



U-AXIS SYSTEM KOMtronic

Efficient actuating tool systems for turning contours
with a stationary workpiece for machining centres and special-purpose machines

TEAM CUTTING TOOLS



CUTTING SOLUTIONS BY
CERATIZIT



KOMET



klenk

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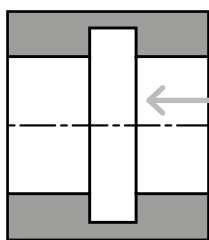
Tooling the Future

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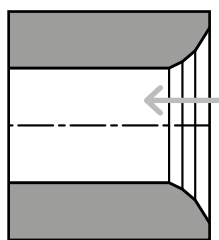
KOMtronic

Efficient U-Axis System
for Machining Centres

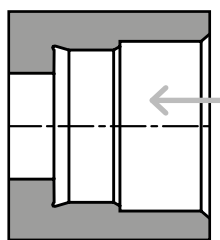
Machining examples



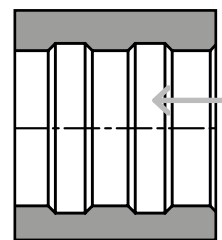
Grooving



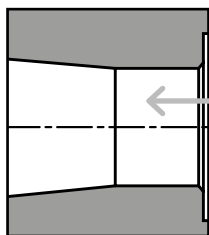
Turning valve seats



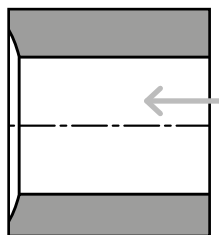
Bearing seat



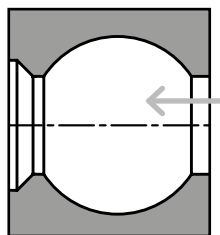
Bore with coolant passages



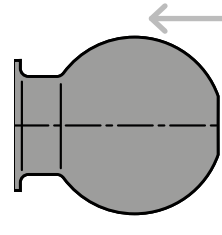
Tie rod



Undercutting differential housing



Internal contour turning



External contour turning



It makes turning contours possible when working with a stationary workpiece

The freely programmable KOMtronic U-axis system make any contour and turning operations possible on non-rotationally symmetrical parts.

Combined with custom-made front tools and the optimum selection of inserts, contours in bores and external machining operations can be successfully carried out. This allows a considerable reduction in production times – with better surface quality and greater accuracy of form.

Higher economy

- ▲ Use of standard instead of special machines
- ▲ Reduction in number of tools
- ▲ No need for clamping devices for finish machining on turning machines

Reduced unit costs

- ▲ Reduction in machining and throughput times
- ▲ Savings on tool changes
- ▲ Replacement of time consuming circular machining operations
- ▲ Reduced holding times
- ▲ High cutting capacity

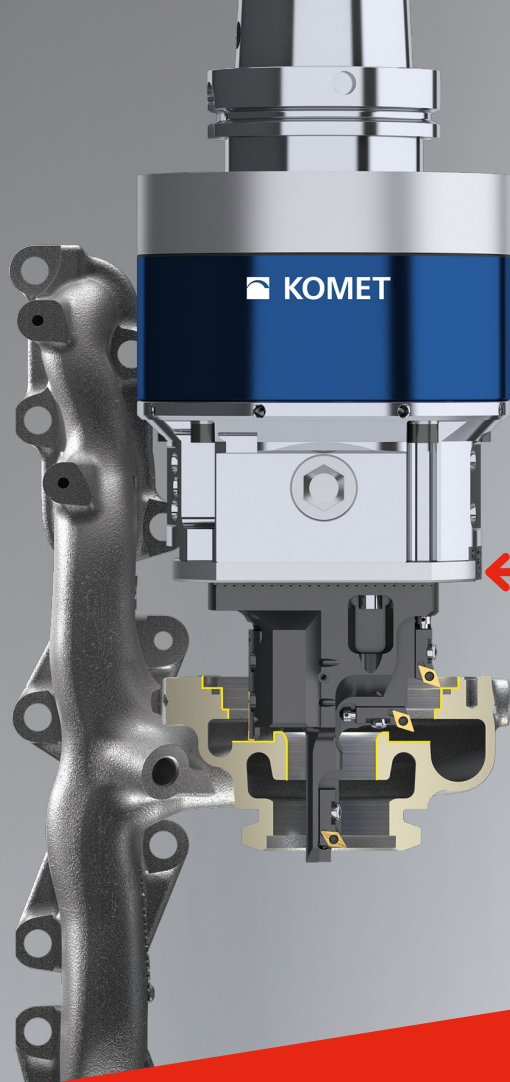
Lower operating costs

- ▲ Complete machining on one machine without the workpiece being rotated
- ▲ Minimum power consumption because of U axis systems

Your Technical Sales Engineer will be happy to answer any further questions or please contact directly

Offer.Actuatingtools@ceratizit.com





Direct path
measurement
system on
the slide



KOMtronic U-Axis system with linear encoder

Advantages Benefits

- ▲ **Direct path measurement system on the slide**
Position detection as close to the tool as possible.
- ▲ **Maximum positioning accuracy**
For precise machining.
- ▲ **Direct coupling of the slide movement**
Mechanical influences such as wear are eliminated.
- ▲ **Consideration of the disturbance variables of mechanical components such as backlash, wear, etc.**
Process-secure machining reduces disturbing influences.
- ▲ **Improvement of the repeatability**
Consistent quality.
- ▲ **Wear monitoring of the mechanical components**
Through double position detection within the U-axis.

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Research project BaZMod 32 – 33



KOMET has successfully led and completed the BaZMod research project with partners from industry and research. The BaZMod research project has resulted in the standardisation proposal of the HSK-i.

KOMlife – Autonomous acquisition of production data accurate to the second 34 – 35

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Tool combinations

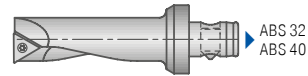
The functionality of the tool combinations depends on the L/D ratio, weight and cutting parameter.

Key

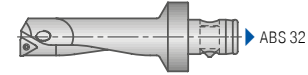
- ▶ ABS connection
- ▶ Cylindrical connection
- ▶ Toothing
- ▶ UniTurn connection

ABS Boring bars

Ø 8 – 28 mm

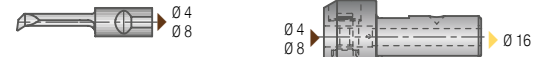


Ø 11,9 – 30 mm



UniTurn Copying tool / Boring tool / Adaptor

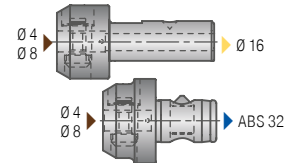
Ø 3 – 8 mm



Ø 3 – 8 mm



Ø 2,7 – 7,5 mm



Boring bars / Adaptor

Ø 5,6 mm / Ø 6,9 mm



Ø 3,0 – 9,0 mm



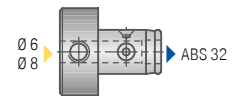
Ø 5,6 – 12 mm



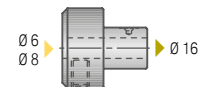
Ø 9 mm / Ø 11 mm



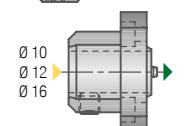
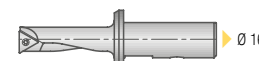
Ø 13 – 17 mm



Ø 6 – 25 mm



Ø 8 – 24 mm

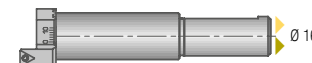


Ø 17 – 26 mm



Serrated body + Insert holder

Ø 25 – 63 mm



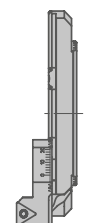
Insert holder

Ø 63 – 93 mm



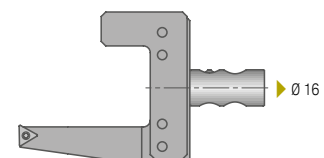
Bridge + Insert holder

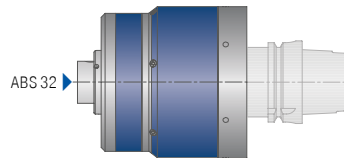
Ø 90 – 365 mm



Mounting bridge for external machining

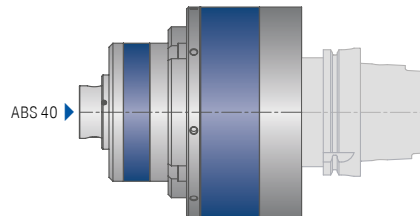
Ø 5 – 70 mm



HPS 115

- ▲ stroke: 2 (± 1) mm
- ▲ max. feed: 80 mm/min
- ▲ max. spindle speed: 6000 rpm

HPS-115-EM-ABS32 → 8

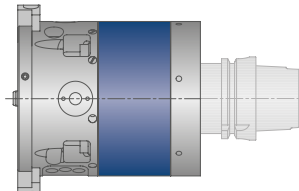
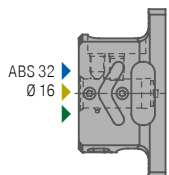
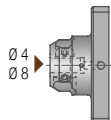
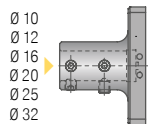
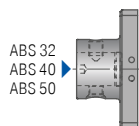
HPS 160

