

Точение.

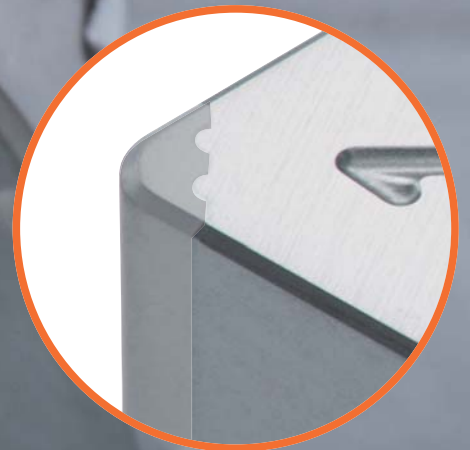
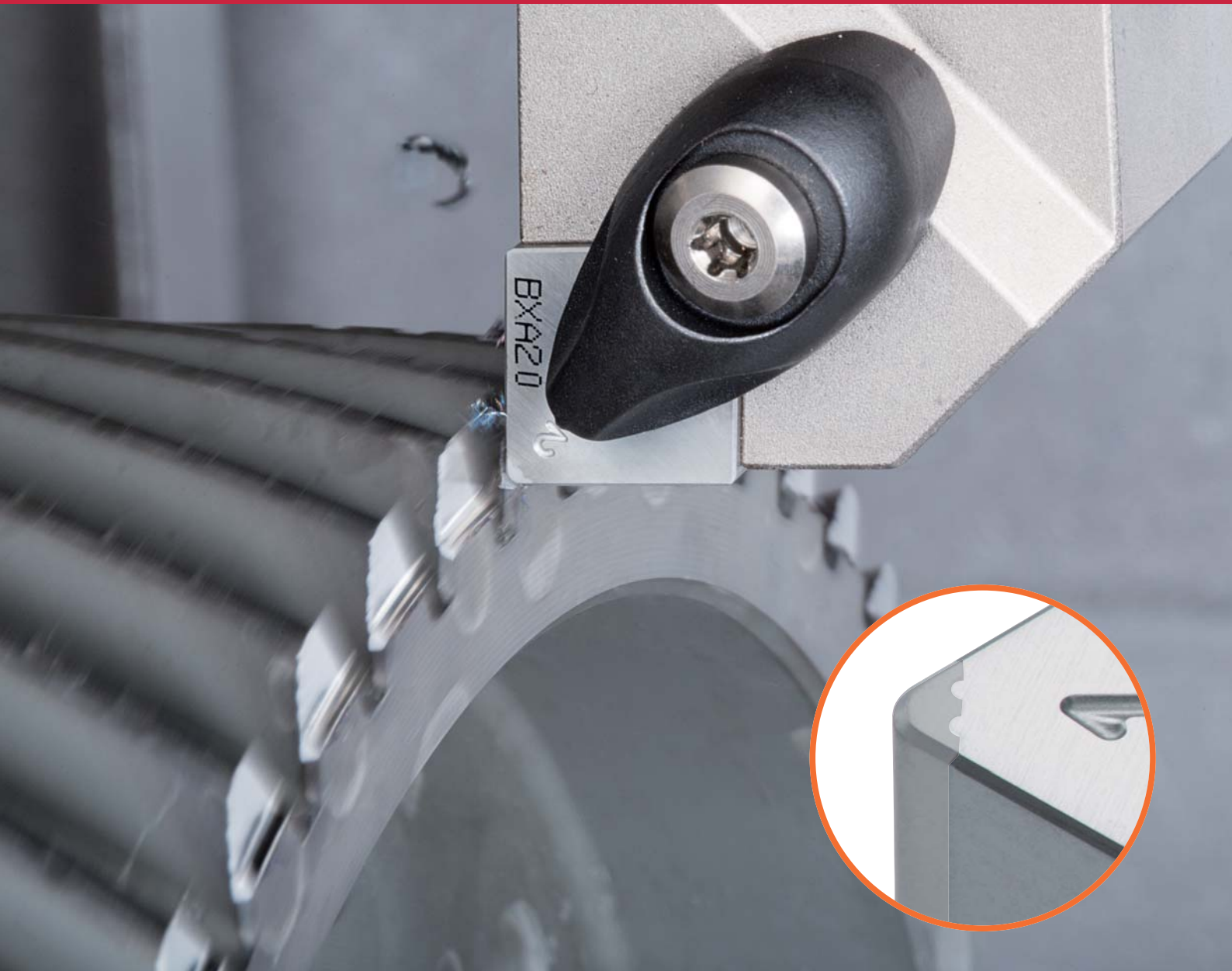


T-CBN SERIES

www.tungaloy.com

Tungaloy Report No. 515-G

CBN with **WavyJoint** technology achieves stable machining of hardened steels



INDUSTRY 4.0
FEED the SPEED!

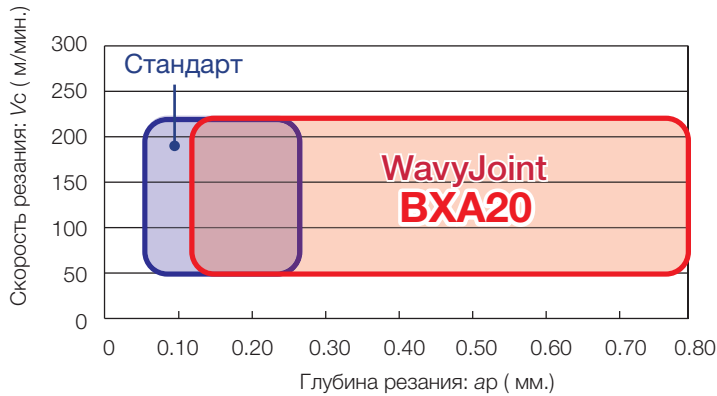


ACCELERATED MACHINING



Применение.

