NAREX MTE®

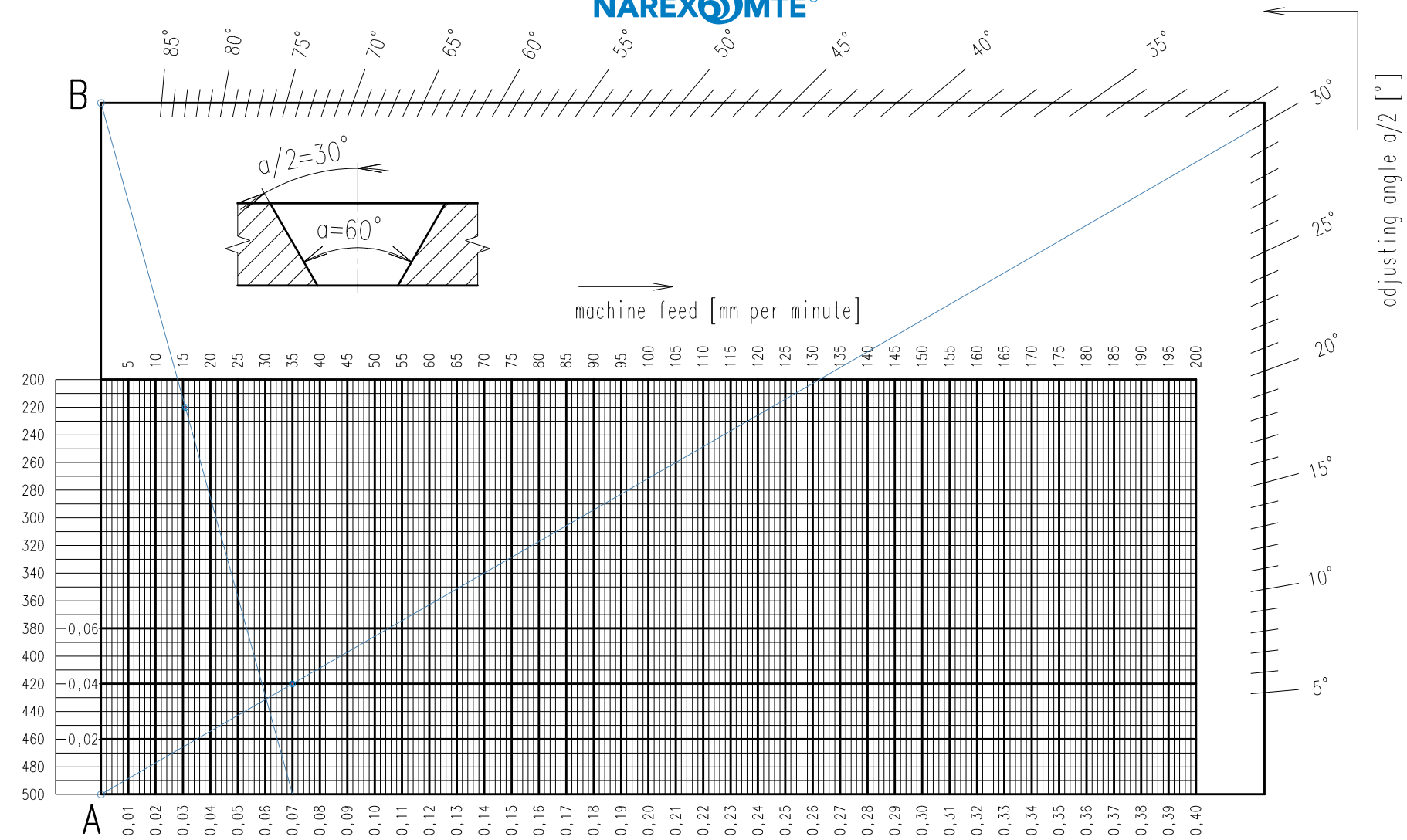

Diagram for Taper Boring with Vhu 36 head

Example:

1. Draw a line from point "A" under the angle of a/2 = 30°. In its cross-section with the line of the slide feed at 0.04 mm per revolution, deduct the spindle feed at 0.07 mm per revolution.
2. Draw a line connecting the spindle feed at 0.07 mm per revolution with point "B". In its cross-section with the spindle revolution line at 220 rpm, deduct the spindle feed at 15 mm per minute.

