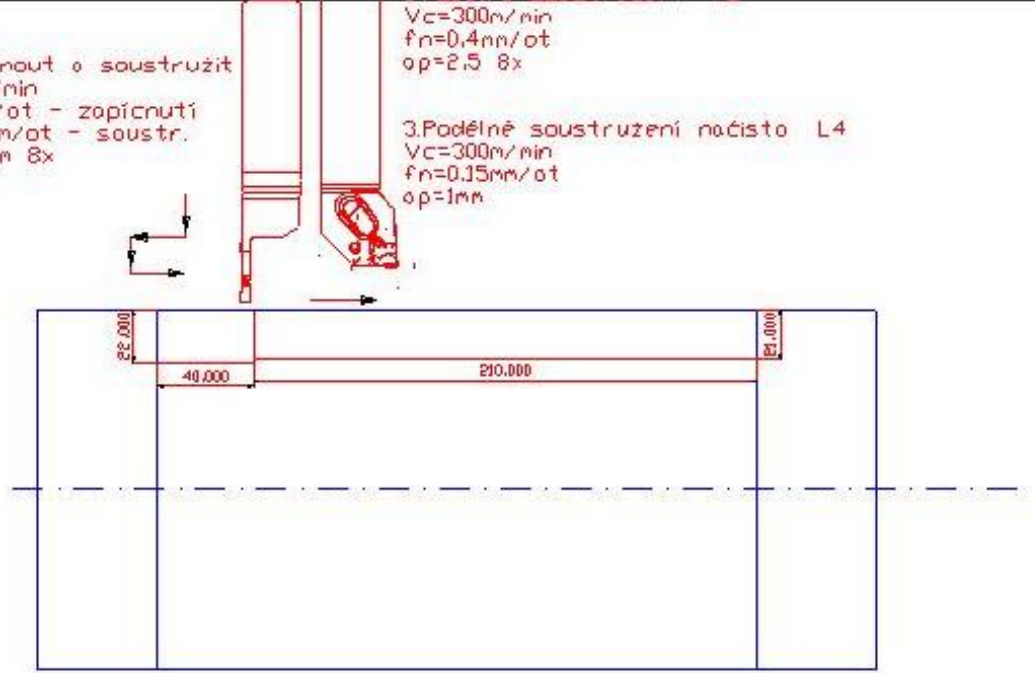
Seminář Kovosvit MAS 9.6.2016;

1. Zapíchnout o soustružit
Vc=180m/min
fn=0.1mm/ot - zapíchnutí
fn=0.25mm/ot - soustr.
op=2,75mm 8x

Vc=300m/min
fn=0,4mm/ot
op=2,5 8x

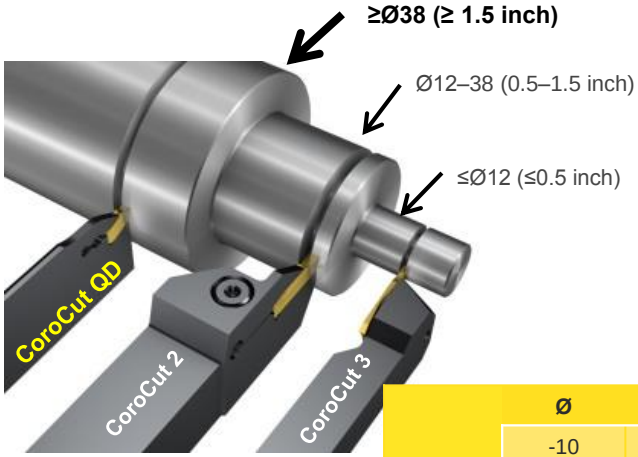
3.Podélné soustružení načisto L4
Vc=300m/min
fn=0,15mm/ot
op=1mm



Systémy Sandvik- vnější

Positioning

- Lathes
  - CoroCut QD should be used in grooves deeper than where the two edges of a CoroCut 2 insert can be used
  - For bar feed machines with bars 38 mm (1.5 inch) and larger



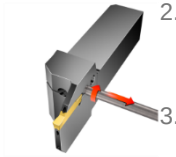
Recommended parting widths	Ø	CW
	-10	1
	10-25	1.5
	25-40	2
	40-50	2.5
	50-65	3

