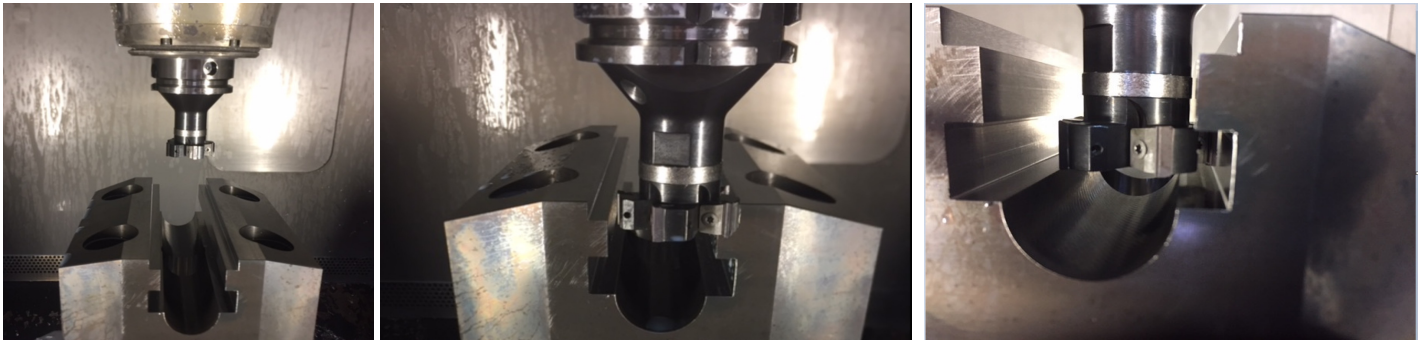


## Requirements

### Finishing guideway with facemilling and facemilling in undercut

- Roughing with ISO-inserts
- Angularity: 0,02mm
- Roughness: Rz=6,3µm
- Flatness: 0,02mm

Component: Box jaw L=180mm (see page 2)  
Machine: Alzmetall GS800 with HSK63-A  
Material: 42CrMo4 / 1.7225  
Competitor: Ingersoll



