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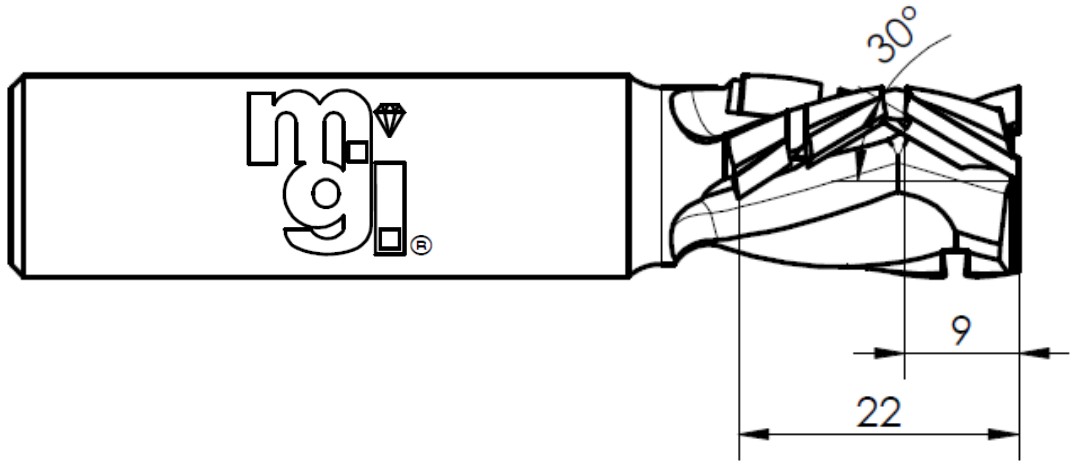
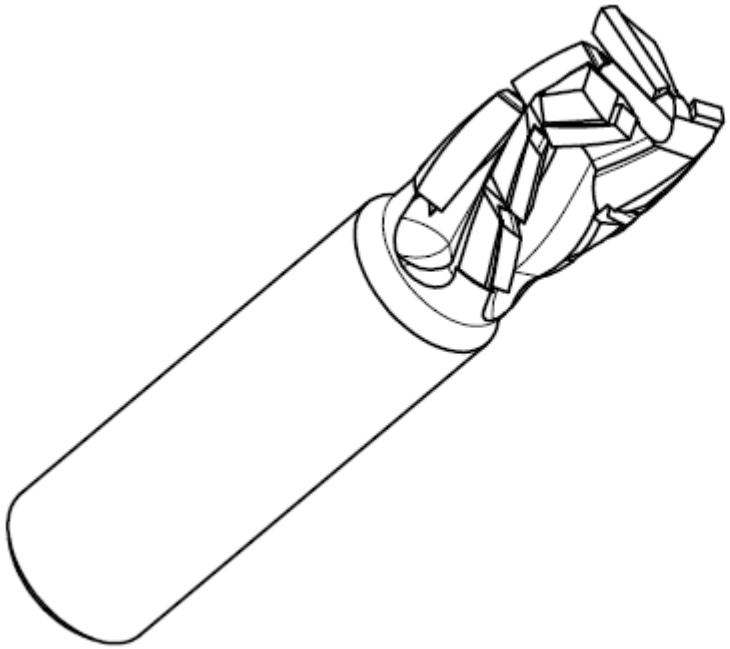
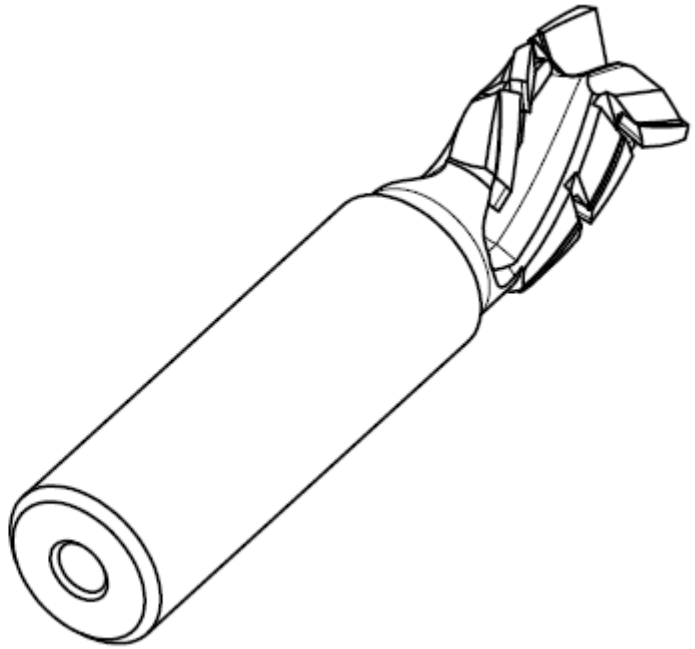
Ø16 x 22 – Z3
Part of the MGI
mid shear (30°)
PCD tooling program







