Deburr components

TNC Controls

WEBINAR

CONTENT

1 **Application possibilities** at a glance

Application possibilities
At a glance

- Deburring contours with NC-drills (90° point angle)
- Cutting position on the tool can be selected as required
- NC program example for deburring contours with any angle
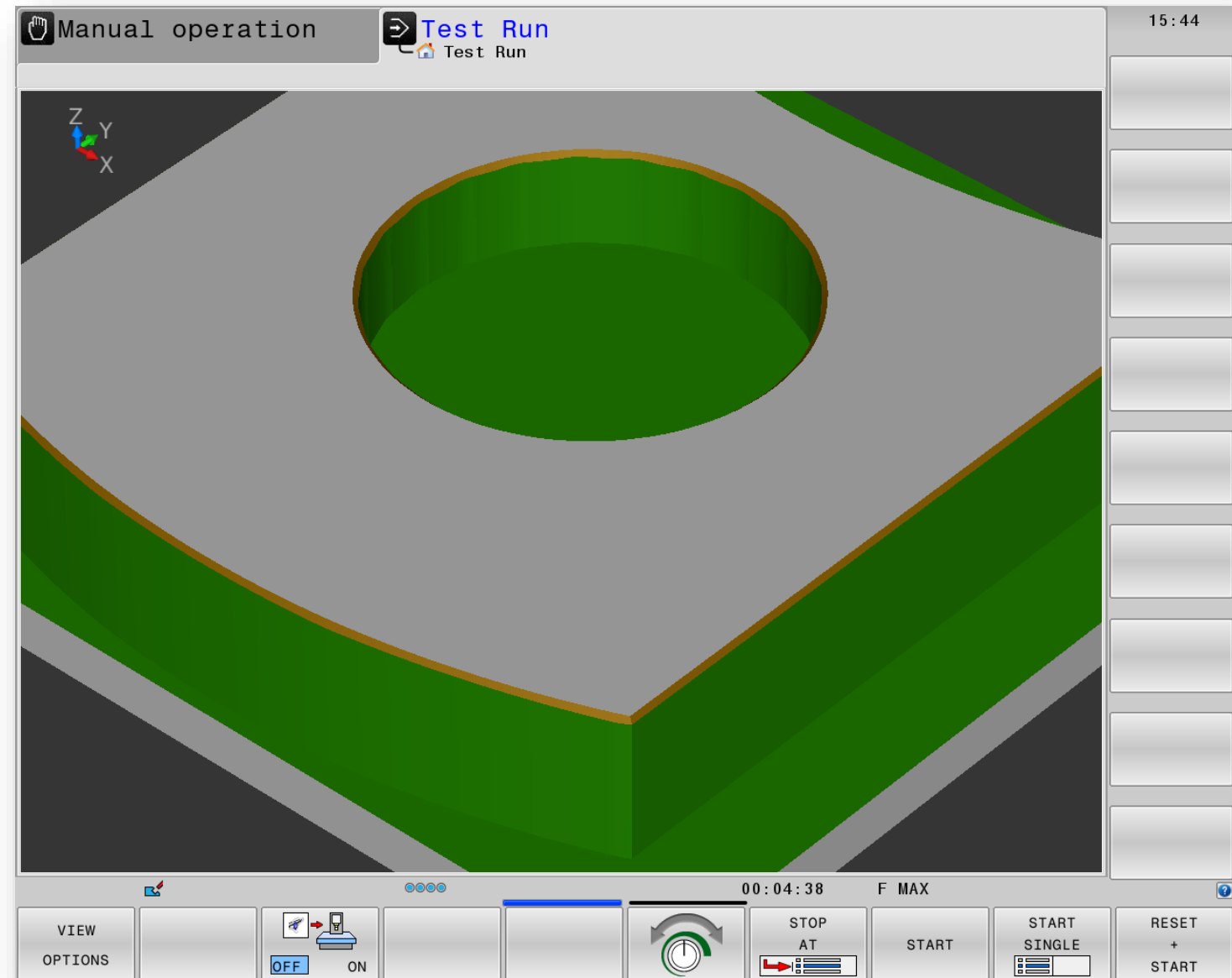- NC program example for deburring contours with any radius

