



D6

6-SN1454

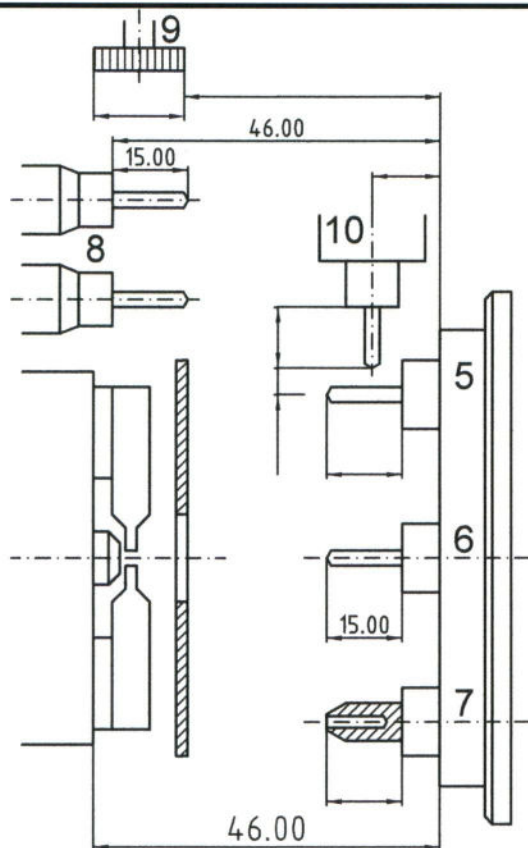
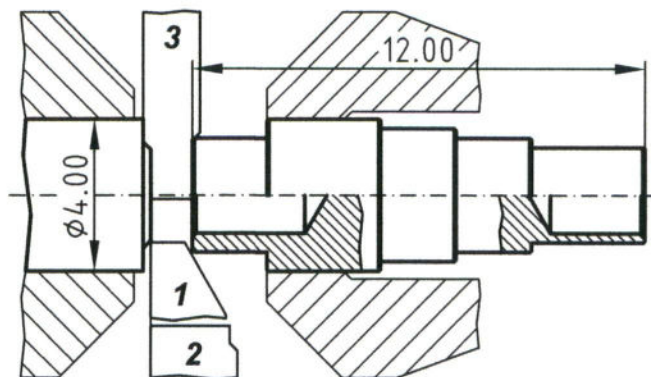
Pièce No. Ø 4.00 x 12.00

EXEMPLE

ESCOMATIC D6SR1A

CANON

CONTRE-PINCE



MATIERE: **LAITON 58A** ϕ 4.00

CAME DE REcul: **1.5°/1mm.**

TOURNAGE: **7'100 t/min.**

CENTRAGE - PERCAGE: **16'000 t/min.**

FILETAGE:

CONTRE PERCAGE D6-28: **16'000 t/min.**

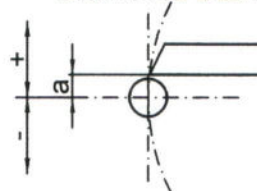
TRANSVERSAL D6-29:

FRAISAGE D6-15:

REDRESSAGE: **1'400 t/min.**

PRODUCTION: **12.50 p/min.**

DISTANCE DES BURINS EN FIN DE COURSE



BURIN No.1: **+ 1.25**

BURIN No.2: **+ 1.50**

BURIN No.3: **- 0.10**

REMARQUES:

OUTIL 1: tourne ϕ 2.50 + ϕ 3.00 + ϕ 3.50

OUTIL 2: fonce ϕ 3.00

OUTIL 3: coupe

BROCHE 1: perçage ϕ 2.00

D6-28: perçage ϕ 2.00

INSTRUCTION DE REGLAGE

VIS No.

EQUIPEMENT No: **6-SN1454**

DESSIN No. ϕ 4.00 x 12.00

Date: 08.09.16

Rédigé: S. PETRUCCELLI



SPC TOOLING
ESCOMATIC SPECIALIST

LISTE DE PAQUETAGE D6SR1A

EQUIPEMENT: 6-SN1454		
PIECE No: ø 4.00 x 12.00		
MACHINE		
*	Machine	D6SR1A
*	Appareil de contre perçage à deux broches	D6-28
CAMES		
2	Cames d'avance	
1	Came de recul 1.5°/1mm	
1	Came outil No.1	
1	Came outil No.2	
1	Came outil No.3	
1	Came de perçage broche No.2	
2	Cames de contre pince	
1	Came de nombrage D6-28	
OUTILS		
1	Burins No.1 (forme XY) H10F	
1	Burins No.2 (forme D) H10F	
1	Burins No.3 (forme DD) H10F	
1	Mèche (F4 - MD - ø 2.00 x ø 3.00 x 30.00 - P)	
1	Mèche (F4 - MD - ø 2.00 x ø 3.00 x 30.00 - P)	
OUTILLAGE		
1	Pince fixe ø 4.00	D6-12-663
1	Pince d'avance ø 4.00	D6-12-663
1	Canon de guidage ø 4.00	D6-12-M4
1	Contre pince ø 4.00	D6-12-1354
1	Extracteur	D6-12-1356
1	Ressort	D6-12-1357
1	Bouchon	D6-12-1355
2	Pinces pour centreur ø 3.00	D6-12-1681
1	Jeu de portes canons rotatifs de redressage	D6-14-M136-A1-3
1	Jeu de canons rotatifs de redressage	D6-14-1697-5

* Outillage du client

Date: 22/06/2018

Diagramme: 6-SN1454

CAO-WinCalcam: SPC TOOLING Srl

Nom du diagramme: 6-SN1454 Modif. tech.: SANDRO PETRUCCELLI
 Date: 08.09.2016 Nom pièce:
 Client: SPC Dessin no: Ø 4.00 x 12.00
 Type de machine: D6SR1A Matière: LAITON 58A
 Appareil de perçage: REV-D6R
 Appareils simples: [] [C] CP-D6SR
 [] [c] CP-D6SR
 [] [n] D6-28

