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| Work preparation form Milling | | | |
| Part name: Axle | | Date: 11-10-2024 | Sheet number: |
| Belonging to drawing: 12112024-03-02 | | Made by: Diego Marcos Alfonso | |
| Part no: 2 | Amount: 1 | Material: AISI 12L3 Steel | |
| Starting dimensions material: 128mm x Ø 12mm | | | |
| Machining sequence: | | | |
| **Operation** | **Tool**  fixtures, tools and other aids | **Settings**  speed (V), number of revolutions (N), feed (f), depth of cut (t0) etc. | **Remarks** |
| Clamp cylinder with curved shape facing machinery |  |  | Use ground paralles |
| Align center line with machinery | Probe | Center line feature |  |
| Make y-line on one of the faces | Probe | Line feature |  |
| Face milling keyclanck hole and mill 22mm | Insert x Ø4mm  Milling fluid | N=800rpm  tO=0.5mm |  |
| Face milling keyclanck hole | Insert x Ø4mm  Milling fluid | N=800rpm  tO=1mm |  |
| Face milling keyclanck hole | Insert x Ø4mm  Milling fluid | N=800rpm  tO=1.5mm |  |
| Face milling keyclanck hole | Insert x Ø4mm  Milling fluid | N=800rpm  tO=2mm |  |
| Face milling keyclanck hole | Insert x Ø4mm  Milling fluid | N=800rpm  tO=2.5mm |  |
| Face milling keyclanck hole | Insert x Ø4mm  Milling fluid | N=800rpm  tO=3mm |  |