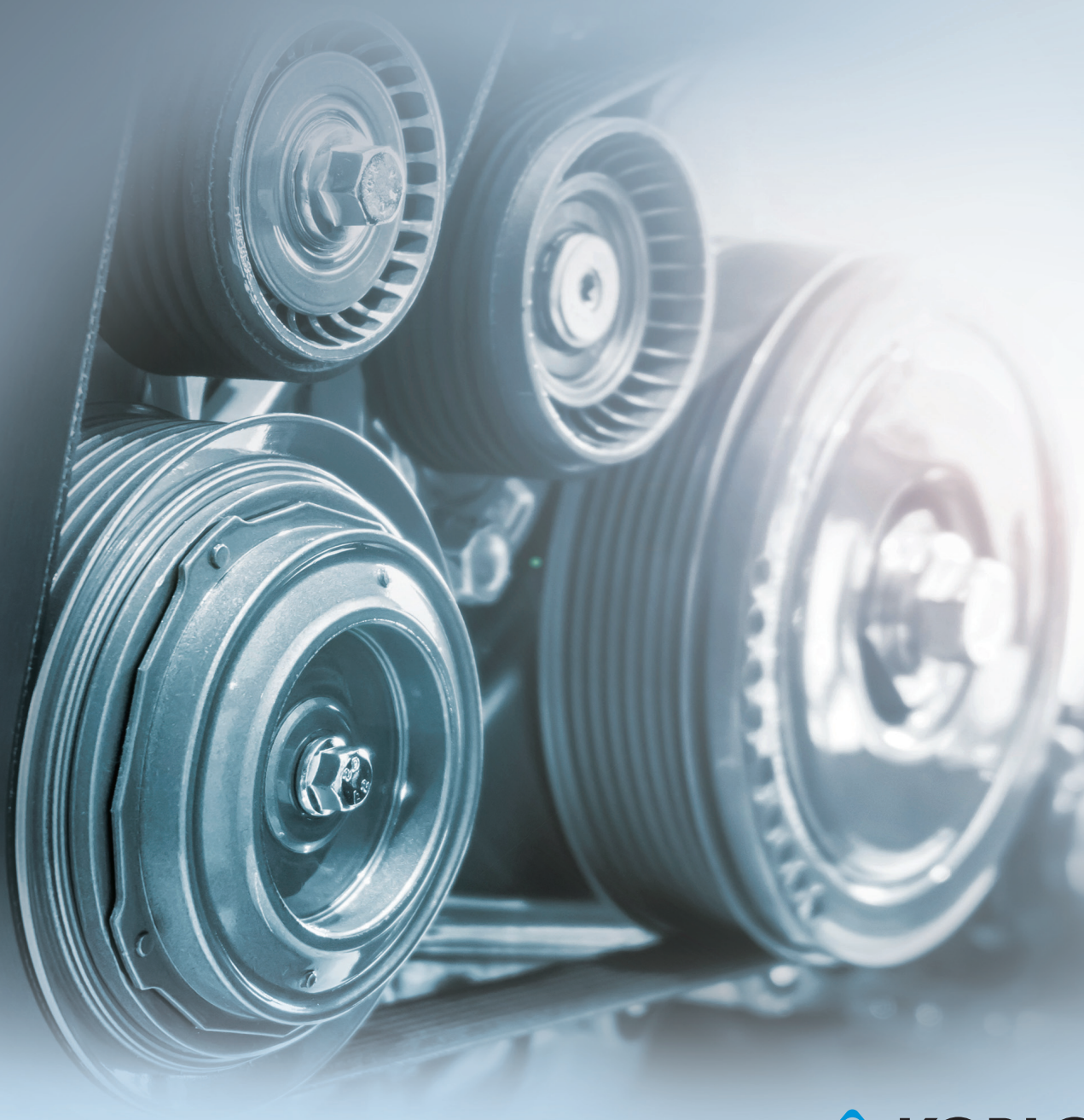


PULLEY APPLICATION



Total solution for various pulley machining

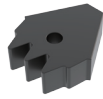
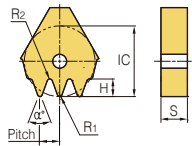
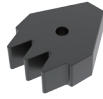
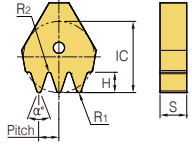
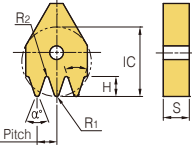


Pulley Application

Code system

Insert(N teeth)

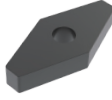
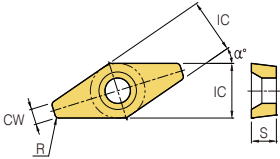
KP	16	047	-	R0.425	-	N2
KORLOY Pulley	Cutting edge length : diameter of inscribed circle	Thickness		Nose R		No. of teeth
	16 : 9.525 mm 22 : 12.7 mm 24 : 14.29 mm 27 : 15.875 mm 33 : 19.05 mm					

