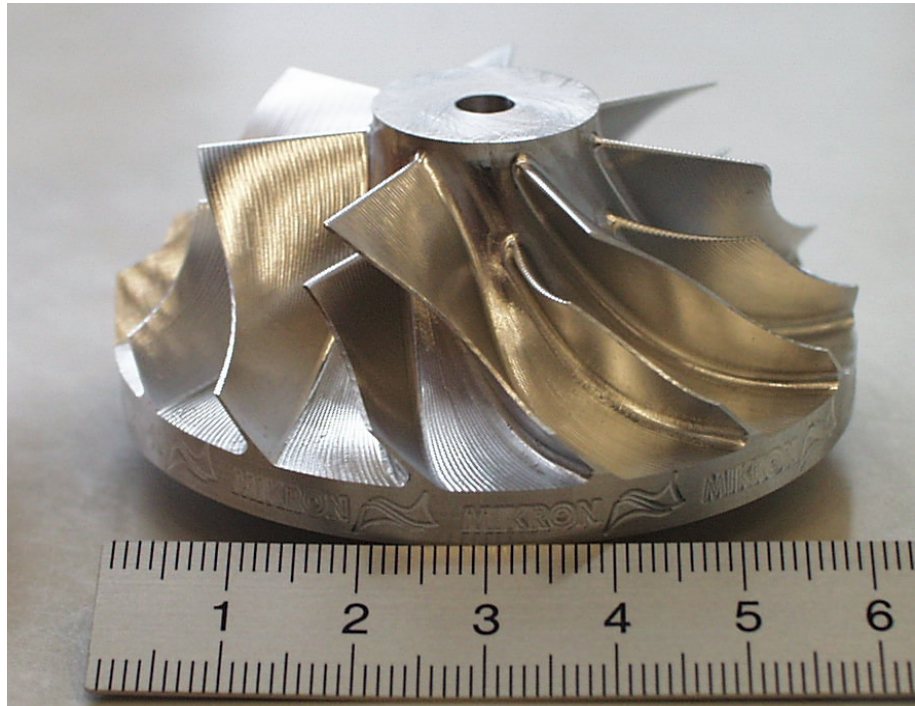


## Impeller 04 – V5 point milling



Process Step	Tool	Diameter [mm]	Corner-Radius [mm]	Number of Teeth	Spindle Speed [min <sup>-1</sup> ]	Feed Rate [mm/min]	Lateral Feed [mm]	Axial Feed [mm]	Processing Time
		<b>D</b>	<b>R</b>	<b>z</b>	<b>n</b>	<b>v<sub>f</sub></b>	<b>a<sub>e</sub></b>	<b>a<sub>p</sub></b>	<b>t</b>
machine preform	torus	8	1	2	38'000	15'000	6	2	45''
machine preform	ball nose	6	3	2	38'000	10'000	1	0.5	40''
roughing	ball nose	4	2	2	38'000	10'000	4	2	2'40''
roughing rest material	ball nose	3	1.5	2	40'000	8'000	3	1	1'50''
prefinishing	ball nose	3	1.5	2	40'000	6'000	0.5	1	3'50''
finishing	ball nose	2	1	2	41'000	4'500	0.2	0.4	15'10''
engraving	ball nose	2	1	2	41'000	4'500	0.2	0.05	1'
<b>Processing Time (Total)</b>									<b>25'55''</b>

**Machine** : HSM 400 U, 42'000 min<sup>-1</sup>

**Material** : Alu

**Focus** : Target surface quality : Ra 5µm