



Tooling demo
'ShakerSS'



Nesting MDF cabinet **doors**

Outside Shaker door profile **with bottom bevel**





Onion skin
Vs
One-shot

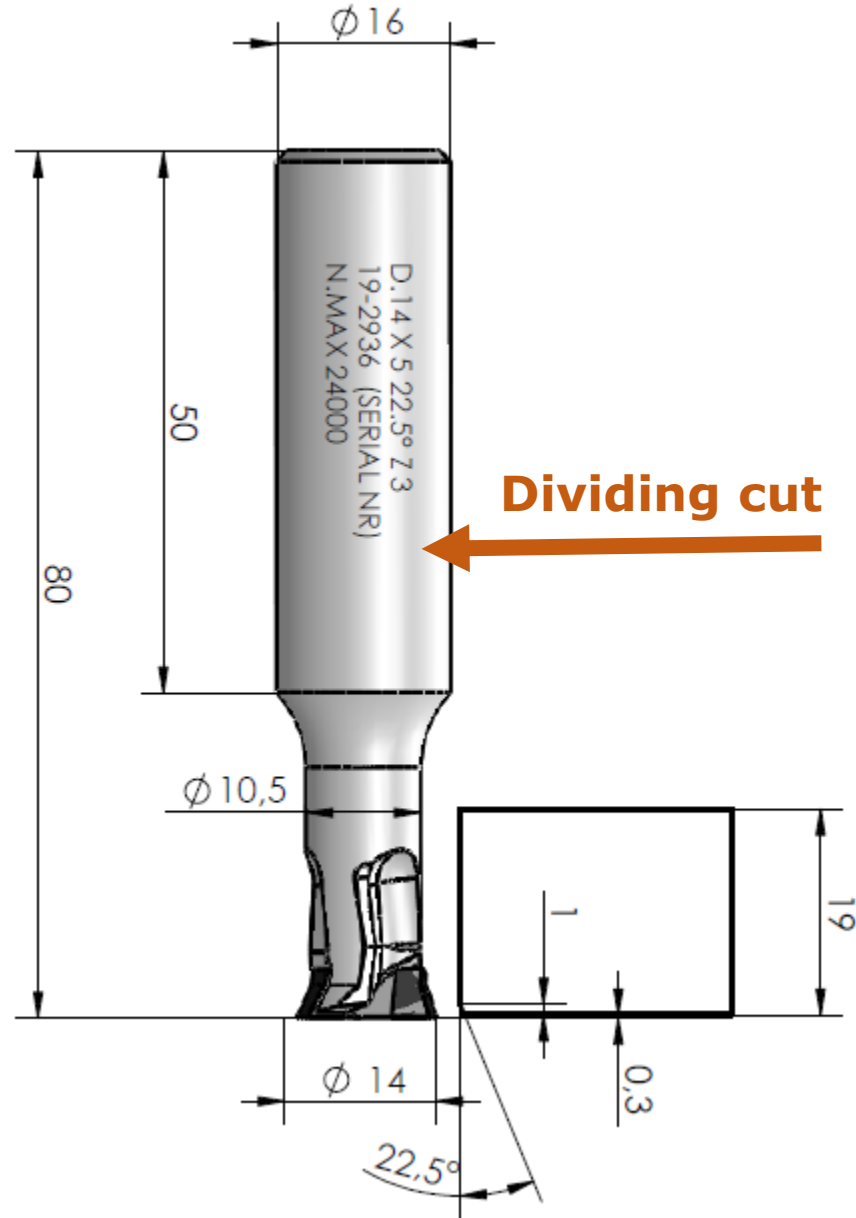
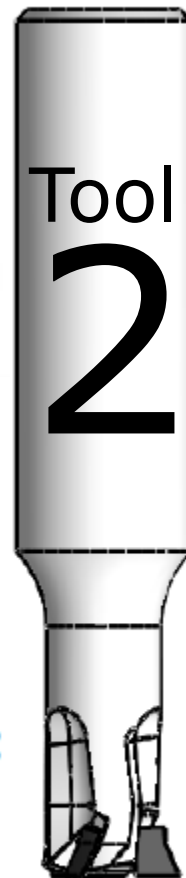
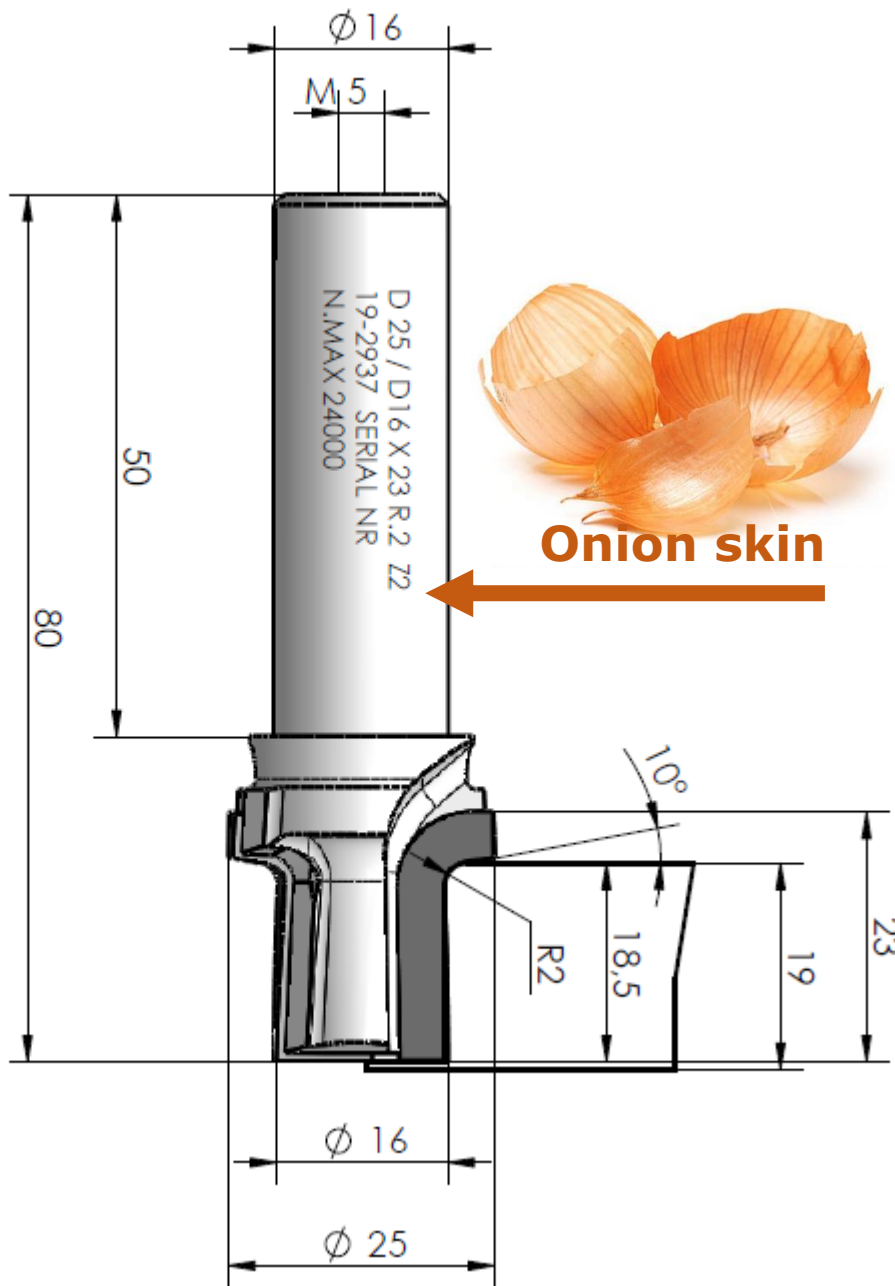
Material: 19mm MDF 1770 x 2800
Nest: 12 pieces

