

To
peça acopladora

Subject: **monociclo**

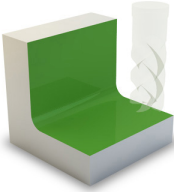
fresamento lateral - desbaste e acabamento

Summary of cutting data for Shoulder

Material details

JIS, A5052, Hardness: 55 HB, Material group:N1.2.Z.UT

Task details

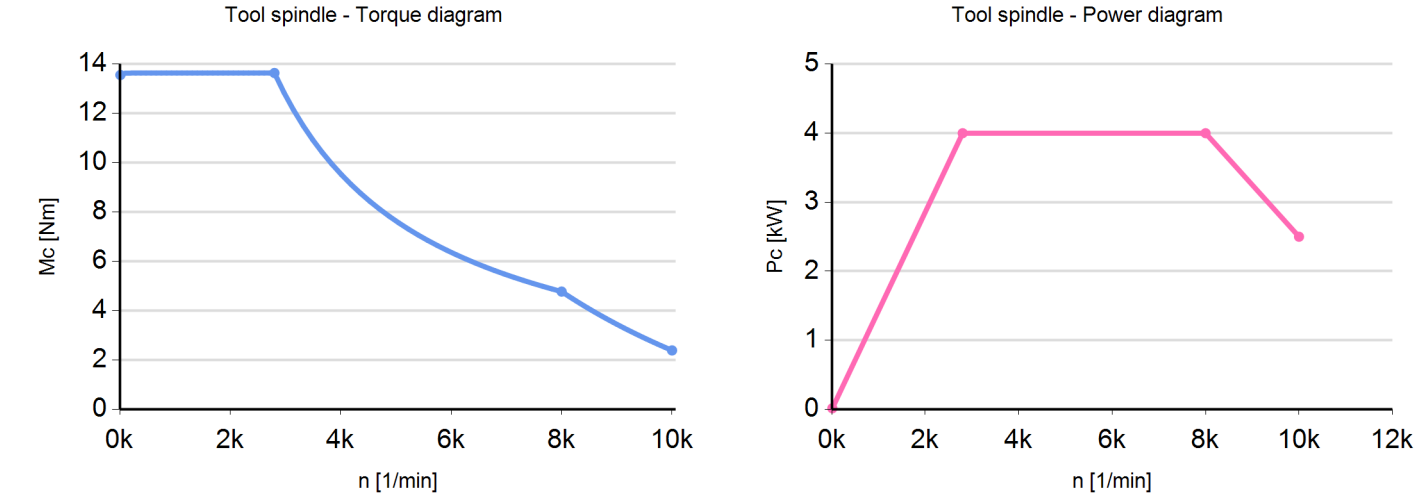


Shoulder

Operation type	Pre-machining and finishing
System stability	Excellent stability
Right angle demand	Right angle required
Axis position	vertical spindle position
Depth	10 mm
Width	40 mm
Length	40 mm
Corner radius	0 mm
Rz wall	3.2 µm
Cutting edge diameter	16 mm

Machine

FANUC RoboDRILL α-21MiB (High Torque)



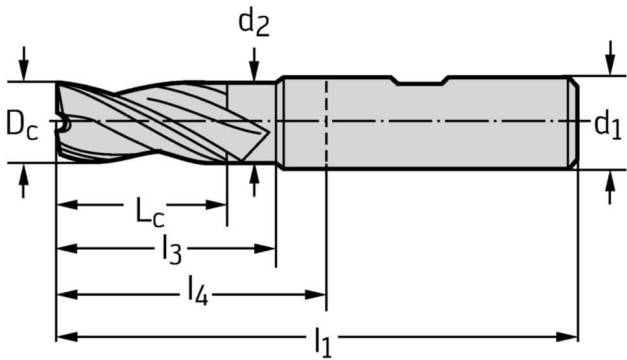
Recommended solution							
Machining	Type of cooling	Coolant	Description	Grade	Tmf [min:s]		
Shoulder Milling	External	Emulsion 10%	Perform	WJ30ED	00:17.940		



Tool	MC232-16.0W3BC-WJ30ED
Type	Body
No. of pieces	1
Description	Perform

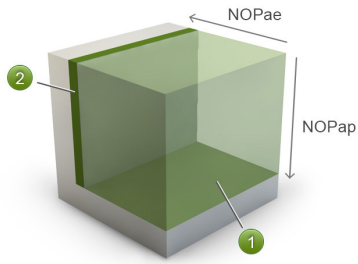
Image similar

MC232-16.0W3BC-WJ30ED



Product name	Perform
Standard	DIN 6527 L
Body material	Carbide
Grade	WJ30ED
Center cutting capability	true
Helix angle	35 °
Cutting edge diameter (Dc)	16 mm
Cutting edge diameter tolerance class	h12
Corner chamfer width (l11)	0.15 mm
Corner chamfer	45 °
Max. depth of cut (Lc)	26 mm
Usable length (l3)	42 mm
Neck diameter (d2)	15.2 mm
Overall length (l1)	92 mm
Maximum overhang (l4)	44 mm
Drive size (d1)	16
Shank diameter tolerance	h6
Peripheral effective cutting edge count (Z)	3
Calculated regrinds	4
Price	163.00 €

Cutting data



Legend

- 1 Premachining
- 2 Finishing

	1	2	
Working engagement (a_r)	5.67	0.32	mm
Depth of cut (a_p)	2	10	mm
Number of passes in AE direction (NOPae)	7	1	NOPae
Number of passes in AP direction (NOPap)	5	1	NOPap
Cutting speed (v_c)	503	503	m/min
Spindle speed (n)	10000	10000	1/min
Feed per tooth (f_z)	0.218	0.151	mm
Feed speed at the contour (v_{fe})	6540	4530	mm/min
Cutting power (P_c)	0.75	0.181	kW
Cutting torque (M_c)	0.716	0.173	Nm
Maximum chip thickness (h_{ex})	0.209	0.0423	mm
Material removal rate (Q)	74.1	14.5	cm ³ /min
Total cutting time ($T_{c\ tot}$)	00:15.420	00:00.744	min:s
Total non-cutting time ($T_{nc\ tot}$)	00:01.812	00:00.000	min:s
Tool life length (LifeLength)	1287.81	5878.78	m
Tool life time (LifeTime)	200	1300	min

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