Commentaires:

OUTIL 1: TOURNE Ø 2.50 + Ø 3.00 + Ø 3.50
 OUTIL 2: FONCE Ø 3.00
 OUTIL 3: COUPE
 BROCHE 2: PERCAGE Ø 2.00
 D6-28: PERCAGE Ø 2.00

Rapport Avance:	1 / 1.00	Rapport broche 2:	1 / 1.00
Rapport bascule 1:	1 / 5.00	Rapport appareil 2:	1 / 1.00
Rapport bascule 2:	1 / 5.00	Rapport appareil 4:	1 / 1.00
Rapport outil 3:	1 / 5.00	Rapport appareil 6:	1 / 1.00

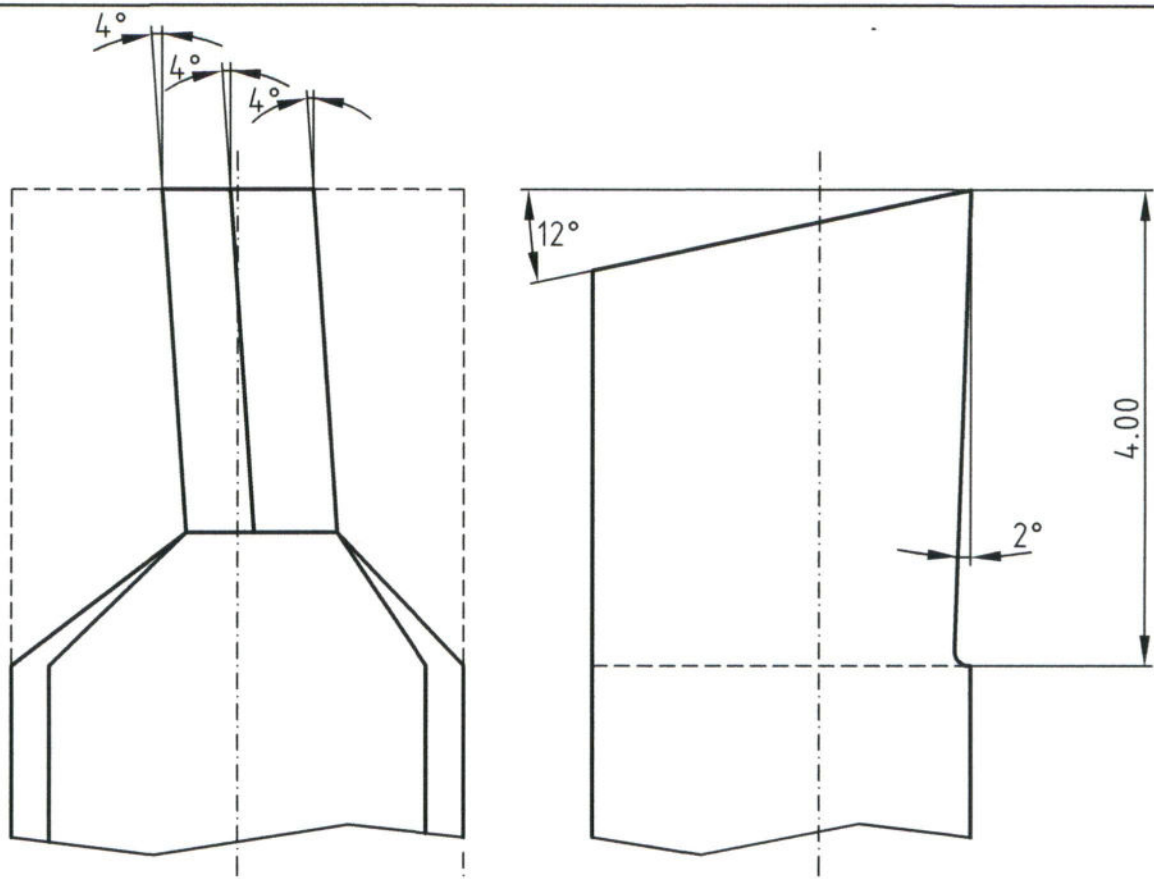
1:Ø 12.000 2:Ø 12.000 C:Ø -0.200 Ø MAT.: 4.000 [4.000]
 V.: 89.2 Rotation: 7100 Production: 12.50

NO.	OP.	OPERATION	Commentaire	DECAL.	AUX.	Ø-H/P	/PIECE	/CAME	COPEAU	TOURS	DEGRES	Du de.	Au de.
1 a0	.RE	REPOS									1	0	1
2	.E2	ENTREE 2				Ø 4.100	3.950	19.750			4	(1	5)
3	.A2	AVANCE 2	FONCAGE Ø 3.00			Ø 3.200	0.450	2.250	0.0250	18	11	(5	16)
4	.A2	AVANCE 2	FINITION			Ø 3.000	0.100	0.500	0.0100	10	6	(16	22)
5	.RE	REPOS									2	(22	24)
6	.R2	RECU 2	FACE			Ø 4.100	-0.550	-2.750	0.0400	13	8	(24	32)
7	.S2	SORTIE 2				Ø 12.000	-3.950	-19.750				(32	32)
8	.RE	REPOS									2	(32	34)
9	.AMR	AVANCE MATIERE R.				1.000	1.000	1.000			4	(34	38)
10 a1	<EC	ENTREE C					31.000	31.000	40.0000		40	(1	41
11	<FPC	FERME CONTRE PINCE		0.000		0.000					8	(41	49)
12 a2	.FP1	FERME PINCE FIXE		0.000		0.000					8	(41	49)
13	.OP2	OUVRE PINCE AVANCE									8	(49	57)
14	.RAV	RECU MATIERE R.			1.100	12.000	-13.100	-13.100			20	(57	77)
15	.FP2	FERME PINCE AVANCE		0.000		0.000					8	(77	85)
16 a3	.E3	ENTREE 3				Ø 4.100						(49	49)
17	.A3	AVANCE 3	COUPE 1			Ø	2.050	10.250	0.0350	58	37	49	86

