

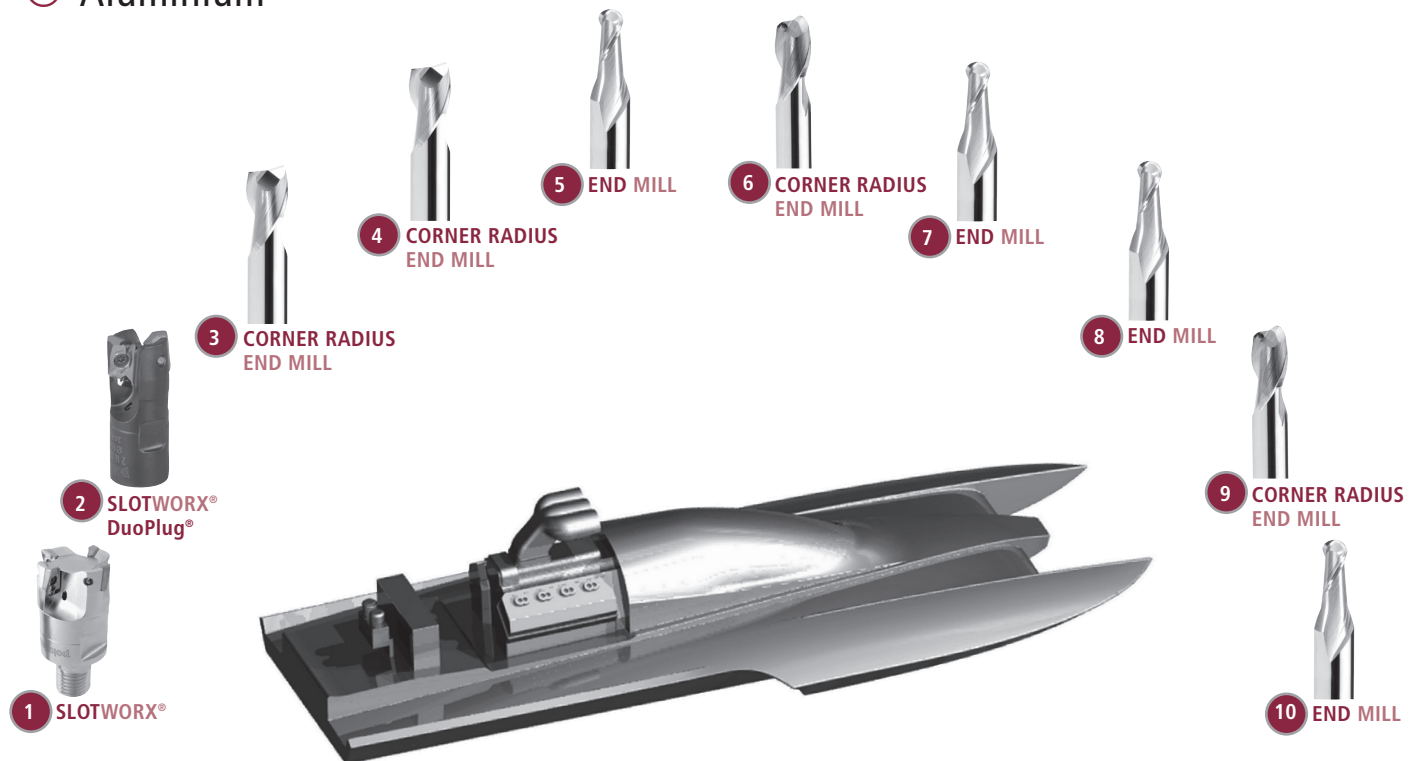
LIVE DEMONSTRATION

Milling a speedboat model

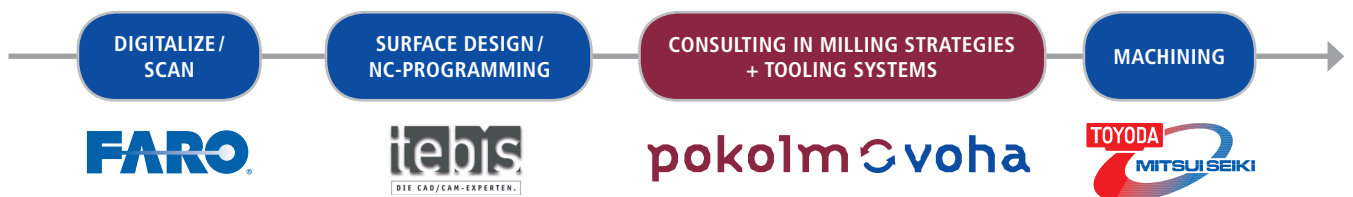


Material

➔ Aluminium



➔ Process chain:



➔ Operation data: see reverse page

LIVE DEMONSTRATION

Technical data

	Step 1	Step 2	Step 3	Step 4	Step 5
Strategy	Roughing z-konstant	Roughing stockmaterial	Roughing stockmaterial	Roughing stockmaterial	Roughing stockmaterial
Milling cutter typ	Slotworx®	Slotworx®	Solid carbide Corner radius end mill	Solid carbide Corner radius end mill	Solid carbide End mill
Article number	4 32 267	2 16 267 SG	0432 47 081	0442 47 060	1412 47 040
Inserts	04 67 820	04 67 820	—	—	—
Diameter d1	32	16	8	6	4
Number of teeth	4	2	2	2	2
Radius	1	1	0,5	1	2
V _c m/min	1.105	1.005	502	433	264
n 1/min	11.000	20.000	20.000	23.000	21.000
f _z mm	0,25	0,2	0,15	0,1	0,07
V _f mm/min	11.000	8.000	6.088	5.000	3.000
a _p mm	2	1	0,4	0,4	0,3
a _e mm	25	8	4	2,5	1,5
Time min	13:04	2:05	13:45	22:42	9:12

	Step 6	Step 7	Step 8	Step 9	Step 10
Strategy	Surface milling	Pre-Finishing	Finishing 5 axis	Finishing 5 axis	Finishing 5 axis
Milling cutter typ	Solid carbide Corner radius end mill	Solid carbide End mill	Solid carbide End mill	Solid carbide Corner radius end mill	Solid carbide End mill
Article number	0442 47 100	1412 47 020	1412 47 060	0442 47 060	1412 47 020
Inserts	—	—	—	—	—
Diameter d1	10	2	6	6	2
Number of teeth	2	2	2	2	2
Radius	2	1	3	1	1
V _c m/min	471	138	414	433	138
n 1/min	15.000	22.000	22.000	23.000	22.000
f _z mm	0,2	0,045	0,14	0,11	0,045
V _f mm/min	6.000	2.000	6.000	5.000	2.000
a _p mm	1	0,3	0,2	0,1	0,15
a _e mm	0,7	0,2	0,2	0,2	—
Time min	11:42	67:00	40:36	47:54	87:00

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