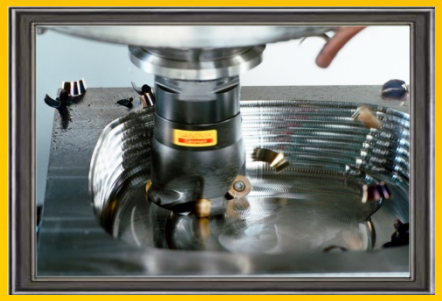
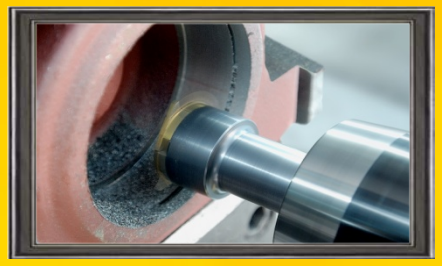
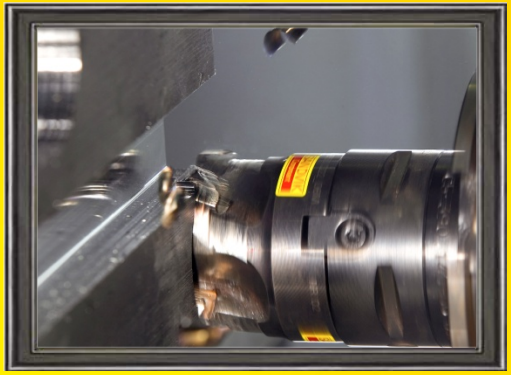
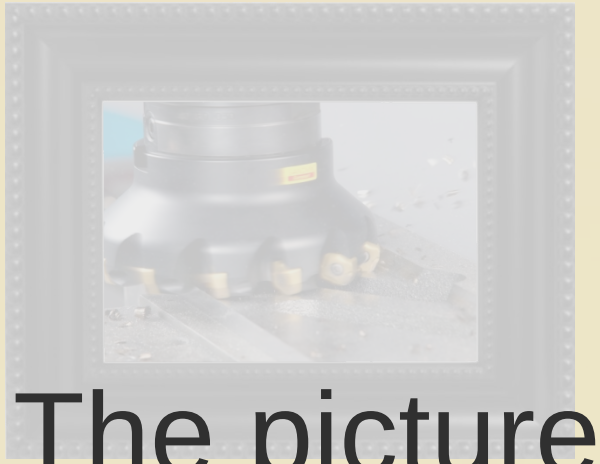
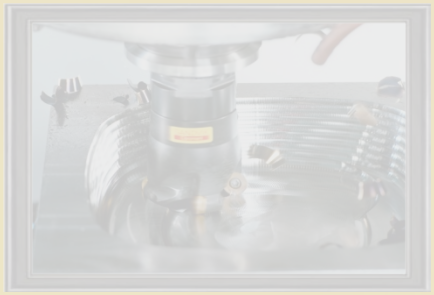









