



Tooling demo
'ShakerSS'



Nesting MDF cabinet **doors**

Outside Shaker door profile **with bottom bevel**





Onion skin
Vs
One-shot

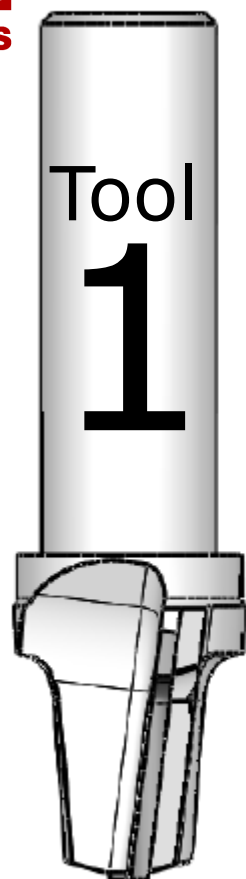
Material: 19mm MDF 1770 x 2800
Nest: 12 pieces

R2

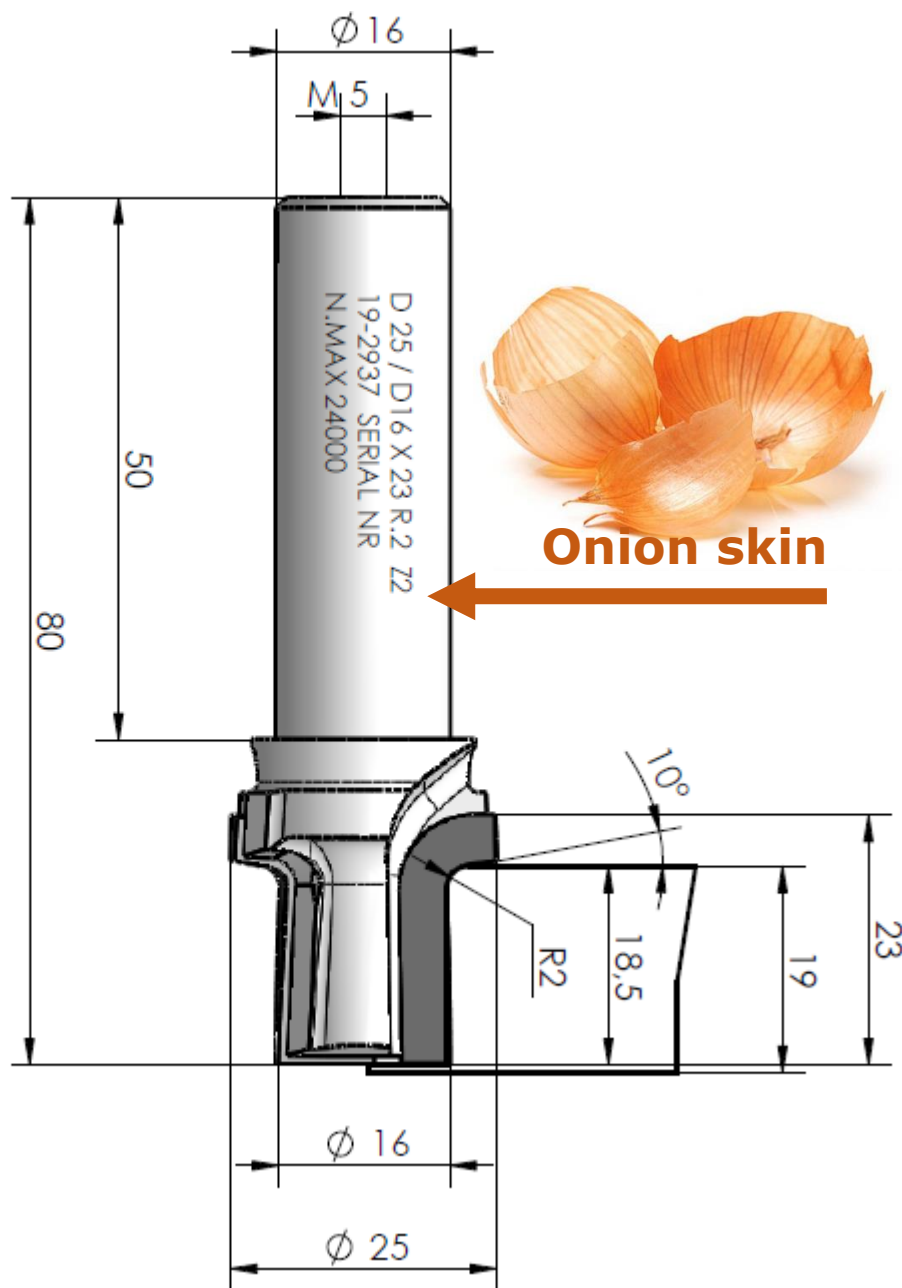
19mm

1mm

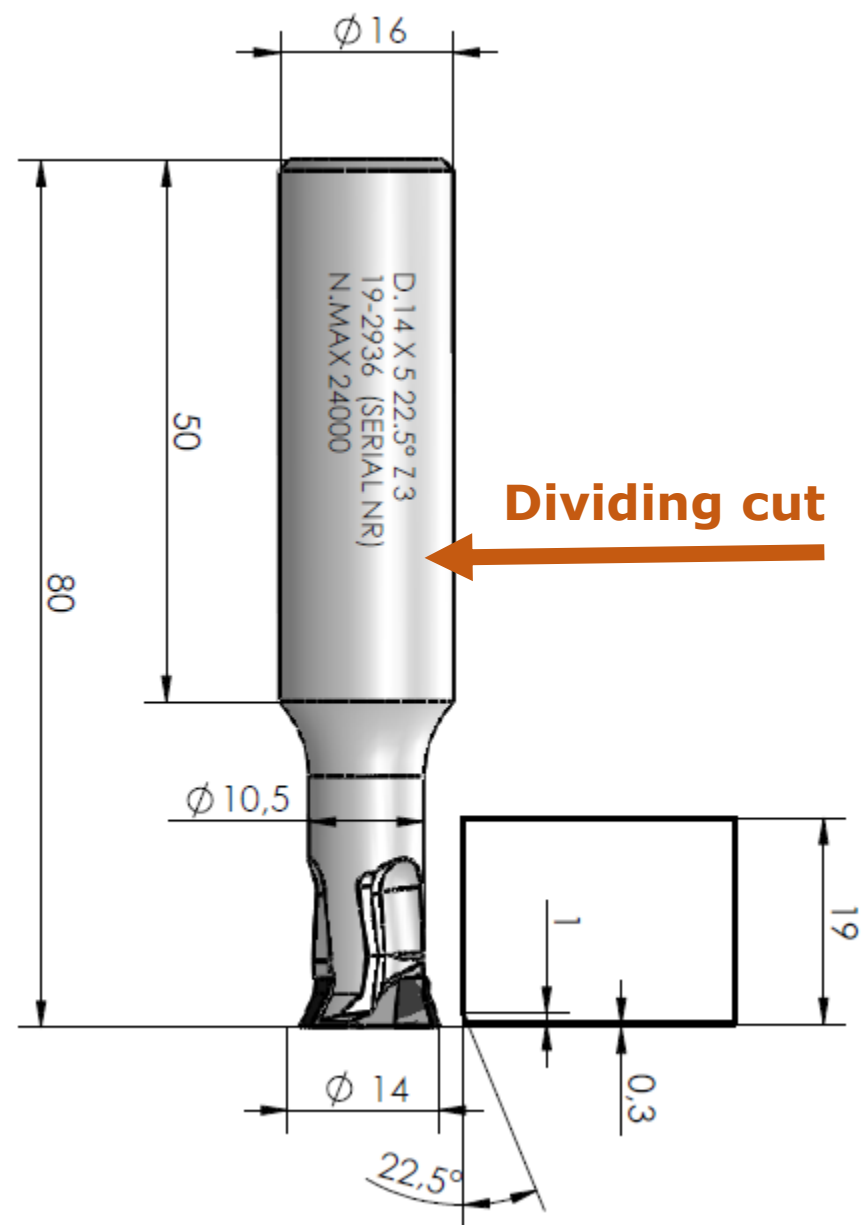
22,5°



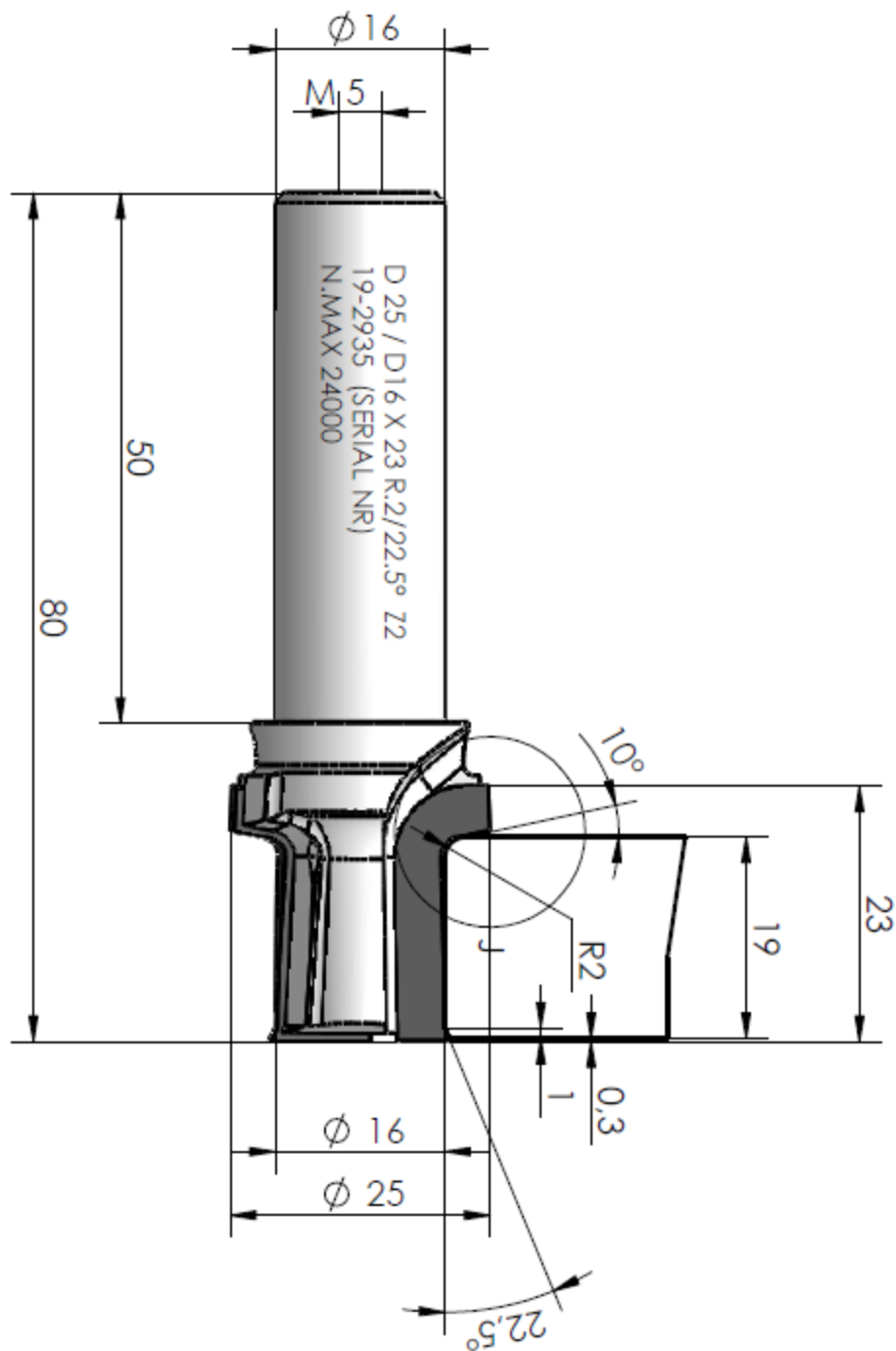
Tool
1



Tool
2



One-shot





Balance class G<2.5
@ 24.000 RPM



Fitted to Thermo-grip
