

mimatic[®]

Tool Systems

Your Partner For Clever Tooling

TurnCutMilling

eltimon[®] pro



Turn Cut Milling
instead of parting off

PolySAW

Manufacturer of Precision Tools Since 1974

Turn Cut Milling with PolySAW

Turn Cut Milling instead of parting off:
Faster parting off than anybody else!

mimatic DTF
advantages:

- Short process times
- Process reliability
- Material saving
- Surface quality
- Absence of burrs
- Short chips

The new process technology from mimatic is called Turn Cut Milling with PolySAW: Turn Cut Milling instead of parting off! This is the combined know how of live tools and cutting tools by mimatic.

PolySAW turn cut milling is enabled by the new QUADROGON interface developed by mimatic. Quadrogon safely and reliably transmits the high performance during Turn Cut Milling.

The high number of cutting-teeth of the PolySAW milling cutter also has a positive effect when machining asymmetric or thin components. Due to its continuous and uninterrupted tooth engagement and the resulting smooth machining process.

PolySAW milling cutters may look like conventional saws on first sight, however, mimatic has provided PolySAW with all the properties of high-value milling tools. The process reliability and performance of PolySAW is unmatched by conventional saws.



PolySAW

Examples for high quality TurnCut Milling:

Material: steel
 $R_z=1,0 - 2,7$
 $R_a=0,17 - 0,53$
 $f_z =0,015 - 0,03 \text{ mm}$
 $V_c=120-200 \text{ m/min}$



Material: aluminium
 $R_z=1,7 - 2,8$
 $R_a=0,36 - 0,6$
 $f_z =0,02 - 0,03 \text{ mm}$
 $V_c=200-600 \text{ m/min}$



Material: aluminium
 $R_z=1,7-4,0$
 $R_a=0,39-0,85$
 $f_z =0,02 - 0,03 \text{ mm}$
 $V_c=200-600 \text{ m/min}$



Material: aluminium
 $R_z=1,6-3,2$
 $R_a=0,38-0,62$
 $f_z =0,02 - 0,03 \text{ mm}$
 $V_c=200-600 \text{ m/min}$

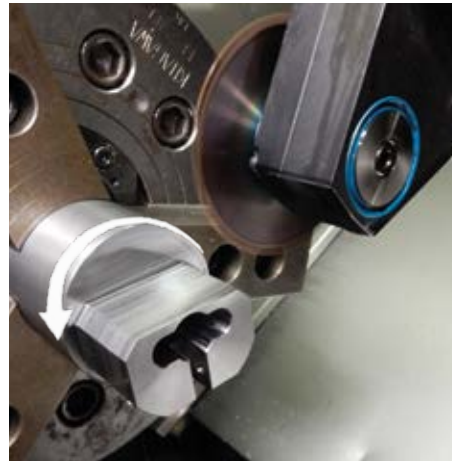


Turn Cut Milling with PolySAW

Turn Cut Milling instead of parting off:
Faster parting off than anybody else!



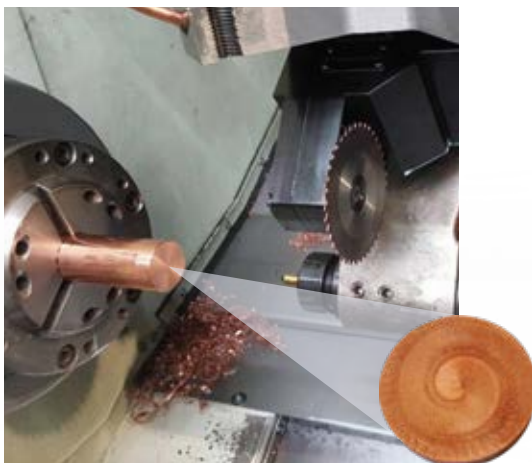
Cutting of VA structured components
Vc = 160 m/min
Fz = 0,1 mm



Turn Cut Milling : steel 16MnCr5
Vc = 160 m/min
Fz = 0,05 mm bei 40 Zähnen



Turn Cut Milling: aluminium
Vc = 800 m/min
feed = 7m / min



Turn Cut Milling: copper ETP
Vc = 300 m/min
Fz = 0,08 mm



videos to be found on youtube:
www.mimatic.de



Turn Cut Milling with PolySAW

Turn Cut Milling is the efficient alternative to parting off: mimatic is shifting the parting off into a new dimension.

