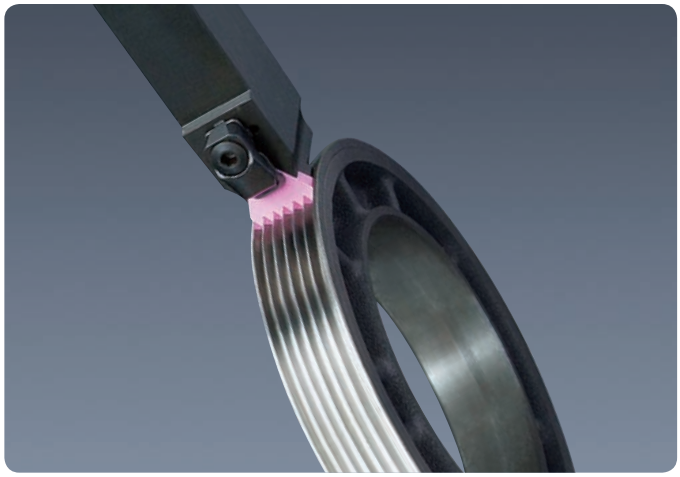
Machining Poly-V Pulley Profiles

Grooving With Ceramics

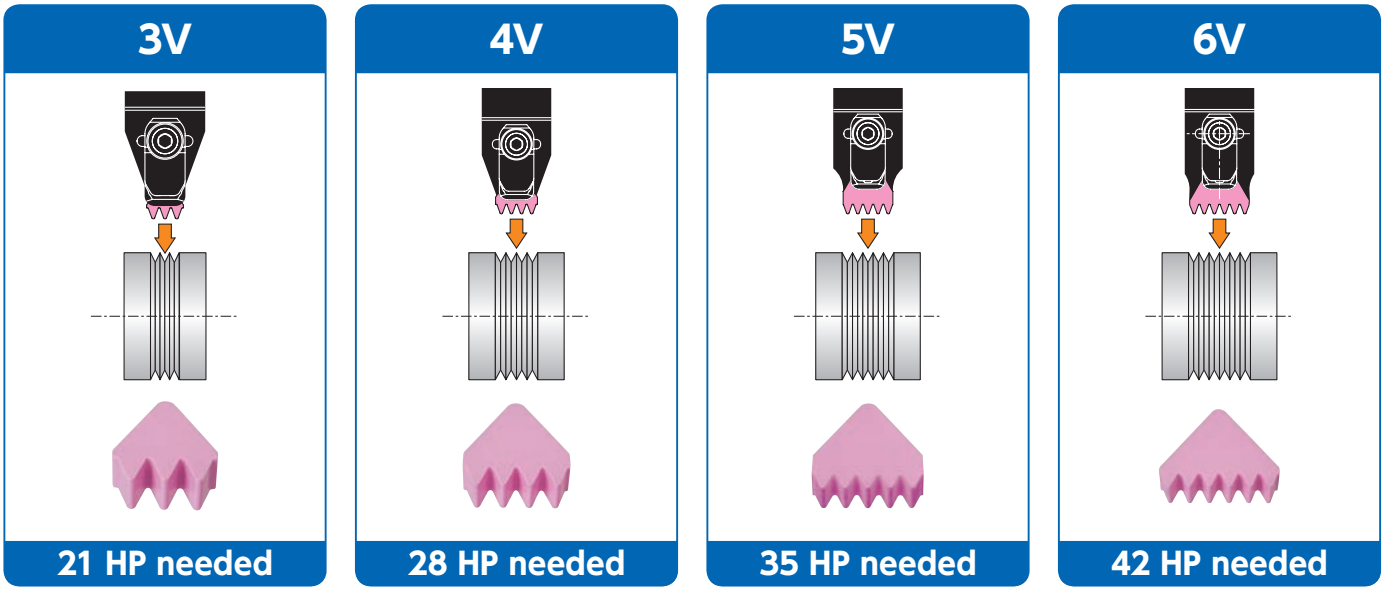


Features

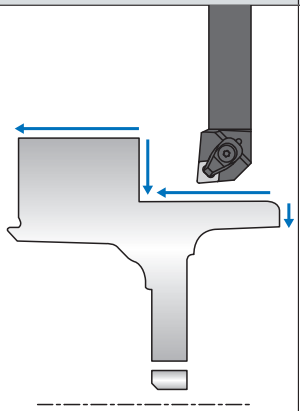
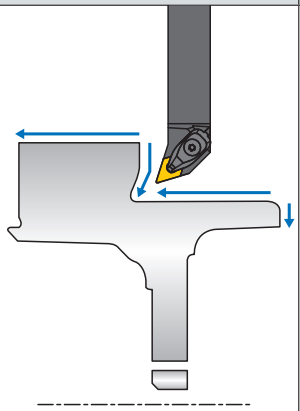
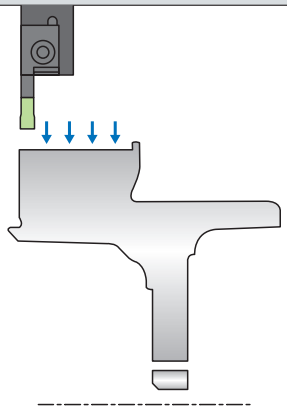
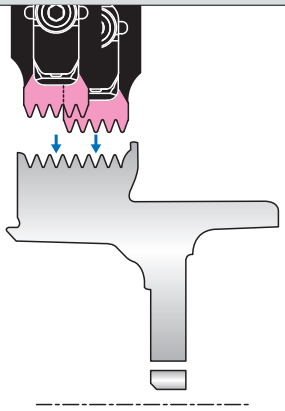
- *High speed machining for Poly-V pulleys*
- *Up to 6-V grooving with single pass*
- *Precision inserts for plunging profiles*

Recommended Cutting Conditions

Material	Grade	Cutting speed (SFM)	Feed (IPR)	DRY	WET
Gray cast iron	**HW2**	1000–2000	.002–.006	●	

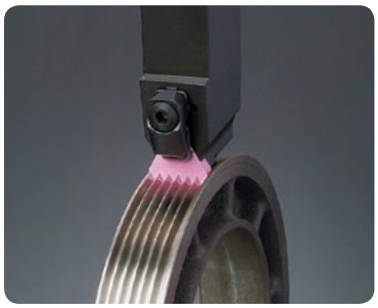


High-Speed Pulley Machining Example using NTK Ceramic Tools

	Process #1	Process #2	Process #3	Process #4
	OD and Profile Roughing	OD and Profile Finishing	Plunge Grooving	Poly-V Grooving
Tooling				
Insert	CNGX 453 T0820 SX6	DNGA 432 T0525 HC6 DNGA 432 T0420 SP9	VDB 250 B031 T0220 WAI	PTM 53 K50504 ENB HW2*
SFM	2000-2800	1500-2000 (HC6) 1800-2400 (SP9)	1000-1400	1200-1500 (1400 SFM recommended)
IPR	.018-.024	.012-.018 (HC6) .018-.024 (SP9)	.008-.010	.002-.006
DOC (inch)	.080-.120	Process dependent (.020)	—	—
Coolant	DRY・(WET)	DRY・(WET)	DRY・(WET)	DRY
Life ／ corner	- 300 pcs	- 300 pcs	- 300 pcs	- 300 pcs

＊Please check machine's HP when select insert.

	3V	4V	5V	6V
Required HP	21HP	28HP	35HP	42HP



- ***NTK's Ceramic Inserts ensure in higher productivity and stable tool life for Damper-Pulley machining.***