MM05

数控多轴制造

国际象棋饰品

黄乙杰、何怡佳、赵金烨、张璐

内容：

1 – 小组成员与分工

2 – 产品设计思路草图

3 – 产品设计草图审核与程序生成

4 – 产品加工过程与结果

5 – 课程感受

PART.01

1-小组成员和分工

宣传-黄乙杰

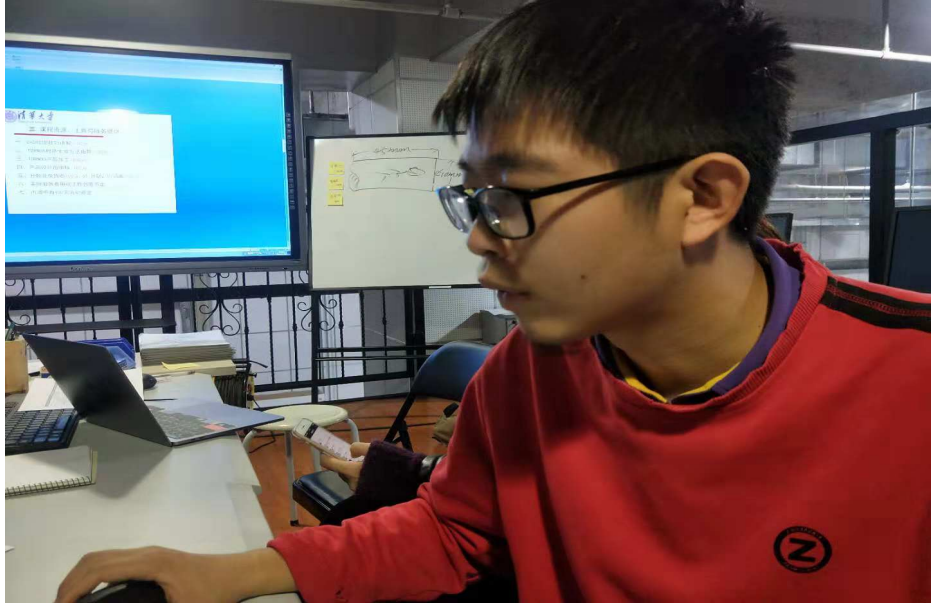
设计-何怡佳

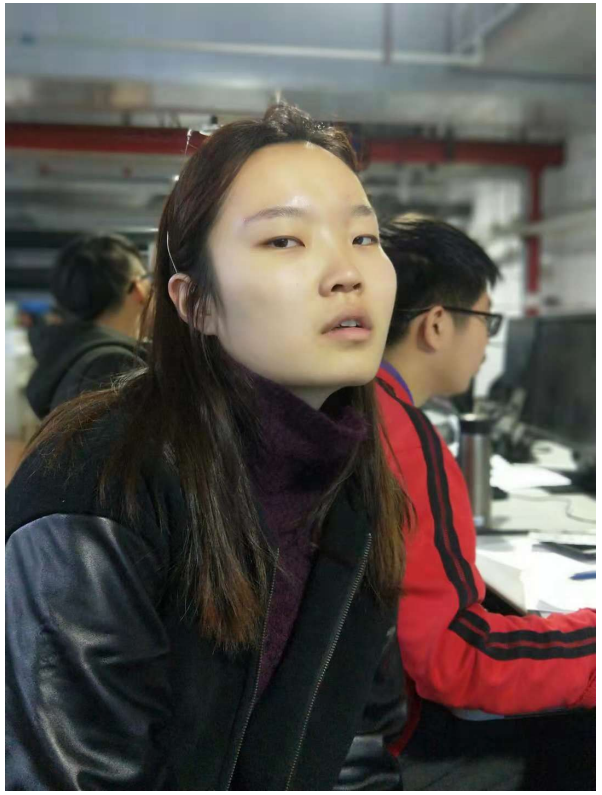
-赵金烨

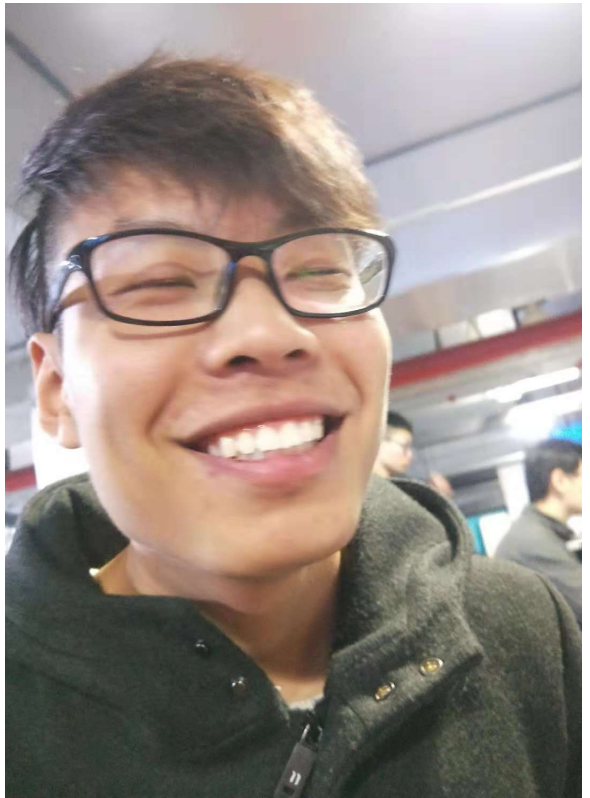
