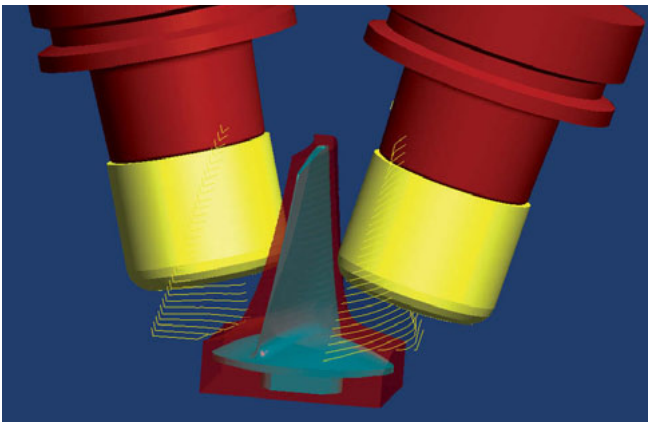
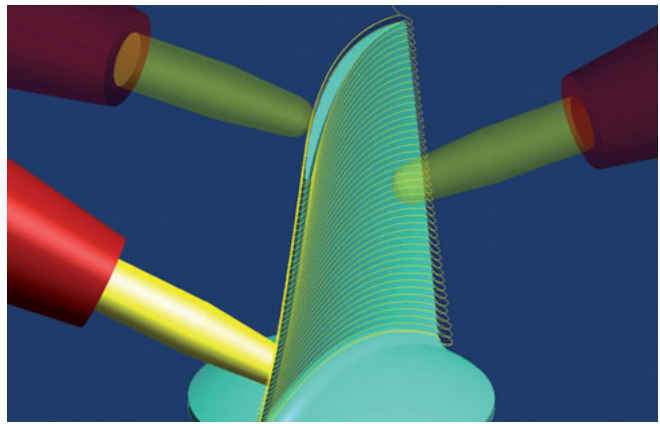


Milling of an adjustable pitch propeller on a DMU 40 monoBLOCK®

The *hyperMILL*® adjustable pitch propeller package offers specially optimised machining strategies that take into account the special technological requirements of these parts, whilst keeping programming simple. Integration in *hyperMILL*® means that 2.5D, 3D and 5-axis strategies with broad applications are also available. Users thus enjoy a high degree of flexibility when choosing the optimal machining strategy and tools.



Roughing: Various machining strategies are available for roughing adjustable pitch propellers. In this case, the vertically clamped short blade is roughed close to the contour using 3D ISO-machining and a large tool.



Finishing: Adjustable pitch propeller fillet machining is a form of rest machining that uses ball mills for the transition area between blade and hub. It can also be used for finishing the whole blade.

Machine: DMU 40 monoBLOCK®

| | | |
|----------------------------|--------------------------------|--------------------------|
| Main drive (motor spindle) | RPM range up to | 24.000 min ⁻¹ |
| Workspace | Rapid traverse/feedrate X/Y/Z | 30 m/min |
| | Traverse path X/Y/Z | 450/400/480 mm |
| NC rotary table | Rapid traverse/feedrate | 60 min ⁻¹ |
| | Clamping area | Ø 450 mm |
| | Max. workpiece weight | 250 kg |
| Swivelhead | Rapid traverse | 35 min ⁻¹ |
| | Tilt time | 1,5 s |
| | Tilt area (0=vert./-90=horiz.) | + 30°/-120° |
| Controller | | HEIDENHAIN iTNC 530 |
| Workpiece | | Pitch Propeller |



OPEN MIND Technologies AG
 Argelsrieder Feld 5 • 82234 Wessling • Germany
 Phone: +49 8153 933-500 • Fax: +49 8153 933-501
 E-mail: Info.Europe@openmind-tech.com
 Internet: www.openmind-tech.com



DECKEL MAHO Pfronten GmbH
 DECKEL MAHO-Strabe 1 • 87459 Pfronten • Germany
 Phone: +49 8363 89-0 • Fax: +49 8363 89-222
 E-mail: info@gildemeister.com
 Internet: www.gildemeister.com