

CNC

Materiał - aluminium

$V_s = 300 \text{ m/min}$

Narzędzie - róz z węgla spiekane

$a_p = 3 \text{ mm}$ - głęb. skrawania

$R_a = 1,25$

$R_{max} = 1,25 \cdot 5 = 6,25$

Obrotki:

$$n = \frac{1000 \cdot 300}{3,14 \cdot 75} = 1275 \text{ obr/min}$$

Posuw:

$$f = \sqrt{\frac{R_{max} \cdot a_p \cdot n}{1000}} = \sqrt{\frac{6,25 \cdot 3 \cdot 1275}{1000}} = 0,2 \text{ mm/obr}$$

Program

% watek

N10 G55 G71 T0110 G90

N20 G95 S1275 F0,2 M4 G42 M8

N30 G0 x79 z78

N40 x75

N50 G1 z-1

N60 x77 z77

N70 x1

N80 G1 z41

N90 G0 x73 z77

N100 x67

N110 G1 z41

N120 x70 z77

N130 x60

N140 G1 z41

N150 G0 x67 z77

N160 x53

N170 G1 z41

N180 G0 x 54 x 44

N190 x 46

N200 G1 x 41

N210 G0 x 50 x 44

N220 x 39

N230 G1 x 41

N240 G0 x 43 x 44

N250 x 34

N260 G1 x 41

N270 G0 x 36 x 44

N280 G3 x 32 x 44,5 424 K 44,5

N290 G1 x 40

N300 G0 x 60

N310 G0 x 45 x 24

N320 G1 x 13

N330 x 60 x 0

N340 G28 x x

N350 M2