



COGSDILL TOOL

products, inc.

APPLICATION *news*

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ZX Boring and Contouring Heads

Dramatic Improvements in Quality and Productivity

A subcontract machine shop had to obtain high quality threads in a very deep bore, with a smooth transition to a 30° angle. The large part, made of stainless steel and Inconel, was about four and a half feet in length and could not be rotated.

The part was machined on a horizontal boring mill. The bore in the end of the part closest to the 1-1/2 inch internal threaded diameter was only 1 inch in diameter. Consequently, they had to “peck” the threads from the opposite end of the part (a distance of over 50 inches) with a series of three taps mounted on long extensions. Then they put in the 30° angle with a form tap. Cycle time was 22 hours. The thread quality was acceptable, but they had great difficulty making a smooth blend to the angle.

Cogsdill recommended a ZX200 Boring and Contouring Head. The head is –actuated by the programmable inner quill on the horizontal boring mill and fitted with an industry-standard boring bar with a mini V-lock insert. The customer now back-bores the threads from the opposite end of the part (only 2-1/2 inches away from the threaded diameter). Thread quality was dramatically improved, the transition to the angle on the threads was consistently smooth, and ***cycle time was reduced from 22 to 1-1/2 hours.*** This very satisfied customer is now applying the ZX head to other machining operations and enjoying substantial time and cost savings.

*Machine a variety of contoured surfaces on horizontal boring machines with a programmable inner quill – in **one tooling set-up.** A wide variety of operations can be performed: boring... facing... taper boring... contour boring... deep-cavity boring... grooving... back spotfacing... chamfering. Refer to our ZX brochure and catalog for more information on Cogsdill's **ZX Boring, Facing, and Contouring Systems.***

— See reverse side for tool and part drawing —

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