The picture of productivity…

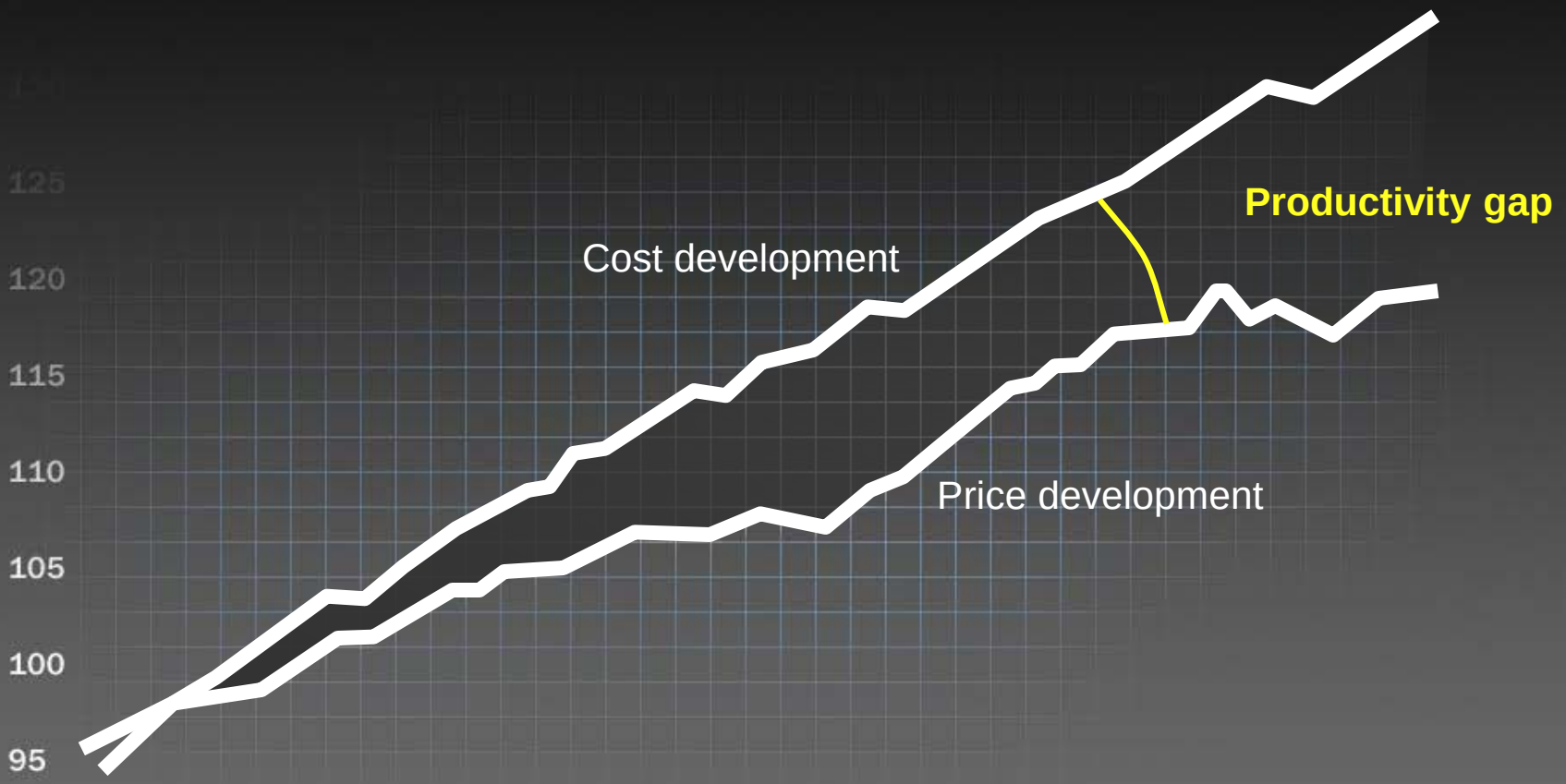
…the art of saving money

The

Modern Art of Milling

SANDVIK Coromant

Closing the productivity gap

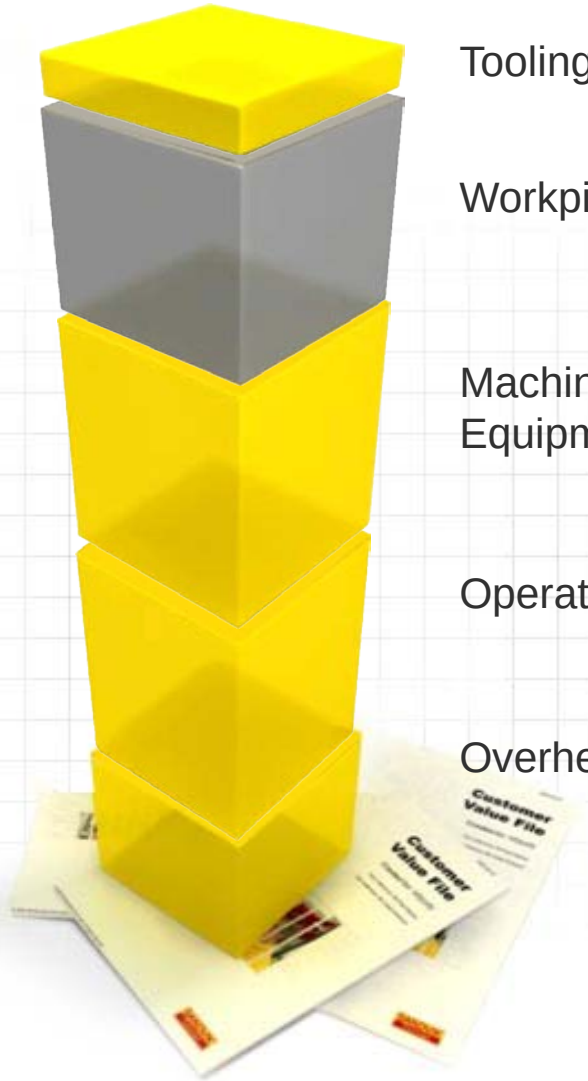


Source: Mechanical Industry in OECD

Manufacturing economics

Variable costs

Fixed costs



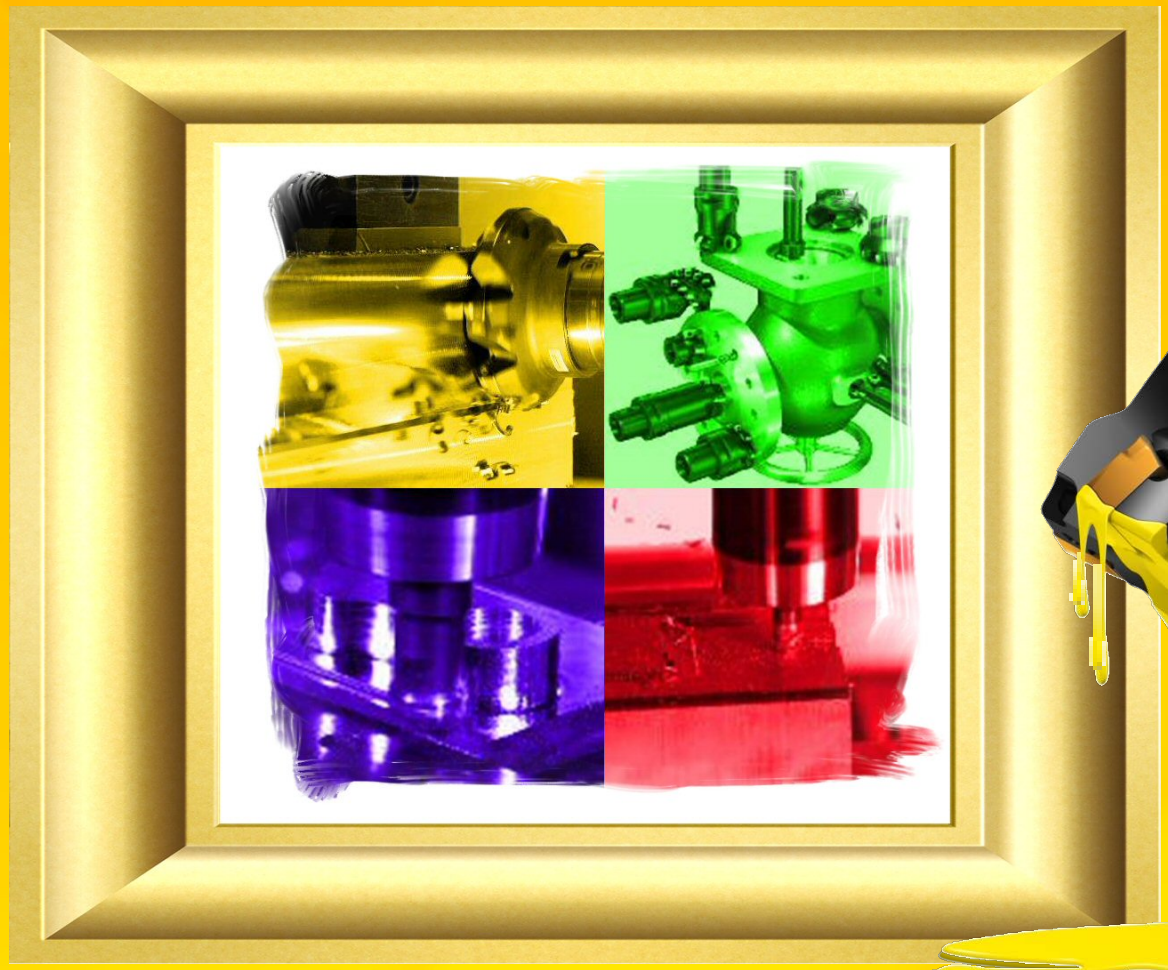
Tooling

Workpiece material

Machinery & Equipment

Operators

Overhead

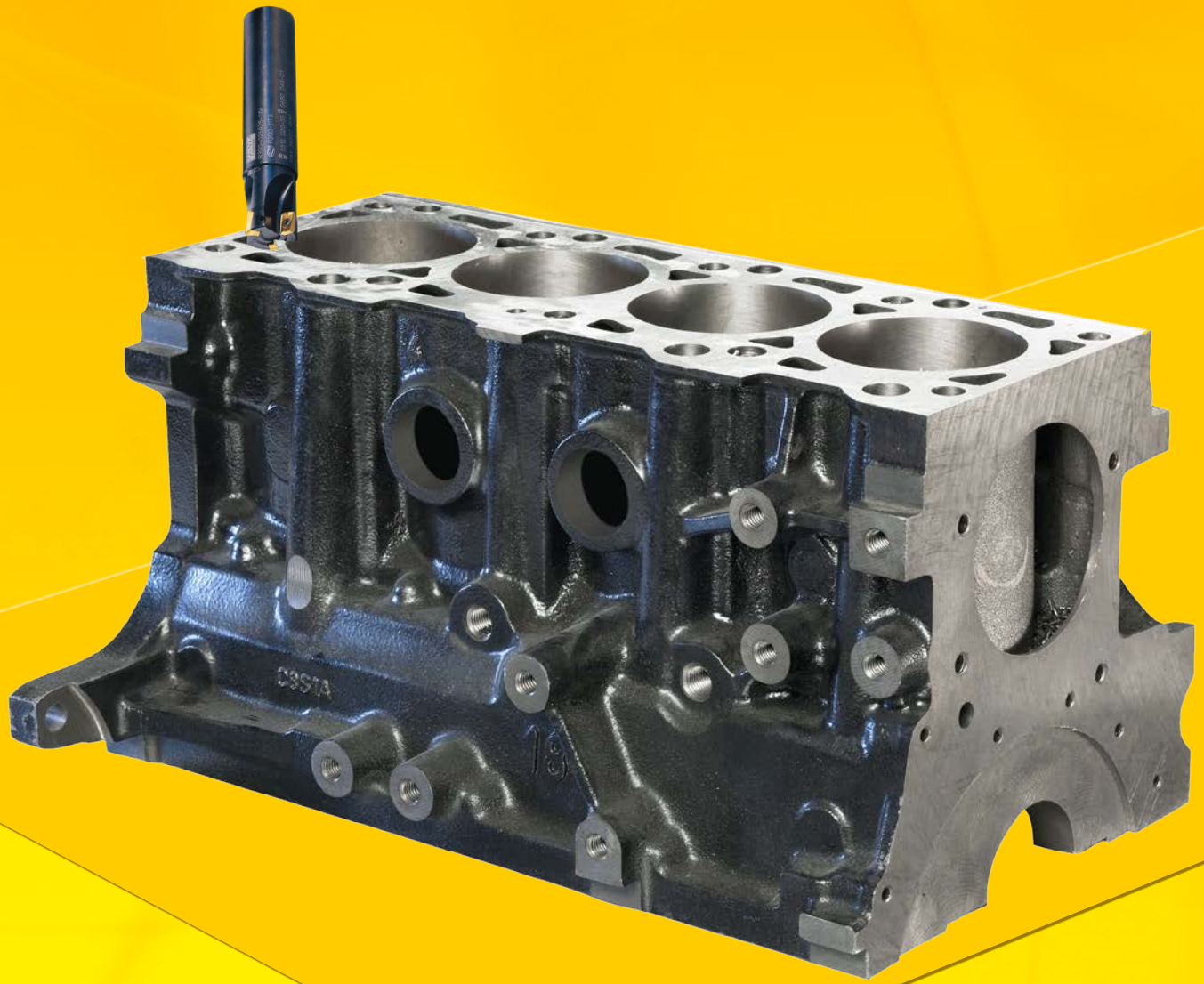


Sandvik Coromant's

Modern Art of Milling

Choose the right tools

SANDVIK Coromant



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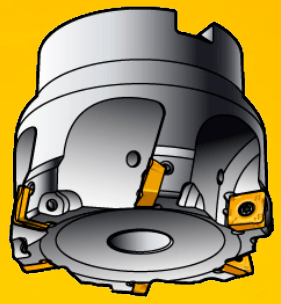
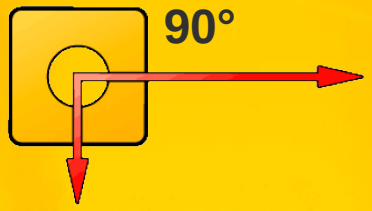
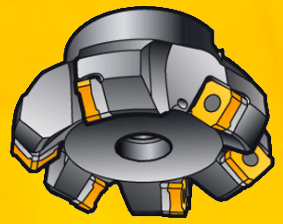
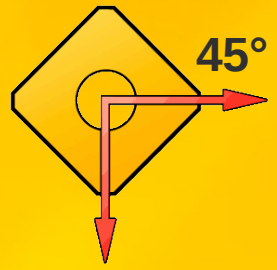
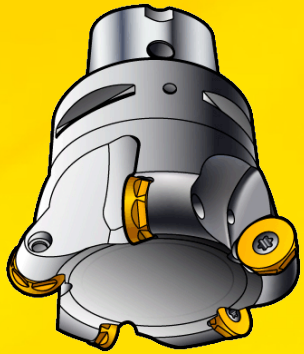
Choose the most productive and cost efficient tool

