

# D6

## 6-SN1454

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Part No. 400-1200-L

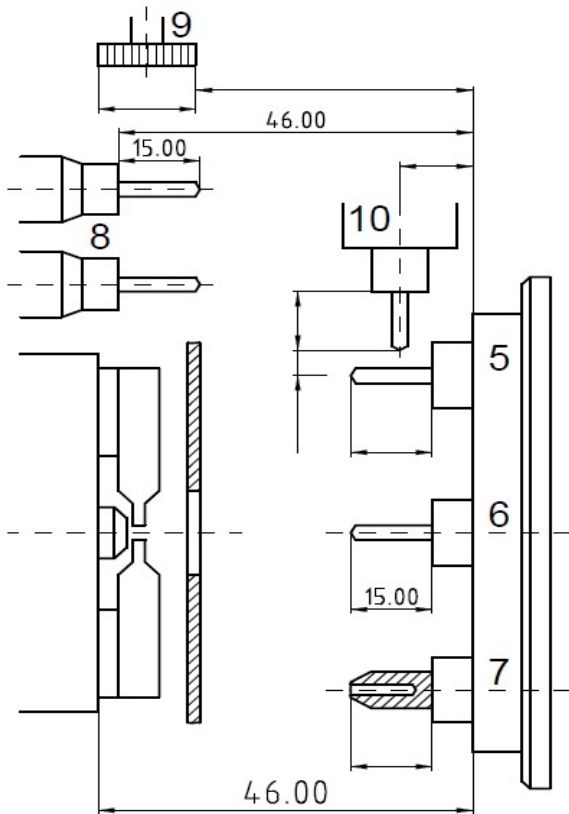
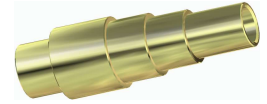
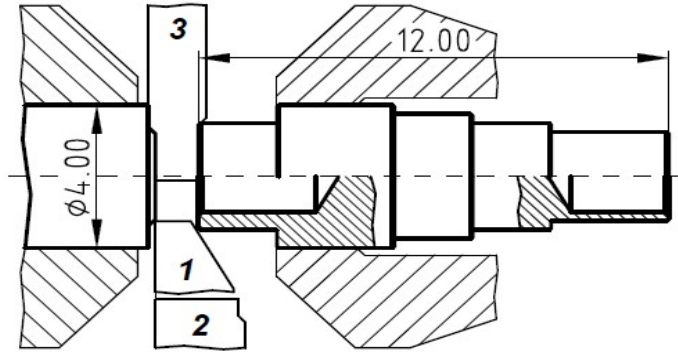
**DEMO**



# ESCOMATIC D6SR1A

GUIDE BUSH

COUNTER COLLET



MATERIAL: **BRASS**  $\phi$  4.00

RETURN CAM: **1.5°/1mm**

TURNING: **7'100 r.p.m**

CENTERING - DRILLING: **16'000 r.p.m**

THREADING:

COUNTER DRILLING D6-28: **16'000 r.p.m**

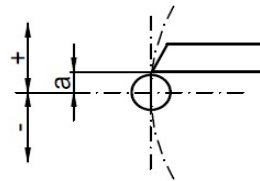
CROSS DRILLING D6-29:

MILLING D6-15:

STRAGHTENING: **1'400 r.p.m**

PRODUCTION: **14.00 p/min.**

DISTANCE OF TOOLS AT THE END OF WORK



TOOL No.1: **+ 1.25**

TOOL No.2: **+ 1.50**

TOOL No.3: **- 0.10**

REMARKS:

TOOL 1: turn  $\phi$  2.50 +  $\phi$  3.00 +  $\phi$  3.50

TOOL 2: cut  $\phi$  3.00

TOOL 3: cut off

SPINDLE 1: drilling  $\phi$  2.00

D6-28: drilling  $\phi$  2.00

SETTING INSTRUCTIONS

SCREW No.

SETTING INSTRUCTIONS	SCREW No.

LAYOUT No: 6-SN1454

DRAWING No. 400-1200-L

Date: 01.02.2025

Calculated: S. PETRUCELLI



**SPCTOOLING**  
ESCOMATIC SPECIALIST

# PACKING LIST D6SR1A

<b>LAYOUT: 6-SN1454</b>		
<b>PART No: 400-1200-L</b>		
<b>MACHINE</b>		
*	Machine	D6SR1A
*	Counter drilling attachment	D6-28
<b>CAMS</b>		
2	Feed cams	
*	Return cam 1.5°/1mm	
1	Tool cam No.1	
1	Tool cam No.2	
1	Tool cam No.3	
1	Cam for spindle No.2	
2	Counter collet cams	
1	Cam for indexing D6-28	
<b>TOOLS</b>		
1	Tools No.1 (form 40) Micro 100	
1	Tools No.2 (form 60) Micro 100	
1	Tools No.3 (form 63) Micro 100	
1	Drills F4 - MD - ø 2.00	
1	Drills F4 - MD - ø 2.00	
<b>TOOLING</b>		
1	Steady collet ø 4.00	D6-12-663
1	Feed collet ø 4.00	D6-12-663
1	Guide bush ø 4.00	D6-12-M4
1	Counter collet ø 4.00	D6-12-1354
1	Ejector	D6-12-1356
1	Spring	D6-12-1357
1	Plug	D6-12-1355
2	Collets for drills ø 3.00	D6-12-1681
1	Set of rotating bush holders	D6-14-M136-A1-3
1	Set of rotating bushes	D6-14-1697-5

\* Tooling from customer

## CAO-Calcam: SPC TOOLING

Layout name: 6-SN1454 Technical change: SANDRO PETRUCCELLI  
Date: 01.02.2025 Part Name:  
Customer: DEMO Drawing No: 400-1200-L  
Machine type: D6SR1A Material: BRASS 58A  
Drill attachment: REV-D6R  
Attachments: [ ] [C] CP-D6SR  
[ ] [c] CP-D6SR  
[ ] [n] D6-28

## Comments:

TOOL 1: TURN  $\varnothing$  2.50 +  $\varnothing$  3.00 +  $\varnothing$  3.50  
TOOL 2: CUT  $\varnothing$  3.00  
TOOL 3: CUT OFF  
SPINDLE 2: DRILLING  $\varnothing$  2.00  
D6-28: DRILLING  $\varnothing$  2.00

