

Hole Finishing Application Example

Heat Exchanger • Tube Sheets

TRM – TOP REAM MODULAR

- Tube holes $\varnothing$ 25,25mm (.994").
- Tolerance range 100 μ m.
- Alloy steel, long-chipping.
- Machining center with internal coolant.

- Six cutting edges.
- Coated cermet.
- Standard 5 x D body clamped into hydraulic chuck.

- $v_c = 90$ m/min (295 SFM).
- $f = 0,48$ mm/rev (.019 IPR).

- After more than 30 minutes only minor wear visible.

- Reduction of machining time in total to less than 60 minutes per plate with 180 holes.
- Predictable tool life as only 2 μ m diameter deviation after 30 minutes tool life.

CHALLENGE**SOLUTION****CUTTING DATA****RESULT****BENEFIT**