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New chip former for copper-zinc alloys without lead

Dieterle's DAK parting off system has been extended by new chip formers specifically for copper-zinc alloys without lead.

Copper-zinc alloys or brass are used in a wide variety of applications and are available in different compositions. Copper-zinc alloys without lead have significantly poorer machining properties compared to lead-containing alloys. In addition to increased tool wear, the formation of long winding chips is particularly problematic. By legal requirements due to the harmful effects on the environment and health the use of lead has increasingly to be dispensed.



New DAK-..B chip former for copper-zinc alloys without lead

In order to meet the challenges of lead-free machining, Dieterle has developed the new cutting insert geometry DAK-..B which ensures optimum chip breaking when cutting off copper-zinc alloys without lead and thus increases productivity. Initial tests at selected customers have achieved significantly better results than the previously used cutting off inserts and scored well in terms of tool life, surface quality and process reliability.

The new DAK-..B chip formers for copper-zinc alloys without lead are based on Dieterle's proven DAK parting off system. Suitable tool holders are available both as classic parting off system in one piece with clamping screw as well as with exchangeable clamps and supporting plates. Precise guiding of the insert is guaranteed by the clamping via double prism V-forms.



Chips without DAK-..B above and with DAK-..B below

The new DAK-..B chip formers are available in neutral and right-hand executions as well as in grooving widths of 1.6 and 2.4 mm and are provided with radius R0.1 on both sides. A coating with a smooth layer surface as well as a high degree of hardness have been designed accordingly in order to be able to achieve optimum results in the machining of copper-zinc alloys without lead.



DAK-..B in DIE Halter mit austauschbaren Klemmen und Stützplatten



Contact:

Otto Dieterle Spezialwerkzeuge GmbH
Predigerstr. 56
78628 Rottweil
Tel.: +49 (0) 741 94205 0
info@dieterle-tools.com
www.dieterle-tools.com



Company portrait Otto Dieterle Spezialwerkzeuge GmbH:

Otto Dieterle Spezialwerkzeuge GmbH manufactures high-precision turning, drilling, milling and broaching tools and has been a respected partner for companies in precision engineering, medical technology and the automotive supply industry for 60 years.

The company was founded in 1962 by Otto Dieterle at Rottweil, Germany. Over the years, extensive investments have been made in machinery and testing equipment, and numerous tool developments have been created in close cooperation with customers. Today, customers of Dieterle can obtain their tooling demands almost completely from a single source.

In 2013, the company moved into a new, modern administration building. The current managing directors are the sons of the senior owner, Michael and Stefan Dieterle, and daughter Petra Dieterle-Müller, with a team of over 60 employees. As a traditional family business with Swabian roots, Dieterle attaches particular importance to customer proximity, reliability and short delivery times.