Calculation Formulas:

machine feed [mm per revolution] = slide feed [mm per revolution] / tg a/2

machine feed [mm per minute] = machine feed [mm per revolution] x spindle rotation [rpm]

NAREX MTE®

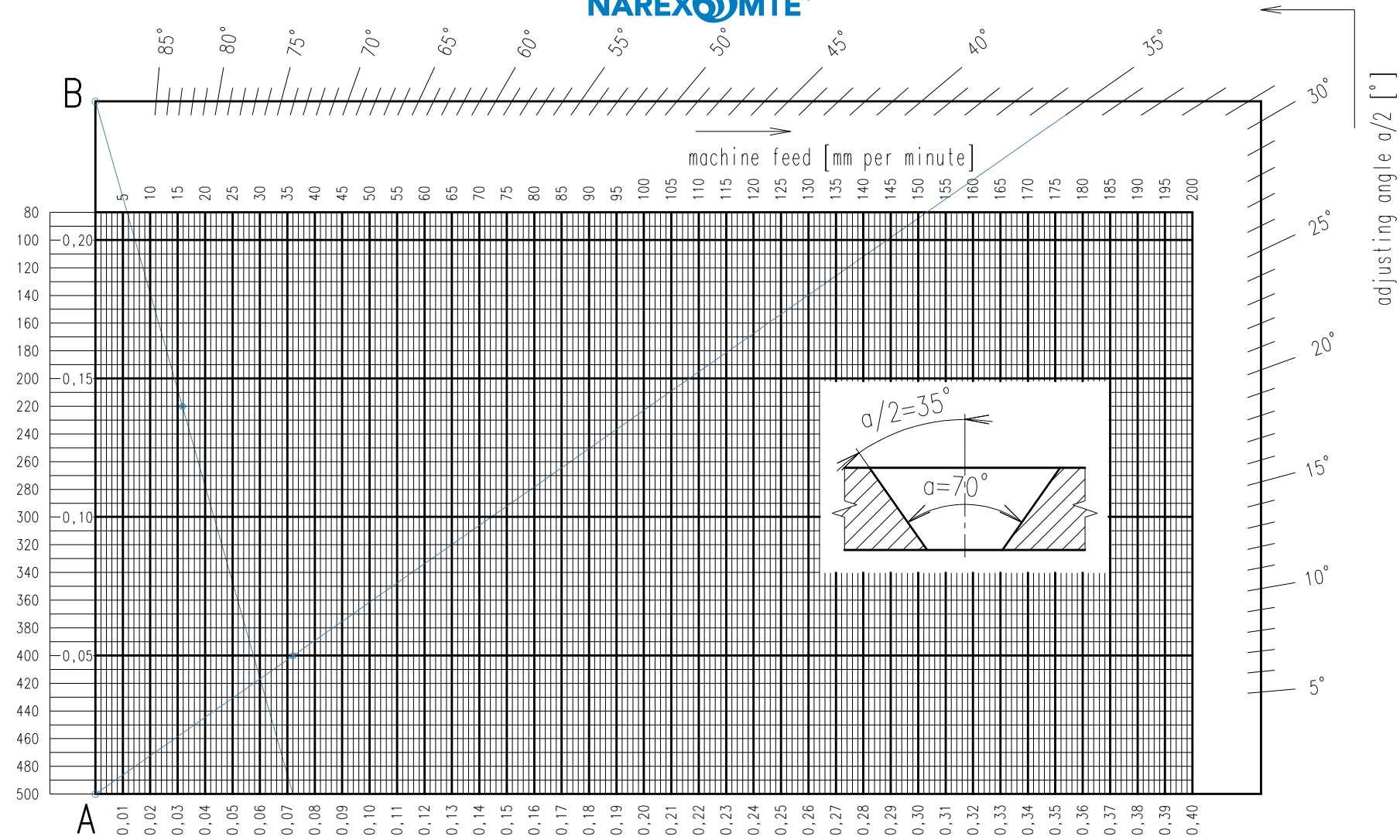

Diagram for Taper Boring with Vhu 56,80,110,125 or 160 heads

Example:
1. Draw a line from point "A" under the angle of a/2 = 35°. In its cross-section with the line of the slide feed at 0.05 mm per revolution, deduct the spindle feed at 0.072 mm per revolution.
2. Draw a line connecting the spindle feed at 0.072 mm per revolution with point "B". In its cross-section with the spindle revolution line at 220 rpm, deduct the spindle feed at 15.7 mm per minute.

Calculation Formulas:
machine feed [mm per revolution] = slide feed [mm per revolution] / tg a/2
machine feed [mm per minute] = machine feed [mm per revolution] x spindle rotation [rpm]