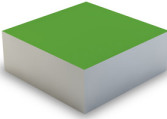


To
peça acopladora

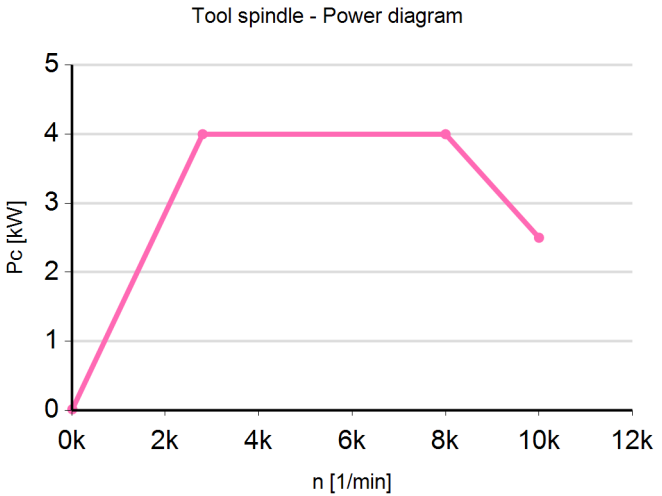
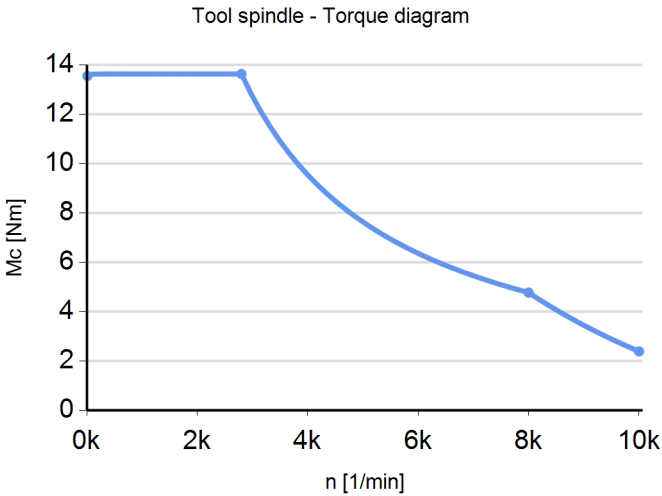
Subject: **monociclo**

faceamento - desbaste e acabamento
FACE DE BAIXO PRA ARRANCAR TUDO

Summary of cutting data for Plain surface

Material details		
JIS, A5052, Hardness: 55 HB, Material group:N1.2.Z.UT		
Task details		
	Plain surface	
	Operation type	Pre-machining and finishing
	System stability	Excellent stability
	Depth	20 mm
	Width	40 mm
	Length	40 mm
	Rz bottom	5 µm
	Cutting edge diameter	64 mm
Machine		

FANUC RoboDRILL α-21MiB (High Torque)



Recommended solution							
Machining	Type of cooling	Coolant	Description	Grade	T _{mf} [min:s]		
Face Milling	External	Emulsion 10%	Xtratec XT	WK10	00:19.140		



Image similar

Tool	M5009-050-B22-04-06-AP
Type	Body
No. of pieces	1
Description	Xtratec XT

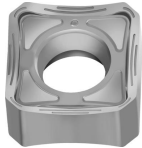
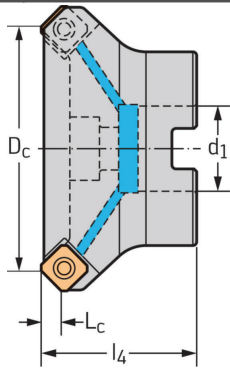


Image similar

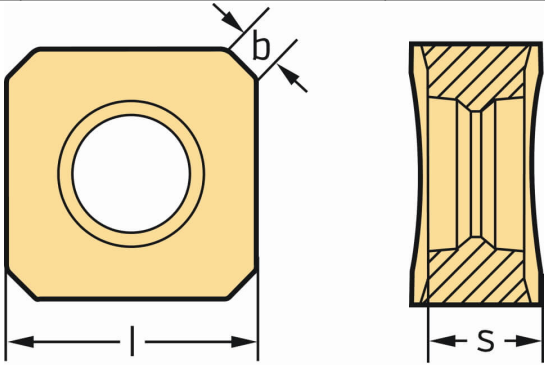
Tool	SNHX1205ANN-K88 WK10
Type	Insert periphery (A) INS_A
No. of pieces	4

M5009-050-B22-04-06-AP



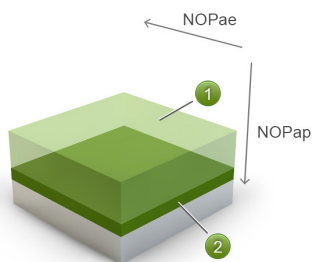
Approach angle (κ)	45 °
Cutting edge diameter (D_c)	50 mm
Max. cutting edge diameter (D_a)	64 mm
Drive size (d_1)	22
Maximum overhang (l_4)	40 mm
Max. depth of cut (L_c)	6 mm
Peripheral effective cutting edge count (Z)	4
Weight	0.608 kg
Cutting item count	4
Maximum ramping angle	0 °
Price	780.00 €

SNHX1205ANN-K88 WK10



Tolerance class insert	H
No. of corners	4
Number of sides	double sided
Cutting edge length (l)	12.7 mm
Insert thickness (s)	5.54 mm
Clearance angle major (α)	0 °
Corner radius (r)	0.8 mm
Wiper edge length (b)	1.5 mm
Price	28.90 €

Cutting data



Legend

- 1 Premachining
- 2 Finishing

	1	2	
Working engagement (a_r)	40	40	mm
Depth of cut (a_p)	0.557	0.5	mm
Number of passes in AE direction (NOPae)	1	1	NOPae
Number of passes in AP direction (NOPap)	35	1	NOPap
Cutting speed (v_c)	1500	1620	m/min
Spindle speed (n)	9220	9980	1/min
Feed per tooth (f_z)	0.232	0.185	mm
Feed speed at the contour (v_{fe})	8560	7390	mm/min
Cutting power (P_c)	2.65	2.16	kW
Cutting torque (M_c)	2.74	2.07	Nm
Maximum chip thickness (h_{ex})	0.164	0.131	mm
Material removal rate (Q)	191	148	cm ³ /min
Total cutting time ($T_{c\ tot}$)	00:15.960	00:00.732	min:s
Total non-cutting time ($T_{nc\ tot}$)	00:02.454	00:00.000	min:s
Tool life length (LifeLength)	3030.02	1840.07	m
Tool life time (LifeTime)	350	250	min

DECLARATION OF EXCLUSION

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