



THE MACHINE:

HARDINGE SUPER-PRECISION® T-51 TURN GRIND

MACHINE SPECIFICATION

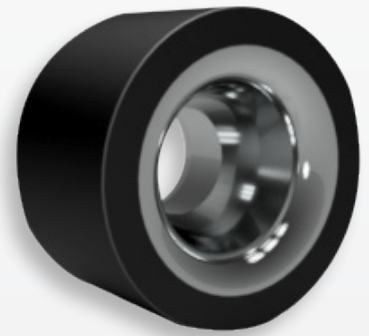
- A2-6/20C Collet Ready Made in the USA Spindle
- 5,000 RPM Main & Sub Spindle
- Live Tooling, Y-Axis, Sub Spindle
- 12 Station BMT 55 Turret with 1/2 Station Index
- Part and Tool Probe
- 30,000 RPM Grinding Spindle

THE INDUSTRY:

CARBIDE DIES & TOOLING

Carbide is used heavily in the canning, bullet, punch, and other precision machining applications across the globe. Traditionally intricate profile and radius requirements were reserved for more costly and complicated manufacturing techniques. With the demand for Carbide dies spiking globally manufacturers are looking for more efficient and cost-effective solutions to install.

Contact us for more information:
HARDINGE.COM | 800-843-8801



THE APPLICATION: CARBIDE DRAW DIE

FEATURES BEING MACHINED

- Main spindle – Grind bore and back chamfer
- Sub spindle- Hard Turn entering radius and taper
 - Polish ID

PART TOLERANCES

- Roundness - .00003"
- Size - +/- .00015"
- Profile - +/- .0002"

TOOL LIFE

- 100 parts per turning tool

CYCLE TIME

- Complete part done in 20 min

This solution is superior because it combines the efficiency of grinding straight diameters and following it up with the ease and control of single point turning pertaining to tight profile tolerances. When you add in our on-board polishing feature this turn/grind/polish solution is the most efficient way to manufacture Draw Dies in a single setup.

