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| Friday, March 04, 2016 | SEITENTEIL |  |

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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 | 19/20 |
|  | |

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

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| Friday, March 04, 2016 | Bild SEITENTEIL |  |

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| XXXXXXX | XXXXXXXXX |

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| Friday, March 04, 2016 | Wkzg.-Katalog SEITENTEIL |  |

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| |  |  |  |  |  | | --- | --- | --- | --- | --- | | 1-Spindle-1A      Schaftfräser |  |  | | | | D: 16 mm AD: 16 | TL: 80 mm OHL: 60 mm CL: 35 mm SL: 35 mm H: 100 mm | H 1        D 51 Zähnezahl: 3 | |
| |  |  |  |  |  | | --- | --- | --- | --- | --- | | 2-Spindle-1A      Schaftfräser |  |  | | | | D: 8 mm AD: 8 | TL: 80 mm OHL: 60 mm CL: 30 mm SL: 30 mm H: 100 mm | H 2        D 52 Zähnezahl: 3 | |
| |  |  |  |  |  | | --- | --- | --- | --- | --- | | 3-Spindle-1A      SPOT DRILL |  | SpotDrill10mm | | | | D: 6 mm A: 90 AD: 6 | TL: 140 mm OHL: 100 mm CL: 3 mm SL: 80 mm H: 100 mm | H 3        D 53 Zähnezahl: 2 | |
| |  |  |  |  |  | | --- | --- | --- | --- | --- | | 4-Spindle-1A      DRILL |  | Drill | | | | D: 4.2 mm A: 118 AD: 4.2 | TL: 58.8 mm OHL: 42 mm CL: 25.2 mm SL: 33.6 mm H: 100 mm | H 4        D 54 Zähnezahl: 1 | |
| |  |  |  |  |  | | --- | --- | --- | --- | --- | | 5-Spindle-1A      TAP |  | HW\_FastenerSize | | | | D: 5 mm TD: 3.78 mm AD: 4.9 | TL: 62.5 mm OHL: 50 mm CL: 25 mm Ch.L: 5 mm H: 100 mm | H 5        D 55 Zähnezahl: 1 Steigung: 0.8 mm | |
| |  |  |  |  |  | | --- | --- | --- | --- | --- | | 6-Spindle-1A      Bohrer |  |  | | | | D: 5.5 mm A: 118 AD: 5.5 | TL: 80 mm OHL: 60 mm CL: 24 mm SL: 30 mm H: 100 mm | H 6        D 56 Zähnezahl: 1 | |

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| Friday, March 04, 2016 | Operation Summary  SEITENTEIL |  |

