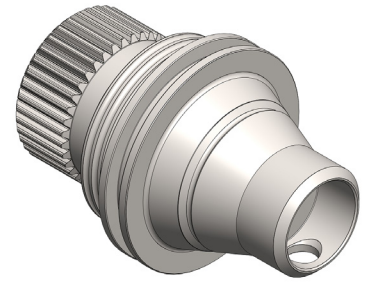


Competent support from Schwanog:

Complete tool design for your turned parts!



Manufacturers of turned parts who, for example, expand their range of parts or open new industries are often pleased to have competent support for tool design.

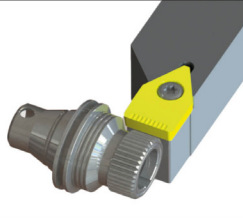


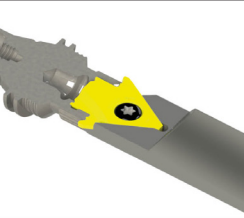
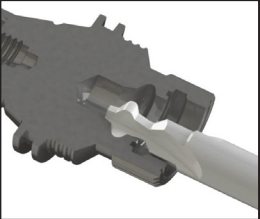

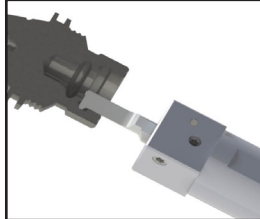




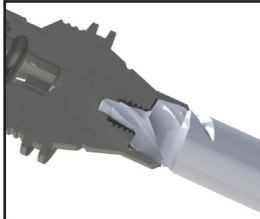
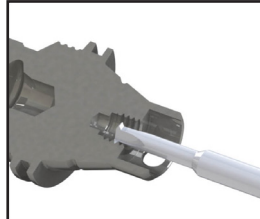

We have recognized these customer needs and have developed comprehensive services to meet them. We offer you our support for the complete tool design for turned parts. This includes both single and multi-spindle automatic lathes, as well as all manufacturing operations.

The fastest way to get support:

Simply send us your part drawing and information on the technical requirements, such as machine and holder type.

Based on this, you will receive a complete process description of the tool design from us along with a sketch and a detailed quotation for the Schwanog tools.

Use the service of the complete tool design by our experienced experts!

<p>Turned Part: Material: 16 MnCr5 (5115)</p>	 <p>ROUGHING OD 1ST SIDE Tool: Type PWP-S b = 15,6 mm Cutting data: Cutting speed (Vc) = 120 m/min Feed (f) = 0,2 mm/Rev.</p>	 <p>FINISHING OD 1ST SIDE Tool: Type PWP 22x5x26,5 Cutting data: Cutting speed (Vc) = 100 m/min Feed (f) = 0,1 mm/Rev.</p>	 <p>FORM DRILLING Tool: Solid carbide Ø10x70 2 Flutes w. i.c. Cutting data: Spindle speed (n) = 2000 mm/min Feed (vf) = 200 mm/min Feed (f) = 0,1 mm/Rev.</p>	 <p>FINISH DRILLING / COUNTERSINKING Tool: Type PWP-BO 22x5x26,5 Cutting data: Spindle speed (n) = 1600 mm/min Feed (f) = 0,1 mm/Rev.</p>
 <p>MILLING ID RECESS Tool: Solid carbide Ø8x70 3 Flutes Cutting data: Spindle speed (n) = 4000 mm/min constant Cutting speed (Vc) = 95 m/min Feed (vf) = 300 mm/min</p>	 <p>MILLING OD SERRATION Tool: Solid carbide Ø12x78 5 Flutes Cutting data: Spindle speed (n) = 2800 mm/min constant Cutting speed (Vc) = 105 m/min Feed (f) = 0,22 mm/Rev. Feed (vf) = 616 mm/min</p>	 <p>FINISHING ID GROOVE Tool: Type WSI Ø6x50 Cutting data: Cutting speed (Vc) = 60 m/min constant Feed (f) = 0,02 mm/Rev.</p>	 <p>BROACHING ID GROOVE Tool: Solid carbide Ø8x49 1 Flute Cutting data: Feed 0,08mm / Stroke Cutting speed (Vc) = 10 m/min</p>	 <p>FINISHING OD 2ND SIDE Tool: Type PWP 22x5x26,5 Cutting data: Cutting speed (Vc) = 100 m/min Feed (f) = 0,1 mm/Rev.</p>
 <p>FINISHING 3 OD GROOVES Tool: Type WEP 23,60x16 3S Cutting data: Cutting speed (Vc) = 80 m/min Feed (f) = 0,06 mm/Rev.</p>	 <p>SKIVING OD 2ND SIDE Tool: Type PWP 19x5x26,5 Cutting data: Cutting speed (Vc) = 50 m/min Feed (f) = 0,25 mm/Rev.</p>	 <p>FORM DRILLING BACK SIDE Tool: Solid carbide Ø12x80 2 Flutes Cutting data: Spindle speed (n) = 2300 mm/min constant Feed (f) = 0,06 mm/Rev.</p>	 <p>THREAD MILLING M6 ID THREAD BACK SIDE Tool: Solid carbide Ø5x80 3 Flutes Cutting data: Spindle speed (n) = 5000 mm/min constant Cutting speed (Vc) = 80 m/min Feed (vf) = 275 mm/min</p>	 <p>FORM DRILLING CROSS HOLE & CHAMFER BACK SIDE Tool: Solid carbide Ø8x60 2 Flutes Cutting data: Spindle speed (n) = 4000 mm/min constant Cutting speed (Vc) = 50 m/min Feed (f) = 0,05 mm/Rev.</p>