- ▲ stroke: 2 (± 1) mm
- ▲ max. feed: 100 mm/min
- ▲ max. spindle speed: 6000 rpm

HPS-160-EM-ABS40 → 9

Front tools

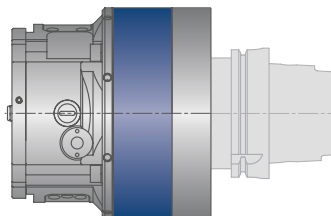
→ 18

**UAS 115**

- ▲ stroke: 22 (± 11) mm
- ▲ max. feed: 300 mm/min
- ▲ max. spindle speed: 4000 rpm

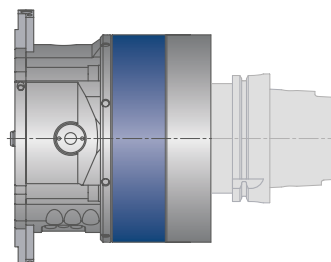
UAS-115-E-G-22-2 / UAS-115-EM-G-22-2 → 10

UAS-115-E90-G-22-2 / UAS-115-EM90-G-22-2 → 11

**UAS 160**

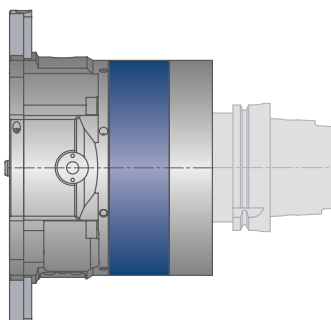
- ▲ stroke: 32 (± 16) mm
- ▲ max. feed: 350 mm/min
- ▲ max. spindle speed: 4000 rpm

UAS-160-EM-G-32-3 → 12



- ▲ stroke: 50 (± 25) mm
- ▲ max. feed: 350 mm/min
- ▲ max. spindle speed: 4000 rpm

UAS-160-EM-G-50-3 → 13

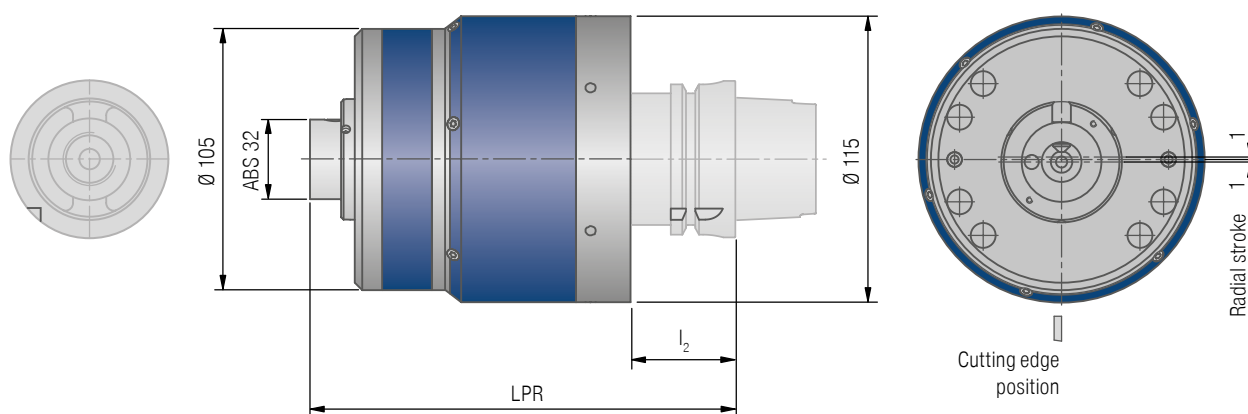


- ▲ stroke: 70 (± 35) mm
- ▲ max. feed: 350 mm/min
- ▲ max. spindle speed: 4000 rpm

UAS-160-EM-G-70-3 → 14

KOMtronic High-Performance-System HPS-115-2

HPS-115-EM-ABS32



Standard interface HSK, other interfaces (page 19) on request.

HPS-115-EM-ABS32 Position sensor direct on slide

Description	KOMET No.	Interface	LPR mm	I ₂ mm	WT kg
HPS-115-HSK63-EM-ABS32-2-2	E32 20012	HSK 63	171	42	6,5
HPS-115-SK40-EM-ABS32-2-2	E32 22012	SK 40	164	35	6,6

Technical data

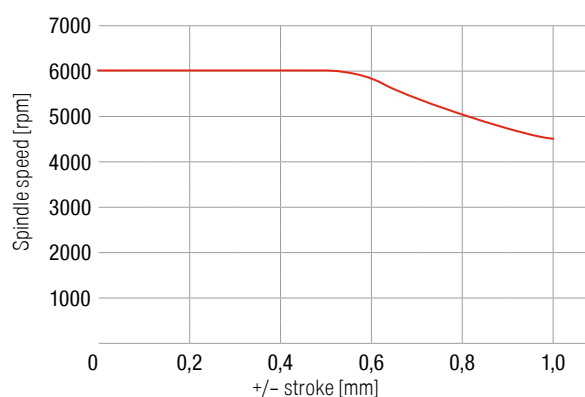
- ▲ stroke: 2 (±1) mm without imbalance correction
- ▲ max. feed: within ± 0,5 mm stroke 80 mm/min above decreasing
- ▲ max. spindle speed: 6000 rpm
- ▲ with internal coolant: 40 bar – MQL possible
- ▲ compact design
- ▲ increased accuracy by position sensor direct at the slide

Protection class: IP67

Operating modes: full NC axis for interpolation

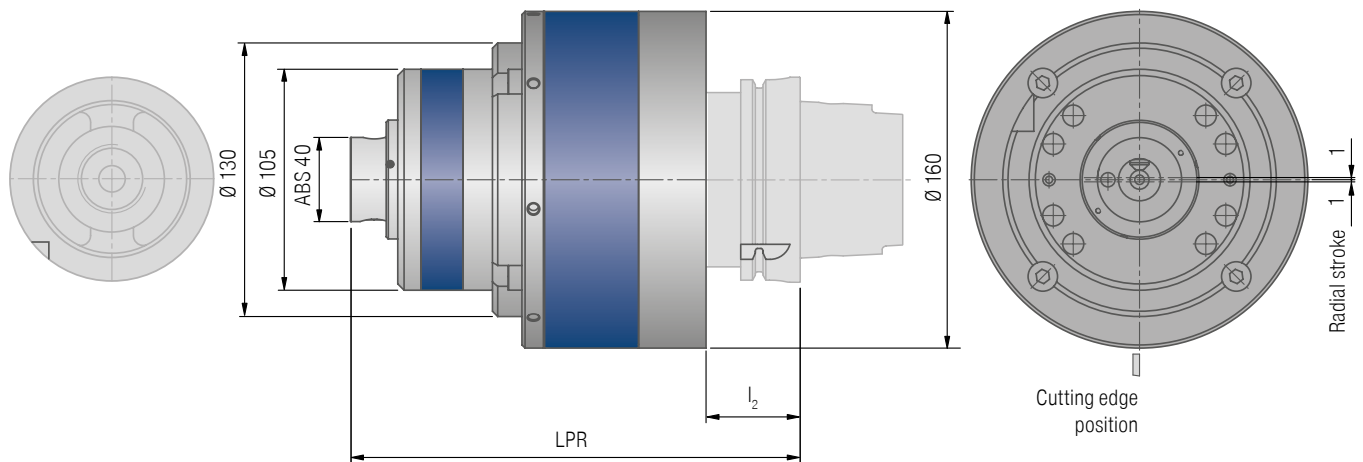
Adaption into machine tool control and spindle: page 16.

Max. stroke/spindle speed diagram
up to 0.6 kg front tool



KOMtronic High-Performance-System HPS-160-3

HPS-160-EM-ABS40



Standard interface HSK, other interfaces (page 19) on request.