NO.	OP.	OPERATION	Commentaire	DECAL.	AUX.	Ø-H/P	/PIECE	/CAME	COPEAU	TOURS	DEGRES	Du de.	Au de.
18	.A3	AVANCE 3	COUPE 2			Ø -0.200	0.100	0.500	0.0100	10	6	86	92
19 b0	.RE	REPOS									2	92	94
20	.R3	RECU 3	FACE			Ø 2.500	-1.350	-6.750	0.0600	22	14	(94	108)
21	.S3	SORTIE 3				Ø						(108	108)
22	.OP1	OUVRE PINCE FIXE									8	(108	116)
23 b1	<SC	SORTIE C					-31.000	-31.000	21.0000		21	94	115
24	=N1	NOMBRAGE 1			2.000						48	115	163
25	*EB2	ENTREE BROCHE 2			0.000	0.000	16.000	16.000			21	163	184
26	*V	VITESSE ROT.			16000.0						0	(184	184)
27	*AB	AVANCE BROCHE	PERAGE 1				0.800	0.800	0.0300	26	7	184	191
28	*AB	AVANCE BROCHE	PERAGE 2				2.300	2.300	0.0500	46	13	191	204
29	*AB	AVANCE BROCHE	PERAGE 3				0.100	0.100	0.0100	10	3	204	207
30	*RE	REPOS									2	207	209
31 c0	*RBR	RECU BROCHE R.					-5.200	-5.200			5	209	214
32	*SB2	SORTIE BROCHE 2					-14.000	-14.000			10	(214	224)
33 c1	.E1	ENTREE 1				Ø 2.500	4.750	23.750				(214	214)
34	.RE	REPOS									2	214	216
35	.V	VITESSE ROT.			7100.0						0	(216	216)
36	.AM	AVANCE MATIERE	TOURNAGE Ø 2.50			3.000	3.000	3.000	0.0536	56	36	216	252
37	.RE	REPOS									2	252	254
38	.R1	RECU 1	FACE			Ø 2.900	-0.200	-1.000	0.0200	10	6	254	260
39	.RE	REPOS									2	260	262
40/	.AM	AVANCE MATIERE	CHANFREIN 45°		/ 45.00	3.050	0.050	0.050	0.0085	8	5	262	267 /
41	.R1	RECU 1				Ø 3.000	-0.050	-0.250		8	5	(262	267)
42	.RE	REPOS									2	267	269
43	.AM	AVANCE MATIERE	TOURNAGE Ø 3.00			5.000	1.950	1.950	0.0591	33	21	269	290
44	.RE	REPOS									2	290	292
45	.R1	RECU 1	FACE			Ø 3.400	-0.200	-1.000	0.0200	10	6	292	298
46	.RE	REPOS									2	298	300
47/	.AM	AVANCE MATIERE	CHANFREIN 45°		/ 45.00	5.050	0.050	0.050	0.0100	7	5	300	305 /
48	.R1	RECU 1				Ø 3.500	-0.050	-0.250		7	5	(300	305)
49	.RE	REPOS									2	305	307
50	.DM	DEGRES MATIERE	DEPART 2EME CAME								0	(307	307)
51	.AM	AVANCE MATIERE	TOURNAGE Ø 3.50			7.000	1.950	1.950	0.0591	33	21	307	328
52	.RE	REPOS									2	328	330
53	.R1	RECU 1	FACE			Ø 3.900	-0.200	-1.000	0.0200	10	6	330	336
54	.RE	REPOS									2	336	338
55/	.AM	AVANCE MATIERE	CHANFREIN 45°		/ 45.00	7.100	0.100	0.100	0.0100	14	9	338	347 /
56	.R1	RECU 1				Ø 4.100	-0.100	-0.500		14	9	(338	347)
57	.S1	SORTIE 1				Ø 12.000	-3.950	-19.750				(347	347)
58	.RE	REPOS									2	347	349
59 e0	.AMR	AVANCE MATIERE R.				12.100	5.000	5.000			10	349	359

NO.	OP.	OPERATION	Commentaire	DECAL.	AUX.	Ø-H/P	/PIECE	/CAME	COPEAU	TOURS	DEGRES	Du de.	Au de.
60	<Ec	ENTREE c					20.000	20.000	26.0000		26	(163	189)
61	<V	VITESSE ROT.			16000.0						0	(189	189)
62	<Ac	AVANCE c	PERCAGE 1				0.800	0.800	0.0300	26	8	(189	197)
63	<Ac	AVANCE c	PERCAGE 2				2.900	2.900	0.0500	58	17	(197	214)
64	<Ac	AVANCE c	PERCAGE 3				0.100	0.100	0.0100	10	3	(214	217)
65	<RE	REPOS									2	(217	219)
66 d0	<RcR	RECU c R.					-3.800	-3.800			4	(219	223)
67	<Sc	SORTIE c					-20.000	-20.000	14.0000		14	(223	237)
68 d1	<En	ENTREE n					20.000	20.000	26.0000		26	(223	249)
69 d2	<OPC	OUVRE CONTRE PINCE	EXTRACTION PIECE								10	(249	259)
70	<Sn	SORTIE n					-20.000	-20.000	14.0000		14	(259	273)
71 d3	=N2	NOMBREG 2			2.000						49	(259	308)
72 e1	=RE	REPOS									1	(359	360)
73	=V	VITESSE ROT.			7100.0						0	(360	360)

