

# ***F92 - Profiling system***

*Special profiles to customer specifications*

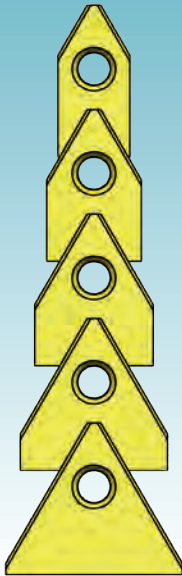
- ▶ *Fast production of special profiles*
- ▶ *5 different pre ground blanks*
- ▶ *Perfect interlock between holder and insert*
- ▶ *Excellent price-performance ratio*



# F92 - Profiling system

## Special profiles to customers specifications

Semi-finished insert  
width: 12 mm - 30 mm

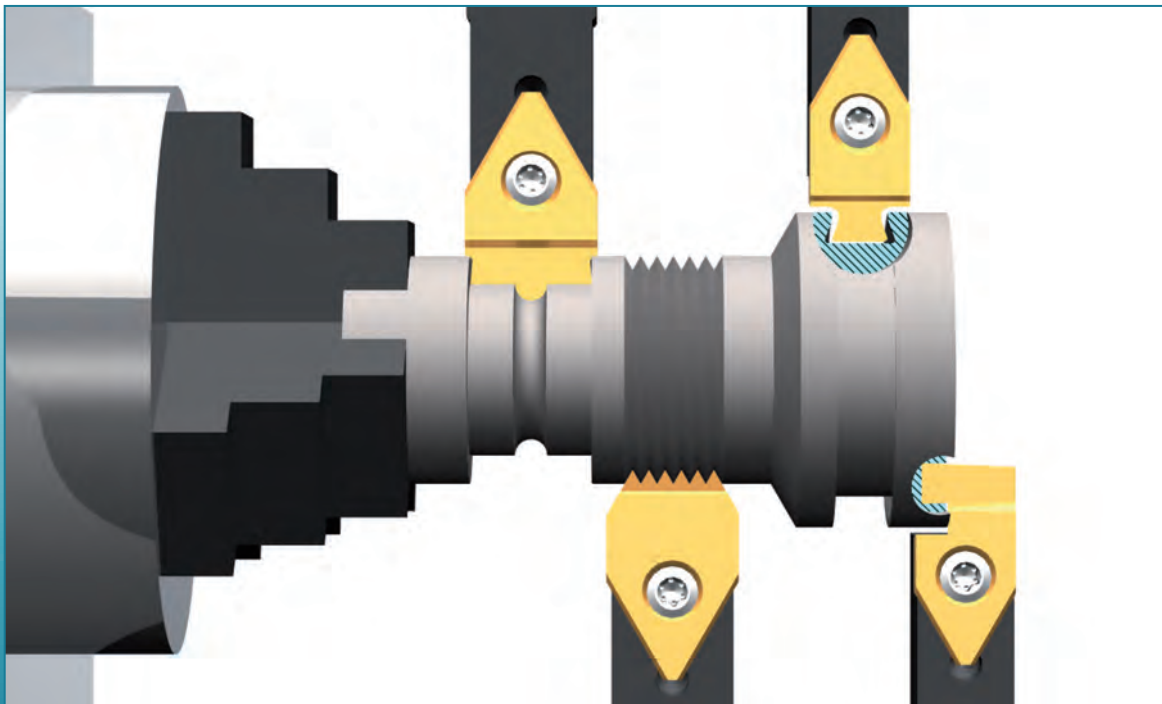


### How to place an order:

Example 1: If you intend to grind profiles yourself, you can order tool holders and pre ground inserts.

Example 2: If you give us the order to produce profile inserts, we definitely need