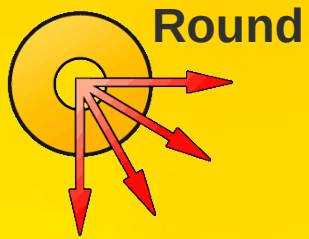




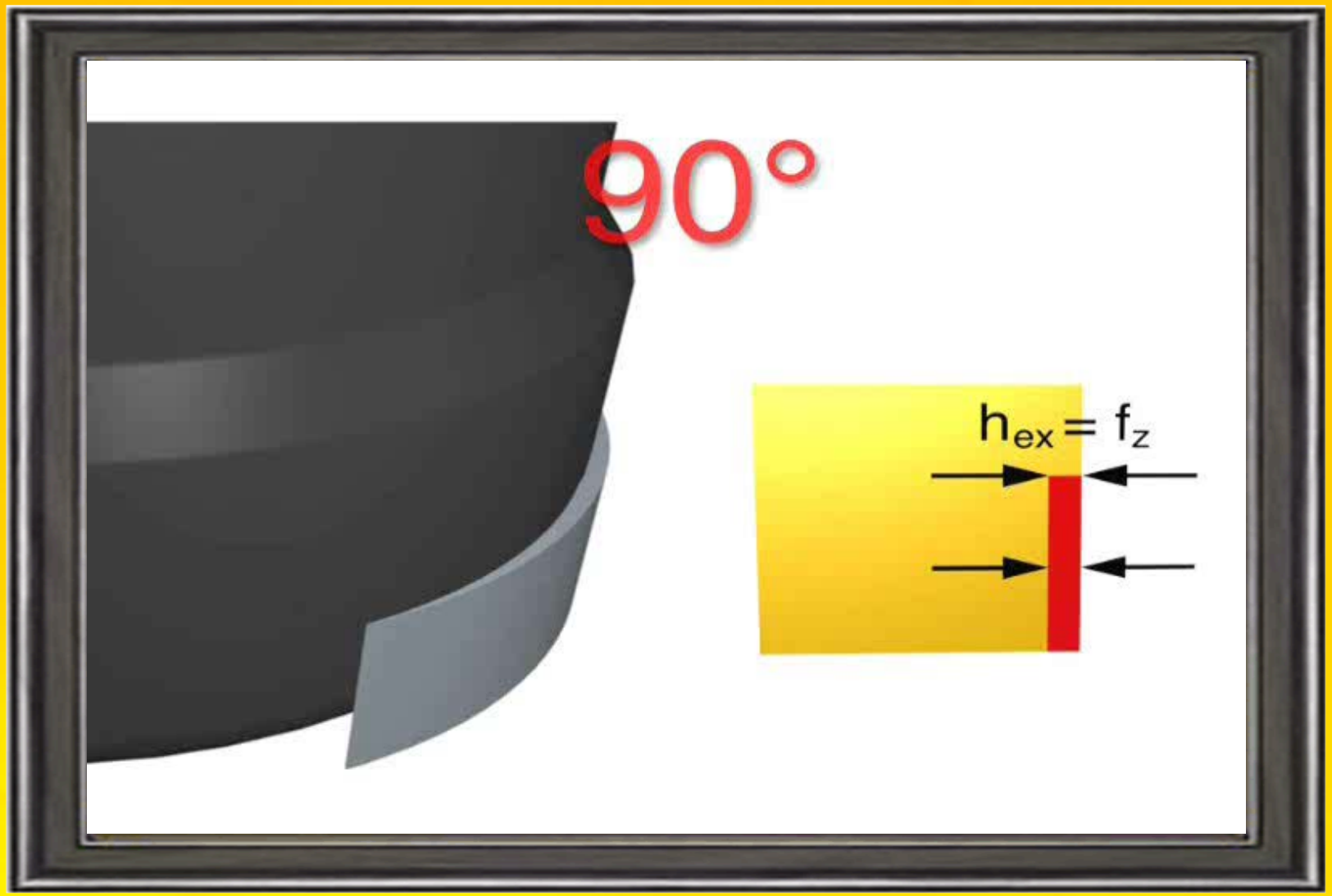




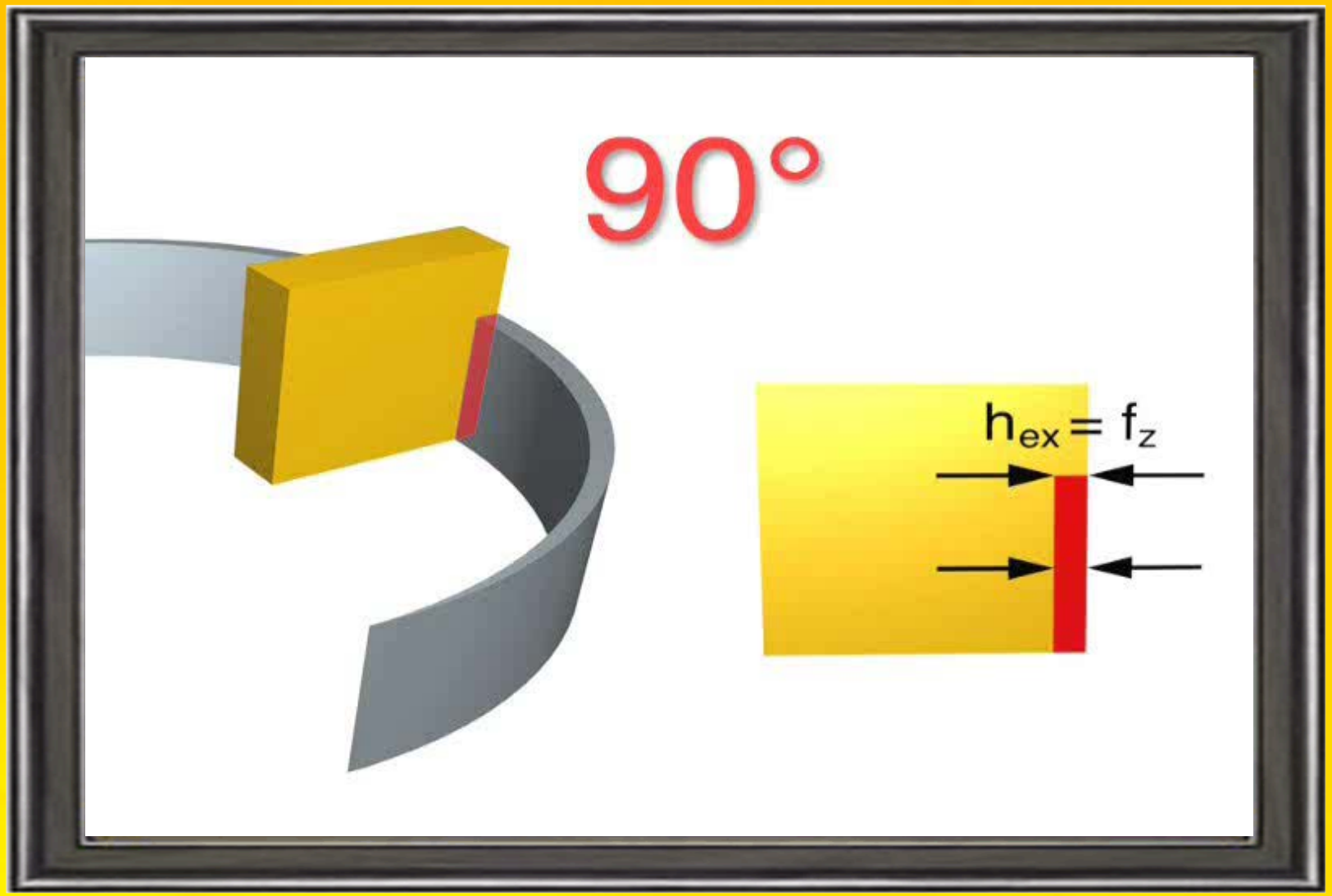




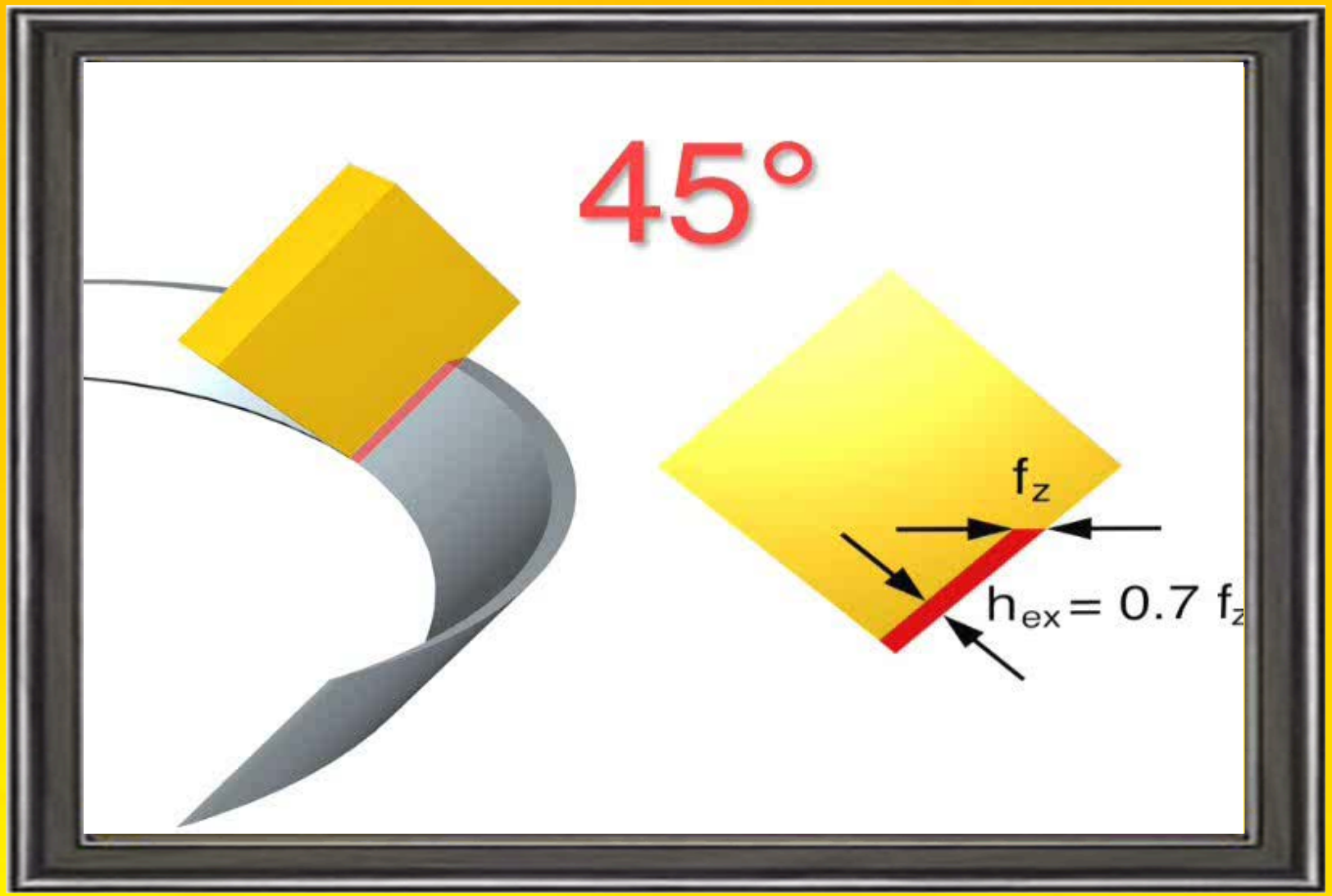
The right tool wins the race



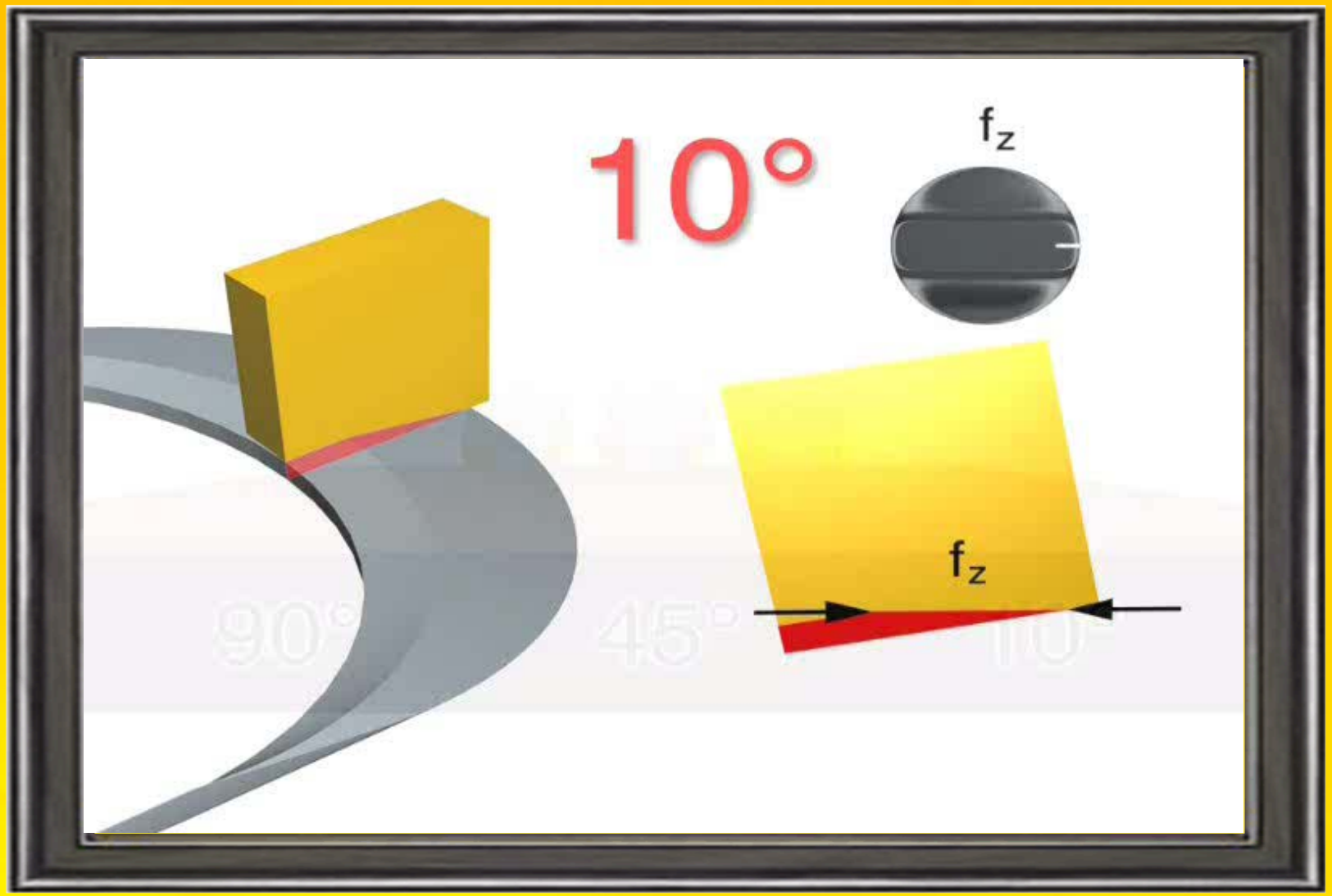
