



# *CV JOINT application*



# Machining: Cv-joint Cage

## ✓ Workpiece

Component : Cv-joint cage

Material : Cf53

Hardness : hrc 60

Surface : Finish Ra0.8

## ✓ Conditions

Operation : I.D turning

Grade : PCBN EBC290

Tool spec : TNGA160412

Rpm : 865

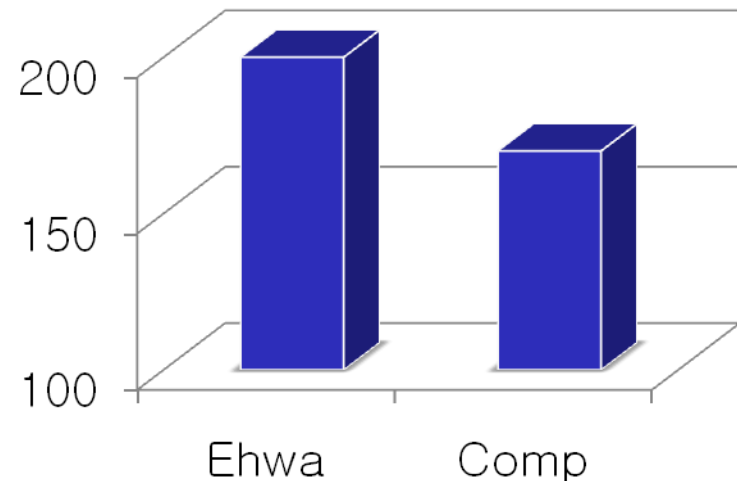
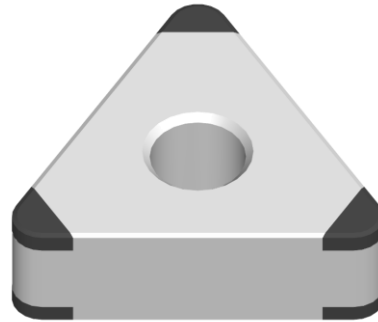
Feed rate : 0.09 mm/rev

D.O.C : 0.13 mm

Coolant : dry

## ✓ Result

200pcs/edge





# Machining: Cv-joint Cage

## ✓ *Workpiece*

Component : Cv-joint cage

Material : Cf53

Hardness : hrc 60

Surface : Finish Ra0.8

## ✓ *Conditions*

Operation : O.D turning

Grade : PCBN EBC290

Tool spec : TNGA160420

Rpm : 579

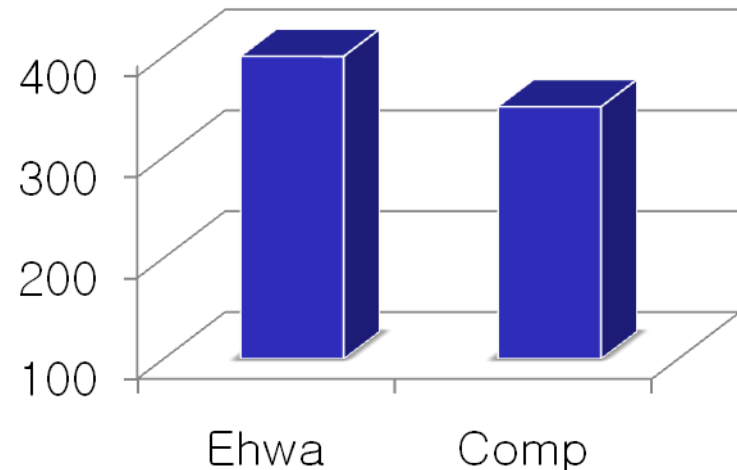
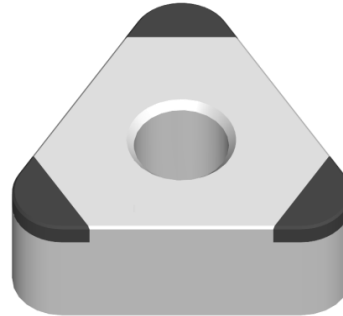
Feed rate : 0.12 mm/rev