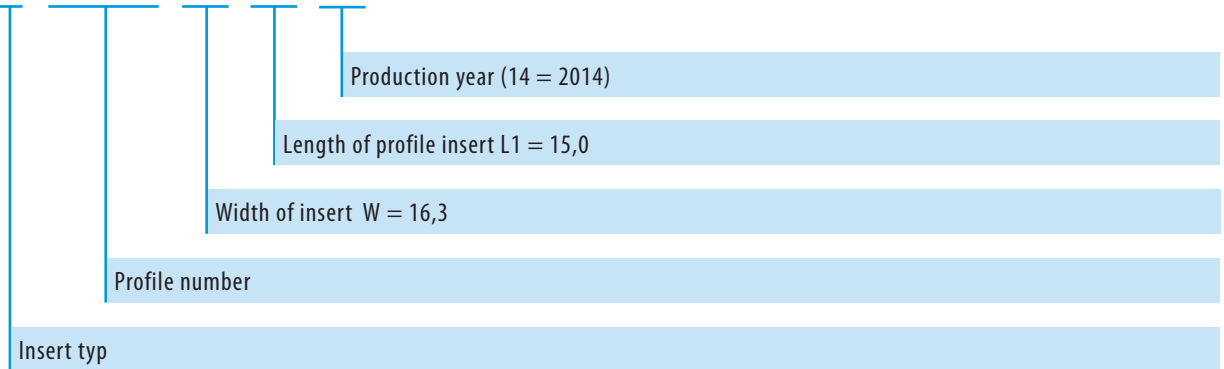
- Complete drawing of the component or the profile with dimensions and tolerances
- Lathe rotation: clockwise or counter clockwise
- Material to be machined
- Required coating (see listing p. 214)
- Planned order quantities of tool holders and inserts
- Required delivery times



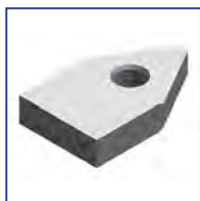
You can see further interesting examples in the section "Special solutions" page 175 onwards

Designation code for profile inserts

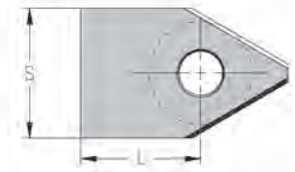
**F 00000 16 15 14**



Pre-ground inserts



**F 00000...00**  
System F92



| WG998 Ref.       | GF 25  | h ±0,10 | s +0,2 | L ±0,1 |
|------------------|--------|---------|--------|--------|
|                  | ID-Nr. |         |        |        |
| F 00000 12 15 00 | 29269  | 5,1     | 12,3   | 15,0   |
| F 00000 16 15 00 | 29272  | 5,1     | 16,3   | 15,0   |
| F 00000 20 15 00 | 29273  | 5,1     | 20,3   | 15,0   |
| F 00000 25 15 00 | 29275  | 5,1     | 25,3   | 15,0   |
| F 00000 30 15 00 | 47291  | 5,1     | 30,3   | 15,0   |

Remark

- Ground faces:
- Both flat-faces
  - Both pocket faces
  - Chamfer between these faces

The hole has got countersinks on both sides to turn the insert around.

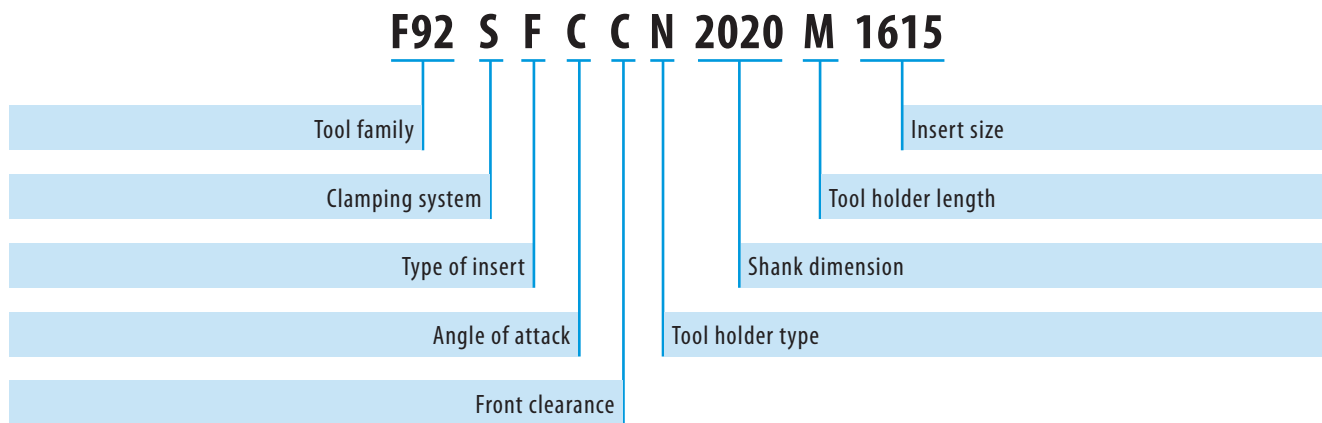
Fitting Holder



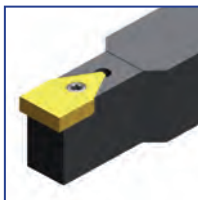
p. 170



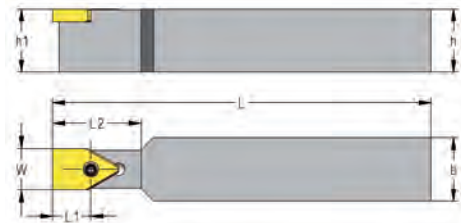
Designation code of tool holders for profile inserts




