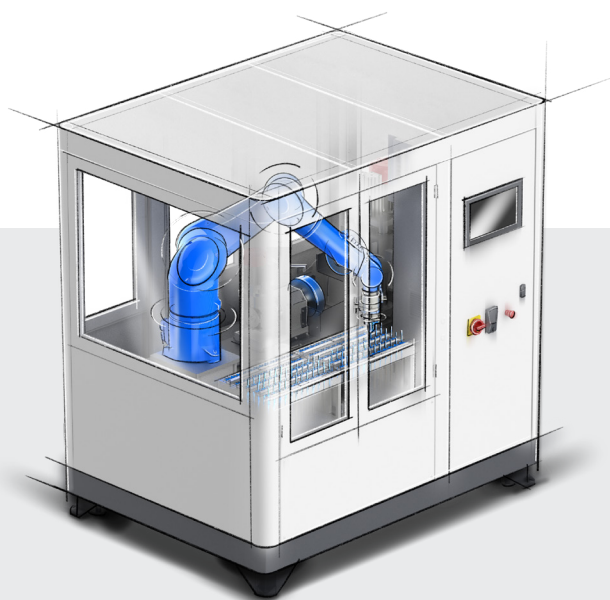
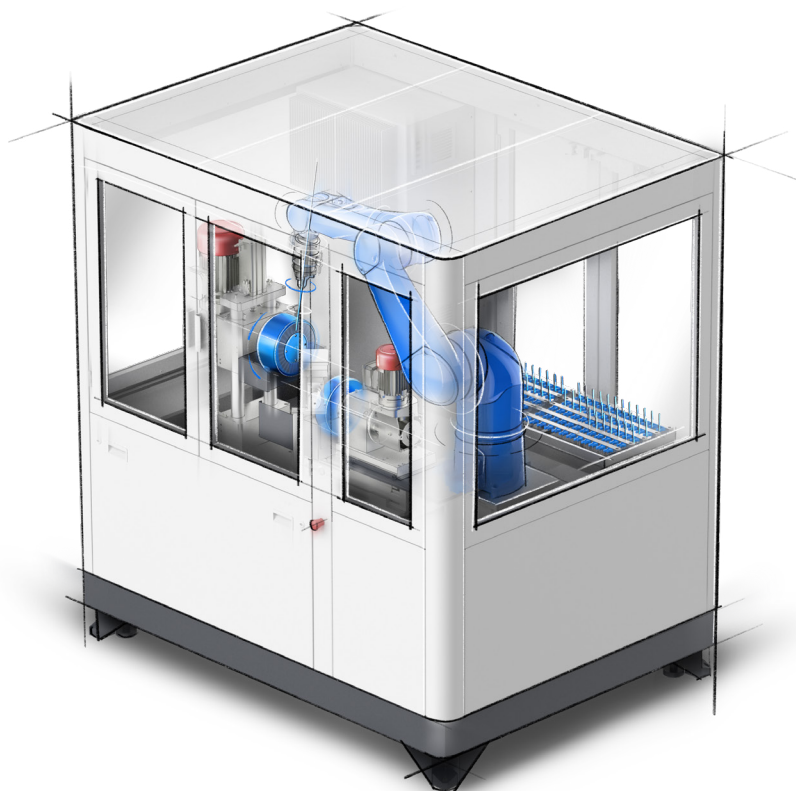


MF66

For all surface treatments on cutting tools.

