



TMSD CS34

Reported by	Pete Binns
Customer Location	Vargus UK
Date	27/01/2011

TMSD for a Better Surface Finish vs. Tap

On the finished product, the surface finish was found to be far superior to that of tapping.

Thread	1"x8UNCx70
Standard	UNC
External/Internal	Internal
Major Diameter	25.4
Pitch	8TPI
No. of starts	1
Thread length	70

Workpiece	
Identification No.	
Material	EN24T
Hardness	300 Brinell

Machine	
Machine type	Doosan HM45H
Controller	Fanuc
Coolant	Soluble
Coolant : int/ext	Both



Test Data	Vardex #1	Vardex #2	Vardex #3	Vardex #4
Insert	2UID60TM			
Grade	VTX			
Tool Holder	CTM2SC16C21-80-2U			
Cutting Speed V(m/min)	92			
RPM	1423			
No. of passes	1			
Infeed method				
Feed f(mm/flute)	0.159			

Results				
Failure - wear/breakage	Wear			
Tool life per corner	250			
Cutting Time	4min 11sec			
Surface Finish	Excellent			