R2

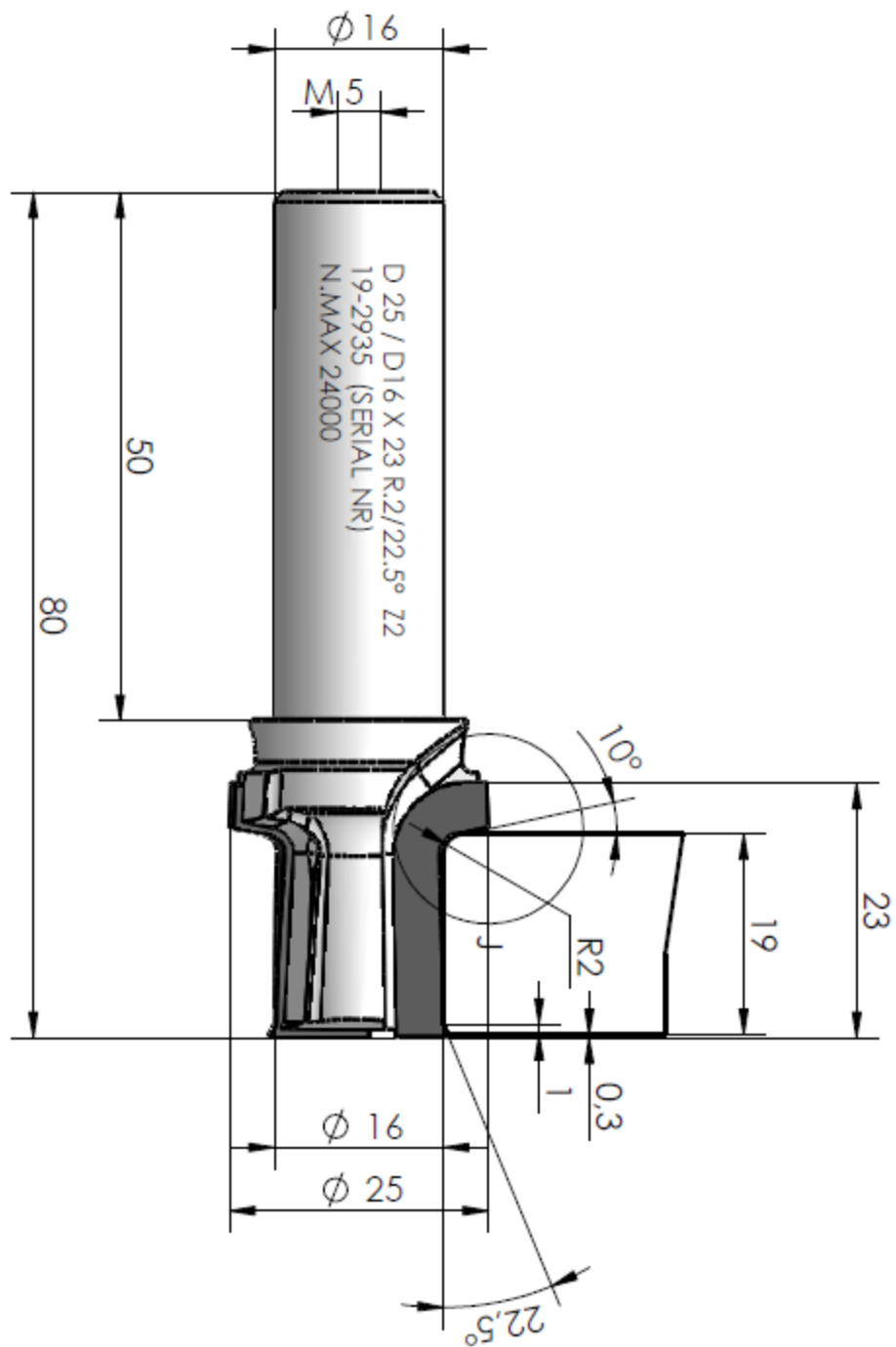
19mm

1mm

22,5°



One-shot





Balance class G<2.5
@ 24.000 RPM



Fitted to Thermo-grip
holders HSK63F

Run-out tolerance \pm
0,02

www.mgtools.it



Tool 1

Operating parameters used:
22.000 RPM @ 12m/min

