

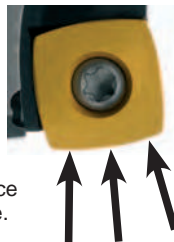


The advantages of face milling and producing cavities with Stellram's high feed face mill are numerous.

The unique design of the insert, approach angle and the cutter body ensure the cutting forces are predominantly directed in the axial direction. The example shown with a round insert tool shows complex forces which result in high levels of vibration and damage to the cutting edge.

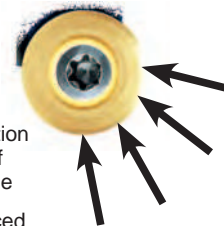
7792VX

- Cutting forces predominantly axial
- Relationship between cutting edge and work piece is at its most stable.
- Results in high feed rates and consistent tool life.



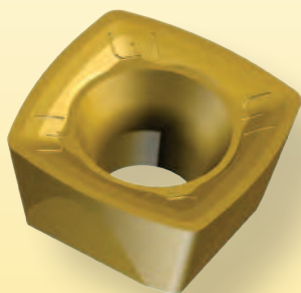
Round Insert Tools

- Tangential forces act around the radius
- Leads to vibration and damage of the cutting edge
- Leads to reduced feed and lower productivity



The 7792VX machines with a constant volume of chip throughout all aspects of producing cavities and produces a side wall that is close to profile.

Round insert tools have increasing chip volume through the process.



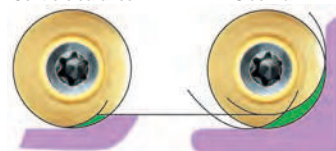
7792VX

- Constant cutting section (chip volume) irrespective of position in cavity.
- Producing a close to profile side wall.
- Near-square side walls possible.



Centre clearance

Side wall



Round insert

- Greater surface contact.
- Increased chip section for side wall machining.
- Vibration in corners.
- Undulating side wall cusps.