

ASSAB 17

lo mejor en buriles



ASSAB 17: Es bien conocido en todo el mundo por sus excelentes propiedades de corte, resistencia al desgaste, tenacidad y resistencia a la temperatura. Está fabricado en acero rápido con una alta aleación de cobalto, y manufacturado de acuerdo a métodos de producción los cuales han sido

desarrollados sucesivamente, basados en una experiencia internacional. La dureza de 67-69 Rockwell C es cuidadosamente ajustada para darle a cada buril ASSAB 17 forma y tamaño con óptimas propiedades para su aplicación.

ASSAB 17

Use coolant to avoid burning and softening the tool bit

Grind over the whole width of the wheel

The grinding pressure must be satisfactory hard, so that the grains bite into the tool bit

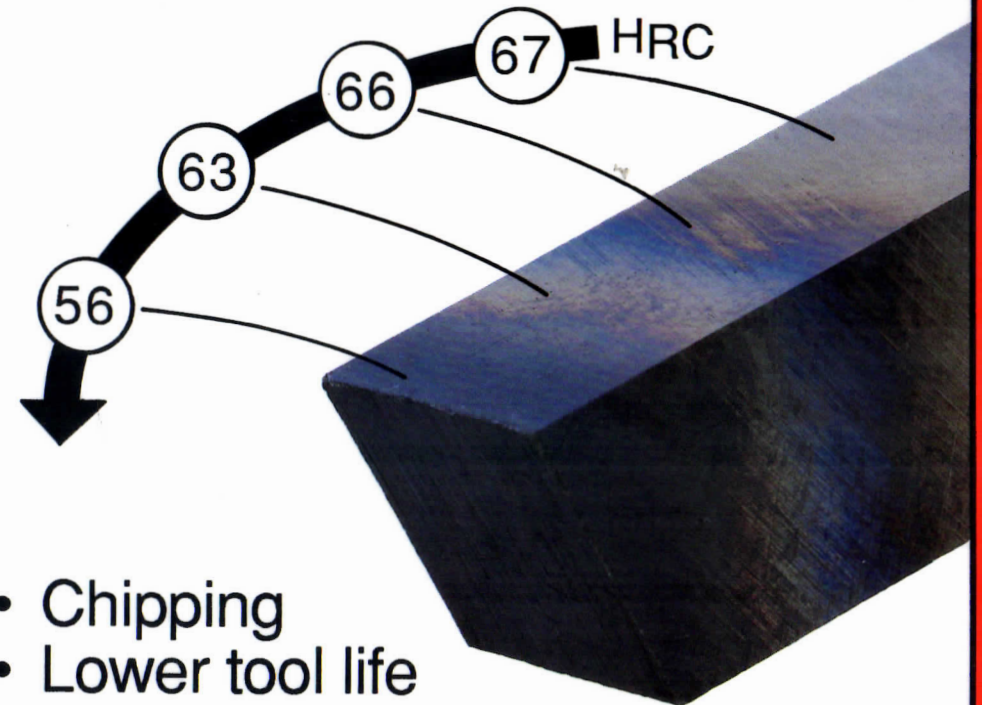
Make sure that the wheel is properly dressed and centred

Grinding wheel selection

Machine	Abrasive	Hardness	Grain size	Grain spacing	Bond
Tool and contour grinder	Aluminium oxide	Soft	46 - 60 *		Vitrified
	Boron nitride	R	120	75	Resinoid
Bench grinder	Aluminium oxide	Soft	46 - 60*		Vitrified

* Grain size 46 is normally used for roughing. For fine radii a grain size around 120 to 180 should be used.

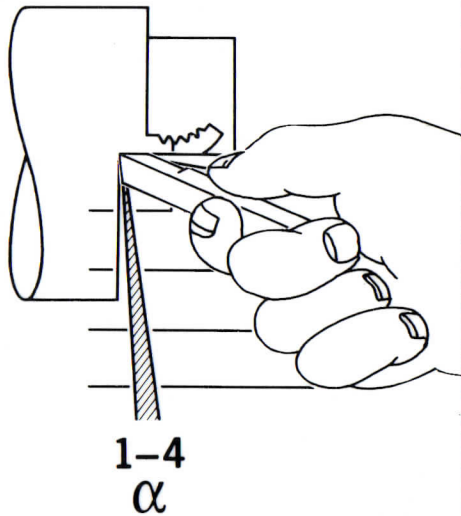
HEAVY HANDED?



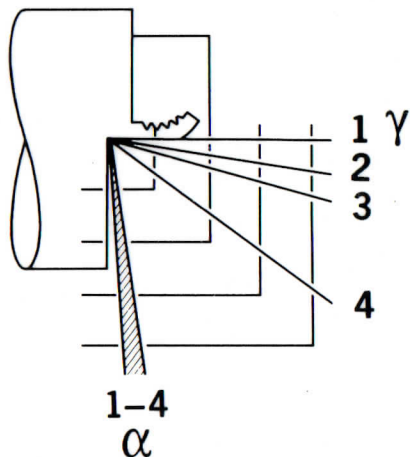
- Chipping
- Lower tool life
- Reduced hardness
- Don't burn your tool bits

ASSAB 17

Tool angles



$\gamma = 3$	Steel < 175 HB	15°
2	Steel 175—250 HB	10°
1	Steel > 250 HB	0°
3	Stainless	15°
2	Castiron — 250 HB	10°
1	Castiron > 250 HB	0°
2	Brass/Bronze	10°
4	Copper/Aluminium	35°
4	Wood	35°



The recommended angles are intended as a rough guide, and should be adapted to the lathe used, the metal being turned and other decisive factors. High rates of feed demand a strong cutting edge, so a smaller clearance angle α and cutting rake angle γ might be necessary.

Chipbreaker

When ASSAB 17 tool bits are used for turning long chipping materials, a chipbreaker should be ground to ensure a smooth chip flow. The best shape depends on the feed and the cutting speed. The depth (d) and the width (w) of the chipbreaker should be increased with increasing depth and / or feed. Tough metals can also require deeper chipbreaker, however excessive chipbreaker depths can cause jamming.