Tool 2

Operating parameters used:
22.000 RPM @ 20m/min



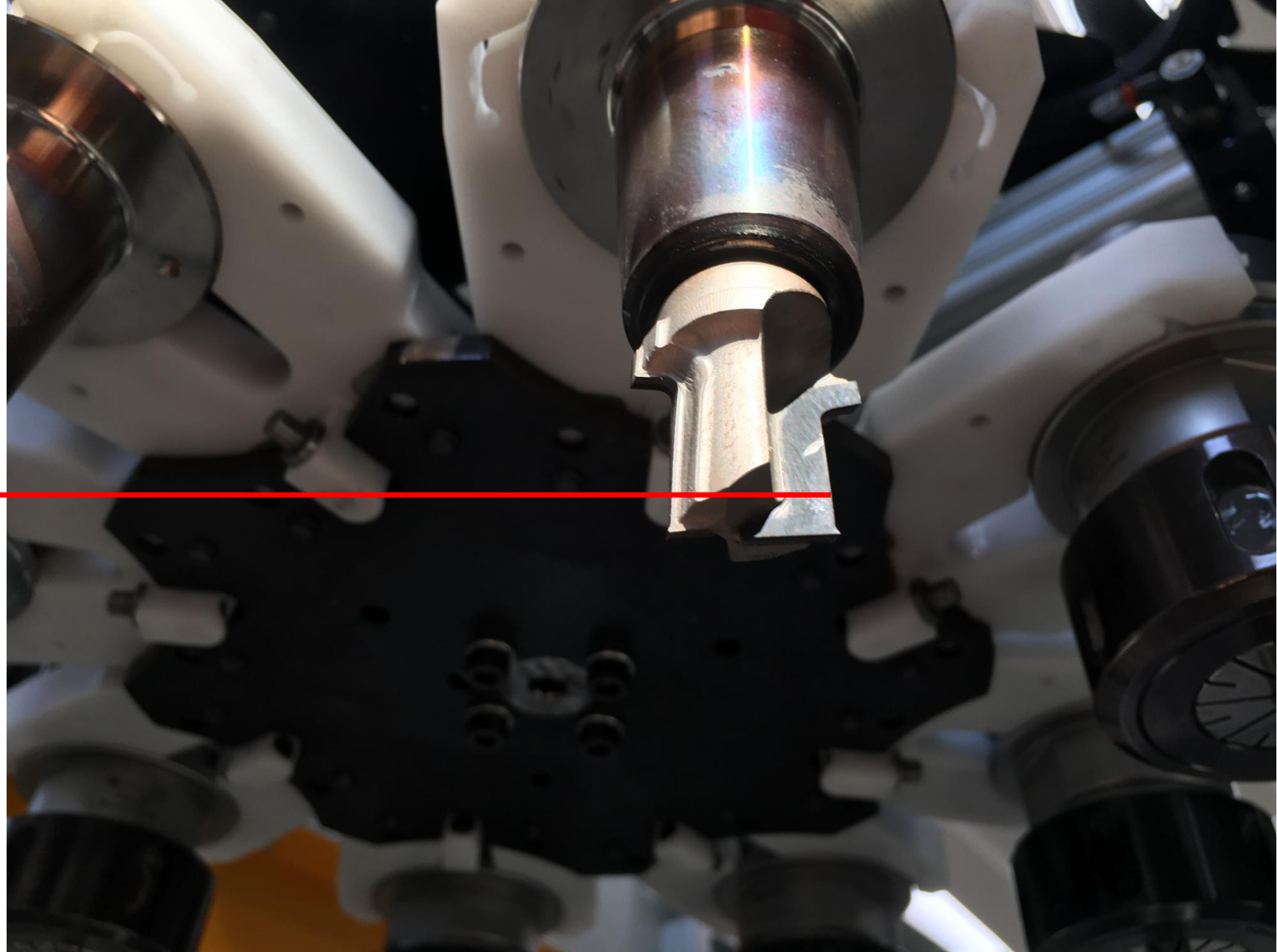
Balance class G<2.5
@ 24.000 RPM

One-shot

Fitted to Thermo-grip
holders HSK63F

Run-out tolerance \pm
0,02

www.mgitools.it





Machining Parameters:

