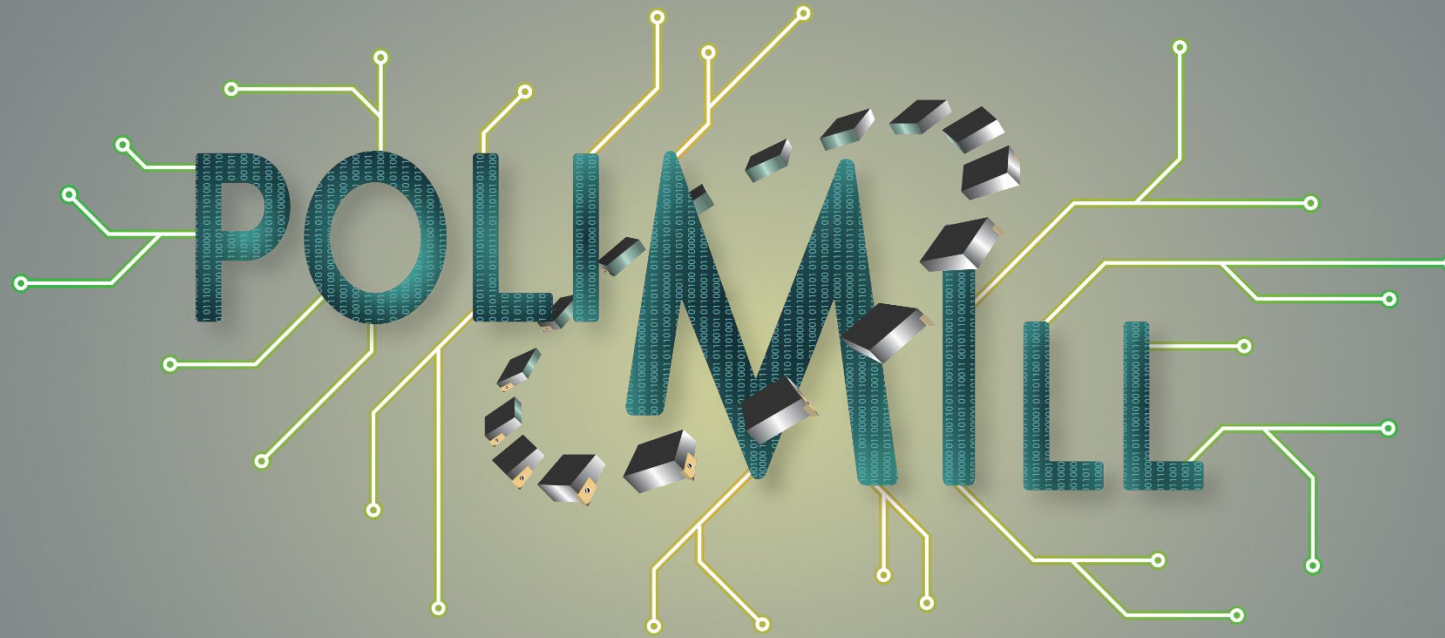
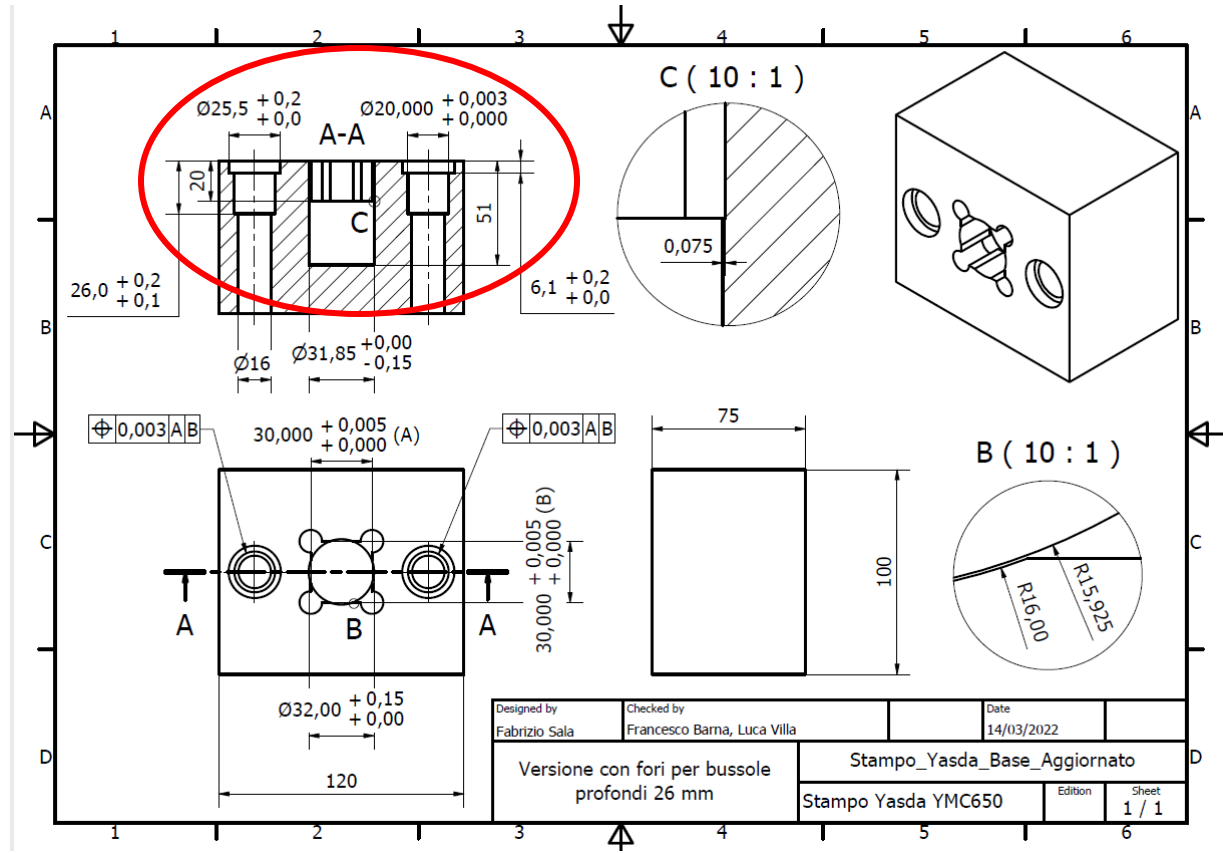