Feed ratio: 1 / 1.00 Drill ratio 2: 1 / 1.00  
Rocker ratio 1: 1 / 5.00 Att. ratio 2: 1 / 1.00  
Rocker ratio 2: 1 / 5.00 Att. ratio 4: 1 / 1.00  
Tool ratio 3: 1 / 5.00 Att. ratio 6: 1 / 1.00

1: $\varnothing$  12.000 2: $\varnothing$  12.000 Cut off.: $\varnothing$  -0.200  $\varnothing$  MAT. 4.000 [ 4.000]  
Cutting speed: 89.2 RPM: 7100 Production: 12.50

NO.	OP.	OPERATION	Comment	T. OFFS.	AUX.	$\varnothing$ -LEN.	/PART	/CAM	FEED	REVS	DEGREES	From .	To D.
1	a0	.DW	DWELL								1	0	1
2		.E2	ENTER 2			$\varnothing$ 4.100					4	( 1	5)
3		.A2	ADVANCE 2			$\varnothing$ 3.200	0.450	2.250	0.0250	18	11	( 5	16)
4		.A2	ADVANCE 2			$\varnothing$ 3.000	0.100	0.500	0.0100	10	6	( 16	22)
5		.DW	DWELL								2	( 22	24)
6		.R2	RETURN 2			$\varnothing$ 4.100	-0.550	-2.750	0.0400	13	8	( 24	32)
7		.O2	OUT 2			$\varnothing$						( 32	32)
8		.DW	DWELL								2	( 32	34)
9		.AMR	ADVANCE MATERIAL R.			1.000	1.000	1.000			4	( 34	38)
10	a1	<EC	ENTER C				31.000	31.000	40.0000		40	1	41
11		<CLC	CLOSE COUNTER COLLET	0.000		0.000					8	41	49
12	a2	.CL1	CLOSE STEADY COLLET	0.000		0.000					8	( 41	49)
13		.OP2	OPEN FEED COLLET								8	( 49	57)
14		.RFL	RETURN MATERIAL R.		1.100	12.000	-13.100	-13.100			20	( 57	77)
15		.CL2	CLOSE FEED COLLET	0.000		0.000					8	( 77	85)
16	a3	.E3	ENTER 3			$\varnothing$ 4.100						( 49	49)
17		.A3	ADVANCE 3			$\varnothing$	2.050	10.250	0.0350	58	37	49	86

NO.	OP.	OPERATION	Comment	T. OFFS.	AUX.	Ø-LEN.	/PART	/CAM	FEED	REVS	DEGREES	From .	To D.
18	.A3	ADVANCE 3	CUT OFF 2			Ø -0.200	0.100	0.500	0.0100	10	6	86	92
19	b0 .DW	DWELL									2	92	94
20	.R3	RETURN 3	FACE			Ø 2.500	-1.350	-6.750	0.0600	22	14	( 94	108)
21	.O3	OUT 3				Ø						( 108	108)
22	.OP1	OPEN STEADY COLLET									8	( 108	116)
23	b1 <OC	OUT C					-31.000	-31.000	21.0000		21	94	115
24	=I1	INDEX 1			2.000						48	115	163
25	*ED2	ENTER DRILL 2			0.000	0.000	16.000	16.000			21	163	184
26	*U	RPM			16000.0						0	( 184	184)
27	*AD	ADVANCE DRILL	DRILLING 1				0.800	0.800	0.0300	26	7	184	191
28	*AD	ADVANCE DRILL	DRILLING 2				2.300	2.300	0.0500	46	13	191	204
29	*AD	ADVANCE DRILL	DRILLING 3				0.100	0.100	0.0100	10	3	204	207
30	*DW	DWELL									2	207	209
31	c0 *RDR	RETURN DRILL R.					-5.200	-5.200			5	209	214
32	*OD2	OUT DRILL 2					-14.000	-14.000			10	( 214	224)
33	c1 .E1	ENTER 1				Ø 2.500						( 214	214)
34	.DW	DWELL									2	214	216
35	.U	RPM			7100.0						0	( 216	216)
36	.AM	ADVANCE MATERIAL	TURNING Ø 2.50			3.000	3.000	3.000	0.0536	56	36	216	252
37	.DW	DWELL									2	252	254
38	.R1	RETURN 1	FACE			Ø 2.900	-0.200	-1.000	0.0200	10	6	254	260
39	.DW	DWELL									2	260	262
40/	.AM	ADVANCE MATERIAL	CHAMFER 45°		/ 45.00	3.050	0.050	0.050	0.0085	8	5	262	267 /
41	.R1	RETURN 1				Ø 3.000	-0.050	-0.250		8	5	( 262	267)
42	.DW	DWELL									2	267	269
43	.AM	ADVANCE MATERIAL	TURNING Ø 3.00			5.000	1.950	1.950	0.0591	33	21	269	290
44	.DW	DWELL									2	290	292
45	.R1	RETURN 1	FACE			Ø 3.400	-0.200	-1.000	0.0200	10	6	292	298
46	.DW	DWELL									2	298	300
47/	.AM	ADVANCE MATERIAL	CHAMFER 45°		/ 45.00	5.050	0.050	0.050	0.0085	8	5	300	305 /
48	.R1	RETURN 1				Ø 3.500	-0.050	-0.250		8	5	( 300	305)
49	.DW	DWELL									2	305	307
50	.DM	DEGREES MATERIAL	START 2ND CAM								0	( 307	307)
51	.AM	ADVANCE MATERIAL	TURNING Ø 3.50			7.000	1.950	1.950	0.0591	33	21	307	328
52	.DW	DWELL									2	328	330
53	.R1	RETURN 1	FACE			Ø 3.900	-0.200	-1.000	0.0200	10	6	330	336
54	.DW	DWELL									2	336	338
55/	.AM	ADVANCE MATERIAL	CHAMFER 45°		/ 45.00	7.100	0.100	0.100	0.0100	14	9	338	347 /
56	.R1	RETURN 1				Ø 4.100	-0.100	-0.500		14	9	( 338	347)
57	.O1	OUT 1				Ø						( 347	347)
58	.DW	DWELL									2	347	349
59	d0 .AMR	ADVANCE MATERIAL R.				12.100	5.000	5.000			10	349	359