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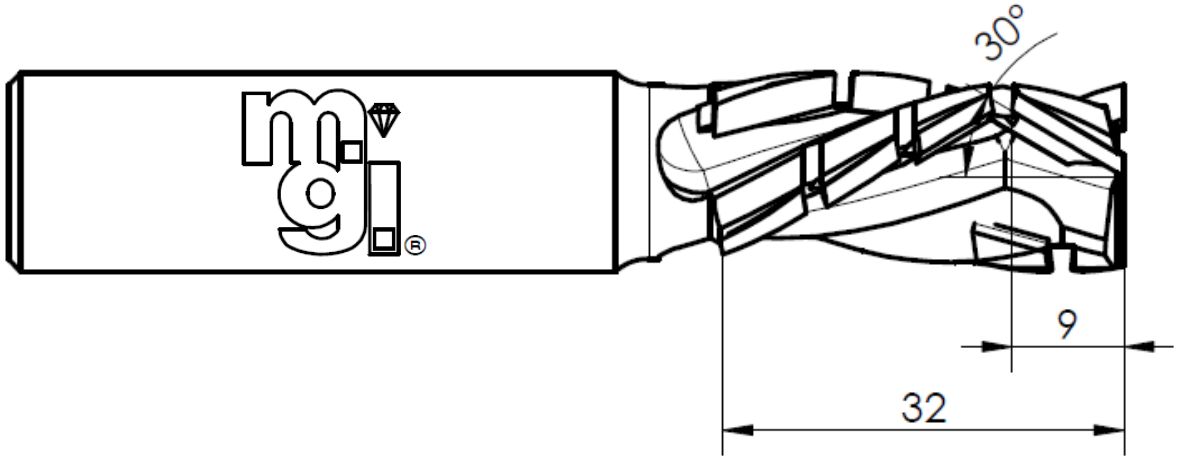
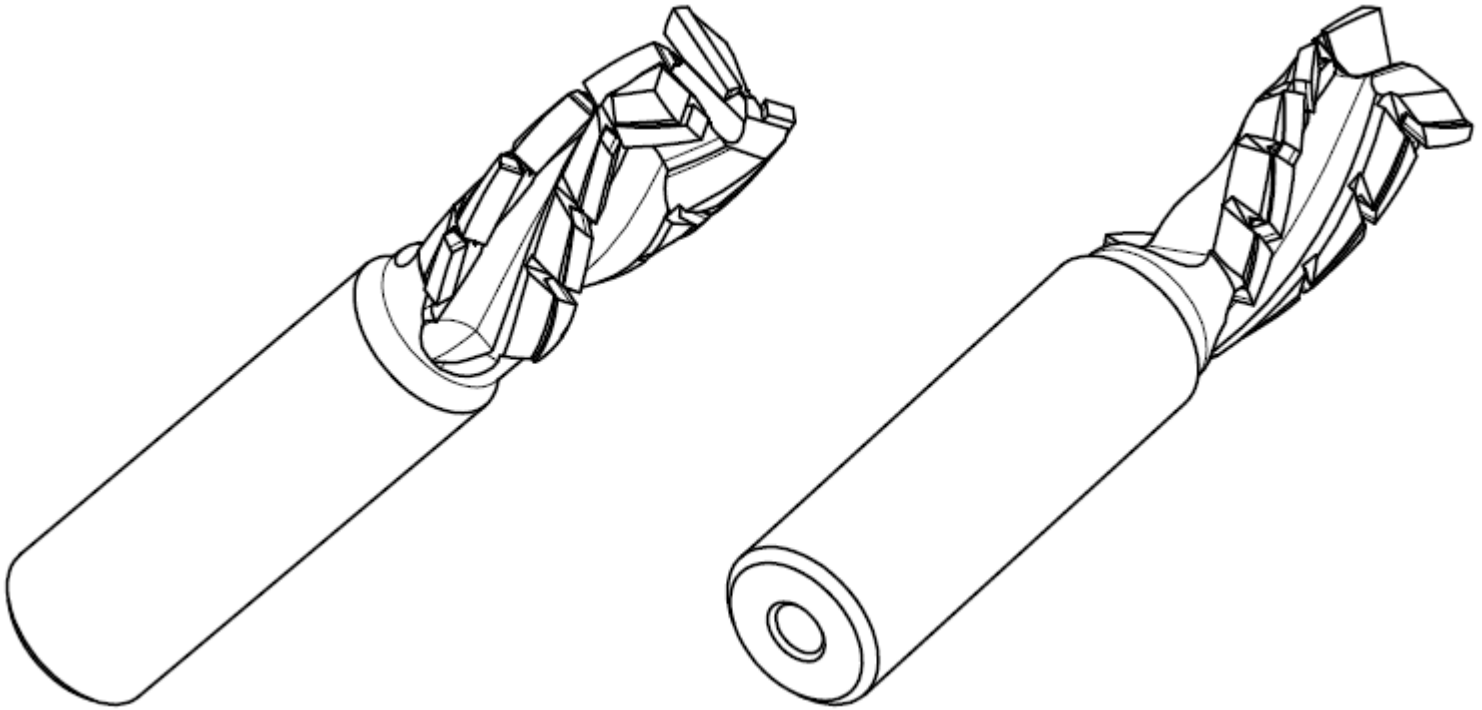


