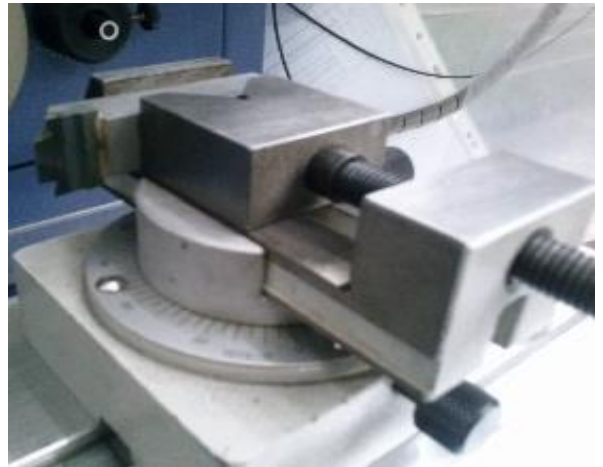


GRP reinforced plastic turning with PCD inserts or cutting tools

Tool Specification: U4788 UT. EST. 20X15X70 PYD34

Application:

- Turning:** Profiled grooved creep feed
Workpiece: Plastic bearing or roll, like photo below:
Material: Reinforced plastic with GRP



Machine:

- Model:** CNC or automatic lathe
Spindle power: 5 kW
Coolant: oil
Pressure: 3 bar

Parameters:

- Speed of cut:** 140 m/min
Feed: 200 mm/min

Note:

The face of the tool has a rake angle in order to help the cut, the cutting edge is sharpened by a diamond wheel. This material is very abrasive so conventional carbide cutting tool has a short lifetime.

For reinforced plastic rings with diameter less than \varnothing 100 mm sintered with a profile (so the total removal is less than 1mm), the contact workpiece-tool last 1 or 2 seconds, you can save setup time with a PCD tool, with a 10 times smaller wear than carbide.

Very important is the surface quality on the cutting edge, in order to avoid a too coarse surface on your workpiece.

CAFRO s.r.l.

via Raimondi 55 - 22073 Fino Mornasco (CO) - Italy - **T** +39 031 880150 - **F** +39 031 880260 - **E** cafro@cafro.com - www.cafro.com
Capitale Sociale € 26.000 i.v. - Registro delle Imprese di Como - C.F. e P.I. IT 01728350131 - R.E.A. 212258 - CCE M. CO 010058