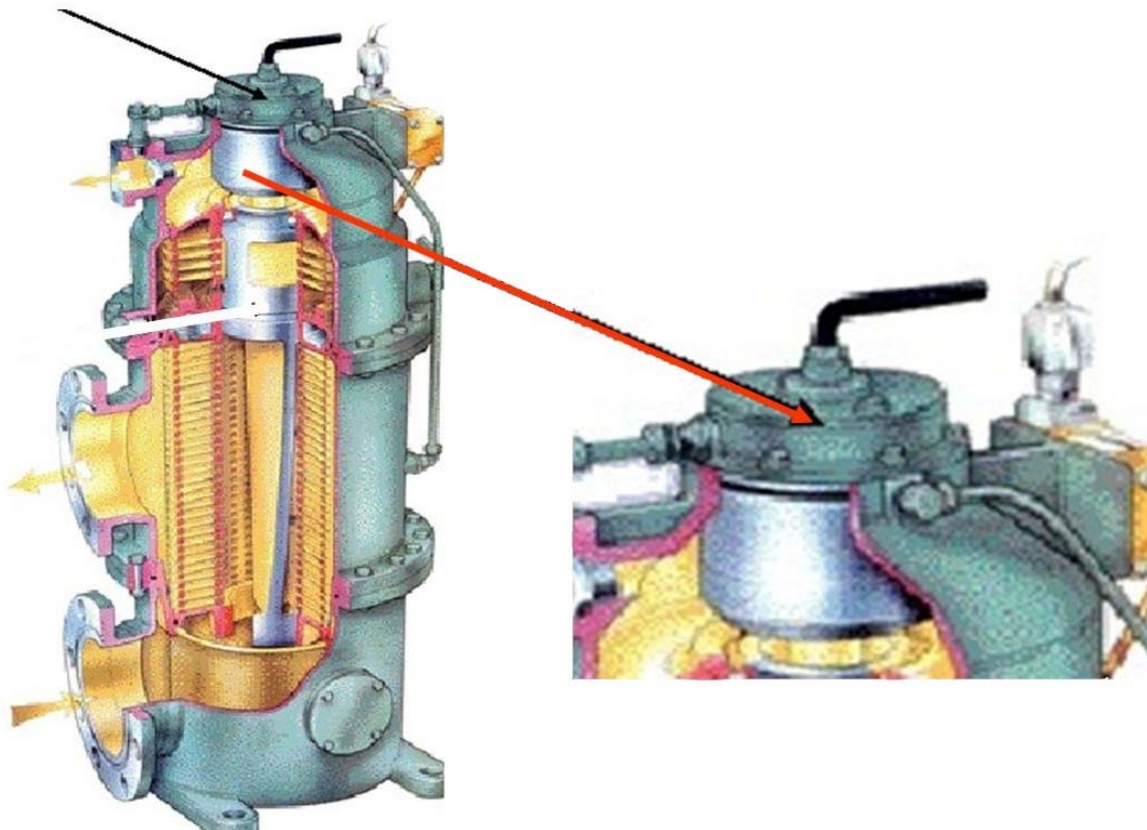


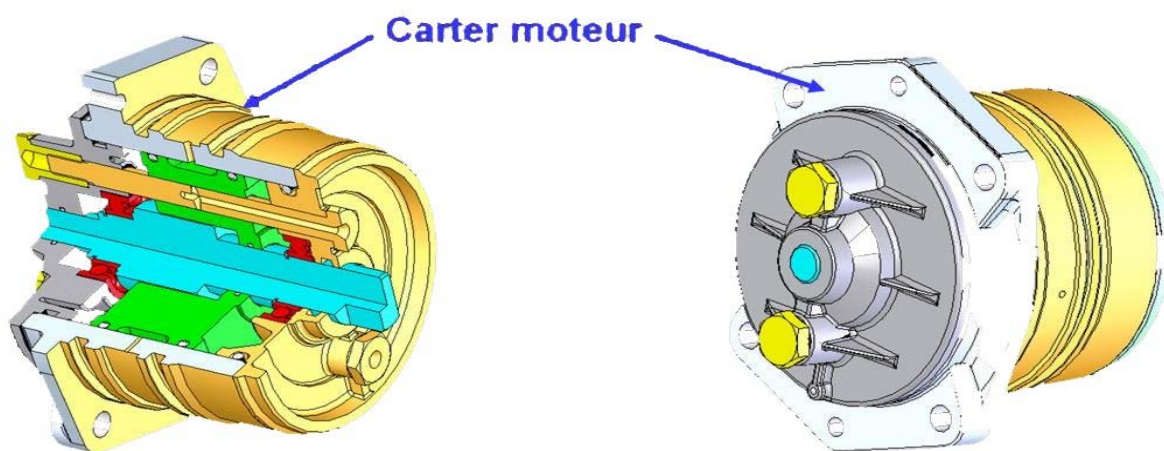
Mise en situation

Le carter fait partie d'un ensemble moteur destiné au client « ALFA LAVAL ». 250 pièces par mois doivent être fabriquées.

