

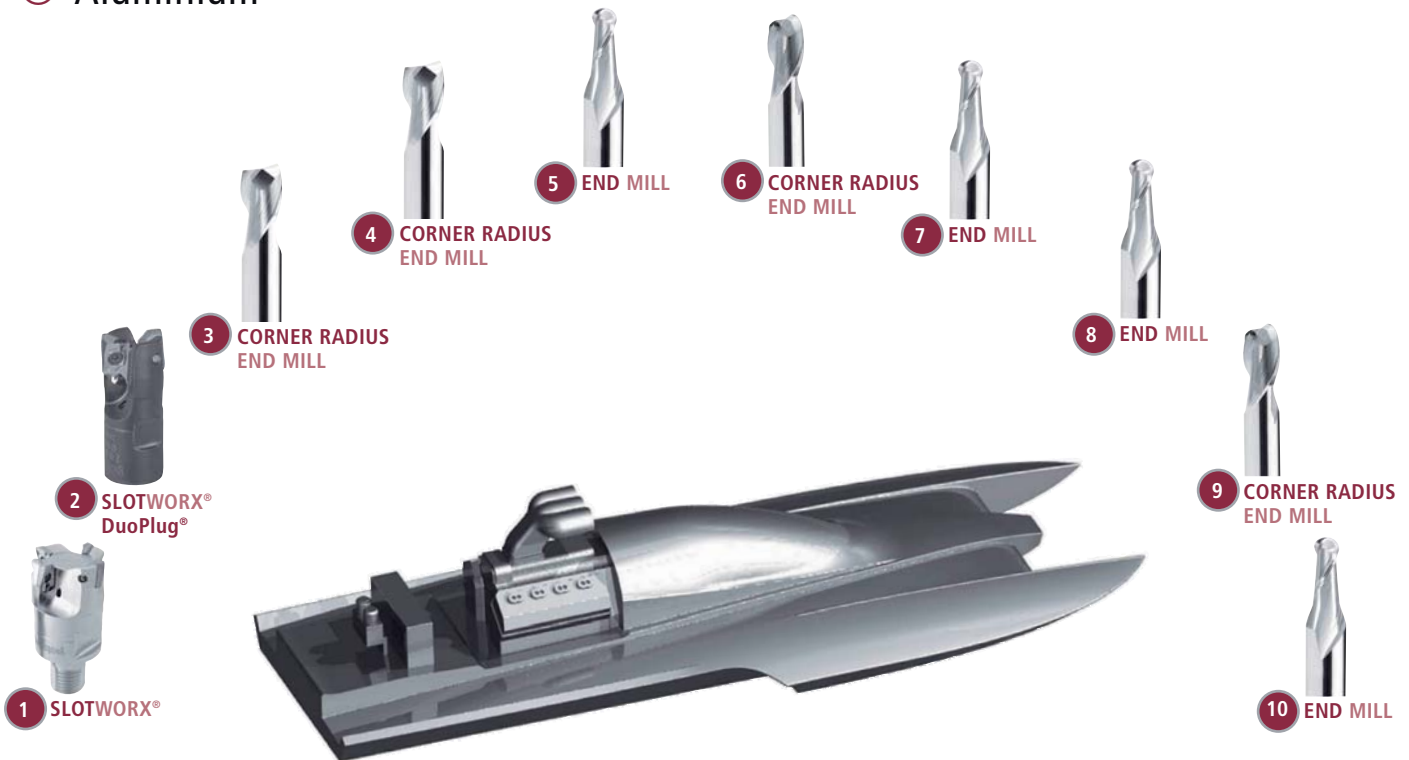
# LIVE DEMONSTRATION

## Milling a speedboat model

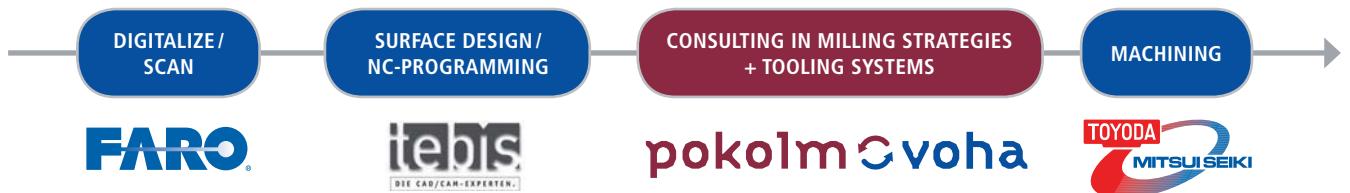


### Material

Aluminium



### Process chain:



Operation data: see reverse page

# LIVE DEMONSTRATION

## Technical data

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

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

**Pokolm**  
Frästechnik GmbH & Co. KG  
Adam-Opel-Straße 5  
33428 Harsewinkel  
Germany

fon: +49 5247 9361-0  
fax: +49 5247 9361-99  
e-mail: info@pokolm.de  
internet: www.pokolm.com

**Voha-Tosec**  
Werkzeuge GmbH  
Schreinerweg 2a + 2b  
51789 Lindlar  
Germany

fon: +49 2266 4781-11  
fax: +49 2266 4781-40  
e-mail: info@voha-tosec.de  
internet: www.voha-tosec.com

Further Information via:  
**WWW.POKOLM-VOHA.COM**

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