协调-张璐

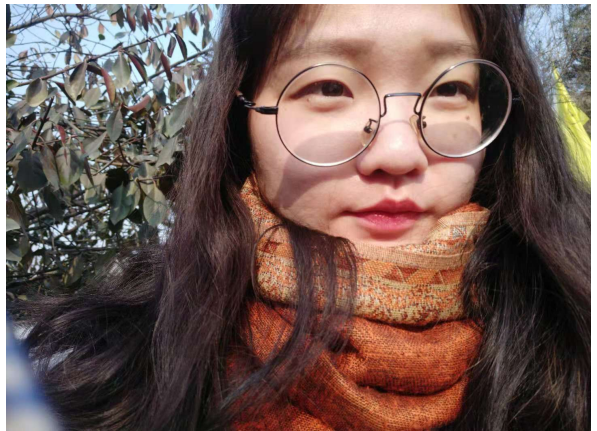
Work hard

Play hard~







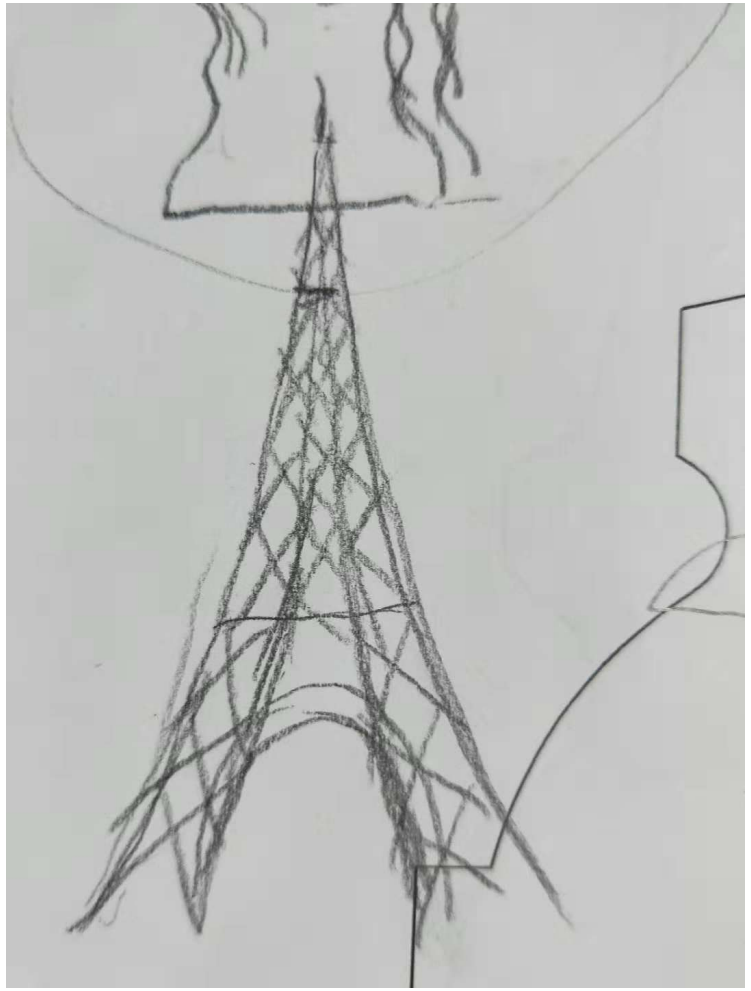


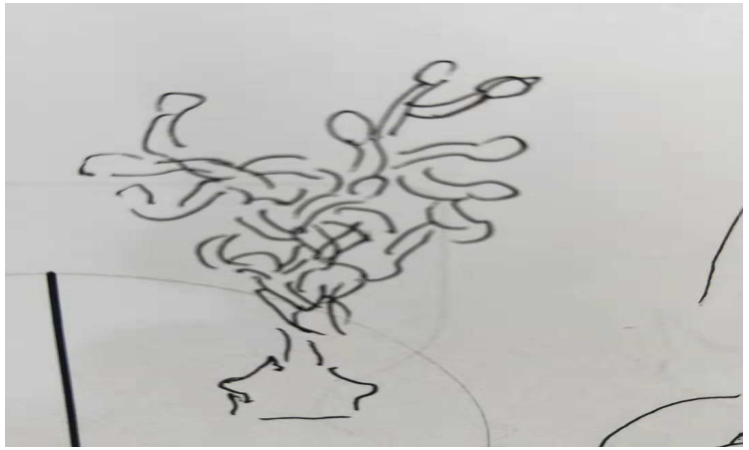
PART.02

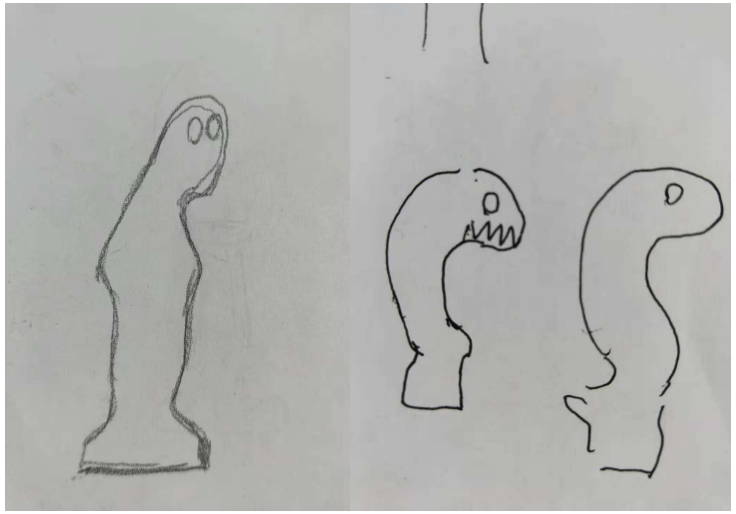
产品设计思路和草图

前期设计思想大风暴

要设计什么样子的国际象棋饰品呢?