Moteur



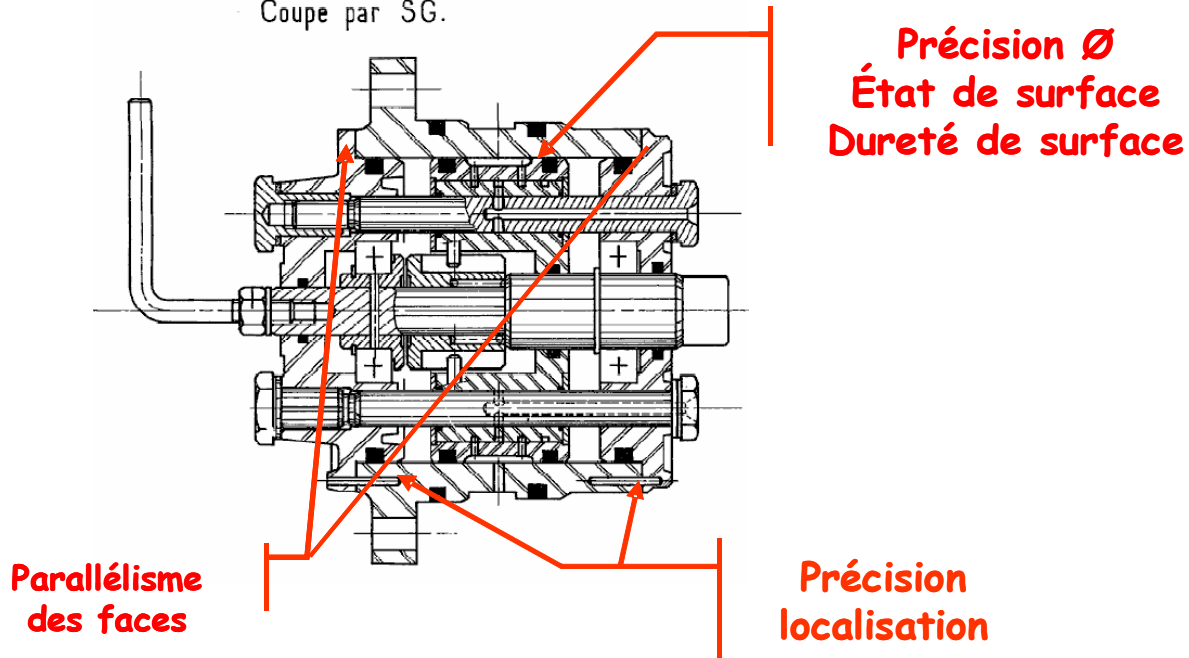
Vue moteur seul



Vue en coupe de l'ensemble moteur

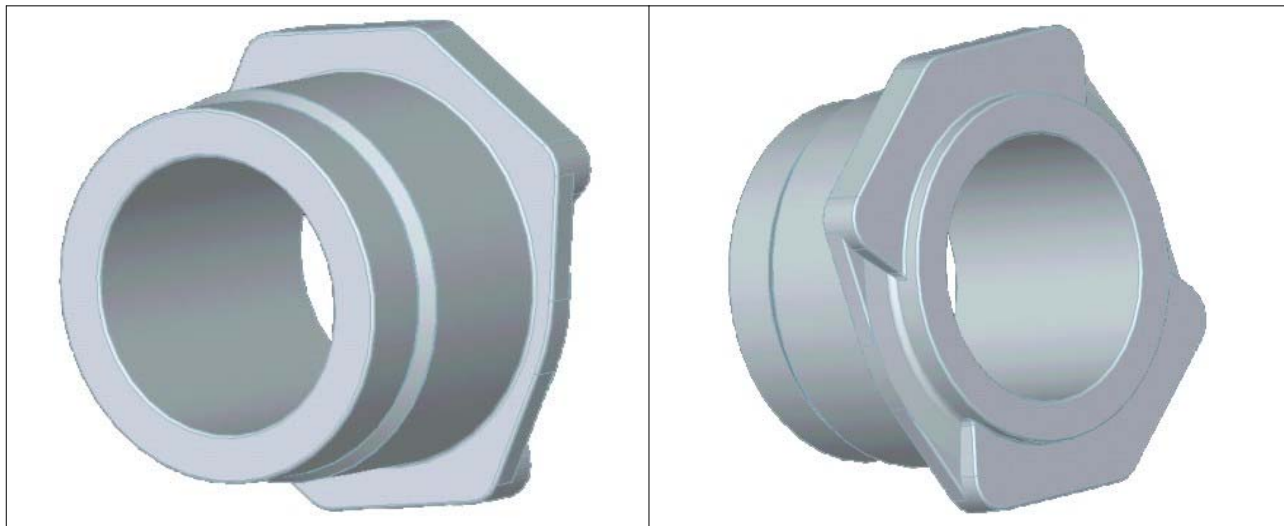
Des contraintes fonctionnelles qui concernent le carter sont portées sur le dessin ci-dessous.

Coupe par S.G.

