Amada EM3510/Pega358 levytyökeskuksien vakiotyökalut (0-asennot)

LEVYTEKNIIKKA OY

31.1.2020

A=Asema N=Normaali välys 0,25 T=Tiukka välys 0,08-0,15 V=Väljä välys 0,5-1,0

45: E=Ei 45° asentoa T=Tiukka välys 45° V=Väljä välys 45° R=Pyöristyssäde kulmissa U=Uusi työkalu

D=A*B

DD=A*B

RO	A	N	T	V	EM	P	45	R	U
0.90	A	X							
1.20	A	X							
1.60	A	X	X		116	138			
2.00	A	X	X		142	239			
2.10	A	X							
2.20	A	X	X		222	143			
2.30	A	X	X						
2.40	A	X	X						
2.50	A	X	X		217	244			
2.60	A	X							
2.70	A	X	X						
2.80	A	X							
2.90	A	X		X					
3.00	A	X	X		133	147			
3.10	A	X							
3.20	A	X							
3.30	A	X	X		213	248			
3.40	A	X							
3.50	A	X	X		243	152			
3.60	A	X	X						
3.70	A	X	X			271			
4.00	A	X	X		234	253			
4.20	A	X	X			170			
4.30	A	X				271			
4.40	A	X							
4.50	A	X	X		208	102			
4.60	A	X							
4.70	A	X	X						
4.80	A	X							
5.00	A	X	X		128	203			
5.10	A	X	X						
5.20	A	X	X						
5.40	A	X	X			107			
5.50	A	X	X			208			
5.80	A	X							
6.00	A	X	X		229	111			
6.10	A	X	X			111			
6.30	A	X							
6.40	A	X							
6.50	A	X	X			212			
6.80	A	X							
7.00	A	X	X		137	116			
7.20	A	X							
7.40	A	X							
7.50	A	X	X						
7.60	A	X							
7.80	A	X	X						
8.00	A	X	X		238	217			
8.10	A	X							
8.20	A	ei		X					
8.30	A	X							
8.50	A	X	X						
8.80	A	X							
8.80	B	ei		X					
9.00	A	X	X			129			
9.50	A	X	X						
10.00	A	X	X			230			
10.20	A	X							
10.50	A	X	X						
11.00	A	X				134			
11.50	A	X	X						
11.80	A	X							
12.00	A	X	X			235			

RO	A	N	T	V	EM	P	45	R	U
12.20	A	X							
12.50	A	X	X						
12.55	A	X							
12.70	A	X							
13.00	B	X	X						
13.20	B	X	X						
14.00	B	X	X						
14.50	B	X							
15.00	B	X	X						
15.20	B	X							
15.50	B	X							X
16.00	B	X	X						
16.50	B	X							
17.00	B	X	X						
17.10	B	X							
17.30	B	X							
17.50	B	X	X						
18.00	B	X	X						
18.50	B	X	X						
19.00	B	X							
20.00	B	X	X	X					
21.00	B	X							
22.00	B	X							
22.50	B	X							
23.00	B	X							
23.50	B	X							
24.00	B	X							
24.60	B	X	X						
25.00	B	X	X						
26.00	B	X	X						
27.00	B	X							
27.75	B	X							
28.00	B	X							
29.00	B	X	X						
30.00	B	X		X		114			
30.20	B	X							
31.00	B	X							
32.00	B	X							
33.00	C	X							
34.00	C	X							
35.00	C	X							
36.00	C	X		X					
38.00	C	X							
39.70	C	X							
40.00	C	X		X					
40.50	C	X							
45.00	C	X							
48.00	C	X							
50.00	C	X	X						
55.00	D	X							
60.00	D	X							
62.50	D	X							
65.00	D	X	X						
70.00	D	X							
74.00	D	X							
74.75	D	X							
76.90	D	X							
77.50	D	X							
77.90	D	X							
79.20	D	X							
80.00	D	X							
87.40	D	ei	X						
90.25	E	X							
102.75	E	X	X						

RE	A	N	T	V	EM	P	45	R	U
00.9*005	A	X	X			304			
00.9*010	A	X	X						
01.1*005.5	A	X							X
01.15*013	B	X	X						
01.15*030.3	B	X							
01.6*004	A	X	X			304			
01.6*007.6	A	X		X					
01.6*037.5	C	X	X						
01.7*007	A	X							
01.8*040	C	X							
02*004	A	X	X			304			
02*006	A	X							
02*015	B	X	X		119	105			
02*030	B	X	X						
02*032	C	X							
02*057	D	X	X						
02.5*005	A	X	X						
02.5*016	B	X	X						
02.5*025	B	X	X		341	342			
02.7*005.2	A	X		X					
03*005.4	A	X	X						
03*012.5	B	X	X						
03*025	B	X	X						
03*031	B	X	X	X	215	220			
03.2*010.2	A	X							
03.5*010	A	X	X		314	309			
03.5*019	B	X	X	X	236	256			
04*010	A	X	X	X	344	313			
04*030	B	X	X	X				0.5	
05*010	A	X	X	X	330	318			
05*020	B	X	X	X					
05*040	C	X		X		246			
05*050	C	X	X	X	201	228			
05*100	E	X	X	X	224	237			
05.4*008.4	A	X	X						
05.5*030	B	X	X	X	104	333			
06*006.7	A	X							
06*015	B	X							
06.5*010	A	X	X	X		339			
06.5*012.5	B	X							
06.5*013	B	X	X	X					
06.5*030	B	X		X				0.5	
07*010	A	X	X	X					
07*015	B	X							
07*022	B	X	X		332	306			
07*040	C	X	X	X				0.5	
07*050	C	X	X	X				0.5	
07.5*020.5	B	X							
08*017	B	X		X					
08*020	B	X		X				0.5	
08*051	D	X							
09.35*013	B	X							
09.5*013	B	X							
09.5*026.1	B	X							
09.6*013.15	B	X							
09.7*013.3	B	X							
11.2*020	B	X							
11.2*043.5	C	X							
12*019	B	X							
12.2*027.3	B	X							
13*016	B	X							
13*017	B	X							
13*029	C	X							
13*033	C	X			225				
13.2*020	B	X							
13.8*016.8	B	X							

