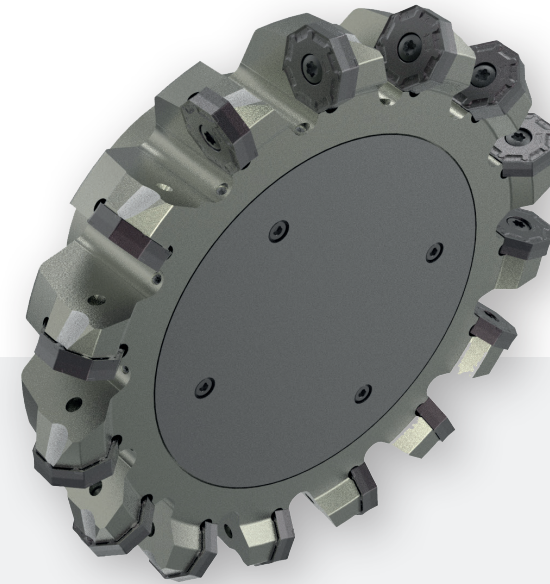
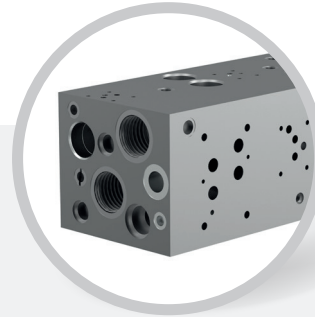


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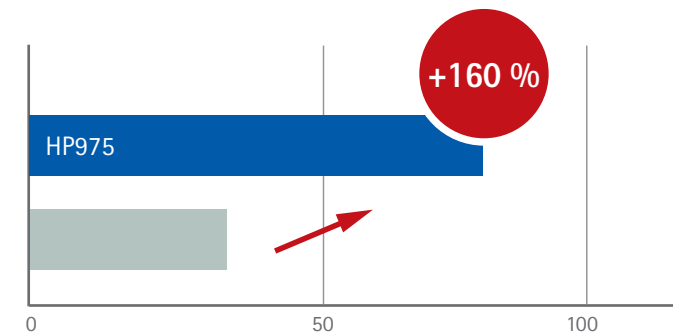
VALVE BODY

Milling of the flat surfaces



	■	■
Material	GGG50	
Tool	Face Mill	Special Face Mill NeoMill®-16-Face
Insert	WSP	ONKU070508R-M05-HP975
Tool-Ø [mm]	200	
Tooth t	12	15
Cutting edges per insert	16	
Coolant	Emulsion	
v_c [m/min]	300	180
f_z [mm]	0,12	0,19
v_f [mm/min]	660	804
a_p [mm]	4	
a_e [mm]	max. 90	
Number of cuts	1	

Machined parts



- Cycle time reduced by 22 %
- Tool life increased by 116 %
- CPP reduced by 47 %