NO.	OP.	OPERATION	Comment	T. OFFS.	AUX.	Ø-LEN.	/PART	/CAM	FEED	REVS	DEGREES	From .	To D.
60	<Ec	ENTER c					20.000	20.000	26.0000		26	( 163	189)
61	<U	RPM			16000.0						0	( 189	189)
62	<Ac	ADVANCE c	DRILLING 1				0.800	0.800	0.0300	26	8	( 189	197)
63	<Ac	ADVANCE c	DRILLING 2				2.900	2.900	0.0500	58	17	( 197	214)
64	<Ac	ADVANCE c	DRILLING 3				0.100	0.100	0.0100	10	3	( 214	217)
65	<DW	DWELL									2	( 217	219)
66 e0	<RcR	RETURN c R.					-3.800	-3.800			4	( 219	223)
67	<Oc	OUT c					-20.000	-20.000	14.0000		14	( 223	237)
68 e1	<En	ENTER n					20.000	20.000	30.0000		30	( 223	253)
69 f0	<OPC	OPEN COUNTER COLLET	EJECTION PART								10	( 253	263)
70	<On	OUT n					-20.000	-20.000	20.0000		20	( 290	310) -
71 f1	=I2	INDEX 2			2.000						49	( 263	312)
72 d1	=DW	DWELL									1	359	360
73	=U	RPM			7100.0						0	( 360	360)

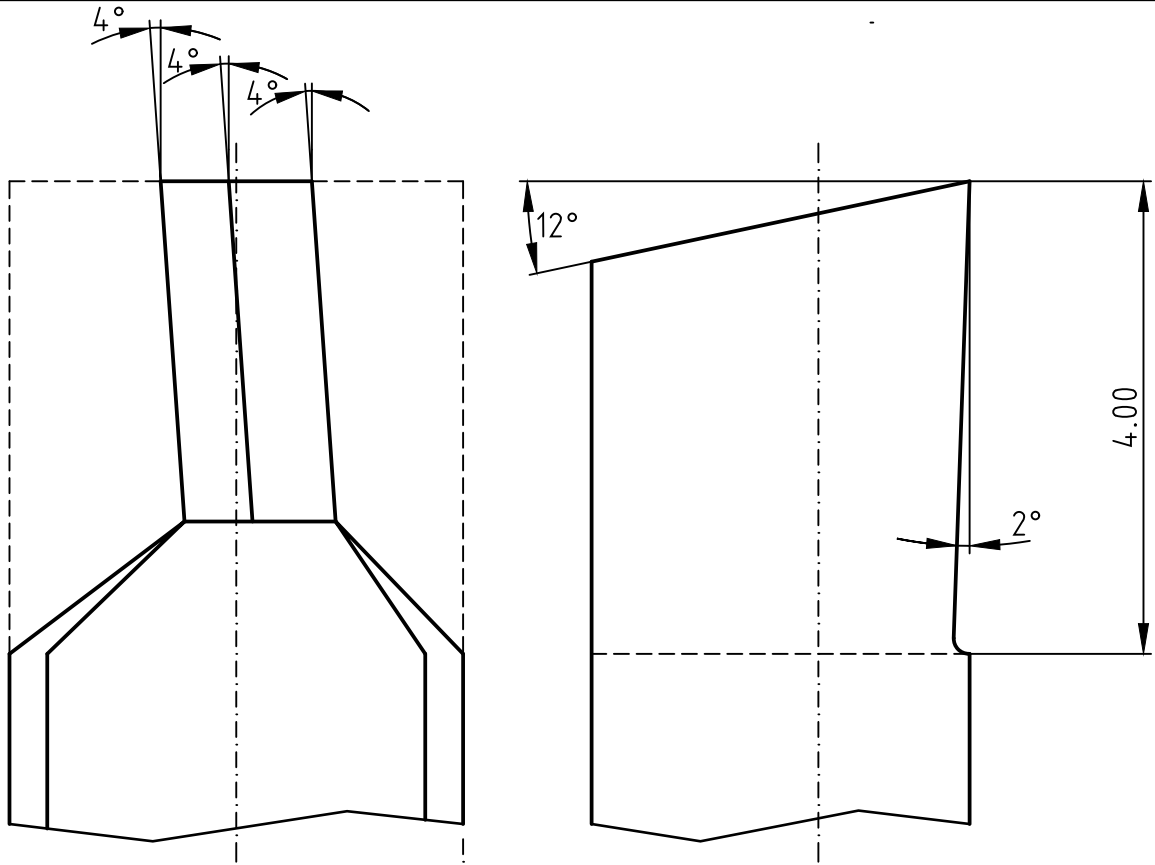
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Prod. degrees: 229.00

