Important information

Guidelines for process parameters

System	Material	Workpiece Ø	Speed n [rpm]	Feed rate, radial f [mm/U]	Impression depth (PT) a_p value [mm]*
Revolving	up to max. R_m = 1000 N/mm²	Any	200	0.08	r = 0.075 Ø = 0.15
Spring-return	up to max. R_m = 1000 N/mm²	Any	200 Unwinding via C-axis is possible	f = d x π (d = workpiece diameter) High speed (possible with restrictions)	r = 0.075 Ø = 0.15

The values provided here are recommendations (base values) and must be optimised for the application.

* The impression depth must always be greater than the concentricity (Ø 0.03 mm).

The embossing quality and the wear of the marking rolls/segments is dependent on:

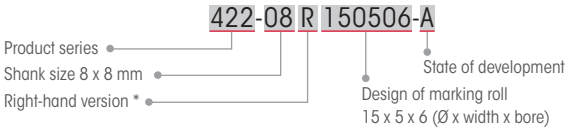
- the combination of workpiece diameter and speed
- the feed rate
- the material
- and the application (e.g. clamping set-up – single- or double-sided)

Surfaces for marking must be clean (free of surface contaminants) to ensure optimal driving of the segments and the marking roll. When marking in axial direction – spindle stop (speed = 0), feed rate in axial direction = feed rate in radial direction.

Spring-return system – start-up when stopped

1. Spindle at standstill
2. Infeed of tool to desired impression depth
3. Run spindle slowly
4. Return of tool

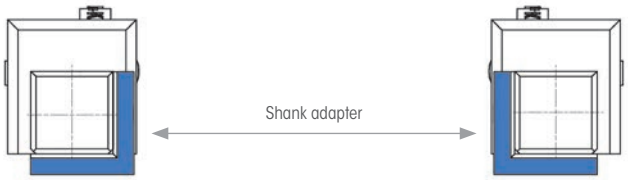
Explanation of tool holder designation



* L = l/h design
M = modular design

Explanation of marking roll designation

Shank adapter



With the modular tool sets 421 and 431 the adapter is used to change the shank size asymmetrically.