Technical features

CoroCut® 1-2

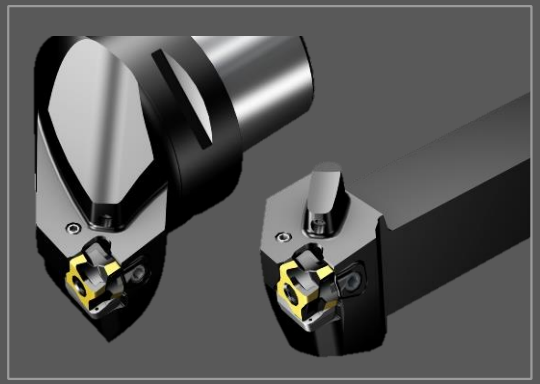
- Stable spring clamping

1. Patented spring clamping for highest rigidity and clamping force accuracy
2. Rail insert seat ensures stable and precise insert position

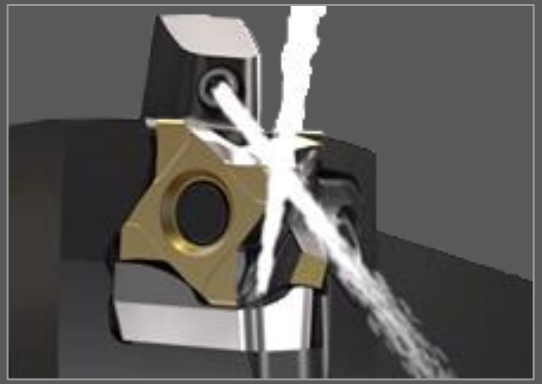


3. No torque wrench needed – always correct clamping with quick-release key
    - Same key as for CoroCut QD tools with larger inserts
    - Always correct clamping force!
    - Two key slots improves access with key
    - Key to be supplied with the tool

Chip control and handling efficiency



Coromant Capto® interface or QS™ shanks enable quick tool change and easy coolant connection for maximized production time