Tours productifs: 361.31
 Degrés productifs: 229.00
 Degrés improductifs: 131.00
 Tours pour 360°: 568.00
 Production calculée (ppm): 12.50



Pince
Zange
Collet
Pinza

Canon
Buchse
Bush
Bussola



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BURIN
DREHSTAHL
TOOL
UTENSILE No. 1

ECH: 20:1
10:1

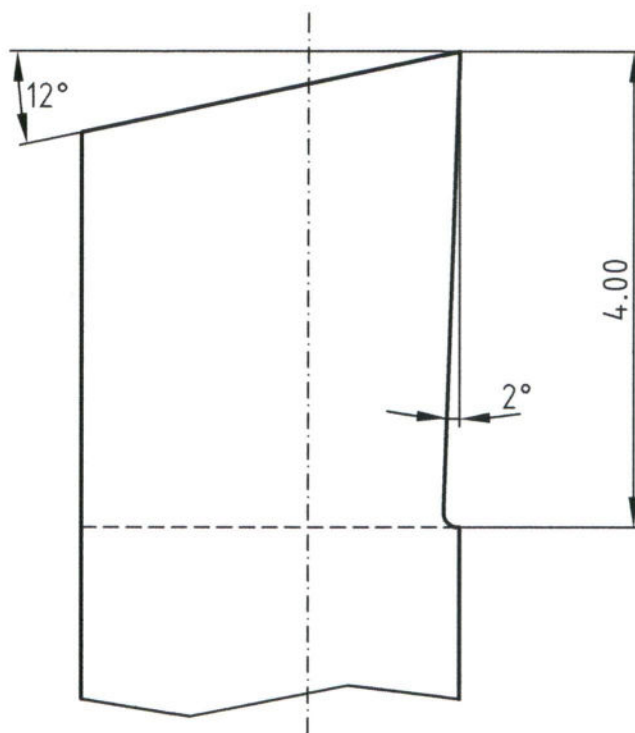
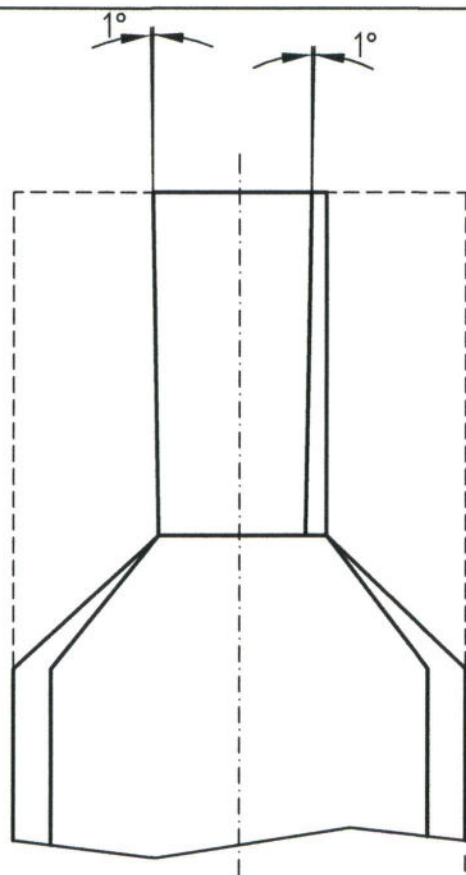
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Matière H10F

