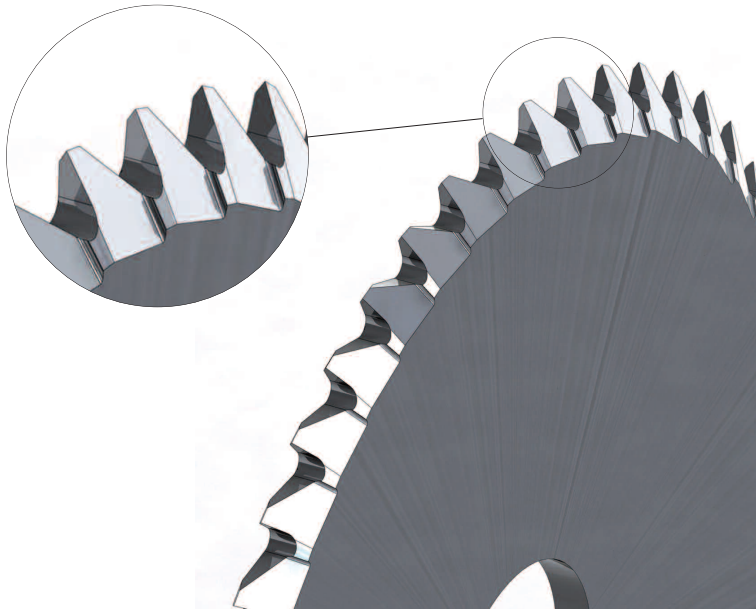


July 2007 - Application of the month

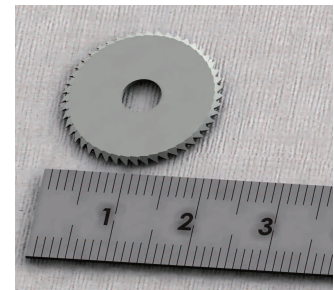
External threading through milling of a S 0.60 screw,
pitch 0.15mm

Application field: Turning screw-cutting/Watchmaking



Tool:

DIXI 1650 Ø20 x 0.6 x Ø5mm, Z=48 / 60°



Cutting conditions

Material	316L (stainless steel)
Machine	STAR - SB 16
Cutting data	Vc = 65 m/min fz = 0.001 mm
Lubricant	Blaser Supracut 23

Results

According to the series, 10'000 to 15'000 workpieces were machined. This technique improves the quality of the thread in comparison to a standard chaser. The thread is closer to the head of the screw, (under one thread). This method is now successfully implemented at the customer.