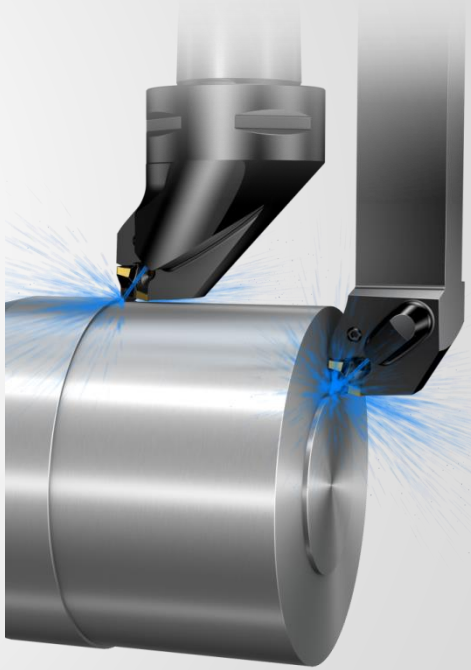


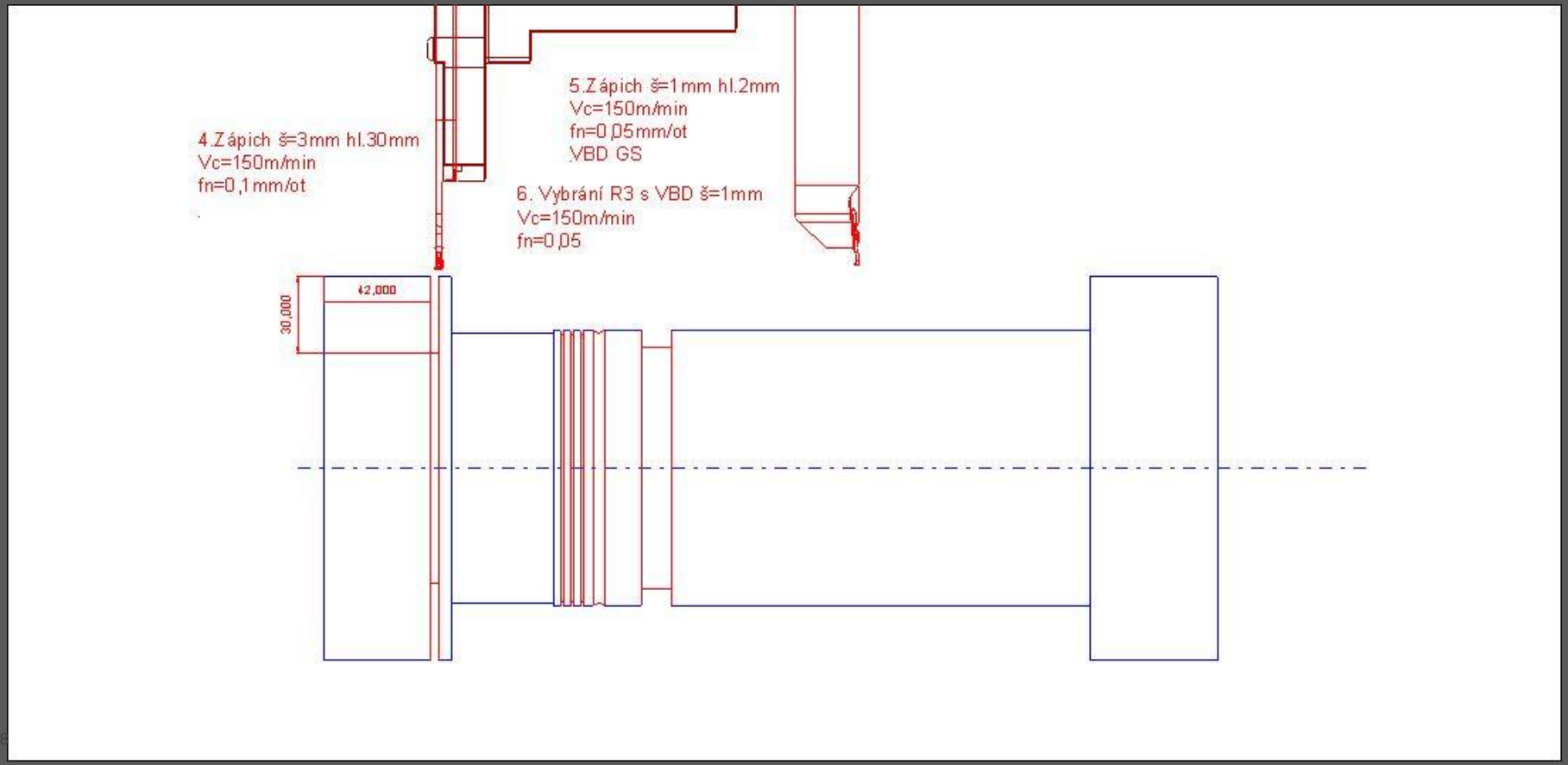
High precision coolant ensures good chip breaking for secure machining, while under coolant controls the temperature for long and predictable tool life

Application

Positioning

- Longitudinal and face turning
- Medium to finishing
- ISO P
- Machine types: turning centres and multi-task machines
- L4, nose radii 08: Excels in a_p 0.5–3 mm (.020–.118 inch) and f_n between 0.12–0.32 mm/r (.005–.013 inch/rev)
- L4, nose radii 12: Excels in a_p 0.65–3 mm (.026–.118 inch) and f_n between 0.15–0.35 mm/r (.006–.014 inch/rev)
- M5, nose radii 08: Excels in a_p 0.8–3.8 mm (.031 –.150 inch) and f_n between 0.2–0.45 mm/r (.008–.018 inch/rev)
- M5, nose radii 12: Excels in a_p 1.2–3.8 mm (.047–.150 inch) and f_n between 0.25–0.55 mm/r (.010–.022 inch/rev)

