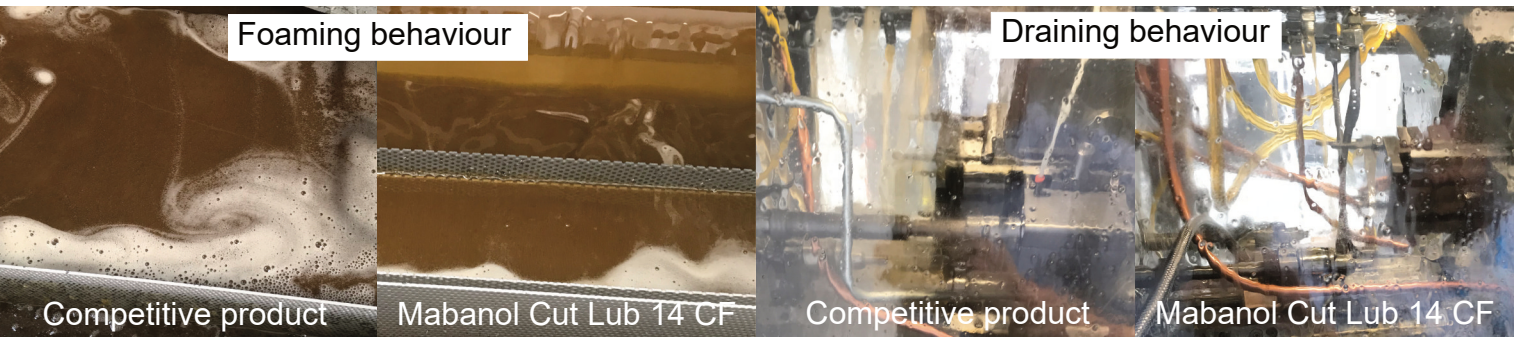
Mabanol Cut Lub 14 CF extends tool life by up to 33%.*



Manufacturer of connection elements | Bielefeld

Initial situation

Processes such as turning and thread cutting of high-alloy steels (70%) and non-ferrous metals (30%) are performed at 20 long-turning machines from DMG and Index. The stainless steel is machined with a 7% additive cutting oil of ISO VG 17, and the non-ferrous metals with a 2% additive cutting oil of ISO VG 25.

The stated target is to extend tool life and reduce setup times.

Recommendation

For stainless steel machining, the use of the high-performance cutting oil Mabanol Cut Lub 14 CF with a maximum additive content of 20% is recommended to improve cutting performance and thus reduce setup times. Furthermore, the use of a lower viscosity aims to improve flushing capacity and reduce cutting oil consumption.

By using Mabanol Cut Lub 22 for non-ferrous metal machining, the top-up amount should also be reduced.

Advantage

According to tool life monitoring, the use of Mabanol Cut Lub 14 CF in stainless steel machining achieves an extension of tool life by 30-33%. This not only saves tool costs but also significantly reduces setup times. The improved flushing behaviour reduces the top-up amount by 15%. Additionally, lower foaming can be observed. The lower residual moisture of the chips after centrifuging demonstrably reduces disposal costs. Hence, these savings contribute to an enhanced productivity throughout the manufacturing process.

Up to

33%

*extended tool life**

*This performance proof is based on the experiences of a single customer. The actual results achieved can depend on the type of machine used and its maintenance, operating and environmental conditions as well as the previously used lubricant.

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