The right tool wins the race



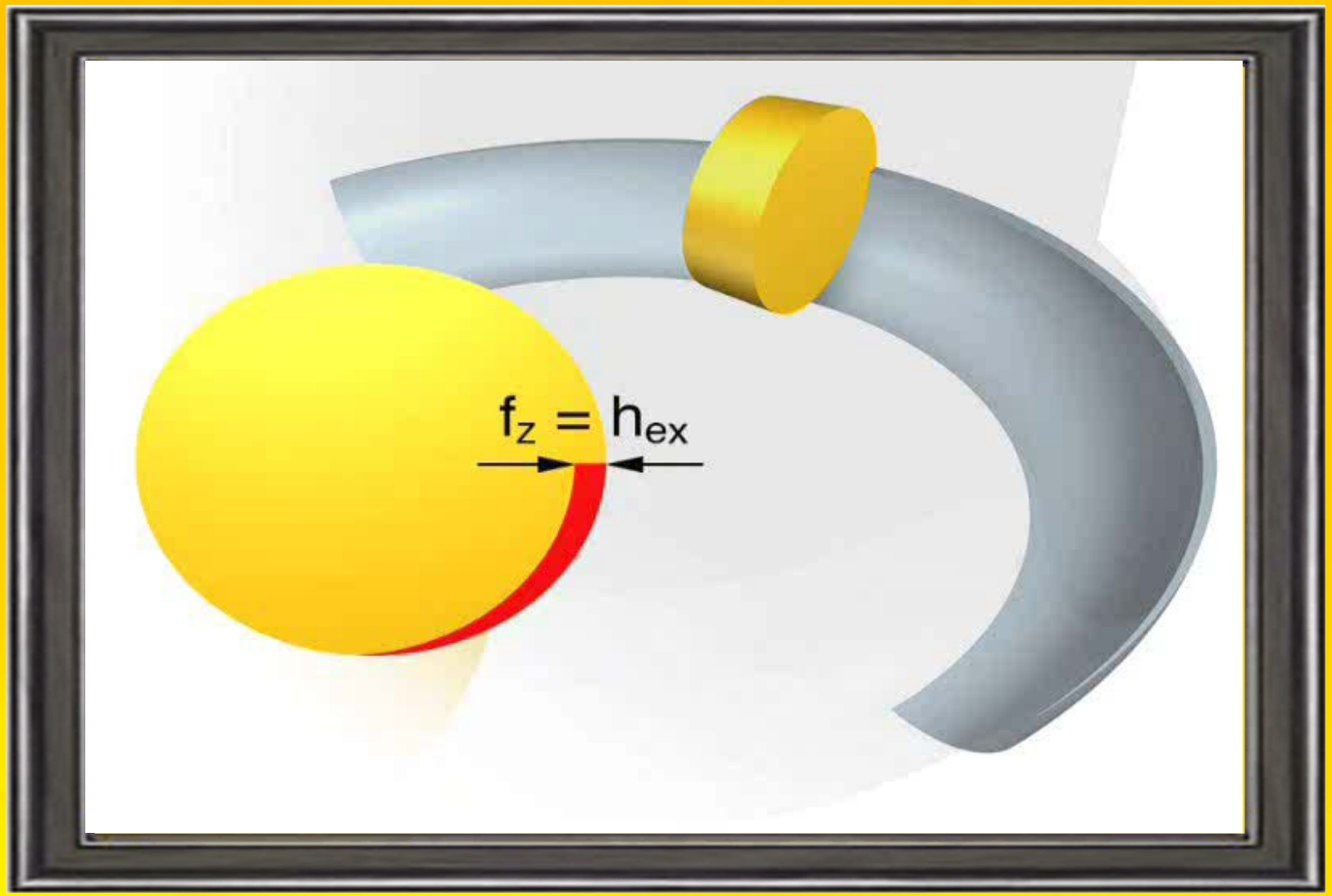
The right tool wins the race



The right tool wins the race



The right tool wins the race



Pick the right tool based on . . .

