MAS
TOOLS & ENGINEERING

インターン©

IN©turn

For soft machining

ハイドロクランプとの
相性抜群

NEW

- **Reduced Tool Costs** 工具費削減
- **Shorter Downtimes** 停止時間削減
- **Increased Output** 停止時間削減
- **Higher Process Reliability** ﾌﾟﾛｾｽﾘﾗｲﾋﾞﾘﾃｨｱｯﾌﾟ
- **Decreased Set-up Times** 段取時間削減

· Perfect Price-Performance Ratio
· Internal Turning from Bore Ø 0,5 mm
· High Change Accuracy and Rigidity
· ONE Holder for all turning Diameters (Ø 0.5 mm to approx. Ø 8.00 mm)
· Direct hydraulic Clamping for maximum Vibration Damping
· High Performance, even in stainless Steels

YAMADA

Small Diameter Machining

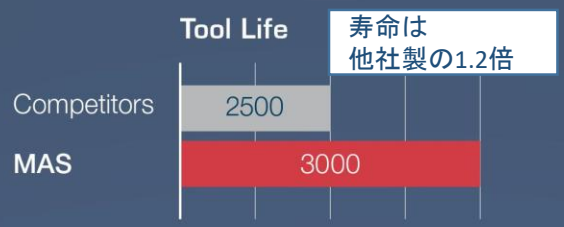
Application Examples

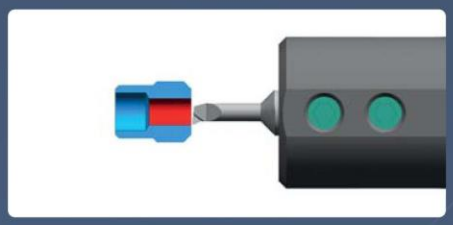
超硬工具での小径加工実績

1.

SUM22相当、φ3.2内径加工
超硬HM120Cボーリングバー（IN6.060.090.015HM120C）
使用
周速Vc=75m/min　送り0.02mm/rev　ap=0.02-0.05
シンコム　A20　油性切削液使用

Stable cutting process with IN©turn. Very good handling and highest process reliability.

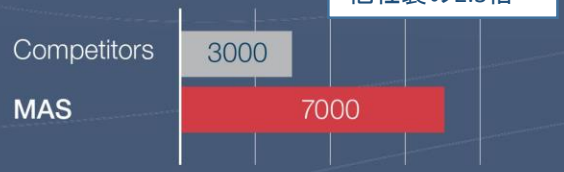


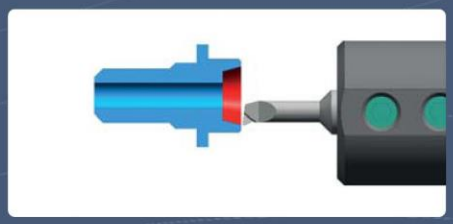


2.

クロムモリブデン鋼16 MnCrS 5相当、φ4.5内径加工
超硬HM120Cボーリングバー（IN6.035.105.015HM120C）使用
周速Vc=28-48m/min　送り0.05mm/rev　ap=0.25
インデックスMS22　油性切削液使用

IN©turn offers very long tool life and significantly reduces tool costs.

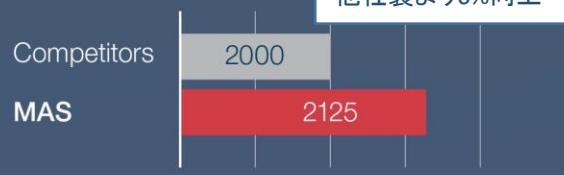


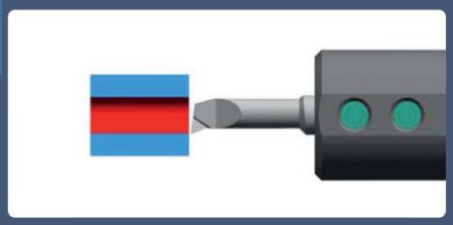


3.

SUS434類似、φ6.95内径加工
超硬HM120Cボーリングバー（IN6.055.165.020HM120C）使用
周速Vc=92m/min　送り0.07mm/rev　ap=0.075
トルノス　ガンマ120　油性切削液使用

With IN©turn, significant fewer tool corrections are required. The output increases considerably.





山田マシンツール株式会社
〒110-8575　東京都台東区台東1-23-6
Tel:03(3834)5041 / Fax:03(3832)6165
ホームページ　http://www.yamada-mt.co.jp
メール　import@yamada-mt.co.jp