

Application Instructions

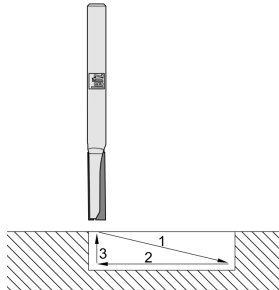


Diamaster Shank Cutters for FixChip Connections

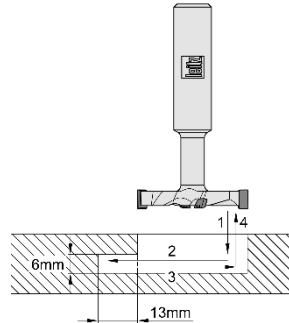
These Diamaster shank cutters are specially designed for milling vertical and horizontal mounting grooves for FixChip connectors on CNC machining centres.



FixChip connector



End mill ID. 191131
Rotational speed 18.000 min⁻¹
Drilling Feed rate -/-
Milling Feed rate 3 – 6 m/min



Profile router ID 191130
Rotational speed 18.000 min⁻¹
Drilling Feed rate 1,5 - 2 m/min
Milling Feed rate 3 - 4 m/min

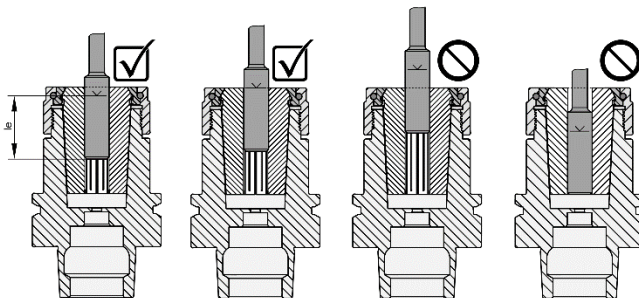
To ensure a precise fit for the FixChip connectors, chucks with a high runout accuracy of $\leq 0,05$ mm are required.

Recommended clamping chucks:

- Leitz NiRo collet chuck for collets with a taper angle of $2^{\circ}52'$ according to ISO 10897, form B → ID 679043
- Leitz ThermoGrip shrink-fit chuck → ID 037712 and ID 037713

Important notes for good processing results:

- The required minimum clamping length l_e must not be exceeded.



- Clamping surfaces must be dry and free from grease and contamination.
- Collets are wear parts and must be checked regularly for damage. Replace damaged collets.
- The cutters are not designed for re-sharpening. Re-sharpening will cause loss of fitting accuracy for the FixChip connector.
- Stable workpiece clamping is necessary to ensure precise milling quality.