

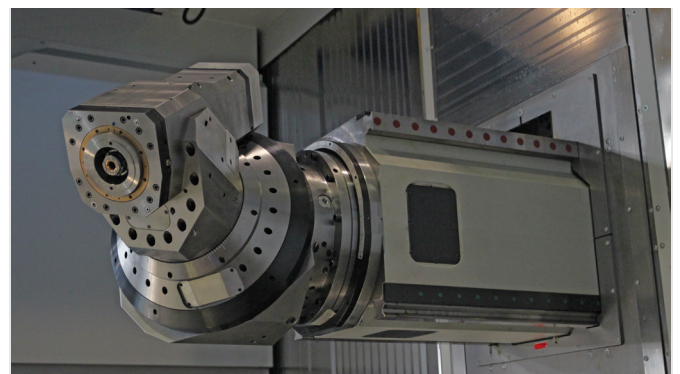
Workshop FRAZER Millturn - 19th and 20th January 2018



Frazer Box Millturn

Sachman latest development for milling and turning

Machine Technical Data		
X-axis (longitudinal)	mm	4000
	inch	157
Y-axis (vertical)	mm	1500
	inch	59
Z-axis (cross)	mm	1100
	inch	43
Rapid Speed	m/min	35
	ipm	1378
Torque (S1/S6)	Nm	480/640
	lb*ft	354/472
Power (S1/S6)	kW	25/33
	hp	33/44
Max Spindle speed	rpm	8000
CNC Type	Siemens 840 D	
Spindle Taper	HSK-A-100	



UNIVERSALE C head (with torque motors)

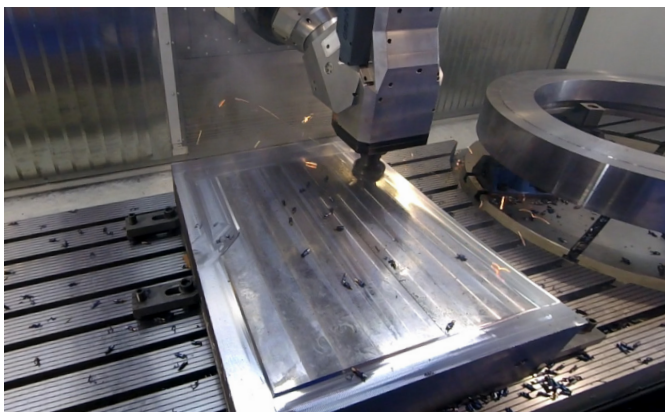
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Test 1/2



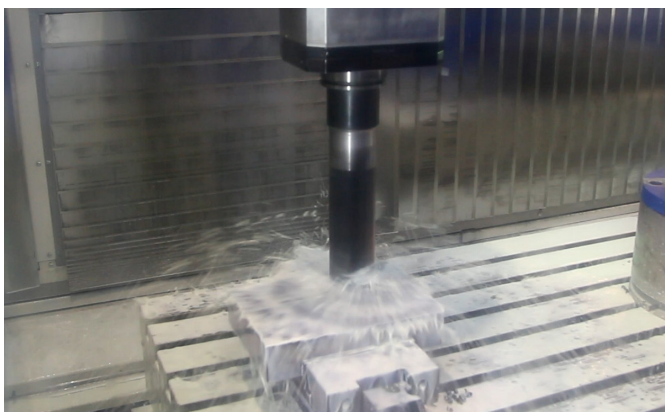
Face Milling on Steel CK45	ø 80 mm Z = 6	ø 66 mm Z = 5
Chip removal	700 cm ³ /min	544 cm ³ /min
Cutting speed	230 m/min	228 m/min
Spindle speed	920 rpm	1100 rpm
Feed	2318 mm/min	8250 mm/min
Cutting depth	5 mm	1 mm
Cutting width	60 mm	66 mm

Test 3



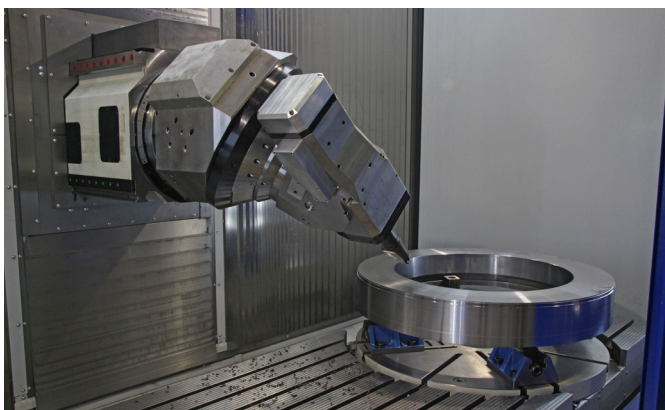
Face Milling on Aluminium ø 80 mm Z = 3	
Chip removal	2160 cm ³ /min
Cutting speed	1508 m/min
Spindle speed	6000 rpm
Feed	9000 mm/min
Cutting depth	4 mm
Cutting width	60 mm

Test 4



Drilling on Steel CK45 ø 75 mm Z = 4	
Tool lenght	355 mm
Cutting speed	100 m/min
Spindle speed	440 rpm
Feed	60 mm/min
Cutting depth	25 mm
Chip removal	265 cm ³ /min

Test 5



Turning on Steel CK45	
Chip removal	400 cm ³ /min
Cutting speed	250 m/min
Table rotation	80 rpm
Feed	0,4 mm/rpm
Cutting depth	4 mm
Cutting width	1000 mm