

| APPLICATION CASES |

WIFEX™ – WIFORCE™

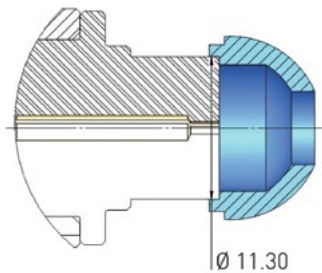
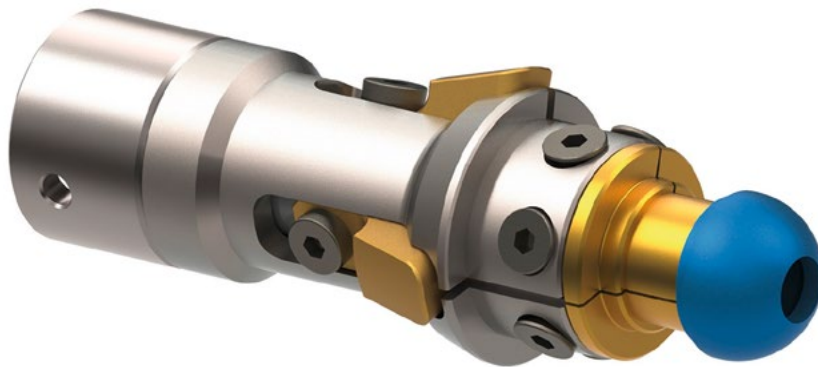
F-TYPE PUSH COLLETS

FOR INTERNAL CLAMPING APPLICATION



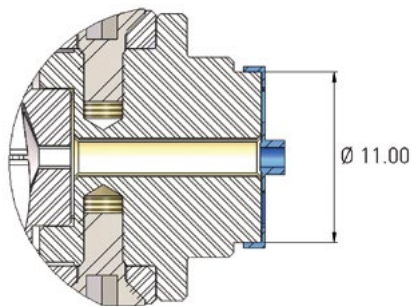
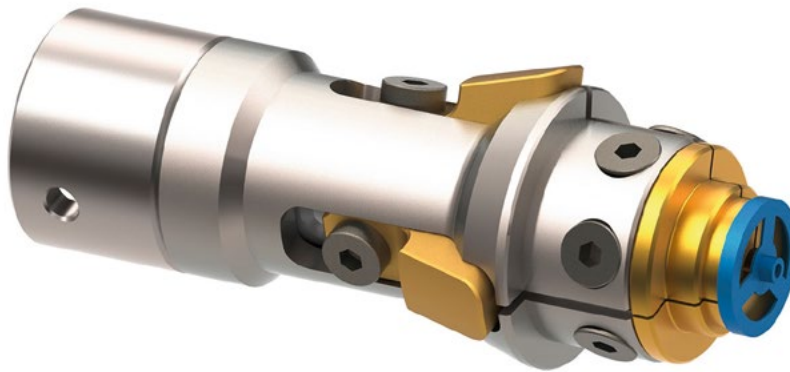
WIFEX™ – APPLICATION CASE 1