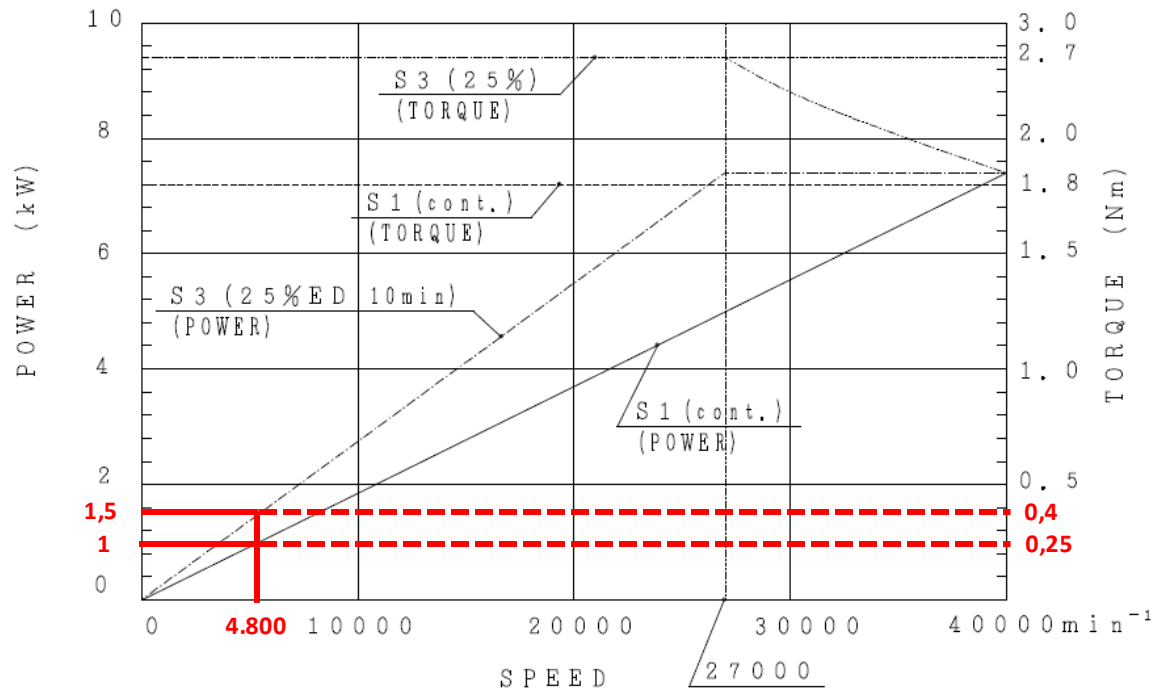


