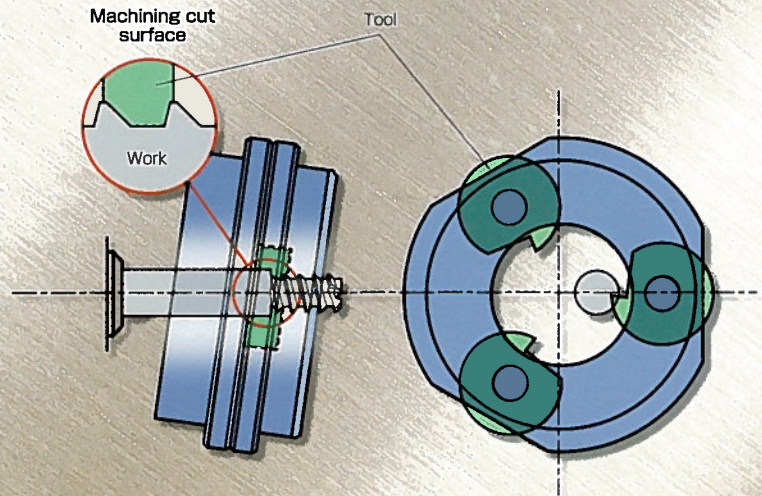
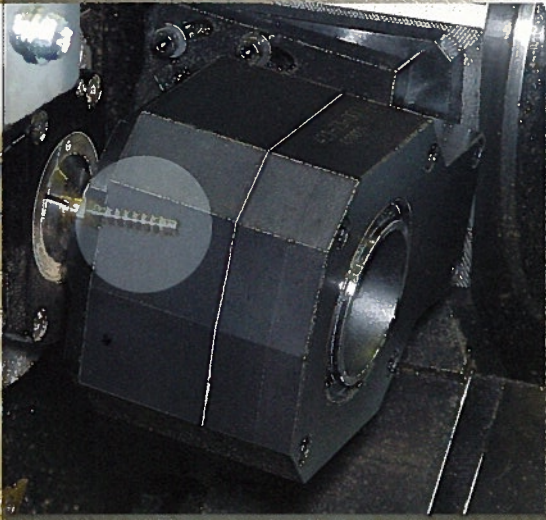


Thread Whirling Unit



Available to Star swiss type automatic lathes - models SV-12/20, SR-16/20R, ECAS-12/20.

An innovative and highly efficient machining technique developed for the production of high precision threads, irrespective of thread length or pitch.



Thread Whirling Features

- Is a process involving the whirling head containing the cutting tools rotating around the bar stock to cut an external thread. During the whirling process, the rotating whirling head is fed in the Z-axis at high speed whilst the bar stock is rotating at slow speed via 'C' axis control.
- When using traditional thread cutting techniques, the Z-axis feed has to match the required thread pitch for each revolution of the bar stock.
- For thread whirling, however, the speed and feed settings can be more freely selected to suit the ideal cutting conditions.
- Thread generation, including full deburr is created in one pass.
- Precision, surface finish and long term quality are achieved because the cutting action takes place close to the guide bush for maximum rigidity. The speed of rotation ensures high surface finish.
- Tooling costs are minimised as the load is shared by a number of tools that only have to be reground on the upper plane only.

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