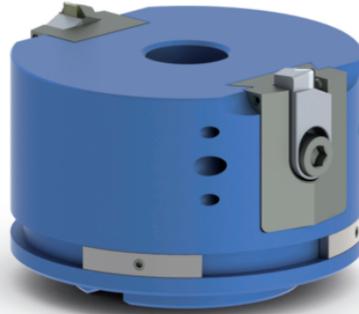


APPLICATION EXAMPLE

PURE COPPER MACHINING

APPLICATION FIELD:
MEDICAL TECHNIQUE



MACHINING

Target	- High requests on surface finish - Very tight tolerances
Tool	DIXI 81000 Ø 60 Surfacing tool for mirror finish with roughing PCD insert and natural diamond finishing insert

MACHINING CONDITIONS

Material	Pure copper CU-HCP
Machine	5 axis Hermle production centre with vacuum table
Lubricant	Emulsion
Cutting conditions	n = 2'000 rpm Vf = 200 m/min ap = 0.5 mm

RESULTS

The tool was used in a finishing process of plates.
The material was already hardened through the heat; therefore it is important to minimize its creation through machining.
This tool allowed to obtain a mirror finish, without machining scraps or marks.
The process allowed substantial gains as polishing end grinding can be removed.