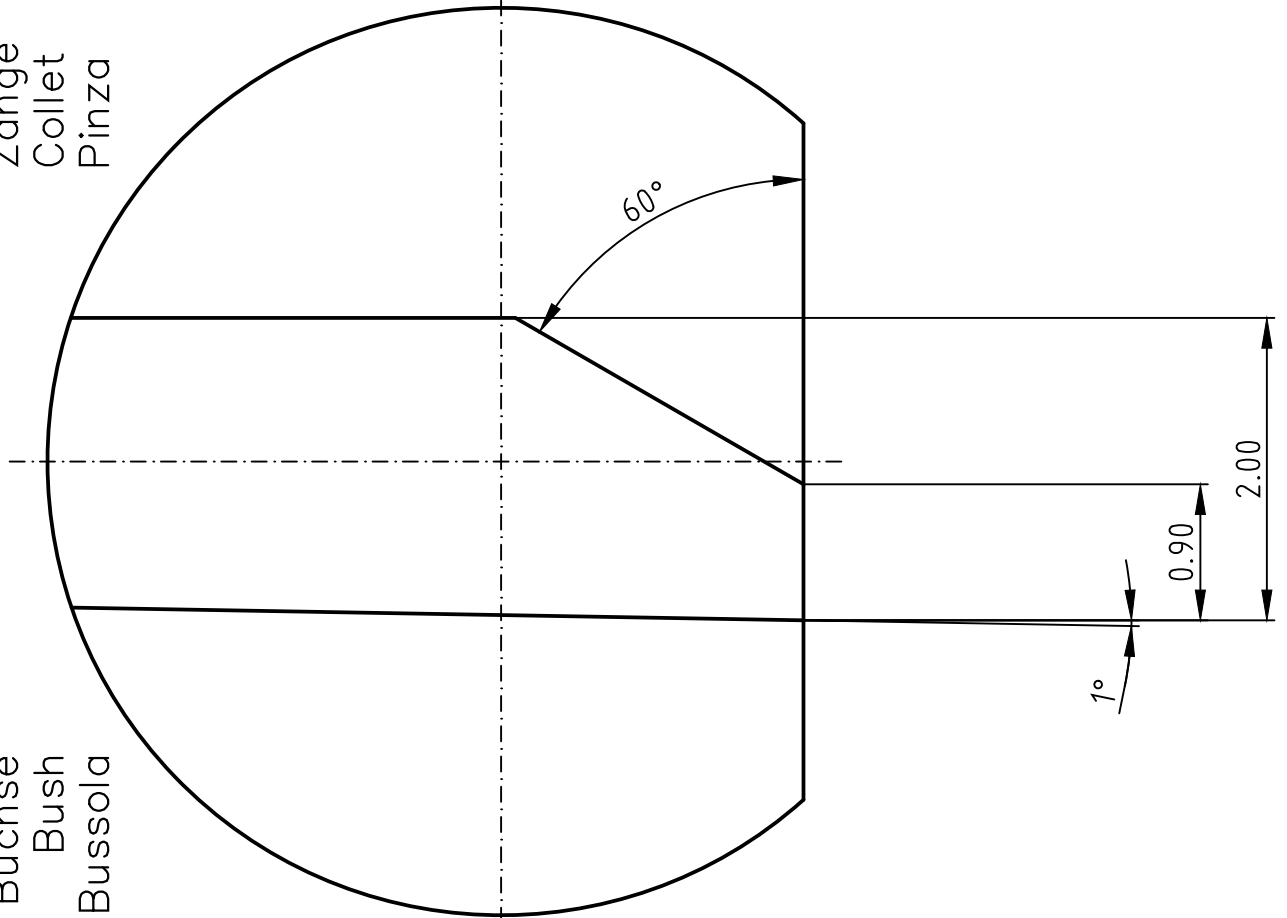
Unprod. degrees: 131.00

Revs for 360°: 568.00

Calculated production: 12.50



Pince  
Zange  
Collet  
Pinza



Canon  
Buchse  
Bush  
Bussola

Matière: Micro 100 400-1200-L

Traitement: ----- Date 01.02.25

Forme: 40 Dessiné Petruccelli

BURIN  
DREHSTAHL  
TOOL  
UTENSILE No. 1

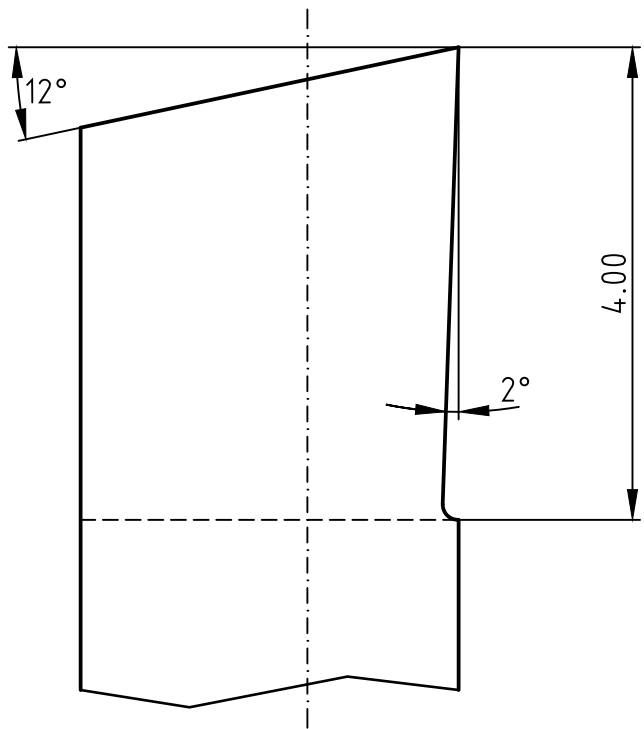
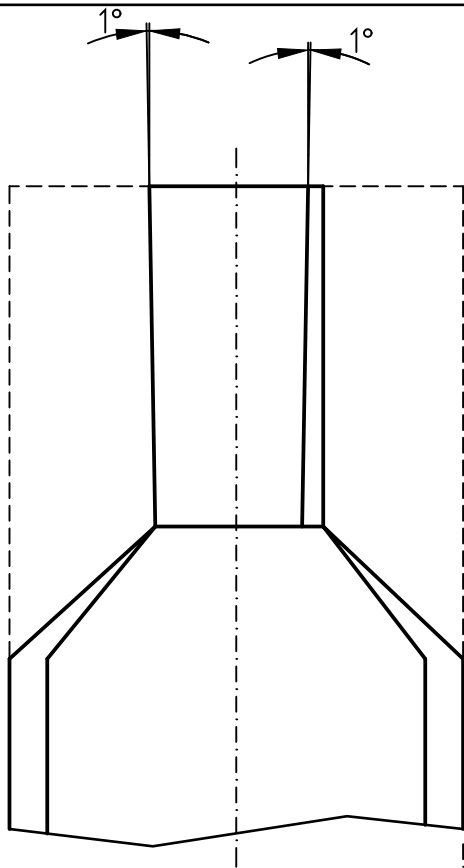
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No. 6-SN1454