Manufacturing of parts in modern machines has to be competitive through automation solutions. One person is operating several machines. Endless long chips are a big risk for a reliable process. Up to now the following alternative solutions are in use:

1. conventional parting off:
 - + tooling cost low
 - + fast at round parts
 - low reliability in the process
 - slow with non circular parts
 - cutting surface
 - formation of burrs and bosses
2. milling cutter with inserts:
 - + reliable Process
 - slow
 - burrs
3. conventional saws:
 - + short chips
 - low reliability in the process
 - slow
 - burrs

- new from mimatic:
4. Turn Cut Milling with PolySAW:
 - + fast at all geometries
 - + highest reliability
 - + short chips
 - + absence of burrs
 - + space between surface quality

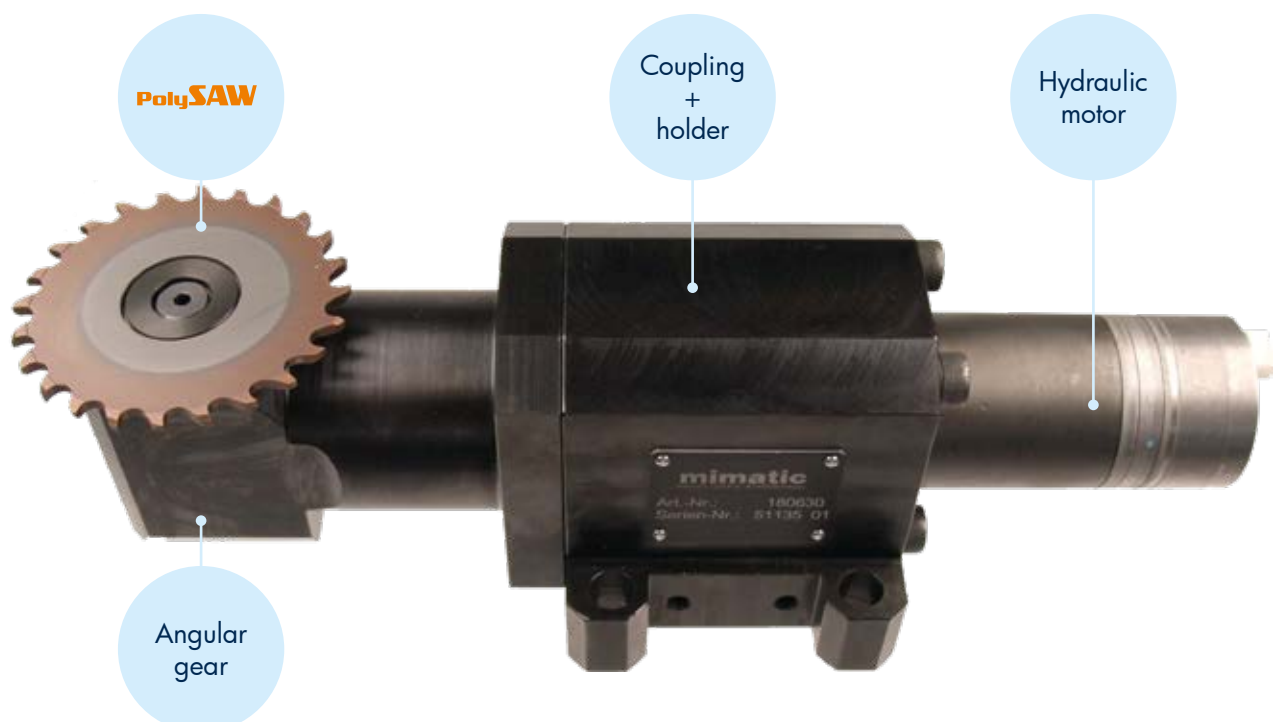
Turn Cut Milling the process:
 a) The part (square, angled, non symmetric or round) rotates slowly, PolySAW -as a multi teeth milling cutter- rotates faster. PolySAW. The turret moves PolySAW continuously into the part. The parting off -depending on material and partsize- will be finished after 2-5 rotations of the part.

b) The part does not move. PolySAW rotates fast. PolySAW moves continuously into the part passing the center. Than the part rotates .

mimatic has developed a software for calculating the process parameters. Customers are getting this support.

