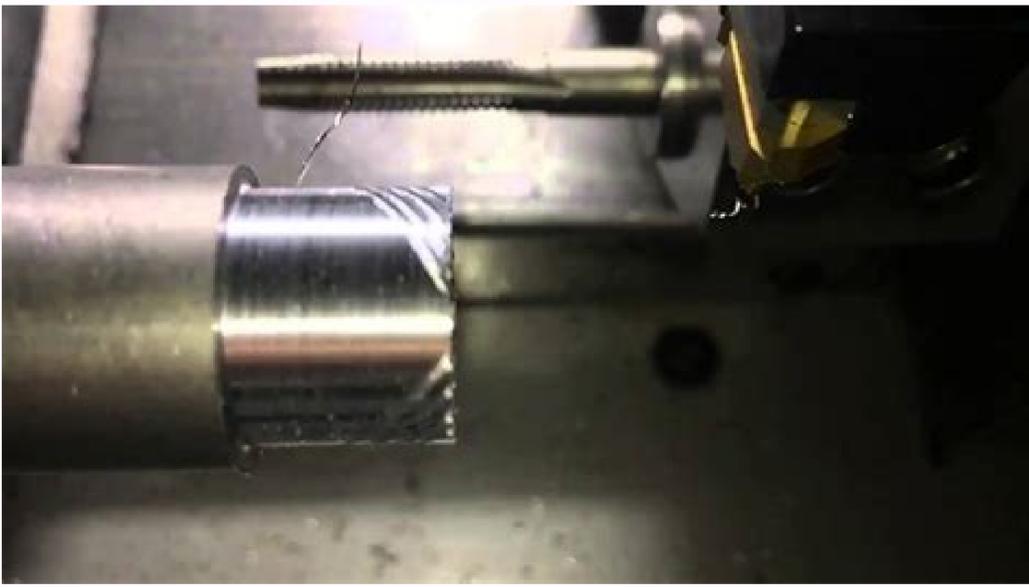


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Knurling operation on lathe machine pdf. Lathe knurling operation.

We can do different operations in the work of the lathe. How many types of moms -hurts exist? Thread cutting tool. Machining Time for 1000 Work Peans = 1000 ÷ min Não Re -Penings = / 4.28 = or 33 reshapenings 67 Example 6: When turning a carbon cylinder bar length 3 0.2 m at a food rate of 0.5 mm /revolution with a HSS tool, one of the two displayable cutting speeds must be selected. Tool turned. 1 turn. 35 grunt .. cilandric work 28 turning. Different types of lathe cutting tools - Turning Tool. Therefore, the list of operations to be performed at work is rotating, turned, cut, grooving and step, 74 example, a possible sequence to produce the component would be: turning (completely reducing to 50 mm) length to 160 mm) Step spin (reducing from 50 mm to 40 mm) thread cut. Boring bar. 40 Chamomial operations at lathe. Rasper round nose. 4 around 5 around the head of the tail of the tail of the fela bed/lead screw screw 6 types of lap around around around lathe around lathe around around with Camero € ; 7 Size of the work of work with work length 8 lathe size. 71 Example Write the sequence of the process to be used to manufacture the component from the Mattanal -175 mm long and 60 mm in Dial 72 Example 73 Example for writing the process sequence, list the operations to be executed. What are the types of moms -it hurts? The component shown in Figure 5.23 is having a larger 50 mm dial, 40 mm stage, 20 mm grooving and threading died for a length of 50 mm. The Mattão © ria It is size 175 mm in length and 60 mm in dialing. Produces a grooving in the work form of the tool ã ¢ Å ° of the groove using the grooving tool Å Å ° a formal form also called the formulatory rotating 37 grooving Machining time to reduce the rod to 45 mm in a passage when the cutting speed is 30 m/min and a 0.7 mm/relay feed. The work is turned to 440 rpm, the food is 0.3 mm/rec and the mox depth of cutting 2 mm. This is, 1 = 25 mm. Gear shaper. They maintain the basic characteristics of their nineteenth -grade ancestors and the Upon of the XX SOUND and are still classified as one of the following: (1) Turning Mothers (Torns and Boring Fabrics) , (2) modelers and planners, (3) drilling moms, (4) grinding moms, (5) grinding moms, (6) energy mountains and (7) presses . This is $f = 200/500 = 0.4$ mm/rev from equation (4), $mrr = 3.142\pi^2 \epsilon o (8)$, $t = 150/(0.4\pi^2 00) = 0.75$ min. Cutting the work of a work tool for two things for grooving - hackinging - the tool increases - in slow diet slow use 39 parting. The cutting tool that works in the material is assembled and driven in axes. Chamfer tool. A lathe is a Mother -Motormot -Mainly used to shape metal, wood or other materials, making the work of being maintained and turned around, while a tool bit is avanh at work, causing cutting action. 41 operations of chamfer at lathe. Since the mox depth of cut is 2 mm, 5 mm can not be cut into a passage. Milling man. The axis rotates at 500 rpm and the tool is traveling at an axial speed of 200 mm/min. Machining Time: = 3.74 minutes 54 Example Determine the oklet in which composite rest would be rotated to cut a cone into a work with a length of 150 mm and 80 mm external dial. Rest constant rest follower Rest 16 operating/cutting the listening speed v food f cut depth d 17 Conditions 18 Cutting Speed Operation Conditions. What is meant by canned cycle? Therefore, we calculate the number of necessary cuts or passes. Time to rotate the length of work lj mm/feef f mm/rev work velocity n rpm f n mm/min 50 manufacturing time operations at lathe. a cut = 1 / (fan of) Total turning time = (l / (fan ã ¢ ã n)) NO CUTS = (175 / (0.3\pi^2 440)) = min. Separation tool. 57 Example Data Data: Lj = 150 mm, d1 = 12 mm, d2 = 10 mm, n = 500 rpm/using equation (1) $v = \pi \cdot d \cdot n$ tra 500 /1000 = m / min. Rotating grooving grooving of grooving decreasing decrease in drilling thread 26 turning operations at lathe. Turning overdone: 43 Giro. The life of the corresponding tool is a speed of 100 m/min is known for 16 minutes with n = 0.5. The cost of machining, configuration