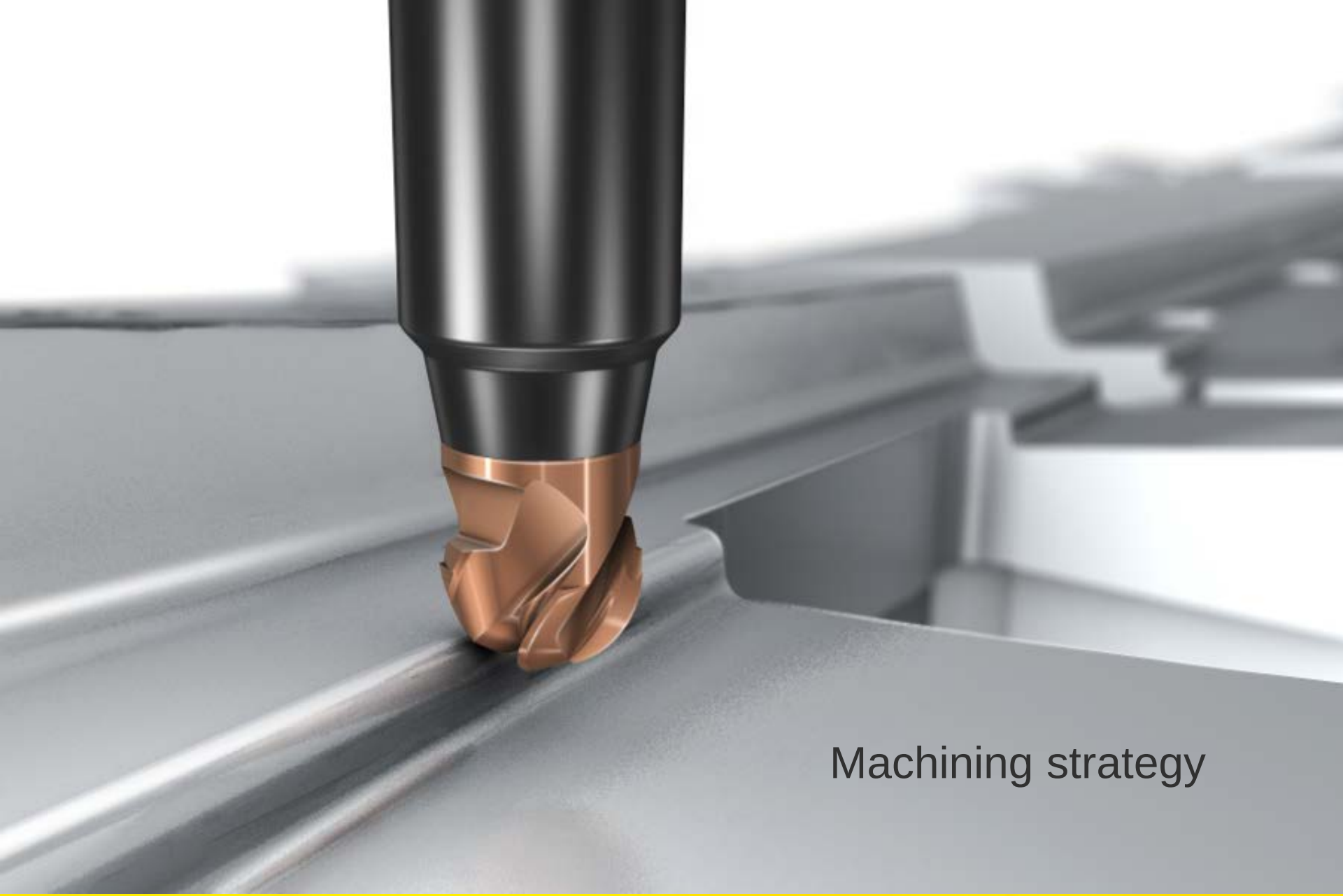
The machine tool

The component features

Number of parts being machined

The material

Maximum metal removal rate



Machining strategy

ld ensure the
ckness
exiting a cut

What is wrong with this picture . . .

