

Y-axis parting

Parting off takes a new direction

CoroCut® QD for Y-axis parting includes all great features of CoroCut QD, but with one important change: the insert pocket is rotated 90 degrees. We call it Y-axis parting and this completely new way of parting off gives a more beneficial direction of the cutting force resulting in much higher stability. It eliminates vibration and reduces noise levels to a minimum.

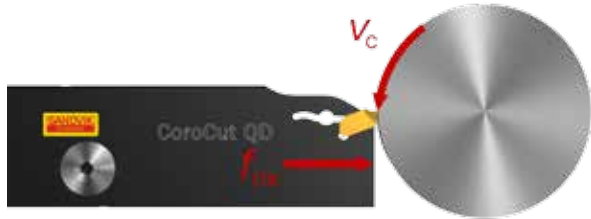
Benefits

- More than six times higher blade stiffness, which allows for significantly higher feed and longer overhang without losing stability
- Improved surface quality and straighter cuts
- Less vibration compared to conventional parting off means less noise
- Allows parting off of much larger diameters than what has earlier been possible

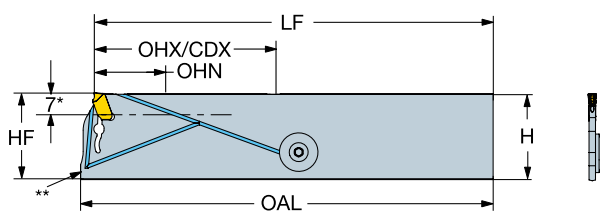
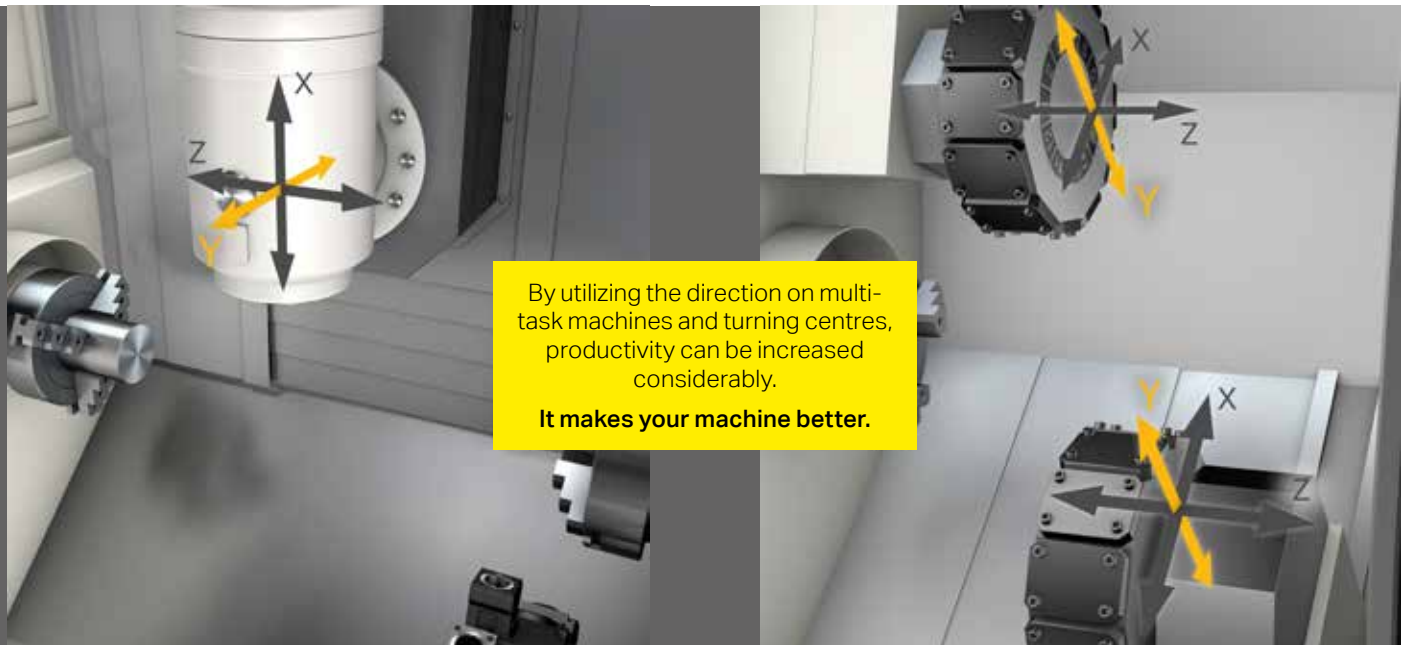
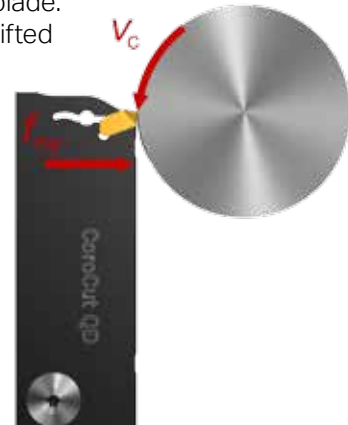


Turning re-invented

Conventional parting off only uses feed motion along the X-axis. The resultant vector of cutting forces is directed across the weakest section of the blade, resulting in high loads and exposure to deformation.



The new concept is designed with the top face of the insert perpendicular to the blade. This way the resultant load is shifted to the strongest section of the blade, which dramatically reduces deflection and noise.



The new blades for Y-axis machining use the same inserts and the same plug and play coolant adaptors as CoroCut QD.

* Cutting edge is 7 mm (0.276 inch) above Y=0 when placed in a standard blade adaptor. Make sure to offset in the CNC program.

** Alternative gauge plane to pre-set the tool length (OAL-LF).

SSC	CZC _{MS}	CDX	CUTDIA	Ordering code	Dimensions, mm, inch						MIID
					H	LF	OAL	HF	OHN	Bar/PSI	
G	25	60	120	QD-NN1G60C25AY	31.9	145	150	32	30	70	QD-NG-0300-0002-CM
		2.362	4.724		1.256	5.709	5.905	1.260	1.181	2.756	
H	25	60	120	QD-NN1H60C25AY	31.9	144	150	32	30	70	QD-NH-0400-0002-CM
		2.362	4.724		1.256	5.669	5.905	1.260	1.181	2.756	
H	25	90	180	QD-NN1H90C25AY	31.9	164	170	32	60	70	QD-NH-0400-0002-CM
		3.543	7.087		1.256	6.457	6.693	1.260	1.181	2.756	

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