

„Schwegler combination One Shoot Tool for Ventil Body“

„One tool insted of two tools“

„Less Cycle Time“

„One Tool Cost instead of two tools“

New **Schwegler** Innovation:

Tool:

Solid carbide

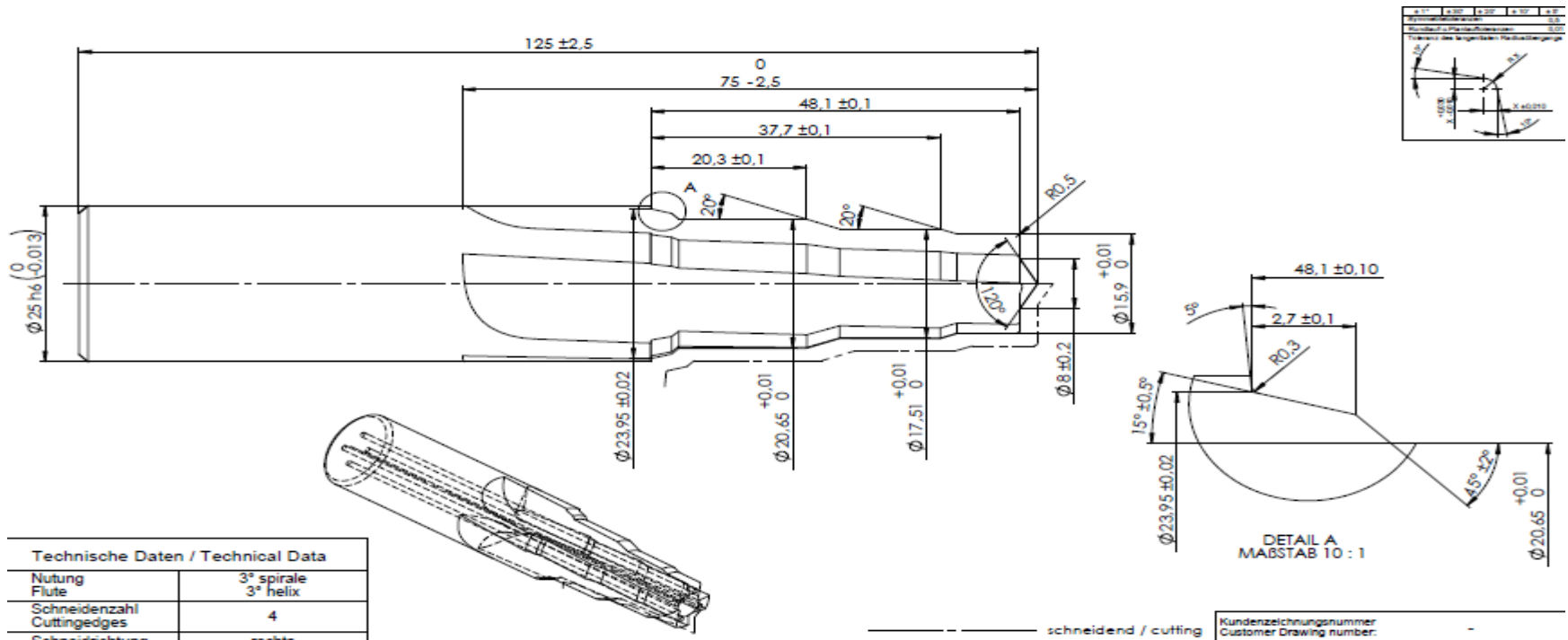
S=1600 1/min. Vc:90m/min.

F=480 mm/min. ft:0,3mm /rev.