Turn Cut Milling with PolySAW is enabled through the new Quadrogon interface from mimatic. The Quadrogon transmits the required forces for Turn Cut Milling with PolySAW. The high number of teeth is especially positive to non symmetric or thin walled parts. PolySAW may look like a conventional saw, but it has the properties of a high performance milling tool. PolySAW reliability and performance is not to be compared with conventional saws!

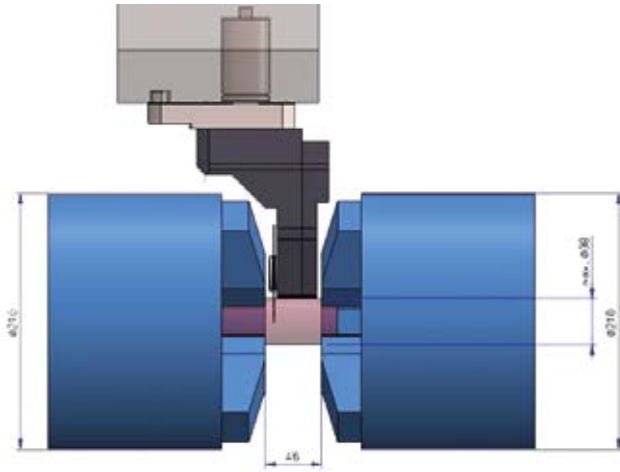
Complete solution in the working chamber of a machine tool



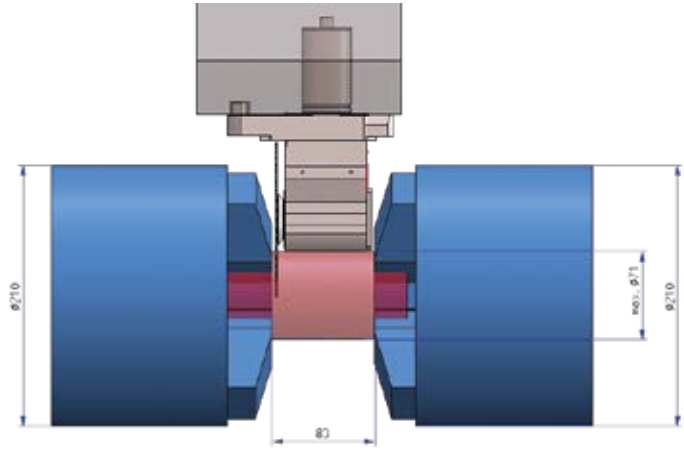
Turn Cut Milling with PolySAW

Examples for high quality Turn Cut Milling

machine with 2 spindles, 2 turrets, mimatic live tool for Turn Cut Milling and PolySAW 80



