

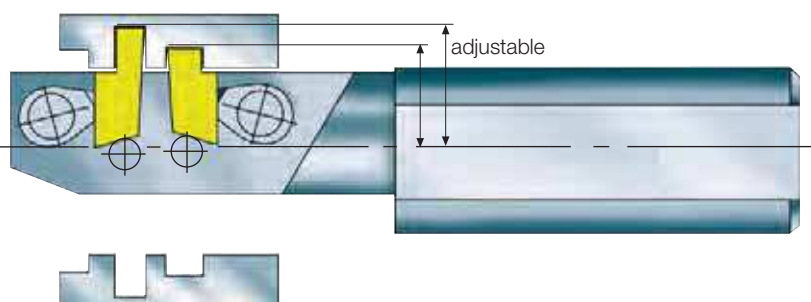
Customer spec. turning tools

Application examples



Application: Camshaft regulator

Workpiece	Camshaft regulator
Material	(DIN) Sint D11 (sintersteel metall)
Tool	Plunging tool for turning machines
Number of teeth	$z = 2$ / effective 1
Insert	acc. to customer specific.
Cutting grade	H06 carbide coated
Cutting speed	$V_C = 220$ m/min ($\varnothing 29.1$)
Number of revolutions	$n = 2.408$ min ⁻¹
Feed rate	$V_f = 241$ mm/min
Feed rate per tooth	$f_z = 0.1$ mm
Depth of cut	~4.5 mm
Coolant	yes, internal coolant



Application: plunge turning - profile recess

Workpiece	Profile shaft
Material	(DIN) 9 S Mn 28K
Tool	Plunging tool
Number of teeth	$z = 2$ / effective 1
Insert	acc. to customer specific.
Cutting grade	H06 carbide coated
Cutting speed	$V_C = 120$ m/min
Number of revolutions	$n = 764$ min ⁻¹
Feed rate	$V_f = 76$ mm/min
Feed rate per tooth	$f_z = 0.1$ mm
Depth of cut	2 mm
Coolant	yes, external

