

# TIP TALK

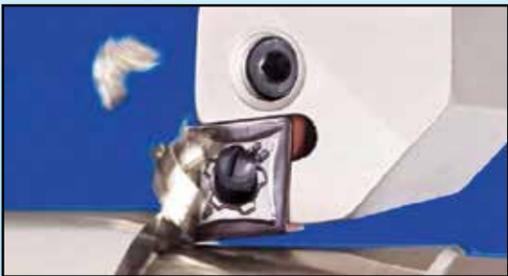
JUNE 2015

www.iscar.co.nz

0800 808 477

## COOL STUFF COMING

### COMBI D-LOCK TOP LEVER



Iscar is introducing an upgraded lever lock to improve the clamping rigidity of the popular and user-friendly insert clamping system.

The new design pulls the insert back into the pocket and clamps the top at the same time.

Currently the lever only pushes the insert against the pocket. This method sometimes fails during interrupted cut or heavy load applications, which causes the rear side of the insert to rise.

The top clamp mechanism does provide high clamping security, but obstructs the chip flow - especially during internal turning applications.

**Iscar's new LR 4TL Top Lever combines the advantages of both systems. The new LR 4TL Top Lever can replace the standard LR 4 levers in any tool.**

## SPINDLE SPEED UP TO 30,000 RPM!

### Use it in your Tool Changer!

SpinJet is a Spindle speed-up device that can reach 30,000 RPM, and soon to be 40,000 RPM!

- Driven by your machine's coolant flow.
- Can fit into your tool changer like any other tool.
- Doesn't require any special adaption to the spindle.
- Doesn't have any electric motors or cables.
- Fits in the palm of your hand.

When compared to normal machining, the use of SpinJet delivers impressive machining time reductions of **over 400%**.

In addition to the CNC machine tool's coolant driving SpinJet, it also maintains a cool cutting tool and improves the chip evacuation.

### Simplicity

SpinJet's design and compact size allows it to be conveniently stored in the machine magazine for regular ATC from where it can be called by the NC programme (as if it were another tool holder), and attached to the machine's spindle with its tool holder.

### It's truly plug and play...even a Swede could use it!



The chosen cutting tool is simply clamped into the SpinJet by using an ER11 collet chuck of the relevant ER11 SPR... collet diameter.

To help users track spindle speed, the SpinJet uses a wireless RPM monitor that clearly displays all required real-time information, allowing instant machining parameters to be made. Thanks to the advanced RPM monitoring system, optimal feed rates can be determined to provide maximum yield.

### Flexibility

Using the SpinJet guarantees high flexibility, enabling quick switching between jobs with their ATC, and most importantly, gives users the ability to perform all operations and HSM on a single CNC machine, small or big.

## A Ribbeting Joke



An engineer crosses a road when a frog calls out to him, "If you kiss me, I'll turn into a beautiful princess."

He bends over, picks up the frog and puts it in his pocket. The frog speaks up again and says, "If you kiss me and turn me back into a beautiful princess, I will stay with you." The engineer takes the frog out of his pocket, smiles at it and returns it to the pocket. The frog then cries out, "If you kiss me and turn me back, I'll do whatever you say!"

Again the engineer takes the frog out, smiles at it and puts it back into his pocket. Finally, the frog asks, "What is the matter? I've told you I'm a beautiful princess, I'll stay with you and do whatever you say. What more do you want?" The engineer says, "Look, I'm an engineer. I don't have time for a girlfriend, but a talking frog, now that's cool!"

## ISOTURN your machining around!



Iscar has added a clever new geometry to its line of small economical inserts. The new insert features a 25° corner angle, making it very cool for machining very narrow V-shaped grooves which cannot be machined by the standard insert.

### You don't even need a new tool holder for it!

The new YNMG 1604 fits into the standard pocket of a VNMG 1604 35 degree insert, in your existing holders.

Call us today to find out how ISOTURN's small size inserts can enhance your machining!

## LOCK 'n' LOAD

### ISCAR has Gun-Drilling in its sights

#### Gun Drills with replaceable inserts!

No more regrinding...  
No more taking the drill out and sending away for refurbishment...  
No more downtime...

#### Just change the insert on the machine and hit cycle start!

- Each insert has 3 chip splitting cutting edges, a positive rake chip breaker, and a wiper for high hole surface quality.
- Each insert has three cutting edges.
- Highly accurate peripherally-ground guide pad insert, provides high hole diameter accuracy of IT10.
- The chip splitter produces narrow chips for efficient chip evacuation, enabling higher feed rates compared to other drills available on the market.
- A wiper on the insert provides extra fine surface finish.
- Direct insert mount - no adjustment needed for accurate hole diameter.



All your tooling needs at  
**grabatool.co.nz**

**ISCAR PLUS**

LIKE us on Facebook!  
Facebook.com/ISCAR.PACIFIC.NZ



# STAND ON THE SHOULDERS OF GIANTS

**Robert Page Engineering Ltd** in Tauranga recently established a preferred supplier agreement with Iscar Plus, which will also include a Matrix dispensing machine to go with their ToolPort insert dispenser.

