



Veltheim, May 17 2014
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u-tec® Program

Excellent results in comparative machining tests

To our valued Denitool partners

A well-known European manufacturer of valves, couplings etc. ran comparative tests with the following:

A) *Standard Live Tool Unit (LTU) w/ ER coupling and cutter APKT (Competitor)*

B) *Heimatec LTU w/ u-tec® and Denitool cutter LTH 3225 w/ SPHW 060204 FN DX50 inserts*

Compared to the standard LTU w/ ER coupling, usage of the extremely rigid Heimatec u-tec® System resulted in a **significantly improved surface quality.**

The new Denitool SPHW 060204 FN inserts showed an **80% increased tool life, reduced cutting time by 55%** and **increased the Qty/cutting edge by 4 times !**



Connector, material C 45, dia. 3.74"-> 6flat WS 3.346", w=0.472"

Due to the excellent results and convinced of the cost-effectiveness (insert w/ 4 cutting edges), it was easy for the customer to sign up for the general conversion to the Heimatec u-tec® solution with Denitool cutters & inserts.

A) *Cutter (competitor), dia 1.575", Z=4, insert: APKT*

Vc	N° of rev.	Feed	Feed	cutting length	Th	tool life/	Qty/edge
ft/min.	RPM	inch/Rev	inch /min.	6-flat inch	min.	edge min.	pcs.
525	1273	0.0055	7.0	6x 2.15	1.851	120	65

B) *Cutter Denitool LTH 3225 RSAS-06, dia 1.260", Z=6, insert: SPHW 060204 FN DX50*

Vc	N° of rev.	Feed	Feed	cutting length	Th	tool life/	Qty/edge
ft/min.	RPM	inch/Rev	inch /min.	6-flat inch	min.	edge min.	pcs.
650	1989	0.0079	15.7	6x 2.15	0.829	220	265

If you have any questions or suggestions please don't hesitate to contact us any time

Best regards Deni Ltd.