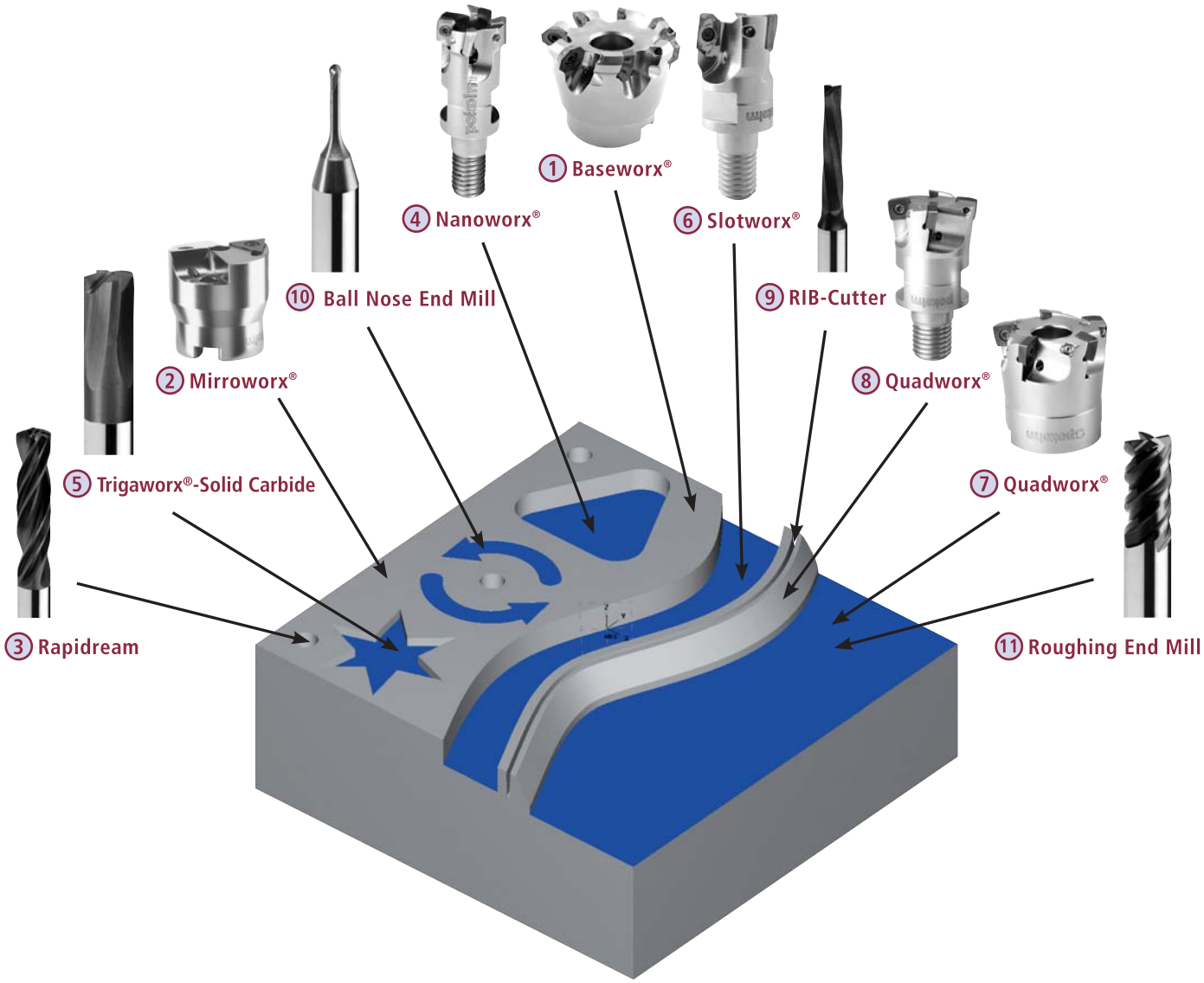
TOOLING SYSTEMS PROCESS OPTIMIZATION CONSULTING IN MILLING STRATEGIES

LIVE DEMONSTRATION

Milling a 2.5 x D model with 10 different tools

Machine details

Material: toolsteel 1.2312



Operation data: see reverse page

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Operation Data

Step 1:	Baseworx®			
strategy	roughing surface	Vc	m/min	250
	one-way	n	1/min	1530
milling cutter type	Baseworx®	fz	mm	0,39
article number	5 52 388	Vf	mm/min	3000
inserts	03 88 840	ap	mm	0,5
diameter d1	52	ae	mm	35
number of teeth	5			

Step 2:	Mirroworx®			
strategy	helix milling	Vc	m/min	461
	surface	n	1/min	3500
milling cutter type	Mirroworx®	fz	mm	1
article number	2 42 384	Vf	mm/min	7000
inserts	04 84 835	ap	mm	0.01
diameter d1	42	ae	mm	25
number of teeth	2			

Step 3:	Rapidream			
strategy	drilling	Vc	m/min	100
milling cutter type	Rapidream	n	1/min	3200
article number	035 100 415	fu	mm	0,31
diameter d1	10	Vf	mm/min	1000
number of teeth	2	drill. depth	mm	12

Step 4:	Nanoworx®			
strategy	roughing: pocket	radius		0,8
	z-constant	Vc	m/min	151
	parallel to contour	n	1/min	3000
milling cutter type	Nanoworx®	fz	mm	0,25
article number	4 16 256	Vf	mm/min	3000
diameter d1	16	ap	mm	0,5
number of teeth	4	ae	mm	12

Step 5:	Trigaworx®-Solid Carbide			
strategy	roughing pocket	radius		0,4
	z-constant	Vc	m/min	~150
	parallel to contour	n	1/min	12000
milling cutter type	Trigaworx®	fz	mm	0,13