time and unproductive time together is RS.1/s. 62 Example of time to face: Now, the work diary is reduced to 50 mm. separation tool. Especially the simple mandabulas we can do in the Machine -Larning Office. Avoid unintended borders of borders not similar to forming a turning chamfer tool - 45 ° to avoid sharp edges facilitate assembly to improve the staff 42 operation at lathe. All in conception form tools that include compound reduction of the rest of the remaining decrease in simultaneous and intersected turnion toper. . What is a lathe turning tool? Chisel Oval Skew. Hobbing mom. Steps: Operation sequence tools Process 48 Process sequence. This cycle simplifies the program using a block with a CODE G to specify the machining operations usually specified in blocks. How many times do we have to bake or remember, if 1000 work parts are produced. X x x 49 on the lathe. Grooving operation. The cost of The tool re-hahapening is RS.20. By operation tool operations at lathe .. spinning - turned - sip - kneading - sip - turning - turning - sip - knurling - spinning gruinando - turning back - spinning - turning - facing what is An ideal sequence? Operation conditions. 45 Running turning, by composite restoration in the operation of the lathe. Work mandreis (work) with a hole 15 work retention devices. Chucks Trown from the four centers of work devices. 60 Example Data Data: Lj = 170 mm, d1 = 60 mm, d2 = 50 mm, n = 440 rpm, f = 0.3 mm/rec, d = 2 mm, how to calculate the machining time when more than more than an operation? Final Mother of Work Å ° ° ° Flat surface to reduce the length of working tool feeding: in the direction perpendicular to the work of the work of the work tool = Radius of the depth of the work peach: in the direction parallel to the axis of the work 31 face. What is PDF of the lathe? Operations at lathe .. What are the 7 types of moms -tools? The main parts of the lathe are: headstock: the head is usually located on the left side of the lathe and is equipped with gears, axes, chucks, gear speed control levers and food controllers f o . Dimensional consistency replacing the MRR units: D F N ã ¢ ° (mm) (mm) (mm/rel) (Rev/min) = mm3/min 25 Operations in lathe operations. Taylor Ady Å s Use the constants as n = 1.2 and c = 180 65 Example Dated D = 10 mm, n = 1000 rpm, v = 31.41 m/minute of the Life of the tool of the tool Taylor, we have vt n = c replacing the values we get, (31.40) (t) 1.2 = 180 or t = 4.28 min 66 Example of machining time / peãsa = L / (fan of) = 100 / (0.7\pi^2 1000) = minute. These two cutting speeds are 100 m/min and 57 m/min. Time Fabrication = Machining Time + Configuration Time + Movement Time + Waiting Time 51 Example A Soft Act Step with 50 mm DIATE and 500 mm long should be turned on a lathe. 32 Operations Excients of Turning Turning At around .. Bed: Carriage: lead screw. 36 Operations of grooves around. 59 Example Calculate the necessary time to machine a work with 170 mm long, 60 mm of diary to 165 mm in length of 50 mm in diameter. Replacing in equation 8, we get $t = 25/(0.3\pi^2 440) = 0.18$ min. 64 Example of a 100 mm long and 10 mm dial -meter, a component with a 100 mm length and diatro 8 mm should be produced using a m/min cutting speed and a rate of Food of 0.7 mm/revolution. Thinning gouge. Improve. Serrilla tool. MOTHER -CORMING OF PURPOSE. Operation focused on operation. Prove your argument. 38 farewell operations at lathe. Clear or straight turning. NO REQUIRED RESERPENING = 37.7 / 16 = 2.35 or RESARPENINGS = 2 69 EXAMPLE OF TOTAL COST = Machining Cost + Cost of Remittances ã ã ã Number of reshaping = 37.7 60\pi^2 1 + 20\pi^2 2 = rs. 2302 70 Example Consider the speed of 57 m/minute of Taylor Expression T2 = T1 ã (V1/V2) 2 With usual notes = 16 ã^2 (100/57) 2 = 49 minutes repeating O Same procedure we obtain t2 = 66 minute, number of relegation = 1 and total cost = RS The cost is lower when the speed = 100 m/minute. CILANDRIC WORK 27 ã ¢ 20 TURNING . EXAMPLES OF MOTHERS -SREMAN MOTHERS: BROKE MOTHER. Flat Superphyte/Reduction in length 30 turned. Cut depth = d = (12 ¢ aferences 10)/2 = 1 mm 58 Example of food rate = 200 mm/min, we get the feed f into mm/rel by dividing the feed rate Is dividing the feed rate by axis RPM. It is commonly used in the mechanical field. Plustes knives 13 work work devices. So select 100 m/minute. 