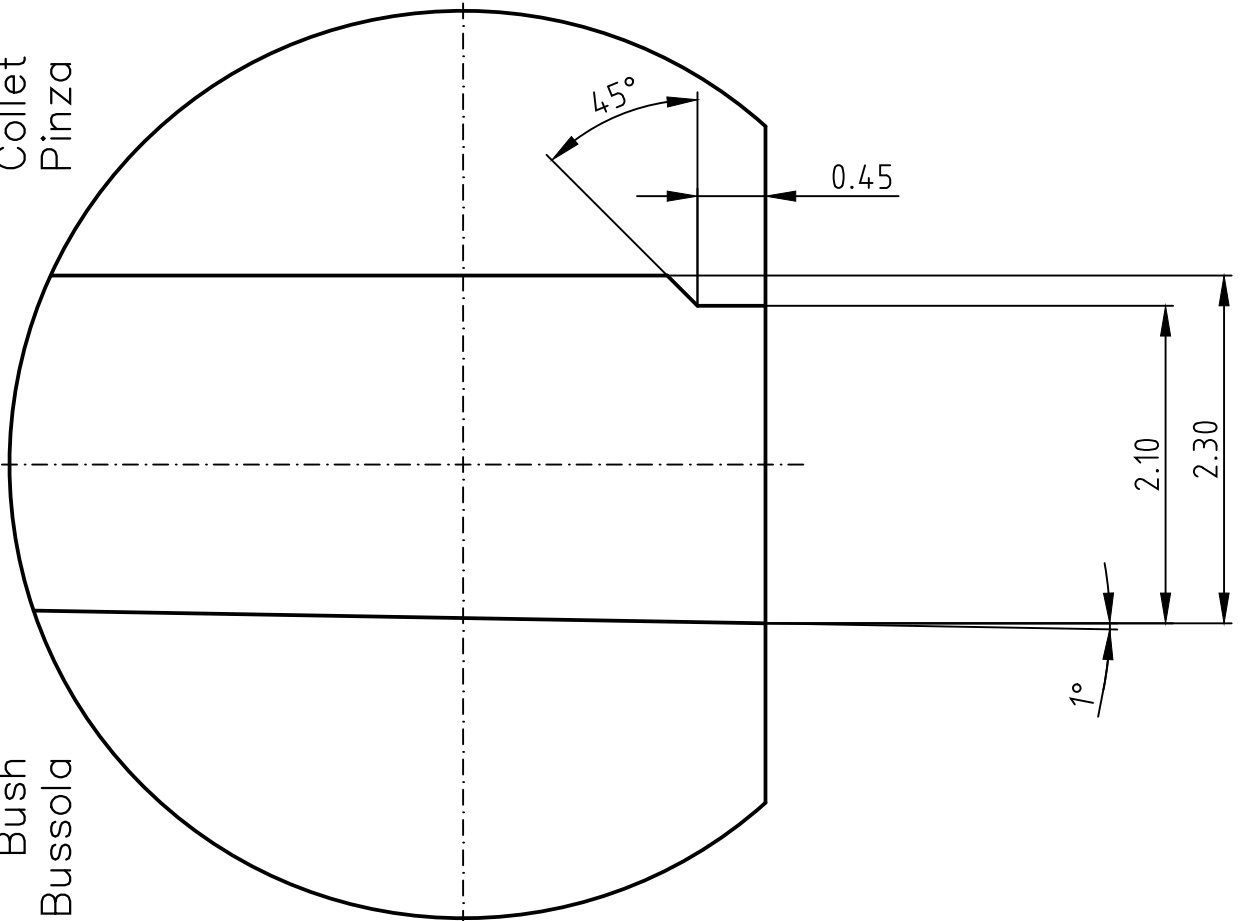


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Pince  
Zange  
Collet  
Pinza



Canon  
Buchse  
Bush  
Bussola

Matière: Micro 100	400-1200-L	
Traitement: -----	Date	01.02.25
Forme: 60	Dessiné	Petrucelli



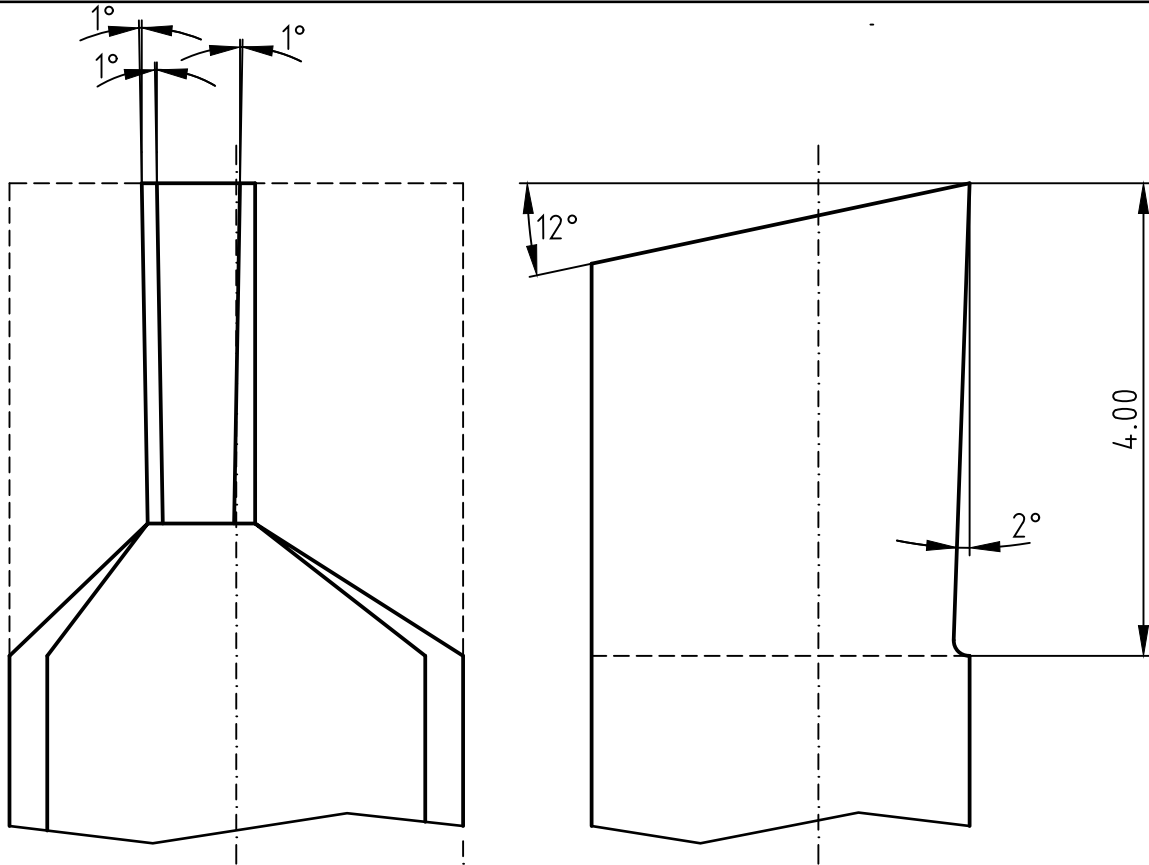
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BURIN  
DREHSTAHL  
TOOL  
UTENSILE No. 2