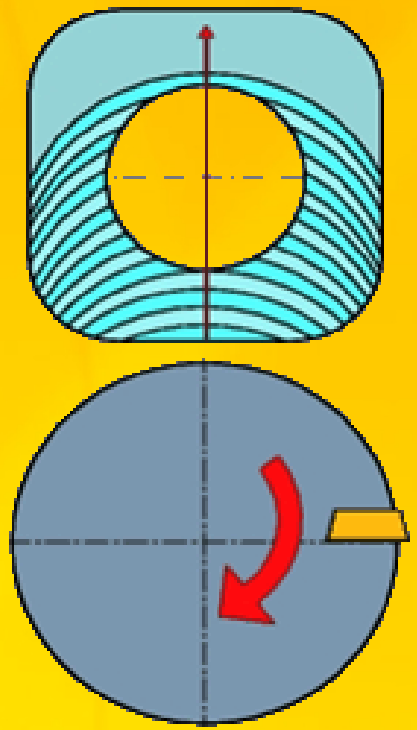
Thick chip on exit

Cutter doesn’t have constant contact with the part going over the boss

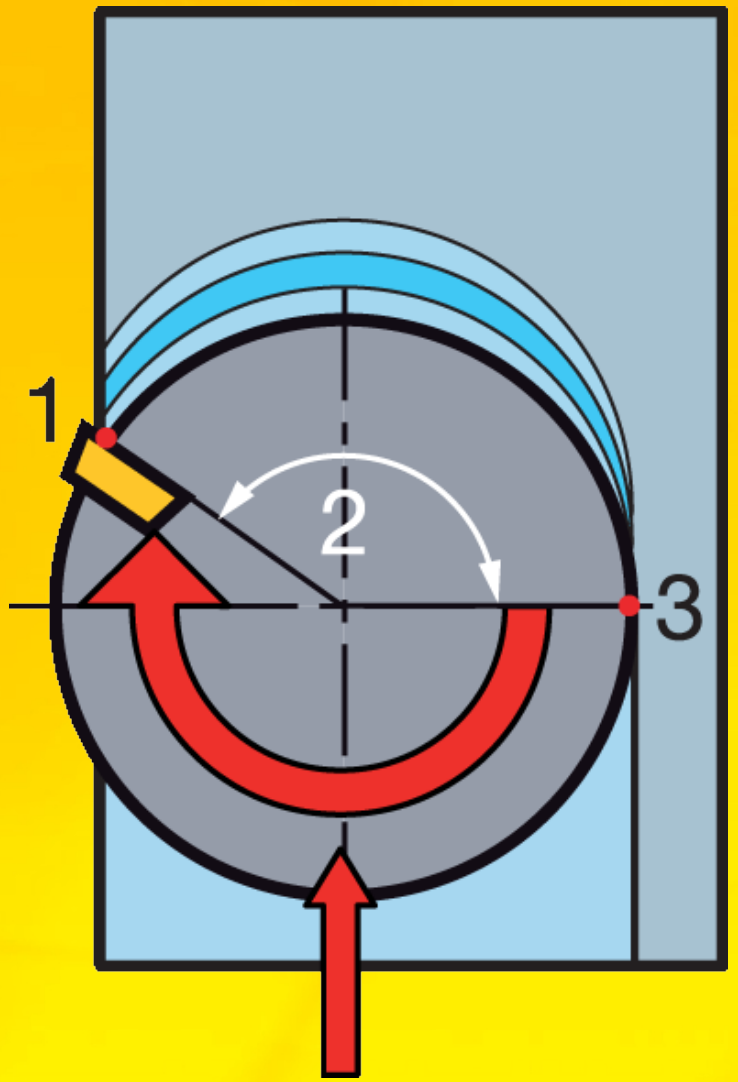
Climb milling on one side, conventional milling on the other

Straight down the center of the part

Diameter of the cutter isn’t optimized



The cutter position forms the chip . . .



Thick chip on entry

Thin chip on exit

Forming the chip

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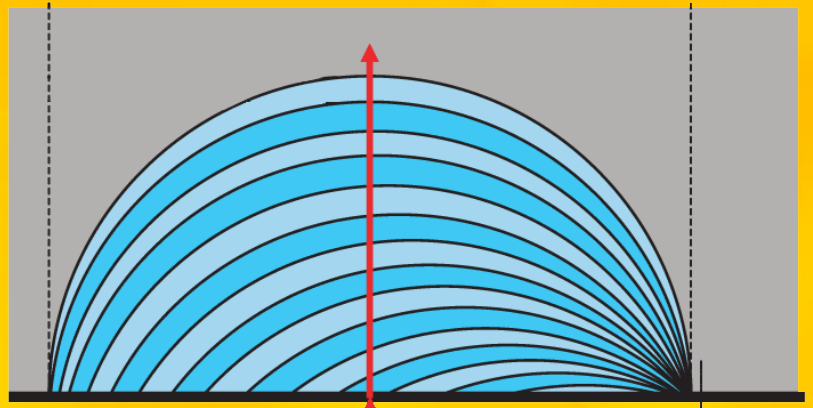
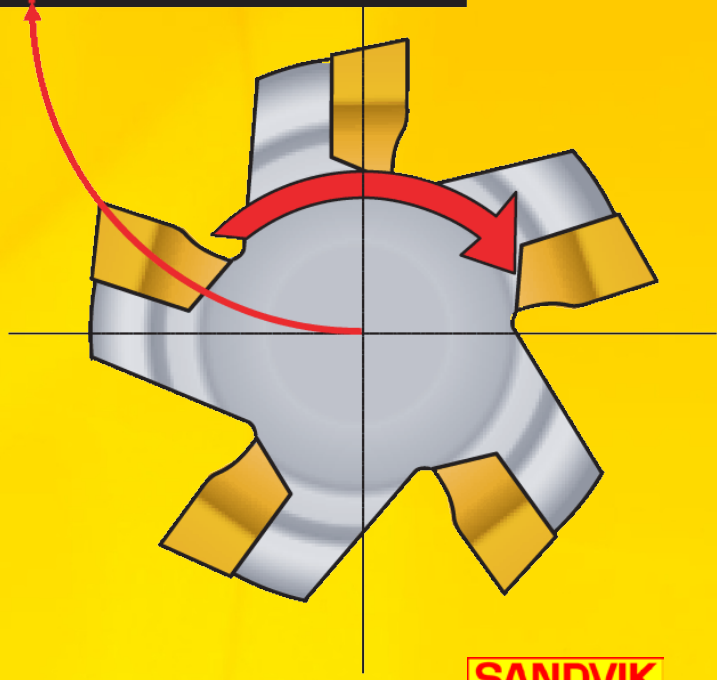
Approaching the part

