

Helping World Manufacturing Reduce Costs Since 1963

High Performance End Mills **322 and VHEM for** Difficult to Machine Materials

www.rigpl.com



322 and 325 Series: Chatter Free, High Performance Milling

ADVANTAGE

- Variable Index End Mills
- Comes with Special NOVA Coating
- Both 4-flute (322 Series) and 5-flute (325 Series) Variants are available
- Excellent for Plunging, Slotting and Keyway Milling Operations
- Best suited to Run at Higher RPM and Higher FEED rates with Smaller Depth of Cuts
- Capable for machining Wide Range of Materials like Carbon Steels, Alloy Steel, Stainless Steels, Titanium etc.



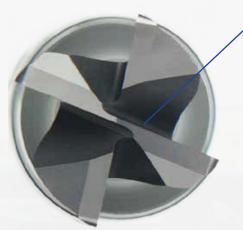
EXCEPTIONAL MILLING PERFORMANCE IN STAINLESS STEELS



APPLICATION SUCCESS DATA

	Description		322 Series						a ma againi		6
	Indu	stry	Aerospace								-
	Com	ponent	IWS P	lates			-	VI.			
CUTTING CONDITIONS	Tool Diameter		20mm								
	Cutting Speed		60m/min								
	RPM		950								
	Feed (mm/ tooth)		0.12								
	Table Feed (mm/min)		456								
	DOC		50mm								
	Radial Cut		2mm								
	Milling Type		Side Milling								
	Coola	ant	6% Mix Water Soluble								
	Material		SS304B4								
	Hard	ness	300-360BHN								
	Mach	nine	Vertic	Vertical Machining Centre							
PERFORMANCE GRAPH											
	LIFE (Metres)	Comp	17.36	17.36							
		Competitor 1 18.67									
		ROHIT - 322 Series							39.06	_	
	(0 5	10	15	20	25	30	35	40		
RESULT	~100% increase in tool life & ~60% reduction in CPC										

VHEM Series : Chatter Free Machining of Difficult to Machine Materials



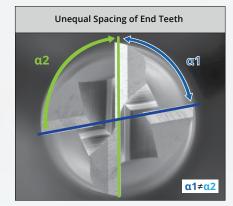
Unequal Spacing of End Teeth

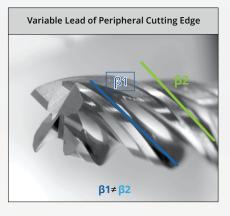
for stable, vibration-free milling

Vibration Suppression

Stable, High Efficiency Milling

Unequal spacing of teeth and variable-lead geometry enables stable and high efficiency milling.





AL-Pro Coating for superior resistance to

thermal cracking

Variable Lead for efficient milling and suppressed vibration

Ideal Flute Shape for smooth chip evacuation



extended tool life

FLEXFUE

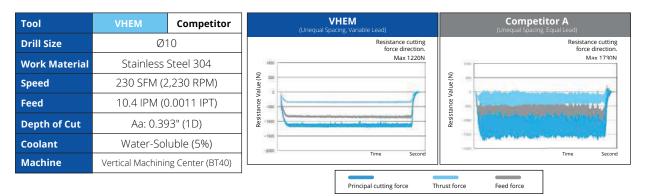


ADVANTAGE

- Variable Helix End Mills gives new dimension to Machining
- Comes with our AL-Pro Coating
- Chatter Free Machining helps in Noiseless Machining and improved productivity
- Capable for machining Wide Range of Materials like Carbon Steel, Alloy Steel, Stainless Steel, Titanium Alloys, Nickel Alloys etc.

CHATTER SUPPRESSION

The VHEM Experiences Less Chatter Versus the Competition





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/ Safe use of cutting tools

- Use safety cover, safety glasses and safety shoes during operation.
 Do not touch cutting edges with bare hands.
 Do not touch cutting chips with bare hands. Chips will be hot after cutting.
 Stop cutting when the tool becomes dull.
 Stop cutting operation immediately if you hear any abnormal cutting sounds.
 Do not modify tools.
- Please use appropriate tools for the operation. Check dimensions to ensure proper selection.

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