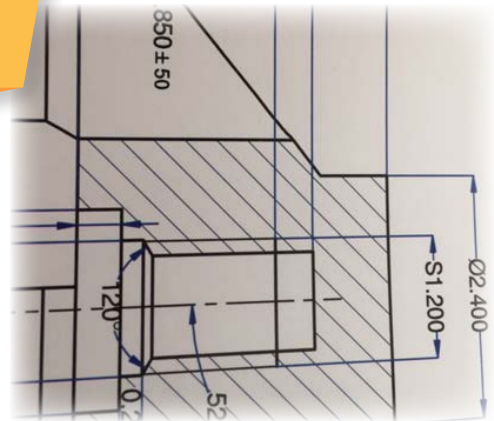


EXAMPLE OF APPLICATION

BLIND HOLE THREAD APPLICATION FIELD : WATCHMAKING



MACHINING

Tool DRILLING THREAD WHIRLERS
DIXI 1737 S 1.20 x 0.25 DRYCUT



MACHINING CONDITIONS

Material	Platinum 950 RU
Machining operation	Blind hole S 1.20 at 1.85» depth
Machine	Multi-axis machining centre (7 axes) Horizontal tapping
Attachment	ER 16 collet on HSK 63 taper
Lubricant	Whole oil
Cutting conditions	Vc = 51 m/min N = 13 559 rpm fz = 0.001 mm/tooth Vf = 40 mm/min

MACHINING PROCESS

1° operation : drilling Ø 1.00 with a flat bottom drill, without centering and without deburring.
2° operation : thread whirling with the DIXI 1737 tool.

1st roughing pass going down with a 0.10mm oversize in relation to the final dimension.
2nd finishing pass upwards.

RESULTS

Threading of 30 holes in the plate with the same whirler.
Result after examination of the tool, no premature wear of the tool.