- ▶ CLAMPING ON A THIN FLANGE FOR TURNING A SPHERE AND REAMING



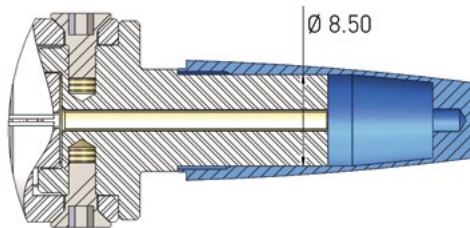
WIFEX™ – APPLICATION CASE 2

- ▶ CLAMPING OF A THIN-WALLED PART FOR FACE TURNING AND FINISHING TURNING



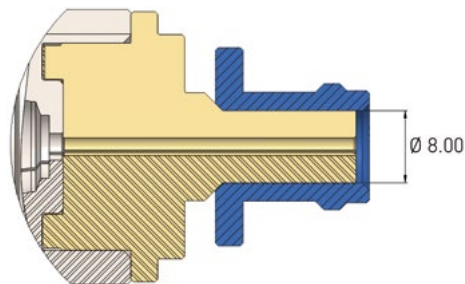
WIFEX™ – APPLICATION CASE 3

- ▶ CLAMPING OF A OFFSET PART FOR FACE TURNING AND LONG FINISHING TURNING



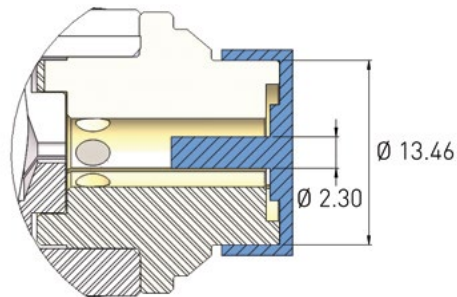
WIFEX™ – APPLICATION CASE 4

- ▶ CLAMPING OVER THE ENTIRE LENGTH OF A PART WITH A THIN FLANGE FOR FACE TURNING AND REAMING THE INTERNAL CHAMFER WITH GEOMETRIC TOLERANCE



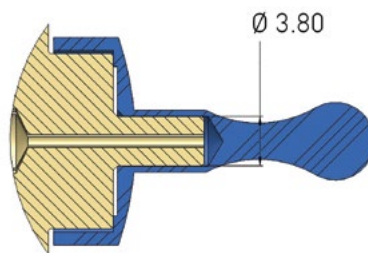
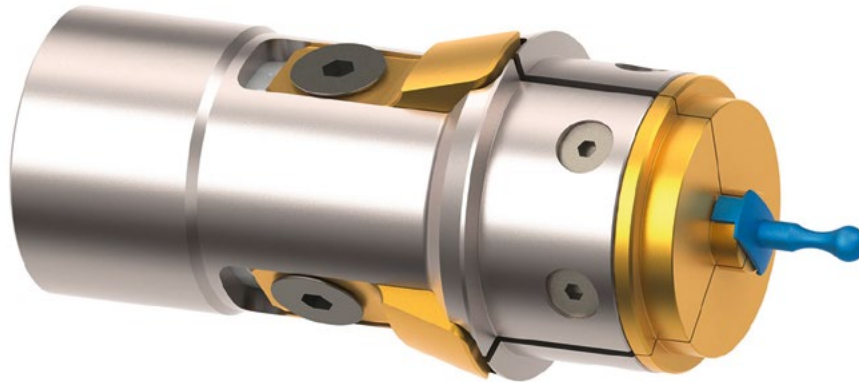
WIFEX™ – APPLICATION CASE 5

