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| Thursday, March 03, 2016 | GEGENPLATTE\_ |  |

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| Einheiten | mm |  |
| Teil-Art | Fräsen |
| CNC-Steuerung | Heidenhain\_iTNC530\_5X\_Muster |
| Programm-Nr. | 1 |
| Unterprogramm-Nr. | 1 |
|  |  |
| Werkzeug-Adapter | SK40 |
| Werkstück-Material | 3.0505 (EN-AW 3105) |
| Bearbeitungen | 21/22 |
|  | |

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| --- | --- |
| Modell- Name | C:\Users\e\_krauts\Desktop\WS-Anschlag SW15 + Übungen\Gegenplatte\_.SLDPRT |
| Arbeitsordner | C:\Users\e\_krauts\Desktop\WS-Anschlag SW15 + Übungen |
| Teil-Name | GEGENPLATTE\_ |

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| Thursday, March 03, 2016 | Bild GEGENPLATTE\_ |  |

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| XXXXXXX | XXXXXXXXX |

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| Thursday, March 03, 2016 | Wkzg.-Katalog GEGENPLATTE\_ |  |

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| |  |  |  |  |  | | --- | --- | --- | --- | --- | | 1-Spindle-1A   HSK A 63 ER 40x120   FACE MILL |  |  | | | | D: 63 mm R: 0 mm TD: 63 mm A: 0 AD: 90 | TL: 60 mm OHL: 40 mm CL: 20 mm SL: 30 mm H: 100 mm | H 1        D 51 Zähnezahl: 6 | |
| |  |  |  |  |  | | --- | --- | --- | --- | --- | | 2-Spindle-1A      Schaftfräser |  |  | | | | D: 16 mm AD: 16 | TL: 80 mm OHL: 60 mm CL: 35 mm SL: 35 mm H: 100 mm | H 2        D 52 Zähnezahl: 4 | |
| |  |  |  |  |  | | --- | --- | --- | --- | --- | | 3-Spindle-1A      Schaftfräser |  |  | | | | D: 8 mm AD: 8 | TL: 80 mm OHL: 60 mm CL: 35 mm SL: 35 mm H: 100 mm | H 3        D 53 Zähnezahl: 4 | |
| |  |  |  |  |  | | --- | --- | --- | --- | --- | | 4-Spindle-1A      Anbohrer |  |  | | | | D: 6 mm A: 90 AD: 6 | TL: 60 mm OHL: 40 mm CL: 3 mm SL: 30 mm H: 100 mm | H 4        D 54 Zähnezahl: 2 | |
| |  |  |  |  |  | | --- | --- | --- | --- | --- | | 5-Spindle-1A      DRILL |  |  | | | | D: 5 mm A: 118 AD: 5 | TL: 80 mm OHL: 60 mm CL: 24 mm SL: 30 mm H: 100 mm | H 5        D 55 Zähnezahl: 1 | |
| |  |  |  |  |  | | --- | --- | --- | --- | --- | | 6-Spindle-1A      Gewindebohrer |  |  | | | | D: 6 mm TD: 4 mm AD: 6 | TL: 60 mm OHL: 40 mm CL: 17 mm Ch.L: 2 mm H: 100 mm | H 6        D 56 Zähnezahl: 1 Steigung: 1 mm | |
| |  |  |  |  |  | | --- | --- | --- | --- | --- | | 7-Spindle-1A      DRILL |  |  | | | | D: 6.6 mm A: 118 AD: 6.6 | TL: 80 mm OHL: 60 mm CL: 24 mm SL: 30 mm H: 100 mm | H 1        D 1 Zähnezahl: 1 | |
| |  |  |  |  |  | | --- | --- | --- | --- | --- | | 8-Spindle-1A      Schaftfräser |  |  | | | | D: 6 mm AD: 6 | TL: 80 mm OHL: 60 mm CL: 24 mm SL: 30 mm H: 100 mm | H 8        D 58 Zähnezahl: 2 | |