HPS-160-EM-ABS40 Position sensor direct on slide

Description	KOMET No.	Interface	LPR mm	l_2 mm	WT kg
HPS-160-HSK100-EM-ABS40-2-3	1E32000100008x	HSK 100	214	45	13,6
HPS-160-SK50-EM-ABS40-2-3	1E32000100010X	SK 50	204	35	14,0
HPS-160-CAT50-EM-ABS40-2-3	1E32000100012X	CAT 50	204	35	14,0
HPS-160-BT50-EM-ABS40-2-3	1E32000100011X	BT 50	222	53	15,1

Technical data

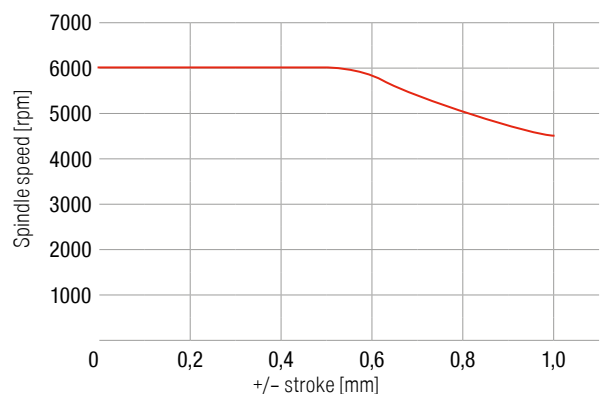
- ▲ stroke: 2 (± 1) mm without imbalance correction
- ▲ max. feed: within $\pm 0,5$ mm stroke 100 mm/min above decreasing
- ▲ max. spindle speed: 6000 rpm
- ▲ with internal coolant: 40 bar – MQL possible
- ▲ compact design
- ▲ increased accuracy by position sensor direct at the slide

Protection class: IP67

Operating modes: full NC axis for interpolation

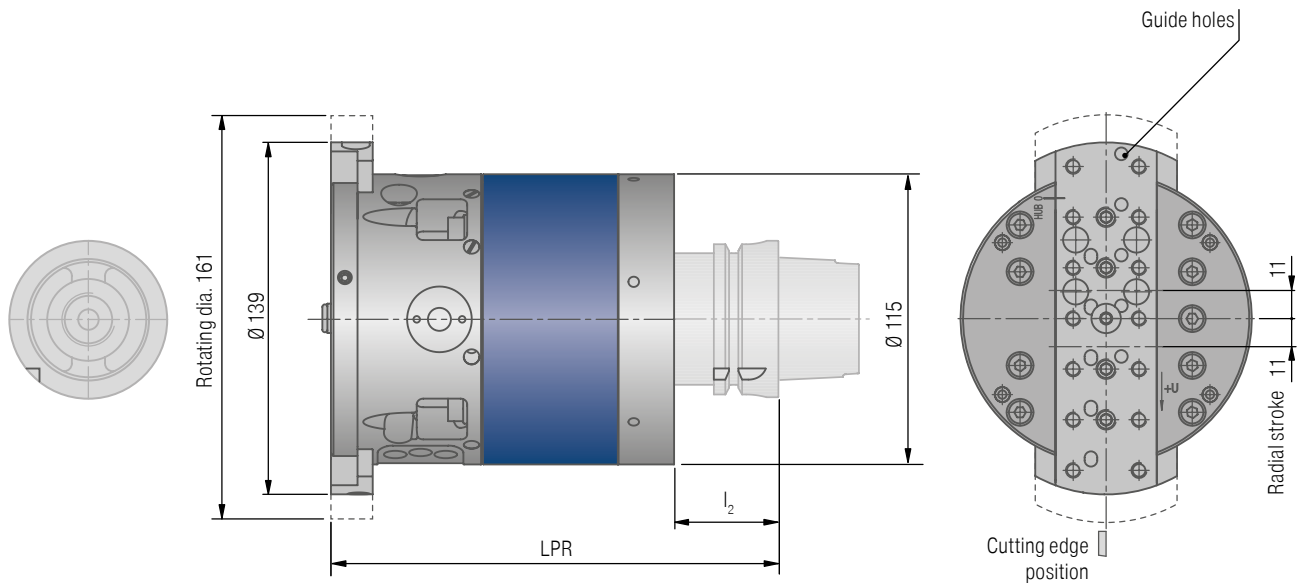
Adaption into machine tool control and spindle: page 17.

Max. stroke/spindle speed diagram
up to 0.8 kg front tool



KOMtronic U-axis UAS-115-2

UAS-115-E-G-22-2 / UAS-115-EM-G-22-2



Dimensioning of drill pattern on page 15.

Standard interface HSK, other interfaces (page 19) on request.

UAS-115-E-G-22-2		UAS-115-EM-G-22-2 Position sensor direct on slide					
Description	KOMET No.	Description	KOMET No.	Interface	LPR mm	l_2 mm	WT kg
UAS-115-HSK63-E-G-22-2	E21 20110	UAS-115-HSK63-EM-G-22-2	E31 20110	HSK 63	178	42	6,4
UAS-115-SK40-E-G-22-2	E21 22110	UAS-115-SK40-EM-G-22-2	E31 22110	SK 40	171	35	6,5
UAS-115-CAT40-E-G-22-2	E21 24110	UAS-115-CAT40-EM-G-22-2	E31 24110	CAT 40	171	35	6,8
UAS-115-BT40-E-G-22-2	E21 26110	UAS-115-BT40-EM-G-22-2	E31 26110	BT 40	178	42	6,7

Technical data

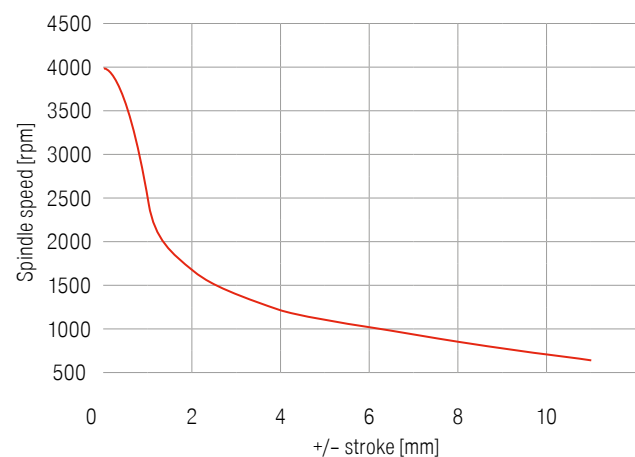
- ▲ Stroke: 22 (±11) mm
- ▲ Max. feed: 300 mm/min
- ▲ Max. spindle speed: 4000 rpm, depending on slide position (see stroke/spindle speed diagram)
- ▲ With internal coolant: 40 bar
- ▲ Versions with other strokes on request

Protection class: IP67

Operating modes: full NC axis for interpolation

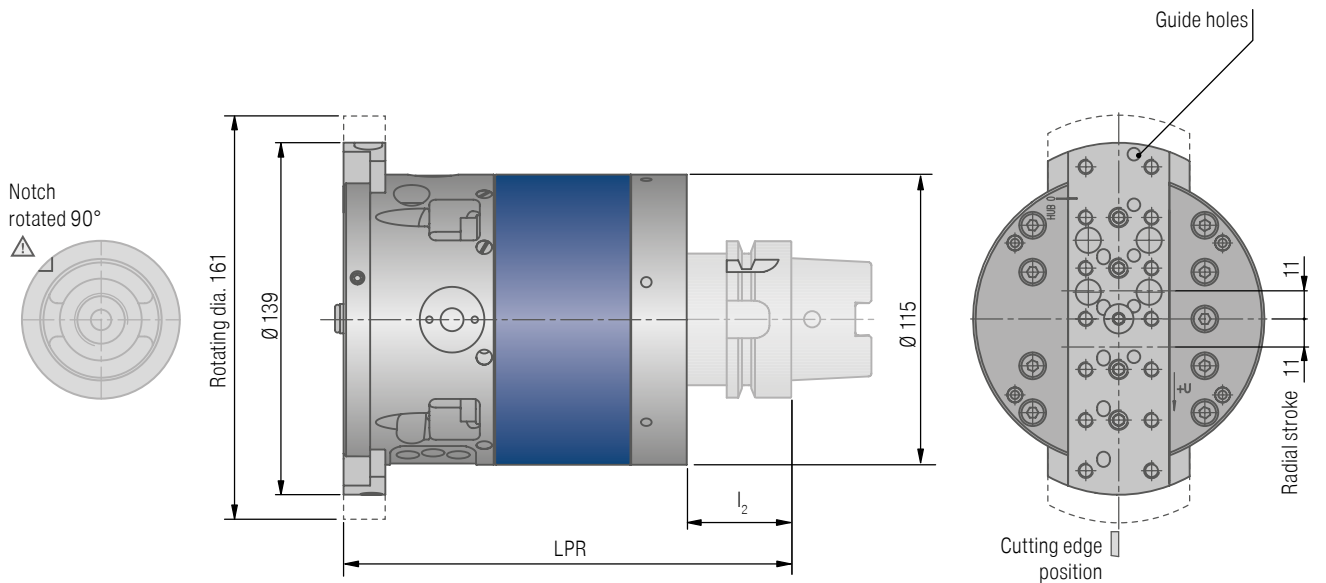
Adaption into machine tool control and spindle: page 16.