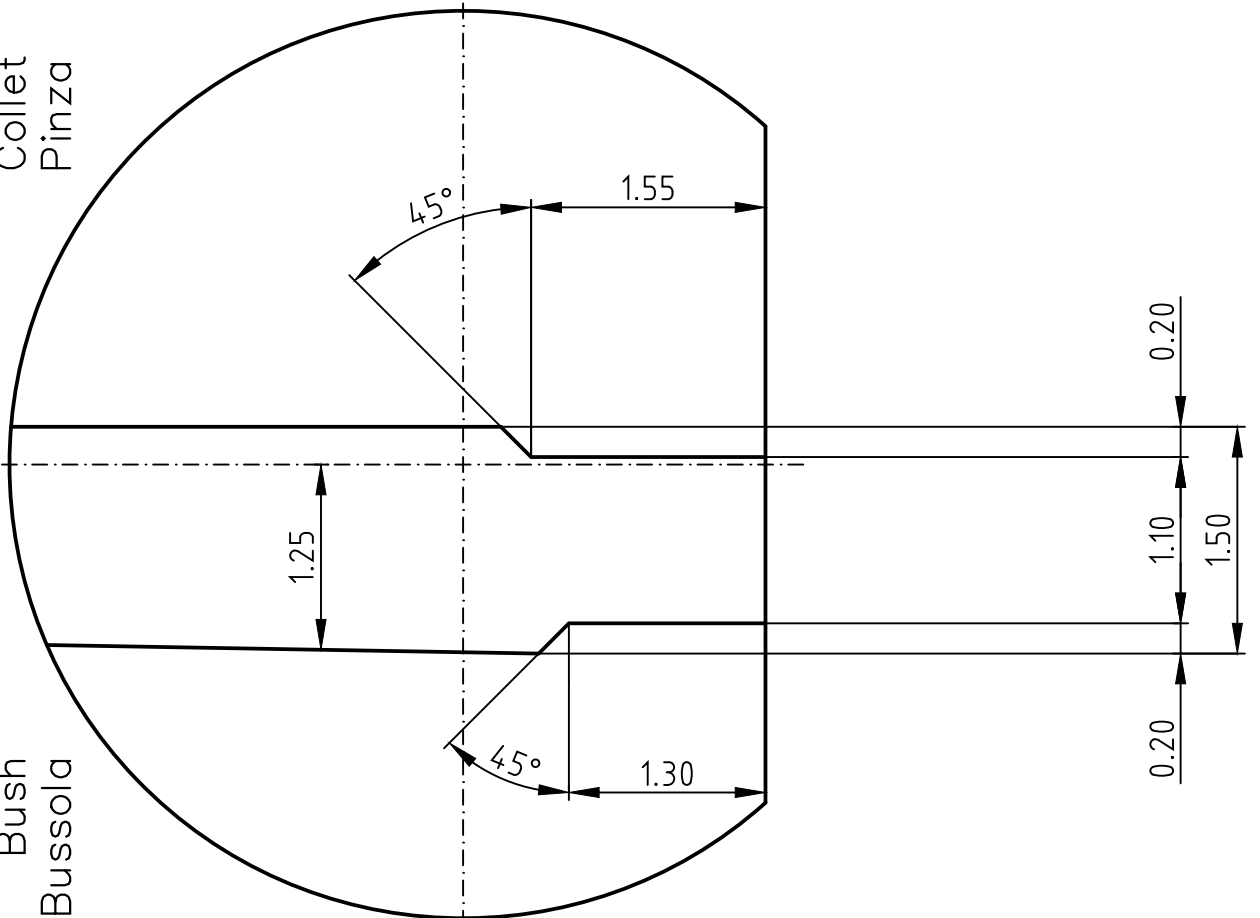
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No. 6-SN1454





Pince  
Zange  
Collet  
Pinza



Canon  
Buchse  
Bush  
Bussola

Matière: Micro 100	400-1200-L	
Traitement: -----	Date	01.02.25
Forme: 63	Dessiné	Petrucelli



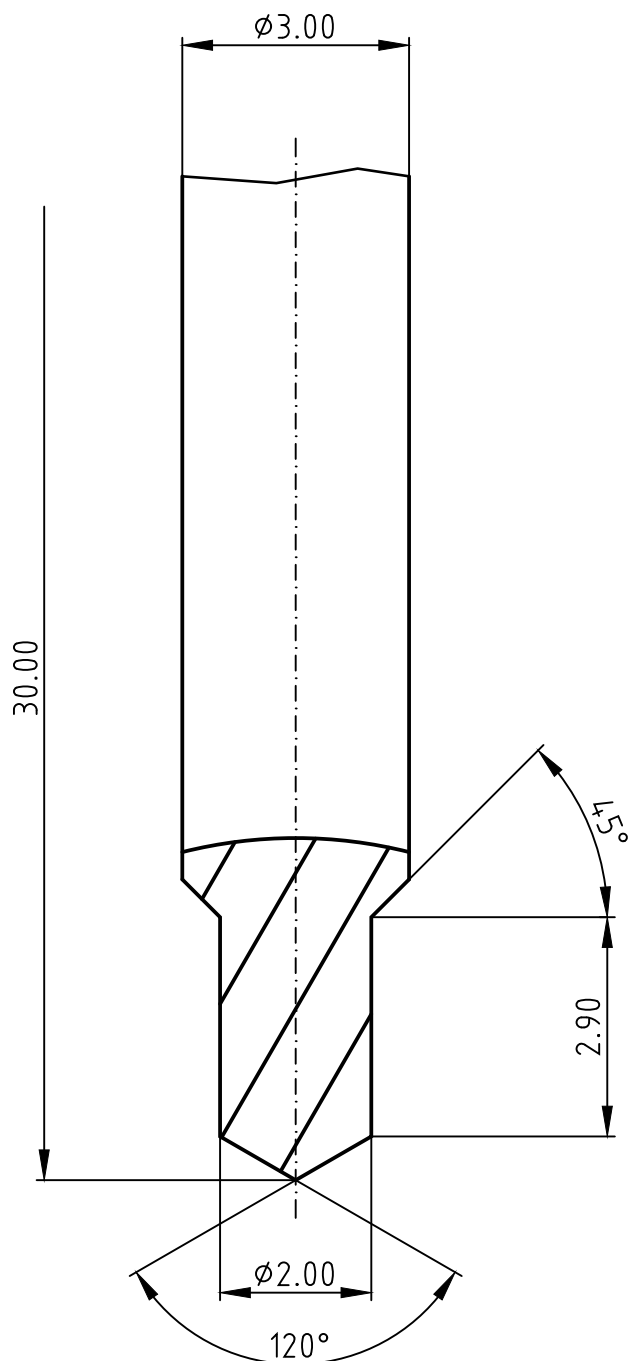
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BURIN  
DREHSTAHL  
TOOL  
UTENSILE