When you have installed one of the biggest horizontal borers in the country, like **Robert Page Engineering** did, you need to make sure the machine is generating maximum turnover possible. Weighing in at 48,000KG the borer has table travels of 4000 in X, 2500 in Y, 2000 in Z, and a table loading of 15,000KGs. This makes this machine the largest CNC borer of its type in New Zealand. All axes, including table rotation, can be used simultaneously for 4-axis machining.

**This is a serious machine that needs to produce parts efficiently, and that's where the tooling comes in.**

Statistics show that while tooling is only 3% of the total cost of running a workshop, it is vital to the output of any company.

come through the door expecting to sell tools unless it's accompanied with a partnership to work with them to reduce real costs. This eliminates buying on price from opportunist suppliers as well as the time taken up by salesmen's visits.

So **Robert Page Engineering** turned to the one company that met all the criteria to form a partnership to improve efficiency, to make sure the right tooling is available, and the best machining and programming processes were being used.



Gavin Parnwell, Robert Page Engineering Ltd, & the largest Horizontal Borer of its type in NZ.

**“Only vending systems like the ToolPort and Matrix will reduce wastage and missing tooling by 20%...”**



**Robert Page Engineering** (while they have skilled programmers and setters) decided that sorting out tooling and its related issues were best left to the specialists, leaving them to concentrate on what they do best, that is, producing high-quality large machine parts, on time and on cost.

To do this they decided that any cutting tool supplier cannot just

The agreement will find an **Iscar Plus** application engineer spending an agreed number of hours in the shop each week, working with company programmers and setters on bottle-necks, helping with new jobs, checking that the best tools and practices are being used, and training.

John Dower from **Iscar Plus** said, *“The agreement means the Iscar engineer will make sure that the right tools and the right processes are being used. Where the best tool is not from the Iscar Plus range, advice will be given where to source the tool so other suppliers are not eliminated. Because efficiency is key, we want our customers to be able to compete globally for work, and their competitiveness is good for both partners long-term even if it means not using one of our tools.”*

To manage tooling, **Robert Page Engineering** had previously installed a ToolPort insert dispenser, and now they have invested in a MATRIX dispenser that will be interfaced with the ToolPort. The MATRIX will deal with end mills, taps, drills, and larger tools.

The MATRIX can also manage gauging by tracking serial numbers and certification dates, who last used the machine, if the gauge is out in the shop, who issued it...etc.

Vending systems like these will reduce wastage and missing tooling by 20%, and Robert Page's staff will no longer have to spend time managing the tooling.

**Kevin O'Dea, Robert Page Engineering Ltd Managing Director** concluded with: *“For us, it's all about getting smarter in what we do every day.”*



## PUT YOUR WORKSHOP ON A DIET



Iscar is releasing a new range of chip breakers to help rationalise choices.

**Each of the chip breakers can replace 2 - 3 inserts that you probably have already in your shop.** These new inserts are specially designed to work efficiently over a range of depths of cut and feed rates.



**For Steel:** Iscar Plus can offer you F3P, M3P, and R3P (F for finishing, M for medium, and R for roughing).

**For Stainless Steel:** Iscar Plus can offer you F3M, M3M, and R3M.

They are available in most ISO shaped inserts.

Iscar's all-in-one chip breakers mean you can perform multiple jobs with one insert.

Cut your inventory, increase production, and save yourself time and money with Iscar's ONESOLUTION chip breaker range!

**You'll save so much money you won't know what to do with it all.**



Grabatool.co.nz is Iscar Plus' online tooling discount store. Buy inserts, drills, taps, and more at **up to 70% off RRP!**



## Jokes of the Month

A blonde, a brunette and a redhead are stuck on an island.

One day, the three of them are walking along the beach and discover a magic lamp. They rub and rub, and sure enough, out pops a genie. The genie says, "Since I can only grant three wishes, you may each have one."

The brunette says, "I've been stuck here for years. I miss my family, my husband, and my life. I just want to go home."

POOF! The brunette gets her wish and she is returned to her family.

Then, the redhead says, "I've been stuck here for years as well. I miss my family, my husband, and my life. I wish I could go home too."

POOF! The redhead gets her wish and she is returned to her family.

The blonde starts crying uncontrollably. The genie asks, "My dear, what's the matter?"

The blonde sniffs, "I wish my friends were still here."

A wife was making a breakfast of fried eggs for her husband. Suddenly, her husband burst into the kitchen.

"Careful," he said, "CAREFUL! Put in some more butter! Oh my gosh! You're cooking too many at once. TOO MANY! Turn them! TURN THEM NOW! We need more butter. Oh my gosh! WHERE are we going to get MORE BUTTER? They're going to STICK! Careful. CAREFUL! I said be CAREFUL! You NEVER listen to me when you're cooking! Never!"

The wife stared at him. "What in the world is wrong with you? You think I don't know how to fry a couple of eggs?"

The husband calmly replied, "I just wanted to show you what it feels like when I'm driving."



## Charities we proudly support in 2015

