

Metkon Application Note

Cutting operation of Shaft

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Sample with requested cutting line:



APPLICATION REQUIREMENTS



SERVOCUT 401-AA-AX

Automatic Abrasive Cutting Machine Programmable with 5,7" HMI touch screen control, with Siemens PLC control unit, with automatic chop cutting and automatic table-feed cutting systems, with various cutting methods, programmable with coloured LCD display of cutting parameters, accurate and motorized positioning of the specimen in X - Y and Z axis (X-axis for plane parallel cutting is optional), integrated feed path control, power dependent adjustable feed rate, variable cutting force, pulse cutting mode, bar graph overload display, compact cutting motor, 2200 rpm cutting speed, with electronic brake system, cutting capacity upto 130/150 mm solid stock, with cut-off wheels upto \varnothing 350/400mm, twin T-slotted table(Y-direction only) made of stainless steel, bottom part as rugged alloy base casting, 100 lt recirculating cooling unit with connection hoses, ready for operation.

Without clamping devices.

Includes a standard set of cutting consumables composed of;

*An assortment of 20 cut-off wheels with 400 mm dia.

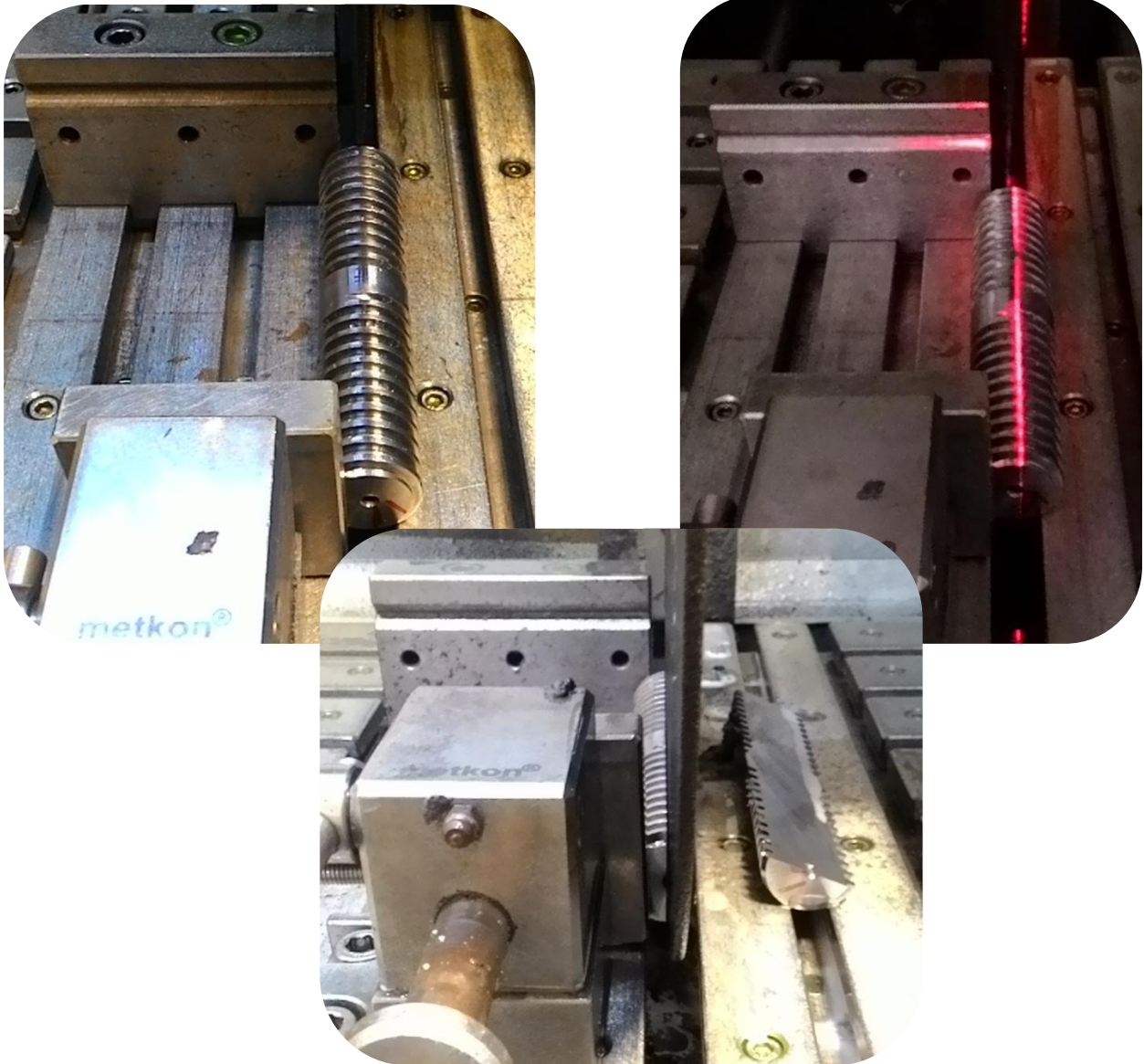
*5 lt of Metcool cooling fluid.

400 V, 3 phase, 50 Hz.

	Order Code	Description
Equipment Used :	14 67	Servocut 401 - AA
Clamping Device :	GR 0030	Quick Acting Clamping Vise Assembly, Left
Cutting Fluid :	19-902	Metcool,Nature Friendly Soluble Oil,5lt.
Cutting Disc :	19-072	Treno-M, \varnothing 400, Medium hard steels and Ferrous metals 23-50 HRC

SAMPLE PREPARATION PROCESSES

Sample has been clamped with GR 0030 easily. Also, laser alignment has been used to be sure about cutting line. After fixed everything properly, we have started to cutting process.



With the help of laser unit, sample has positioned quickly from the requested cutting line.

At the result, sample has cut properly from the requested observation point.



Photo-1

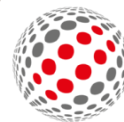


Photo-2

There was some shrinkage after cutting operation but they can be easily remove from surface in 10-20 seconds by hand. As can be seen in photo-2 result was convincing.

Metkon Instruments Inc.

Demirtas Dumlupinar Organize Sanayi Bolgesi
Ali Osman Sonmez Cad. No:14 Bursa / TURKEY
Tel: +90 224 261 1840 Fax: +90 224 261 1844
E-mail: metkonsales@metkon.com Web: www.metkon.com



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