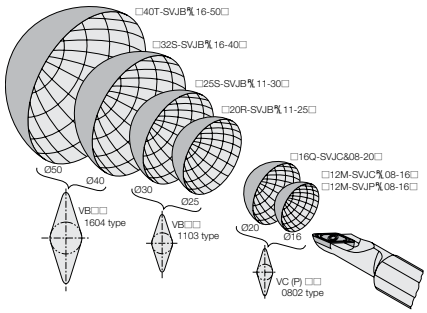
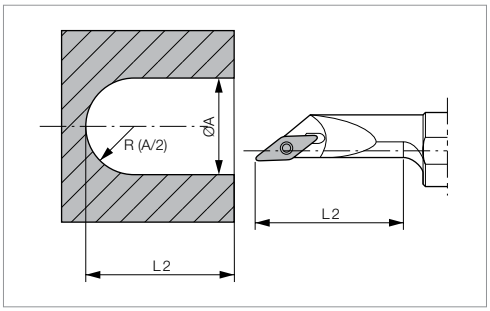
для заказа - kyocera@kyocera-tools.ru

A...SVJP(C)-○, S...SVJP(C)-○ Excellent Bar (Internal Spherical Machining / Internal Facing)

〔Refer to Page ➡ **F58** (Dynamic Bar)〕

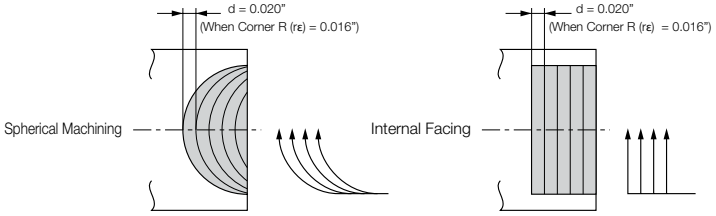
1. Application Range





2. Machining Method

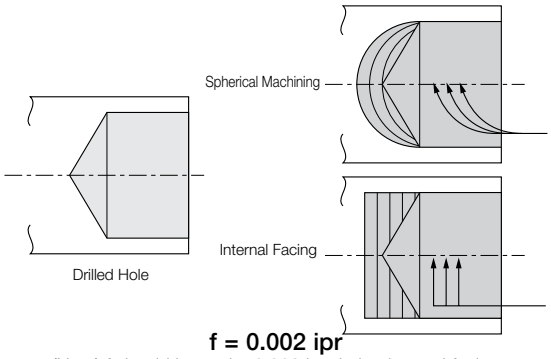
In Cases with No Existing Hole



f = 0.002 ipr

(Note) f should be under 0.002 ipr at internal facing

In Cases with Drilled Hole

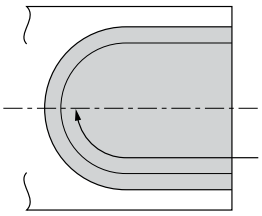


f = 0.002 ipr

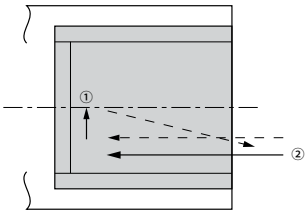
(Note) f should be under 0.002 ipr during internal facing

Finishing

Spherical Machining

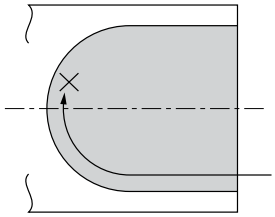


Internal Facing

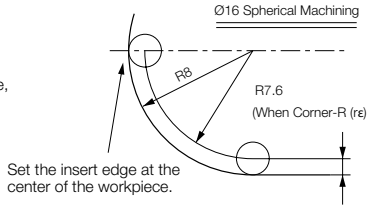


Machining Process
1. Finish the internal face firstly.
2. Next, finish the internal diameter.

3. Caution

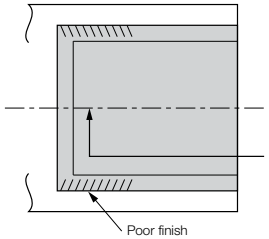


When machining past the center of the workpiece, insert breakage may occur.



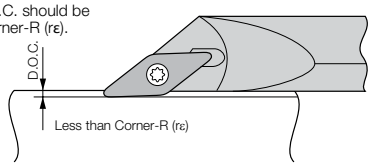
Set the insert edge at the center of the workpiece.

Adjust the machining program of radius smaller by Corner-R (rε) value.



Machining of this kind is available, but the oblique part may be scratched by chips.

For internal profiling, D.O.C. should be less than the value of Corner-R (rε).



[Burrs may occur, if D.O.C. is bigger than Corner-R (rε)]