- ▶ CLAMPING OF A PART WITH INTERNAL SHAPES FOR FACE TURNING OF A LARGE SURFACE



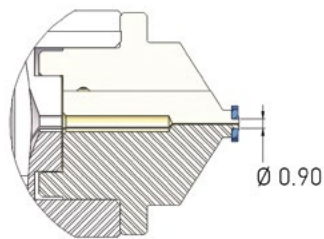
WIFEX™ – APPLICATION CASE 6

- ▶ CLAMPING AND GUIDING ON 2 DIFFERENT DIAMETERS FOR EXTERNAL TURNING



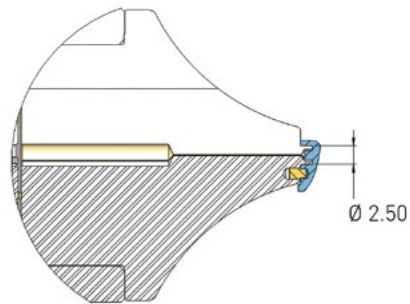
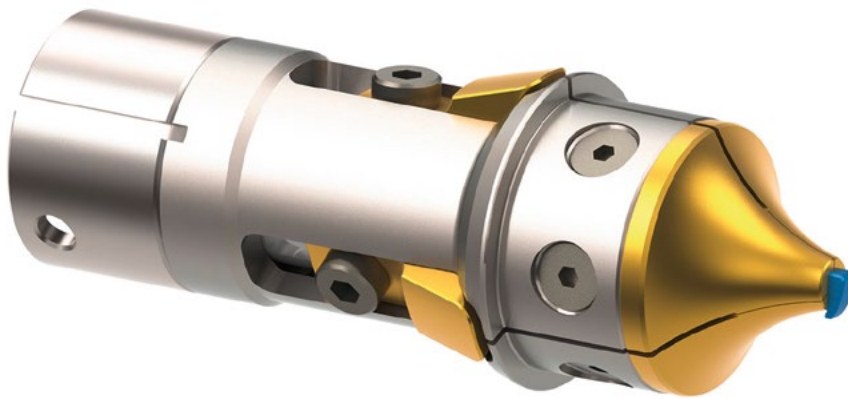
WIFEX™ – APPLICATION CASE 7

- ▶ CLAMPING A DIAMETER LESS THAN 0.04 INCH FOR FACE TURNING OF A FEW THOUSANDTHS OF AN INCH



WIFEX™ – APPLICATION CASE 8

- ▶ CLAMPING WITH POSITION GUIDE OF A SHAPED PART FOR NON-CYLINDRICAL FACE TURNING



WIFORCE™ – APPLICATION CASE 1

► FULL WIDTH CLAMPING FOR END MILLING OF A HEXAGON

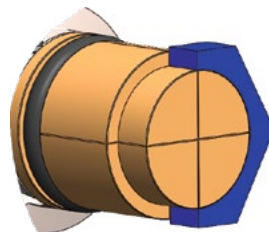
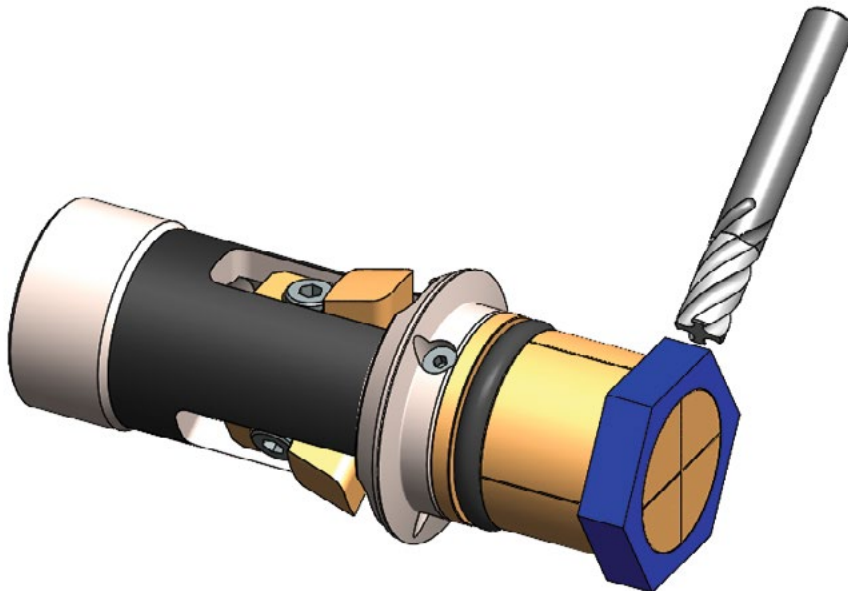
| Material: 1.4034 (martensitic stainless steel X46Cr13)