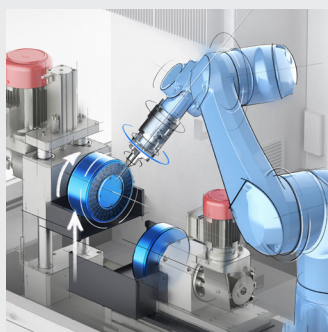
MF66 machine utilizes Magnetfinish® technology for fine deburring, precise rounding of cutting edges, and surface



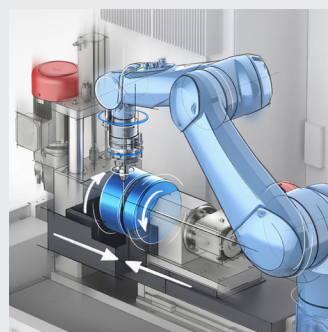
Singular Properties

- » All movements are executed by a wear-free robot.
- » Automated pick & place for 120 tools.
- » Controlling of the K-factor for both, the tool tip and the cylinder part.
- » Stored recipes for all kinds of cutting tools (drills, endmills, ballnose, reamers, steptools, etc.)
- » Different processes in one run e.g. cylinder honing and flute polishing with separated process parameters.
- » All operations are managed via an onboard 17" touchscreen, with no robot know-how required.

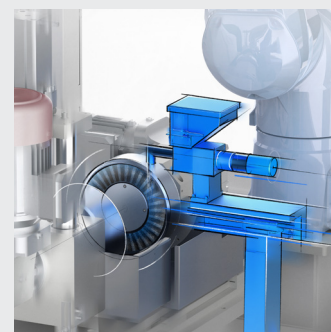
- » Parts are manually placed on the pallets by the operator.
- » Wide range of workpieces diameter from 0.05mm to 25mm.
- » Up to 10 different tool types in magazine.



Single Head process
Treatment on tool tip



Double Head process
Treatment on cylinder part



Automatic powder feeding
Abrasive powder dispensing

Technology

Whenever defined honing, polishing, or deburring is required, MF provides the best reproducible results in the shortest time.

Characterization

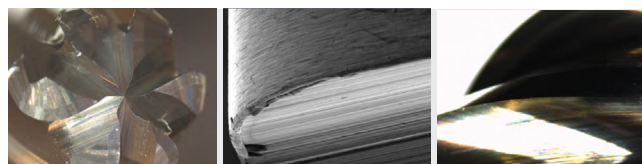
- » Magnetfinish® utilizes special diamond abrasives, achieving the shortest process times for both honing and polishing.
- » Suitable for a wide range of tasks (honing of carbide, polishing of carbide, polishing of coatings, deburring of steel), all selected by stored programs
- » Reproducible results due to continuously refreshing of abrasive material
- » No limit for maximum honing radius
- » Separation of processing cylinder and tip of tool with independent parameters
- » Automatic run with mixed tool types and adopted parameter for every type.
- » Controllable process intensity allows processing of smallest tools ($D=0.05\text{ mm}$)
- » Controlling k-factor for tooltip and cylinder part

Applications

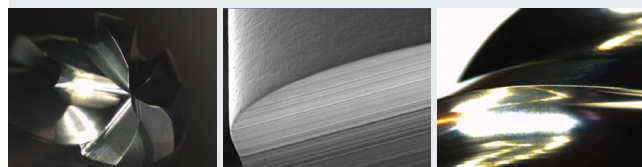
- » Honing of cutting edges on steel, carbide, CBN, PCD, etc.
- » Polishing the flute of cutting tools (drills, deephole drills, endmills, thread tools, etc.)
- » Polishing after coating, removing droplets
- » Fine deburring on components
- » Combined applications for tools and components, e.g. honing of cutting edges and polishing of flutes

Benefits

- » Extended lifetime, improved adhesion for all coatings by honing cutting edges
- » Improved chipflow, increased productivity of tools, decreasing of roughness till $Ra\ 0.02\text{ micron}$
- » Friction reduction
- » Avoiding of the running-in phase, extending lifetime, better work results
- » Executed in only one run.
That guarantees highest productivity

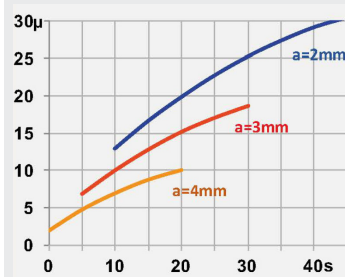


Before MF



After MF

Honing with different working distances



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