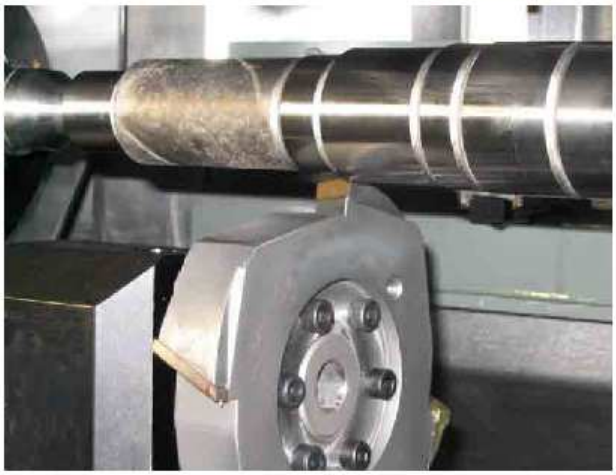
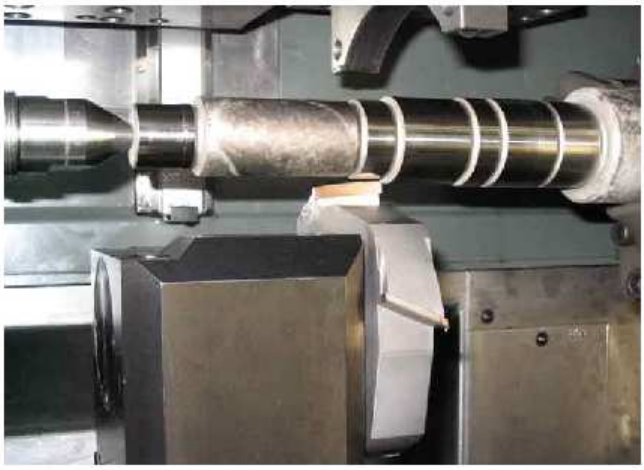
WEISSER sets new standards!





Surfaces free of lead by rotational turning

Thanks to an absolutely new process now it is possible to produce turned surfaces **free of lead** using high quality rotational turning. This newly developed technology with operations such as

- **External turning**
- **Internal turning**
- **Facing**
- **Hard and Soft turning**

provides reduced machining time while producing high quality contact surfaces on shafts requiring lip type seals.

This rotational turning technology developed by Weisser replaces time consuming finish-machining such as grinding or burnishing.

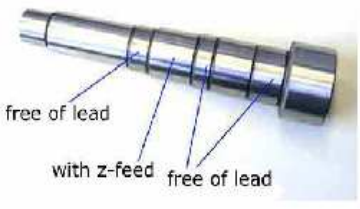
Hard and rotational turning with a disc type turret head means:

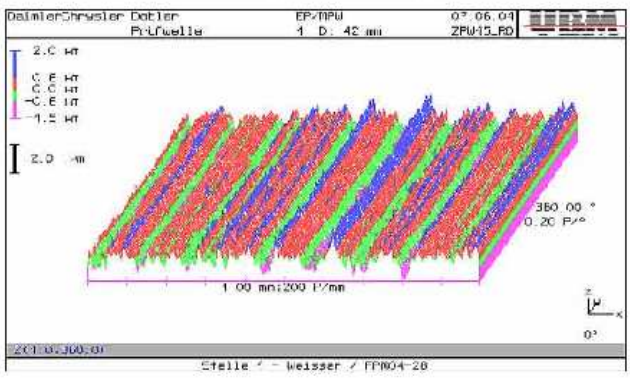
- Shorter machining times
- Higher cutting speed
- Low investment costs
- High process guarantee
- Dry machining
- Defined surfaces free of lead

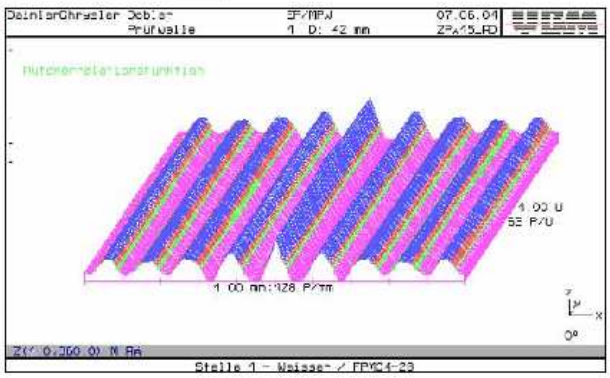
[X] Neuzustand	[ ] Ausbau nach		km		h
Auftrag:	Fa. WEISSER	Zchn. Nr.:		Messort:	Stelle 1
Teil-Nr.:	1	Datei:	PW15	Bearb.:	rotationsgedreht
Bemerkungen:	Zoom R-Profile über 360° (cut-off:0,40mm) / Autokorrelationsfunktion				

Lead		Periodlength	number of starts	mean	mean theoretical	DRAVI
Gradient	Angle			Lead-depth	cross-section	
0.00 mm	0°00'	0.11 mm	0 - gängig	0.76 µm	58 µm2	

Rauheitskenngrößen aus Messblatt Einzeltastschnitt !					
Rz	Ra	Rmax	Rpk	Rk	Rvk
3,35 µm	0,48 µm	3,78 µm	0,64 µm	1,50 µm	0,54 µm







At least 3 times faster !

(when lead free surfaces are not required)

rotational hard turning with Z-feed

Process	Radius	Vc	F/U	F tang./U	F rad./U	Cut time in seconds
Hard turning	0,80 mm	180	0,09			14,5
Hard turning with Wiper	0,80 mm	180	0,13			10,0
Rotational hard turning with Z-feed	**Special**	**180**		**0,18**	**0,16**	**3,3**

Component	Gearbox-shaft
Material	Hardened Steel 62 HRC / EHT 0,5 +0,2
Cutting material	CB 08 / Sandvik Coromant
Diameter	39,00
Length	32,00
Surface quality	Rz in µm < 4 Ra in µm < 0,60

Sample components: