

## **CHAMFERCUT**

定义一个  
全新的标准

Definition of  
a new standard



# 定义一个全新的标准

Defintion of a new standard

**高质量-高稳定性-低单件成本** 这就是拥有专利权的倒角刀工艺。

由倒角刀技术提供的倒角加工后无需任何附加工艺、无需二次切削。而这些正是挤压式倒棱所欠缺的。

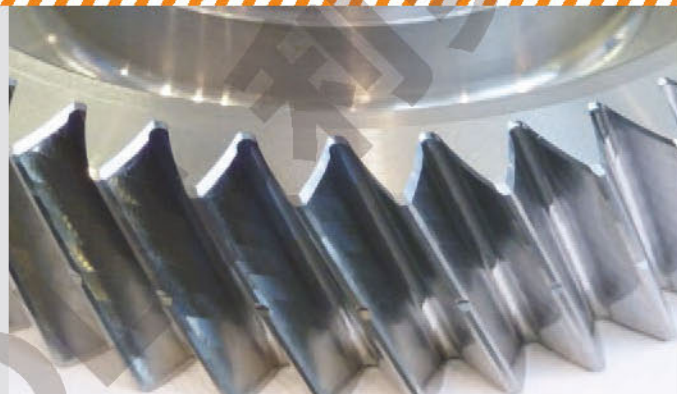
使用倒角工艺，可以切出非常准确的倒角。而且相对于挤压式倒棱，倒角不会影响材质结构。这样就不会对热处理之后的精加工造成影响（如珩齿）。LMT Fette设计的工艺精度是无可争议的。这种倒角的质量定义了一个全新的标准-重复加工精度极高。

这类工艺组合使得倒角刀成为市场上倒角去毛刺工艺中刀具成本最低的刀具。

## 优势

- 高精度
- 100%的倒角质量
- 凭借机床的控制使倒角调整成为可能
- 高效率
- 简单、低成本的修磨
- 模数范围0.8-42

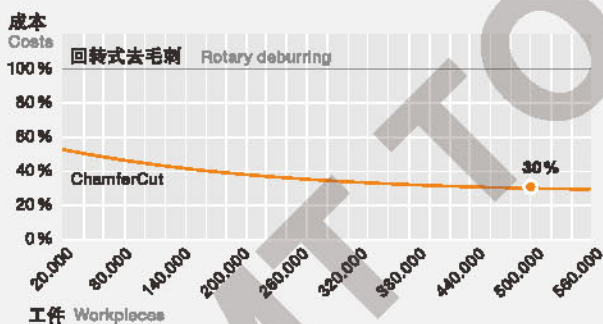
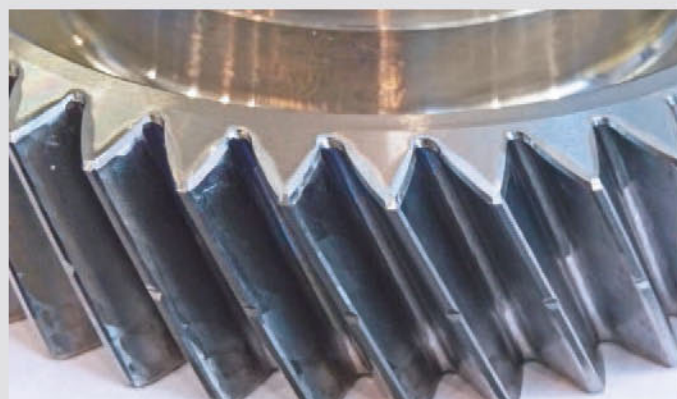
500,000件工件 500,000 workpieces	回转式去毛刺 Rotary deburring	倒角刀 ChamferCut
最大刀具节拍 Tool cycles max.	100 %	600 %
新刀成本 New tool costs	100 %	55 %
修磨成本 Reconditioning costs	100 %	5 %
总刀具成本 Tool costs	100 %	30 %



## 倒角刀-高精度倒角

倒角工艺提高一个连续的倒角深度-即使是齿根

**ChamferCut - highest precision in chamfering**  
A constant chamfer depth is produced with the ChamferCut process - also in the root.



## 倒角刀-降本提效

一个简单的计算清楚地显示：单单刀具成本就提供了一个生产中极具潜力的成本降低。更别提在齿轮加工中的降本提效（无需二次切削）及提高后续精加工（如珩磨）稳定性了

### ChamferCut - efficiency that pays off

A simplified calculation clearly shows: The tool costs alone offer a great potential saving in production. Not to mention the better cost-effectiveness in gear cutting (no second cut required) as well as increased process reliability in finishing (e.g. honing).

## 挤压式倒棱工艺造成的材料塑性变形

去毛刺过程中（如回转式去毛刺工艺）材料会发生塑性变形。这是后续精加工（如珩磨）主要问题的源头

### Material forming during the deformation-based deburring process

During deburring processes (e.g. rotary deburring) material build up and deformations occur. This can cause major problems during finishing (e.g. honing).



**Precise – reliable – cost-effective. This is chamfering with the patented ChamferCut process.**

After chamfering with the ChamferCut technology, no additional processing is necessary. No need for a second cut, often required during the deformation-based deburring process for the removal of material build up.

With the chamfering process, the exact chamfer form is cut. In contrast to deformation-based processes, the material structure is not affected. Thus, there is no negative impact on finishing after heat treatment (e.g. honing). The precision of this LMT Fette engineered process is undisputed. The quality of such chamfers defines a new standard – with maximum repetitive accuracy.

The combination of these process benefits along with low tool costs makes the ChamferCut the most economic deburring and chamfering process on the market.

**Advantages:**

- Highest precision
- 100 % chamfer quality
- Chamfer correction possible via machine control
- High efficiency
- Simple, cost-effective reconditioning
- Module range 0.8–42



Foto: Pflaum, Liebherr-Verzahntechnik GmbH

**倒角刀作为一个刀具系统**

使用倒角刀使得齿轮切削与去毛刺能在一根芯轴上完成。无需附加投资。

**ChamferCut as a tool system**

Using ChamferCut as a tool system enables gear cutting and deburring on one arbor. No additional investment is required.

**倒角刀在独立的倒角工位**

使用倒角刀在独立的倒角工位使其能与滚齿同时加工

**ChamferCut in a separate chamfering unit**

Using ChamferCut in a separate deburring unit enables main time parallel machining.

**ChamferCut in action**



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LMT TOOLS 利美特

Printed in China 2019年3月版

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