Ø16 x 32 – Z3
Part of the MGI
mid shear (30°)
PCD tooling program



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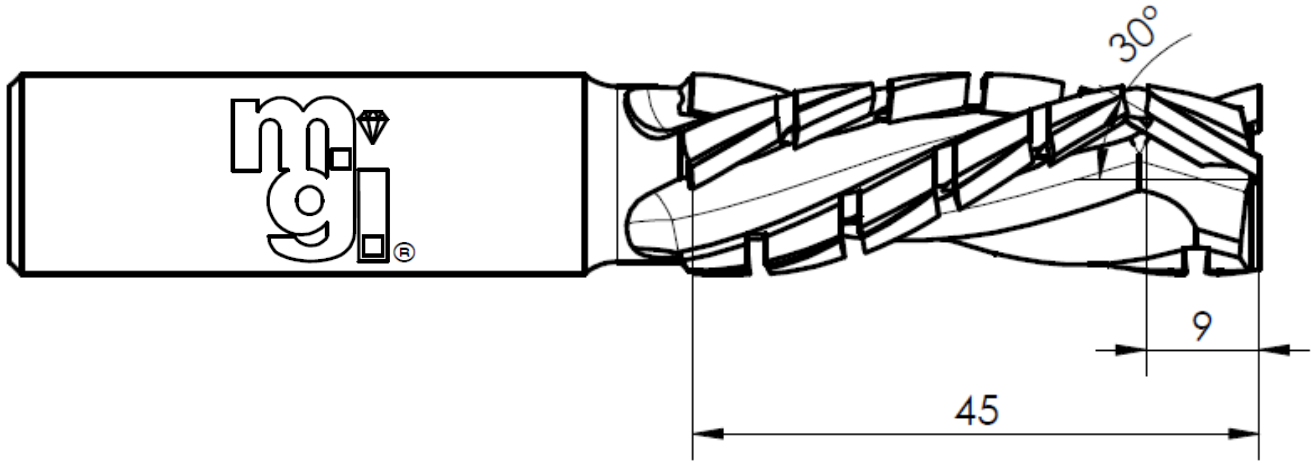