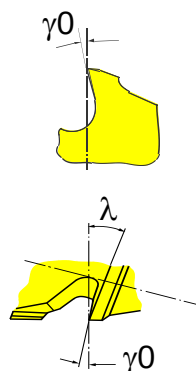


Macchina Utensile : Yasda YMC650

Componente : K110 Hrc58-60



Scelta Utensile : Teoria



Acciaio Temprato > 48 HRC e Ghisa

NEGATIVO



**NEUTRO
POSITIVO**

Acciaio e Ghisa



POSITIVO

Acciaio inox



**Molto
POSITIVO**

Leghe non ferrose



- 8°30' / -18°30' frese 90°

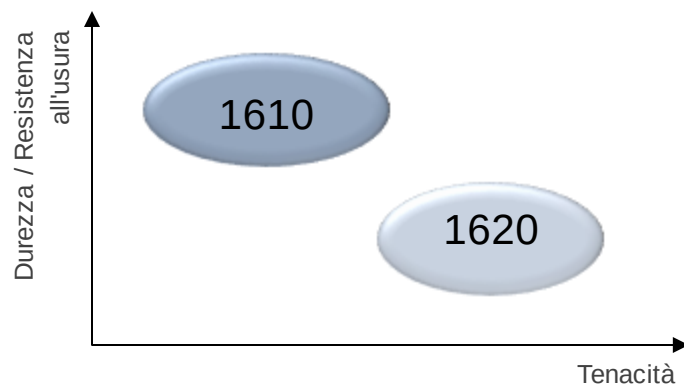
-6° / +1°30' frese raggiate

0° / +1°30' frese raggiate

+ 5°/+ 10°30' frese 90°

+ 5°/+ 10°30'
frese 90° e raggiate

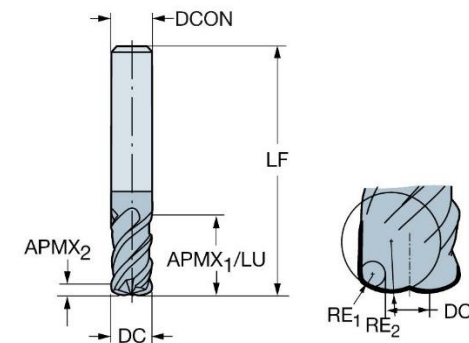
+10°30' / +13°30'



Scelta Utensile : Pratica

SANDVIK
Coromant

R215.H4-08050CAC05P 1620



Angolo di spoglia superiore radiale(GAMF) - 18 deg

Angolo di spoglia superiore assiale(GAMP) + 6 deg

1P360-0800-XA 1620



Angolo di spoglia superiore radiale(GAMF) + 10,5deg

Angolo di spoglia superiore assiale(GAMP) + 13,5 deg

Scelta Percorsi :