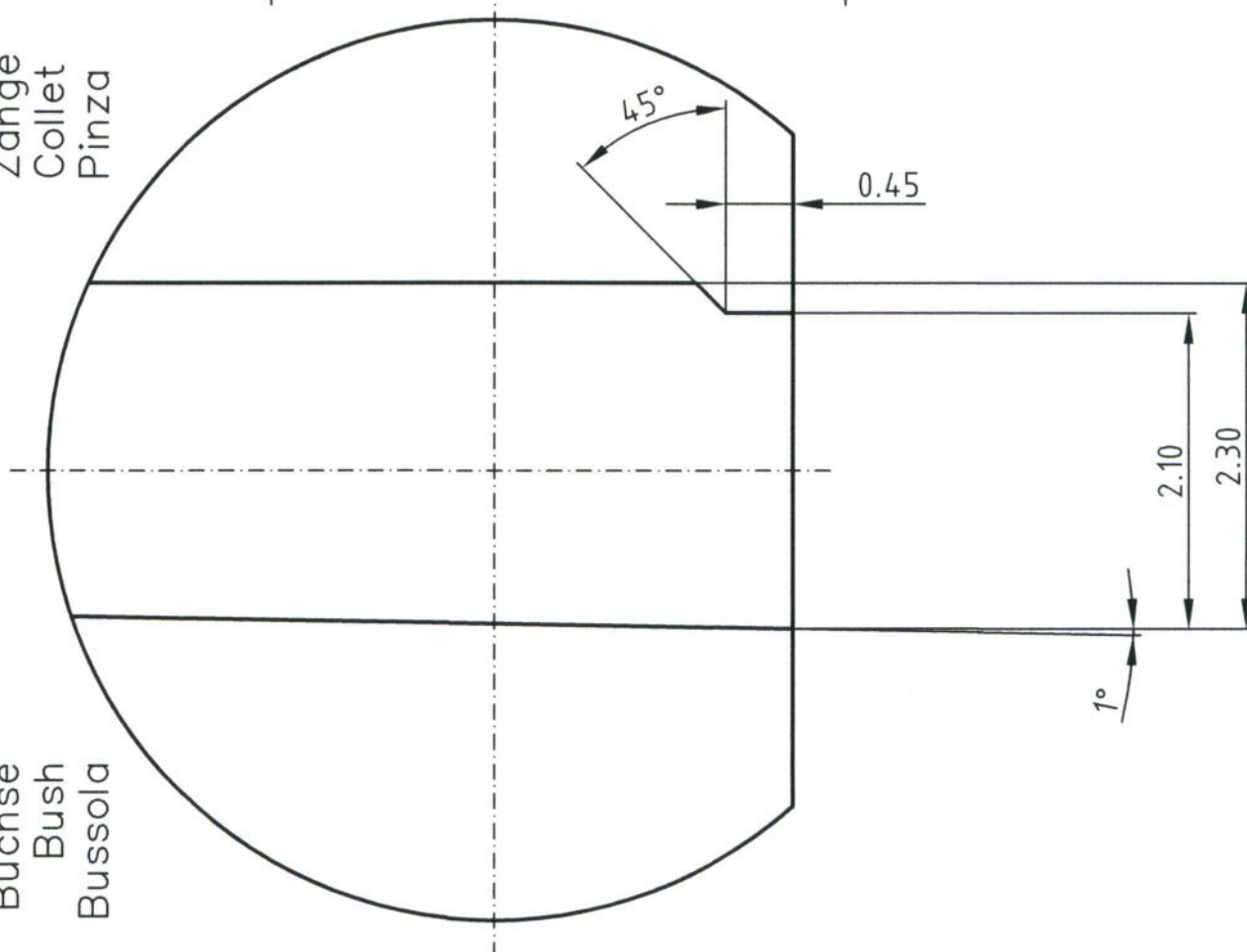
Date 08.09.16

Dessiné Petruccelli

No. 6-SN1454



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Pinza



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BURIN
DREHSTAHL
TOOL
UTENSILE

No. 2

Forme: D

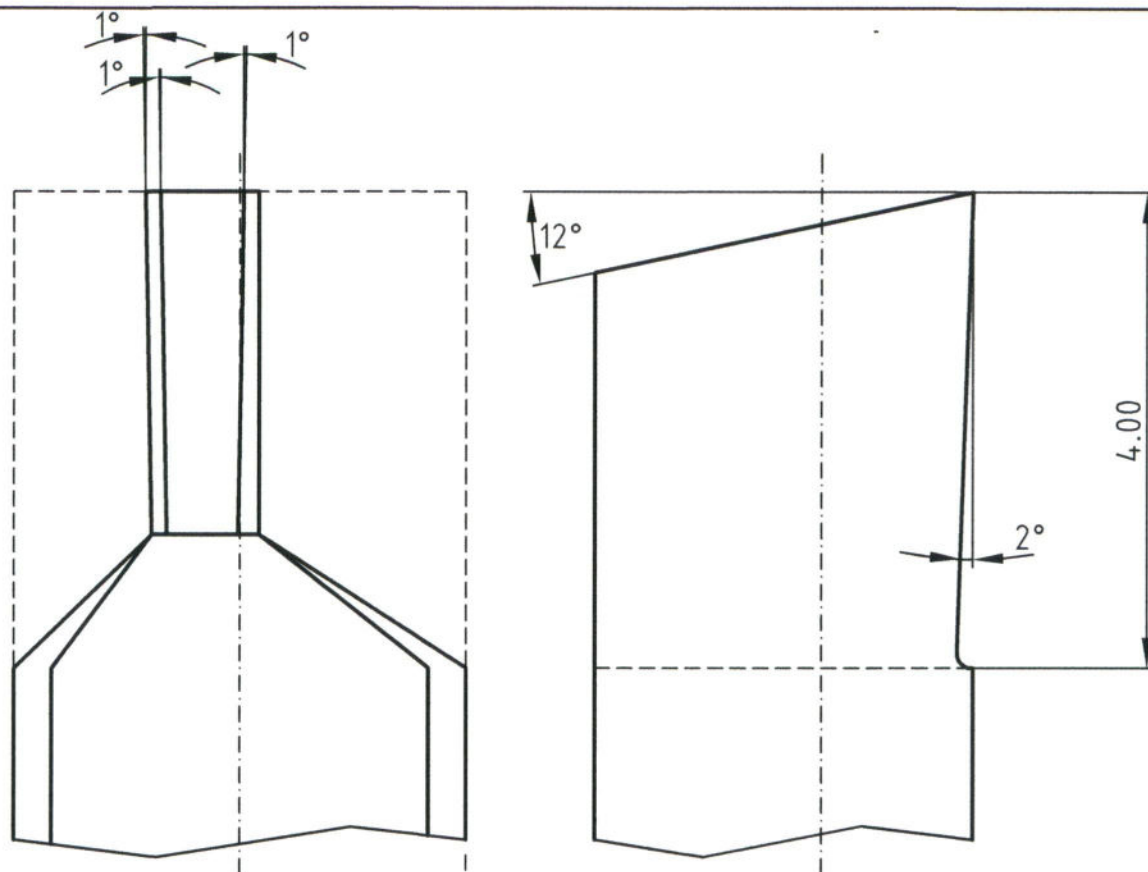
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Date 08.09.16

