

Machine: K2X 15 [5-Axis]

Application: Turbine

Machine used : K2X 15
Spindle : 18.000 rpm

Material :
- AFNOR : AU4G
- DIN : 3.1325
Hardness : 40 Mpa – 127 HB

Comments :
All of part is manufactured with 5-axes



Operations	Tool	Rotation rpm	Feedrate mm/min	Width mm	Depth mm	Discharge cm ³ /min	Surface quality μm	Time minutes
Roughing	Ø12-r6	16.000	3.000					
	Ø10-r5	18.000	2.000					
	Conical milling cutter Ø16-r5	2.500	1.000					
Roughing								
Finishing Height = 50 in 1x	Conical milling cutter Ø16-r5	1.200	400					
Finishing								
Surface quality obtained : Ra = 2.0 μm				TOTAL MACHINING TIME				185 mn