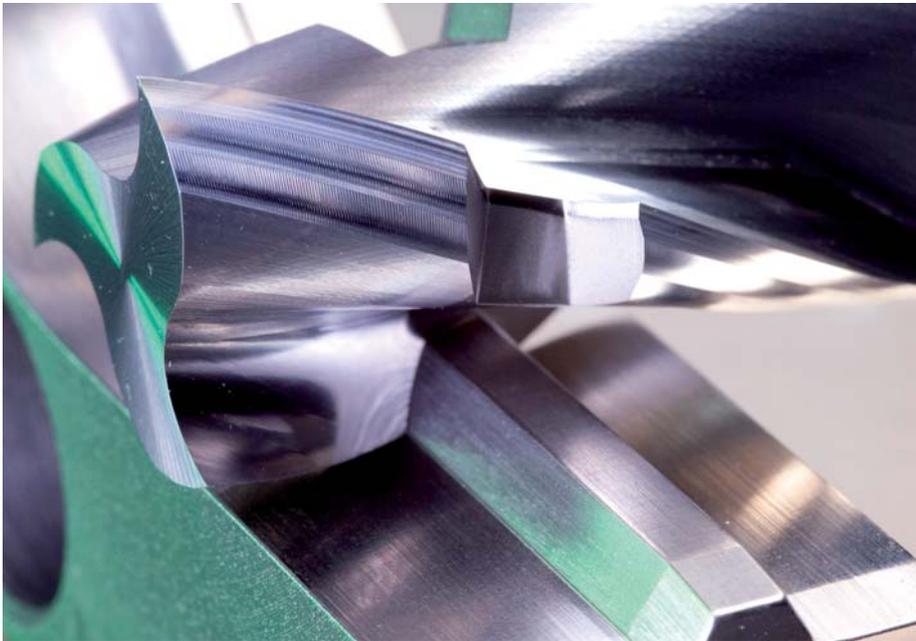


Complex contours with solid carbide form cutters

In today's machine building industry, as well as in the automotive and its supplying industry, demand has been rising that the components produced and their geometry become more and more complex. To be able to produce effectively with the highest precision, the alternative is often a form cutting tool adapted especially to the very manufacturing phase. This ALMÜ Insider shows you such a tool solution.



The horseshoe-shaped workpiece to be produced is a holding fixture for a HSK-50 tool changer. The demand for large numbers of units, as well as the machining process, make using this form cutter an ideal solution. As the first step of the process, roughing is done with a standard tool, whereas the further milling is carried out by a form cutter in one go. Using such multiple form end cutters usually reduces former processing times by up to fifty percent. Instead of working on two machining stations, a single one is enough. You can work on various materials, such as grey cast iron, as well as lots of kinds of tempered steel and aluminum alloys. The cutter's material is a special K40 solid carbide with a flexural strength of 4300 N/mm², at a hardness

of 1600 HV30. The cutters are even capable of working on hardened or tempered steel at reasonable cost. ALMÜ offers its customers a "comprehensive no-hassle package": as you plan, order, and use your form cutters, we take care of configuring the chipping parameters required by your individual CNC machining center. If you need more essential information, we can provide you with the milling data and the cutting speed and feed, your machining strategy, as well as your programming in ISO code. Many of our customers love our special regrinding service, helpful due to the complex geometry of these form cutters: it means that the tools are resharpener using the original programs, to ensure the highest profile accuracy.

Facts:

Material: 42 CrMo 4

S = 1200

Vc = 75 m/min

F = 80 mm/min

Fz = 0,025 mm





The great demand, as well as the interesting developments in the world of milling, have made ALMÜ create the most various versions of this kind of tool. The form cutters are offered in both disk and spindle versions.

Günter Frank: enjoy your well-earned retirement after twenty years at ALMÜ! A little portrait.

"Have you seen Herr Frank?" You could hear questions like this one time and again over the past weeks and months – no matter if on the phone or when talking to people at ALMÜ. After twenty years of loyal service, Günter Frank has enjoyed his well-earned retirement since December 31, 2010

Insider: Herr Frank, how long had you actually been with ALMÜ?

Günter Frank: I joined ALMÜ on April 1, 1990, and have stayed with this great company for more than twenty years.

Insider: And what was your job at ALMÜ? Which were your responsibilities?

Günter Frank: Initially, I worked for the construction department as its technical manager. Over the years, I began taking care of entire projects of our customers. We always worked together as a strong team. That has always been important for me. Only together, we were able to manage the multitude of tasks.

Insider: That leads us to the next question. What were the things you enjoyed most during your job?

Günter Frank: For me as a technician, developing tools was always very fascinating to me. Organizing and carrying out our customers' orders and projects was exactly the job for me. Working with the colleagues, the customers, and, of course, with the Müller family was always what I enjoyed most. I've really never been a paper pusher, but I enjoyed keeping in touch with everybody.

Insider: Yes, let's talk developments: what had actually changed over the past twenty years at ALMÜ?

Günter Frank: When I joined the company, the world of construction was still

a big drawing board. We kept drawing and designing. And there were many files. In these files, we kept everything on paper. We typed our offers on an electric typewriter. At that time, phone and fax were our means of communication. When the PCs and CAD were introduced at ALMÜ in 1992, that meant a real revolution at the construction tables – everything changed very fast. And it made our everyday work easier. In the end, we had linked everything to everything else. No matter whether we're talking 3D constructions or CAD/CAM: all data had become immediately available, at the PC as well as at the CNC machine. Today, we keep writing each other e-mails, and I've hardly heard the word fax machine lately.

Insider: What was your biggest, most interesting project? Or your greatest challenge?

Günter Frank: The most demanding challenges had always consisted in recognizing those technical developments that have helped our customers create additional benefit by using our tools. There were lots of interesting projects. The ones I remember best were those with Gearbox in Sweden and with Scania in Spain. When we presented them our solutions on the spot, days were exciting. Or with Daimler in Mannheim: I worked with them from 1993 to the day of my retirement. Such kinds of close partnerships were always my greatest joy.

Insider: Twenty years at ALMÜ ... You enjoyed your work a lot, and Herr Müller mentioned your high competence, as well as your attachment to the company. But let's turn to the lighter side ...

Günter Frank: I'd better remain silent on



Günter Frank

fauxpas situations and silly stuff. We always had lots of fun, ALMÜ still has a family atmosphere. I always liked driving the twenty-nine kilometers to Zell and back home. The nice colleagues, my bosses, the Müllers – all of them formed a superb team, a great whole where everyone had joined the spirit. I guess our customers feel that as well. After all, ALMÜ isn't an anonymous big player.

Insider: Now follows your well-earned retirement. Any great plans?

Günter Frank: I soon found out all about my new hobby: beekeeping. I have already completed the first courses, and have started winning honey. But what I enjoy most is that I can decide myself what I do with my time. Now, I can travel to beautiful Lake Constance, as much as and whenever I want. And all that together with my loved ones.

Insider: Let us then wish you all the best and lots of fun. And as for your successor at ALMÜ, Herr Göppinger, lots of success for his professional future.