F92 Tool holders for profile inserts



**F92 SFCCN**  
System F92



| WG360 Ref.                | ID-Nr. | (°) | h  | h1 | b  | W         | L   | L1 | L2 |  |
|---------------------------|--------|-----|----|----|----|-----------|-----|----|----|---|
| F92 SFCCN 1212 K12 15     | 29265  | N   | 12 | 12 | 12 | 12,0      | 125 | 15 | 35 | 25  |
| F92 SFCCN 1212 K16 15     | 29342  | N   | 12 | 12 | 12 | 16,0      | 125 | 15 | 35 | 25  |
| F92 SFCCN 1616 K12 15     | 29343  | N   | 16 | 16 | 16 | 12,0      | 125 | 15 | 35 | 25  |
| F92 SFCCN 1616 K16 15     | 29266  | N   | 16 | 16 | 16 | 16,0      | 125 | 15 | 35 | 25  |
| F92 SFCCN 1616 K20 15     | 29344  | N   | 16 | 16 | 16 | 20,0      | 125 | 15 | 35 | 25  |
| F92 SFCCN 2020 M12 15     | 29345  | N   | 20 | 20 | 20 | 12,0      | 150 | 15 | 35 | 25  |
| F92 SFCCN 2020 M16 15     | 29346  | N   | 20 | 20 | 20 | 16,0      | 150 | 15 | 35 | 25  |
| F92 SFCCN 2020 M20 15     | 29267  | N   | 20 | 20 | 20 | 20,0      | 150 | 15 | 35 | 25  |
| F92 SFCCN 2525 M16 15     | 29347  | N   | 25 | 25 | 25 | 16,0      | 150 | 15 | 35 | 25  |
| F92 SFCCN 2525 M20 15     | 29348  | N   | 25 | 25 | 25 | 20,0      | 150 | 15 | 35 | 25  |
| F92 SFCCN 2525 M25+30 15* | 29268  | N   | 25 | 25 | 25 | 25,0+30,0 | 150 | 15 | 35 | 25  |

\* Both inserts fit: F0000251500 and F0000301500



Fitting inserts



Torque

p.227-228,238



p. 169



Remark

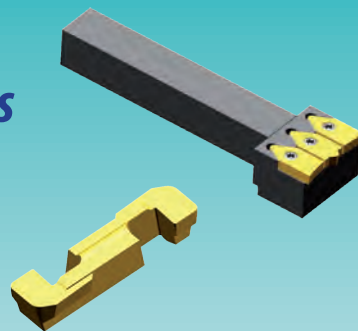
AWN-28 System and GLM Cartridge System on request.



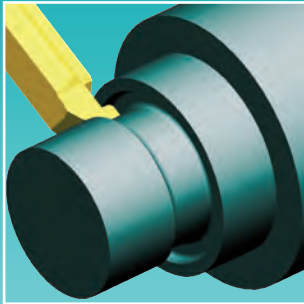
# *Tailor made solutions*

*...a real challenge*

- ▶ *Special tool holders*
- ▶ *Special inserts*

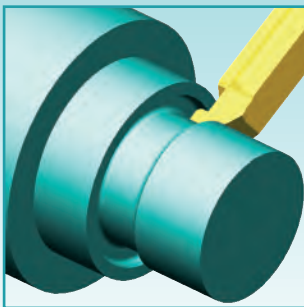


## When and why should tailor made solutions be applied?



- ▶ when standard tools are not efficient,
- ▶ general cost saving measures,
- ▶ to reduce production time,
- ▶ to save on tool costs.

