

LIVE-DEMONSTRATION

SMASHING



Material

Aluminium



SLOTWORX® „M”



Solid carbide ball nose end mill



Solid carbide ball nose end mill



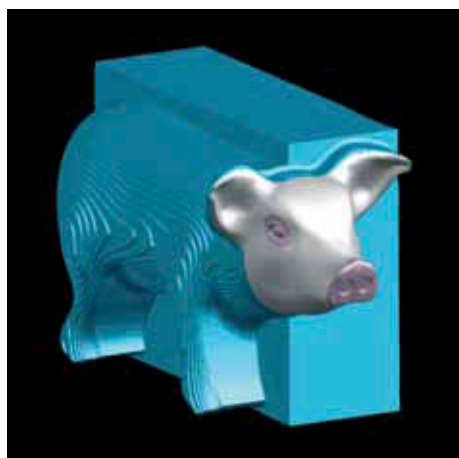
Solid carbide ball nose end mill



Operation data: see on reverse page

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Operation Data



P-F-5F-E-1108

Step 1: Slotworx® „M“

Strategy	Roughing	V _c	m/min	704
Cutter type	Slotworx® „M“	n	rpm	14 000
Catalogue-no.	2 16 267 SG	f _z	mm	0.43
Insert	04 67 820	V _f	mm/min	12 000
Diameter	16	a _p	mm	1.0
No. of teeth	2	a _e	mm	12.8

Step 2: Solid carbide ball nose end mill

Strategy	Remaining material & Pre-Finishing	V _c	m/min	302
Cutter type	Ball Nose End Mill	n	rpm	12 000
Catalogue-no.	1412 47 080	f _z	mm	0.33
Diameter	8	V _f	mm/min	8 000
No. of teeth	2	a _p	mm	0.5
		a _e	mm	0.5

Step 3: Solid carbide ball nose end mill

Strategy	Remaining material & Pre-Finishing	V _c	m/min	264
Cutter type	Ball Nose End Mill	n	rpm	14 000
Catalogue-no.	1412 47 060	f _z	mm	0.21
Diameter	6	V _f	mm/min	6 000
No. of teeth	2	a _p	mm	0.3
		a _e	mm	0.3

Step 4: Solid carbide ball nose end mill

Strategy	Pre-Finishing	V _c	m/min	94
Cutter type	Ball Nose End Mill	n	rpm	15 000
Catalogue-no.	1412 47 020	f _z	mm	0.1
Diameter	2	V _f	mm/min	3 000
No. of teeth	2	a _p	mm	0.05
		a _e	mm	0.05

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