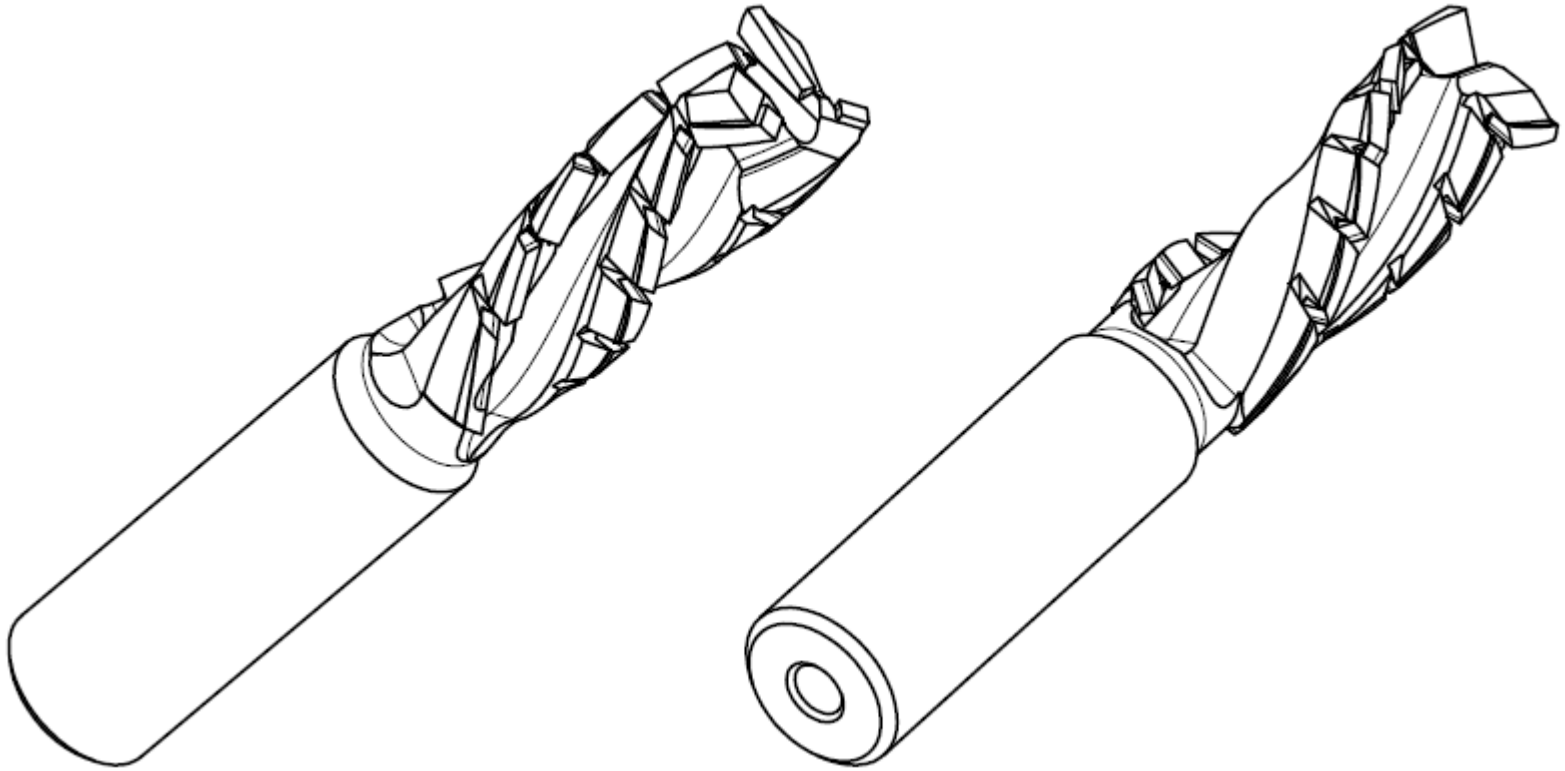
Ø16 x 45 – Z3
Part of the MGI
mid shear (30°)
PCD tooling program





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Parameters:

