



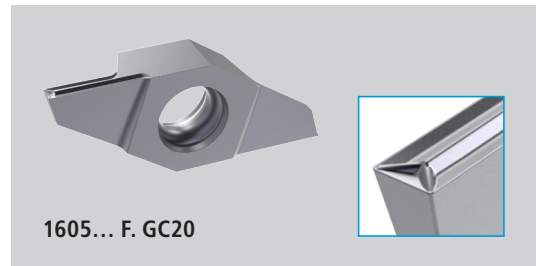
Success story

OPERATION GROOVING AND TURNING WITH THE "GC20" CHIP BREAKER

In a comparison between the new G-LINE "GC20" chip breaker and a ground chip breaker which has been established for a long time, perfect rolled chips and an extremely neat finish were achieved on the workpiece with consistent cutting data. The tool life was increased by 200 %, from 3000 to 9000 parts.

CHIP REMOVAL COMPARISON

Machine model	Star SR 10 type C
Material number	1.4435
Material specification	X2CrNiMo 18-14-3 (316 L)
Bar diameter (mm)	4
Operation	Grooving and turning
Cooling	Oil



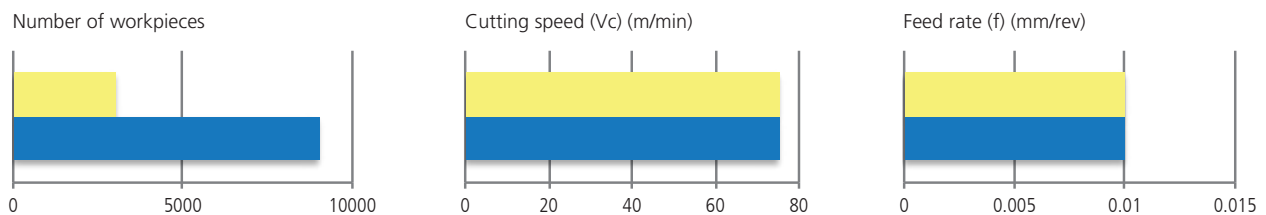
CURRENT

Insert designation	Ground grooving and turning insert	Make	Competitor
Cutting speed (Vc)	75 m/min		
Cutting depth (ap)	1.00 mm		
Feed rate (f)	0.01 mm/rev		
Number of workpieces	3000		

UTILIS (multidec-CUT, G-LINE)

Insert designation	1605-1.0-1.5 FL GC20 R05 UHM20 HPX	Make	UTILIS
Cutting speed (Vc)	75 m/min		
Cutting depth (ap)	1.00 mm		
Feed rate (f)	0.01 mm/rev		
Number of workpieces	9000		

SUMMARY



■ Utilis AG, Precision Tools

Kreuzlingerstrasse 22, CH-8555 Müllheim, Switzerland
Phone +41 52 762 62 62, Fax +41 52 762 62 00
info@utilis.com, www.utilis.com