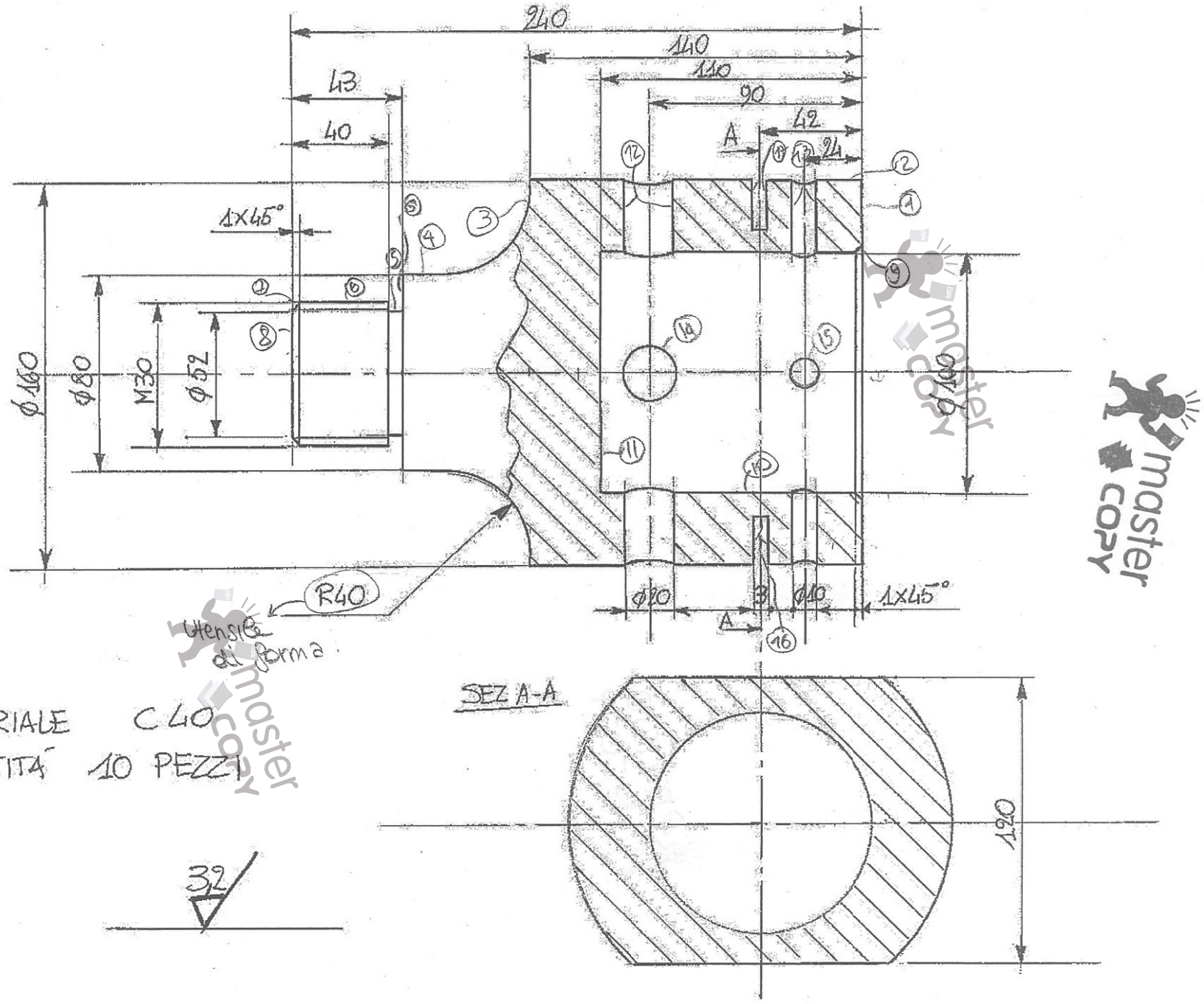
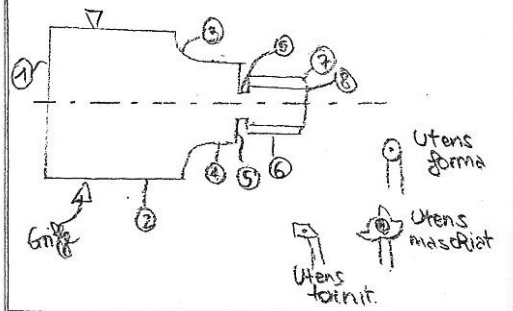
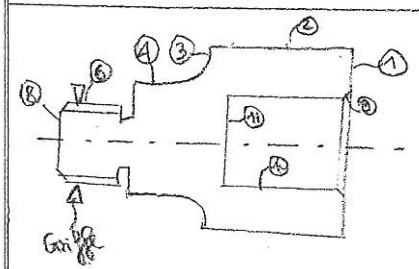
