0R01	6,5	3	100	Fu 0,3	4900	1470	-	-	---	IN2205
13	OP30 T11	Bohren Ø5 drilling	FR0500035T7R01	5,0	3	100	Fu 0,25	6370	1590	-	-	---	IN2205
14	OP30 T12	Schräge fräsen Milling bevel	12N1R020044W5R00	20/37	3	220	0,15	1900	855	8	8	BOMT130404R	IN2505
15	OP30 T13	Flachsenkung sink	15C1C011025W2R01	11	1	180	0,07	5210	365	-	-	SCLT050204N-PH	IN2005
16	OP30 T14	Gewinde fräsen M6 Thread milling	MTECS06047C20 1.0 ISO	4,65	3	100	0,02	6850	310	0,5	0,5	---	IN2005
17	OP30 T15	Sägeschlitz 4mm slotting	S020LRS-A-23	39,7	10	180	0,08	1445	1160	10	4	19T39740LRRN04	IN2005
18	OP30 T16	Sägeschlitz entgraten Deburring	S010T06CA064	17,7	3	300	0,1	5400	2130	0,2	0,2	16N17734T6RK14	IN1530

# 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> 	<p>14</p> 	<p>15</p> 	<p>16</p> 
<p>17</p> 	<p>18</p> 		

# 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> 	<p>14</p> 	<p>15</p> 	<p>16</p> 
<p>17</p> 	<p>18</p> 		