

Numerical Control Lathe Shaft Machining Image

1. External Roughing

Internal Coolant
Excellent Chip Control and Longer Tool Life

DCLNL2525M-12JCT
CNMG120408PG
(CA025P)

$V_c=250\text{m/min}$
 $a_p=1.0 \sim 2.5\text{mm}$
 $f=0.40\text{mm/rev}$



2. External Finishing

High Speed Machining
with CVD Coated Cermet

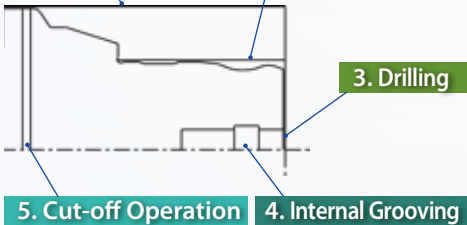
PVPNL2525M-16Q
VNMG160408L-VC(CCX)

$V_c=500\text{m/min}$
 $a_p=0.5 \sim 1.0\text{mm}$
 $f=0.2\text{mm/rev}$



Workpiece: **SCM415**
Ø70 × 100L

1. External Roughing 2. External Finishing

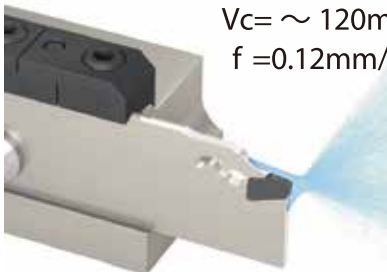


5. Cut-off Operation KPK

Unique Design for Superior Performance
in Cut-Off Operations

KPKB32-3JCT
PKM30N-025PM (PR1625)

$V_c \sim 120\text{m/min}$
 $f=0.12\text{mm/rev}$



4. Internal Grooving SIGC

Newly Developed Clamping System
Ensures a Firm Insert Hold.
Excellent Chip Evacuation

SIGCL0812-EH
GC08L200-010 (PR1725)

$V_c=80\text{m/min}$
Groove depth = 1.0mm
 $f=0.03\text{mm/rev}$



3. Drilling DRA

Excellent Hole Accuracy with
a Low Cutting Force Design

SF16-DRA100M-3
DA1000M-GM (PR1525)

$V_c=100\text{m/min}$
 $H=20.0\text{mm}$
 $f=0.1\text{mm/rev}$

