

# Machine: KX 15 [5-Axis]

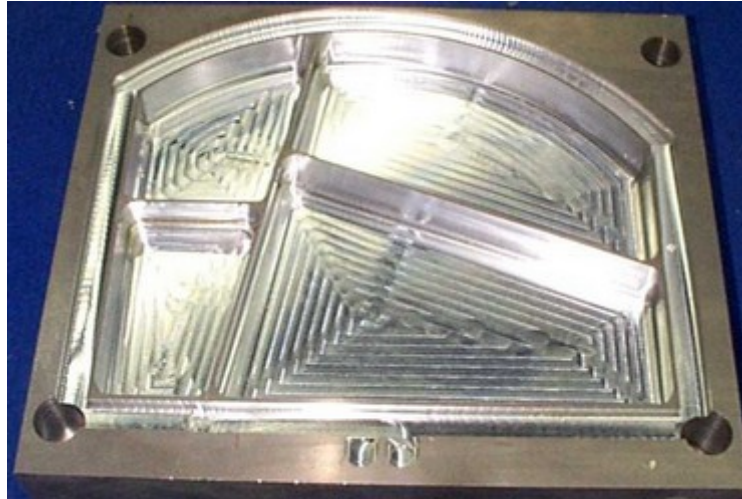
## Application: Aeronautical Part

Date of test : 2004  
Machine used : K2X 15  
Spindle : 24.000 rpm

Material :  
- AFNOR : AU4G  
- DIN : 3.1325  
Hardness : 450 Mpa – 127 HB  
Dimensions : 360 x 310 x 50 mm

Comments :

- Part machined in 5 continuous axes.
- Pocket Depth of 27 mm
- Thin 3 mm walls in positive and negative undercut



Operations	Tool	Rotation rpm	Feedrate mm/min	Width mm	Depth mm	Discharge cm3/min	Surface quality $\mu\text{m}$	Time minutes
Roughing	$\varnothing$ 16-2	20.000	6.000	14	3	252		<b>35,80</b>
<b>Roughing</b>								<b>35,80</b>
Finishing	$\varnothing$ 16-r2	20.000	6.000	0.5				<b>10,19</b>
<b>Finishing</b>								<b>10,19</b>
<b>TOTAL MACHINING TIME</b>								<b>46 mn</b>