article number	0374 55 042	Vf	mm/min	6000
diameter d1	4	ap	mm	3
number of teeth	4	ae	mm	0,15

Step 6:	Slotworx®			
strategy	complete slot	radius		1
	z-constant	Vc	m/min	180
	finishing 1st side	n	1/min	2300
milling cutter type	Slotworx®	fz	mm	0,15
article number	3 25 267	Vf	mm/min	1000
diameter d1	25	ap	mm	2
number of teeth	3	ae	mm	25

Step 7:	Quadworx®			
strategy	roughing pocket	radius		1,5
	z-constant	Vc	m/min	251
	parallel to contour	n	1/min	3200
milling cutter type	Quadworx®	fz	mm	0,83
article number	3 25 248	Vf	mm/min	8000
diameter d1	25	ap	mm	0,5
number of teeth	3	ae	mm	15

Step 8:	Quadworx®			
strategy	plunging down	radius		1,5
	and pulling up	Vc	m/min	353
milling cutter type	Quadworx®	n	1/min	4500
article number	3 25 248	fz	mm	0,74
inserts	03 48 842	Vf	mm/min	10000
diameter d1	25	ap	mm	12
number of teeth	3	ae	mm	1

Step 9:	RIB-Cutter			
strategy	2 x d, ramping down	Vc	m/min	169
milling cutter type	RIB-Cutter	n	1/min	17900
article number	0816 46 0300	fz	mm	0,036
diameter d1	3	Vf	mm/min	1300
number of teeth	2	ap	mm	0,1
radius	0,2	ae	mm	1,5

Step 10:	Ball Nose End MIll			
strategy	finishing contour	Vc	m/min	55
milling cutter type	Ball Nose End Mill	n	1/min	17500
article number	1192 85 0101	fz	mm	0,037
diameter d1	1	Vf	mm/min	1300
number of teeth	2	ap	mm	0,15
radius	0,5	ae	mm	0,05

Surface milling with roughing/slotting end mill 0380 56 120; n = 9600 / fz = 0,26 / ap = 15,5 / Vf = 10000

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