Type	Picture	Designation	IC	S	R1	R2	H	α°	Pitch	NT	Geometry
A		KP1604-R0.425-N2	9.525	4.76	0.425	0.35	4.67	20°	3.56	2	
		KP16047-R0.425-N2	9.525	4.76	0.425	0.35	3.4	40°	3.56	2	
		KP2204-R0.41-N2	12.7	4.76	0.41	0.46	3.2	40°	3.56	2	
		KP22047-R0.42-N3	12.7	4.76	0.425	0.48	3.16	40°	3.56	3	
B		KP1604-R0.5-N3	9.525	4.76	0.5	0.3	3.351	40°	2.4	3	
		KP22047-R0.46-N2	12.7	4.76	0.46	0.4	3.24	40°	3.56	2	
		KP22047-R0.1-N3	12.7	4.76	0.1	0.2	2.64	40°	2.34	3	
		KP22047-R0.5-N3	12.7	4.76	0.5	0.3	3.35	40°	3.56	3	
		KP2204-P2.34-N5	12.7	4.76	0.4	0.2	2.07	39°24'	2.34	5	
C		KP2204-R0.43-N3	12.7	4.76	0.43	0.43	3.654	36°52'	3.56	3	
		KP22047-R0.42-N3	12.7	4.76	0.42	0.35	3.409	40°	3.56	3	
		KP22047-R0.3-N4	12.7	4.76	0.3	0.2	2.3	40°	2.4	4	
		KP2204-P2.34-N6	12.7	4.76	0.4	0.2	2.07	39°24'	2.34	6	
		KP22064-P2.34-N5	12.7	6.4	0.4	0.2	2.06	40°	2.34	5	

※ Special types are available for quotation

Insert

VP	20	06	-	5.1	-	R0.8
V-Type Pulley	Cutting edge length : diameter of inscribed circle	Thickness		Width of Cutting Edge		Nose R

Picture	Designation	IC	S	CW	R	α°	Geometry
	VP1806-4.8-R0.8	15.89	6.35	4.8	0.8	38	
	VP1906-4.72-R0.8	15.89	6.35	4.72	0.8	38	
	VP2006-5.1-R0.8	17.18	6.35	5.1	0.8	38	
	VP2006-5.03-R0.8	17.18	6.35	5.03	0.8	38	
	VP2106-4.1-R0.7	17.46	6.35	4.1	0.7	40	
	VP2206-10.2-R0.8	22.24	6.35	10.2	0.8	34	
	VP2306-9.7-R0.8	22.76	6.35	9.7	0.8	35.5	
	VP2306-9.1-R0.8	22.87	6.35	9.1	0.8	37.5	

※ Special types are available for quotation

Performance evaluation

V-belt pulley

Workpiece Low carbon steel(C10)

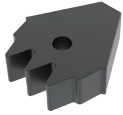
Cutting condition

- **Roughing** $vc(m/min) = 380$, $fn(mm/rev) = 0.23$, $ap(mm) = 2$, wet
- **Finishing** $vc(m/min) = 311$, $fn(mm/rev) = 0.2$, $ap(mm) = 2$, wet

Tool

Insert KP2504-3.56-R0.46-D40(PC8105)

Holder CDXNN2525-KP25



- » Longer tool life by applying V-Type corner in roughing
- » Good chip control and continuous cutting
- » Longer tool life with reduced cutting load and increased cutting edge strength



[After]



[Before]

Workpiece Low carbon steel(C10)

Cutting condition $vc(m/min) = 295$, $fn(mm/rev) = 0.2$, $ap(mm) = 0.2$, wet

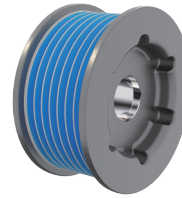
Tool

Insert KP2204-R0.43-N3(NC3225)

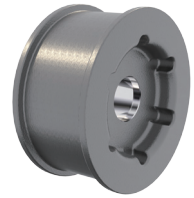
Holder CDXNN2525-KP22



- » Reduced cutting time by applying 3-cornered inserts
- » Reinforced insert side to prevent lateral breakage

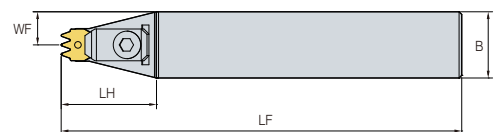
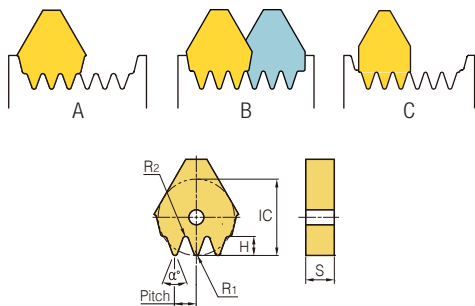


[After]



[Before]

Special order form



[Insert]									[Holder]							
Type	IC	S	R1	R2	H	α°	Pitch	NT	β°	H	B	LH	WF	HF	LF	
A																
B																
C																

• Customers' requests :

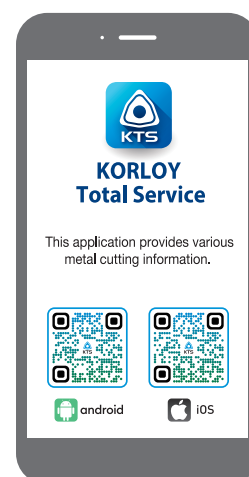
For the safe metalcutting

- Use safety supplies such as protective gloves to prevent possible injury while touching the edge of tools.
- Use safety glasses or safety cover to hedge possible dangers. Inappropriate usage or excessive cutting condition may lead tool's breakage or even the fragment's scattering.
- Clamp the workpiece tightly enough to prevent its movement while its machining.
- Properly manage the tool change phase because the inordinately used tool can be easily broken under the excessive cutting load or severe wear, and it may threat the operator's safety.
- Use safety cover because chips evacuated during cutting are hot and sharp and may cause burns and cuts. To remove chips safely, stop machining, put on protective gloves, and use a hook or other tools.
- Prepare for fire prevention measures as the use of the non-water soluble cutting oil may cause fire.
- Use safety cover and other safety supplies because the spare parts or the tools can be pulled out due to centrifugal force while high speed machining.



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