

PYRAMID

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☉ ONE HARSHIP CASE - FOUR STRATEGIES

☉ CONTACT

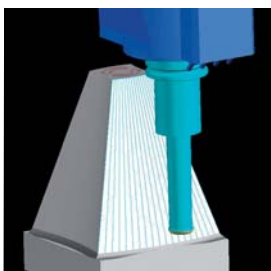
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ONE HARSHIP CASE - FOUR STRATEGIES



Step 1 Strategy: plunging

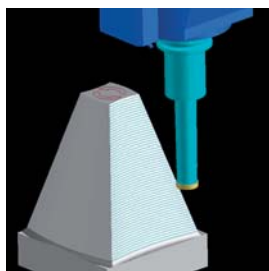


- larger side-steps possible compared with z-constant
- identical surface-accuracy
- better result

Cutter type	Milling cutter body for round inserts
Catalogue-no.	5 25 200 5G
Inserts	02 07 892
Diameter d	25
No. of teeth	5
Radius R	3.5
V _c m/min	900
n rpm	11 500
f _z mm	0.08
V _f mm/min	4500
a _p mm	0.25
a _e mm	0.5
Time min	26



Step 2 Strategy: z-constant

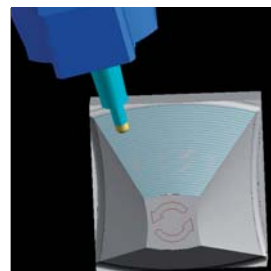


- suitable for steep areas and excellent surface accuracy
- low cutting pressure also in deep contours

Cutter type	Square sholder face a. slotting cutter body
Catalogue-no.	25 281 SG
Inserts	02 79 892
Diameter d	25
No. of teeth	4
Radius R	1
V _c m/min	900
n rpm	11 500
f _z mm	0.08
V _f mm/min	4500
a _p mm	0.25
a _e mm	0.25
Time min	28



Step 3 Strategy: 5-axis-area-conform

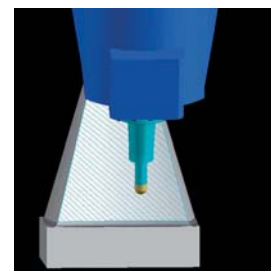


- large side-steps results in reduced machining time

Cutter type	Toric end mill
Catalogue-no.	0275 59 120
Inserts	–
Diameter d	12
No. of teeth	5
Radius R	3.5
V _c m/min	252
n rpm	6 700
f _z mm	0.15
V _f mm/min	2 000
a _p mm	0.25
a _e mm	1.5
Time min	11



Step 4 Strategy: 45° parallel to axis

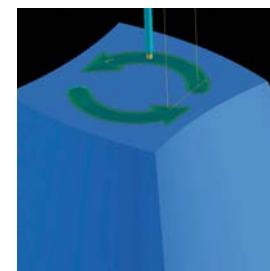


- suitable for steep and shallow areas

Cutter type	Solid carbide ball nose end mill
Catalogue-no.	1312 59 121
Inserts	–
Diameter d	12
No. of teeth	2
Radius R	6
V _c m/min	301
n rpm	8 000
f _z mm	0.1
V _f mm/min	1 600
a _p mm	0.25
a _e mm	0.25
Time min	42



Engraving



Cutter type	Solid carbide corner radius end mill
Catalogue-no.	0722 85 015
Inserts	–
Diameter d	1.5
No. of teeth	2
Radius R	0.2
V _c m/min	75
n rpm	15 000
f _z mm	0.05
V _f mm/min	1 500
a _p mm	0.05
a _e mm	0.1
Time min	2.5



DUOPLUG®

- highest concentricity
- outstanding rigidity



Vibration-free milling in steep areas up to 90° and extremely deep contours through small contact-zone of our inserts.



Material

UDDEHOLM SLEIPNER | 58 HRC

good machinability

- reduced machining time

very good ductility and toughness values

- high edge stability