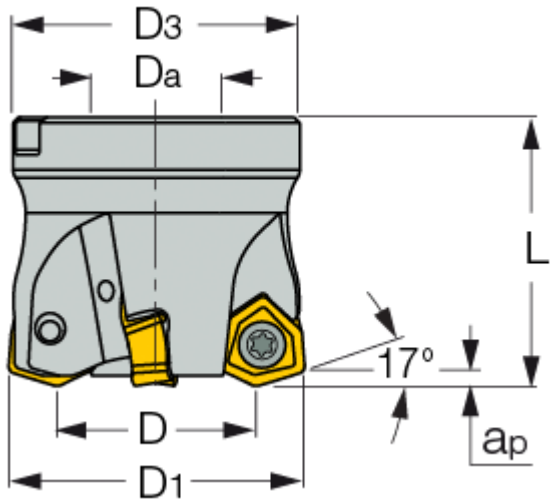
ÖRNEK HESAPLAMA

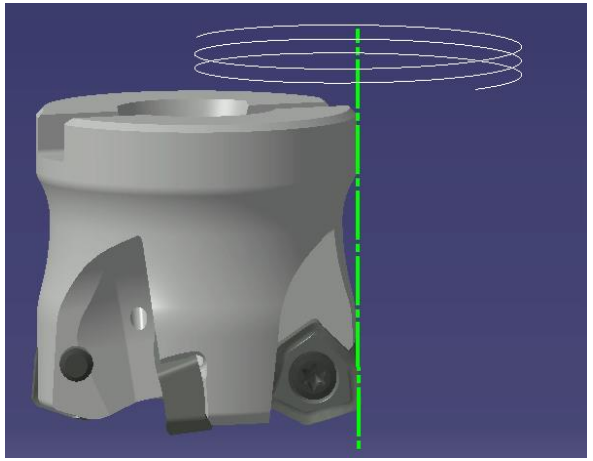
3105112 - FF FWX D050-04-22-08 İÇİN MİNİMUM VE MAKSİMUM HELİSEL İNTERPOLASYON ÇAPLARI NEDİR?



D	D1	ap	Z	L	D3	Da	Arbor	Rd°	Kg
34.00	50.00	2.00	4	45.00	48.00	22.00	A	4.8	0.343

MAX interpolasyon çapı

2xD1 – 1 mm

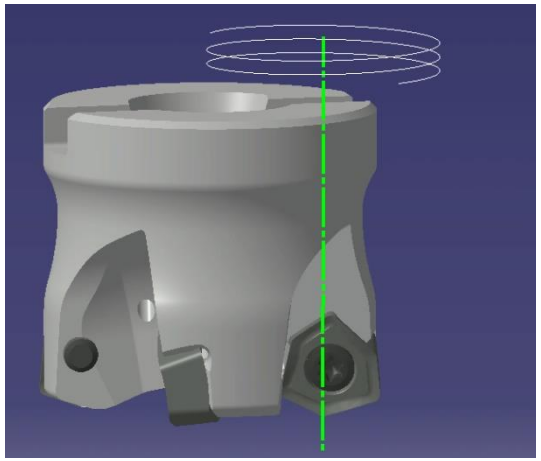


2xD1 – 1 mm

2x50 – 1 = 99 mm

MIN interpolasyon çapı

D+D1 mm



D+D1 mm

34+50 = 84 mm

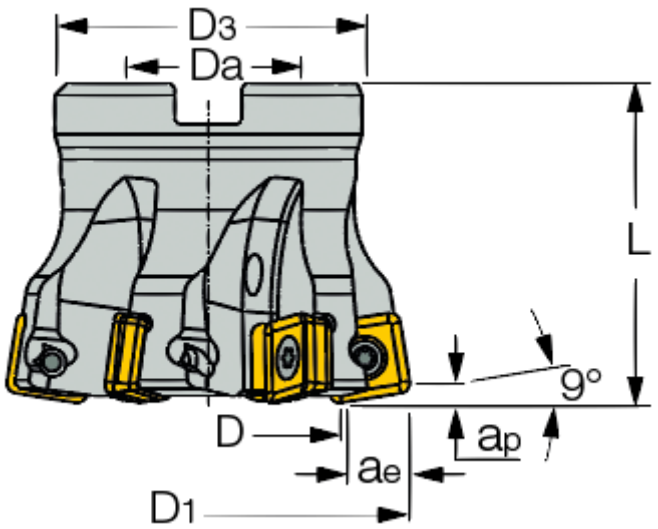
H600 WXCU … UÇ BOYUTLARINA GÖRE KESME ŞARTLARI

Inserts	Cutting Recommendations for FF Tools		Radius for Programming on FF Tools	Cutting Recommendations for MF Tools		Radius for Programming on MF Tools
	ap (mm)	fz (mm/t)		ap (mm)	fz (mm/t)	
H600 WXCU 040310HP	0.5-0.8	0.34-0.68	1.9	0.5-1.5	0.2-0.4	2.6
H600 WXCU 040310T	0.5-0.8	0.68-1.03	1.9	0.5-1.5	0.4-0.6	2.6
H600 WXCU 05T312HP	0.7-1.0	0.34-0.68	2.3	0.8-2.0	0.2-0.4	3.3
H600 WXCU 05T312T	0.7-1.0	0.68-1.03	2.3	0.8-2.0	0.4-0.6	3.3
H600 WXCU 070515HP	1.0-1.5	0.34-0.86	3.1	1-2.7	0.2-0.5	4.1
H600 WXCU 070515T	1.0-1.5	0.68-1.37	3.1	1-2.7	0.4-0.8	4.1
H600 WXCU 080612HP	1.5-2.0	0.34-0.86	3.3	1.8-3.5	0.2-0.5	4.8
H600 WXCU 080612T	1.5-2.0	0.68-1.37	3.3	1.8-3.5	0.4-0.8	4.8
H600 WXCU 080616RM	1.5-2.0	0.68-1.37	3.7	1.8-3.5	0.4-0.8	5.2