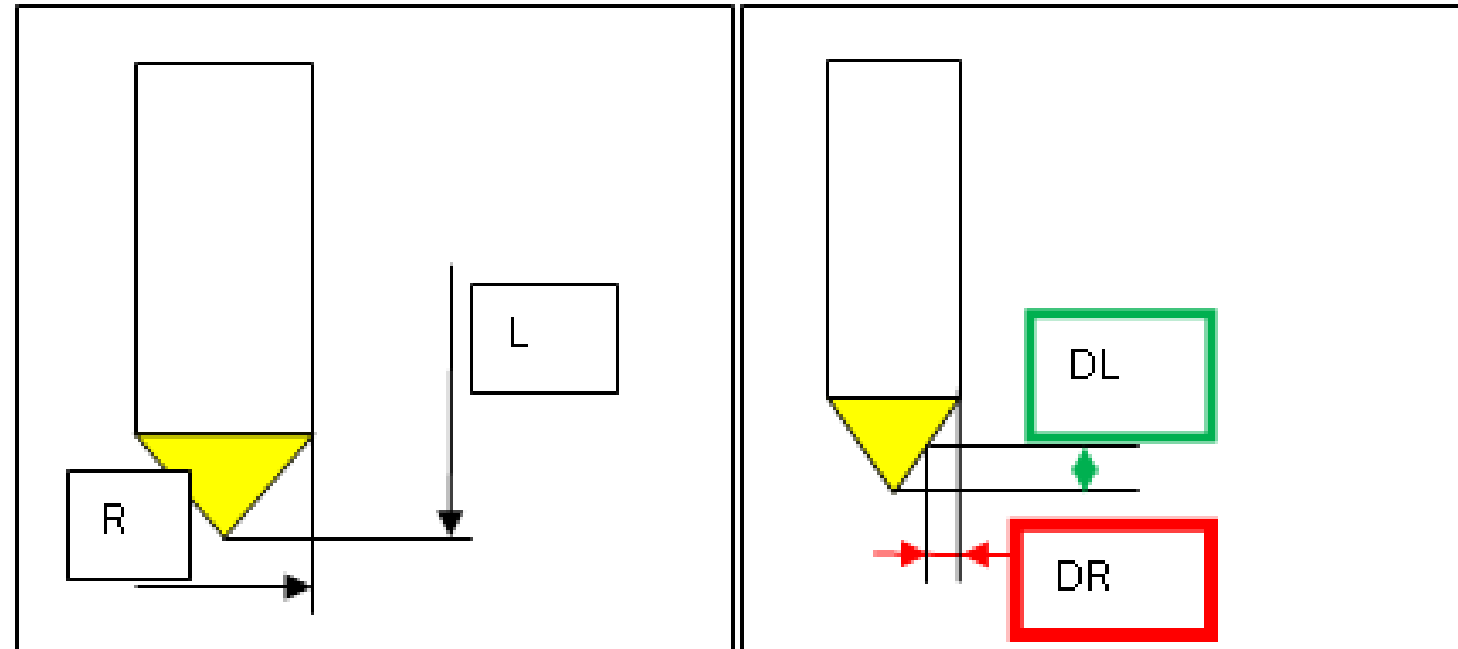# 2 Deburring with NC-drill

Deburring
With NC-drill

■ Measure tool length to theoretical tip

■ External tool radius

■ Contact point can be varied via DL/DR

■ DL+ DR must always give the tool radius

Deburring
With NC-drill

- Contact point can be varied via DL/DR

- Contours/cycles are finished with radius compensation

- Depth corresponds to the chamfer size

3 Attaching chamfer to contour
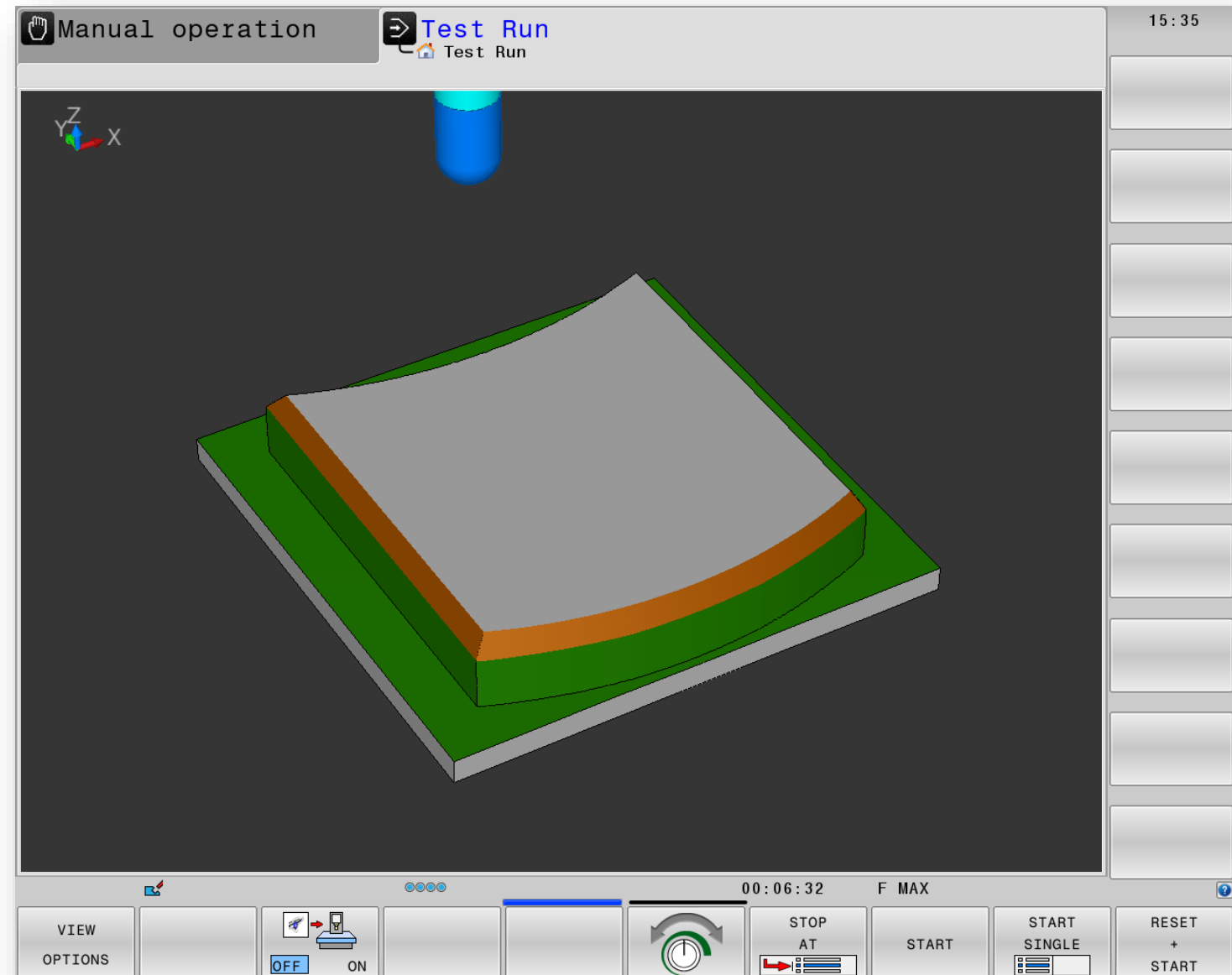
Any bevel angle
along contours

- Finished program example from the NC database

- Fill in charging parameters

- The program calculates all sequences

- The following types of tools can be used:

  end mills, ball end mills or torus mills

- Link:

  https://www.klartext-portal.com/en/tips/nc-solutions/#/en/eintraege/fase-an-kontur-fraesen.html

Klartext

HEIDENHAIN

Milling a chamfer on a contour

NC3255

This NC program is for multipass-milling a chamfer on the upper edge of any contour. The control first machines the contour with Cycle 25. It then mills the chamfer in contour lines. Milling of the contour can be performed with an end mill, a ball-nose cutter, or a toroid cutter. For this purpose, the control reads the radius of the cutting edge from the tool table and calculates the corresponding tool path, without you needing to change anything in the NC program.

