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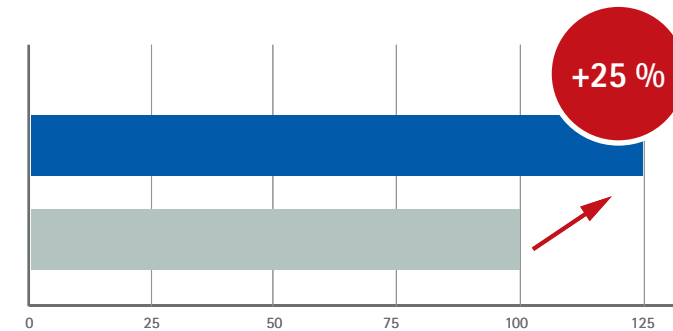
TURBOCHARGER

Face milling operations on turbine housing



Material	Cast steel GX40NiCrSiNb38-19 (1.4849)	
Tool	Face Mill	Face milling cutter NeoMill®-16-Face
Insert	WSP	ONKU070508R-R03-HP985
Tool-Ø [mm]	100	
Tooth t	11	14
Cutting edges per insert	12	16
Coolant	Emulsion	
v_c [m/min]	110	
f_z [mm]	0,28	
v_f [mm/min]	1.078	1.372
a_p [mm]	2	
a_e [mm]	70	
Number of cuts	1	

Machined parts

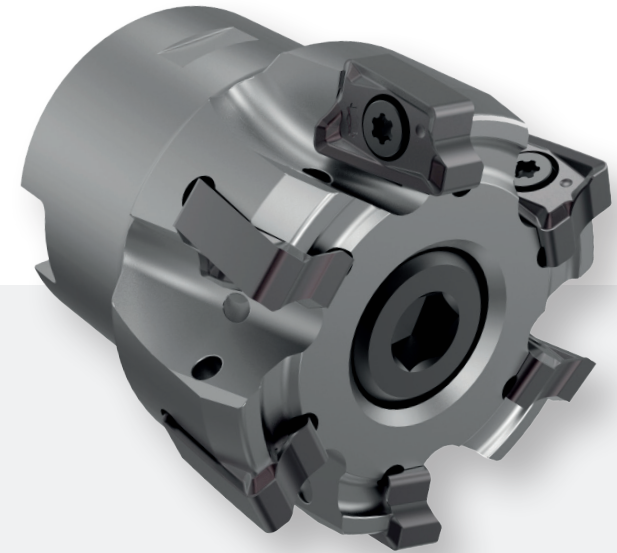


- Cycle time reduced by 27 %
- Tool life increased by 25 %
- CPP reduced by 13 %

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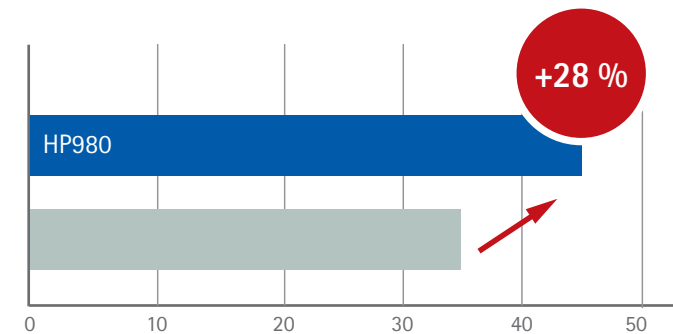
TURBOCHARGER

Corner milling on turbine housing



Material	Low Nickel Cast steel (similar to 1.4837)	
Tool	Corner Mill	Corner Mill NeoMill®-4-Corner
Insert	WSP	ANMU120508R-M05-HP980
Tool-Ø [mm]	40	
Tooth t	6	
Cutting edges per insert	2	4
Coolant	MMS	
v_c [m/min]	145	
f_z [mm]	0,12	
v_f [mm/min]	852	
a_p [mm]	2 x 1,5 / 1 x 0,2	1 x 3,0 / 1 x 0,2
a_e [mm]	3 - 27	
Number of cuts	3	2

Machined parts



- Cycle time reduced by 30 %
- Tool life increased by 28 %
- CPP reduced by 53 %