| # | 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 (iMachining)  <> | | | | |
| MAC 1 (1- Position) | 9171 | 6185 | 30000 | 0:00:31 |
| 1-Spindle-1A |  | | |  |
|  | | | | |
| |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | | -84.434 | 84.432 | -27.877 | 27.882 | 0 | 3 | | | | | |
| 2 | Außenkontur schruppen (iMachining)  <> | | | | |
| MAC 1 (1- Position) | 6813 | 2653 | 30000 | 0:00:06 |
| 1-Spindle-1A |  | | |  |
|  | | | | |
| |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | | -85.24 | 85.24 | -25.24 | 26.671 | -20.5 | 2 | | | | | |
| 3 | unterer Absatz schruppen (iMachining)  <> | | | | |
| MAC 1 (1- Position) | 6813 | 2653 | 30000 | 0:00:20 |
| 1-Spindle-1A |  | | |  |
|  | | | | |
| |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | | -85.122 | 85.12 | -27.626 | 27.864 | -16.5 | 2 | | | | | |
| 4 | oberer Absatz schruppen (iMachining)  <> | | | | |
| MAC 1 (1- Position) | 6813 | 2653 | 30000 | 0:00:18 |
| 1-Spindle-1A |  | | |  |
|  | | | | |
| |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | | -76.87 | 76.829 | -16.876 | 16.875 | -4.5 | 2 | | | | | |
| 5 | oberer Absatz schlichten (iMachining)  <> | | | | |
| MAC 1 (1- Position) | 10322 | 1621 | 30000 | 0:00:02 |
| 2-Spindle-1A |  | | |  |
|  | | | | |
| |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | | -30.305 | 30.305 | -9.982 | 9.982 | -4.5 | 2 | | | | | |
| 6 | Außenkontur schlichten (iMachining)  <> | | | | |
| MAC 1 (1- Position) | 7913 | 1649 | 30000 | 0:00:14 |
| 2-Spindle-1A |  | | |  |
|  | | | | |
| |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | | -81 | 81 | -21 | 21.49 | -20.5 | 2 | | | | | |
| 7 | unterer Absatz schlichten (iMachining)  <> | | | | |
| MAC 1 (1- Position) | 8746 | 1628 | 30000 | 0:00:30 |
| 2-Spindle-1A |  | | |  |
|  | | | | |
| |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | | -79 | 79.585 | -19 | 19 | -16.5 | 2 | | | | | |
| 8 | Kreistaschen schruppen (iMachining)  <> | | | | |
| MAC 1 (1- Position) | 10248 | 1619 | 30000 | 0:00:42 |
| 2-Spindle-1A |  | | |  |
|  | | | | |
| |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | | -65.76 | 65.76 | -5.76 | 5.76 | -16.5 | -2.5 | | | | | |
| 9 | Kreistaschen schlichten (iMachining)  <> | | | | |
| MAC 1 (1- Position) | 10248 | 1619 | 30000 | 0:00:03 |
| 2-Spindle-1A |  | | |  |
|  | | | | |
| |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | | -66 | 66 | -6 | 6 | -16.5 | -2.5 | | | | | |
| 10 | Rechtecktasche schruppen (iMachining)  <> | | | | |
| MAC 1 (1- Position) | 8626 | 1087 | 30000 | 0:01:20 |
| 2-Spindle-1A |  | | |  |
|  | | | | |
| |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | | -10.76 | 10.76 | -3.26 | 3.26 | -17 | 2 | | | | | |
| 11 | Rechtecktasche schlichten (iMachining)  <> | | | | |
| MAC 1 (1- Position) | 8626 | 1087 | 30000 | 0:00:08 |
| 2-Spindle-1A |  | | |  |
|  | | | | |
| |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | | -11 | 11 | -3.5 | 3.5 | -17 | 2 | | | | | |
| 12 | Tap Spot Drill (Bohren)  <> | | | | |
| MAC 1 (1- Position) | 2605.67 | 130.283 | 130.283 | 0:00:03 |
| 3-Spindle-1A |  | | |  |
|  | | | | |
| |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | | 20 | 20 | 0 | 0 | -2.75 | 2 | | | | | |
| 13 | Tap Drilling (Bohren)  <> | | | | |
| MAC 1 (1- Position) | 3412.19 | 341.219 | 341.219 | 0:00:05 |
| 4-Spindle-1A |  | | |  |
|  | | | | |
| |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | | 20 | 20 | 0 | 0 | -18.262 | 2 | | | | | |
| 14 | Tapping (Bohren)  <> | | | | |
| MAC 1 (1- Position) | 1137.4 | 0.8 | 0.8 | 0:00:02 |
| 5-Spindle-1A |  | | |  |
|  | | | | |
| |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | | 20 | 20 | 0 | 0 | -14.2 | 2 | | | | | |
| 15 | Planfräsen 2.Aufspannung (iMachining)  <> | | | | |
| MAC 2 (1- Position) | 10051 | 9662 | 30000 | 0:00:12 |
| 1-Spindle-1A |  | | |  |
|  | | | | |
| |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | | -81.258 | 81.256 | -30.248 | 27.266 | 0 | 6 | | | | | |
| 16 | Zentrieren D5.5 (Bohren)  <> | | | | |
| MAC 2 (1- Position) | 1000 | 33 | 33 | 0:00:09 |
| 3-Spindle-1A |  | | |  |
|  | | | | |
| |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | | -20 | -20 | 0 | 0 | -2 | 2 | | | | | |
| 17 | Bohren D5.5 (Bohren)  <> | | | | |
| MAC 2 (1- Position) | 3500 | 300 | 300 | 0:00:09 |
| 6-Spindle-1A |  | | |  |
|  | | | | |
| |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | | -20 | -20 | 0 | 0 | -21.652 | 2 | | | | | |
| 18 | Stirnsenkung Zylinder-0.5 (Profil)  <> | | | | |
| MAC 2 (1- Position) | 3500 | 1000 | 300 | 0:00:02 |
| 2-Spindle-1A |  | | |  |
|  | | | | |
| |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | | -21.2 | -18.8 | -1.2 | 1.2 | -0.5 | 2 | | | | | |
| 19 | Fase Stirnsenkung (Profil)  <> | | | | |
| MAC 2 (1- Position) | 1000 | 100 | 33 | 0:00:57 |
| 3-Spindle-1A |  | | |  |
|  | | | | |
| |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | | -22.25 | -17.75 | -2.25 | 2.25 | -3.45 | 2 | | | | | |
| Gesamtzeit: | | | | | 0:05:53 |