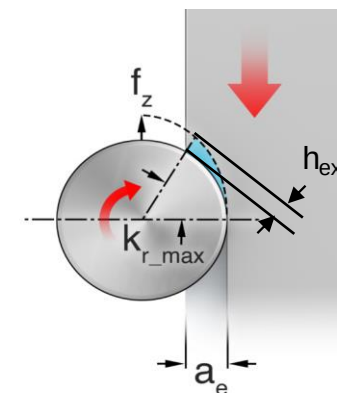
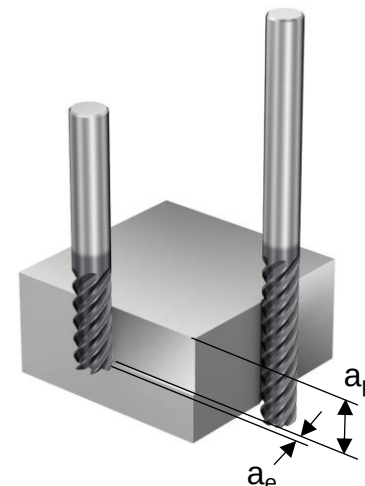
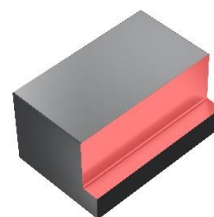
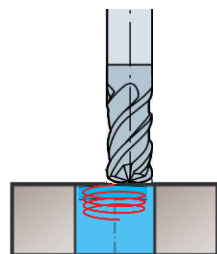
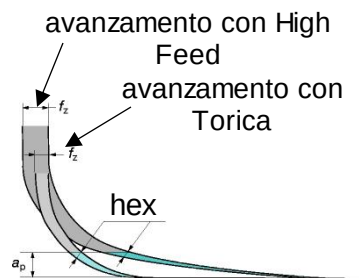
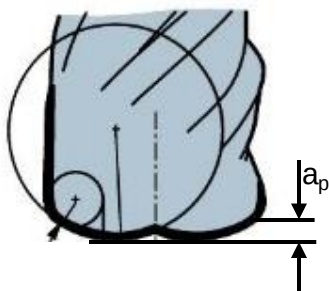
Fresatura ad elevate avanzamenti e interpolazione elicoidale



Fresatura di spianatura ad avanzamenti elevati

- Piccole A_p
- Elevato Volume Truciolo Q [cm³/min]. f_z fino a 0,9 mm/dente
- Lavorazione sicura e affidabile su tutti i materiali