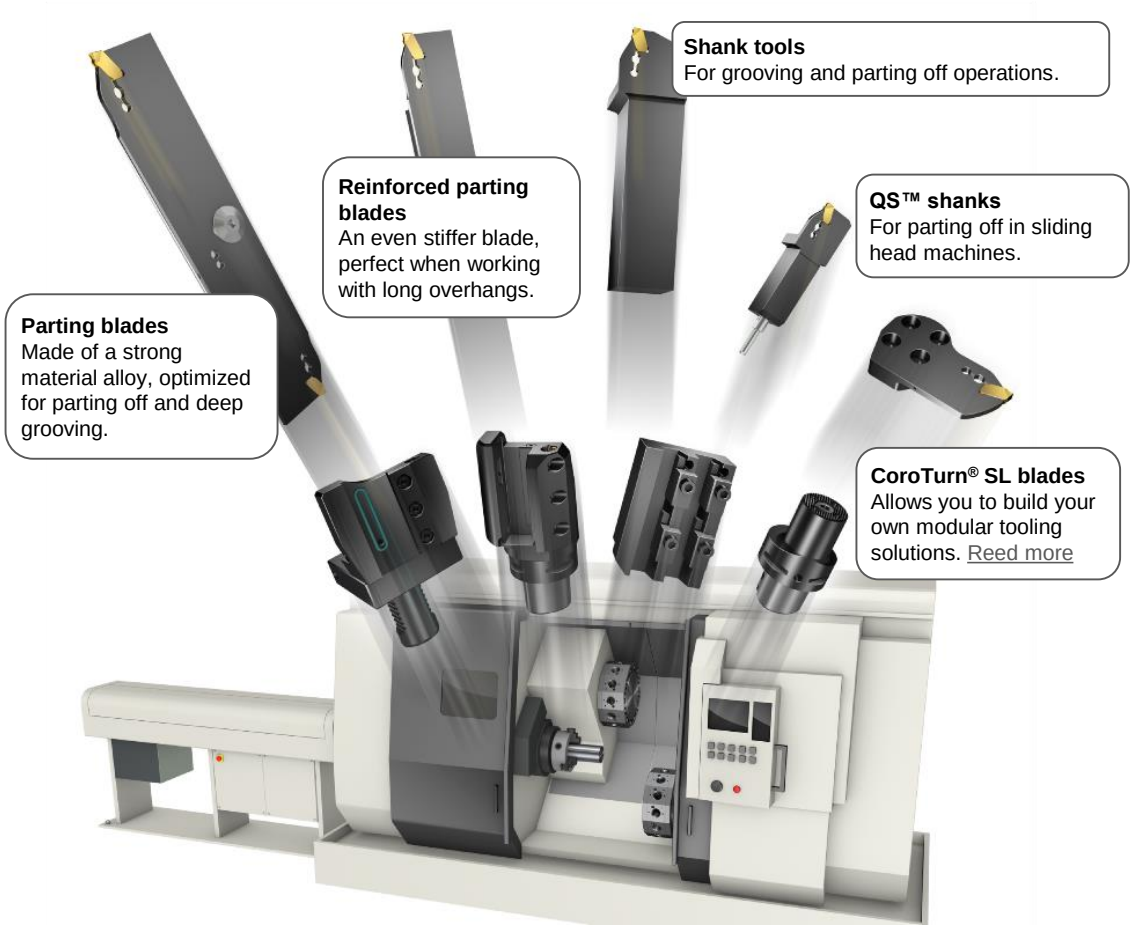



4.Zápich š=3mm hl.30mm
Vc=150m/min
fn=0,1mm/ot
5.Zápich š=1mm hl.2mm
Vc=150m/min
fn=0,05mm/ot
VBD GS
6. Vybrání R3 s VBD š=1mm
Vc=150m/min
fn=0,05
42,000
30,000

CoroCut® QD

Unrivalled reliability and maximum effectiveness

CoroCut® QD is the strongest and most advanced parting and grooving system on the market. When parting off or machining deep grooves without compromising process security or machining efficiency – CoroCut QD is your option, regardless of the material to be machined, or the machine type standing in your workshop.



CoroCut® QD

Insert- and blade width up to 8 mm

The inserts and parting blades are now thicker than ever – perfect when you need to remove high amounts of stock in the widest and deepest grooves or pockets.

More adaptors for parting blades

The wide assortment of plug and play adaptors for easy coolant connection is extended with machine specific adaptors.

More information in Supplement 15.1, chapter G

Extended Tailor Made offer for inserts and tools

www.sandvik.coromant.com/tailormade

Insert grade GC4325

Equipped with Inveio™ – these inserts offer high wear resistance and long tool life in steel and cast iron applications.

Inveio™
Uni-directional crystal orientation

CoroCut 3