

B681

Cylinder boring – roughing

B681 is designed and developed for roughing in cylinder boring operations.

The solution produces excellent roundness and cylindricity, allowing for a smooth semi-finishing operation due to the integrated Silent Tools™ damped adaptors.



Silent Tools™ damper

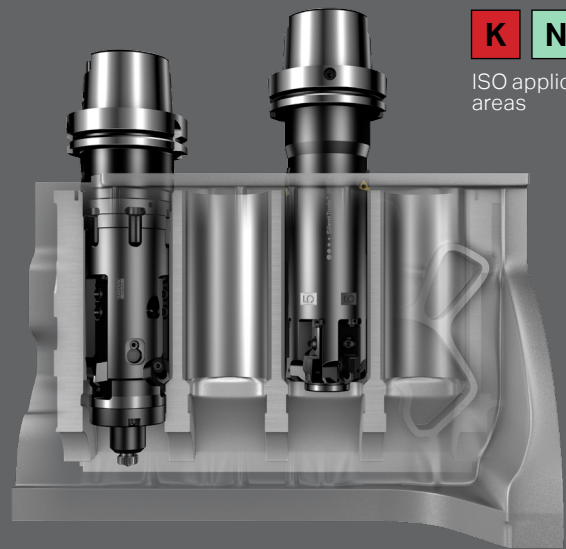
The damper inside the Silent Tools™ adaptor helps provide excellent hole geometry and outstanding surface quality.

Solution for roughing

- Roughing operations while retaining the required high level of quality in roundness and cylindricity
- Provides an excellent foundation for a successful semi-finishing operation
- Machine types: unit centres and transfer lines

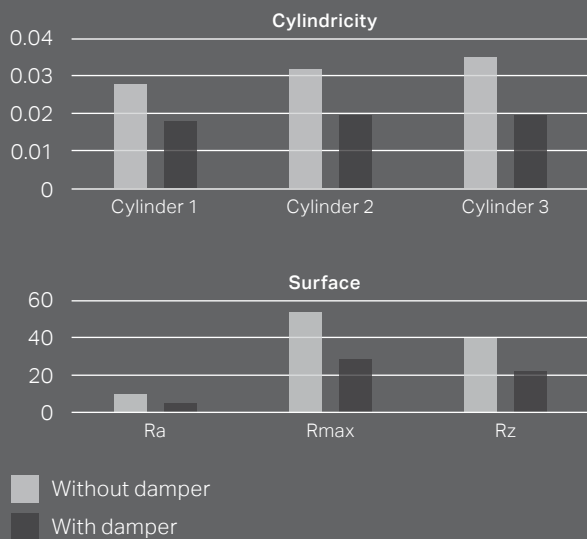
Application

- Cast iron cylinder blocks
- Cast iron cylinder liners and sleeves casted in aluminium blocks
- All cylinder liner operations



ISO application areas

Comparison between conventional tool and Silent Tools™ solution



- Tests have been performed with and without Silent Tools™
- Quality surface, cylindricity and roundness were significantly better with Silent Tools™

- v_c : 800 m/min (2,625 ft/min)
- f_z : 0.15 mm/z (0.0059 in/z)
- v_f : 2,557 mm/min (100.669 in/min)
- Insert: engineered CBN insert

For more information, contact your local Sandvik Coromant representative or visit www.sandvik.coromant.com

Head office:
 AB Sandvik Coromant
 SE-811 81 Sandviken, Sweden
 E-mail: info.coromant@sandvik.com
www.sandvik.coromant.com

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