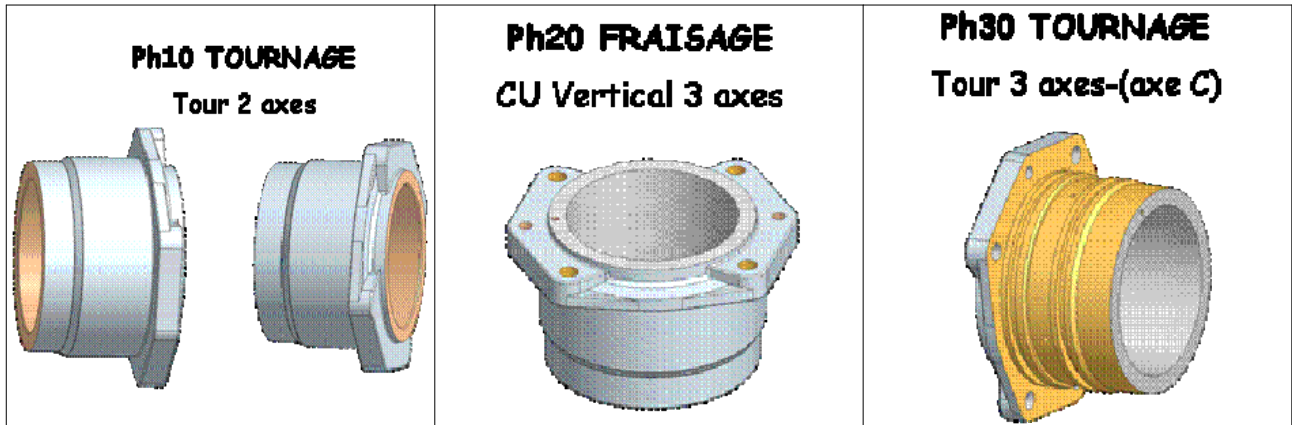


Présentation des pièces brutes

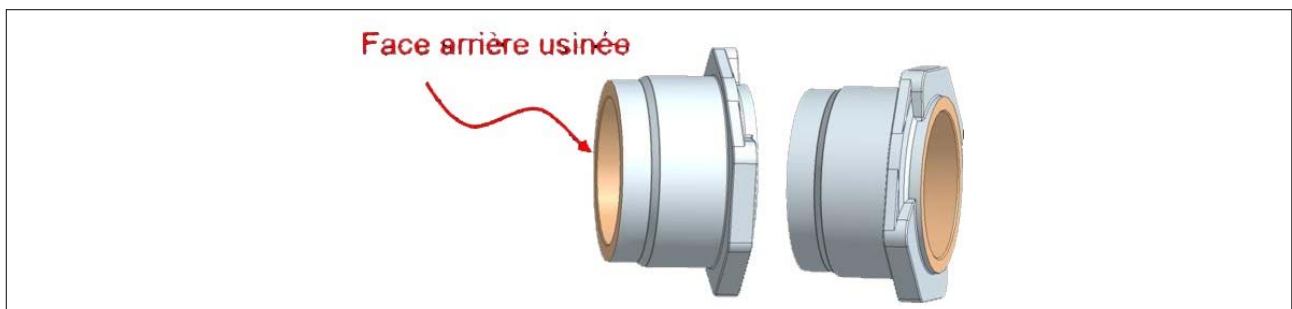
Matière: Al Si7 Mg



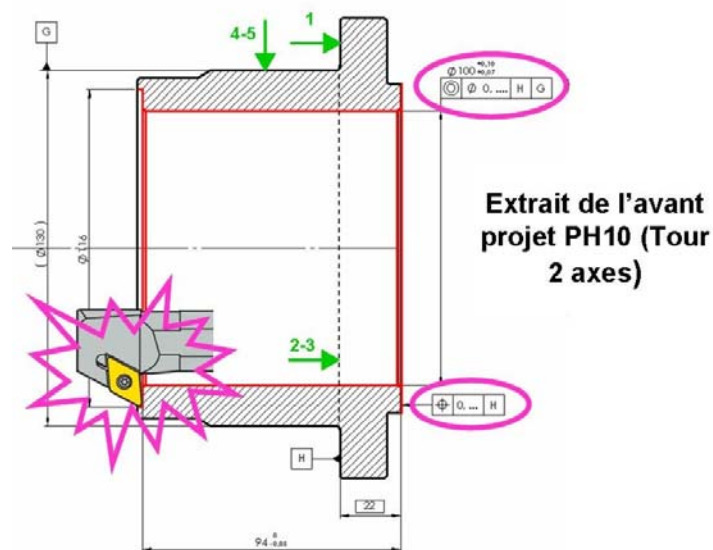