D.O.C : 0.13 mm

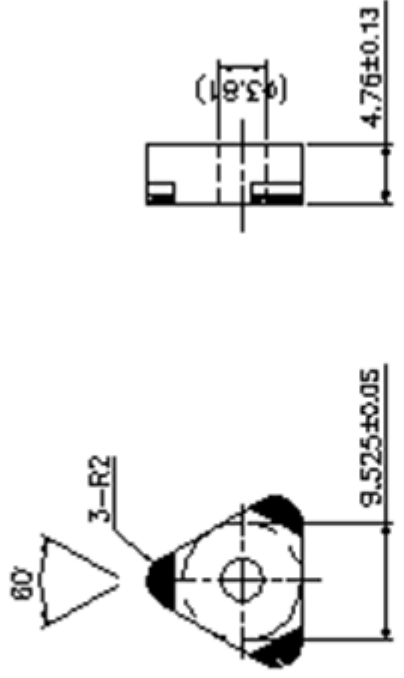
Coolant : dry

## ✓ *Result*

400pcs/edge




5020013065



MARKING사항

NOTE)  
 1. Chamfer: 45°x0.05  
 2. Coating

△	CUSTOMER	ITEM	PCBN - INSERT
△	SIZE 3C-TNGA160420T45005	ITEM No.	
△	DATE 2011.11.07	SY: NATIONAL DIPPS	PROJ: DRG NO. B022673W
△	SCALE 2:1	K10	mm
△	DESIGN	CHECKED	APPROVED
△	 EHWA DIAMOND INDUSTRIAL CO., LTD.		
REVISIONS			

# Machining: Cv-joint Cage

## ✓ *Workpiece*

Component : Cv-joint cage

Material : Cf53

Hardness : hrc 60

Surface : Finish Ra 2.0

## ✓ *Conditions*

Operation : Window milling

Grade : PCBN EBC290

Tool spec : CCGW060208

Rpm : 350

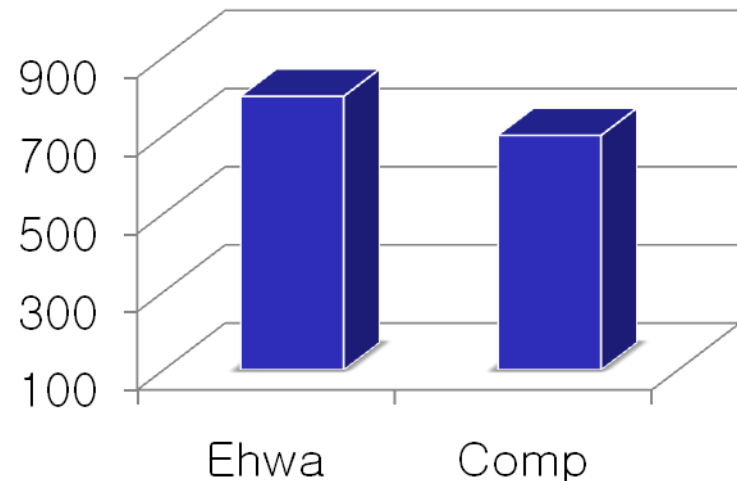
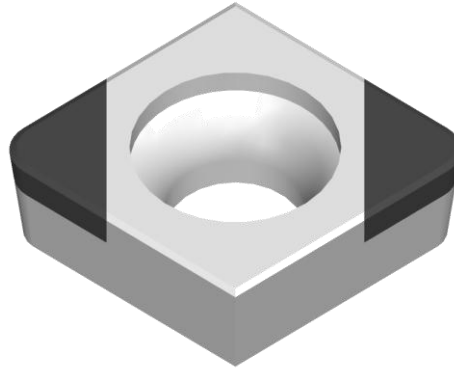
Feed rate : 0.42 mm/rev

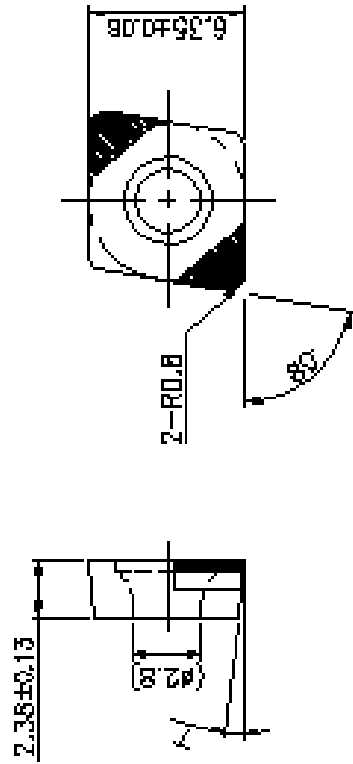
D.O.C : 0.15 mm

Coolant : dry


## ✓ *Result*

800pcs/edge





NOTE)  
 1. Chamfer: 25°x0.12+Honing

△	CUSTOMER	ITEM	PCBN-INSERT
△	SIZE	2MT-CCGN060208S25012	ITEM No
△	DATE	SCALE	TOLERANCE
△	2011.11.11	4:1	MATERIAL
△	DESIGN	CHECKED	APPROVED
△			DRW No. 3rd 8022698N
<b>EHWA®</b> EHWAD DIAMOND INDUSTRIAL CO.,LTD.			
REVISIONS			

