



COGSDILL TOOL

products, inc.

APPLICATION *news*

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NUMBER CAN2-03

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Nobur® JA Series Automatic Recessing Tool Allows Faster Production Time

Cycle time is reduced by more than 94% as Nobur Recessing replaces circular interpolation for grooving operation

A manufacturer of hydraulic valves had to machine two O-ring grooves in a spool valve bore. They were circular interpolating one groove at a time with a key slot cutter. The approximate cycle time with this method was **six minutes per part**. The grooving operation was a bottleneck in their manufacturing process.

With the use of the Nobur JA Automatic Recessing tool from Cogsdill, both grooves were machined simultaneously for a total cycle time of only **20 seconds per part**. The customer's fixture holds 16 piece parts; for grooving all 16 parts, the total cycle time is reduced from 96 minutes to 5.33 minutes, for a total cycle time reduction of more than 94%!

NOTE: Tool shown in photo is NOT the same tool as described above. Cutters and pilots are designed to suit the application.

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.



— See reverse side for machining data —

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Machining data

Tool type: Nobur® JA Series Automatic recessing tool

Machine type: Vertical machining center

Material type: Cast iron

Spindle speed: 250 RPM

Feed rate: .004 IPR (.10 mm/rev)

Cycle time: 20 seconds per part

Coolant: Water soluble oil

Refer to catalog no. 400 for more information on Cogsdill's complete line of automatic recessing and grooving tools, generating heads, and precision chamfering tools.