torque: 10 Nm
cutting depth: 17 mm
width of tool: 46 mm

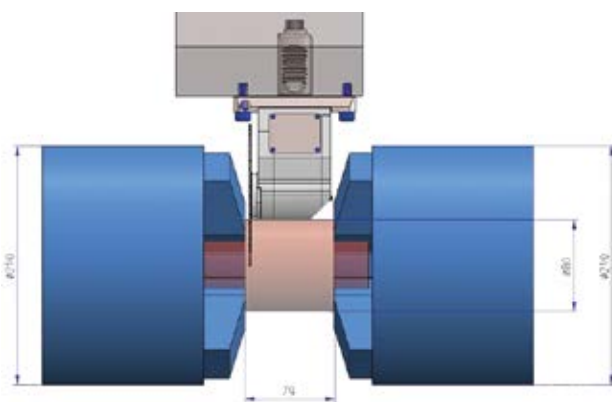


torque: 25 Nm
cutting depth: 15 mm
width of tool: 85 mm

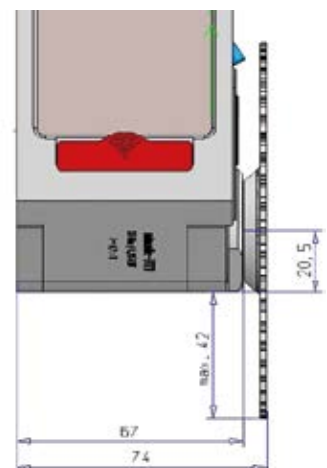
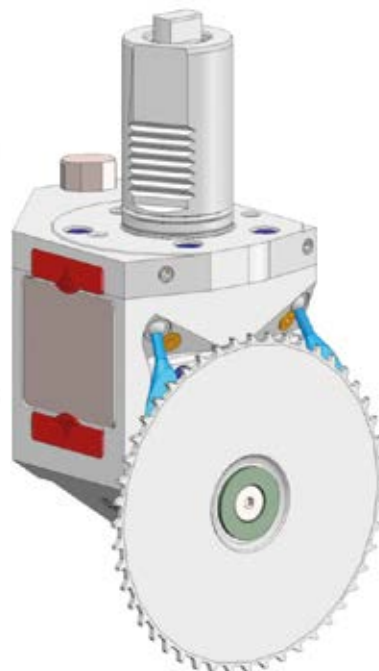


new: PolySAW 125 + DTF HD + eltimon[®]pro

DTF HD Turn Cut Milling „heavy duty“ with PolySAW 125: Turn Cut milling instead of parting off. DTF HD is the standard tool for all turning machines size similar to VDI 30 and VDI 40. High performance, high torque, high reliability and great cutting depth are the reasons! Reliable parting off for all parts until 80 mm diameter. The cutting is fast for all geometries, is burr free and with a super surface.



torque: 55 Nm
cutting depth: 40,5 mm
width of tool: 79 mm

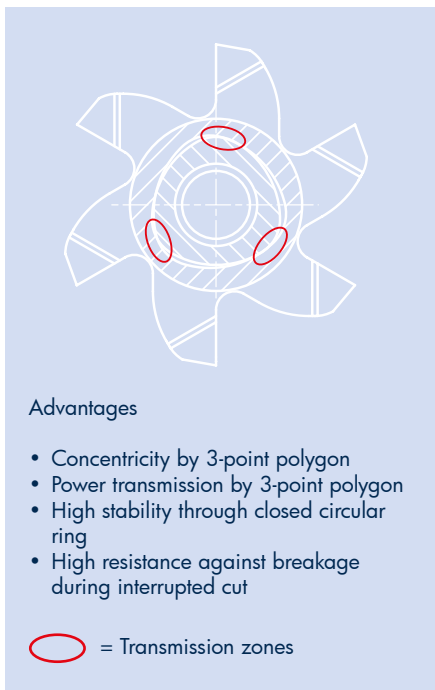


Turn Cut Milling with PolySAW

Quadrogon*-Interface For the new generation of mimatic tools

Since more than 40 years, mimatic has experience in the development and production of interfaces between tool holders and carbide inserts for milling. The most successful of these developments was the mimatic P-interface, which is today in use in many countries in the world. This interface has a front face with a polygonal power transmission of the cutting forces. The so-called triple-polygon is statically determined and has a self-centring effect of the carbide insert against the holder.

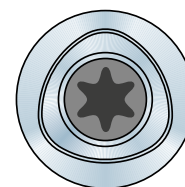
The main features of the previous mimatic P-interface have been maintained in the development of the Quadrogon interface.



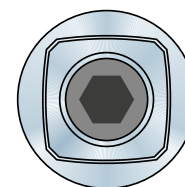
* Patent-protected

The front face as well as the declining behavior against stress peaks are also central features. The fact, that there are four polygonale elements in the Quadrogon interface causes, that the cutting forces can be shared on a larger area and thus stress peakes can be reduced still more effectively.

