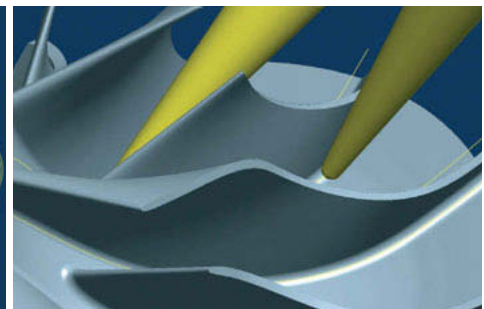
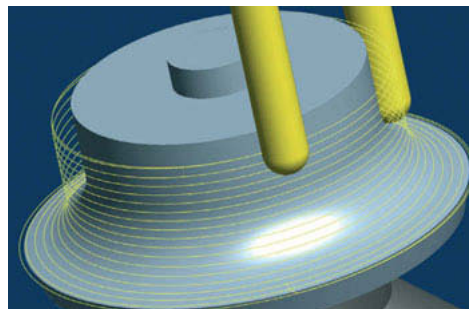


Impeller: milled on a Mikron HSM 400U

hyperMILL® multiblade package simplifies the milling of impellers. In contrast to specialist systems, no particular programming skills or pre-machined stocks are required. Optimised machining programs are easily generated thanks to the numerous integrated automated functions. They ensure that the best surfaces are created with the minimum machine running time.



Blank milling: Integrating the multiblade package into *hyperMILL*® also allows the milling or millturning of stock. Machining is more flexible, particularly during the production of prototypes.

Multiblade swarf cutting: When blade geometries permit swarf cutting, machining times can be reduced. The Flank Milling machining strategy automatically calculates the 'snuggest' fitting tool position.

Machine: Mikron HSM 400U

Processing	Tool	Diameter [mm]	Corner Radius [mm]	Number of Teeth	Spindle Speed [min ⁻¹]	Feed Rate [mm/min]	Lateral Feed [mm]	Axial Feed [mm]	Processing Time [min]
		D	R	z	n	v _f	a _e	a _p	t
Roughing outside	Bull nose	12	1,5	2	30.000	12.000	3,0	3,0	
Roughing outside	End mill	10	0	2	40.000	10.000	-	-	
Roughing outside	Ball nose	8	4	2	42.000	12.000	0,2	0,2	
Roughing Blades	con. ball nose 4°	5	2,5	3	40.000	10.000	3	7,5	3'26"
Roughing restmat. Blades	con. ball nose 4°	3	1,5	2	40.000	9.000	3	6	2'48"
Semi fin. Blades	con. ball nose 4°	3	1,5	2	40.000	4.000	-1	18	1'00"
Finishing Hub	Ball nose	2	1	2	42.000	7.000	1	1,6	5'43"
Finishing Blades	con. ball nose 6°	2	1	2	6.000	700	0,1	22	3'06"
Processing Time (Total)									16'03"

Spindle with 42.000 min⁻¹ Material Aluminium Focus machining time, surface quality



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