# Machining: Cv-joint Outer race

## ✓ Workpiece

Component : Outer race

Material : Cf53

Hardness : hrc 60

Surface : Finish Ra0.8

## ✓ Conditions

Operation : I.D turning

Grade : PCBN EBC290

Tool spec : TNGA160412

Rpm : 800

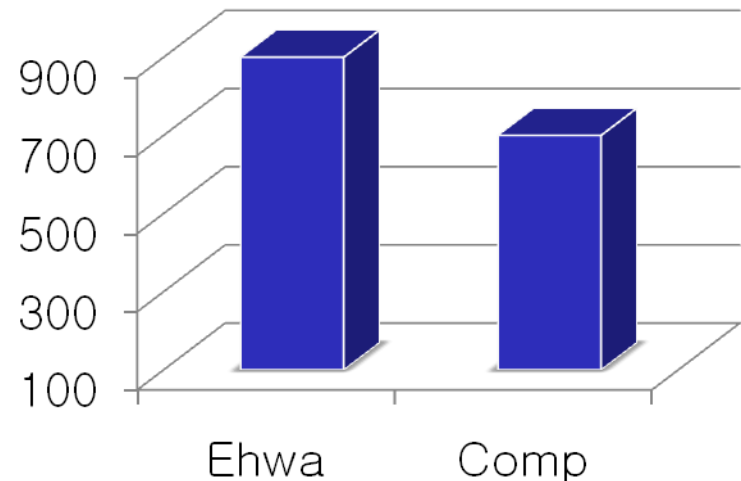
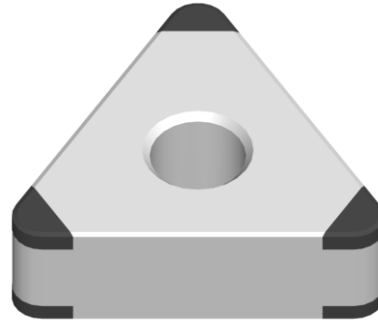
Feed rate : 0.15 mm/rev

D.O.C : mm

Coolant : dry

## ✓ Result

900pcs/edge







# Machining: Cv-joint Inner race

## ✓ *Workpiece*

Component : Inner race

Material : Cf53

Hardness : hrc60

Surface :

## ✓ *Conditions*

Operation : O.D turning

Grade : EB290

Tool spec : TNGA160420

Rpm : 820

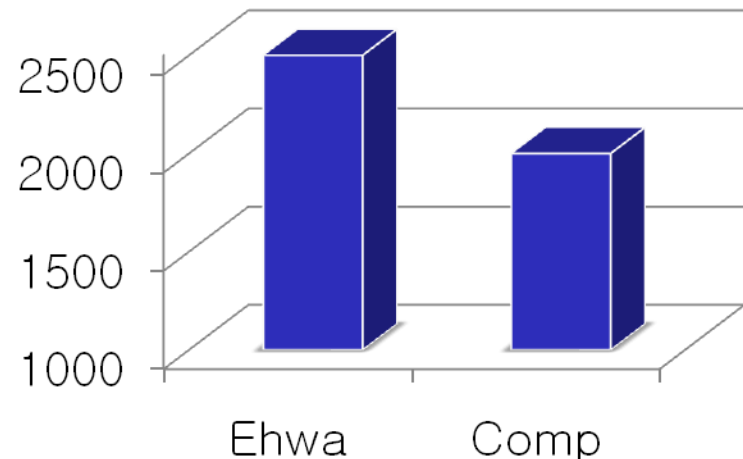
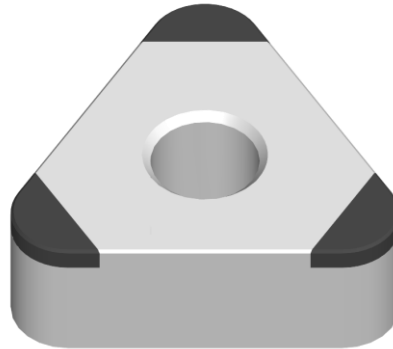
Feed rate : 0.13mm/rev