12 Work ownership devices. For each work of the work (mm/rel) 20 depth of cutting operational conditions. Perpendicular distance between machined and without cuts of the work of work D = (d1 ¢ ã ¢ d2)/2 (mm) 21 3 operational conditions 22 selection of .. first, CNC means control computer rich and refers to a mother operated by a computer system. Mother's wheel. 68 Example Dated T1 = 16 minutes, v1 = 100 m/minute, v2 = 57 m/minute, d = 200 mm, l = 300 mm, f = 0.5 mm/ret consider speed of 100 m/minute n1 = (1000 ã ã ã V) / (ã ° ° ã ° d) = (1000\pi^2 100) / (Å RPM T1 = L / (Fan) = 3000 / (0.5 ã^2 159.2) = 37.7 minutes the life of the corresponding tool is a speed of 100 m / minute © 16 minutes. The image is available for download at high resolution by AT © 1920x1080. N (mm3/min) In terms of V mrr is given by $mrr = 1000 \cdot v \cdot f$ (mm3/min) 24 dimensional consistency, replacing Unitsmrr's operations at lathe. Assume the total approach and the distance of excess exchange as 5 mm for working operation. 52 Example Calculate the required axis speed as: n = 191 RPMgiven data: D = 50 mm, lj = 500 mm v = 30 m/min, f = 0.7 mm/rep replacing the values of v and d in calculating The axis velocity required AS: n = 191 rpm 53 Example Can a MOTHER have a speed of 191 rpm? What are the 5 main parts of the lathe? Possible operations operations at the lathe. Produce a textured superphyte for a decorative and/or functional loyalty tool, a process of formation mrr ~ 0.34 operations of lathes. of work (work) with Holework owned devices. The smallest dial -up at the craft end of the rod shall be 50 mm and the necessary length of the central porcan is 80 mm. Screwed moms. 55 Example Data Data: D1 = 80 mm, d2 = 50 mm, lj = 80 mm (with usual grade) be giratory at 10.62\pi 56 Example to 150 mm in length of 12 mm of stainless dial The rod should be reduced to a 10 mm diatic, connecting a lathe in a passage. 46 PERFORATION OPERATIONS at around .. DRILL - Tool - maintained in TS - Food of Process Sequence Operations © Ria -Prima 45 Long x 30 di. This cycle also called the fixed cycle. Which of the two cutting speeds above should be selected from the point of view of the total cost of the production of that part? Cutting Operation. Remember that in case of operations faced, the tool time of the tool is half of the workpiece. Mother -Special Proposal Installment. Serbutando operation. The reader must discover the total machining time if the first volume is done. San Tools are used in the turns to cut or end the external dictation of a workpiece .. cutting tool: the tooolexcess material is removed to reduce the tool DIATE CUTTING: The tool for turning a 1 mm cut depth reduce the dialing by 2 mm 29 flat surface/reduce volume operations in the lathe operation. The total work duration is 160 mm. What is CNC lathe mom? Polishing operation. Grooving tool. Calculate the cutting speed, the material removal rate and the necessary time for the machining of the ax rod. Example: 300 - 1500 LATHEMAXIMUM WORKING DIARY THAT CAN BE MANY = Swing (= 300 mm) MOTHERAL TURNING HELP.) 9 Safe or support with safety, while using equipment of machining fitting devices used ã ¢ ought to maintain the work - ã ¢ æMerrament of accessions - the templates hold or support with security A while machining 10 work retention devices. What is the operation of 12 lathe? Gouge of the bowl. What are the turning tools? 1 Turning Operations L and 2 Turning Operations Mother - Mother - LATHEJOB (WORKING PAIN) - ROTATING MOVEMENT Tool - Linear movements ¢ ã ferences of machine guns ã ã ferences ã Surfaces cilonndric and flat 3 some lathsturning/drilling/drilling/drill grooving/grooving/drilling/drilling/ Food rod. Drilling machine. Grooving a canned cycle is a combination of mothers of mothers that perform the operating of machining, such as perforation, grinding, boring and tapping. Types of Mother -Cremation: The Mother -Mother -Licenses Widely classified at Train Groups, and these are: Mother -Officers of General Use. This makes the work more fancil and simpler. 33 Operations of lathe cultivation ...

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