## Our Strengths



- ▶ Qualified service
- ▶ Specified quotations
- ▶ Fair prices
- ▶ Production on most advanced machine tools
- ▶ Short delivery times



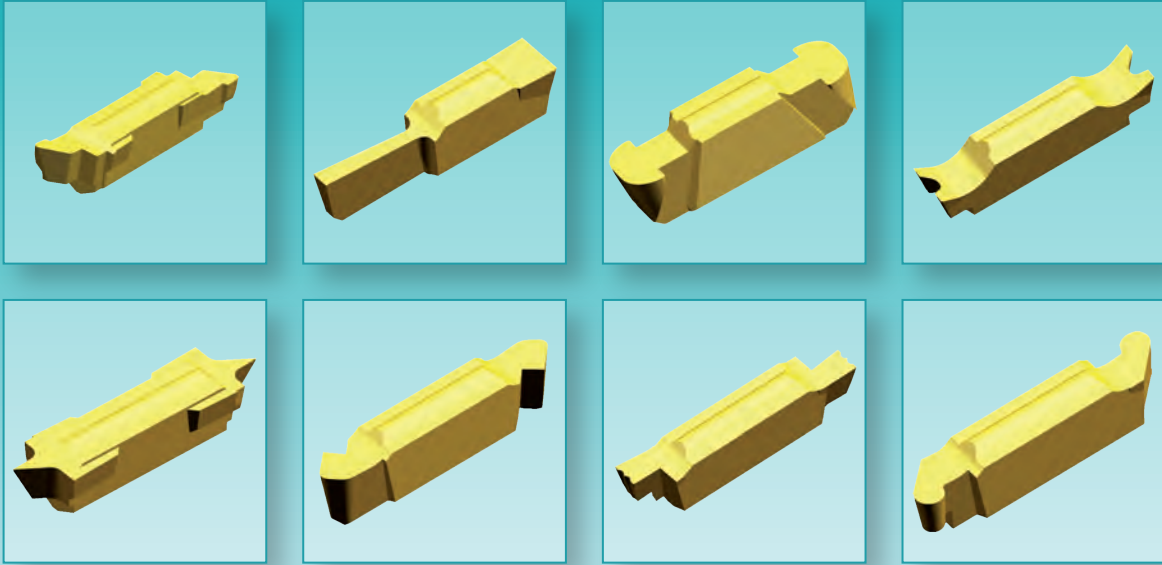
## Tailor made inserts

- ▶ So far more than 3700 different profiles have been ground
- ▶ Manufactured on most advanced machine tools
- ▶ Qualified employees
- ▶ Small quantities can also be made
- ▶ Precise cutting edges (Perfection on the edge)





## Tailor made inserts with 2 edges based on P92 and P92-P System



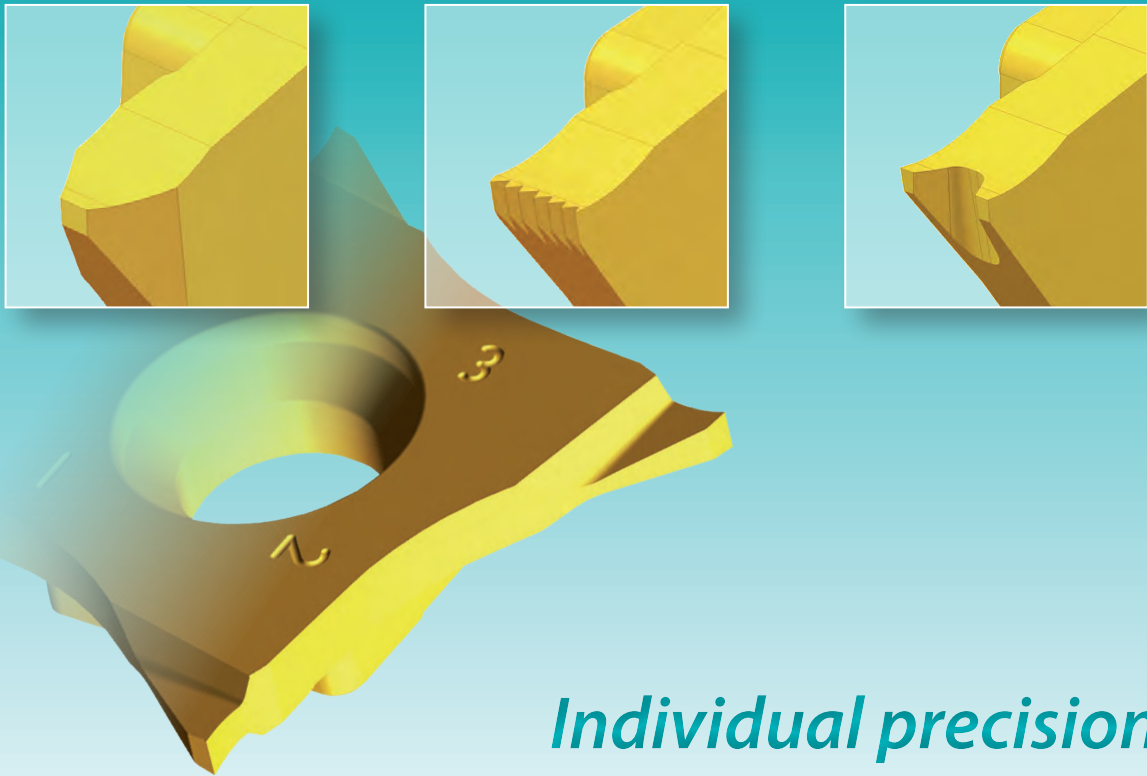
*Special requirements?  
We will fulfill them!*