Front tools: page 18.

Max. stroke/spindle speed diagram
up to 1 kg front tool incl. adaptor

KOMtronic U-axis UAS-115-2

UAS-115-E90-G-22-2 / UAS-115-EM90-G-22-2



Dimensioning of drill pattern on page 15.

Standard interface HSK, other interfaces (page 19) on request.

UAS-115-E90-G-22-2		UAS-115-EM90-G-22-2 Position sensor direct on slide					
Description	KOMET No.	Description	KOMET No.	Interface	LPR mm	I ₂ mm	WT kg
UAS-115-HSK63-E90-G-22-2	E21 20120	UAS-115-HSK63-EM90-G-22-2	E31 20120	HSK 63	178	42	6,4
UAS-115-SK40-E90-G-22-2	E21 22120	UAS-115-SK40-EM90-G-22-2	E31 22120	SK 40	171	35	6,5
UAS-115-CAT40-E90-G-22-2	E21 24120	UAS-115-CAT40-EM90-G-22-2	E31 24120	CAT 40	171	35	6,8
UAS-115-BT40-E90-G-22-2	E21 26120	UAS-115-BT40-EM90-G-22-2	E31 26120	BT 40	178	42	6,7

Technical data

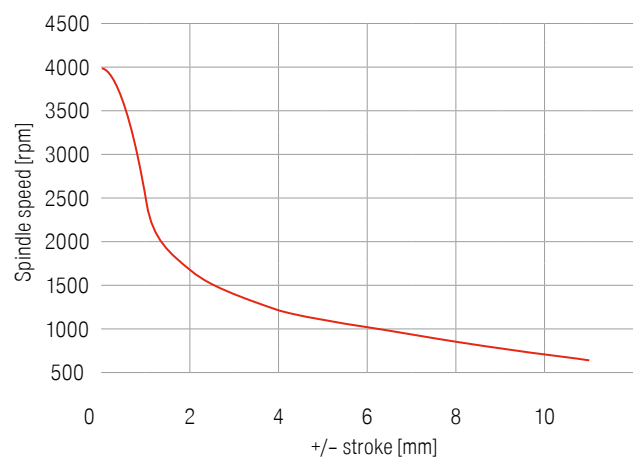
- ▲ Stroke: 22 (±11) mm
- ▲ Max. feed: 300 mm/min
- ▲ Max. spindle speed: 4000 rpm, depending on slide position (see stroke/spindle speed diagram)
- ▲ With internal coolant: 40 bar
- ▲ Versions with other strokes on request

Protection class: IP67

Operating modes: full NC axis for interpolation

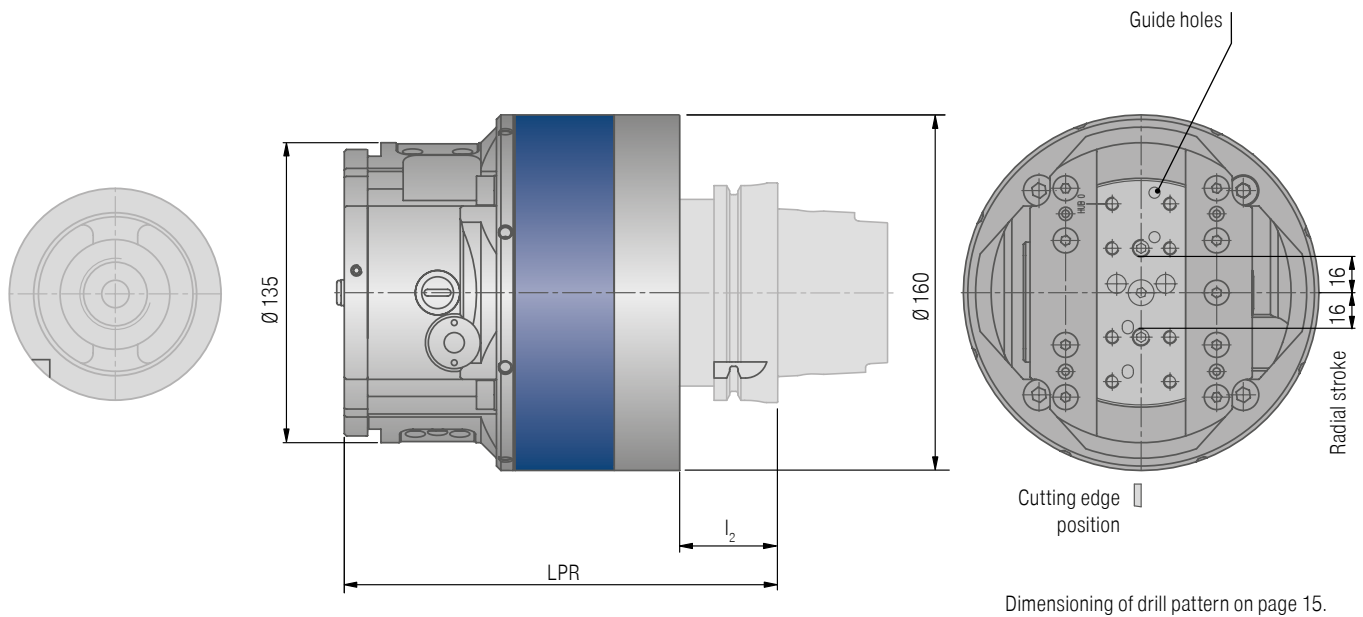
Adaption into machine tool control and spindle: page 16.

Front tools: page 18.

Max. stroke/spindle speed diagram
up to 1 kg front tool incl. adaptor

KOMtronic U-axis UAS-160-3

UAS-160-EM-G-32-3



Standard interface HSK, other interfaces (page 19) on request. Interface rotated by 90° on request.

UAS-160-EM-G-32-3 Position sensor direct on slide

Description	KOMET No.	Interface	LPR mm	I ₂ mm	WT kg
UAS-160-HSK100-EM-G-32-3	1E313310032010	HSK 100	198,5	45	12,1
UAS-160-SK50-EM-G-32-3	1E313330032010	SK 50	188,5	35	12,5
UAS-160-CAT50-EM-G-32-3	1E313350032010	CAT 50	188,5	35	12,5
UAS-160-BT50-EM-G-32-3	1E313370032010	BT 50	206,5	53	13,6

Technical data

- ▲ Stroke: 32 (±16) mm
- ▲ Max. feed: 350 mm/min
- ▲ Max. spindle speed: 4000 rpm, depending on slide position (see stroke/spindle speed diagram)
- ▲ With internal coolant: 40 bar
- ▲ Versions with other strokes on request

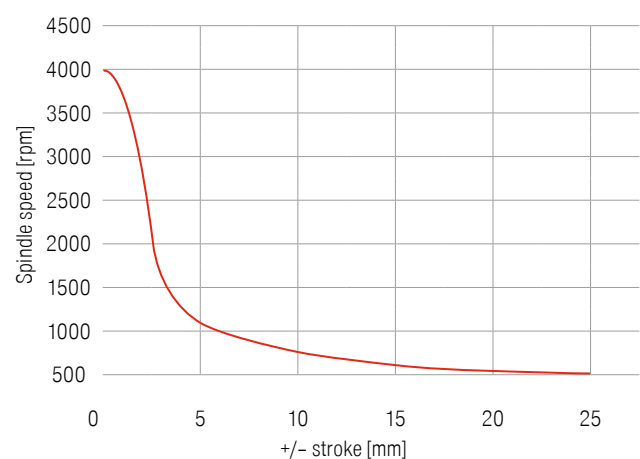
Protection class: IP67

Operating modes: full NC axis for interpolation

Adaption into machine tool control and spindle: page 17.