## Solution

Tool: Face milling cutter D=40 monoblock version; H6120-400 8063 R  
see page 3

Insert: W6120-0418 1000 N G16

Cutting data: Vc: 130 m/min rpm: 1034 rev/min  
fz: 0,08 mm Vf: 413 mm/min

## Result => Benefit for customer

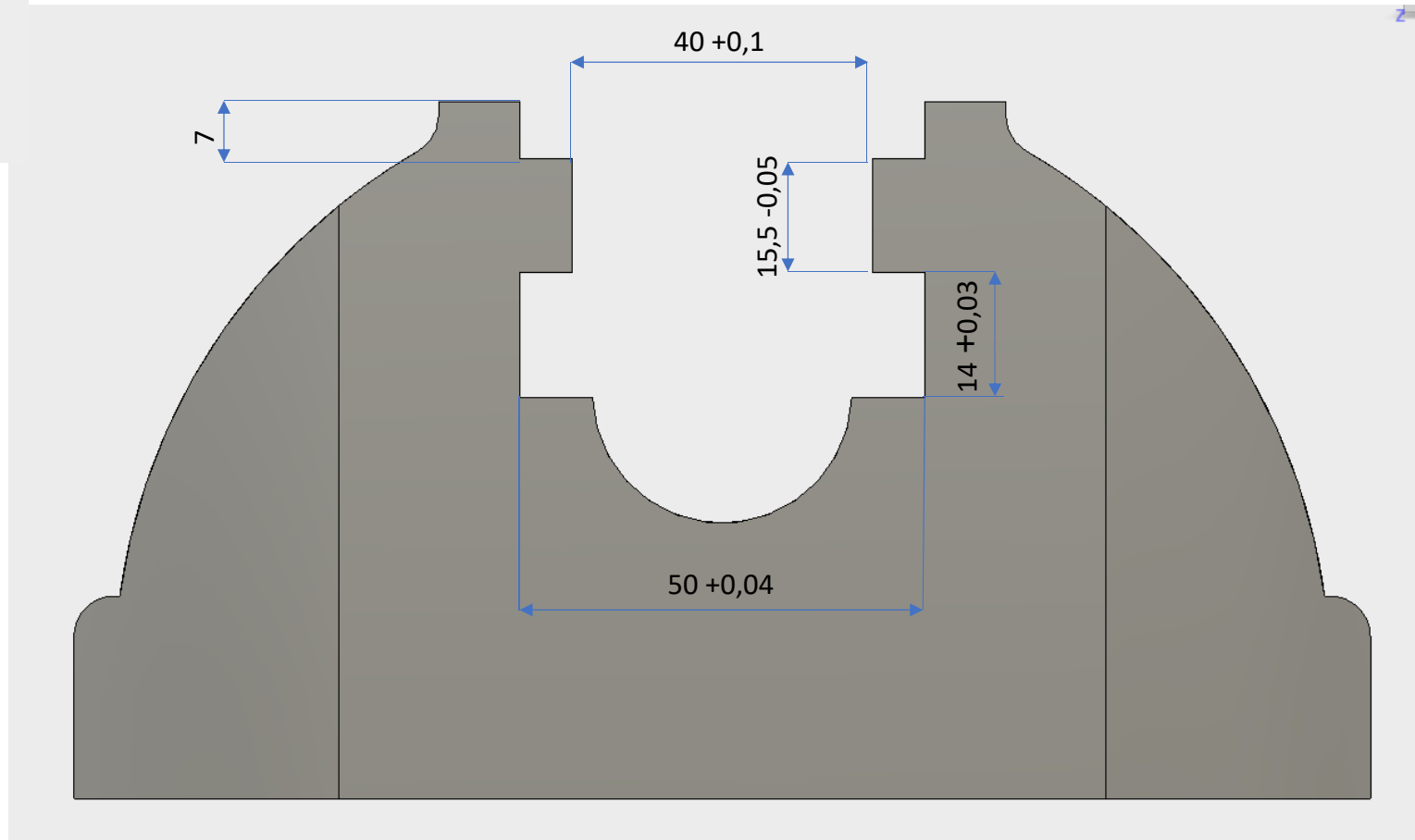
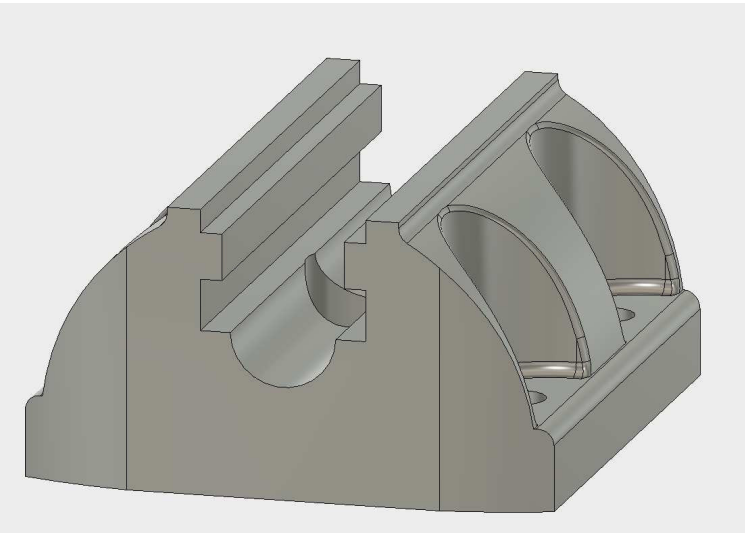
Angularity, surface and flatness are machined inside the required tolerance.