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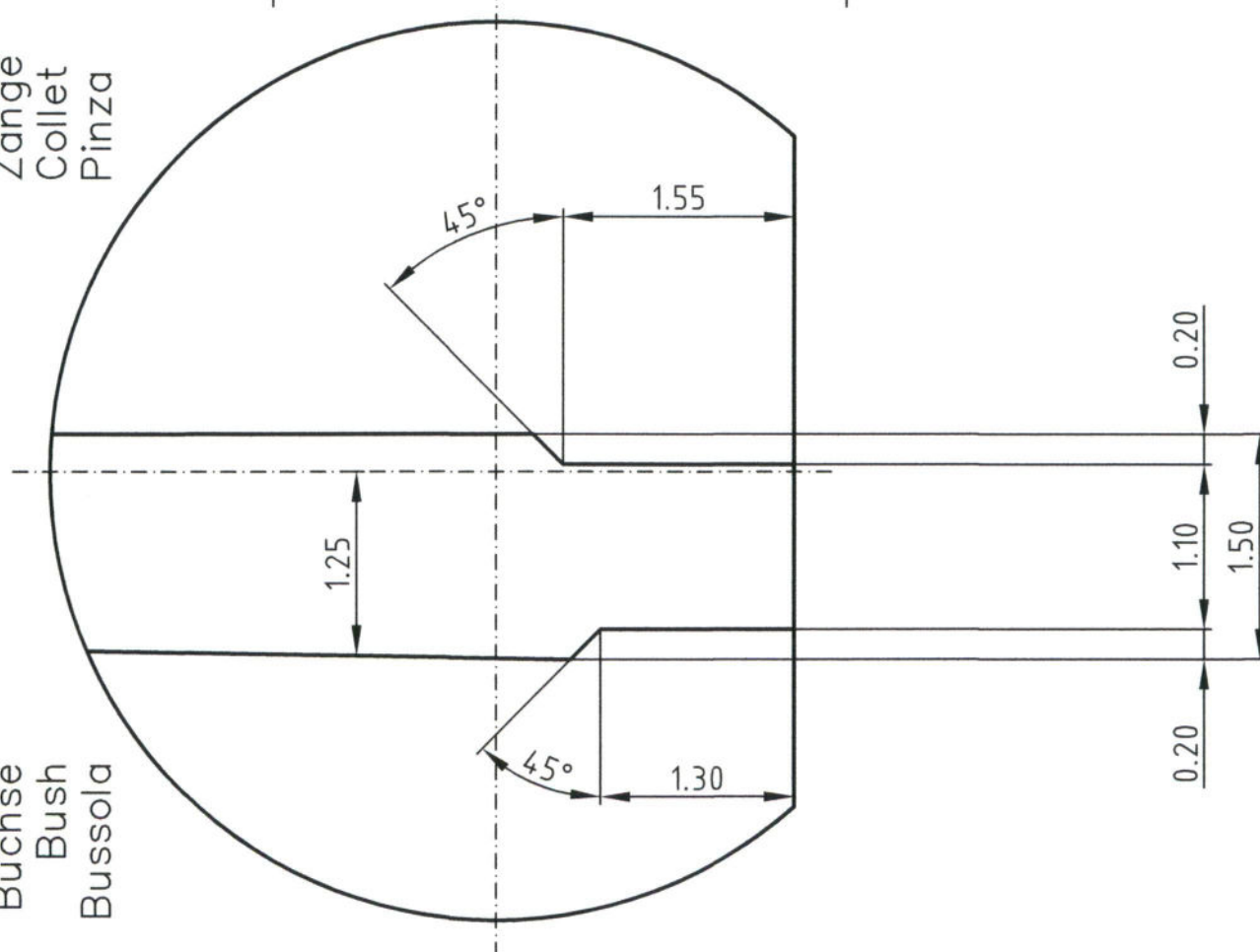
ECH: 20:1
10:1

No. 6-SN1454



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BURIN
DREHSTAHL
TOOL
UTENSILE