Program description

- Description_of_NC_program_3255.pdf
- Tool Table.pdf
- Notes for using the NC-Solutions.pdf

Program files

- 3255_en.h

Control

TNC 640   TNC 620   TNC 320

OK

TNC 410

Any bevel angle
along contours

- Finished program example from the NC database

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- Link:

  https://www.klartext-portal.com/en/tips/nc-
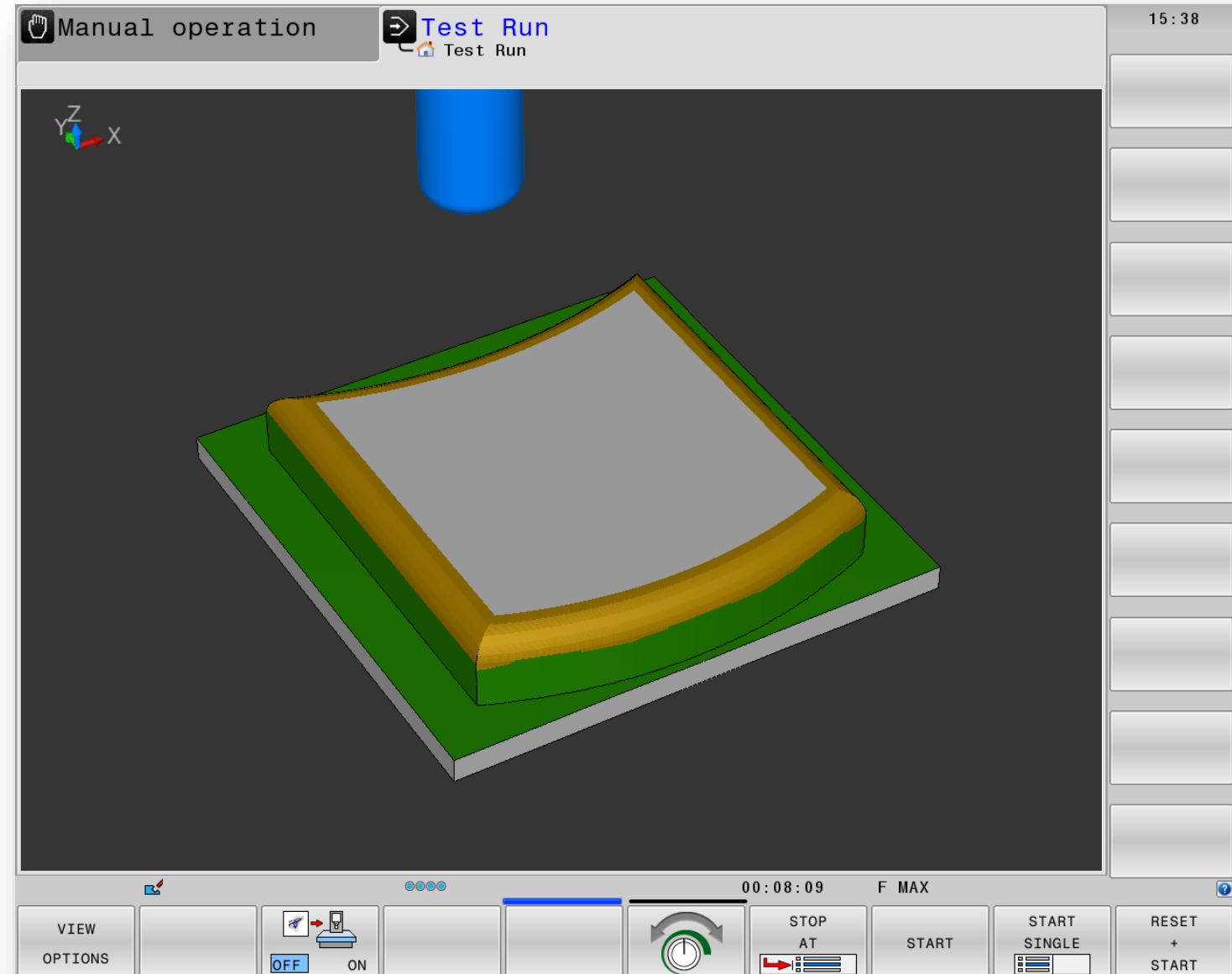
  solutions/#/en/eintraege/fase-an-kontur-

  fraesen.html

4 **Apply radius to contour**

Any radius
along contours

■ Finished program example from the NC database

■ Fill in charging parameters

■ The program calculates all sequences

■ The following types of tools can be used:

end mills, ball end mills or torus mills

■ Link:

https://www.klartext-portal.com/en/tips/nc-solutions/#/en/eintraege/radius-an-kontur-fraesen.html

Any radius
along contours

- Finished program example from the NC database

- Fill in charging parameters

- The program calculates all sequences

- The following types of tools can be used:

  end mills, ball end mills or torus mills

- Link:

  https://www.klartext-portal.com/en/tips/nc-solutions/#/en/eintraege/radius-an-kontur-fraesen.html

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