

TIP TALK

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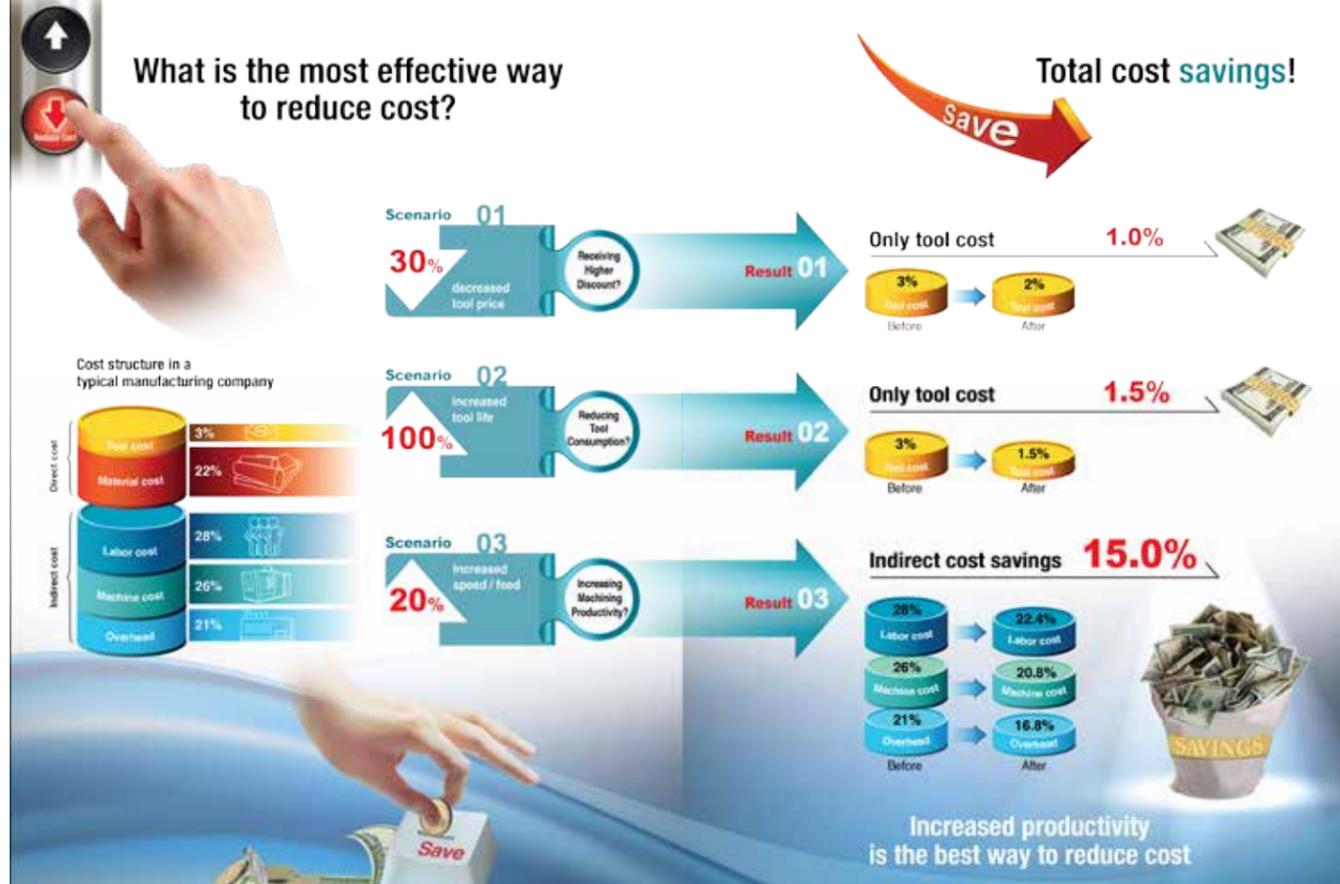
MACHINING STRATEGIES

For the last two newsletters we have introduced the concept of machining strategies to lower the cost of production.

