

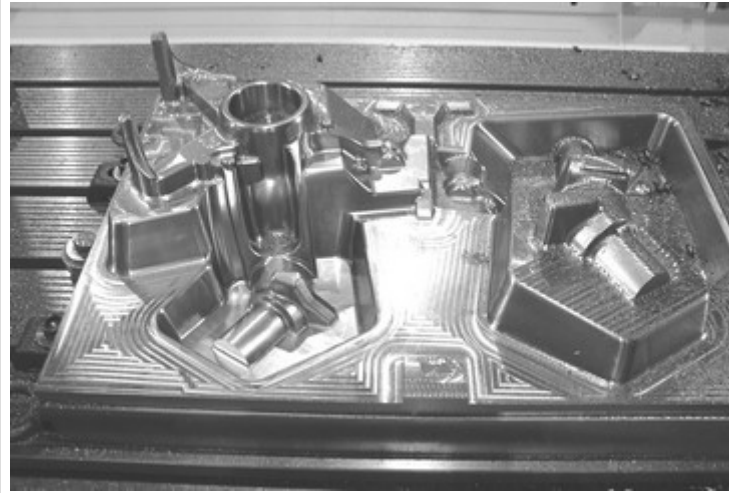
# Machine: KX 50 [5-Axis]

## Application: Wheel Shaft Support

Machine used : KX 50  
Spindle : 18.000 rpm

Material :  
- AFNOR : 40CMD8  
- DIN : 1.2311  
Hardness : 35 Hrc  
Dimensions : 700 x 500 x 215 mm

- Comments :
- General machining in 3+2
  - Engraving machining with milling cutter Ø1,00



Operations	Tool	Rotation rpm	Feedrate mm/min	Width mm	Depth mm	Discharge cm3/min	Surface quality µm	Time Hours
<b>Extract of the machining range</b>								
Roughing cycle	Ø50-5-r3	1.100	5.500	40	0,60	132		21,60
2 <sup>nd</sup> roughing cycle	Ø25-2-r5	2.000	4.000	10	0,30			2,50
	Ø12-2-r6	4.800	1.500	2	1			6,60
	Ø5-2-r2,5	9.500	1.000	0,8	0,4			5,00
<b>Roughing</b>								
Finishing	Ø8-2-r4	10.000	3.000	0,2	0,2			54,16
	Ø5-2-r2,5	13.000	2.500	0,1	0,1			
	Ø3-2-r1,5	15.000	1.200					
	Ø2-2-r1,0	18.000						
	Ø1-2-r0,5	18.000						
<b>Finishing</b>								
<b>TOTAL MACHINING TIME</b>								90,00 h