TOS VARNSDORF a.s.

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Interpolation turning

New technological function

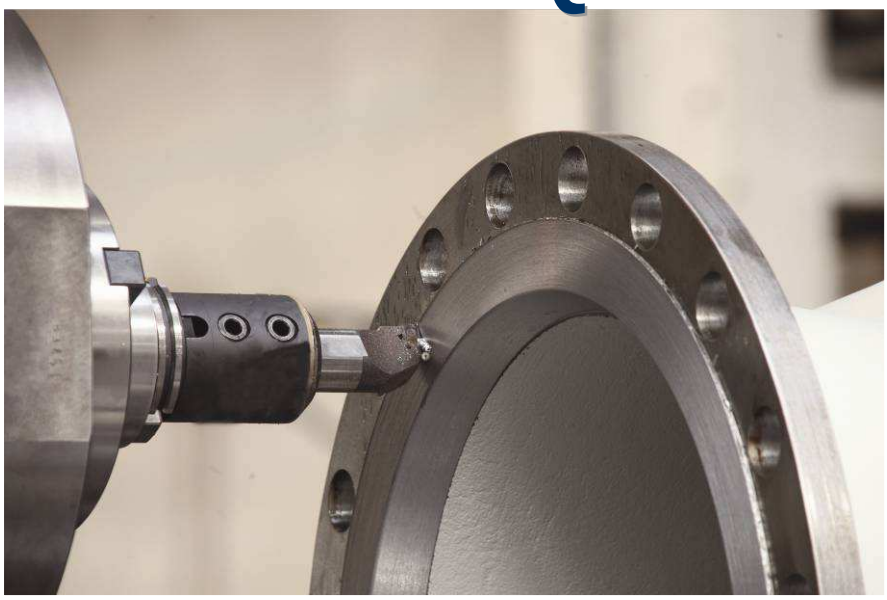
Company TOS VARNSDORF a.s. has extended the offer of machines technological usage. Machines have been fully tested on new technology of interpolation turning.

Technology of interpolation turning can be applied on all machines of TOS VARNSDORF a.s. company.

The technology has been tested on control systems HEIDENHAIN iTNC530 and SIEMENS Sinumerik 840D.

Examples of practical use:

WHN 110 Q

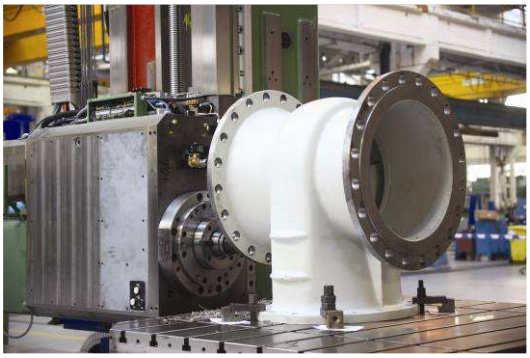


Workpiece from cast iron GG20 – valve body - clamped on the table.

Feed F = 10,000 mm/min
Machined average D = 550 mm
Spindle speed n = 7 R.P.M.
Cutting speed vc = 14 m/min

Spindle power = 0,35 kW
Feed/spindle speed f = from 0,1 up to 0,3 mm
Machining depth ap = 2 mm

Achievements:
Roundness – 0,02 mm



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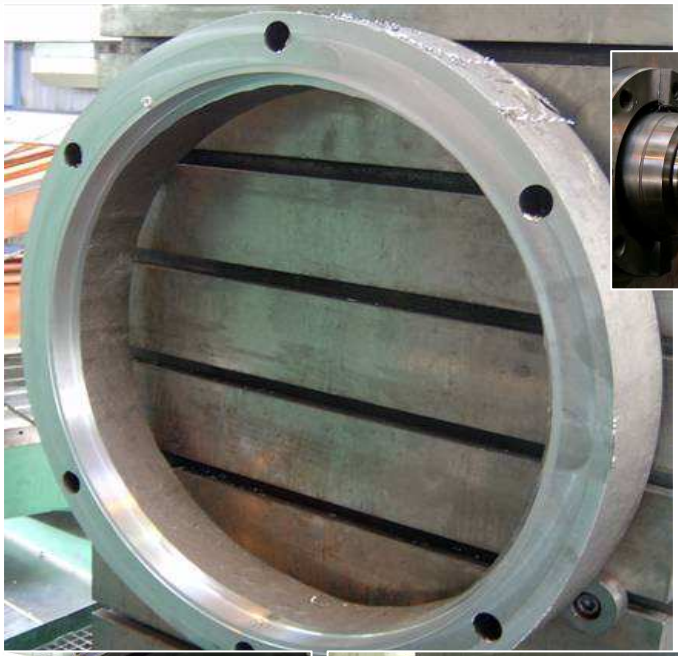
WRD 130 Q

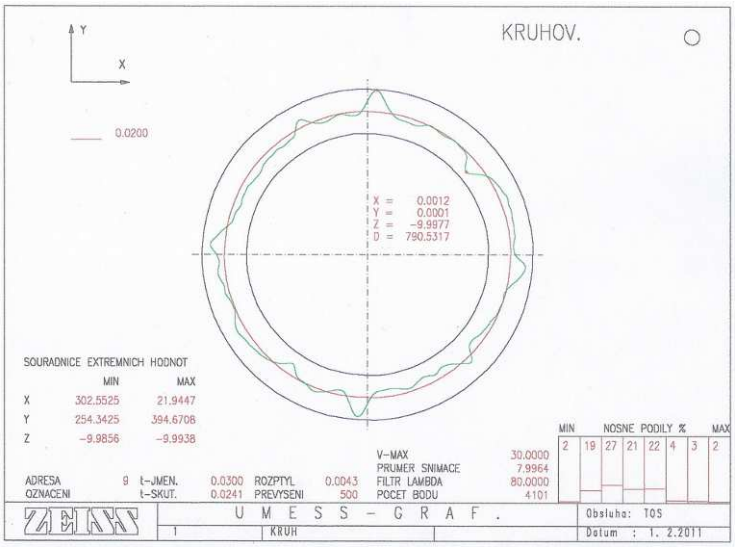


Workpiece from steel - armature flange
ČSN 11 600 (DIN St 60-2) clamped on clamping angle plate UU2000.

Feed F = 15,000 mm/min
Machined average D = 790 mm
Spindle speed n = 6,5 R.P.M.
Cutting speed vc = 16 m/min

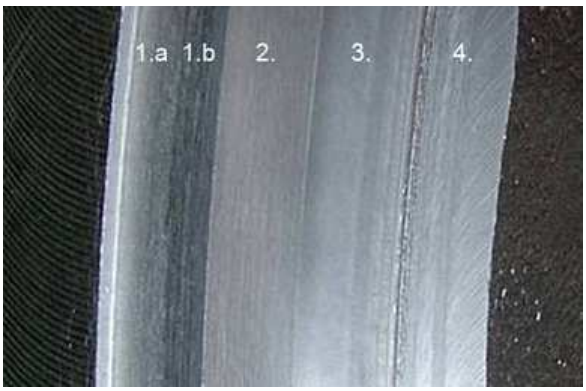
Spindle power = 0,4 kW
Feed/spindle speed f = from 0,2 up to 0,3 mm
Machining depth ap = from 1,5 up to 3 mm

Achievements: roundness – 0,02 mm



Surface quality
1.a – face turning f = 0,3 mm/R, ap = 3 mm
1.b – face turning f = 0,2 mm/R, ap = 3 mm
2 – face turning f = 0,2 mm/R, ap = 0,05 mm

R = spindle speed



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