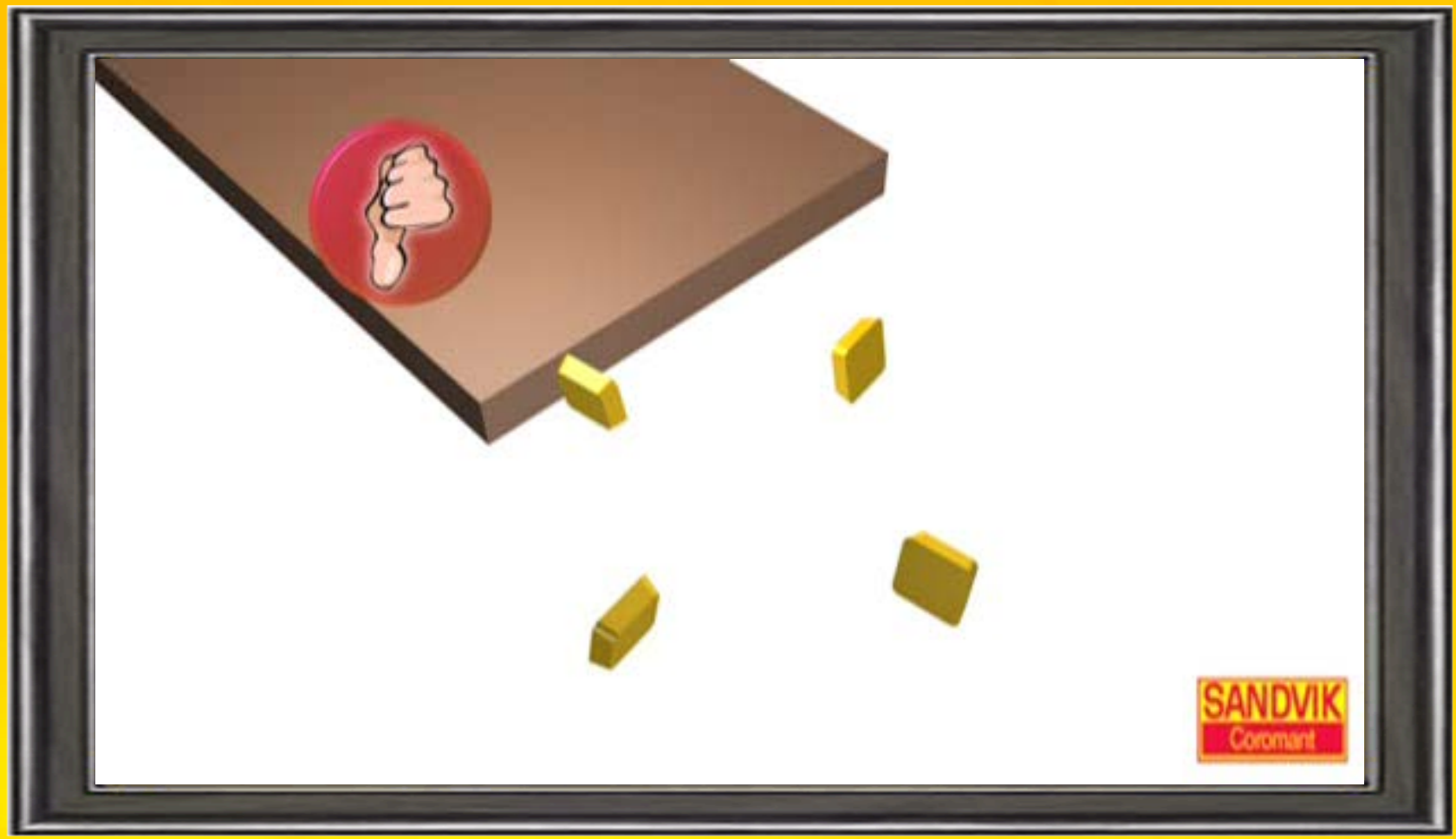
Roll-in method





- Allows the inserts to ease into cut
- Keeps the chip thin on exit
- Reduces vibration
- Increases tool life

Roll-in method



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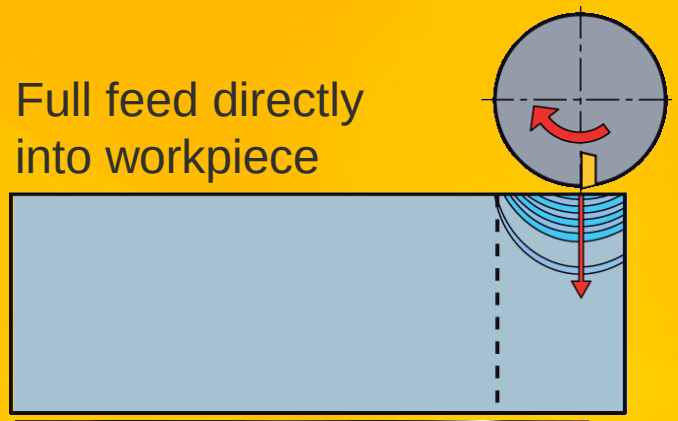
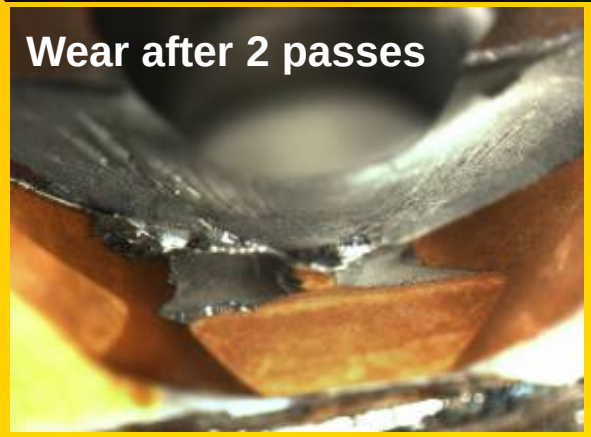
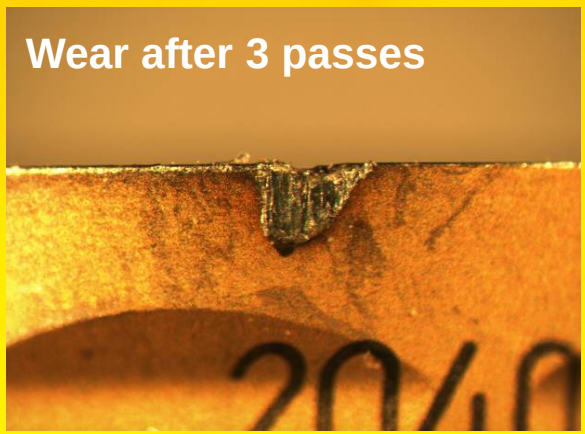
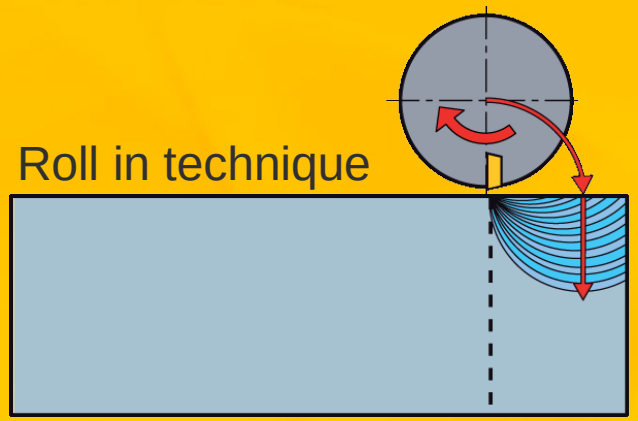
Full feed directly into workpiece