Présentation d'un projet de processus

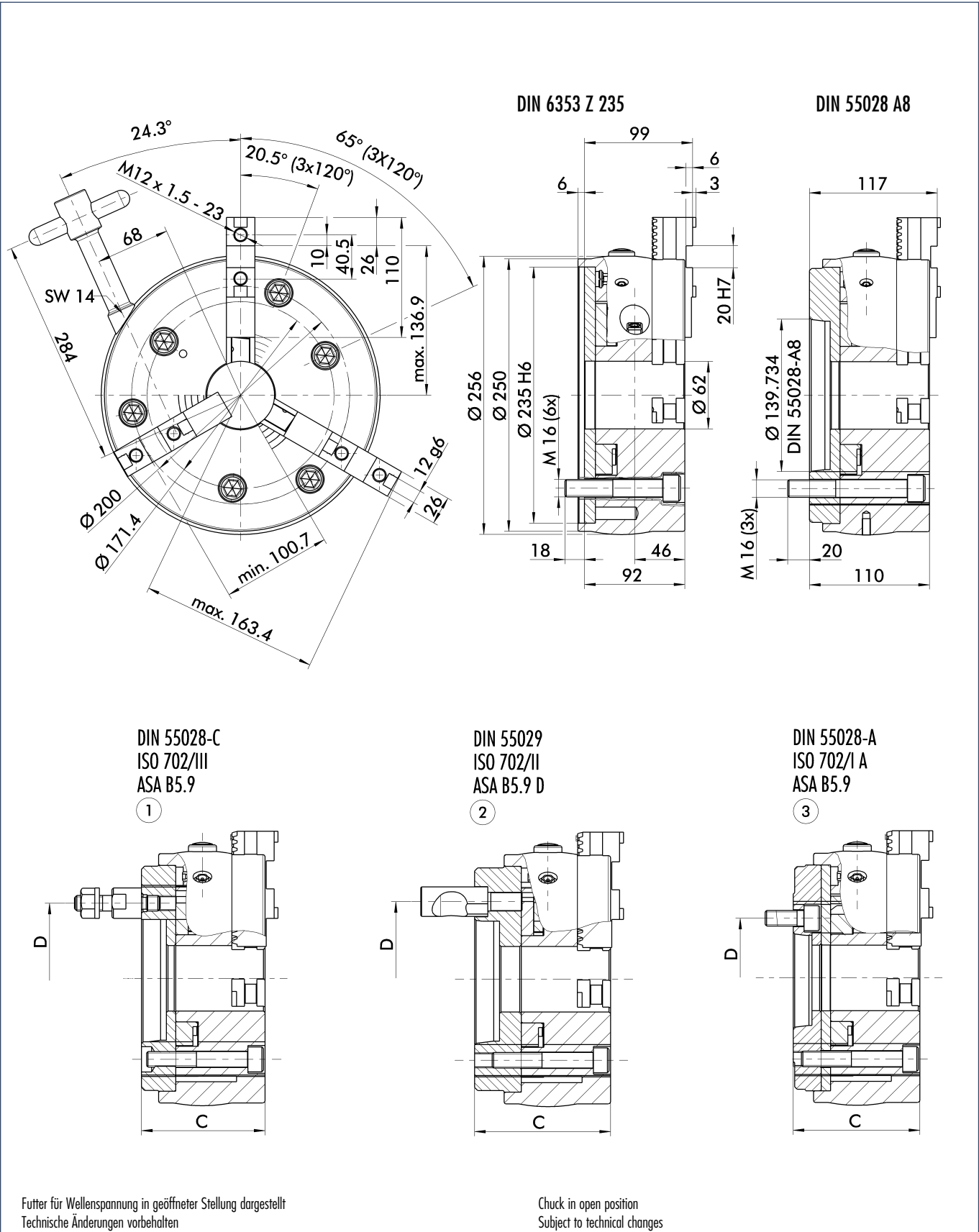


Pré-conception montage phase 10



Éléments à considérer pour définir les conditions d'aptitude à l'emploi de l'outillage