D.O.C :       mm

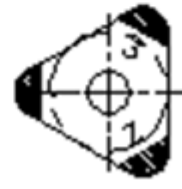
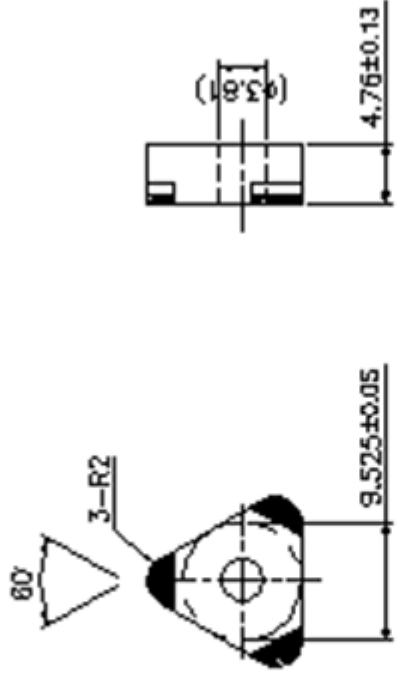
Coolant : dry

## ✓ *Result*

2500pcs/edge




5020013065



MARKING사항

NOTE)  
 1. Chamfer: 45°x0.05  
 2. Coating

△	CUSTOMER	ITEM	PCBN - INSERT
△	SIZE 3C-TNGA160420T45005	ITEM No.	
△	DATE 2011.11.07	SY: NATIONAL DIPPS	PROJ. DRW. NO. B022673W
△	SCALE 2:1	K10	mm
△	DESIGN	CHECKED	APPROVED
△	 EHWA DIAMOND INDUSTRIAL CO., LTD.		
REVISIONS			

# Machining: Cv-joint Trunnion

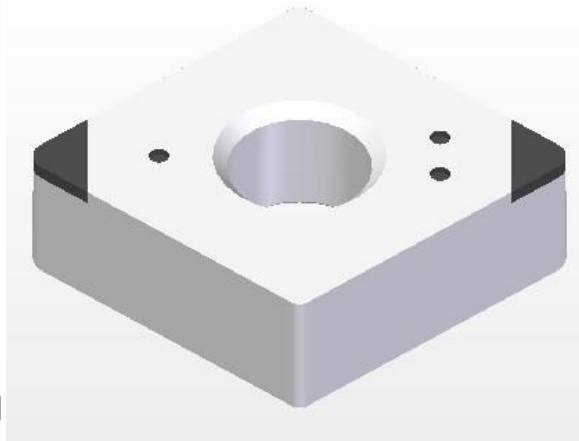
## ✓ Workpiece

Component : trunnion

Material : Cf53

Hardness : hrc 60

Surface : Finish Ra0.7



## ✓ Conditions

Operation : O.D turning

Grade : EB28x

Tool spec : CNGA120408

Rpm : 200

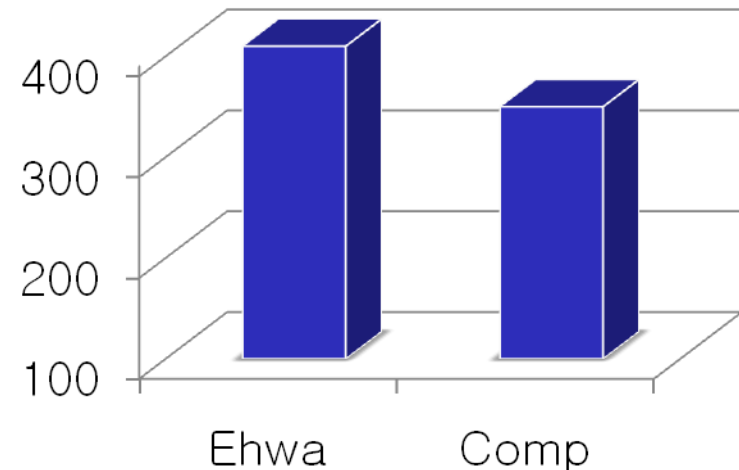
Feed rate :

