What does suitable mill He Nixi have todistinguish? What actor drawback do eachhave?aa

Distinction: Milling cutter rotates the feed direction of the way thatcuts work and workpiece is called instead go against mill; Millingcutter rotates the feed way of the way that cuts work and workpiece is same call suitable mill.

Actor defect:

Go against mill: Cutting ply from 0 arrive the biggest, cutting toolservice life is low, already machined exterior quality difference,generation is perpendicular up milling component of force, haveinstigate the trend that workpiece destroys fixed position, danKexi takes crustaceous work, when orgnaization of nut of lever ofworkbench feed silk has space, workbench also won't change ismoved;

Arrange mill: Cutting ply from the biggest to 0, cutting tool servicelife is tall, it is good to already machined exterior quality,generation is perpendicular the milling component of force thatbe down, conduce to the fixed position clamp of workpiece, butcannot the workpiece with mill crustaceous belt, whenorgnaization of nut of lever of workbench feed silk has space,workbench may change is moved.

Divisional

1, suitable mill: The feed way of the direction of rotation of millingcutter and workpiece is same.

Arrange the limits of mill: Do not have when workpiece surfacecrustaceous, when orgnaization of machine tool feed does nothave clearance, should choose suitable mill.

Advantage: The quality of spare parts surface is good, toothwears away small.

Fit stuff: Alloy of heat-resisting of alloy of aluminum-magnesiumalloy, titanium.

2, go against mill: The feed way of the direction of rotation ofmilling cutter and workpiece is opposite.

Go against the limits of mill: When workpiece surface crusty,when the feed orgnaization of the machine tool has space,choose more go against mill.

Advantage: Tooth is from already machined the surface to be cut,won't die knife; The clearance of orgnaization of machine tool feed won't cause vibration and crawl.

Means choice

The power of suitable mill is used up should compare when going against mill small, below coequal cutting condition, suitable mill power is used up should low 5% ? 15% , arrange mill at the same time also more be helpful for discharging bits.

Answer to use treatment of suitable mill law as far as possible commonly, be machined in order to rise of spare parts surface bright and clean degree (reduce surface roughness) , assure dimension precision. But there is horniness layer on cutting face, indigestion surface of broken bits, workpiece is uneven more remarkable when, forging like treatment semifinished product, should use the method that go against mill.

When suitable mill, cutting by thick attenuate, tooth is cut from raw surface, advantageous tothe