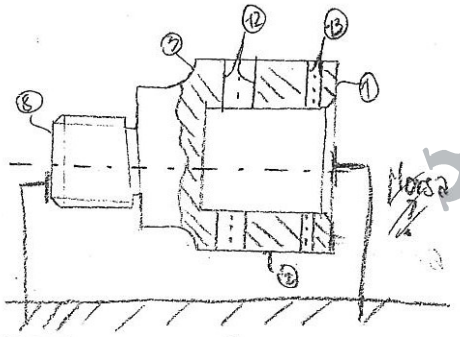
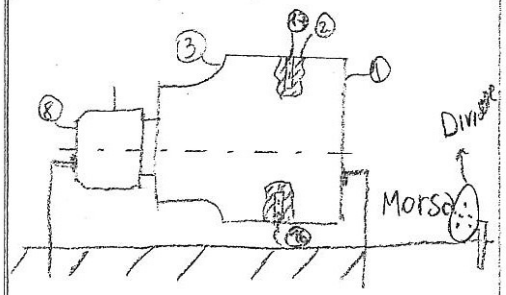
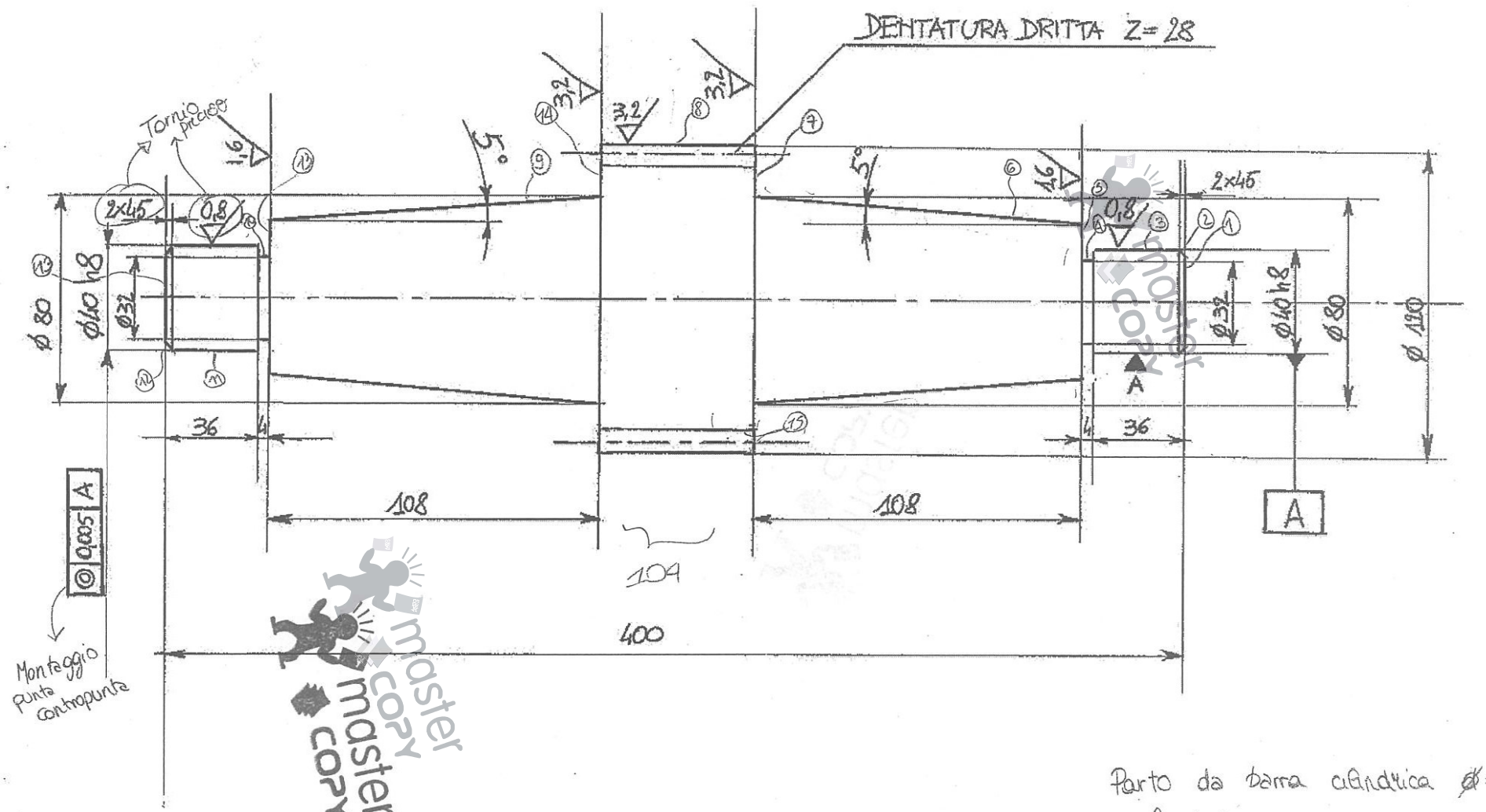

240
140
110
90
43
40
42
24
A
1x45°
Φ160
Φ80
M30
Φ52
Φ140
R40
Utensile di forma
Φ10
3
Φ10
1x45°
SEZ A-A
120
32
MATERIALE C40
QUANTITA' 10 PEZZI

	Fasi	Operazioni	Macchine	Attr	SB	SR	Note
	10 a	Sfacciatura 8 Cilindr est 6 + spalle 5! Gl est 4 Gl est 3 (utensforma) Gola 5 Filettatura 6 Smusso 7	Tornio parallelo	Mandrino griffe x esterni	SB 2	SR 2 SR 8 SR 1	* Smusso inclinare torretta portautensili
	10 b	Sfacciatura 1 Sgross Gl est 2 Centratura 10 foratura 10 Gl Alleg int 10 + spallamento 11 Smusso 9		Punta centri Punta elica	SB 6	SR 6 SR 8 SR 3	
	20	Tracciatura 12,13,14,15	Banco a tracciare	Truschino	SP (1)	SR 1 SR 3 SR 2	
	30	Centratura 12,13 Foratura 13,12 → Centratura 14,15 Foratura 14,15	Trapano a montante	Piattaforma girev Morsa [basta fasciare spazio]	SB 1 SB 8	SR 1 SR 3 SR 2	→ Girare pezzo di 90°
	40	Cava 17 Cava 16	Fresatrice copy orizzontale [albero portafrez]	Fresa a disco [3 taglienti] Morsa + divisore universale	SB 1 SB 8	SR 1 SR 2	Ruotare pezzo di 180° con divisore

master copy



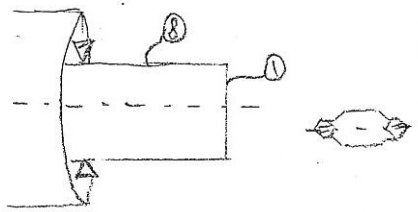
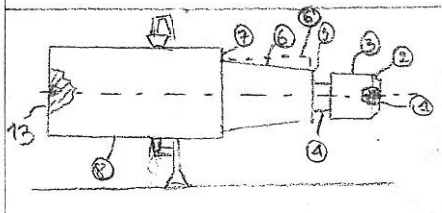
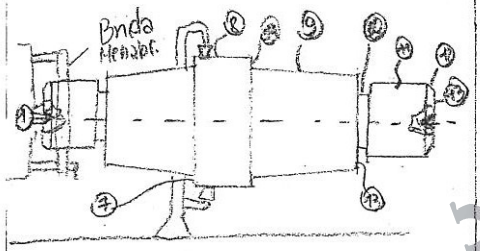
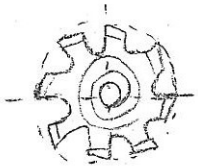
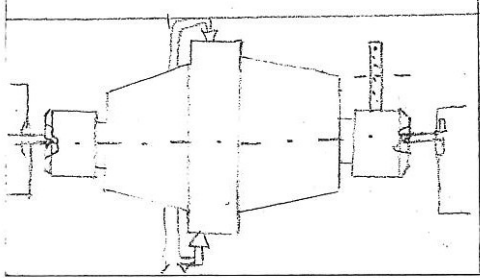
Parto da barra cilindrica Ø = 125
ℓ = 400.