No. 3

ECH: 20:1
10:1

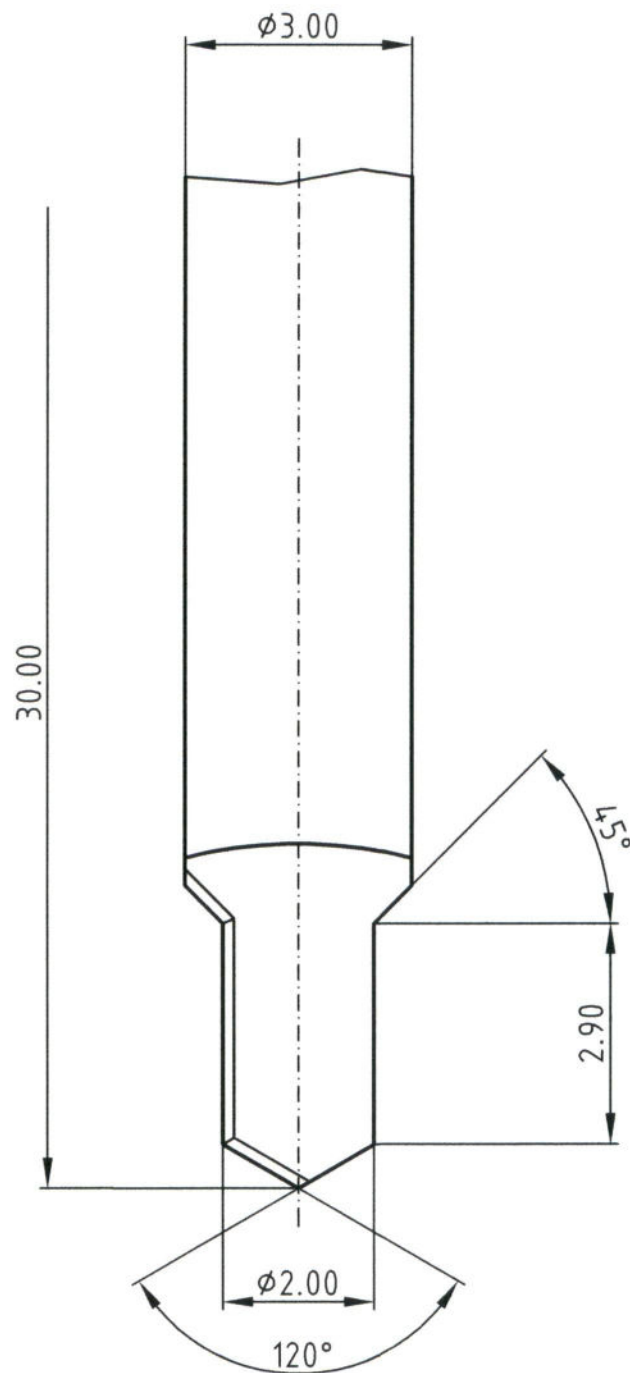
Forme: DD

Matière H10F

Date 08.09.16

Dessiné Petruccelli

No. 6-SN1454



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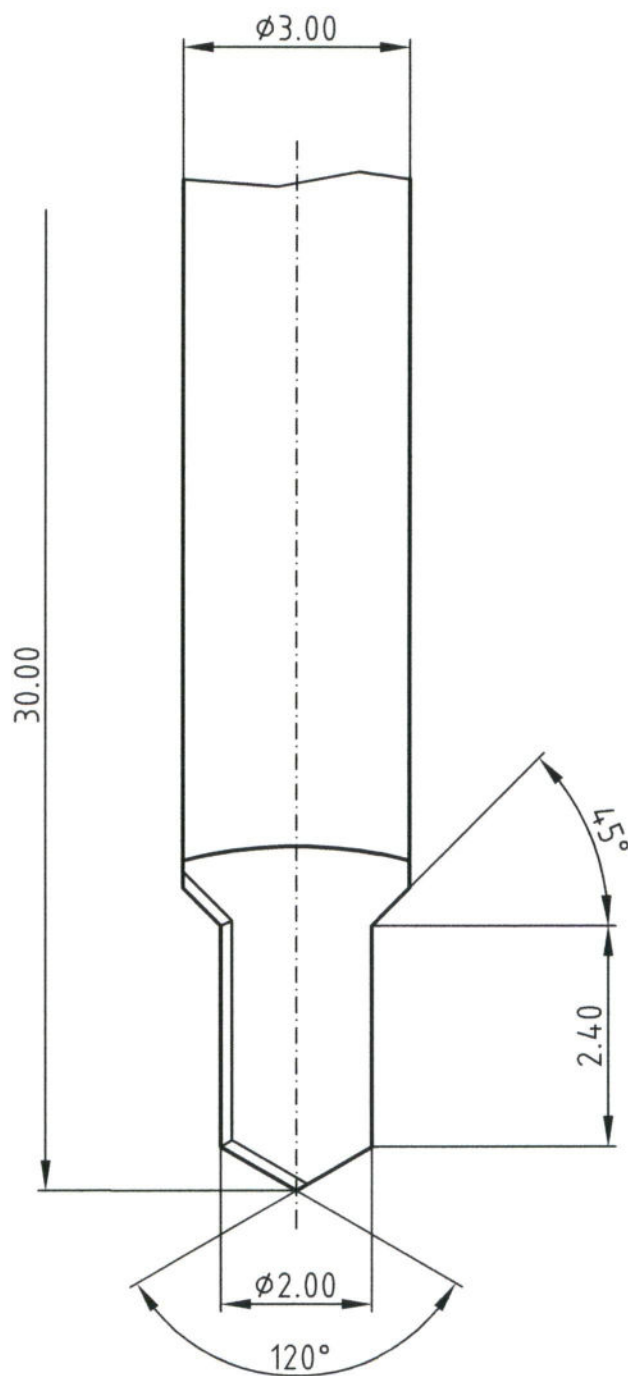
Mèche metal dur
F4

ECH: 20:1
10:1

Coupe pour:
LAITON

No. 6-SN1454

Date	08.09.16
Dessiné	Petrucelli



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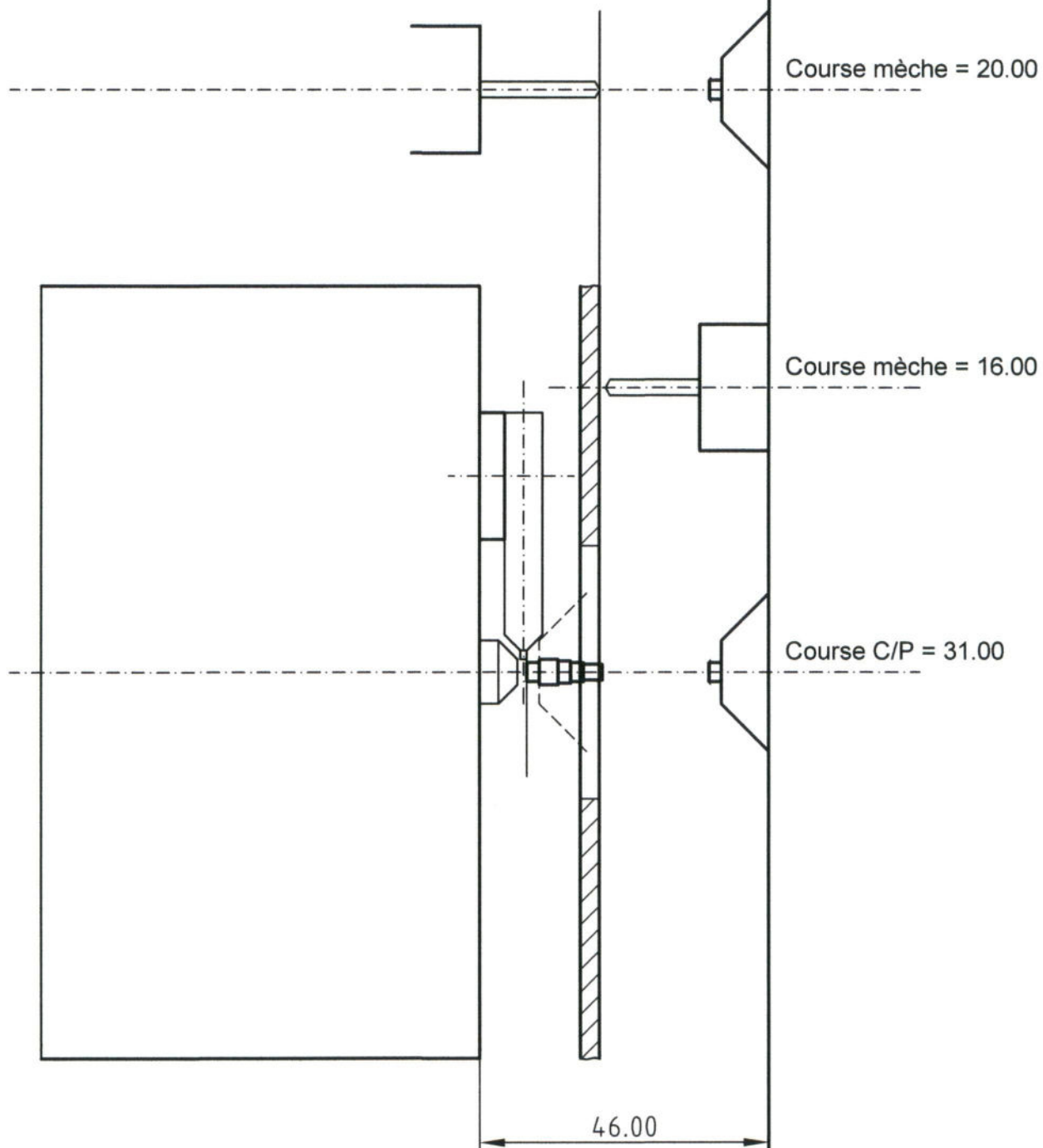
Mèche metal dur
F4

