

Yi Sika: ? Car of ? of carboxyl of fish hawkof talk in one's sleep of ?of ? of a hugelegendary turtle of Lan aspic Wo ? ?aa

Introductive

In raising thick mill to machine considerably, every age feed, means of this one treatment is called fast feed milling (FF) or bigfeed milling (HFM) , apply to industrial domain at 90 time. Toshortening becauseof the user the mould produces the demandof production time to increase in great quantities, mouldindustry makes one of fields that use means of milling of HFM big feedthe earliest to undertakemanufacturing carrying out. HFM of bigfeed milling cutter make a response to demand of this onemarketnot only; Still offered efficient treatment cutting tool to beused at improving productivity at the sametime. Big feed machines means to basically be based on two principles: Thegeometrical appearance ofmilling cutter; Milling cutter acquiresdrive of high speed big feed on the machine tool.

Big feed milling is relevant

Typical big feed milling cutter has the characteristic of small toolcutting edge angle, its value is $9-17^{\circ}$ normally. Characteristic ofthis one design will be derivative 3 important results. It is to resultfrom firstlycut bits to decrease small effect to make every tinefeed has the possibility that gets comparativg rising substantially. For example, in the face mill treatment of low-alloysteel, the biggest value of every tinefeed is 0.2mm; It is howeverin big feed treatment, what can realize 2mm normally is thebiggest everytinefeed. It is cutting tool appearance ensuresimplementation is small secondly cut deep. Millingtreatmentreduced cutting deepness DOC, reduced cutting force andmachine tool power to use up. Theradialweight that is cuttingforce thirdly is the least spend couple axial weight is the greatestchange,makecutting force main effect the axial direction atmachine tool main shaft, that is to say, cutting forcebasicallypoints to the way with machine tool the oldest tidity. This roseto machine stability.

Raise every tine feed to mean higher feed rate, need the feedvalue that cutting tool of machine tool drive gives out to justclose. In case of afore-mentioned big feed milling that are aimedat 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 peopledevelopment goes for big feed milling the sundry machine tool ofspecial 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