holders HSK63F

Run-out tolerance $\pm$
0,02

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Tool 1

Operating parameters used:
22.000 RPM @ 12m/min

Tool 2

Operating parameters used:
22.000 RPM @ 20m/min





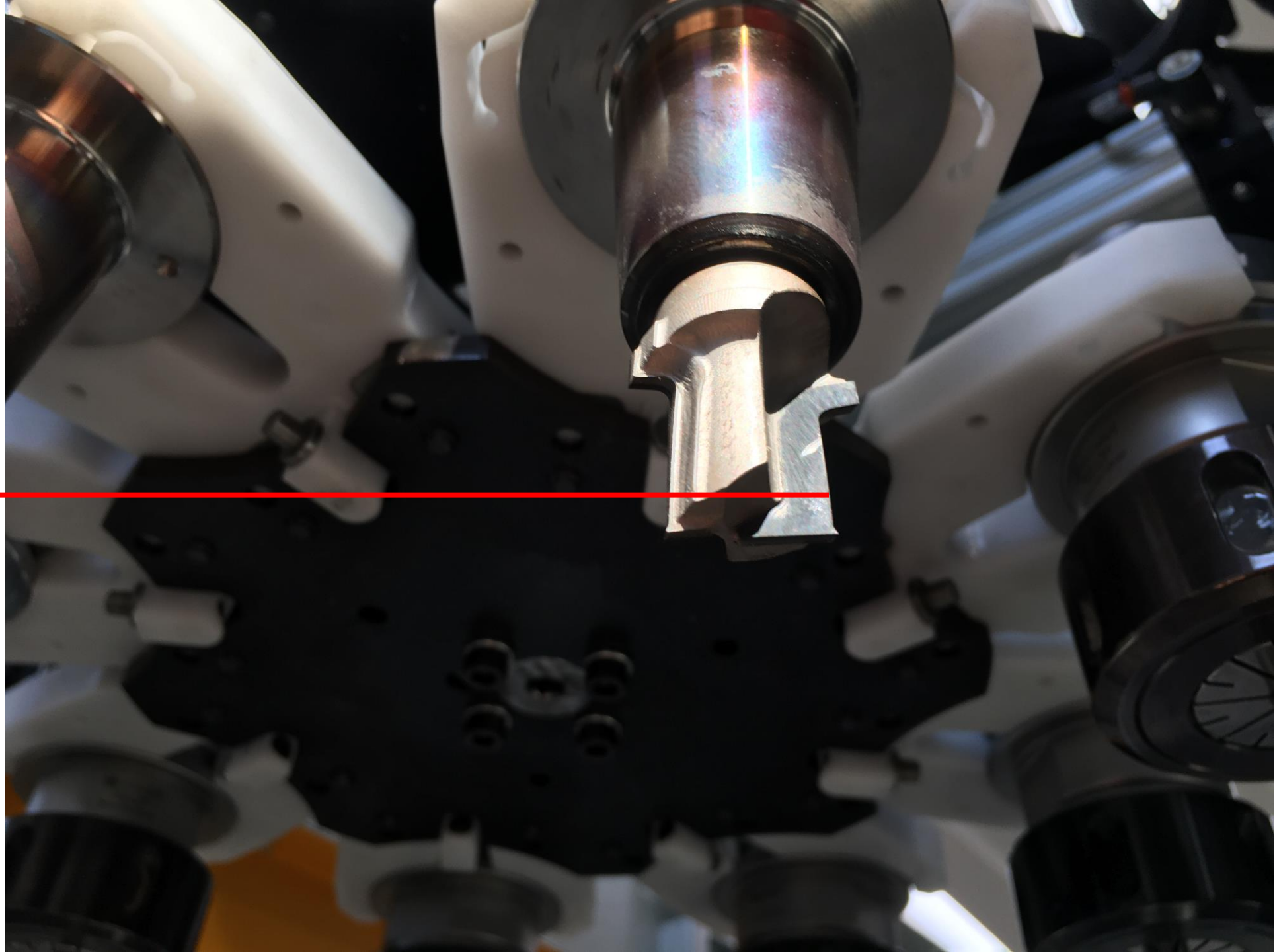
Balance class $G < 2.5$
@ 24.000 RPM

One-shot

Fitted to Thermo-grip
holders HSK63F

Run-out tolerance $\pm$
0,02

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Machining Parameters:

