

HEULE CASE STUDY

Precision Machining Application COFA

Replacing Time-Consuming Manual Deburring for Cross Holes

Challenge:

A mechanical engineering company was deburring the bores in this bushing manually. What made the deburring difficult was the fact that the bores were located in the lubrication groove. The task was to deburr the outer and the inner bore edge of these cross bores automatically.

Application details:

- Outer diameter: Ø144.0 mm
- Inner diameter: Ø130.0 mm
- Crossbore diameter: Ø6.0 mm
- Material: Brass

Machining parameters:

- Working speed: 500 rev./min.
- Working feed: 0.1 mm/rev.
- Coolant: external coolant

Solution:

Tool: COFA6/6.0/H
Blade: GH-C-M-0002

The difficulty to deburr the bores thoroughly lies in interior of the bushing. These grooves put high demands on the blade. This is why low cutting values have to be applied. The blade has to be given enough time to follow the bore edge.

Results:

Time-consuming manual deburring was replaced with the HEULE COFA tool, resulting in reduced labor and cycle times, which also reduced production costs.