MATERIALE C10

QUANTITA' 1 PEZZO

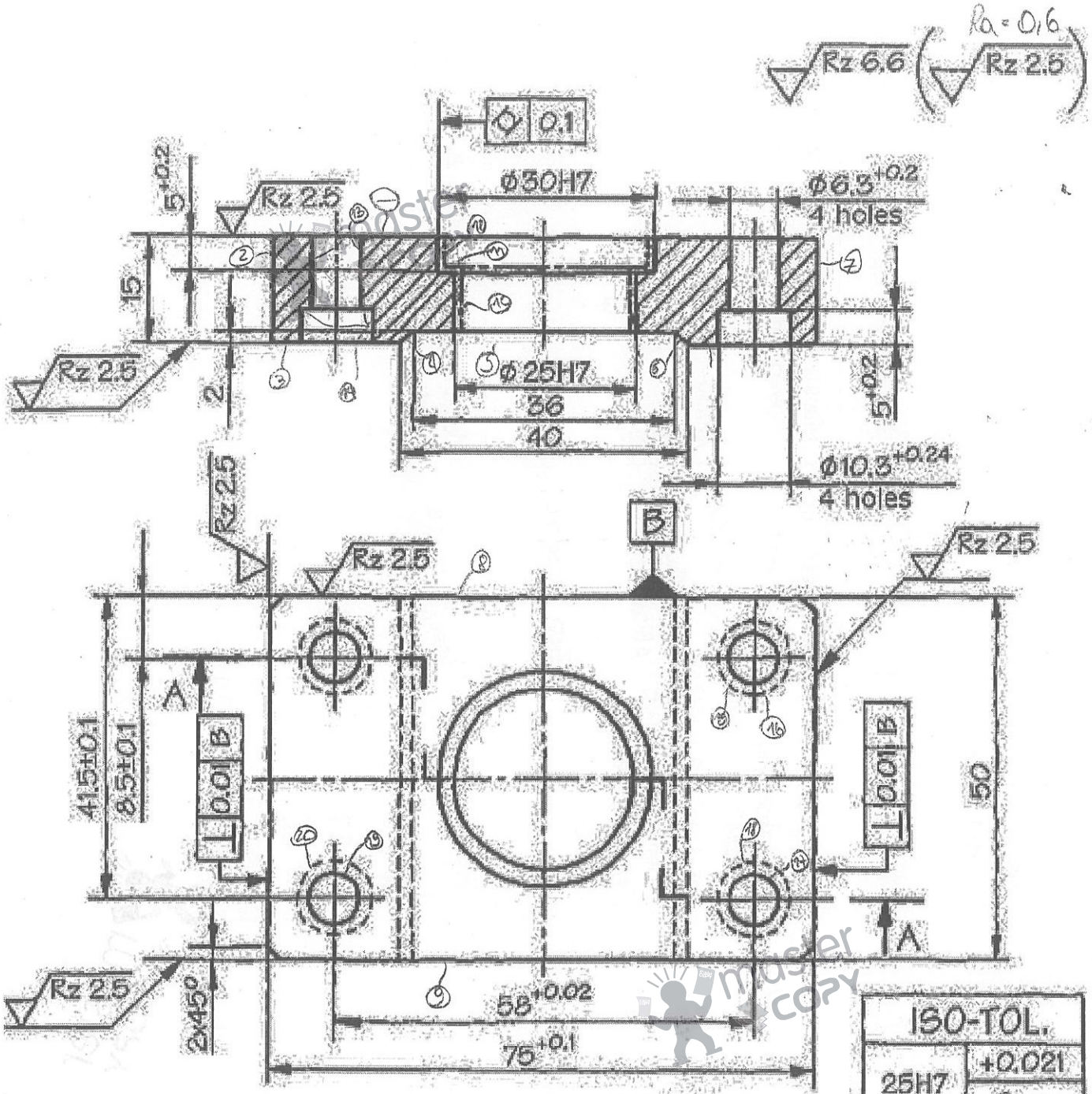
Posso non sfacciare 1/13

6,4 (3,2 / 0,8 / 1,6)

	Fasi	Operazioni	Macchina	Attr	SB	SR	Note
	10 a	Centratura 1 Sfacciatura 1	Tornio parallelo	Mandrino autocentran griffe × esterni +Punta centri	SB 8	SR 8 SR 13	Inserisco pezzo nella cavità del mandrino per $e = 150$
	10 b	Sfacciatura 13 Centratura 13	//	//	SB 8	SR 1 SR 13	//
	10 c	Sgross 3 + spall 5 Gola 4 Fin. spall 5 Cil sgross 6' + spall 7 Cil sgross 8 (P=105) Cil conica 6 - Smusso 2	//	Punta contropunta Brida menabrida Lunetta fissa	SB 1 SB 13 SB 8	SR 1 SR 8 SR 13	Lunetta fissa perché $\frac{L}{Dm} = 5$ Inclino a SR tornio → Inclino torretta porta utensili
	10 d	Sgross 11 + spall 13 Gola 10 Finit spall 9 Sgross 9' + spall 14 Cil conica 9 Smusso 12	//	//	SB 1 SB 13 SB 8	SR 1 SR 8 SR 3 SR 7	
	20	Scanalature 15 × 28	Fresatrice in cong verticale Fresa con denti spogliati (z=28)	Punta e contropunta Divisore universale Fresa a disco + cod	SB 1 SB 13	SR 8 SR 7 SR 14	
	30	Rettifica in tondo per esterni 11, 3 1 Usura mola	Rettificatrice universale	punta contropunta brida menabrida Lunetta fissa	SB 1 SB 13 SB 8	SR 8 SR 1 SR 13	

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Barra rettangolare 55 × 80 ρ = 20



ISO-TOL.	
25H7	+0.021
	0
30H7	+0.021
	0

Tolerances, which are not defined are: $\pm \frac{IT14}{2}$

Holes ⌀30H7 and ⌀25H7 are machined with Rz 2.5

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