

HEULE CASE STUDY

Automotive Application SNAP



Producing Quality Chamfers on Car Hydraulic Components

Challenge

A manufacturer of car hydraulics components faced the problem that their solid carbide chamfer tool did not produce the required chamfers in the desired quality on the cast surface.

Application details:

- Bore-Ø: 6.7 mm
- max. Chamfer-Ø on front and backside of the bore: 7.0 mm
- Material: Cast steel 304 stainless
- Volume: 50,000 parts per year
- Machine: MAZAK Vertical machining center
- Machining: vertical
- Coolant: external coolant

Solution

Tool: SNAP5/6.5
Blade: GH-Q-M-30207

Machining parameters:

Speed: 1800 rev./min.
Feed: 0.12 mm/rev.



Results:

The SNAP tool is producing consistent high quality chamfers and is much easier for the operators to adjust than the previous chamfer tool.