No. 3

ECH: 20:1  
10:1

No. 6-SN1454



400-1200-L



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Mèche metal dur  
**F4**

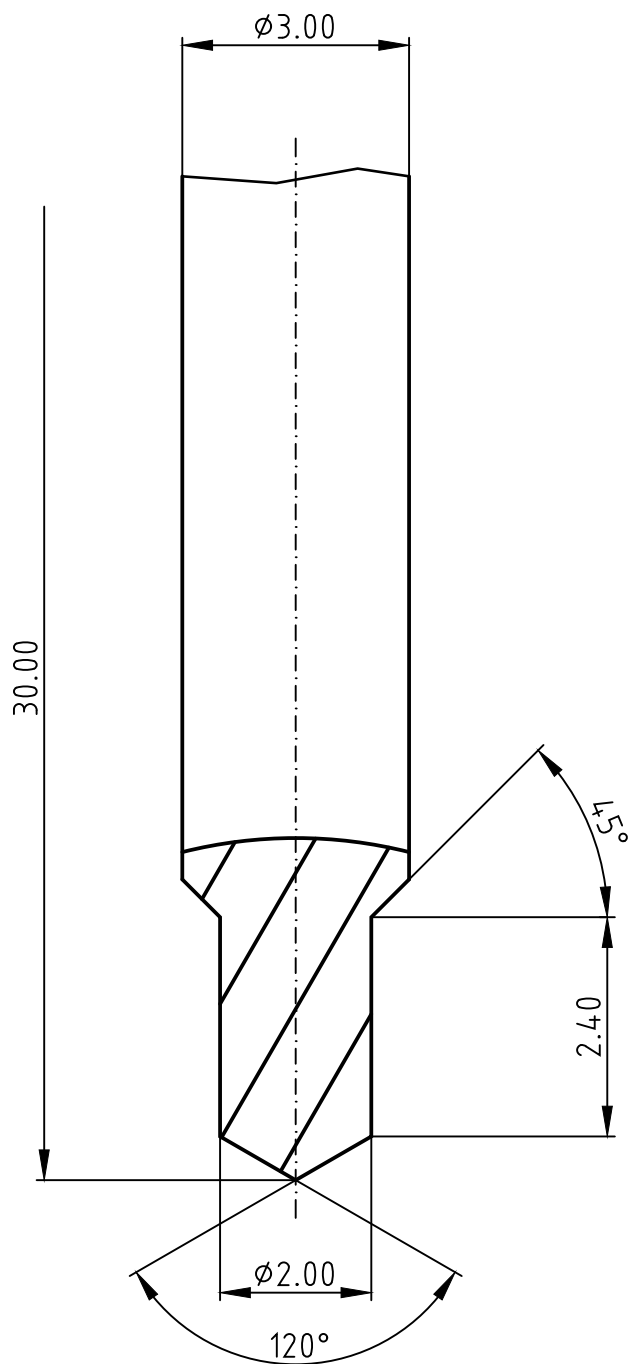
ECH: 20:1  
10:1

Coupe pour:  
**LAITON**

**No. 6-SN1454**

Date 01.02.25

Dessiné Petruccelli



400-1200-L



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Mèche metal dur  
**F4**

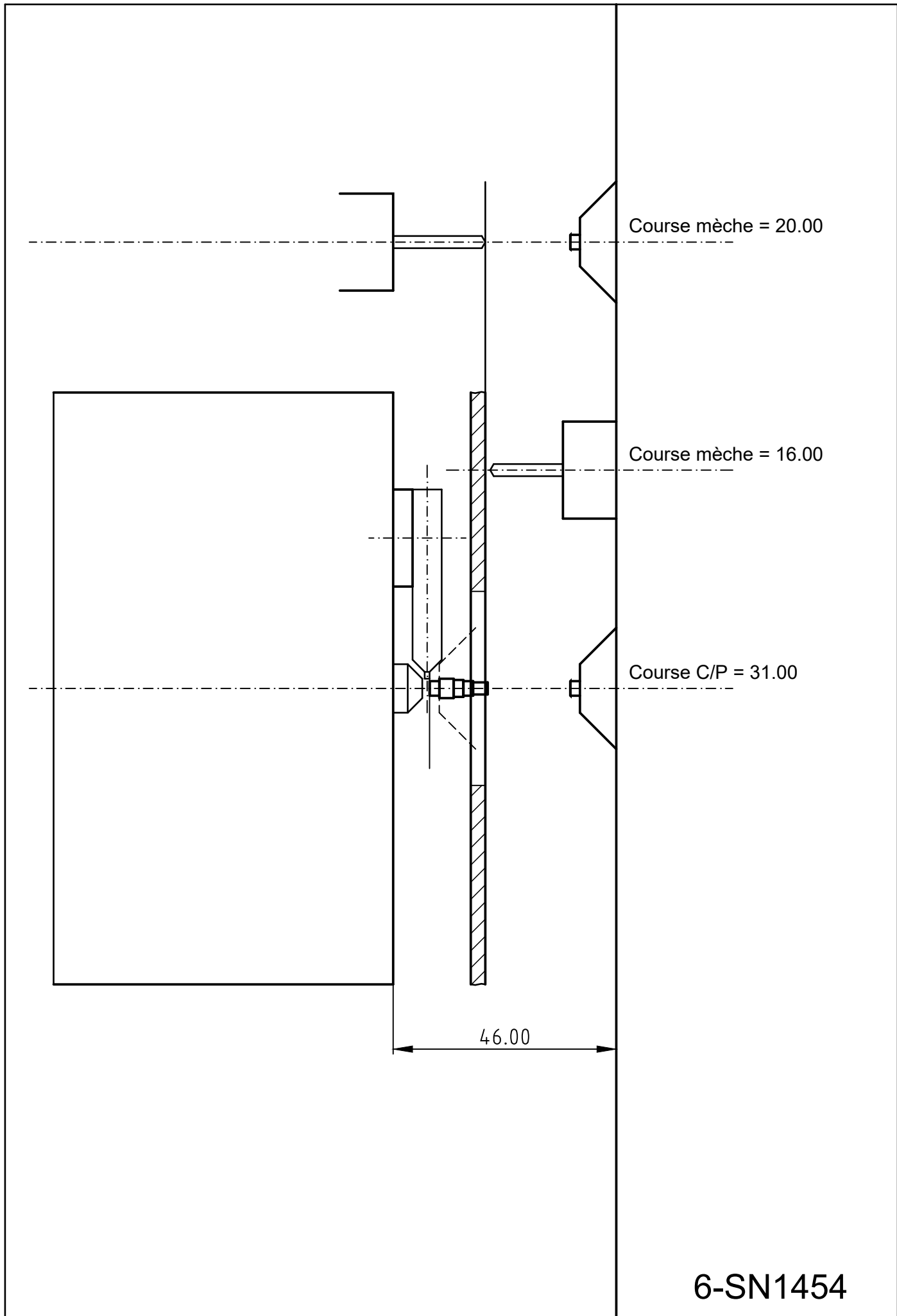