D.O.C : 0.15mm

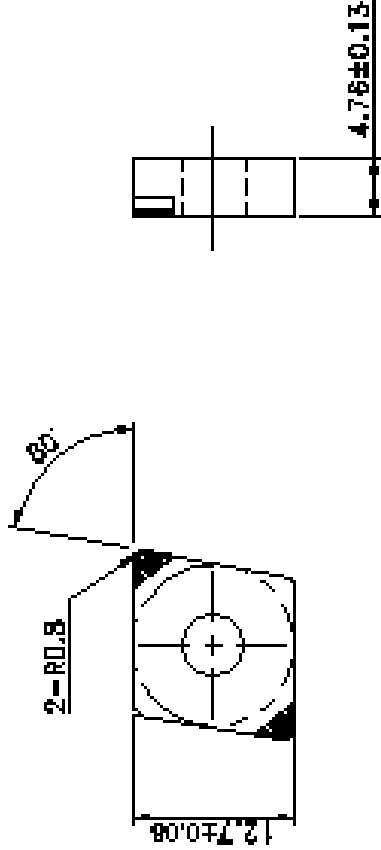
Coolant : dry

## ✓ Result


400pcs/edge



5020012927



NOTE)  
1. Chamfer: 25°x0.15+브러쉬호닝

△	CUSTOMER		ITEM	PCBN-INSERT
△	SIZE	2MT-CNGA120408525015	ITEM No.	
△	DATE	2011.05.19	MATERIAL	DWG No.
△	DESIGN	2:1	K10	3rd
△			PROJ	BDZ19Z4W
△			CHECKED	APPROVED
△			 EHWA DIAMOND INDUSTRIAL CO.,LTD.	
REVISIONS				

# Machining: Cv-joint Trunnion

## ✓ *Workpiece*

Component : trunnion

Material : Cf53

Hardness : hrc 60

Surface : Finish Ra0.1

## ✓ *Conditions*

Operation : O.D Grooving

Grade : EB29X

Tool spec : DNGA1104 1.35W

Rpm : 1500

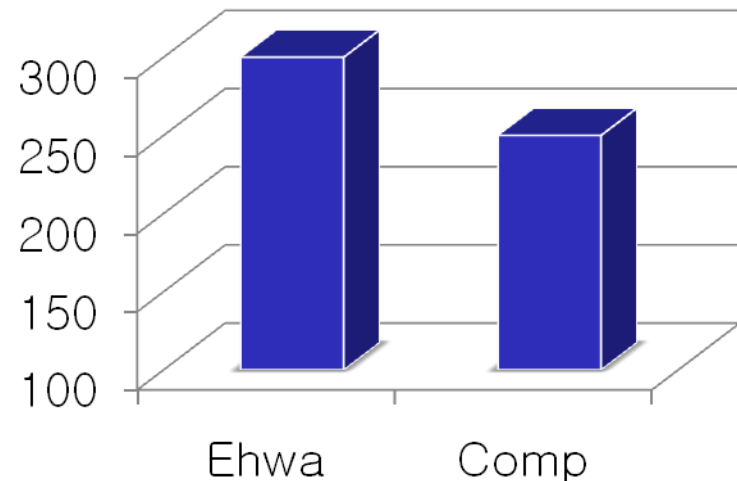
Feed rate : 0.25mm

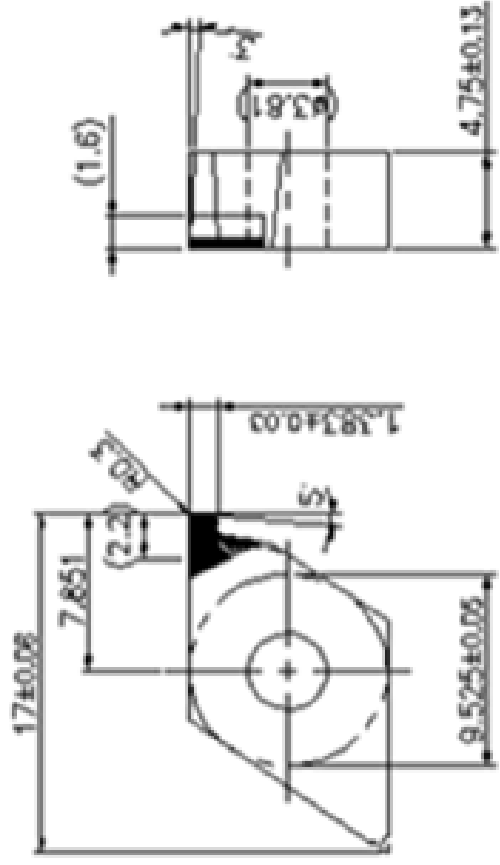
D.O.C : mm

Coolant : dry



## ✓ *Result*

300 pcs/edge





1. Chamfer: 20°x0.12

△	CUSTOMER		ITEM	PCBN-GX
△	SIZE	DNGA1104-1.38W-0.3R	ITEM No.	
△	DATE	2011.11.11	TOLERANCE FOR MANUFACTURER'S	PROJ. DRG No.
△	SCALE	2:1	mm	◆ B0722699W
△	DESIGN	CHECKED	APPROVED	
△				
REVISIONS				