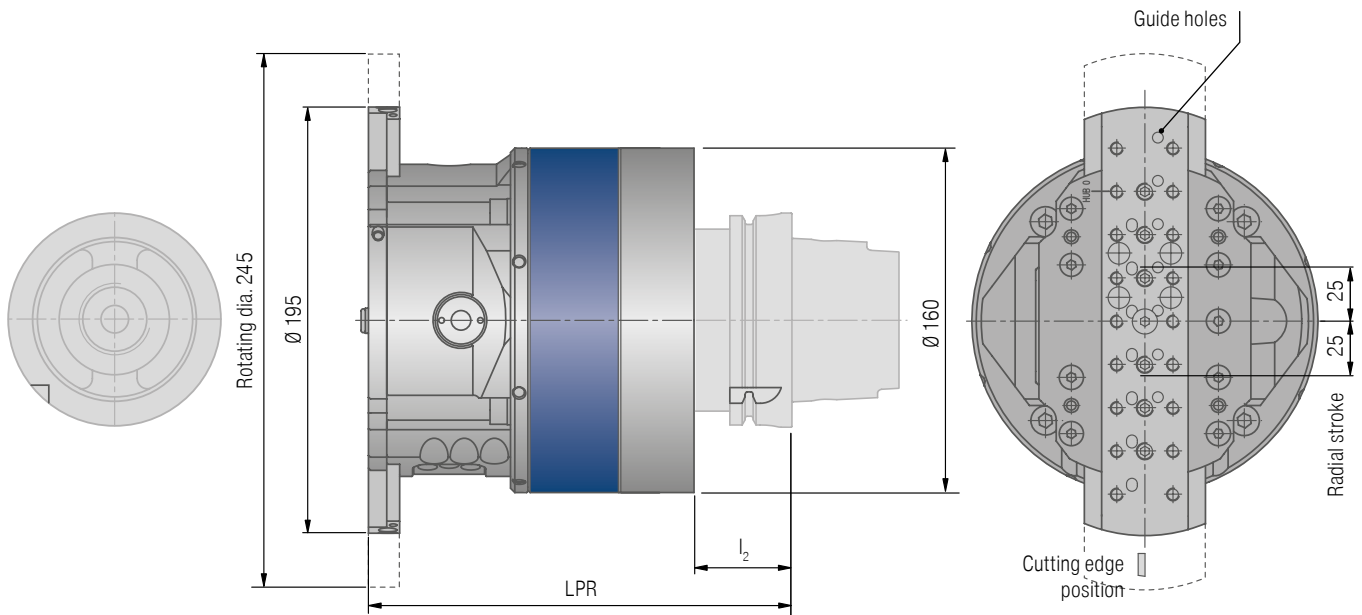
Front tools: page 18.

Max. stroke/spindle speed diagram
up to 1,8 kg front tool incl. adaptor



KOMtronic U-axis UAS-160-3

UAS-160-EM-G-50-3



Dimensioning of drill pattern on page 15.

Standard interface HSK, other interfaces (page 19) on request. Interface rotated by 90° on request.

UAS-160-EM-G-50-3 Position sensor direct on slide

Description	KOMET No.	Interface	LPR mm	I ₂ mm	WT kg
UAS-160-HSK100-EM-G-50-3	1E313310050010	HSK 100	196	45	12,4
UAS-160-SK50-EM-G-50-3	1E313330050010	SK 50	186	35	12,8
UAS-160-CAT50-EM-G-50-3	1E313350050010	CAT 50	186	35	12,8
UAS-160-BT50-EM-G-50-3	1E313370050010	BT 50	204	53	13,9

Technical data

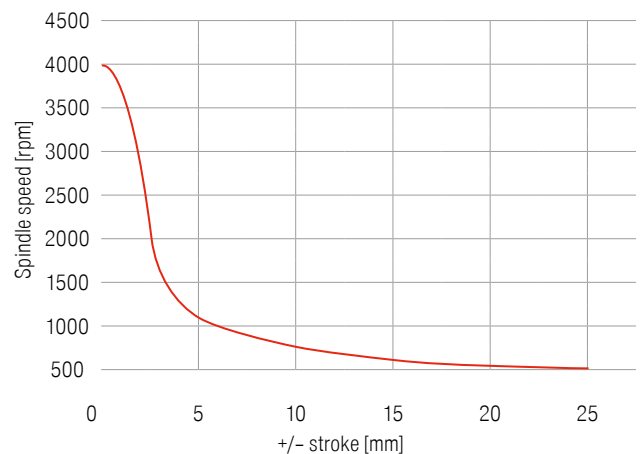
- ▲ Stroke: 50 (±25) mm
- ▲ Max. feed: 350 mm/min
- ▲ Max. spindle speed: 4000 rpm, depending on slide position (see stroke/spindle speed diagram)
- ▲ With internal coolant: 40 bar
- ▲ Versions with other strokes on request

Protection class: IP67

Operating modes: full NC axis for interpolation

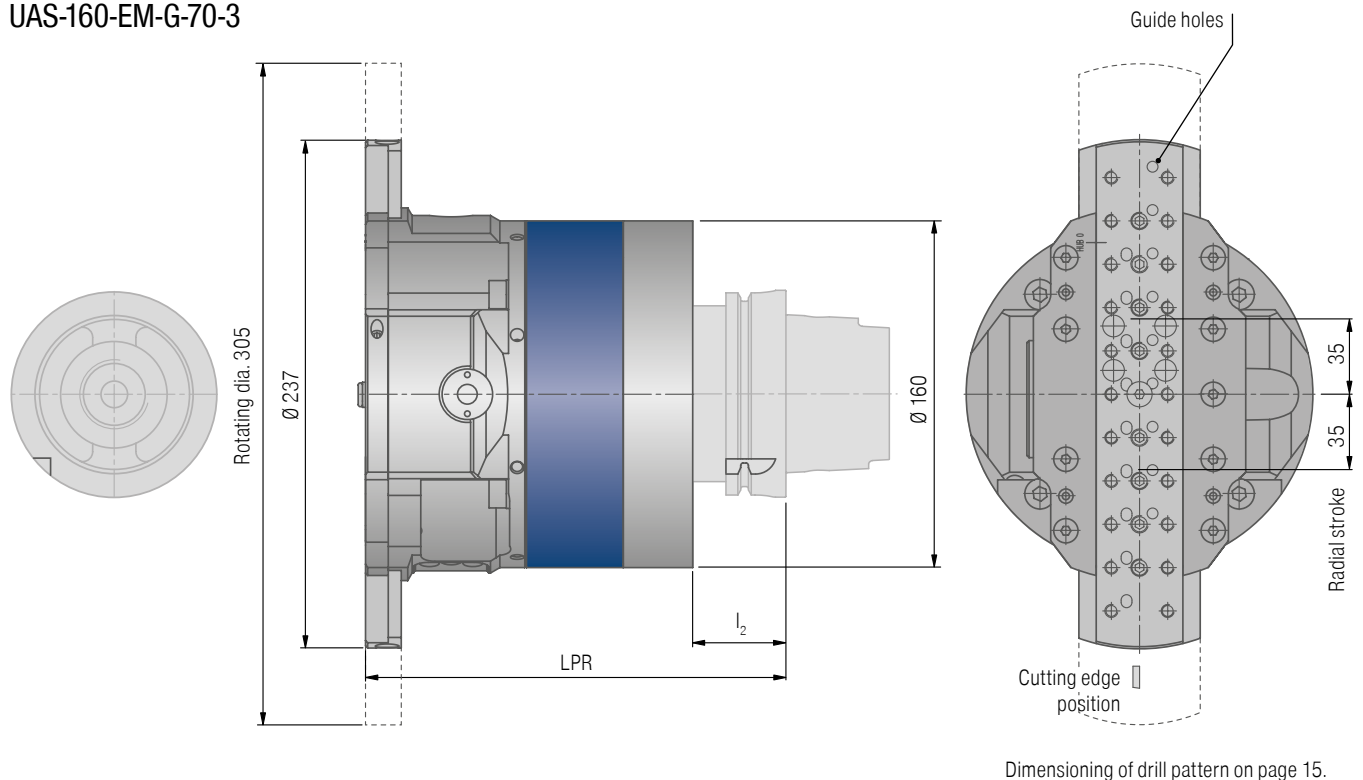
Adaption into machine tool control and spindle: page 17.

Front tools: page 18.

Max. stroke/spindle speed diagram
up to 1,8 kg front tool incl. adaptor

KOMtronic U-axis UAS-160-3

UAS-160-EM-G-70-3



Standard interface HSK, other interfaces (page 19) on request. Interface rotated by 90° on request.