RE	A	N	T	V	EM	P	45	R	U
14*038	C	X							
14.8*031.3	C	X						3	
15*045	C	X	X						
17*065	D	X							
17.5*032	C	X							
18*024.5	B	X	X					2	
21*081	D	X							
21.6*053	D	X						2	
22*030.5	C	X							
22.1*044.1	C	X							
22.2*027.2	C	X							
22.4*026.7	C	X		X					
22.5*044.6	C	X							
23.75*039.55	C	X							
24*059.8	D	X							
24*099	E	X						2	
25*035	C	X						2	
26*101	E	X							
27.7*039.7	C	X						5	
30*038	C	X						3	
31*061	D	X							
34*059.7	D	X						2	
43.8*055.2	D	X							
50*090	E	X						10	

SQ	A	N	T	V	EM	P	45	R	U
2.50	A	X	X						
3.00	A	X	X		323	340	T		
3.50	A	X	X				E		
5.00	A	X	X	X	335	345			
6.00	A	X	X	X		354			
7.00	A	X	X	X		367			
8.00	A	X	X		318	372			
8.50	A	X					E		
9.20	B	X	X	X		141	V		
9.50	B	X					E		
10.00	B	X	X	X			E		
11.20	B	X	X	X	102	342			
12.00	B	X	X	X			E		
13.00	B	X	X	X	131	150	T		
16.00	B	X	X	X	140	351			
17.42	B	X	X					2	
18.00	B	X	X	X	303	168			
19.80	B	ei	X						
20.00	B	X	X	X	320	369			
21.00	B	X				369	E		
25.00	C	X	X	X		264			
32.00	C	X							
36.00	C	X						2	
40.00	D	X		X	227	219			
50.00	D	X				219			
62.50	D	X							
70.00	E	X					E	7.5	

D	A	N	T	V	EM	P	45	R	U
06.4*06	A	X							
09.5*08.8	A	X							
09.7*08.9	A	X							
10*09.2	A	X							
12.5*11.7	A	X							
12.9*12.1	B	X							
20.2*18.5	B	X							

DD	A	N	T	V	EM	P	45	R	U
03.4*06	A	X							
03.6*06.2	A	X							
07.8*10	A	X							
08*12	A	X							
08.1*10.3	A	X							
08.3*10	A	X							
11.2*12.5	A	X							
14.9*16.1	B	X							
16.2*19.2	B	X							
17.6*20.1	B	X							
30.5*33	C	X							

OB	A	N	T	V	EM	P	45	R	U
01.7*008.5	A	X							
02*022	B	ei	X						
02*040	C	ei	X						
02.2*005	A	X							
02.5*005	A	X	X						
02.5*020	B	X		X					
02.5*025	B	X							
02.7*003.5	A	X							
02.7*017.5	B	X							
02.7*025.7	B	X							
03*025	B	X							
03*050	C	X	X		206	246			
03*080	D	X							
03.3*004	A	X							
03.3*006.3	A	X	X						
03.3*010	A	X				331			
03.3*015.3	B	X							
03.3*022	B	X		X					
04*008	A	X							
04*011	A	X	X						
04*015	B	X	X						
04.5*007	A	X							
04.5*008.5	A	X	X						
04.8*009	A	X							
05*006.8	A	X							
05*008	A	X	X						
05*009	A	X							
05.2*011	A	X							
05.5*009.5	A	X							
05.5*014	B	X							
05.8*011	A	X							
06*007	A	X							
06*010	A	X							
06*011	A	X							
06*040	C	X		X					
06.4*007.6	A	X		X					
06.4*010	A	X		X					
06.5*009.5	A	X		X					
06.5*014	B	X	X	X					
06.5*030	B	X	X	X					
07*009	A	X		X					
07*010	A	X		X		336			
07*018	B	X	X						
07.5*047.5	C	X	X						
08*010	A	X	X						
08*016	B	X							
08*020	B	X							
09*011	A	X		X					
09*012	B	X	X	X					
09*014	B	X	X	X					
09.5*090	E	X							
10*030	B	X	X						
10*040	C	X		X					
10.3*016.3	B	X		X					
11*015	B	X		X					
11*018	B	X		X					
12*019	B	X		X					
12*024	B	X							
12*047	C	X		X					
12.5*050	C	X		X					
13*060	D	X							
14*030	B	X		X					
14*040	C	X		X					
15*020	B	X							
15*055	D	X							
15.5*025	B	X							X
19.5*039.5	C	ei		X					
36.6*100	E	X							