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| Thursday, March 03, 2016 | Operation Summary  GEGENPLATTE\_ |  |

| # | Job - Name (Bearbeitungstyp) <Transform> | | | | |
| --- | --- | --- | --- | --- | --- |
| Nullpunkt | Schlichtdrehzahl | Vorschub XY/Vorschübe Schruppen | Z-Vorschub/Vorschub - Schlichten | Zeit |
| Wkzg.-Nr. | Wkzg.-Kühlung | | | |
| Beschreibung | | | | |
| |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | | X Min | X Max | Y Min | Y Max | Z Min | Z Max | | | | | |
| 1 | Planfräsen (Fläche) | | | | |
| MAC 1 (1- Position) | 1500 | 1000 | 300 | 0:01:08 |
| 1-Spindle-1A |  | | |  |
|  | | | | |
| |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | | -155.95 | 155.95 | -43.625 | 43.625 | 0 | 1.5 | | | | | |
| 2 | Außenkontur schruppen (iMachining)  <> | | | | |
| MAC 1 (1- Position) | 6813 | 3941 | 30000 | 0:00:13 |
| 2-Spindle-1A |  | | |  |
|  | | | | |
| |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | | -128.328 | 128.328 | -53.383 | 53.383 | -30.5 | 2 | | | | | |
| 3 | Außenkontur schlichten (iMachining)  <> | | | | |
| MAC 1 (1- Position) | 6853 | 3786 | 30000 | 0:00:15 |
| 2-Spindle-1A |  | | |  |
|  | | | | |
| |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | | -123 | 123 | -48 | 48 | -30.5 | 2 | | | | | |
| 4 | unterer Absatz schruppen (iMachining)  <> | | | | |
| MAC 1 (1- Position) | 7569 | 3775 | 30000 | 0:01:26 |
| 2-Spindle-1A |  | | |  |
|  | | | | |
| |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | | -122.101 | 122.177 | -50.719 | 50.719 | -25 | 2 | | | | | |
| 5 | unterer Absatz schlichten (iMachining)  <> | | | | |
| MAC 1 (1- Position) | 7447 | 2350 | 30000 | 0:00:35 |
| 3-Spindle-1A |  | | |  |
|  | | | | |
| |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | | -114.413 | 114 | -39 | 39 | -25 | 2 | | | | | |
| 6 | oberer Absatz schruppen (iMachining)  <> | | | | |
| MAC 1 (1- Position) | 7796 | 3786 | 30000 | 0:01:11 |
| 2-Spindle-1A |  | | |  |
|  | | | | |
| |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | | -116.054 | 119.788 | -40.463 | 44.842 | -5 | 2 | | | | | |
| 7 | oberer Absatz schlichten (iMachining)  <> | | | | |
| MAC 1 (1- Position) | 7796 | 3786 | 30000 | 0:00:03 |
| 2-Spindle-1A |  | | |  |
|  | | | | |
| |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | | -29.513 | 29.513 | -21.721 | 21.721 | -5 | 2 | | | | | |
| 8 | Kreistaschen schruppen (iMachining)  <> | | | | |
| MAC 1 (1- Position) | 7796 | 3786 | 30000 | 0:00:23 |
| 2-Spindle-1A |  | | |  |
|  | | | | |
| |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | | -81.76 | 81.76 | -6.76 | 6.76 | -25 | -3 | | | | | |
| 9 | Kreistaschen schlichten (iMachining)  <> | | | | |
| MAC 1 (1- Position) | 7796 | 3786 | 30000 | 0:00:03 |
| 2-Spindle-1A |  | | |  |
|  | | | | |
| |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | | -82 | 82 | -7 | 7 | -25 | -3 | | | | | |
| 10 | Zentrieren (Bohren)  <> | | | | |
| MAC 1 (1- Position) | 10000 | 1000 | 300 | 0:00:02 |