UAS-160-EM-G-70-3 Position sensor direct on slide

Description	KOMET No.	Interface	LPR mm	l_2 mm	WT kg
UAS-160-HSK100-EM-G-70-3	1E313310070010	HSK 100	196	45	12,6
UAS-160-SK50-EM-G-70-3	1E313330070010	SK 50	186	35	13,0
UAS-160-CAT50-EM-G-70-3	1E313350070010	CAT 50	186	35	13,0
UAS-160-BT50-EM-G-70-3	1E313370070010	BT 50	204	53	14,1

Technical data

- ▲ Stroke: 70 (±35) mm
- ▲ Max. feed: 350 mm/min
- ▲ Max. spindle speed: 4000 rpm, depending on slide position (see stroke/spindle speed diagram)
- ▲ With internal coolant: 40 bar
- ▲ Versions with other strokes on request

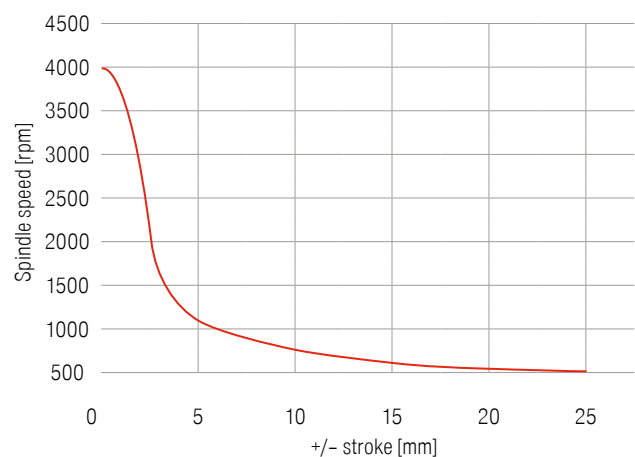
Protection class: IP67

Operating modes: full NC axis for interpolation

Adaption into machine tool control and spindle: page 17.

Front tools: page 18.

Max. stroke/spindle speed diagram
up to 1,8 kg front tool incl. adaptor



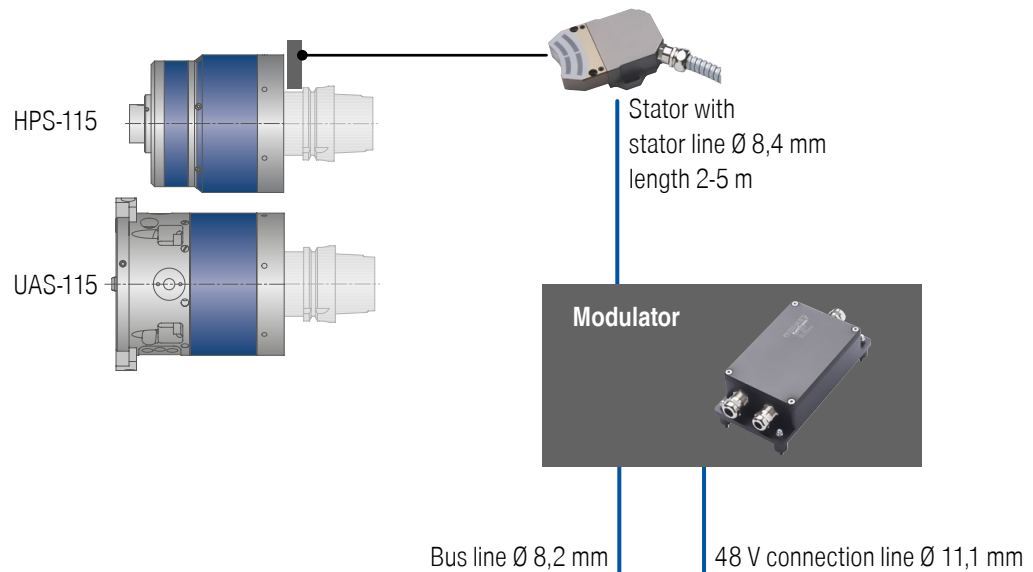
Dimensioning of drill pattern for front tools



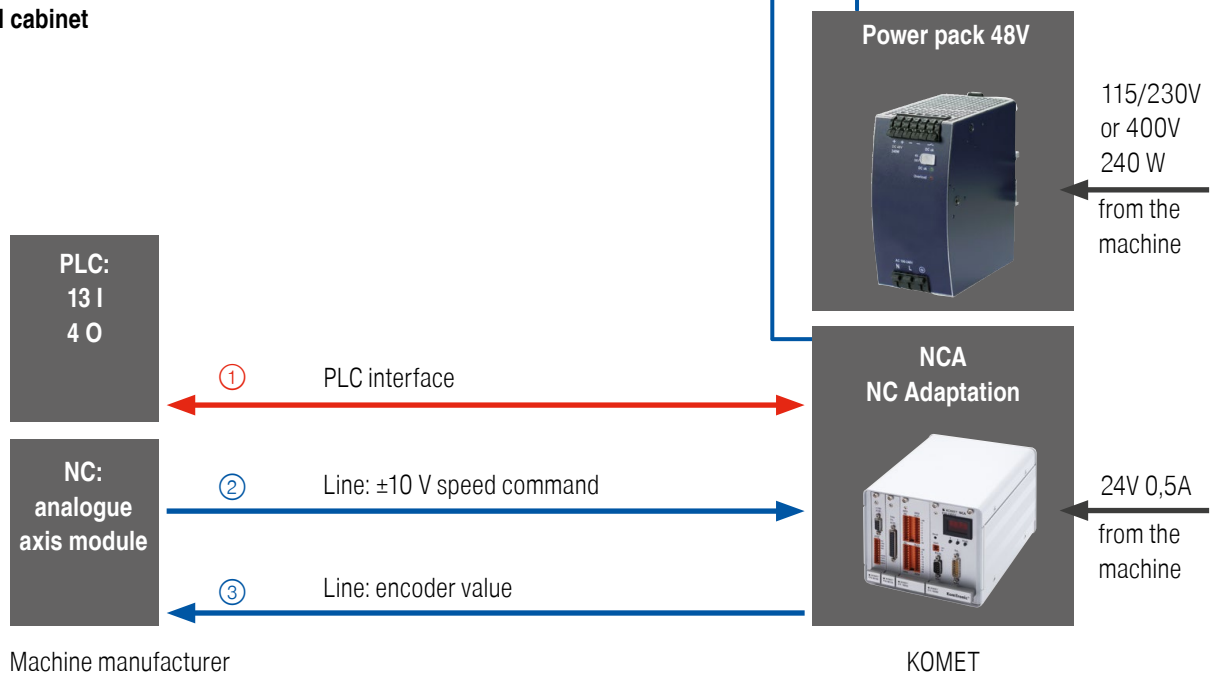
Adaptation into machine tool control and spindle (schematic overview)

Detailed schematic overview will be created based on the specific project.

Machine / spindle



Electrical cabinet



① PLC connection

13 inputs and 4 outputs are required on the PLC. 3 M-commands are required for selecting u-axis functions.

② Nominal value requirement

± 10 V nominal speed value from analogue axis module of NC control to the KOMET NCA.

③ Incremental actual position value

The current position is transmitted from the KOMET NCA to the analogue axis module for the NC control.

The following signal forms are available:

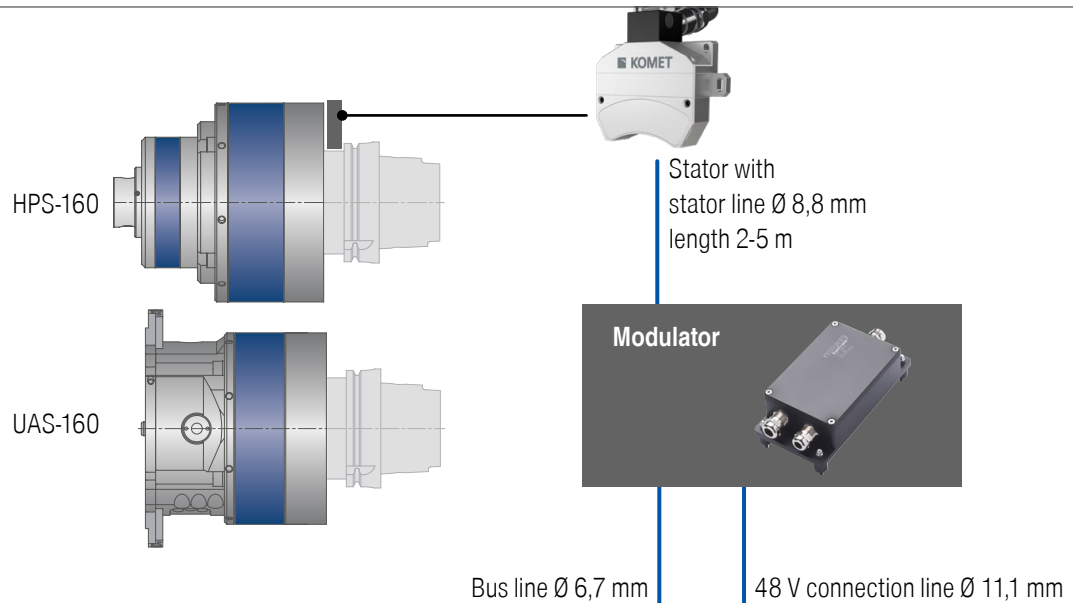
- ▲ TTL level (5 V) in acc. with RS 422, interpolated, square signal form
- ▲ 1 Vpp (1 V peak to peak), sine signal form

The KOMtronic u-axis system does not need a power unit on the NC control.

