

THREADMILL TOOL LIFE & CYCLE TIME TEST:



TOOL DATA:

STEINER:

Manufacturer:	JBO
Tool Type: (GF/GFM/GFT)	GF
Tool Part #:	JB0313425
Tool Cost:	399.21

PART DATA:

Part Name:	Test Piece
Part No.:	N/A
Thread Size	9/16-18
Thread Depth (in):	.709"
Material & Hardness:	4140 Steel
Quantity Holes Per Year:	N/A

MACHINE DATA:

Make & Model:	HAAS Vf4
Spindle Taper:	HSK63 in Hydraulic Holder
Overhead Rate (\$/hr):	N/A

MACHINING PARAMETERS:

STEINER

Spindle Speed (RPM):	3996
Feed Rate (IPM):	23.9
Number of Radial Passes:	2 (2/3 radial depth rough, 1/3 radial depth final)
Cut Time (Seconds):	2.94
Tool Life (# of Holes)	3750

JBO conducted an in-house tool life and cycle time test for one of their new Shark thread mills. Running at aggressive feeds and speeds, we were able to achieve a cycle time of less than 3 seconds per hole using 2 passes in a standard 4140 steel test piece.

The tool generated a total of 3750 holes before it was determined that the thread mill had reached the end of its operational life.

We feel that this test was a huge success given the incredible cycle time achieved as well as maintaining a high tool life.

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**REQUEST
A QUOTE**



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