

To eixo

Subject: monociclo


sangramento

Summary of cutting data for Parting of bar

Material details

AISI/SAE, 1045, Hardness: 207 HB, Material group:P1.2.Z.AN

Task details

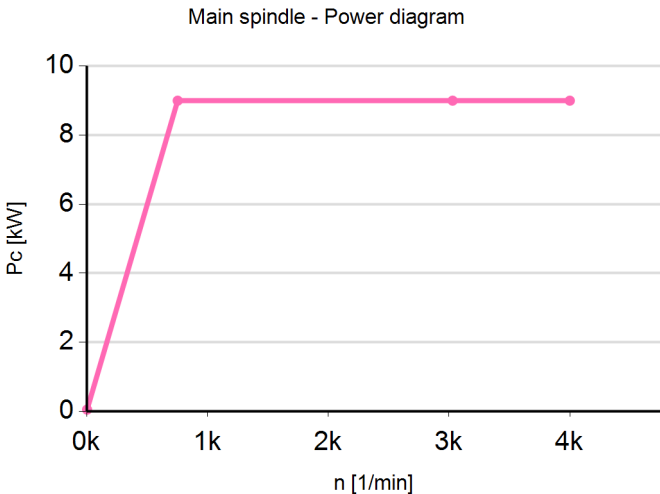
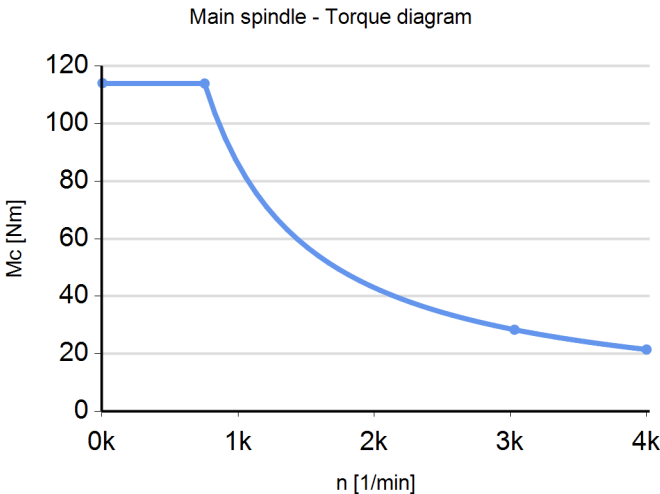


Parting of bar

Start diameter	25.4 mm
Cutting width	3 mm
Minimum cutting width	3 mm
Maximum cutting width	3 mm
Cutting condition	Continuous cut
Workpiece surface condition	Pre-machined
System stability	Excellent stability

Machine

Centur 30D



Recommended solution							
Machining	Type of cooling	Coolant	Grade	T _{mf} [min:s]	Adaption type		
Parting off	External	Emulsion 10%		00:02.814	Walter parting off and grooving blade -size 26		



Tool	G2042.26N-3T38SX
Type	Body
No. of pieces	1

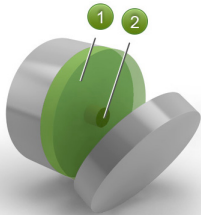
Image similar



Tool	SX-3E300N02-CF6 WSM33S
Type	Insert
No. of pieces	1
Description	WALTER-Cut

Image similar

Cutting data



Legend

- 1 Parting, recommended feed
- 2 Parting, reduced feed

	1	2	
Number of passes in AP direction (NOPap)	1	1	NOPap
Start diameter (D _{ms})	25.4	4.5	mm
End diameter (D _{me})	4.5	0	mm
Depth of cut (a _p)	3	3	mm
Cutting speed (v _c)	153	153	m/min
Feed per revolution (f _n)	0.116	0.029	mm
Tool life time (LifeTime)	27	68	min
Tool life length (LifeLength)	3745.17	1920.29	m
Maximum chip thickness (h _{ex})	0.116	0.116	mm
Corner radius (R)	0.2	0.2	mm

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