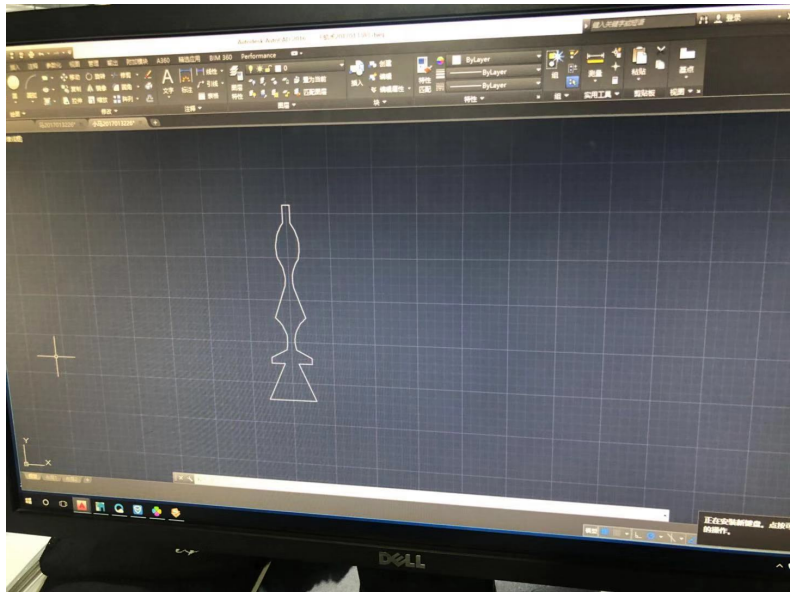
PART.03

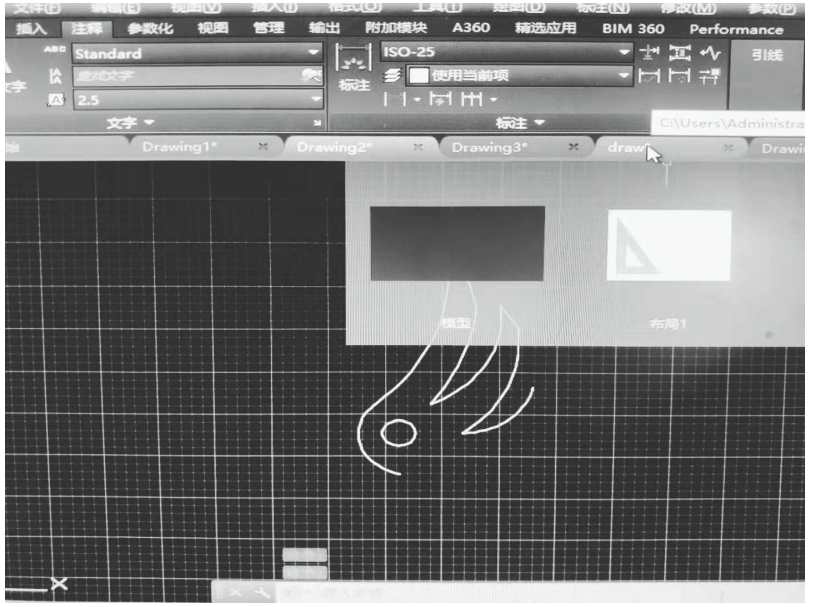
3 – 产品设计草图审核与程序生成

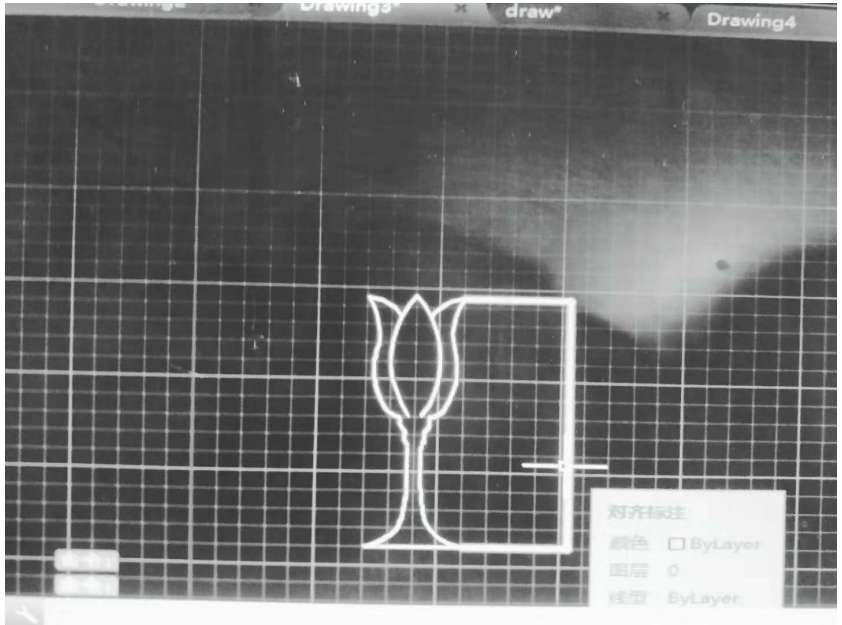
产品设计草图审核

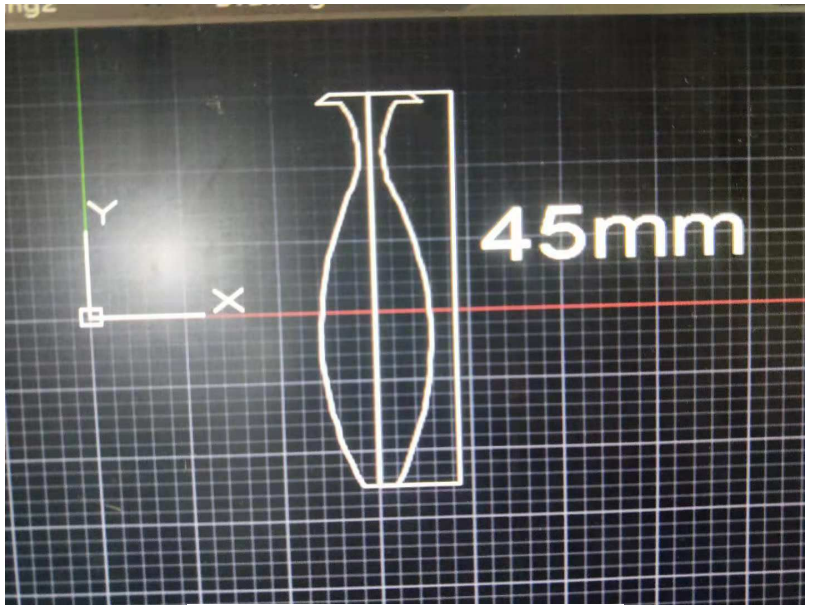
- 这是我们的设计方案

一共四个版本



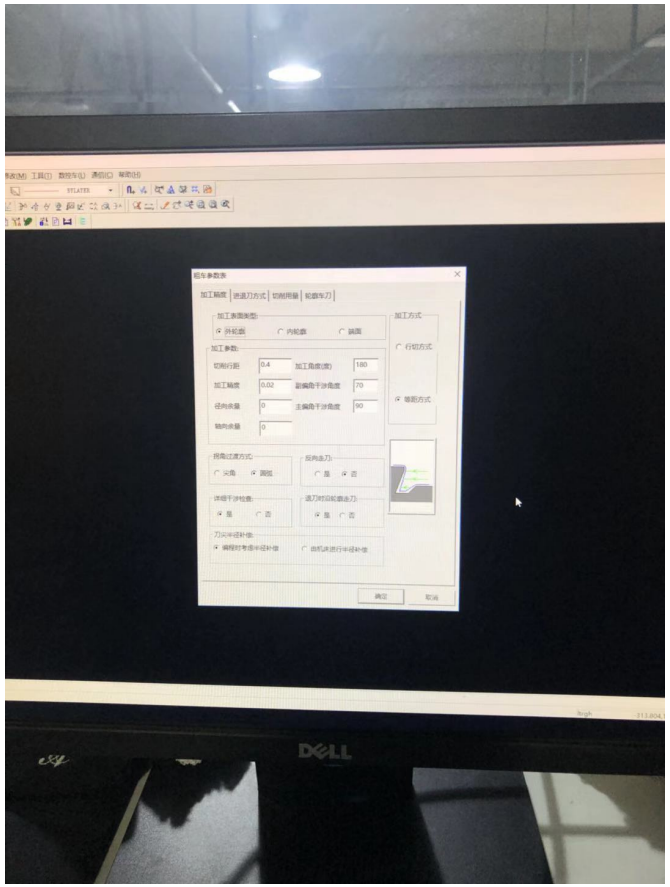






这是我们最终的方案

- 草图拟定好就可以开始程序生成了！



数控编程学习过程

学习—摸索—实践

一 从懵懂得到认识

第二节课上老师指导并讲述了关于数控编程及走刀流程的步骤及知识

