

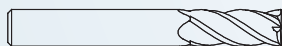
3C零件不锈钢加工方案

Stainless steel processing program of 3C parts

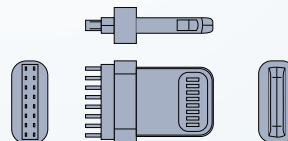
I/O接口

公头加工

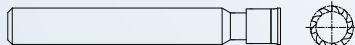
工序一
OP1



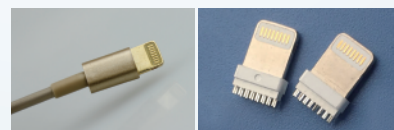
D6四刃平头刀
D6,4 Flute,Square endmill



工序二
OP2



D7.6十刃左旋成型刀(右旋)
D7.6,10 Flute,Left/Right,Forming cutter



鱼嘴加工

工序一
OP1



D6成型刀 (粗和精加工)
D6 Forming cutter(Roughing/Finishing)



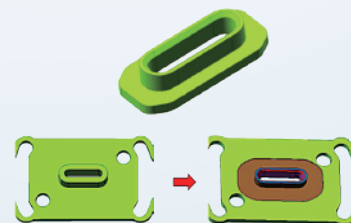
D3铣刀 (粗和精加工)
D3 Endmills(Roughing/Finishing)



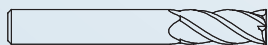
D1.5铣刀 (粗和精加工)
D1.5 Endmills(Roughing/Finishing)



D4 倒角刀 (粗加工)
D4 Chamfering cutter(Roughing)



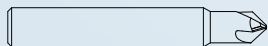
工序二
OP2



D4铣刀 (粗加工)
D4 Endmills(Roughing)



D2铣刀 (粗和精加工)
D2 Endmills(Roughing/Finishing)



D4 倒角刀 (精加工)
D4 Chamfering cutter(Finishing)



工序三
OP3

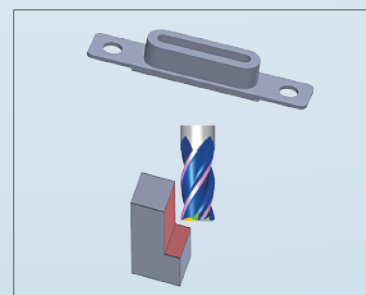


D4 倒角刀 (粗和精加工)
D4 Chamfering cutter(Roughing/Finishing)



加工案例 Case Studies

规格 Size	D6*R0.5*16*50*d6
加工工件 Processing workpiece	I/O接口
工件材料 Workpiece material	SUS316L
加工方式 Processing Way	侧铣, 粗加工 Side milling,Roughing
加工参数 Cutting Data	N=11000rpm F=1500mm/min ap=2mm ae=0.2mm
冷却方式 Cooling Method	油冷 Oil cooling
加工设备 Processing equipment	精雕 Carver PMS16_ATC_C
寿命状况 Tool Life	要求 Requirement : 3000pcs LION CBD : 3000pcs



试验结果：我司刀具满足客户使用要求。Test Results: Our tools can meet customer's requirement

摄像头环圈 Camera Ring

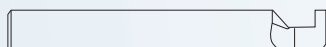
主轴面夹持工序 Spindle surface clamping surface OP

工序一
OP1



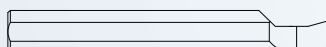
钻头 : D5.55*1.8*D6.5*10*60*D7

工序二
OP2



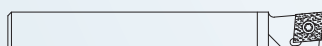
钻头 : W0.8*1.0*3*D4*L40

工序三
OP3



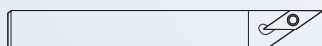
刀杆 : D4*W3.8*R0.03*L30

工序四
OP4

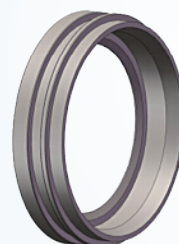


刀杆 : SCLNR1212F-07FF
刀片 : CNGU070301MFP-C36 LC1550

工序五
OP5



刀杆 : SVJBR1212JX-11FF
刀片 : VBET110301MR-FSF LC1550

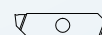


工序六
OP6



刀杆 : FGFTWR1212H-T3-32
刀片 : FGFT32R050-003N LC3225

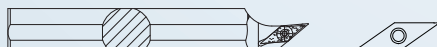
工序七
OP7



刀杆 : FGHHL-1212*100-T6-10-N1C-1525
刀片 : FGPOL-0.6-2.5-R0.05-N1C-1525

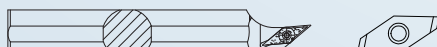
副轴面夹持工序 Secondary axis clamping surface OP

工序一
OP1



刀杆 : S20R-SUVBR-11
刀片 : VBET1103005MF-FSF LC1550

工序二
OP2



刀杆 : S20K-SVLPR11-26M-A
刀片 : VPGT110301R-XM LC3225

工序三
OP3



刀杆 : S20K-SVLPR11-26M
刀片 : VPET110302FB LC3225

摄像头其他高光刀方案 Special tool for camera part



指纹按键高光刀 Special tool for home button



陶特新科技有限公司
TAOTE NTE CO., LTD.

地址 Add : 广州市东华西路86号丽华大厦西塔17楼(510055)
17th Floor, West Tower of Lihua Building, No.86, Donghuaxi Road, Guangzhou
电话 Tel : 020-83881463
传真 Fax : 020-83881477
邮箱 E-mail : taotente@toolingcn.com



www.toolingcn.com