This means, that higher forces can be transferred for same diameters.



mimatic
Polygon Interface



mimatic
Quadrogon*

Turn Cut Milling in action



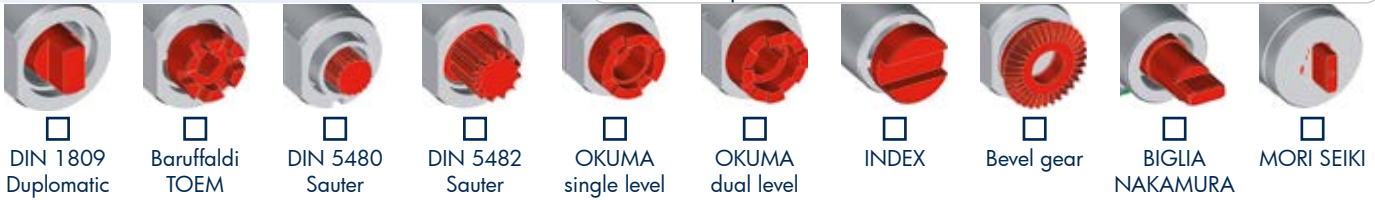
Turn Cut Milling with PolySAW

We adjust Turn Cut Milling to your turning machine, your material and your components!

Company	
Name	
Street	
Zip/City	
Phone	
Fax	
E-Mail	

Specifications of the Machine

Manufacturer	
Type, Year of manufacturing	
Machine No.	
Coolant	
Coolant pressure (internal coolant)	
max. Spindle speed	r.p.m.
max. torque of the spindle	Nm
Turret manufacturer	Typ No.
Turret type	Disc-tape turretStar-type Turret
Number of slots	
max. required diameter for tools on turret	mm
Operation	Main spindle <input type="checkbox"/> Sub spindle <input type="checkbox"/>
interface	<input type="checkbox"/> BMT, <input type="checkbox"/> VDI30, <input type="checkbox"/> VDI 40, other:
turret drive	please mark with a cross:



Info for Turn Cut Milling:

diameter parts		previous:	
cutting width			mm
Material			
tool type			
cutting speed			m/min
Part drawing	yes (please transmit)		
time for parting off			sec
other			
required surface quality			Rz
burrs		<input type="checkbox"/> yes <input type="checkbox"/> no	
boss		<input type="checkbox"/> yes <input type="checkbox"/> no	
Coolant		<input type="checkbox"/> yes <input type="checkbox"/> no	
internal coolant pressure max.			bar
Nozzle		<input type="checkbox"/> yes <input type="checkbox"/> no	
Coolant pipe		<input type="checkbox"/> yes <input type="checkbox"/> no	
Remarks:			

mimatic®

Tool Systems

Your Partner For Clever Tooling

- Circular- and Thread Milling Tools
- RPK-Reamers with Polygonal Interface
- Driven Toolholders for CNC Machining Centers
- Driven Toolholders for CNC Turning Machines
- Multi-Spindle Technology
- Modular Quick Change Toolholders mimatic® mi
- Static Toolholders for CNC Turning Machines
- Precision Chucks
- Special Cutting Tools

- Zirkular- und Gewindefräswerkzeuge
- RPK-Reibahlen mit polygonaler Schnittstelle
- Angetriebene Werkzeuge für CNC-Bearbeitungszentren
- Angetriebene Werkzeuge für CNC-Drehmaschinen
- Mehrspindel-Technologie
- Modulare Werkzeugaufnahmen mimatic® mi
- Statische Werkzeugaufnahmen für CNC-Drehmaschinen
- Präzisions-Spannfutter
- Sonder-Zerspannungswerkzeuge



184864 WM-PROSPEKT-DTF-ELTIMONEN

mimatic®
Tool Systems



mimatic GmbH
Westendstraße 3
D-87488 Betzigau
Tel. +49 (0) 831 / 574 44-0
info@mimatic.de
www.mimatic.de