So where are the big savings in your machine shop going to come from? From buying cheaper tooling? Or getting your tools to last longer? The biggest saving will come

from reducing the time from start to finish of any job simply because labour charges are 10 times more than any tooling cost.

The opportunities in this area are huge, talk to us about our systems to kill production costs.



The opportunities in this area are huge, talk to your Iscar Pacific sales rep about our systems to kill your production costs.



PINZBOHR modular system.

BORING STUFF

There is nothing worse than boring systems that are tricky to set. Let's face it, when you finish boring something it's usually the last operation of the whole job and if you get the size wrong, it's scrapped.

That's why 20 years ago we added the PINZBOHR boring systems to our tooling line up, because of its attention to quality and reliability at sensible prices. The most important test of any system is when the set size does not change after you adjust the size and then lock the head. Can you do this reliably with your boring system?

As a modular system, PINZBOHR features adaptors to match PINZBOHR couplings with standard Face Milling cutter holders, Weldon, Morse and adaptors for Drill Chucks (DIN 238). Chamfering heads with 45° angle approach can be fitted on the PINZBOHR couplings axially positioned where you need it.

Indexable cartridges are mounted on Finish and Rough boring heads from 68mm-500mm, and feature different insert geometries and different angle approach (75° or 90°). Cartridges also have an additional radial adjustment on the slide body.

- 12 different boring head sizes cover a diameter range from 24mm to 500mm, both in double cutting and single cutting heads
- Integral insert pocket design for boring heads sizes 22, 27, 32, 42 and 54.
- Insert cartridge design for boring heads sizes 68, 85, 100, 200, 300, 400 and 500.
- Boring heads and cartridges available for different standard ISO insert styles.
- Pre-load device between body and slide block to prevent movement when tightening lock screw for working.
- Micrometer adjustment with 0.002mm increments on diameter.
- Boring head's cartridges have their radial adjusting screw for individual setting of cartridges.
- Change to different lead angle or insert style by simply exchanging cartridges

MACHINING INTELLIGENTLY

ISCAR continues to expand its existing array of products which established many benchmarks in the global metal working industry. The new ISCAR IQ campaign introduces several new innovative tool families.

The tool families under the new HIGHQLINE campaign assist the user to increase profitability by employing leading edge engineering solutions. These new tools will enable manufacturers to continue to improve their efficiency by using modern machining strategies under ISCAR's new campaign motto "Machining Intelligently".

The new tools focus on increased productivity with smart insert locking mechanisms, creating a more stable machining process. ISCAR has responded to the new market demands resulting from the trend toward high speed machining and mill-turn CNC, with upgrades in both tool and insert geometries, leading to less machine downtime and less labour.

"increased productivity with smart insert locking mechanisms, creating a more stable machining process"

ISCAR's new HIGHQLINE tools are well-suited for the new generation of machining centers, enabling high feeds and speeds for highly productive machining operations.

ISCAR's new HIGHQLINE is their answer to global market requests. ISCAR has always been at the heart of manufacturing and shall continue to be for many years to come. The new tools are a part of ISCAR's commitment to the ongoing success of its customers.

Some of ISCAR's best ideas have resulted from its R&D engineers working with their field engineers, who are out in the real world and listening to the needs their customers.

We will be introducing these new ideas and products over the next six months in this newsletter. Featured this month are the new round milling insert cutter H606 and chatter free inserts Heli2000 CF.



The Heli2000 CF, in stock now.

CELEBRATING 30 YEARS OF NZ TOOLING

30 years ago a young and innocent Nathan Stronge was offered the opportunity to take over the NZ agency for an Israeli carbide tooling company, ISCAR. He thought it looked like a good opportunity to take a crack at starting his own business and so Iscar Pacific was created.

