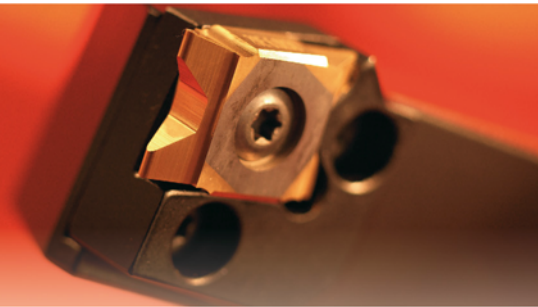


Newsletter



February 2008

QuadCut® CBN External

A range of 12E inserts is now available for immediate delivery.

External metric threads as partial profile with pitches 0.5, 0.75, 1.0, 1.5 and 2.0 mm respectively. Typical order number is 12E 0.5ISO CBN T10

Other profiles and pitches to be quoted.

The CBN edge on the QuadCut insert is made of a well-proven quality from a

leading global supplier of CBN materials.

The CBN inserts are suitable for threading in hardened tool steels of 45-70 HRC.

The minimum possible thread diameters are depending on the pitch. Threads with cutting interruptions, for example safety grooves, can be manufactured when first phased.

Recommended cutting speed V_c is 80-120 m/min.

Flank infeed in Z-axis of 28° is to be used. A constant infeed in X-axis is made with 0.05 – 0.09 mm per pass. The number of passes should be calculated according to the thread depth.

In case of constant cutting the machining can be done dry or wet. With interrupted cutting the machining should be done dry.

New clamping holder for QuadCut® External

This special holder enables threading where space is limited. It is suited for 12E and 12X inserts and has a standard 1.5° Helix angle.

Order number is:
QER 202003K-12-1.5

