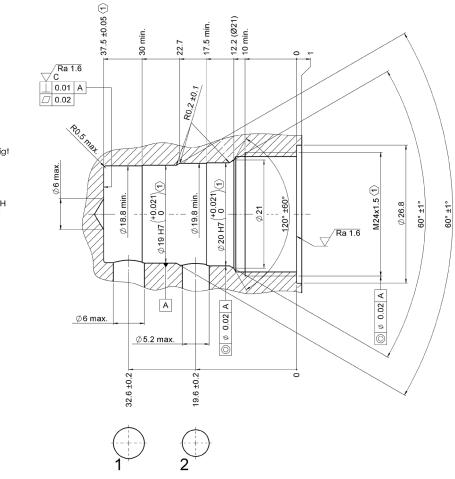


Manufacturing Process and tools

WS700 cavities

2/2 - way cavity

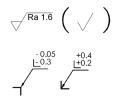
- 1. Drill max. ø18.5 for pre-drilling up to and including calotte ø6 max
- 2. A solid carbide step drill part no. 4652624*. For the floor, ø18.8 with 60° bevels up to ø19.8
- A solid carbide step milling cutter for circular milling part no. 4652679**.
 For the 60° bevel from ø20H7 to ø21, thread core hole with chamfer and ø26.8
- 4. Thread milling cutter 1.5 mm , manufactured in the same clamping as point 2. (stepdrill)
- 5. Standard reamers or a standard end mill for circular milling for ø19H7 and ø20H7
- 6. Deburring



 $\langle 1 \rangle$ In gleicher Aufspannung gefertigt Machined in one clamping

Tolerierung ISO 8015 Tolerancing ISO 8015

Allgemeintoleranzen ISO 2768-mH General tolerances ISO 2768-mH



* Gühring-No.: 37701336

** Gühring-No.: 37701334

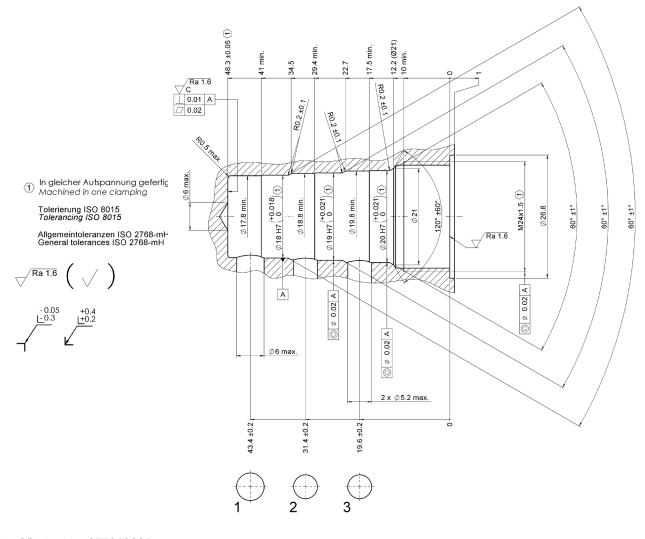
Bieri disclaims any liability in case of incorrectly manufactured cavity.



Manufacturing Process and tools

3/2 - way cavity

- 1. Drill max. ø17.5 for pre-drilling up to and including calotte ø6 max.
- 2. A solid carbide step drill part no. 4652678*. For the floor, ø17.8, ø18.8 with 60° slopes up to ø19.8
- 3. A solid carbide step milling cutter for circular milling part no. 4652679**. For the 60° bevel from ø20H7 to ø21, thread core hole with chamfer and ø26.8
- 4. Thread milling cutter 1.5 mm , manufactured in the same clamping as point 2. (stepdrill)
- 5. Standard reamers or a standard end mill for circular milling for ø18 H7, ø19H7 and ø20H7
- 6. Deburring



* Gühring-No.: 377010335

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