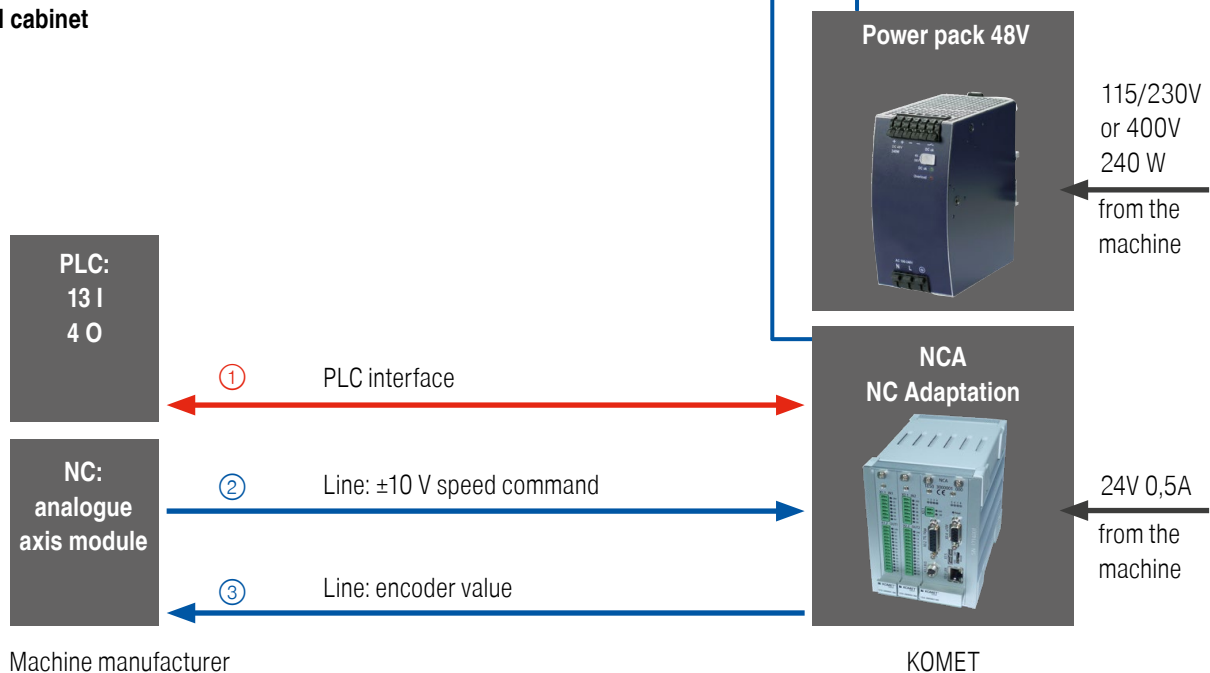
Adaptation into machine tool control and spindle (schematic overview)

Detailed schematic overview will be created based on the specific project.

Machine / spindle



Electrical cabinet



① PLC connection

13 inputs and 4 outputs are required on the PLC. 3 M-commands are required for selecting u-axis functions.

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± 10 V nominal speed value from analogue axis module of NC control to the KOMET NCA.

③ Incremental actual position value

The current position is transmitted from the KOMET NCA to the analogue axis module for the NC control.

The following signal forms are available:

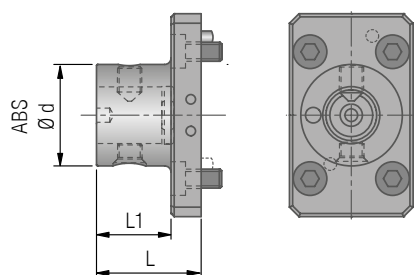
- ▲ TTL level (5 V) in acc. with RS 422, interpolated, square signal form
- ▲ 1 Vpp (1 V peak to peak), sine signal form

The KOMtronic u-axis system does not need a power unit on the NC control.

Front tools

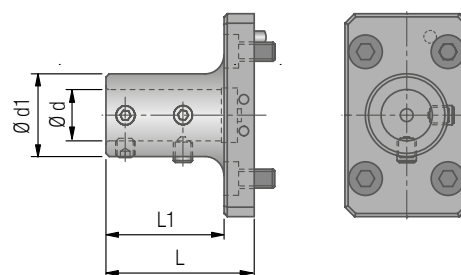
The front tool can be mounted directly onto the slide.

The following adaptors are available when using standard tools (others available on request).



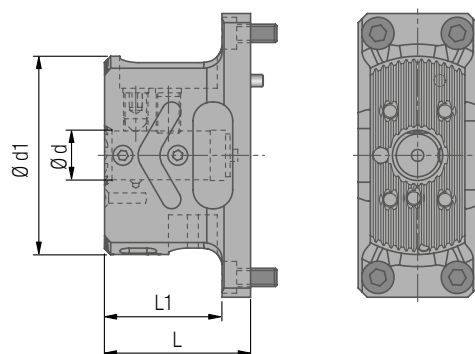
ABS adaptor

d ABS mm	L mm	L1 mm	WT kg	KOMET No.
32	33	23,5	0,28	P80 23060
40	37	27,5	0,37	P80 24060
50	42	28	0,64	P80 25060



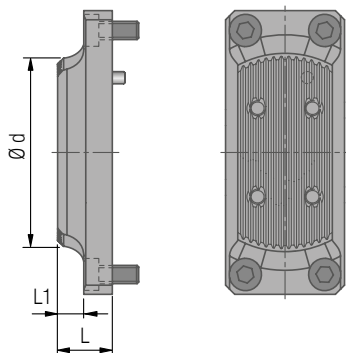
Cylindrical adaptor

d mm	d1 mm	L mm	L1 mm	WT kg	KOMET No.
10	17,8	36	26,5	0,22	P81 21070
12	21,8	36	26,5	0,23	P81 21080
16	25,8	46,5	37	0,27	P81 21090
20	33,8	46,5	37	0,38	P81 21100
25	38,8	56	46,5	0,53	P81 21110
32	47,8	58,5	49	0,67	P81 21120



