



METKON

Application Note

Slice cutting operation with double disc



INDEX

1. INTRODUCTION
2. APPLICATION REQUIREMENTS
3. SAMPLE PREPARATION PROCESSES
4. RESULT



In this application, slices will be obtained from on engine piston the requested area.



Application Requirements

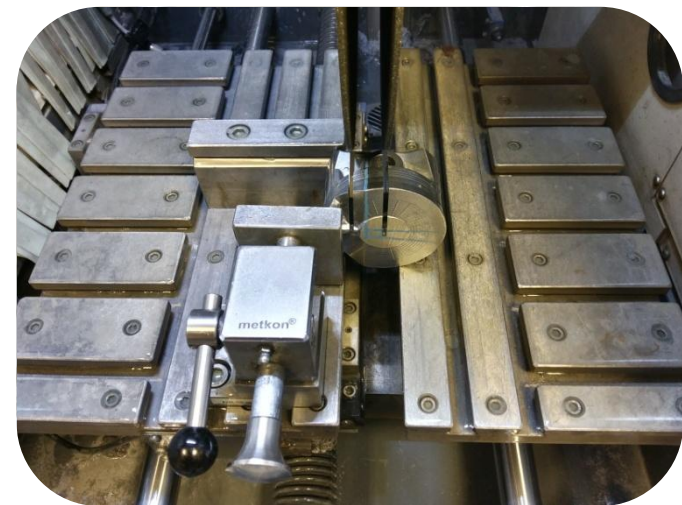
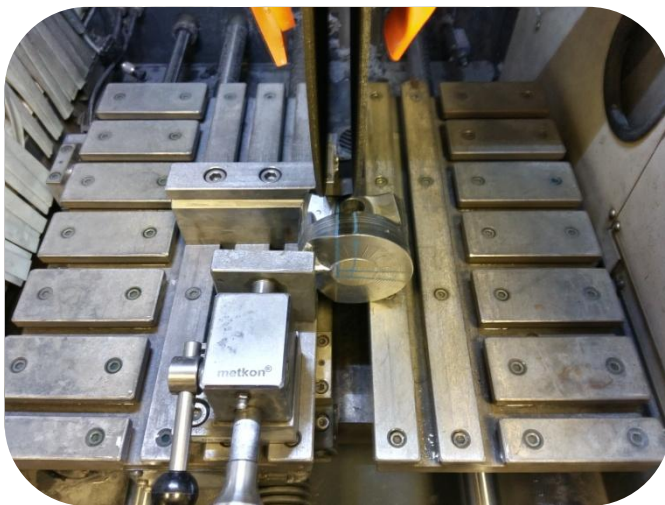


	Order Code	Description
Equipment Used	14 67	SERVOCUT 401 AA V-AX
Clamping Devices	GR 0029	Quick acting clamping vise assembly, right
	GR 0030	Quick acting clamping vise assembly, left
Cutting Fluid	19 902	Nature Friendly Soluble Oil, 5 lt.
Cutting Disc	19-070	TRENO NF Ø 400 mm, for Non Ferrous materials

New flanges produced as requested slices width.