10

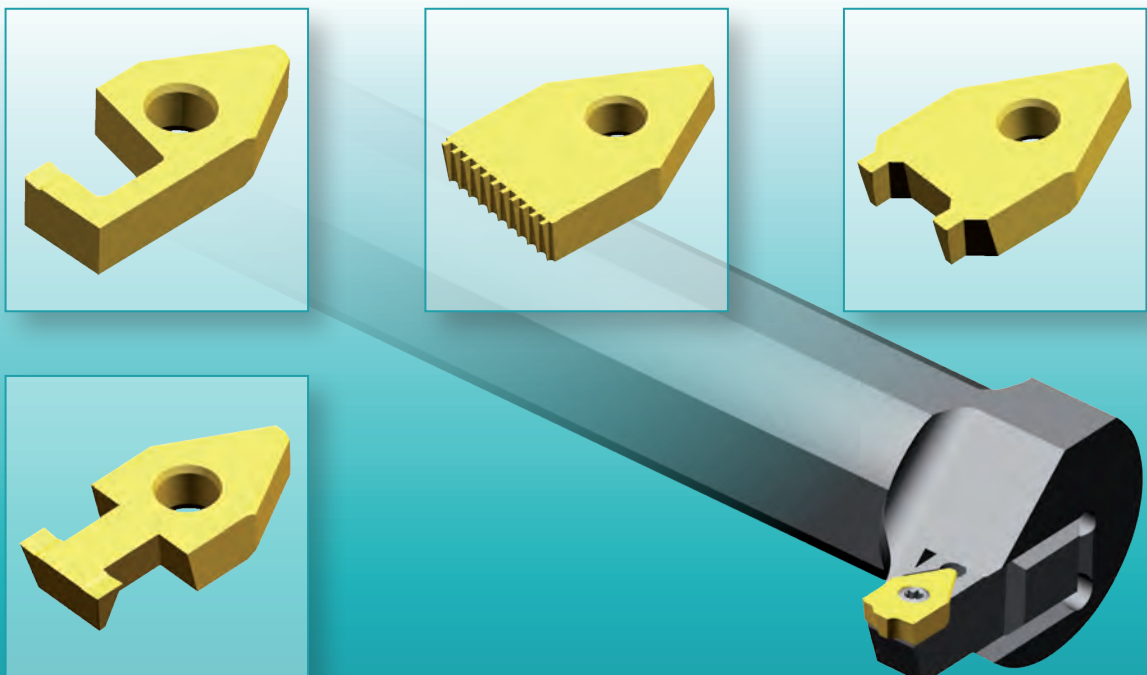


## Tailor made insert with 4 edges based on MC4 system

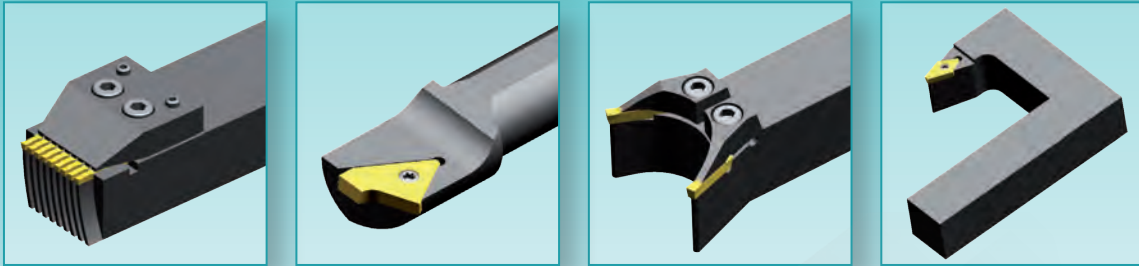
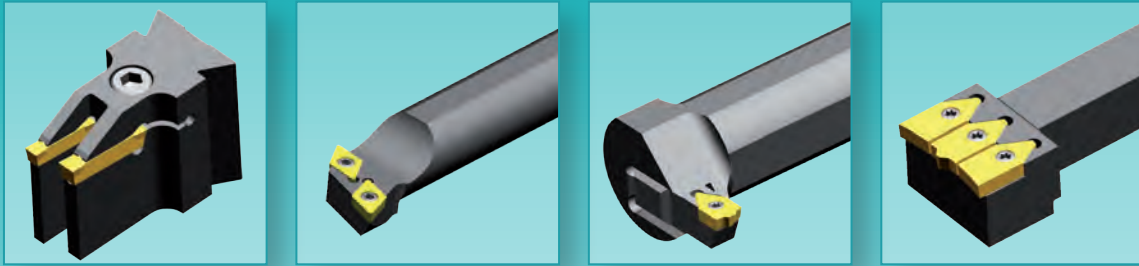


*Individual precision  
on each corner*

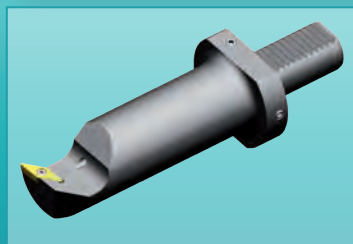
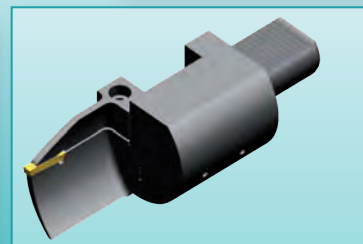
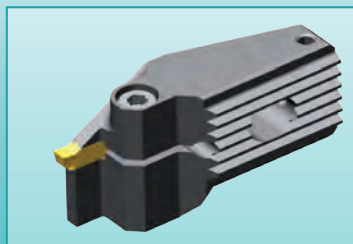
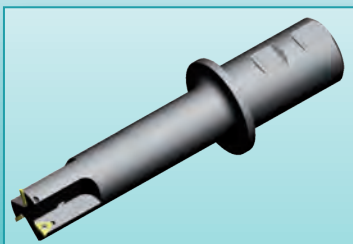
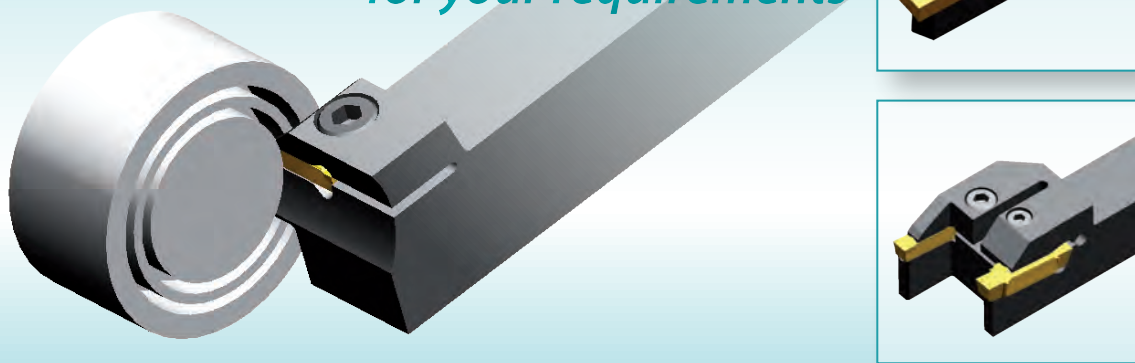
## Profile inserts based on F92 system



## Special tool holders with inserts



*Sophisticated solutions  
for your requirements*



## Two examples for cost saving solutions

*The cutting and grooving insert MTNZ 4 NANOSPEED completely finishes the shaft; front and rear side of the pinion.*



### Actual situation:

Expensive production sequence caused by awkward turning operations using left and right tool holders. The customer delegates the problem to the designer.

### Process:

At first he considers the problem. Some days later, he has found the solution.

### *Clearance cut using a modified TPGN insert.*

**Goal:** The production time for this piston had to be reduced.

**Mission:** The task to create a special tool to save time. A tough nut to crack, for the designer. However he solved it.

In a letter of gratitude the customer stated that the special tool reduces component production time by 10 minutes.



**Production time  
reduced by 10 min!**

