

# Application example

## Fineboring tools for customer specific tools

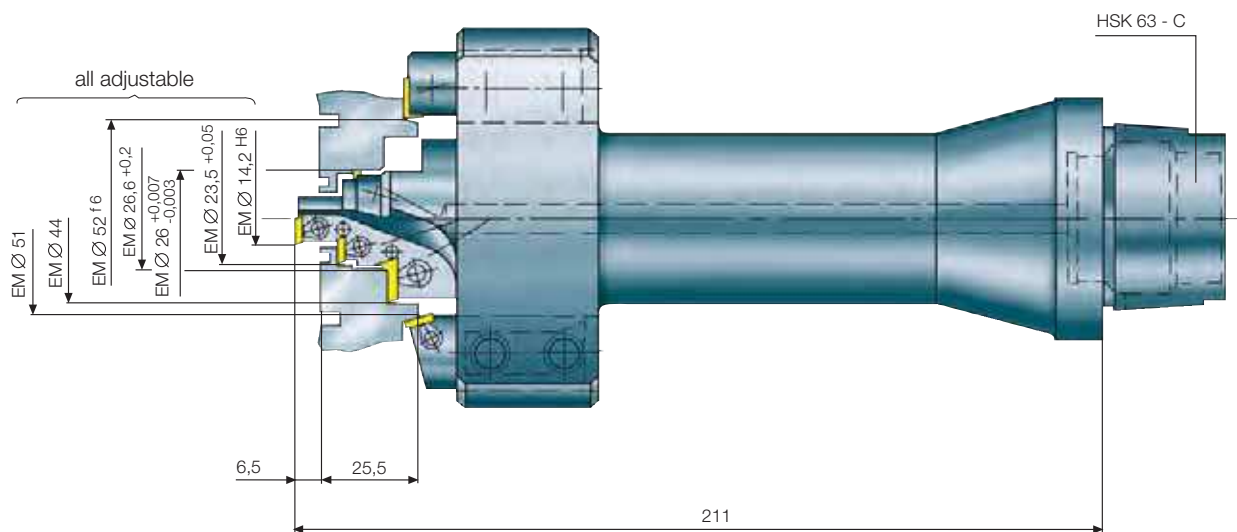
### Application: Gearbox case



Combination tool for 6 machining steps.

All inserts adjustable.

Cartridges for different types of housings exchangeable.



Workpiece	Gearbox case for hand drilling machine
Material	GD - Al Si 9 Cu 3 (DIN)
Tool	Fineboring-, chamfering- and face tool
Number of teeth	6 - effective 1 je Ø
Insert	Standard / acc. to customer specification
Cutting grade	PCD / K10
Cutting speed	$V_C = 800 \text{ m/min}$
Number of revolutions	$4.900 \text{ min}^{-1}$
Vorschubgeschwindigkeit	$735 \text{ mm/min}$
Feed rate per tooth	$f_z = -0.15$
Depth of cut	$0.5 \text{ mm}$
Coolant	yes, internal