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Automatic measuring procedure for a sure increase in productivity

Face milling cutters are considered to be sophisticated and very efficient tools. Precondition for a process reliable use and appropriate tool life is that carbide inserts in run-out move within the defined tolerances. ZOLLER developed a new presetter and measuring machine - »millCheck«. With this machine you can handle this without any great effort.

Because of the very high cutting capacity face milling cutters are mainly used in the engine production or for the treatment of grey cast iron. In addition these tools rate as very flexible because the change of face milling cutters can be completed very fast. As the cutting edges on the perimeter are tightly arranged a contact-free measurement and gathering of the cutting edges – even by the help of the current image processing technology – is mostly not possible. The up to now practiced manual presetting entails – beside the large expenditure of time – that the results can not be documented or logged. As the leading manufacturer of presetter and measuring machines Zoller therefore enlarged its range of products in this field. The presetter and measuring machine »millCheck« is based on the machine series »venturion« - a special measuring sensor as well as an automatic measuring sequence were added. For the use in practice this specially means: After entering the ID-no. the measuring procedure starts. For this the run-out on the basic holder of the milling cutter will be registered automatically and will be compensated for the presetting/measuring on the cutting edge. After a 360°-rotation all cutting edges of the lateral axis (run-out) are measured and proved within the defined tolerance range. Cutting edges which are out of the tolerance can be selected via the graphical presentation and can be swivelled in via the cutting edge correction. After correcting the cutting edge it will be measured once again and the and the result will be updated. This process can be repeated any number of times – till all cutting edges are inside the tolerance range or till a μ -precise run-out of the cutting edges is ensured.

With the use of »millCheck« a considerable increase of the achievable facing quality as well as a measurable extension of tool life can be reached. That certainly also reduces machine down times and increases the measurable productivity.

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Sophisticated tools with a lot of cutting edges:
Face milling cutters, also known as Cap-cutters



ZOLLER presetter and measuring machine for metal cutting tools
»millcheck«



Automatical measuring sequence with graphical display