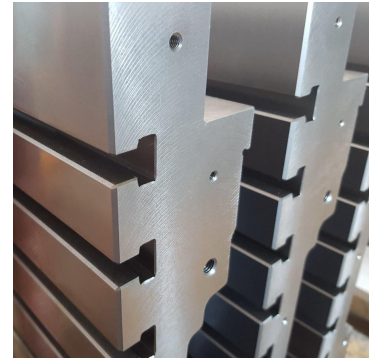
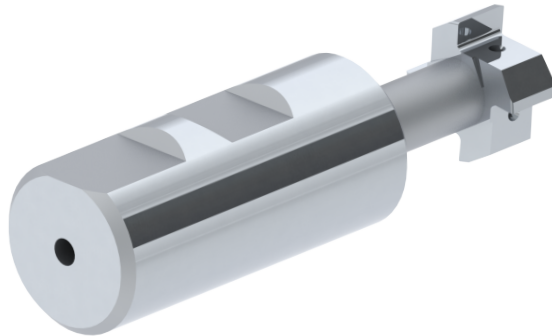


APPLICATION EXAMPLE

T-SLOT CUTTERS

APPLICATION FIELD: MILLING OF MACHINE TABLES



INITIAL SITUATION

Necessity to improve the process of milling the slots of machine tables

MACHINING

Goal	Improve process security Improve cycle time
Tool	T-SLOT CUTTERS DIXI 1516 Ø 21 x 9 x Ø 25 x 75 Z=4 with internal cooling in the flute coolant CUTINOX SP

CUTTING CONDITIONS

Material	GG30			
Machine	Kekeisen UBF 4700			
Cutting data	Old method		New method	
	Milling cutter with inserts		DIXI carbide T-slot cutter	
	Vc 80 m/min	n 1'213 rev/min	Vc 100 m/min	n 1'516 fev/min
fz 0.03 mm	Vf 145 mm/min	fz 0.04 mm	Vf 242 mm/min	

RESULTS

Cycle time: old method: **45 min** per workpiece
 new method: **29 min** per workpiece (35% faster)

Improvement of machining process. Tool life has been increased by 30%.
 Potential for an increase in cutting parameters and performance.