Raggio grande frontale

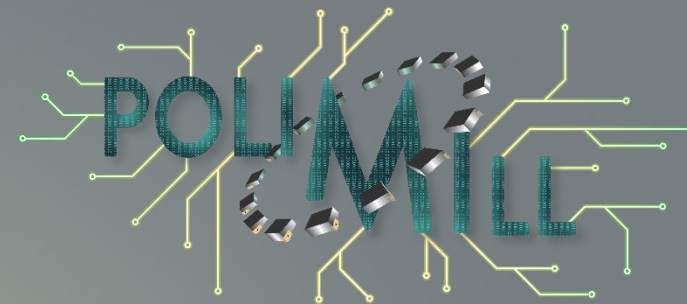
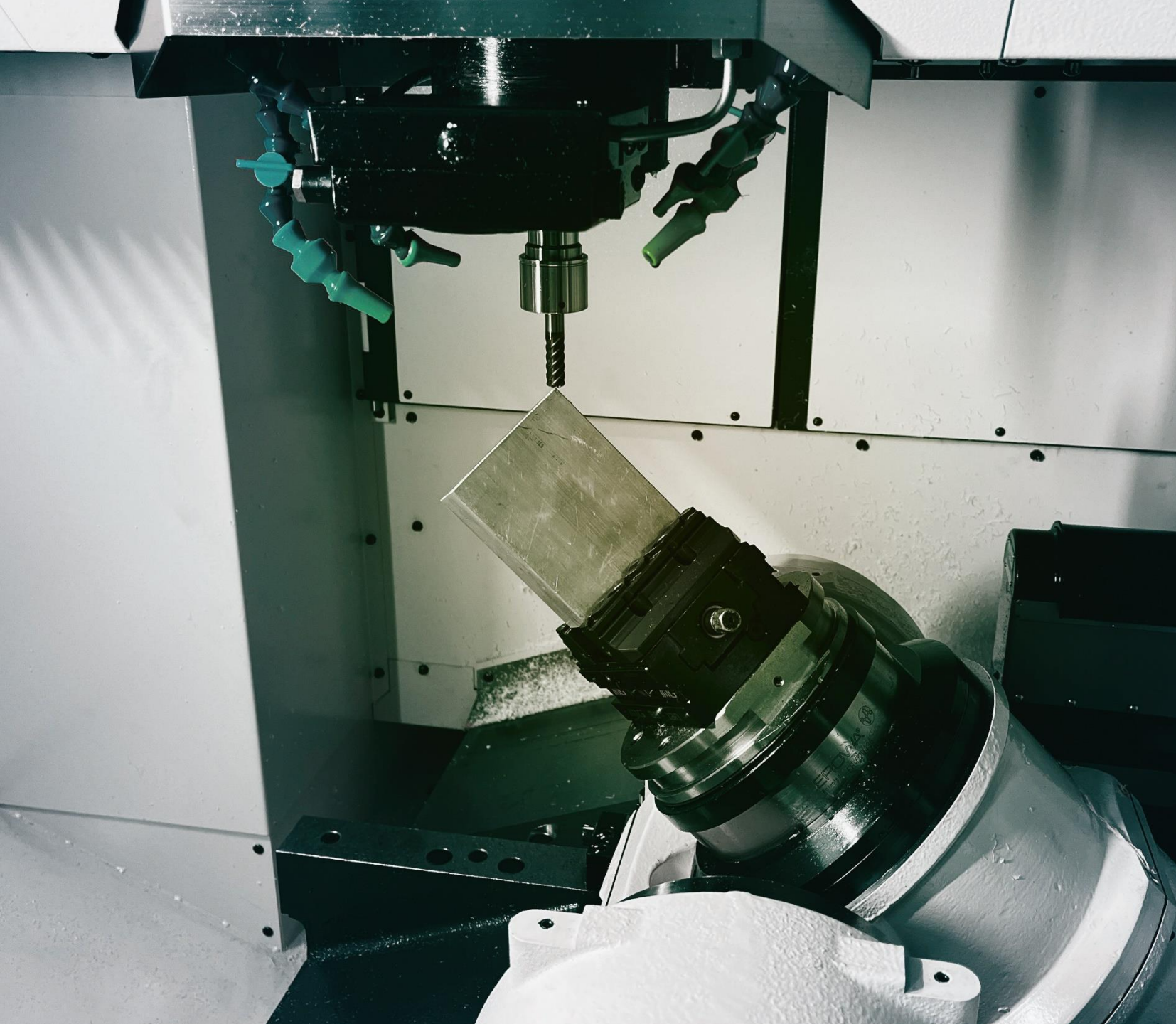


Interpolazione Elicoidale

- Minimizza le problematiche del controllo truciolo
- Diminuisce la richiesta di Potenza e Momento Torcente
- Riduce le forze assiali

Fresatura laterale ad avanzamenti elevati

- h_{ex} costante
- Forza di taglio costante
- Direzioni delle forze controllate



CONTACT

Massimiliano Annoni
massimiliano.annoni@polimi.it

Francesco Barna
francesco.barna@polimi.it
+39 3891106111

POLITECNICO
MILANO 1863