

Modular Pineapple Mill



- ✓ **Side milling of high quality surfaces.**
- ✓ **For geometries which aren't accessible for face milling.**

SUPERIOR SURFACE FINISH CAPABILITY

- > Based on successful pineapple system for lateral and face milling, this new development allows the combination of the previous solution with excellent finish on lateral perpendicular faces.
- > Flat and non-flat surfaces can be machined with the same high quality.
- > The modular system allows for full interchangeability between tool systems.

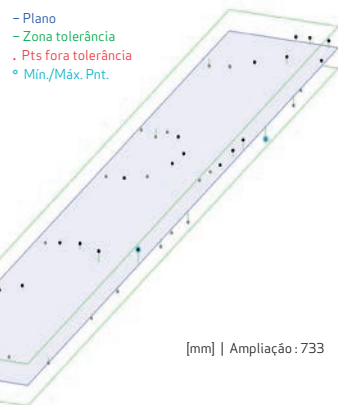


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Superior Surface Finish Capability



CUTTING PARAMETERS			
S (rpms)	F (mm/min)	Ap (mm)	Fz (mm)
5000	600 mm/min	0,5	0,04

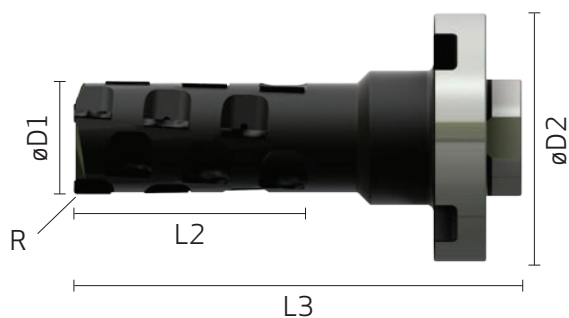


PRODUCT DETAILS

- PCD tipped.
- Excellent for finishing in side milling applications.
- Soft cutting through axial rake development.
- Excellent tool life.
- Fine balanced for High Speed Cutting.
- With internal cooling.
- Modular adapter with 4x4.

APPLICATIONS

- Can be used both for mild roughing and finishing.
- Common system for gear box and cylinder head production.
- Perfect for Aluminum, AL-Alloys and Magnesium.
- With finishing parameters Ra-0,4 μm (and below) achievable.



With this system it is possible to achieve a surface roughness between:

$$Ra \rightarrow 0,4 \text{ to } 0,2 \mu\text{m}$$

Flatness of 0,013mm
(measured on 200mm length)

Art. n°	øD1	øD2	L1	L2	R	Z
9594.0300	30	70	110	50	0,4	3
9594.0400	40	80	130	60	0,4	4
9594.0500	50	100	150	70	0,4	5

Requires cutting edge run-out adjustment in the machine spindle.