He had no business plan, computer, mobile phone or even fax and a single employee. 30 years later the company is still going strong(e), employing 20+ staff, taken on three more brands and have become the biggest carbide tooling supplier in the country.

Thank you to all the loyal customers, new and old for helping us reach this milestone.



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CUT THE CHATTER

The concept of chatter free cutters has been around for some time in Solid Carbide cutters. How it works is each flute is differentially pitched as well as different axial angles so the harmonics of the machining process are interrupted making for a "chatter free" process.

Cunningly, ISCAR engineers have worked out how to do this with Carbide inserts and we introduce a unique geometry on the workhorse HELI2000 ADKT insert line that turns a standard HM90 end mill or face mill into a high performance chatter free cutter.

"turns a standard HM90 end mill or face mill into a high performance chatter free cutter."



In stock now HM90 ADCT 1505PDR-CF

ISCAR have created an asymmetrical insert with two different cutting edges with different axial angles the same as a solid carbide cutter. This reduces machine induced harmonics and increases tool life.

These new inserts reduce power consumption by 10% and clear the chip faster using the axis variable cutting edge.

Each insert is mounted in the HM90 cutter with alternate edges around the cutter. You can easily identify the edges as they are different colours - black and yellow.

The best results come from where you need to use long overhangs and extra reach is required.



POWER TOOL RACING RETURNS

In an empty warehouse one Saturday morning, Auckland's best engineers gathered to pit creation versus creation, company versus company to find this year's Power Tool Racing champion.

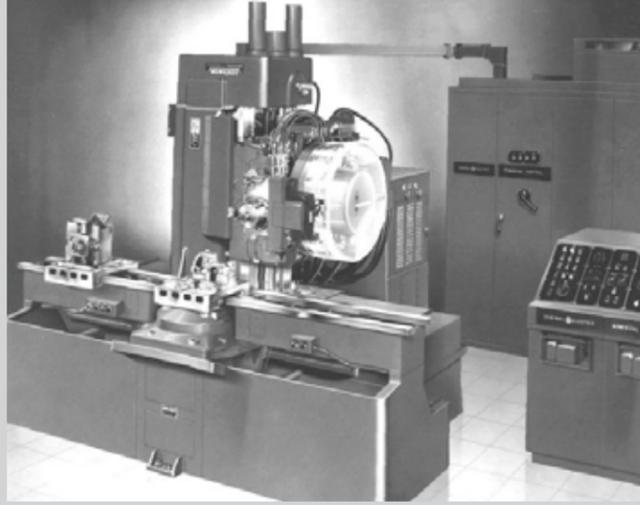
Last year's favourites returned; Jamie from RPM to defend his title of Grand Champion, Paul & Neil from Buckley Systems Limited and Russell from Xact. Jamie smashed his old record of 2.208 with a new record of 1.821 seconds.

We had a few casualties through-out the day with Team Opti-Flow from F&P Healthcare literally losing a head and Neil from BSL coming off the tracks.

Results:

- Superstock Fastest in Class: Paul, BSL
- Pro-Superstock Fastest in Class: Nathan, Iscar
- Funny Cars Fastest in Class: Jamie, RPM
- Challenged: Michael Ronayne, F&P Healthcare
- Most Likely to Impress the Girls: Brendan, BSL
- Best Engineered: Ross, BSL
- Fastest run of the day: Jamie, RPM
- Grand Champion: Jamie, RPM

For more photos and videos from the day jump on to our Facebook: www.facebook.com/iscar.pacific.nz



Milwaukee-Matic-II, 1959. Source: CNC Cookbook

DO YOU HAVE THE OLDEST CNC MACHINE IN THE

We're running a competition to find the oldest CNC machine still in operation in New Zealand.

Simply upload a photo of your machine with a description to our Facebook page, www.facebook.com/iscar.pacific.nz, and you could be in to win a double pass to Gold Class.



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