Твердое точение.



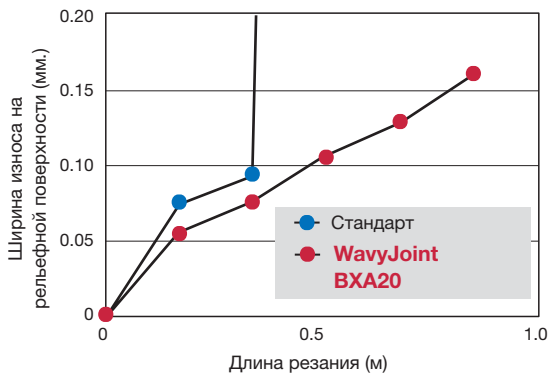
H

WavyJoint BXA20

Great performance for continuous to heavy interrupted cutting at low and medium speeds.

Производительность обработки.

Влияние увеличения площади пайки



H

Пластина : Стандарт = 2QP-CNGM12408-HM BXA20
 WavyJoint = 4QS-CNGG120408-HM BXA20
 Workpiece material : SCM420 / 20CrMo4 (60HRC) ø63 наружное точение
 Cutting speed : $V_c = 150$ м/мин.
 Feed : $f_z = 0.20$ мм/об.
 Depth of cut : $a_p = 0.75$ мм.
 Coolant : без СОЖ



Стандарт



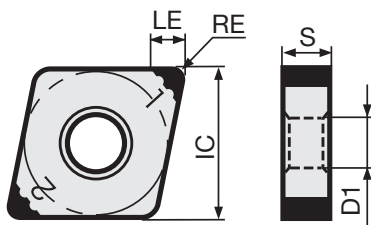
WavyJoint BXA20

The WavyJoint technology prevents the braze from overheating due to the increase in cutting edge temperature during dry cutting, greatly improving the brazing strength. The result: stable machining and extended tool life.

Пластины.

Feature	Shape	Обозначение	Сплав	No. of corners	I. C. dia.	Thick-ness	Hole dia.	Corner radius	CBN length
			Coated						
			BXA20						
					IC	S	D1	RE	LE
Heavy horning		4QS-CNGA120408-H	●	4	12.7	4.76	5.16	0.8	1.5
		4QS-CNGA120412-H	●	4	12.7	4.76	5.16	1.2	1.7
With chipbreaker		4QS-CNGG120408-HM	●	4	12.7	4.76	5.16	0.8	1.5
		4QS-CNGG120412-HM	●	4	12.7	4.76	5.16	1.2	1.7
Heavy horning		4QS-DNGA150408-H	●	4	12.7	4.76	5.16	0.8	1.6
		4QS-DNGA150412-H	●	4	12.7	4.76	5.16	1.2	1.6
With chipbreaker		4QS-DNGG150408-HM	●	4	12.7	4.76	5.16	0.8	1.6
Heavy horning		6QS-TNGA160408-H	●	6	9.525	4.76	3.81	0.8	1.6
		6QS-TNGA160412-H	●	6	9.525	4.76	3.81	1.2	1.8
With chipbreaker		6QS-TNGG160408-HM	●	6	9.525	4.76	3.81	0.8	1.6
Heavy horning		4QS-VNGA160408-H	●	4	9.525	4.76	3.81	0.8	1.7
With chipbreaker		4QS-VNGG160408-HM	●	4	9.525	4.76	3.81	0.8	1.7
Heavy horning		6QS-WNGA080408-H	●	6	12.7	4.76	5.16	0.8	1.5


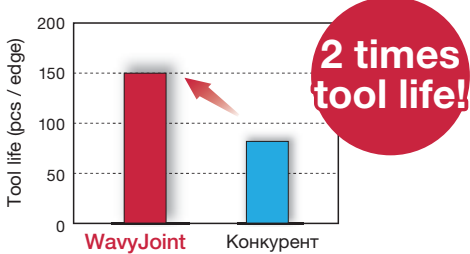
● : Line-up



СТАНДАРТНЫЕ РЕЖИМЫ РЕЗАНИЯ.

ISO	Обрабатываемый материал	Сплав	Условия работы	Скорость резания Vc(м/мин.)	Глубина резания ap (мм.)	Подача f (мм/об.)
H	Термообработанная сталь	BXA20	непрерывный	50 - 220	0.12 - 0.80	0.10 - 0.30
		BXA20	прерывистый	50 - 200	0.12 - 0.80	0.10 - 0.20

ПРАКТИЧЕСКИЕ ПРИМЕРЫ

Деталь	Деталь автомобиля
Пластина	4QS-CNGA120412
Сплав	BXA20
Workpiece material	SCM420 / 20CrMo4 (60HRC)
	 H
Cutting conditions	Cutting speed : Vc (m/min)
	Feed : f (mm/rev)
	Depth of cut : ap (mm)
	Coolant
Результат	 <p>2 times tool life!</p> <p>The WavyJoint technology insert successfully machined 150 pcs/corner, almost twice that of the competitor's, without CBN tip failure.</p>

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