上课感受：尽管刚开始接触的时候会有一些迷茫和不知所措，在老师一遍一遍不断反复地耐心讲解下，我们终于明白其原理并可以开始自己亲手尝试制造。

运用与实践

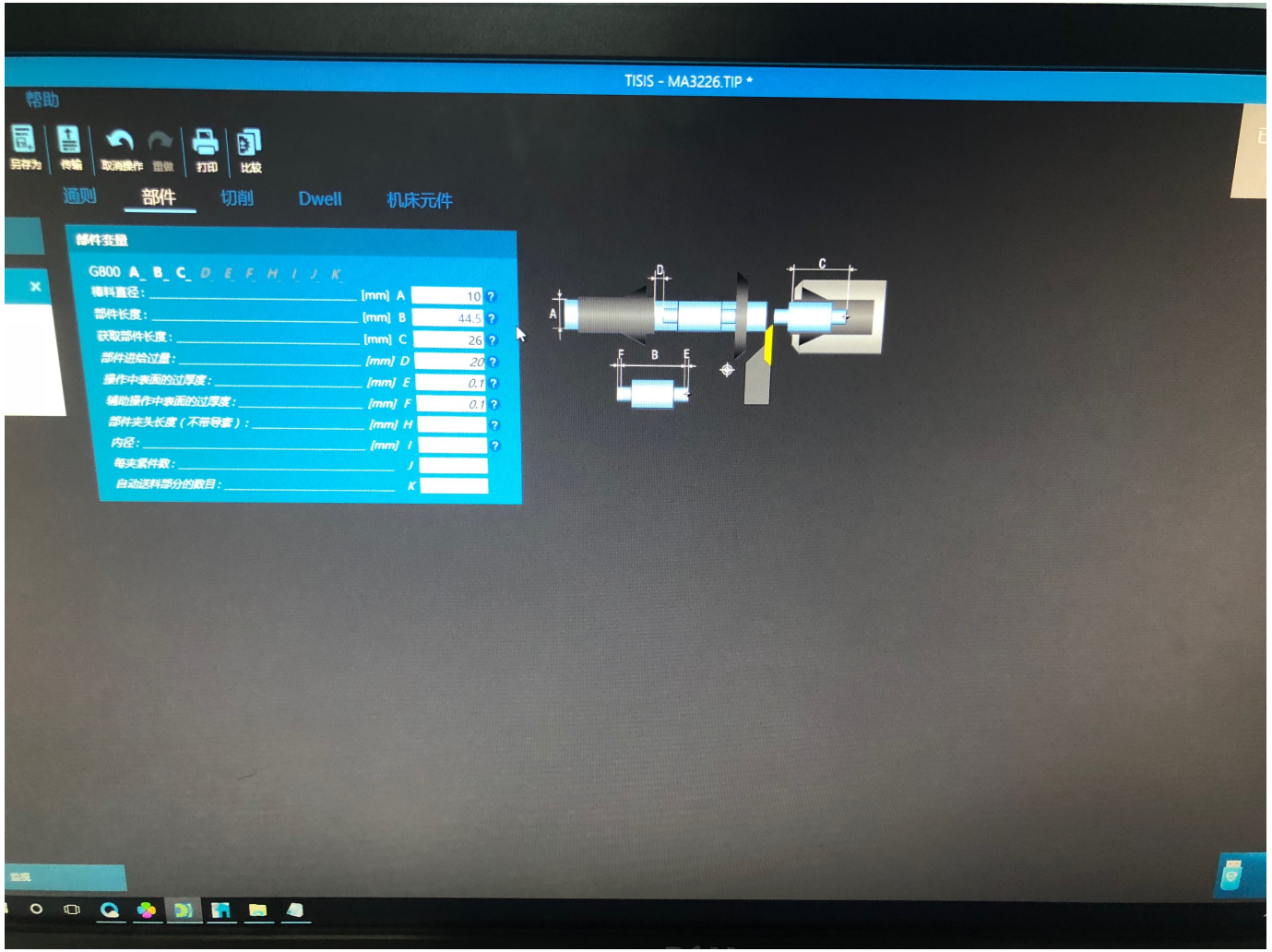
一

在实践的过程中，我们仍然遇到很多问题，反复尝试了以后又询问老师，终于把第一版的棋子设计好了！

但是由于未知力量，在生产和制作环节中我们的作品制作失败，紧接着开始做第二版的编程制作

修改、调整、寻求帮助、修改.....

功夫不负有心人，我们的第二版终于出炉了



PART.04

产品加工过程与结果

I love you more than I've ever loved any woman. And I've waited longer for you than I've waited for any woman.

