



COGSDILL TOOL

products, inc.

APPLICATION *news*

DATE September 18, 2003

NUMBER CAN4-03

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Nobur® JA Replaces Expensive and Time-Consuming Secondary Operations

***Automatic Recessing tool pays for itself in two weeks as cutting
and welding operations are eliminated***

A MANUFACTURER OF SPECIAL COMPONENTS was producing a frame for a motion picture camera. The frame features tubes that slide together and must be fastened. They needed to countersink holes inside each end of a six-foot long tube to allow a screw head to be recessed below the tube ID. They were cutting a section of the tube out, countersinking it, then welding it back into place. The customer does about 100-200 parts per month. These processes were very costly and time-consuming.

With the Nobur® JA Automatic Recessing tool from Cogsdill, the customer can perform the countersinking operations inside the tube without cutting the tube open. The tool runs in a drill bushing, with the tube mounted in a special custom fixture.

The tool paid for itself by the second week of production. The customer is very happy, first for finding Cogsdill on the Internet, and then for Cogsdill's help in achieving great results and lower costs with the Nobur JA Automatic Recessing tool.

Machining Data

Machine type-----Drill press

Tool type -----Nobur JA

Material type-----303 stainless steel tube

Spindle speed ----300 RPM

Feed rate ----- .003 IPR (.076 mm/rev)

Cycle time -----1 minute

Coolant -----Thin machine oil

Size required ----- .490 in. (12.45mm) dia.
(82° countersink)

Size achieved -----As required

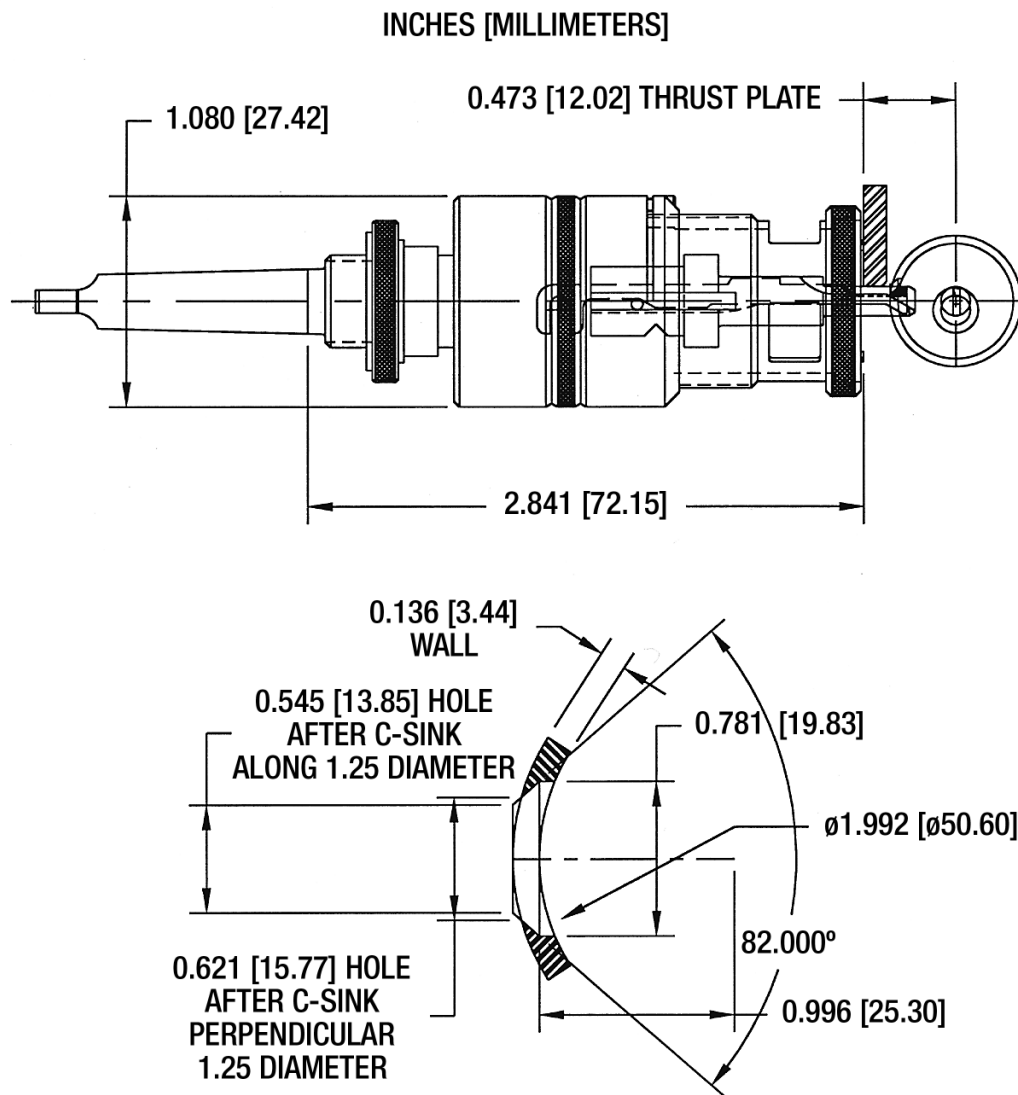
Finish required --Smooth and chatter-free

Finish achieved --As required

— *See reverse side for tool-and-part drawing* —



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NOBUR® JA SERIES RECESSING TOOLS are designed for deep bore recessing and grooving. In-bore pilot supports cutter along entire length; eliminates tool deflection; ensures concentricity through rigid cutting action. Ideal for multiple grooves, chamfers, or metering lands, and for O-ring and retaining ring grooves.

Refer to our catalog no. 400, "Automatic Recessing, Generating Heads, & Precision Chamfering," for more information.