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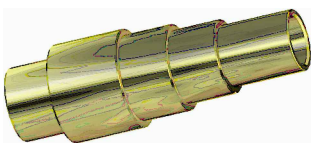
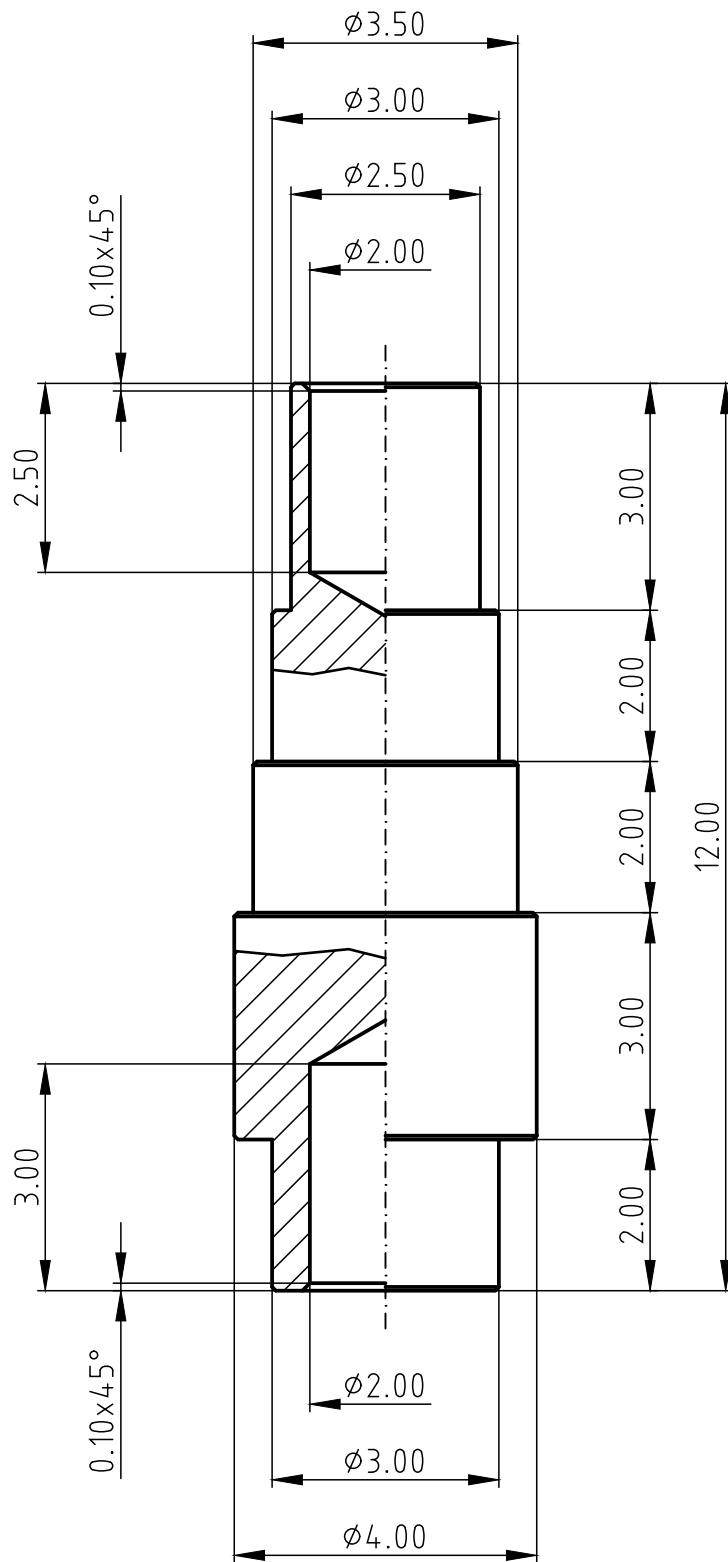
Coupe pour:  
**LAITON**

**No. 6-SN1454**

Date 01.02.25

Dessiné Petruccelli





Anglé 0.05 x 45°



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Matière: LAITON 58A

Date	01.02.25
Dessiné	Petrucelli

ECH: 10:1

400-1200-L