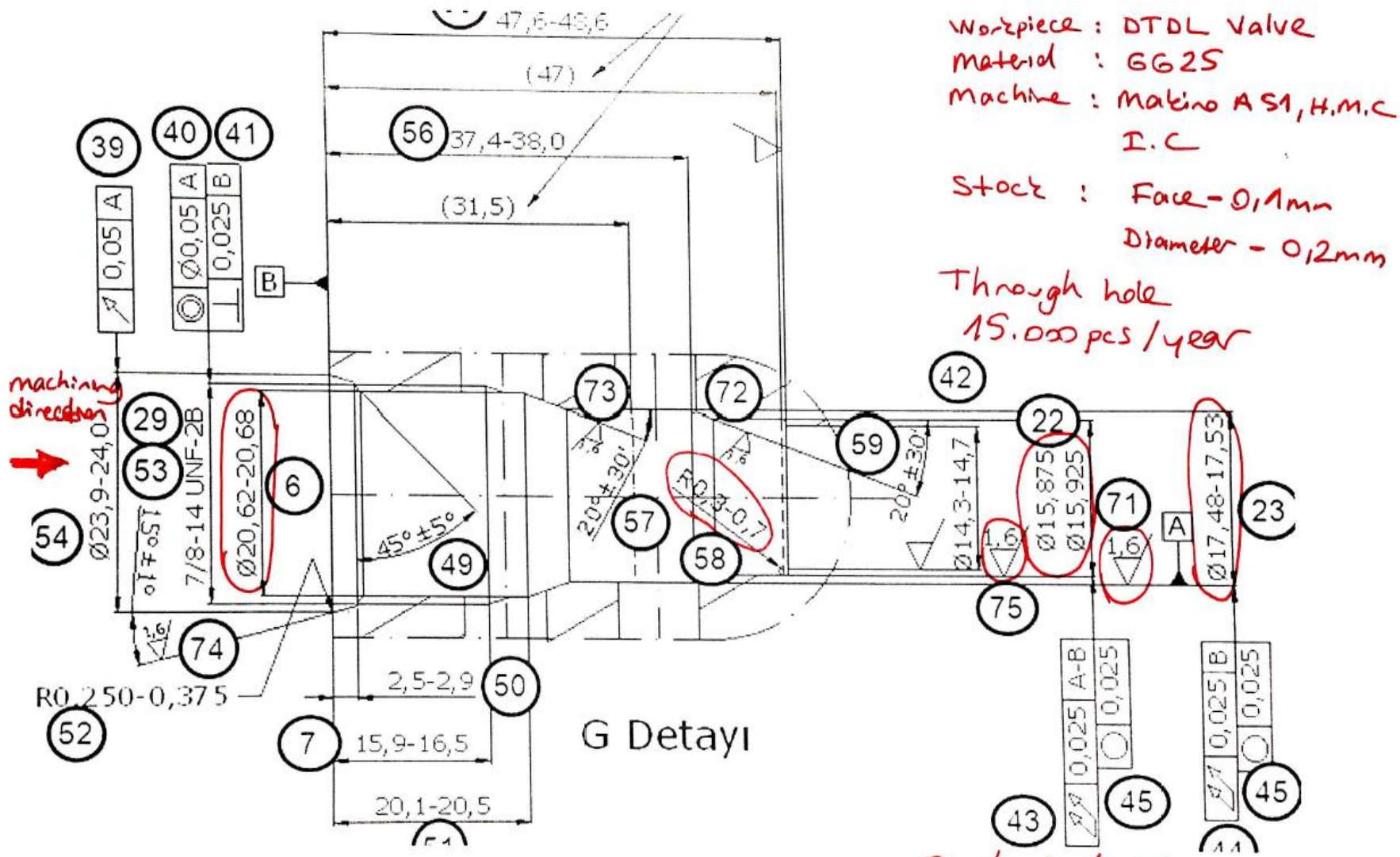
Machine : Makino A51

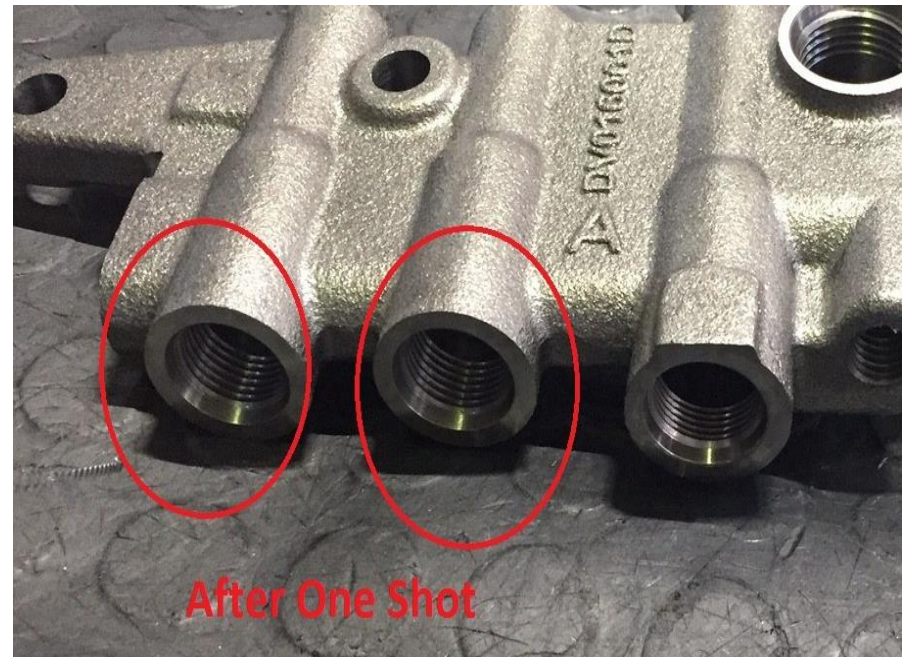
Material : GG 25

Full Material Drilling with OneShot Tool



Workpiece Drawing





Before : VHM Drill (350 € / pc) and VHM Reamer (300 € /pc) **Total : 650 €**

After : VHM One Shot Tool **350 € / pc**

**Cycle Time decreased 40 sec./part because of one shot tool instead of two tools.
Tool cost decreased too.**

Workpiece's surface



Ra max : 1,6 μ m

First Part : Ra 0,3 μ m

Tool Life 500 parts because of Ra 1,6