

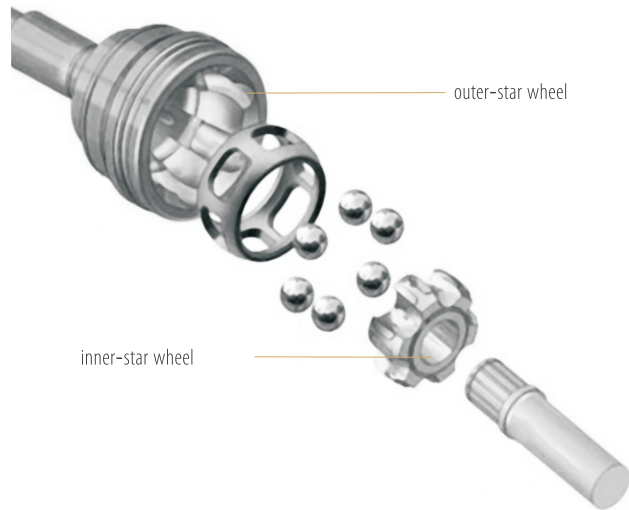
MTHM/MTSMF/MTSMR series
CVJ Ball-nose mill



CVJ Ball-nose mill

Ball cage type constant velocity joint is one of the key essential parts of modern automobile. Its emergence promoted the automobile's progress and development of front-wheel drive and all-wheel drive technology.

The traditional processing of the inner-star wheel and the outer-star wheel, which is used in CV joint milling machine and grinding machine conducting wet milling and grinding. The processing is tedious and difficult to guarantee the precision, with low processing efficiency and higher cost.



Zhengzuan CVJ ball-nose mill is classified as hard milling (MTHM) series and soft milling (MTSMR/MTSMF) series.



MTHM series

Used for finish processing of the inner/outer-star wheel after heat treatment.



MTSMF series

Used for finish processing of the inner/outer-star wheel before heat treatment.



MTSMR series

Used for rough processing of the inner/outer-star wheel before heat treatment.

Aimed at the disadvantages of traditional processing technology of the inner/outer-star wheel, Depending on years of technical advantages and working site experiences, Zhengzuan researched and developed CVJ ball-nose mill which is special for machining the inner/outer-star wheel roller.

CVJ ball-nose mill has advantages as below:

- Milling replace grinding is well realized a more flexible processing method.
- Milling surface produces compressive stress and the grinding surface produces tensile stress, so machining work piece produced by milling replace grinding owns higher anti-fatigue strength and good durability.
- Good environmental protection, air-cooled dry cutting avoids the high maintenance cost of cutting fluid and does not cause environmental pollution.
- The processing efficiency is greatly improved.

Matched tool holder

tool holder for machining inner-star wheel

tool holder for machining outer-star wheel



MTHM series

CVJ Ball-nose mill

Adopting PCBN high speed hard and dry cutting processing technology, the ball track which is on inner/outer-star wheel can be formed in one time.



- PCBN cutting edge material.
- Quick and accurate clamping on the taper face and end face.
- Four blade structure with good cutting stability.
- Special treatment of the blades, stronger blade strength and performance.
- The air vent arrangement is favorable for cooling and chip removal in time.
- Profile tolerance of cutting edge is $\pm 0.003\text{mm}$, cutting edge runout is within 0.005mm .
- High strength steel tool body.
- Simple and convenient disassembly.
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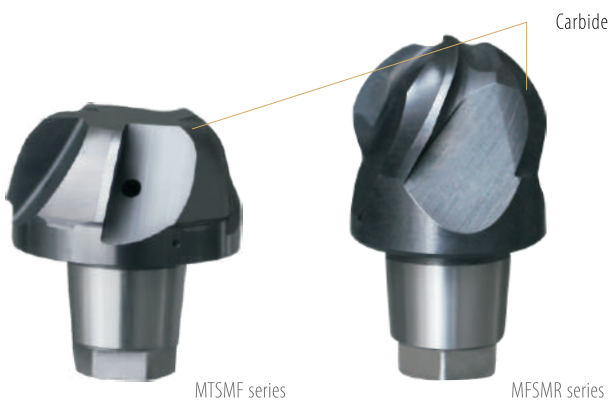


MTHM series specifications

Types	Diameter of steel ball mm	Number of blade Z	Blade material	Tool body material
MTHM-0120AS	$\Phi 12.700$	4	PCBN	steel
MTHM-0130AS	$\Phi 13.494$	4	PCBN	steel
MTHM-0140AS	$\Phi 14.288$	4	PCBN	steel
MTHM-0150AS	$\Phi 15.081$	4	PCBN	steel
MTHM-0160AS	$\Phi 16.00$	4	PCBN	steel
MTHM-0170AS	$\Phi 17.15$	4	PCBN	steel
MTHM-0180AS	$\Phi 18.00$	4	PCBN	steel
MTHM-0190AS	$\Phi 19.050$	4	PCBN	steel
MTHM-0200AS	$\Phi 20.00$	4	PCBN	steel
MTHM-0210AS	$\Phi 21.431$	4	PCBN	steel
MTHM-0220AS	$\Phi 22.00$	4	PCBN	steel
MTHM-0230AS	$\Phi 23.019$	4	PCBN	steel

MTHSMF、MTHSMR series

CVJ Ball-nose mill



- Tool blade material is fine-grained cemented carbide.
- Rough machining series matched with finishing series.
- Special coating.
- Quick and accurate clamping on the taper face and end face.
- Simple and convenient disassembly.



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