

# SB50

Period	2001. 12. 18
Grade	IBON-SB50
Operation	Continuous Turning
Component	Main Shaft for Transfer Case (SUV)
Work Material	4027 Hardened Steel (HRc 58~62)
Machining Parameter	Cutting Speed = 450~550 ft/min (137~168 m/min) Depth of Cut = 0.015 inch (0.381 mm) Feed Rate = 0.003~0.004 in/rev (0.076~0.102 mm/rev) Coolant : Dry
Insert type	VNMA332
Holder type	
Competitor	C Company - c
Results	Outperformed 2 : 1 (machined 600 pcs while competitor's did 300 pcs)

## AMERICAN SUPERABRASIVES CORP.

59 Avenue at the Common Shrewsbury , NJ 07702

[email-njabrasive@aol.com](mailto:email-njabrasive@aol.com) [www.diamond-abrasives.com](http://www.diamond-abrasives.com)

TEL-732.389.8066 FAX 732.389.8069