ECH: 20:1
10:1

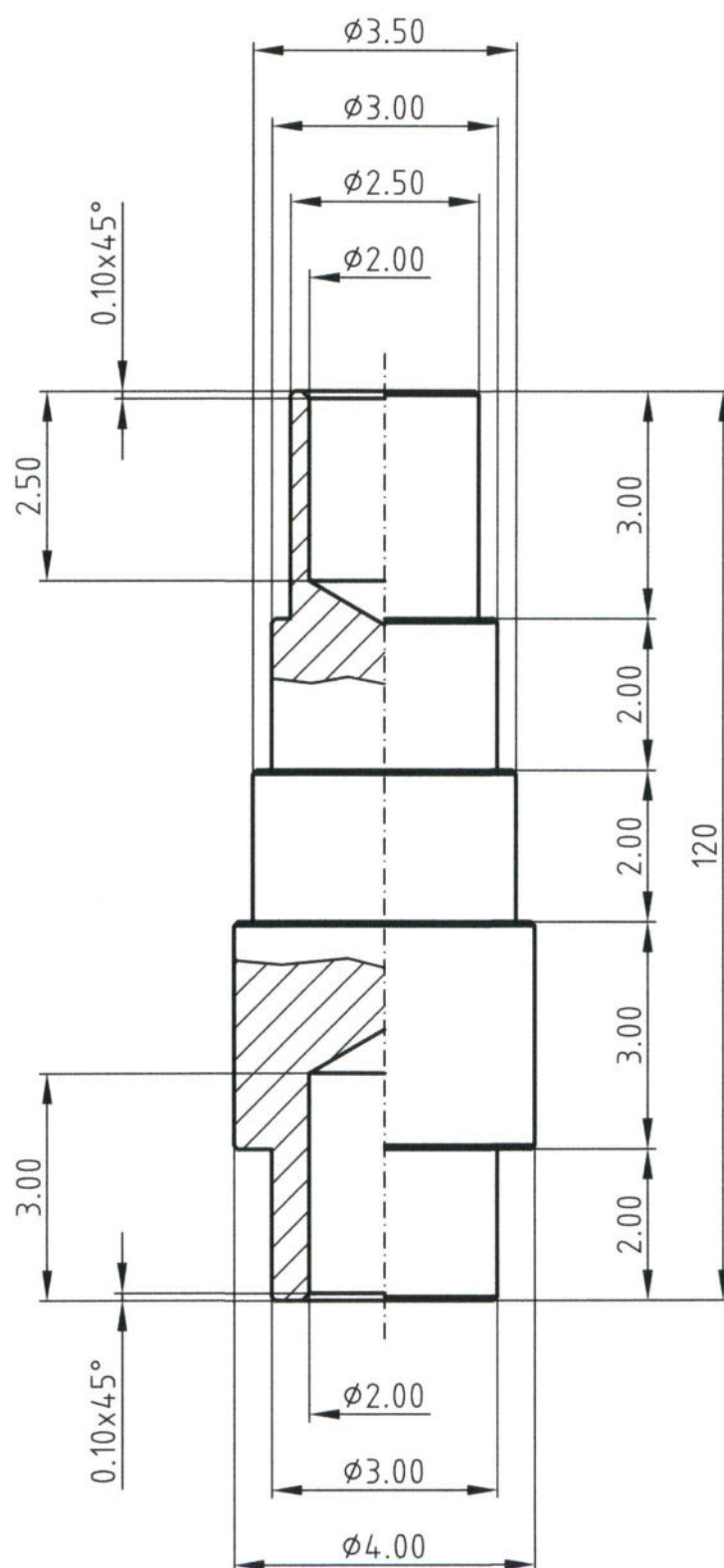
Coupe pour:
LAITON

No. 6-SN1454

Date	08.09.16
Dessiné	Petrucelli



6-SN1454



Anglé 0.05 x 45°



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Matière: LAITON 58A

Date 08.09.16

Dessiné Petruccelli

ECH: 10:1

$\varnothing 4.00 \times 12.00$