22.000 RPM - 12m/min
Z2 - Chip-load = 0,27



22.000 RPM - 20m/min
Z3 - Chip-load = 0,30

22.000 RPM - 10m/min
Z2 - Chip-load = 0,23
One-shot

www.mgtools.it

*6 minutes
17 seconds*

Cycle

times

*4 minutes
48 seconds*

Pros & Cons

- More robust tool designs
- Easy to extract the R2 tool if the machine stops during a Nesting cycle
- The Z3 design of the bevelling tool makes the cutter usable even after damage to a single bevelling spur

- **Slower cycle time**
- **Two tool purchase**

- Single tool purchase
- Faster cycle time

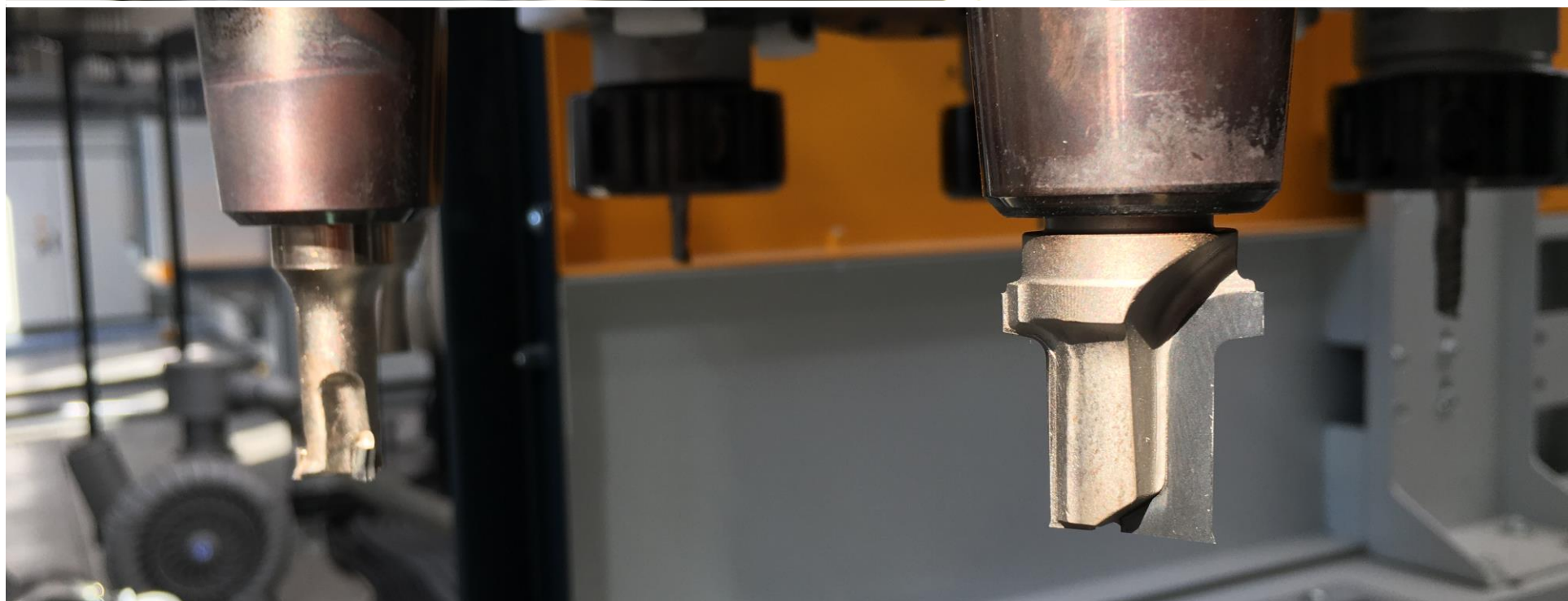
- **The bottom bevelling spurs makes the PCD edge profile quite delicate**
- **Due to the bottom bevelling spurs it would be difficult to extract tool if the machine stops during a Nesting cycle**
- **Forced extraction would lead to breaking the bevelling spurs**
- **Damage to even a single bevelling spur would make the tool un-usable**
- **Requires a pre-milled hole to introduce the tool into the Nest – Z,X,Y plunging is not recommended (4,48 cycle time included the production of the holes)**



Nesting MDF ?

Try MGI

we know how



www.mgtools.it