



CNC Inserts for Aluminum Alloy Wheel Hub Machining-

→ High efficiency and stability

- ◆ Special material guarantee the inserts have good wear and impact resistance
- ◆ Excellent chipbreaker design ensure the inserts have well cutting flow direction and chip breaking ability
- ◆ Super precision grinding technical for cutting edges make sure every piece inserts have accuracy dimentions,high qualified edges and reliable installnation

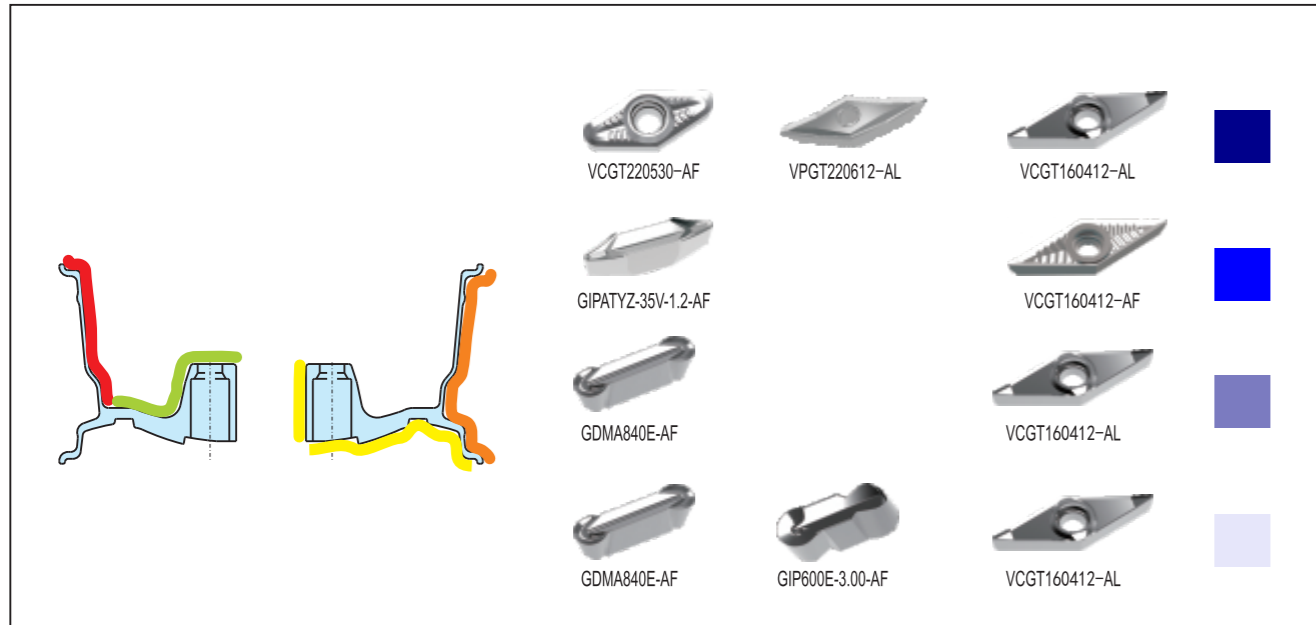


株洲大有新材料有限公司

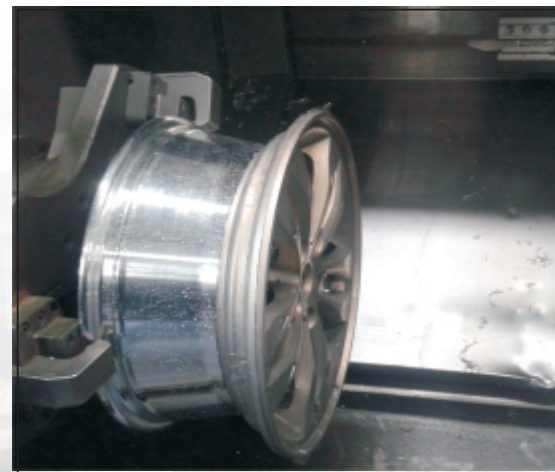
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铝合金轮毂加工方案

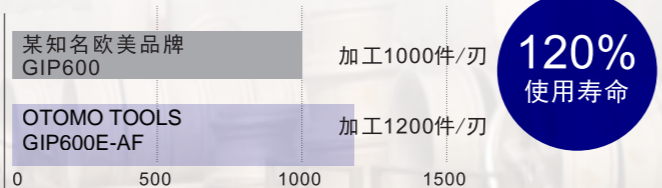


Application Cases: Machining for the out rim of the aluminum alloy wheel hub



Working condition
 Workpiece name: R17 Aluminum alloy wheel hub
 Workpiece material: Low-pressure casting aluminum alloy
 Insert type: GIP600E-AF

切削参数 Cutting parameters
 切削速度Vc: 2400m/min
 每转进给Fn: 0.5-0.7mm/rev
 切削深度Ap: 1-2mm
 加工工件数: 1200件/刃
 冷却方式: 高压切削液



Working condition
 Workpiece name: R17 Aluminum alloy wheel hub
 Workpiece material: Low-pressure casting aluminum alloy
 Insert type: VCGT220530-AL

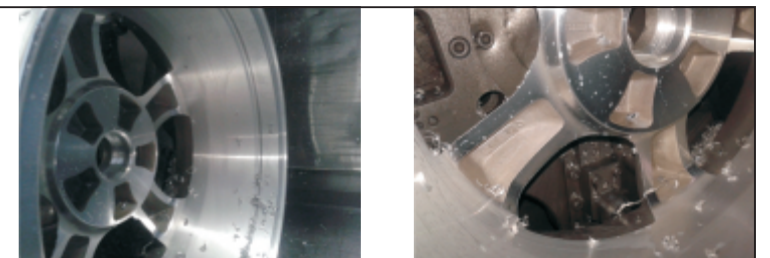
切削参数 Cutting parameters
 切削速度Vc: 2450m/min
 每转进给Fn: 0.5-0.7mm/rev
 切削深度Ap: 1.5-2.5mm
 加工工件数: 700件/刃
 冷却方式: 高压切削液



刀片基本形状 The basic shape of inserts	型号 Type	基本尺寸 Dimension (mm)					材质推荐 Grade recommendation
		L φI.C	B	S	R	a°	Uncoated Grade
							H10
	GDMA840-AF	30	8	8.2	4	7°	★
	GIPATYZ-35V-1.2-AF	30	7.2	8.2	1.2	7°	★
	GIP600E-3.00-AF	18	4.8	6.5	3	7°	★
	VCGT 160412-AF 220520-AF 220530-AF	9.525 12.7 12.7	4.76 5.96 5.96	1.2 2 3	7° 7° 7°		★ ★ ★
	VPGT 220612-AL 220530-AL	12.7 12.7	5.96 5.96	1.2 3	11° 11°		★ ★

Application Cases: Strong interrupted rough machining of aluminum alloy wheel hub spoke

Working condition
 Workpiece name: R16 Aluminum alloy wheel hub
 Workpiece material: Gravity casting aluminum alloy
 Insert type: GDMA840-AF



切削参数 Cutting parameters
 切削速度Vc: 2340M/MIN
 每转进给Fn: 0.5-0.7mm/rev
 切削深度Ap: 0.5-3.0mm
 加工工件数: 1200件/刃
 冷却方式: 高压切削液