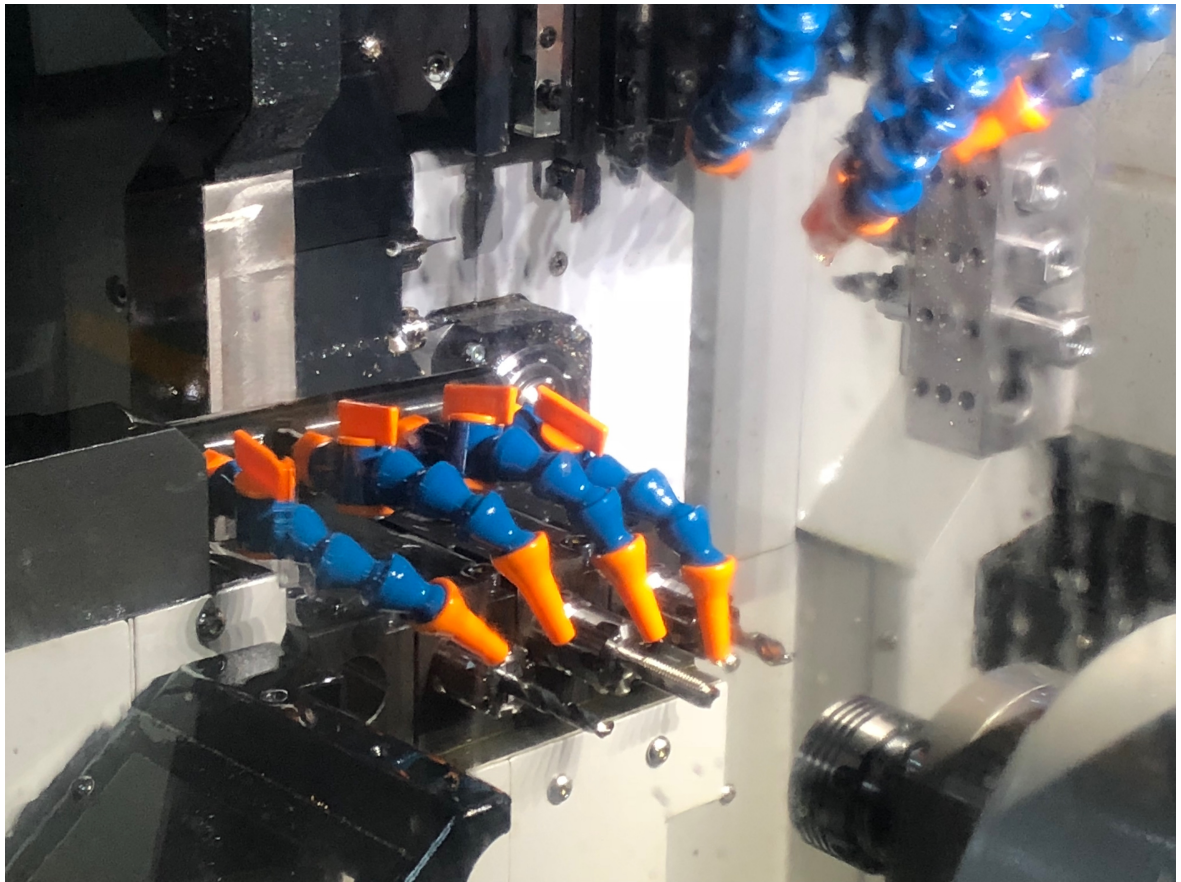
I love you more than I've ever loved any woman. And I've waited longer for you than I've waited for any woman.