## Contact

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+49 (0) 172/6570 744

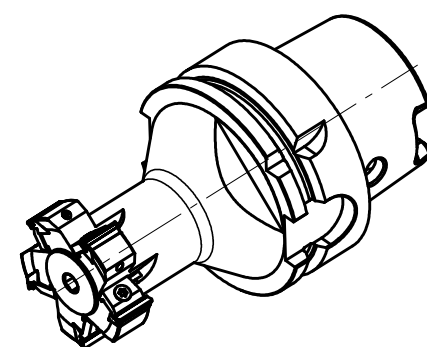
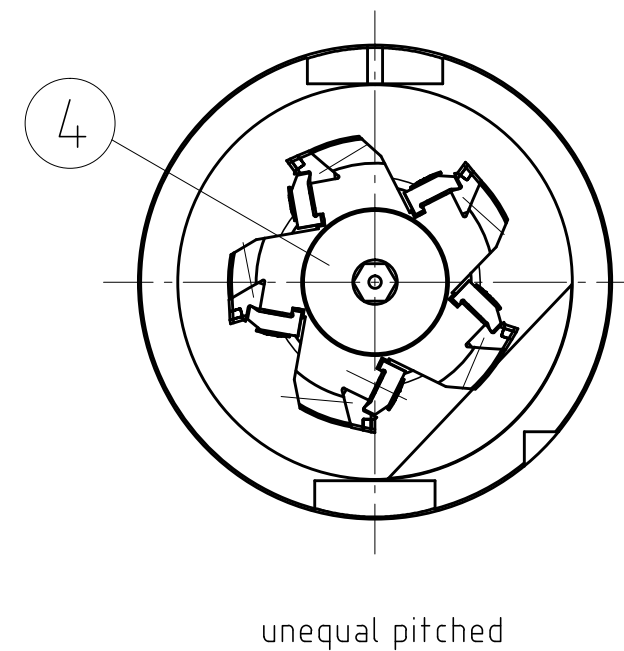
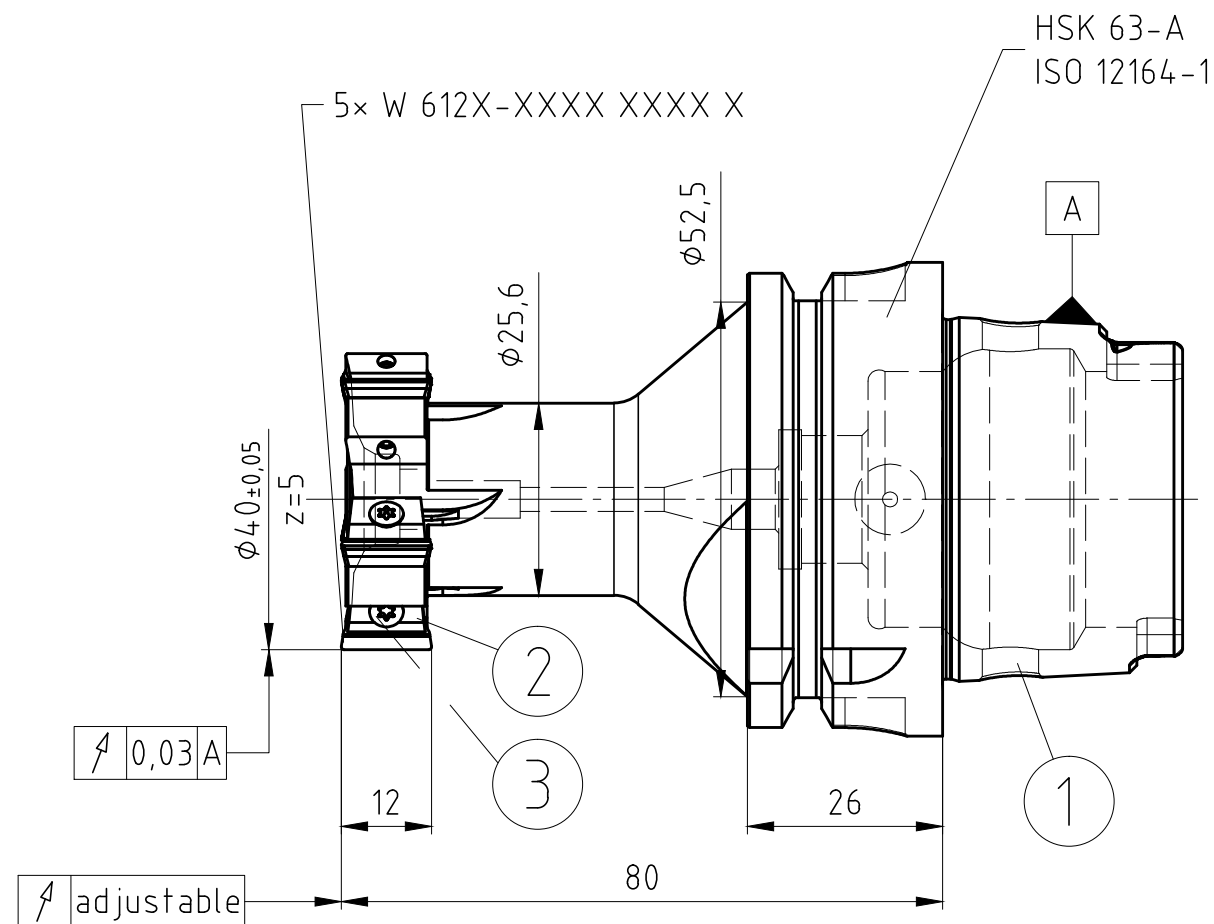
Mail:  
[b.hackeneis@hollfelder-cuttingtools.de](mailto:b.hackeneis@hollfelder-cuttingtools.de)



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index	modification	date	name



1:2

maximum allowed rotations: 48.000 1/min

complete tool assembly balanced		
X	static	balanced
	dynamic	
G= 6,3	n= 15.000	min <sup>-1</sup>

pc.	designation	pos.	number of drawing	material-/itemnr.	remark
1	Coolant distribution screw	4	E4192	20054 40,000	secured
5	Adjustment element	3	E4120	20052 2,501	SW 1,5
5	Clamping set	2	E4119	20051 2,500	Tx8 - 14.0 Ncm
1	Shank	1	H 6120-4000 8063 R	20002 40,002	-

AutoCad construction alternation only by CAD	surface quality, unless determined by standard specifications: $\sqrt{Rz 25}$	scale	general tolerances DIN ISO 2768 - m		
		1:1	drwn.:	23.09.2016	S.L.
This drawing is the property of Guehring KG. It is not allowed to copy it partially or completely, to publish it, or to use or communicate it for the purpose of competition without authorization.	undimensioned edges free of burrs: 0,3 x 45° (pocket seat excepted)	size	appr.:	23.09.2016	G.S.
		A3	Hollfelder - marking:		
	tempered 1.600 N / mm <sup>2</sup> burnished	material	H 6120-4000 8063 R		
	weight: 0,955 kg.		20002 40,002		



Milling cutter  $\phi 63$

pg. 1  
from 1 pg.

20002 40,002