

Yi Sika: ? Car of ? of carboxyl of fishhawk of talk in one's sleep of ?of ? ofa huge legendary turtle of Lan aspicWo ? ?aa

Introductive

In raising thick mill to machine considerably, every agefeed, means of this one treatment is called fast feedmilling (FF) or big feed milling (HFM) , apply to industrialdomain at 90 time. To shortening becauseof the user themould produces the demand of production time toincrease in great quantities, mouldindustry makes one offields that use means of milling of HFM big feed theearliest to undertakemanufacturing carrying out. HFM ofbig feed milling cutter make a response to demand of thisone marketnot only; Still offered efficient treatmentcutting tool to be used at improving productivity at thesame time.Big feed machines means to basically bebased on two principles: The geometrical appearance ofmillingcutter; Milling cutter acquires drive of high speedbig feed on the machine tool.

Big feed milling is relevant

Typical big feed milling cutter has the characteristic ofsmall tool cutting edge angle, its value is 9-17 ° normally.Characteristic of this one design will be derivative 3important results. It is to result from firstlycut bits todecrease small effect to make every tine feed has thepossibility that gets comparativg rising substantially. Forexample, in the face mill treatment of low-alloy steel, thebiggest value of every tine feed is 0.2mm; It is however inbig feed treatment, what can realize 2mm normally is thebiggest every tine feed. It is cutting tool appearanceensures implementation is small secondly cut deep.Milling treatment reduced cutting deepness DOC,reduced cutting force and machine tool power to use up.The radial weight that is cutting force thirdly is the leastspend couple axial weight is the greatest change, make cutting force main effect the axial direction at machinetool main shaft, that is to say, cutting forcebasically points to the way with machine tool the oldest tidity.This rose to machine stability.

Raise every tine feed to mean higher feed rate, need thefeed value that cutting tool of machine tool drive gives outto just close. In case of afore-mentioned big feed millingthat are aimed at low-alloy steel, feed speed can amount to 7000-9000 Mm/min, than groovy feed tower above one big chunk.

Take market demand, machine tool manufacturer people development goes for big feed milling the sundry machine tool of special design. These power have relative to lower machine tool " 3 tall " characteristic: Tall torque, tall thrust main shaft, drive of high speed feed. These machine tools are provided sufficient the hardware of CNC of advanced computerized numerical control and software.HFM of big feed milling machined means to turn round thick mill to machine a concept greatly. Replacethe treatment way that cuts wide means to undertake centralized purify to workpiece material greatly is reached greatly with be being cut greatly on high power machine tool, treatment means advocates big feed milling to go up in low power machine tool with small the milling treatment that cuts productivity of deep executive freeboard, cutting cutting tool rotates at full speed.

Big feed milling already all previous classics a few interesting change. Original its are inspected mould industry antrum and narrow the effective method that small-sized antrum thick mill machines, but the advantage is had in be being confirmed in the face mill is machined very quickly. The diametrical limits of milling cutter of fast feed FF is in outspread; Apply to the project material series that introduces means of big feed milling to undertake machining also increasing ceaselessly. Big feed milling is permeated very quickly entered numerous industry field. Big feed milling serves as efficient processing technique no longer industry of mould of service of bureau be confined to, begin with general be put on Yugejin to belong to cutting domain by the means of tall productivity treatment of agree. Although steel reaches cast-iron material,be big feed milling is main use up material, however alloy of stainless steel, titanium is tall even lukewarm alloy, super alloy is succeeded as much ground treatment. This leads tool supplier again conversely people the sundry big feed milling cutter that rolls out different form. They are rolled out but