① Für Kurzkegel Bajonettbefestigung
DIN 55027, ISO 702/III, ASA B5.9

② Für Kurzkegel Camlockbefestigung
DIN 55029, ISO 702/II, ASA B5.9 D

③ Mit Zwischenflansch für Kurzkegel
DIN 55026 A, ISO 702/I A, ASA B5.9

① For short taper Bayonet-Mount
DIN 55027, ISO 702/III, ASA B5.9

② For short taper Camlock-Mount
DIN 55029, ISO 702/II, ASA B5.9 D

③ With adapter plate for short taper
DIN 55026 A, ISO 702/I A, ASA B5.9

H G F E D C B A

4

3

2

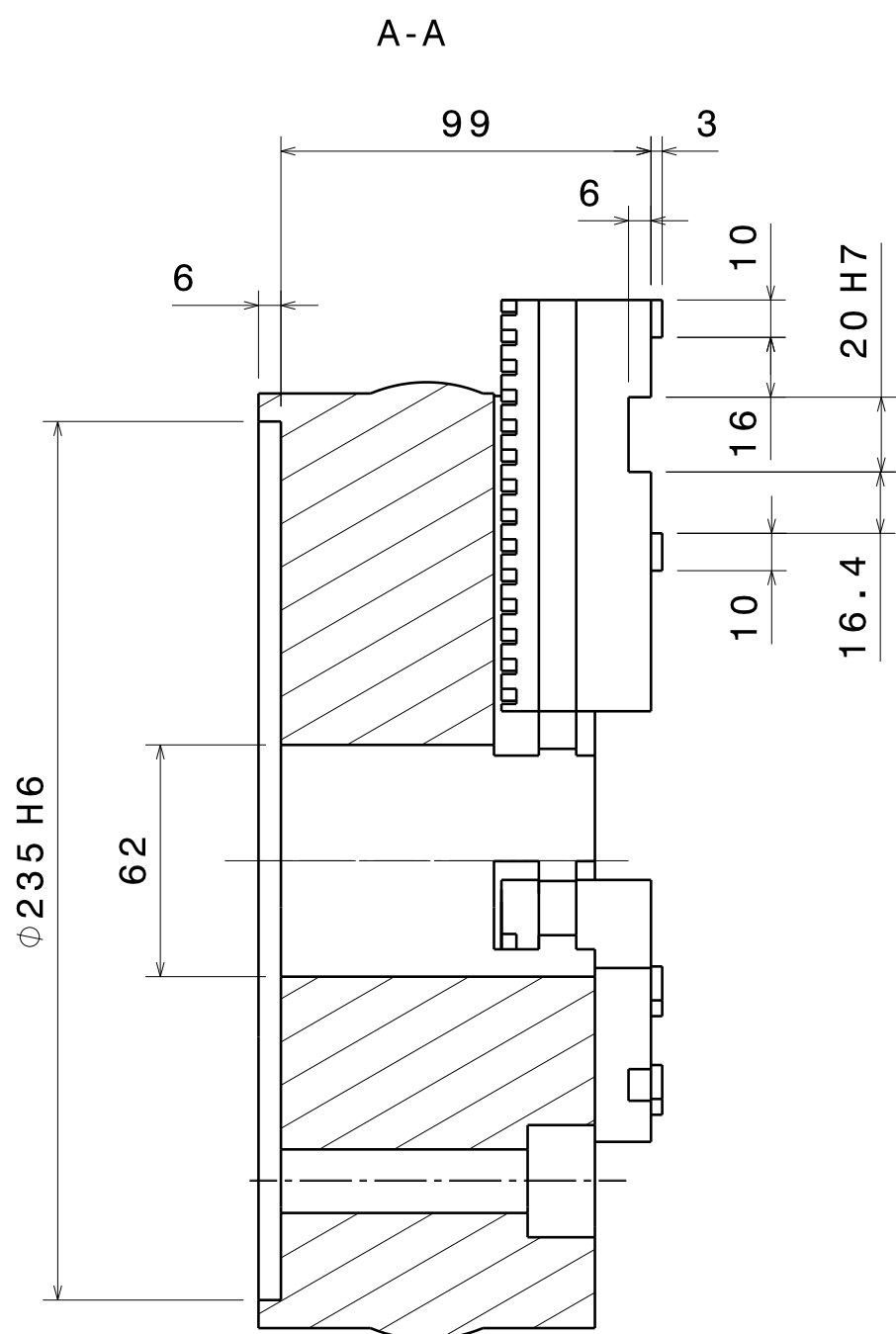
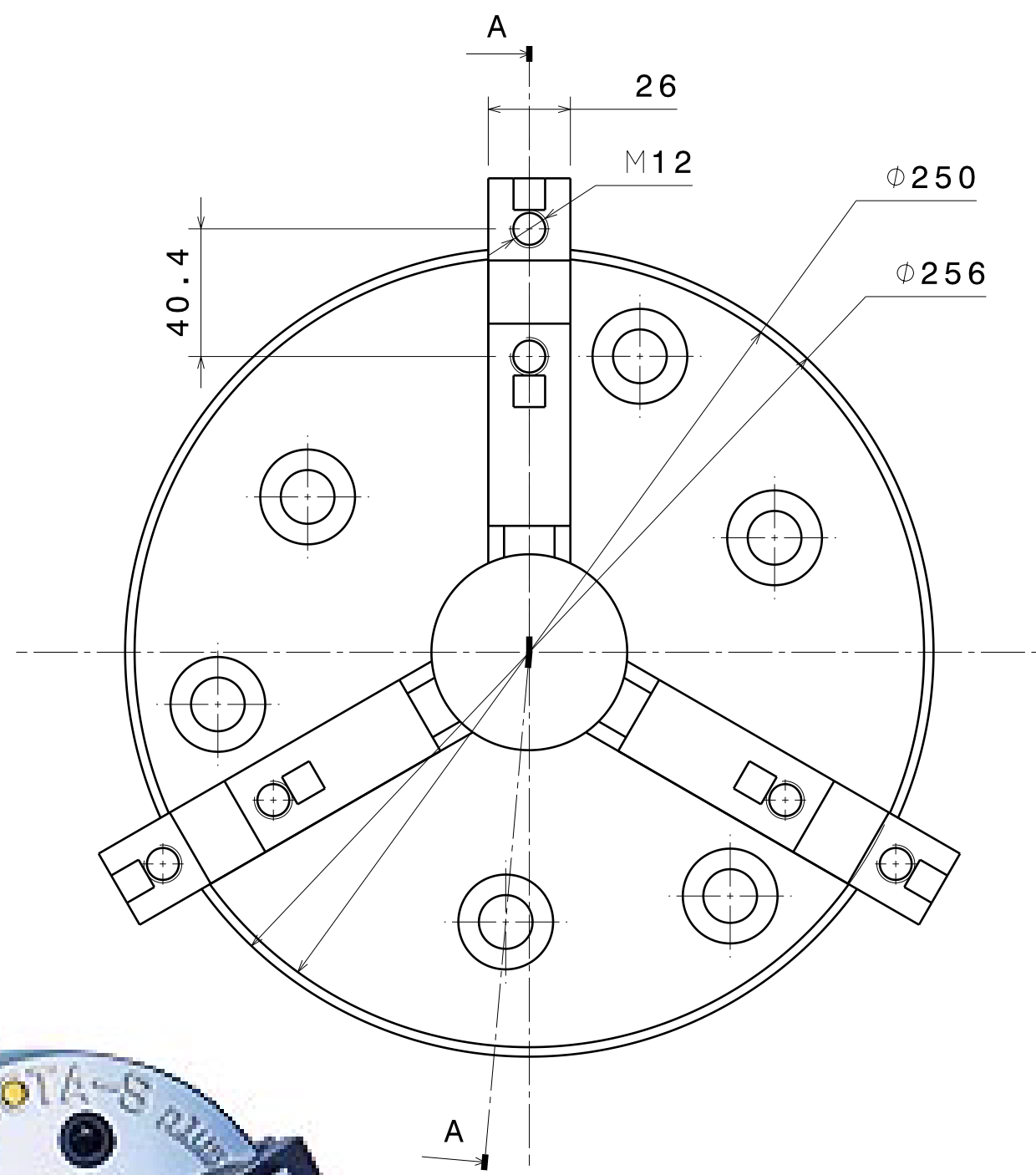
1