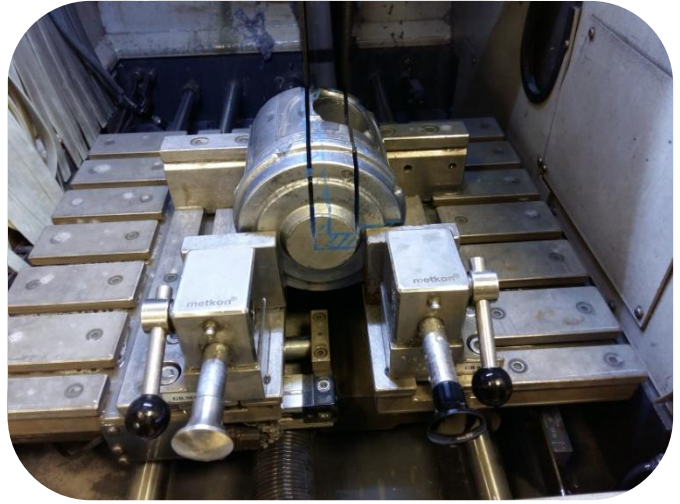
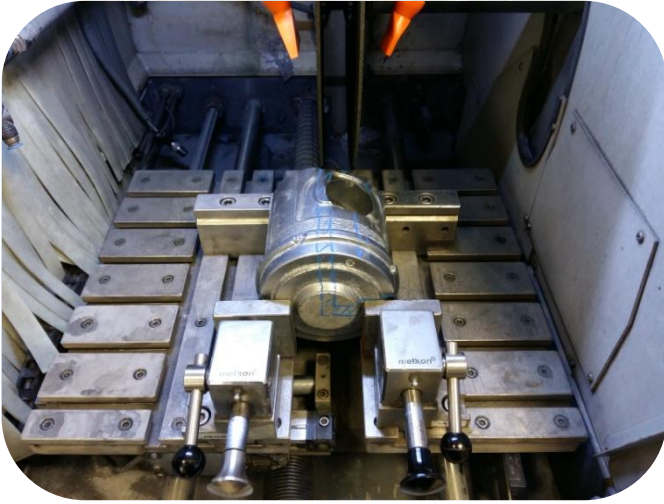
Small part was fixed with GR 0030 Quick acting clamping vise to the SERVOCUT 401 table.
Requested width: 20mm



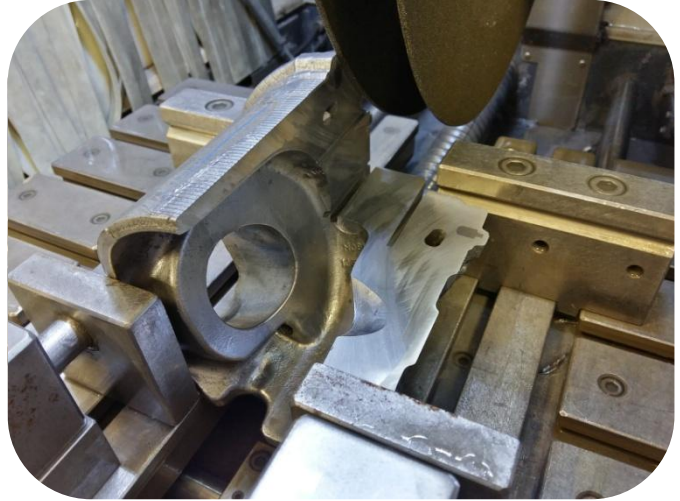
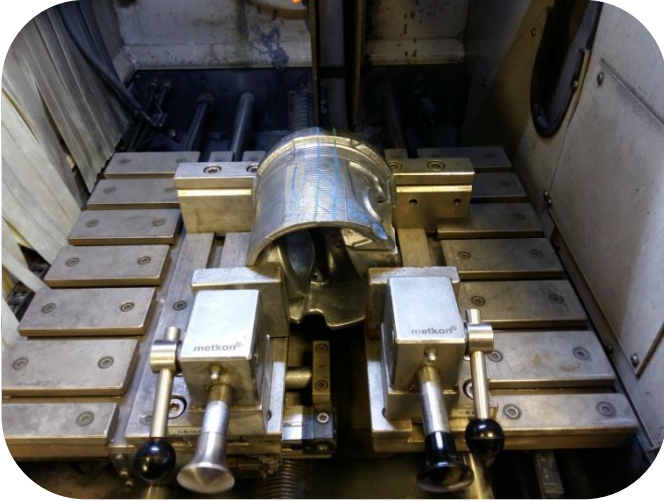
Sample was turned from second slice:



Big one was fixed to the table with GR 0029 and GR 0030 Quick acting clamping vises.
Requested width: 30mm



Sample was turned from second slice:



Cutting parameters for small piston :

Feedrate: 100 μ/sn

RPM: 2200 r/min

Time: 21 min

Cutting parameters for big piston :

Feedrate: 150-200 μ/sn

RPM: 2200 r/min

Time: 23 min

At the finally, samples cut properly.



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Technology behind Specimen

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20
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