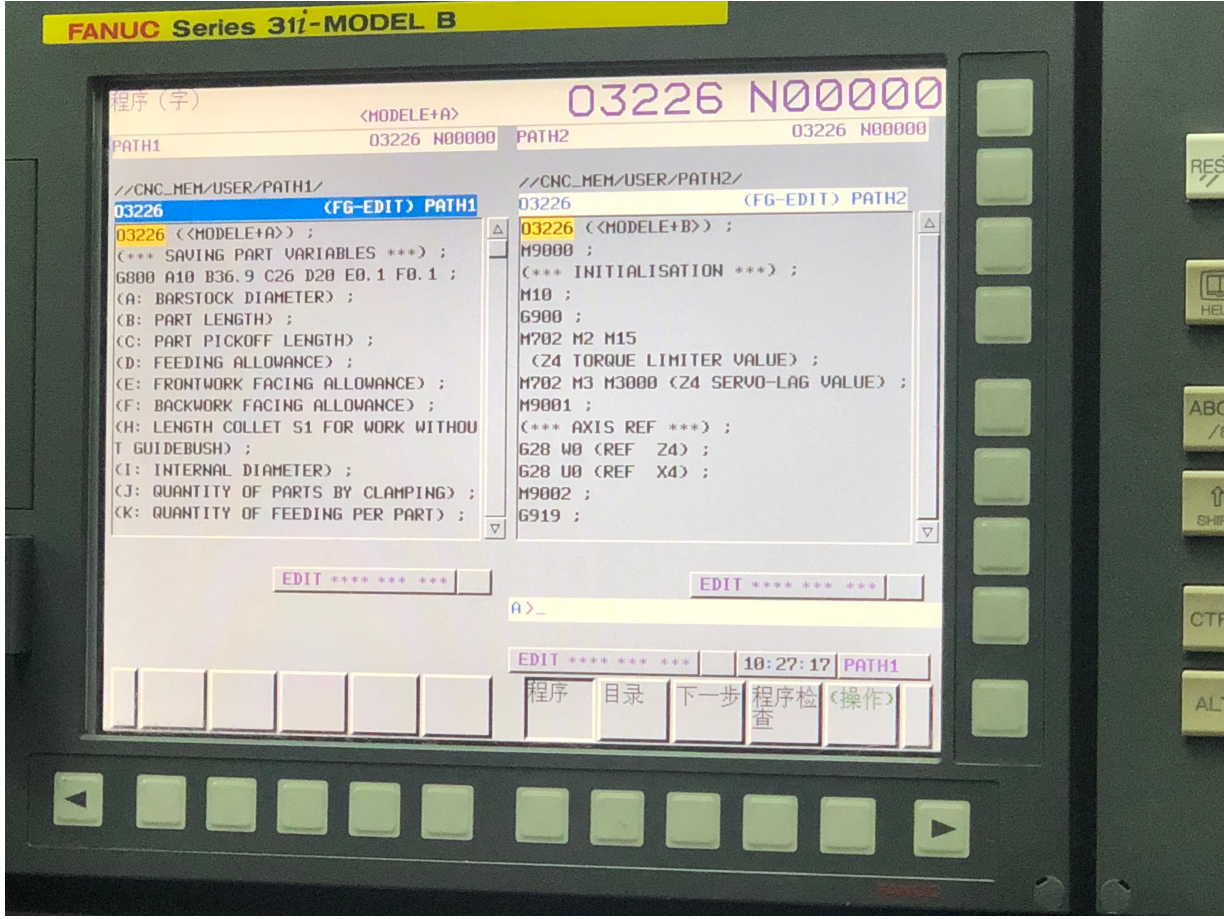
加工第一步

跟随老师去工房，观看及其加工

第二部 打磨

Swiss DT 13




FANUC Series 31i-MODEL B
程序（字）
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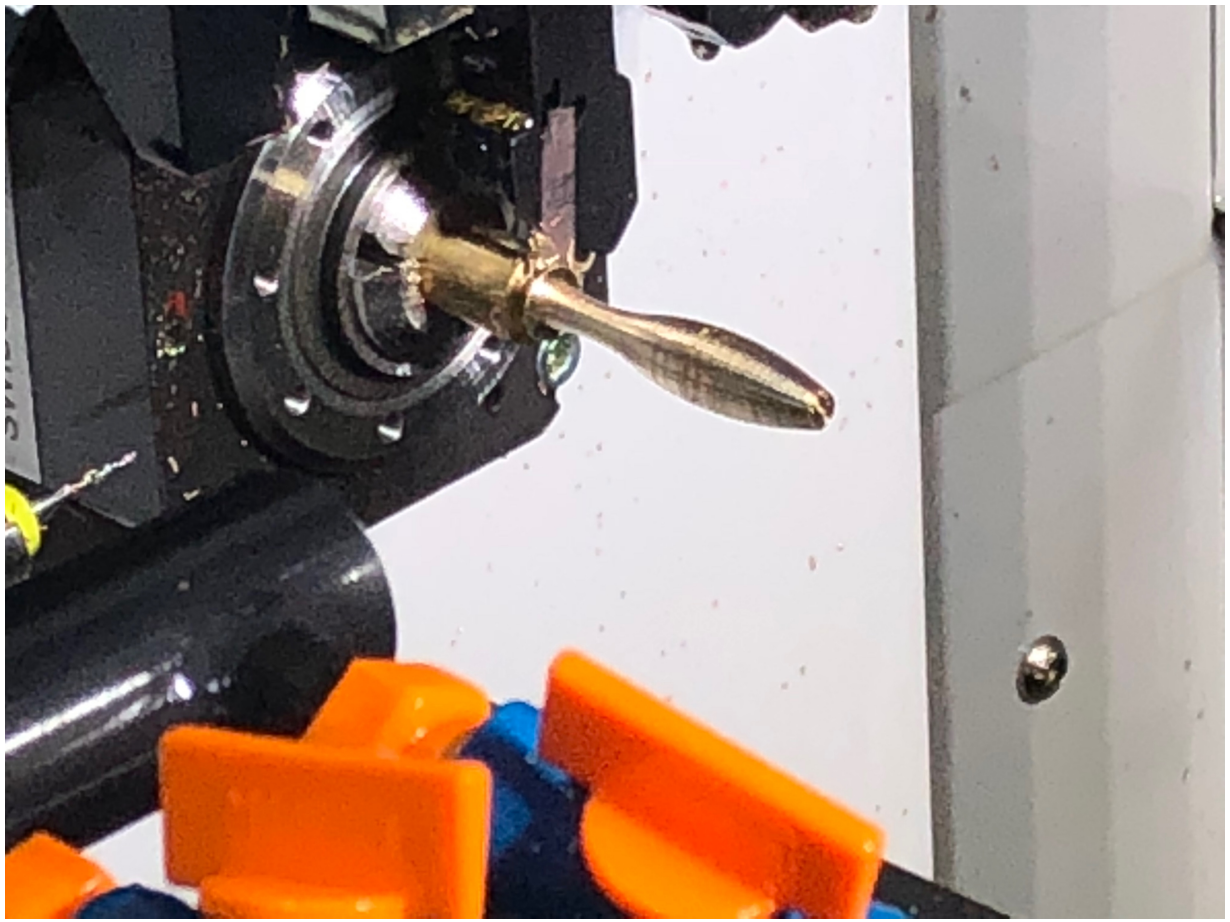
PATH1
03226 N00000
PATH2
03226 N00000
//CNC_MEM/USER/PATH1/
03226
(FG-EDIT) PATH1
03226 (<MODELE+A>) ;
(*** SAVING PART VARIABLES ***) ;
G800 A10 B36.9 C26 D20 E0.1 F0.1 ;
(A: BARSTOCK DIAMETER) ;
(B: PART LENGTH) ;
(C: PART PICKOFF LENGTH) ;
(D: FEEDING ALLOWANCE) ;
(E: FRONTWORK FACING ALLOWANCE) ;
(F: BACKWORK FACING ALLOWANCE) ;
(H: LENGTH COLLET S1 FOR WORK WITHOU
T GUIDEBUSH) ;
(I: INTERNAL DIAMETER) ;
(J: QUANTITY OF PARTS BY CLAMPING) ;
(K: QUANTITY OF FEEDING PER PART) ;
//CNC_MEM/USER/PATH2/
03226
(FG-EDIT) PATH2
03226 (<MODELE+B>) ;
M9000 ;
(*** INITIALISATION ***) ;
M10 ;
G900 ;
M702 M2 M15
(Z4 TORQUE LIMITER VALUE) ;
M702 M3 M3000 (Z4 SERVO-LAG VALUE) ;
M9001 ;
(*** AXIS REF ***) ;
G28 W0 (REF Z4) ;
G28 U0 (REF X4) ;
M9002 ;
G919 ;
EDIT **** *** ***
EDIT **** *** ***
A>_
EDIT **** *** ***
10:27:17
PATH1
程序
目录
下一步
程序检查
(操作)



