



Technical data

Work piece	piston
Material	1.756 35SPb20+C
Tensile strength	-
Tool	PMC 16R-1.5D
Insert	PM 16RG 252004-M20 CTC1435
Competitor	2 tools

		CERATIZIT	Competitor
v_c	[m/min]	105	105
a_p	[mm]	0,03 - 5,0	0,3 - 5,0
$f_{turning}$	[mm]	0,15	0,1
$f_{grooving}$	[mm]	0,06	0,06

Criteria

- Increase in productivity
- Insufficient quality of groove surface

Result

- Machining time reduced by 50%
- Enhanced groove quality