

HEULE CASE STUDY

Energy Application BSF



An Efficient and Reliable Solution for Back Spotfaces on a Wind Rotor

Challenge

A manufacturer of wind rotors was looking for a more efficient and stable solution for the application of back spotfaces to bores.

Application details:

- Main bore: Ø14.0 mm
- Counterbore diameter: Ø22.0 mm
- Material: GG40
- Machining: Horizontally with internal coolant
- Machine: Gantry Boring and Milling Machine Center

Solution

HEULE recommended the BSF tool with a working length of 80 mm, together with a TiAlN coated carbide blade type BSF-M-E-1A-5.0.

Machining parameters:

Speed: N=500 rev/min
Feed: F=20 mm/min
Coolant: Internal coolant



Results:

By replacing their old tool, which needed pre-adjustments, this customer found more stability and better process capability. More stability led to a longer blade life for the tool. The customer is very happy with the solution and noted that their process is more efficient, precise, and safe.