

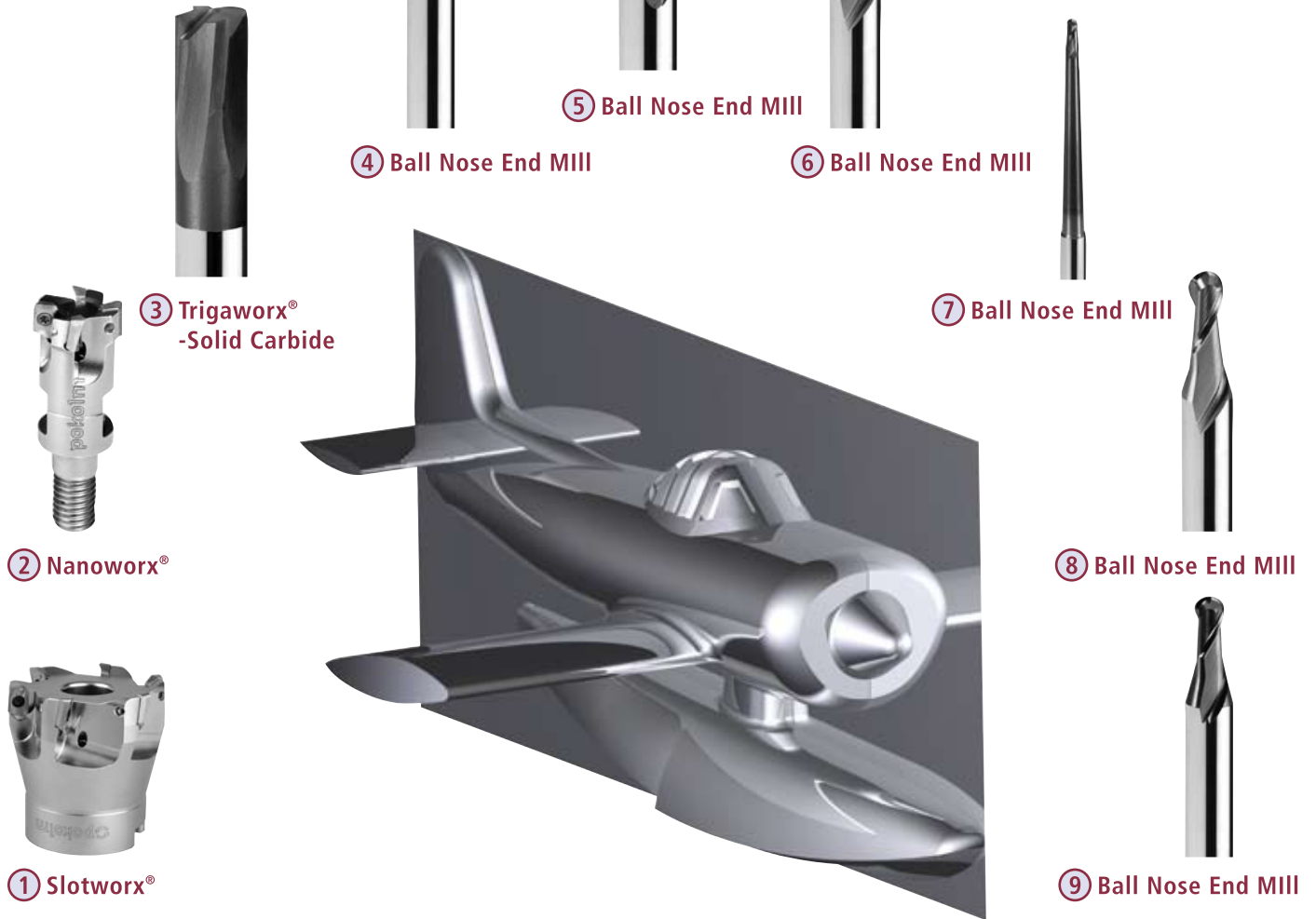
LIVE DEMONSTRATION

Milling a model-aircraft



Machine details

- ⊕ Toyoda Vertex 550 5X
- ⊕ Material: brass



⊕ Operation data: see reverse page

Operation Data

Step 1: Slotworx®			
strategy	roughing surface	diameter d1	42
	z-constant	number of teeth	5
arbor	50 16 750 Z	radius	1
inserts	04 67 848	fz	mm 0,22
material	brass	Vf	mm/min 6000
milling cutter type	Slotworx®	n	1/min 1530
article number	5 42 367		

Step 2: Nanoworx®			
strategy	roughing remaining material	diameter d1	16
		number of teeth	4
arbor	50 08 750	radius	0,8
inserts	02 71 840 R08	fz	mm 0,09
material	brass	Vf	mm/min 6000
milling cutter type	Nanoworx®	n	1/min 16000
article number	4 16 256		

Step 3: Trigaworx®-VHM			
strategy	roughing remaining material	diameter d1	6
		number of teeth	4
		radius	0,5
arbor	50 06 750 S	fz	mm 0,22
material	brass	Vf	mm/min 8000
milling cutter type	Trigaworx®-VHM	n	1/min 9100
article number	0374 55 042		

Step 4: Ball Nose End Mill			
strategy	remaining material in concave mouldings 3+2	diameter d1	4
		number of teeth	2
arbor	50 06 750 S	radius	2
material	brass	fz	mm 0,08
milling cutter type	Ball Nose End Mill	Vf	mm/min 4000
article number	1162 56 040	n	1/min 24000

Step 5: Ball Nose End Mill			
strategy	remaining material in concave mouldings 3+2	diameter d1	3
		number of teeth	2
arbor	50 06 750 S	radius	1,5
material	brass	fz	mm 0,17
milling cutter type	ball nose end mill	Vf	mm/min 4000
article number	1412 47 030	n	1/min 24000

Step 6: Ball Nose End Mill			
strategy	pre-finishing aircraft cockpit 3+2	diameter d1	2
		number of teeth	2
arbor	50 06 750 S	radius	1
material	brass	fz	mm 0,08
milling cutter type	Ball Nose End Mill	Vf	mm/min 4000
article number	1412 47 020	n	1/min 24000

Step 7: Ball Nose End Mill			
strategy	finishing of wings, 5-axis simultaneously and remaining surfaces	diameter d1	4
		number of teeth	2
		radius	2
arbor	50 06 750 S	fz	mm 0,08
material	brass	Vf	mm/min 4000
milling cutter type	Ball Nose End Mill	n	1/min 24000
article number	1162 56 040		

Step 8: Ball Nose End Mill			
strategy	remaining material 3+2	diameter d1	2
arbor	50 06 750 S	number of teeth	2
material	brass	radius	1
milling cutter type	Ball Nose End Mill	fz	mm 0,03
article number	1412 47 020	Vf	mm/min 1500
		n	1/min 24000

Step 9: Ball Nose End Mill			
strategy	engraving title	diameter d1	1
arbor	50 04 750 S	number of teeth	2
material	brass	radius	0,5
milling cutter type	Ball Nose End Mill	fz	mm 0,03
article number	1412 47 010	Vf	mm/min 1500
		n	1/min 24000

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