| 4-Spindle-1A |  | | |  |
|  | | | | |
| |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | | 0 | 0 | 20 | 20 | -3 | 2 | | | | | |
| 11 | Bohren Kernloch M6 (Bohren)  <> | | | | |
| MAC 1 (1- Position) | 3500 | 300 | 300 | 0:00:07 |
| 5-Spindle-1A |  | | |  |
|  | | | | |
| |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | | 0 | 0 | 20 | 20 | -26.502 | 2 | | | | | |
| 12 | Gewindebohren M6 (Bohren)  <> | | | | |
| MAC 1 (1- Position) | 3500 | 3500 | 3500 | 0:00:01 |
| 6-Spindle-1A |  | | |  |
|  | | | | |
| |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | | 0 | 0 | 20 | 20 | -20 | 2 | | | | | |
| 13 | Anfasen oberer Absatz (Profil)  <> | | | | |
| MAC 1 (1- Position) | 10000 | 1000 | 300 | 0:00:34 |
| 4-Spindle-1A |  | | |  |
|  | | | | |
| |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | | -110.5 | 110.5 | -35.5 | 35.5 | -5.6 | -3 | | | | | |
| 14 | Anfasen obere Insel (Profil)  <> | | | | |
| MAC 1 (1- Position) | 10000 | 1000 | 300 | 0:00:15 |
| 4-Spindle-1A |  | | |  |
|  | | | | |
| |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | | -20.5 | 26.5 | -30.5 | 31 | -0.6 | 2 | | | | | |
| 15 | Anfasen Außenkontur (Profil)  <> | | | | |
| MAC 1 (1- Position) | 10000 | 1000 | 300 | 0:00:42 |
| 4-Spindle-1A |  | | |  |
|  | | | | |
| |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | | -115.5 | 115.5 | -40.5 | 48.839 | -25.6 | -23 | | | | | |
| 16 | Planfräsen 2.Aufspannung (iMachining)  <> | | | | |
| MAC 2 (1- Position) | 6813 | 3538 | 30000 | 0:01:30 |
| 2-Spindle-1A |  | | |  |
|  | | | | |
| |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | | -117.669 | 117.475 | -49.67 | 47.413 | 0 | 6 | | | | | |
| 17 | Zentrieren Senkung (Bohren)  <> | | | | |
| MAC 2 (1- Position) | 10000 | 300 | 300 | 0:00:01 |
| 4-Spindle-1A |  | | |  |
|  | | | | |
| |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | | 0 | 0 | 20 | 20 | -2 | 2 | | | | | |
| 18 | Bohren Senkung (Bohren)  <> | | | | |
| MAC 2 (1- Position) | 3500 | 300 | 300 | 0:00:14 |
| 7-Spindle-1A |  | | |  |
|  | | | | |
| |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | | 0 | 0 | 20 | 20 | -32.483 | 2 | | | | | |
| 19 | Stirnsenkung schruppen (iMachining)  <> | | | | |
| MAC 2 (1- Position) | 9938 | 844 | 30000 | 0:00:04 |
| 8-Spindle-1A |  | | |  |
|  | | | | |
| |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | | -2.26 | 2.26 | 17.74 | 22.26 | -6.4 | 2 | | | | | |
| 20 | Stirnsenkung schlichten (iMachining)  <> | | | | |
| MAC 2 (1- Position) | 9938 | 844 | 30000 | 0:00:02 |
| 8-Spindle-1A |  | | |  |
|  | | | | |
| |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | | -2.5 | 2.5 | 17.5 | 22.5 | -6.4 | 2 | | | | | |
| 21 | Anfasen 2.Aufspannung (Profil)  <> | | | | |
| MAC 2 (1- Position) | 10000 | 1000 | 300 | 0:00:45 |
| 4-Spindle-1A |  | | |  |
|  | | | | |
| |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | | -115.5 | 115.5 | -40.5 | 44.637 | -0.6 | 2 | | | | | |
| Gesamtzeit: | | | | | 0:09:33 |