4

3

2

1



DESIGNED BY:	jgb		Mandrin Schunk ROTA-S plus 250-62
DATE:	15/09/2007		
CHECKED BY:	XXX		Lycée Jean Moulin - Béziers
DATE:	XXX		
SIZE	A3		
SCALE	1:2	WEIGHT (kg)	DRAWING NUMBER
		XXX	Attachement DIN 6353 Z 235
			SHEET
			1/1

I	-
H	-
G	-
F	-
E	-
D	-
C	-
B	-
A	-

H G B A

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Inserts

General turning



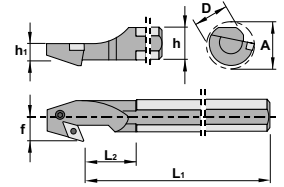
Characteristics:

Backwards boring bar for internal turning and profiling applications equipped with rhombic negative inserts (angle 55°) and strong cutting edges. The lever lock ensures good rigidity and chip flow in roughing applications.

Applications:

Backwards profiling boring bar for general applications, roughing, semi-finishing and finishing. For low powered machines and small pieces choose boring bars Ref. SDUC-EX (Page: C.36).

Axial: -6°
Radial: -14°



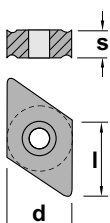
PDUN 93°-EX

Ref.	D	h	h1	L1	L2	f	A	Insert size	Kg
S32U PDUN R/L 15-EX	32	30	15,0	350	50	22	39	DN.. 1506..	2,050
S40V PDUN R/L 15-EX	40	37	18,5	400	60	27	48	DN.. 1506..	3,750
S50W PDUN R/L 15-EX	50	47	23,5	450	65	35	61	DN.. 1506..	6,500



Ref.	S32U PDUN R/L 15-EX	S40V PDUN R/L 15-EX	S50W PDUN R/L 15-EX
8415	1648	5003	-
8415	1638	5003	3715
8415	1638	5003	3715
			4112
			0012
			3725
			4135

For DNM.. 1504.. inserts



DN..

l

s

d

Negative 55° rhombic inserts.

For more information see page: A.22

Ref.	DN.. 1504..	DN.. 1506..
	15,50	15,50
	4,76	6,35
	12,70	12,70

DNMG-CF	DNMG-CM	DNMG-CS					
DNGP	DNMA	DNMG-CFC	DNMG-CFM	DNMG-CMC	DNMG-CMF	DNMG-CMR	DNMX