22.000 RPM - 12m/min
Z2 - Chip-load = 0,27



22.000 RPM - 20m/min
Z3 - Chip-load = 0,30

22.000 RPM - 10m/min
Z2 - Chip-load = 0,23
One-shot

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*6 minutes
17 seconds*

Cycle

times

*4 minutes
48 seconds*



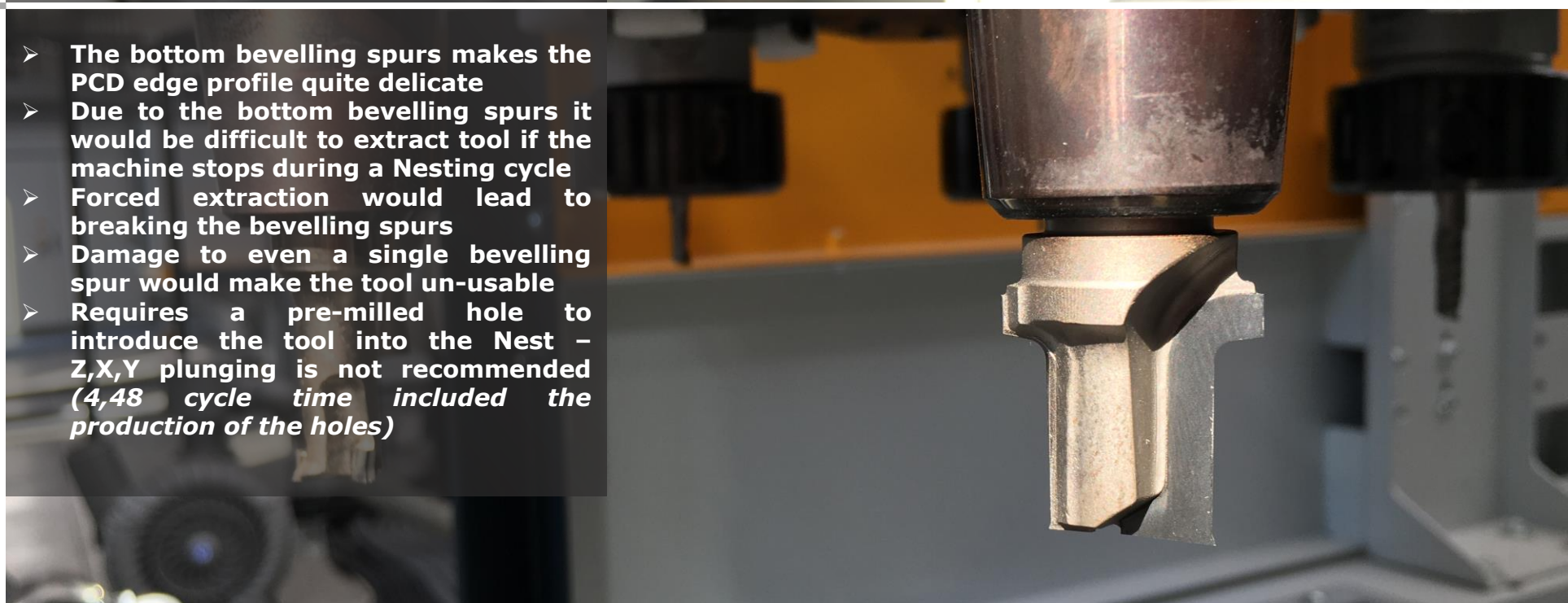
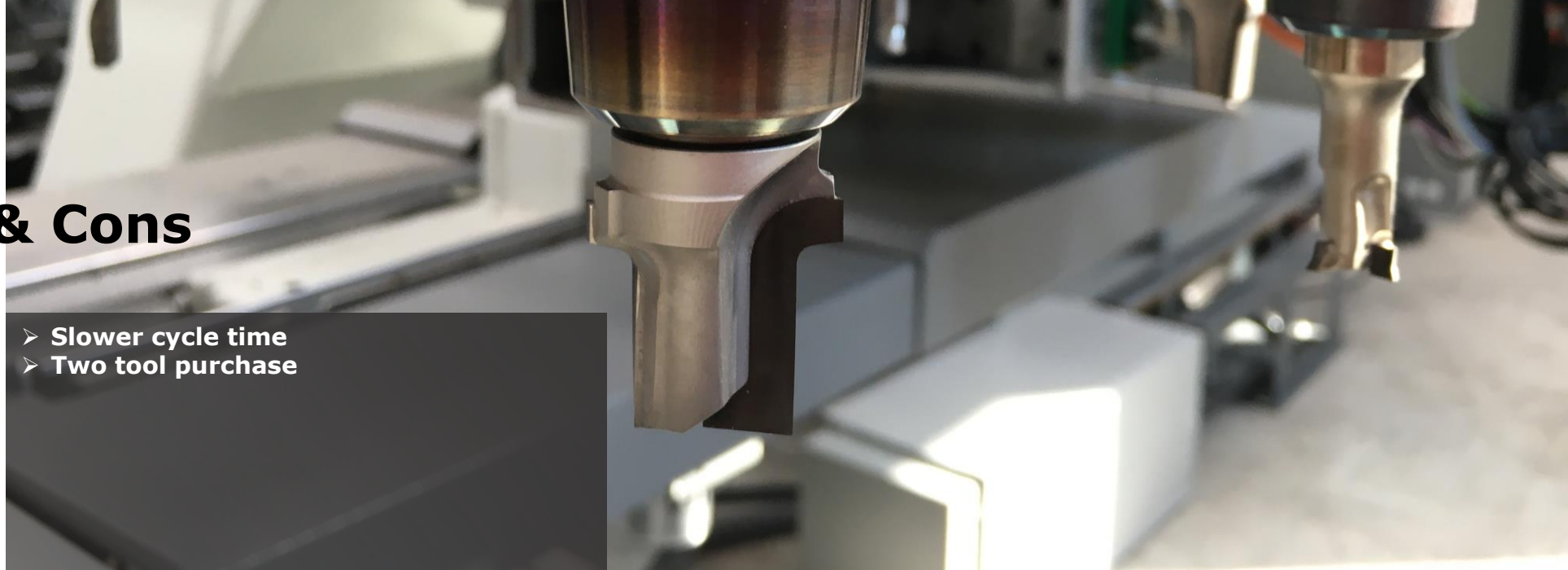
Pros & Cons

- More robust tool designs
- Easy to extract the R2 tool if the machine stops during a Nesting cycle
- The Z3 design of the bevelling tool makes the cutter usable even after damage to a single bevelling spur

- **Slower cycle time**
- **Two tool purchase**

- Single tool purchase
- Faster cycle time

- **The bottom bevelling spurs makes the PCD edge profile quite delicate**
- **Due to the bottom bevelling spurs it would be difficult to extract tool if the machine stops during a Nesting cycle**
- **Forced extraction would lead to breaking the bevelling spurs**
- **Damage to even a single bevelling spur would make the tool un-usable**
- **Requires a pre-milled hole to introduce the tool into the Nest – Z,X,Y plunging is not recommended (4,48 cycle time included the production of the holes)**





Nesting MDF ?

Try MGI

we know how

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