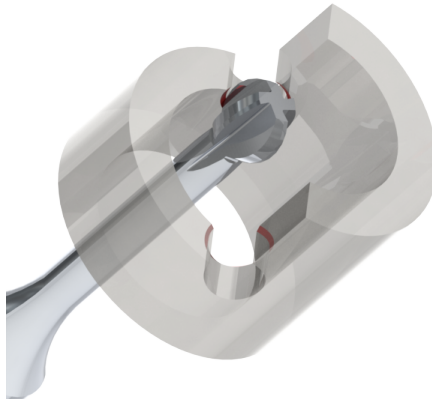


APPLICATION EXAMPLE

SECCANT HOLE CHAMFERING APPLICATION FIELD: TURNING AND DECOLLETAGE



MACHINING

Tool **DIXI 7655 SP** minimal $\varnothing = 1$ mm, maximal $\varnothing = 20$ mm, Z = 4
Cutting tools realised as specials



CUTTING CONDITIONS

Material	All types of materials
Machine	Mon and multi spindle luther, camshaft luther and production centres
Lubricant	Dry or with cooling
Cutting data	40 to 140 m/min Vf as per \varnothing
Life time	According to material Aluminium: 15'000 chamfers Stainless steel: 6'000 chamfers
Limitation	The ratio D/d between main \varnothing and the one of the seccant hole must be > 2

RESULT

Regular chamfer on the whole circumference
Simple setting, single plunging
Width of chamfering according to depth of plunging
No manual chamfering anymore
No complex programming with a ball nose end mill on a milling center