| End mill $\varnothing 10$ z4

| Depth of cut (**Ap**): 4mm
Width of cut (**Ae**): 5mm

| Cutting speed (**Vc**): 80m/min
Feed per tooth (**Fz**): 0.03mm

| Spindle speed (**S**): 2500 tr/min
Feed (**F**): 300 mm/min



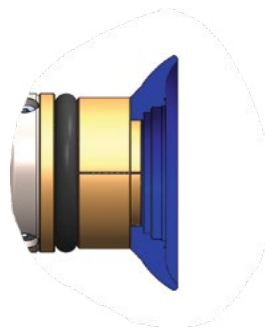
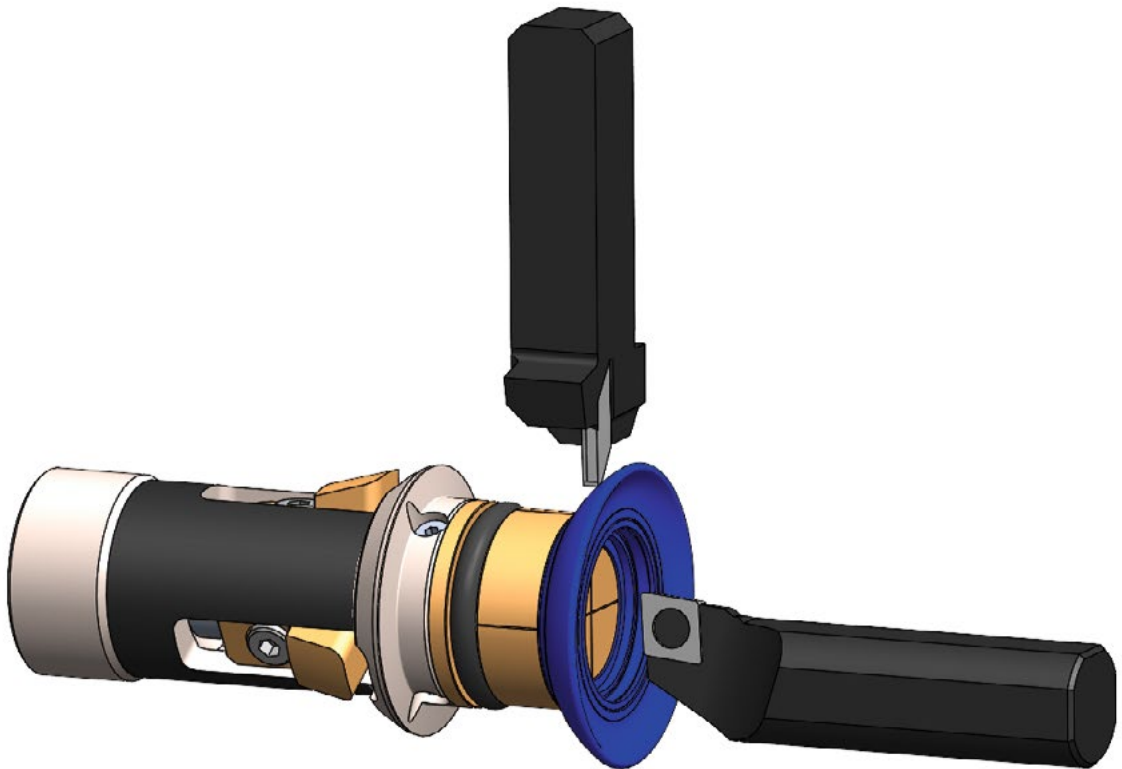
WIFORCE™ – APPLICATION CASE 2

▶ SIMULTANEOUS ROUGH TURNING OF THE EXTERIOR REAR PROFILE AND INTERIOR OF A WATCH CASE

| Material: 316L

| Cutting speed (**V_c**): 80m/min
Feed per revolution (**F**): 0.15mm/rev

| Width of cut (Exterior): 2mm
Depth of cut (Interior): 1mm



WIFORCE™ – APPLICATION CASE 3

- ▶ ROUGH MILLING OF THE EXTERIOR OF A WATCH CASE.
MACHINING OF THE PROFILE OVER THE ENTIRE HEIGHT OF THE CASE.

| Material: 316L

| Roughing End Mill $\varnothing 8$ z4

| Cutting speed (**Vc**): 100m/min
Feed per tooth (**Fz**): 0.05

| Spindle speed (**S**): 3980rpm
Feed (**F**): 800mm/min