当心触
DANGER! EL

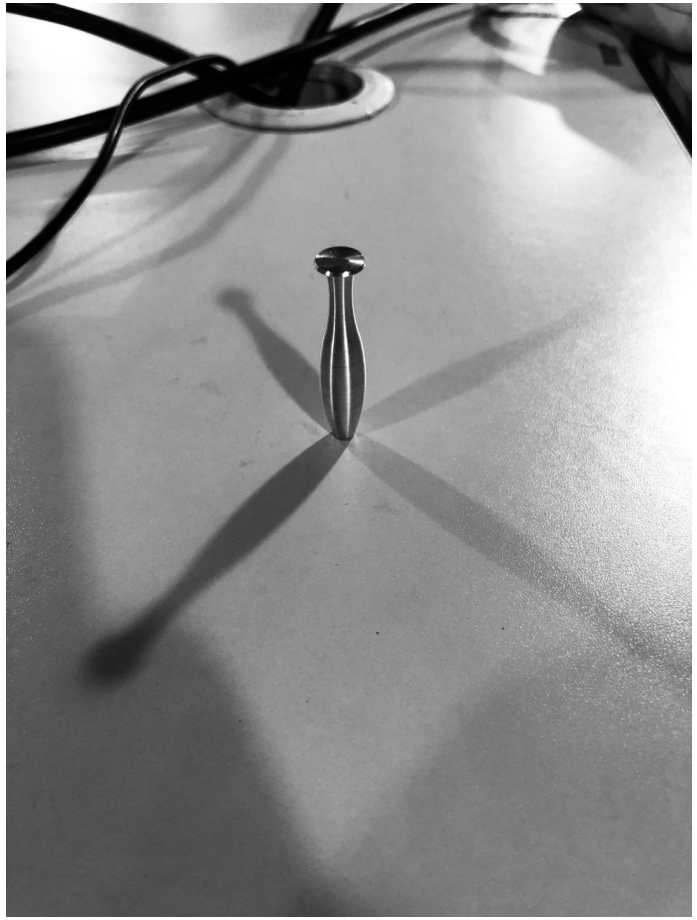
第一个失败品

- 设计的时候没有考虑到实际情况，一味追求美感，产品的脖颈设计过细，导致颤刀，使产品表面凹凸不平。

失败品展示

终于我们的第二版作品制作成功了

这是成功品



课程感想

THE
END

THANK YOU

And I've waited longer for you than I've waited for any woman.