



FLUTING WHEELS



CASE STUDY REAMER, 3 FLUTES

WORKPIECE: Reamer, 3 Flutes

DIMENSIONS: 1.25" Diameter


FLUTE LENGTH: 5"

DEPTH OF CUT:

.180" (*Rough Pass*) | .145" (*Finish Pass*)

MATERIAL: Carbide

MACHINE: ANCA TX7+

	COMPETITOR WHEEL	
PRODUCT	D240	1A1 6 X .5 X 2 D240
FEED RATE	2.1"/MIN (25% SPINDLE LOAD) <i>*ADAPTIVE CONTROL WAS ON</i>	2.1"/MIN (CHANGED SPINDLE LOAD WITH ADAPTIVE CONTROL TO 40% AND LEFT ON)
STICK DRESSING	EVERY TOOL	EVERY 3 TOOLS
Q'= (DOC MM x Feed Rate (VT) in MM/min)/60	4.1 <i>Rough</i> 3.3 <i>Finish</i>	7.3
CYCLE TIME	16 (MIN.)	10 (MIN.)



SUCCESS

By taking full depth of cut, achieved **40% REDUCTION** in total fluting cycle time.