Inserts	Cutting Recommendations for FF Tools in plunging		Radius for Programming on FF Tools	Cutting Recommendations for MF Tools in plunging		Radius for Programming on MF Tools
	ae (mm)	fz (mm/t)		ae (mm)	fz (mm/t)	
H600 WXCU 040310HP	3.7	0.04-0.08	1.9	3.5	0.04-0.08	2.6
H600 WXCU 040310T	3.7	0.04-0.10	1.9	3.5	0.04-0.10	2.6
H600 WXCU 05T312HP	5	0.04-0.08	2.3	4.75	0.04-0.08	3.3
H600 WXCU 05T312T	5	0.04-0.10	2.3	4.75	0.04-0.10	3.3
H600 WXCU 070515HP	6.5	0.04-0.10	3.1	6.15	0.04-0.10	4.1
H600 WXCU 070515T	6.5	0.04-0.12	3.1	6.15	0.04-0.12	4.1
H600 WXCU 080612HP	8	0.04-0.10	3.3	7.65	0.04-0.10	4.8
H600 WXCU 080612T	8	0.04-0.12	3.3	7.65	0.04-0.12	4.8
H600 WXCU 080616RM	8	0.04-0.12	3.7	7.65	0.04-0.12	5.2

FEEDMILL

FFQ4 D-12



MAX interpolasyon çapı
2xD1 – 1 mm

MIN interpolasyon çapı
D+D1 mm

Designation	D	D1	ap	ae	Z	L	D3	Da	Arbor	Rd°	Kg	MIN Ø	MAX Ø
FFQ4 D040-4-16-12	18	40	1.5	10	4	45	38	16	A	4.3	0.25	58	79
FFQ4 D050-5-22-12	28	50	1.5	10	5	50	48	22	A	2.7	0.418	78	99
FFQ4 D063-6-22-12	41	63	1.5	10	6	50	48	22	A	1.8	0.492	104	125
FFQ4 D080-7-27-12	58	80	1.5	10	7	50	76	27	A	1.2	1.055	138	159
FFQ4 D100-8-32-12	78	100	1.5	10	8	50	78	32	B	0.9	1.335	178	199

FEEDMILL

Average Cutting Data for FFQ4-12 Fast Feed Face Mills

Workpiece Material						Insert type	Carbide grade	D.O.C. ap [mm]		Cutting speed Vc, [m/min]	Feed fz [mm/tooth]		Coolant
ISO class DIN/ISO 513	Description	ISCAR mat. group*	Hardness, HB	Typical representstive AISI/SAE/ ASTM	Typical representstive DIN W.-Nr.			Recom-mended	Range		Recom-mended	Range	
P	Non-alloy steel	1-5	130-180	1020	1.0402	T	IC808	1.5	0.5-1.5	150-220	1.5	0.5-2.0	Dry
							IC830			140-200	1.6	0.5-2.0	Dry/Wet
	Low alloy steel	6-8	260-300	4340	1.6582		IC808			140-200	1.5	0.5-2.0	Dry
							IC830			120-180	1.6	0.5-2.0	Dry/Wet
		9	HRC 35-42**	3135	1.5710		IC808			130-180	1.5	0.5-1.8	Dry
							IC830			120-160	1.5	0.5-1.8	Dry/Wet
	High alloy steel	10-11	200-220	H13	1.2344		IC808			120-170	1.3	0.5-1.8	Dry
							IC830			100-150	1.4	0.5-1.8	Dry/Wet
	Ferritic/martensitic stainless steel	12-13	200	420	1.4021		IC808			110-160	1.3	0.5-1.8	Dry
							IC830			100-150	1.4	0.5-1.8	Dry/Wet
M	Austenitic stainless steel	14	200	304L	1.4306	HP	IC830	1.5	0.5-1.5	80-140	1.0	0.5-1.5	Wet
							IC808			100-160	1.0	0.5-1.5	
							IC5820			100-160	1.0	0.5-1.6	
							IC882			80-130	1.0	0.5-1.8	
K	Grey cast iron	15-16	250	Class 40	0.6025 (GG25)	T	IC810	1.5	0.5-1.5	150-220	1.5	0.5-2.0	Dry
	Nodular cast iron	17-18	200	Class 65-45-12	0.7050 (GGG50)		IC810			120-200	1.5	0.5-2.0	
S	High temperature alloys	33-35	340	Inconel 718	2.4668	HP	IC830	1.5	0.5-1.5	23-35	0.7	0.5-1.0	Wet
							IC808			25-40	0.7	0.4-1.0	
							IC5820			23-35	0.7	0.5-1.0	
							IC882			20-30	0.7	0.5-1.0	
		36-37	HRC 35-40	AMS R56400	3.7165 (Ti6Al4V)		IC830			20-45	0.7	0.5-1.0	
							IC808			20-30	0.7	0.4-1.0	
							IC5820			20-30	0.7	0.5-1.0	
							IC882			20-30	0.9	0.5-1.0	
H	Hardened steel	38	HRC 45-49	HARDOX 450 plate		T	IC808	1	0.5-1.5	50-75	0.5	0.4-0.5	Dry

* ISCAR material group in accordance with VDI 3323 standard

** Quenched and tempered

For machining in unstable conditions, the recommended cutting data should be reduced by 20-30%.

Programlama Radyusu: 3.1 mm