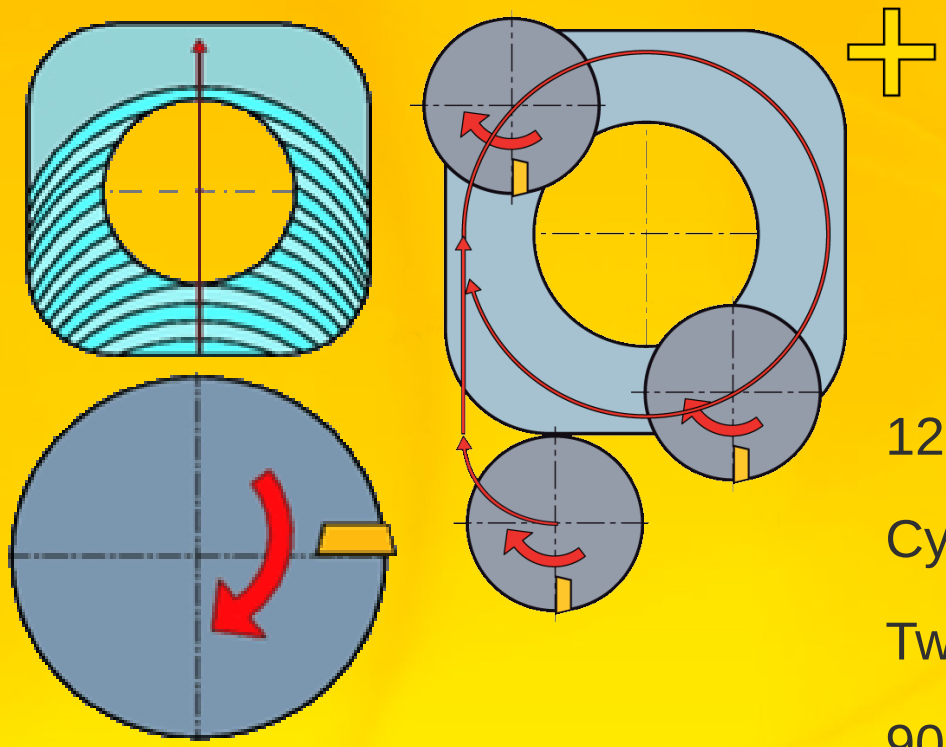


Roll in technique



Keep the cutter engaged

Component reprogrammed



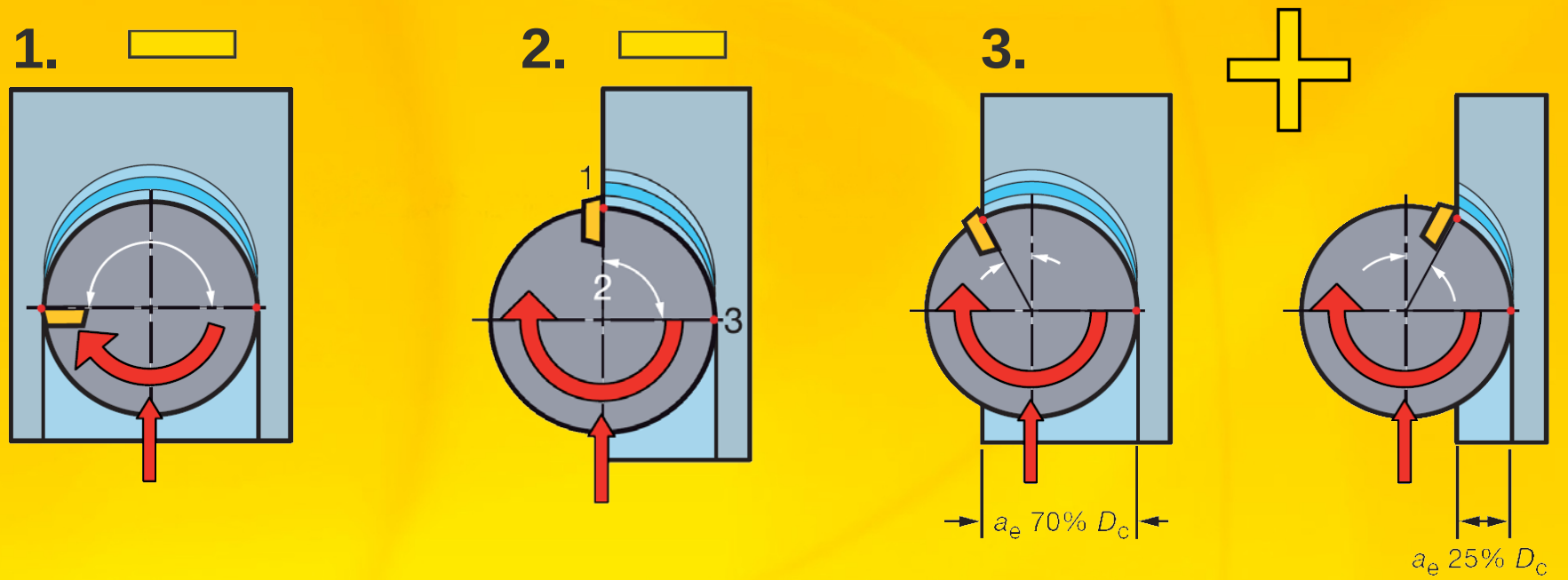
12 insert cutter to 5 inserts

Cycle time halved

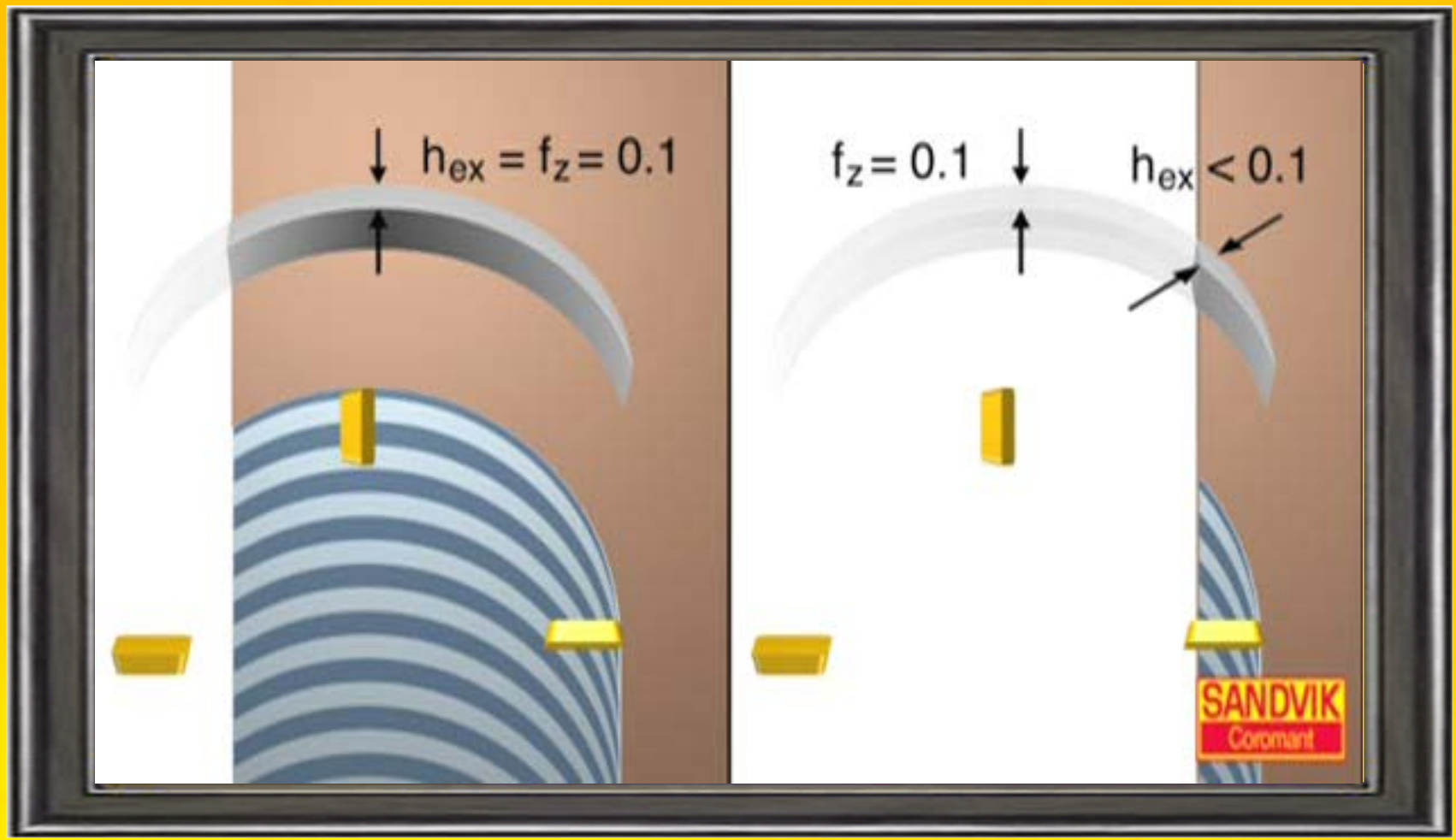
Twice as many bosses per edge

90 inserts per comp to 5

Cutter engagement



Effective use of the cutter diameter



Your success in focus