Edge routing removing 3mm
18.000 RPM
18m/min
Chip-load = 0,33

Full dividing cut
18.000 RPM
14m/min
Chip-load = 0,26

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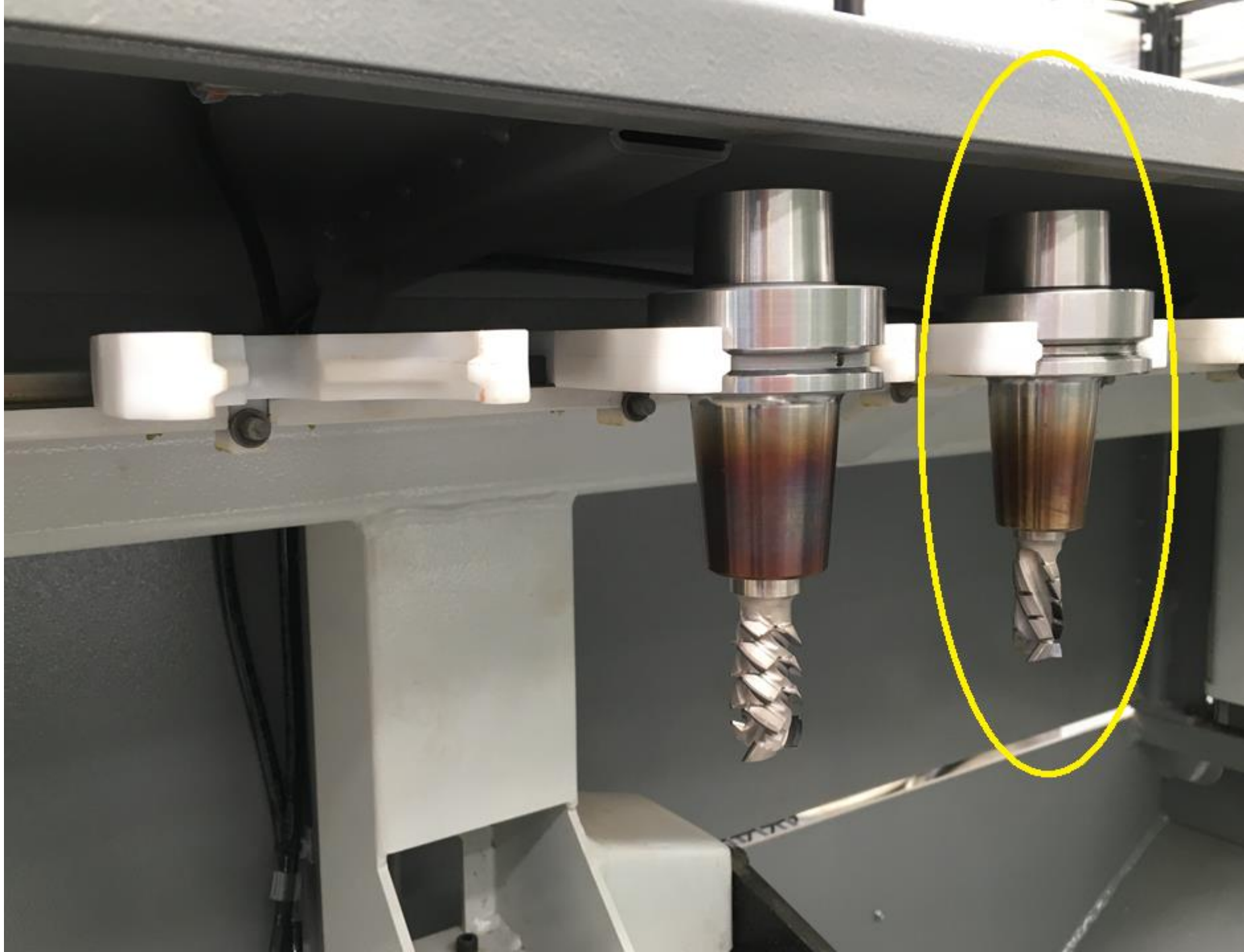
Balance class:
G2.5 @ 24.000 RPM

Tool-holder:
Thermo-Grip – HSK63F / d16



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Results on the material:
EDGES

Single pass:
Sharp edges, compact core

Melamine faced chipboard
Thickness 25mm

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Potential for faster cycles:
EDGE TRIMMING
20.000 RPM at 20m/min
22.000 RPM at 22m/min
24.000 RPM at 24m/min

For 25mm thick MFC reduce feed by 20% for dividing cuts

Melamine faced chipboard
Thickness 25mm

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PCD, Dense grade

Tollerance +-0,01

Best use:
Dividing cuts & roughing cycles at high feed speeds

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mgi®
TOOLS

Best use:
Dividing cuts & roughing cycles at high feed speeds

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