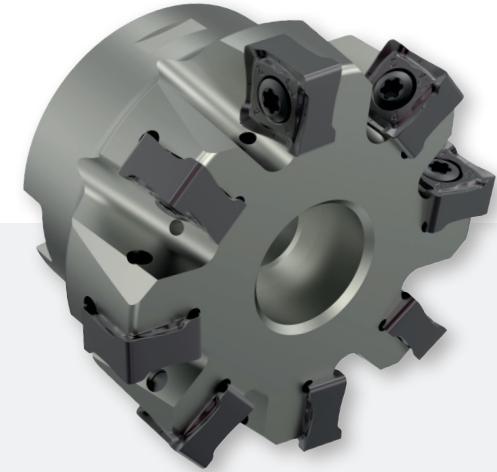
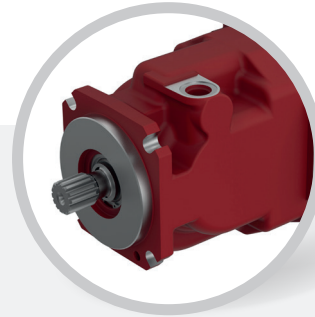


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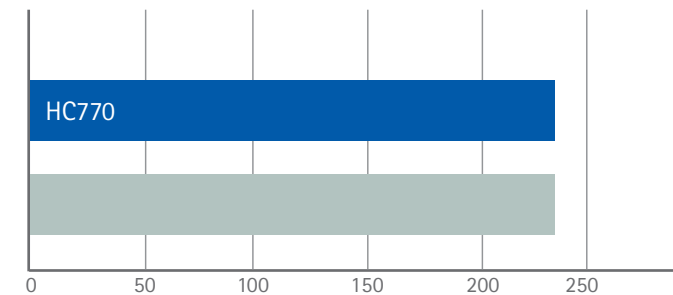
HYDRAULIC PUMP

Pre-machining drive side



	■	■
Material	EN-GJL-300 (GG30)	
Tool	Corner Mill (tangential)	Corner Mill NeoMill®-8-Corner
Insert	Tangential	SNMU120508R-M05-HC770
Tool-Ø [mm]	63	
Tooth t	8	
Cutting edges per insert	4	8
Coolant	Air	
v_c [m/min]	336	272
f_z [mm]	0,18	0,64 / 0,31
v_f [mm/min]	2.500	7.060 / 3.400
a_p [mm]	12,45	7 / 5,45
a_e [mm]	15 - 43	3,5 / 15 - 43
Number of cuts	1	2

Machined parts



- Cycle time neutral despite 2 cuts
- Cutting division results in fewer cutting forces, which lead to lower form and position tolerances
-> better component quality
- CPP was reduced by 64 %