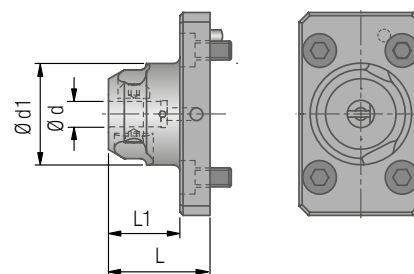
Universal adaptor

d mm	d1 mm	L mm	L1 mm	WT kg	KOMET No.
16 ABS32	65	48	38	0,56	P81 29060



Bridge adaptor

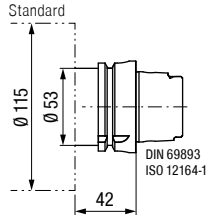
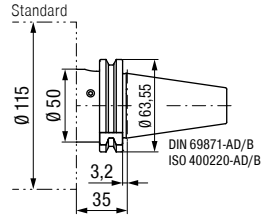
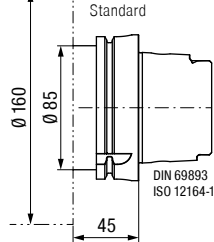
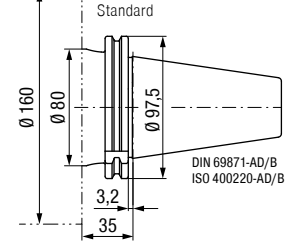
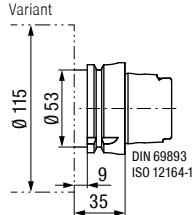
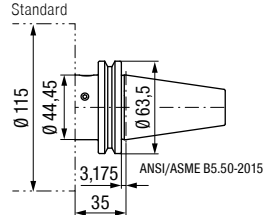
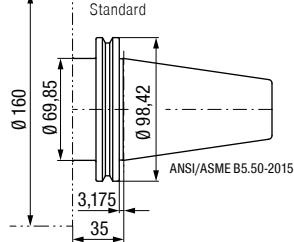
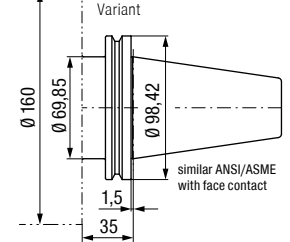
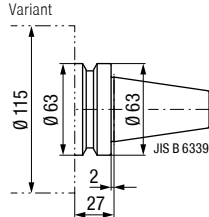
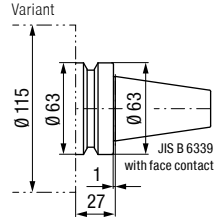
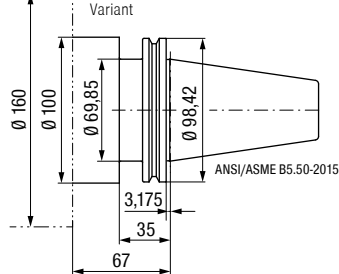
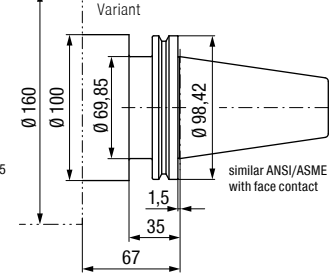
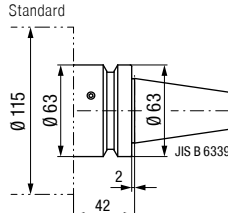
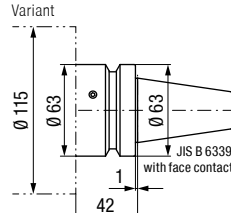
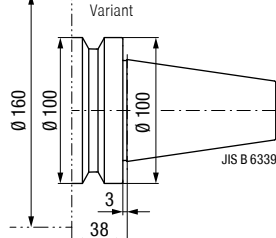
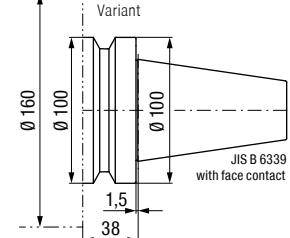
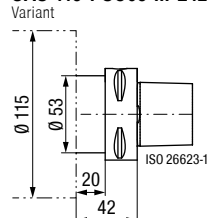
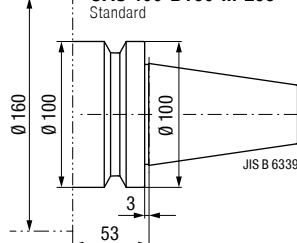
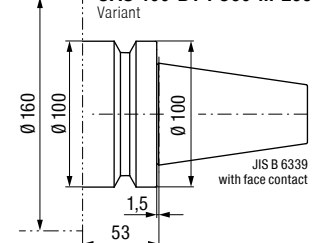
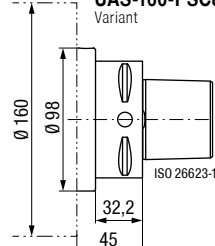
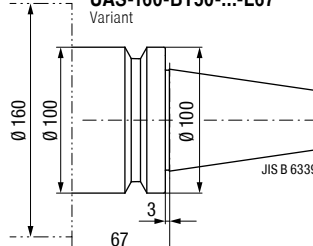
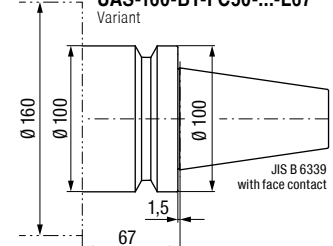
d mm	L mm	L1 mm	WT kg	KOMET No.
65	18	8,49	0,36	P81 29070



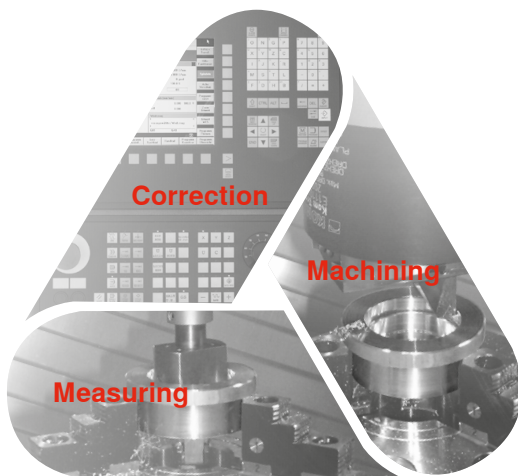
UniTurn adaptor

d mm	d1 mm	L mm	L1 mm	WT kg	KOMET No.
4	32	28	18,5	0,26	P81 22020
8	32	32	22,5	0,29	P81 22030

Overview tool interfaces

UAS-115-HSK-A63-...-L42**UAS-115-SK40-...-L35****UAS-160-HSK-A100-...-L45****UAS-160-SK50-...-L35****UAS-115-HSK-A63-...-L35****UAS-115-CAT40-...-L35****UAS-160-CAT50-...-L35****UAS-160-CAT-FC50-...-L35****UAS-115-BT40-...-L27****UAS-115-BT-FC40-...-L27****UAS-160-CAT50-...-L67****UAS-160-CAT-FC50-...-L67****UAS-115-BT40-...-L42****UAS-115-BT-FC40-...-L42****UAS-160-BT50-...-L38****UAS-160-BT-FC50-...-L38****UAS-115-PSC63-...-L42****UAS-160-BT50-...-L53****UAS-160-BT-FC50-...-L53****UAS-160-PSC80-...-L45****UAS-160-BT50-...-L67****UAS-160-BT-FC50-...-L67**

Complete machining in a closed process chain



Turning and measuring on the machining centre

Complete machining:

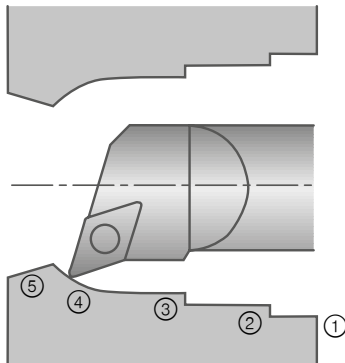
- No switching to a turning machine
- Saving on tools, no special tools required
- Higher quality

Measuring of fits:

- Precision measurement with a barrel gauge or calliper
- Automatic test cut possible

- ▲ Saving time
- ▲ Saving on tools
- ▲ Increase in quality
- ▲ Automatic wear compensation

Programming as usual ...



G0 U15		
G1 Z0		
G1 U14.5 Z-0.5	①	Chamfer
G1 Z-6		
G1 U14	②	Level
G1 U13.75 Z-6.25	②	Chamfer
G1 Z-17		
G1 U13.5	③	Level
G1 Z-25		
G3 Z-34.18 U9.9 E13.5	④	Radius
G1 Z-42 U12	⑤	Incline
G0 U9.75		
G0 Z10		

Integration of the KOMtronic U-Axis system into different machine control systems

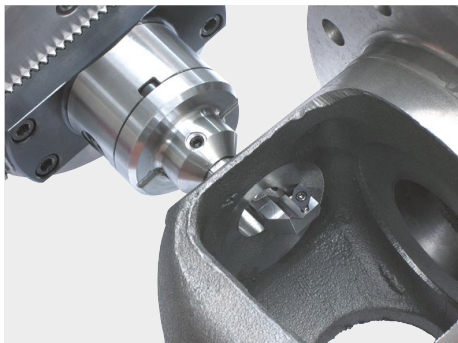
Control system Manufacturer	
SINUMERIK 840 D powerline	SIEMENS
SINUMERIK 840 D(i) solution line	
Fanuc 15i 16i 18i 21i	FANUC
Fanuc 30i 31i 32i 0i from version D	
Heidenhain iTNC 530 iTNC 530 HSCI	HEIDENHAIN
Heidenhain TNC 640	
Mazatrol Matrix SmoothX	MAZAK
Bosch Rexroth MTC-200 V18	BOSCH REXROTH
Bosch Rexroth MTX	
Meldas	MITSUBISHI

Workpiece: differential housing

- ▲ Flexibility
- ▲ Saves on expensive blanking
- ▲ Replaces separate machining on a lathe and thus eliminates the need for a clamping device
- ▲ Increase in quality

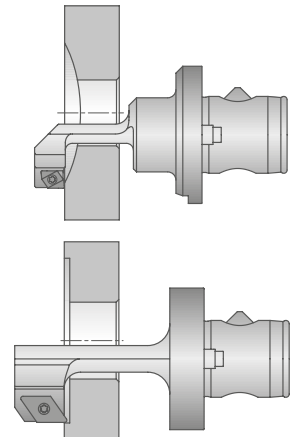
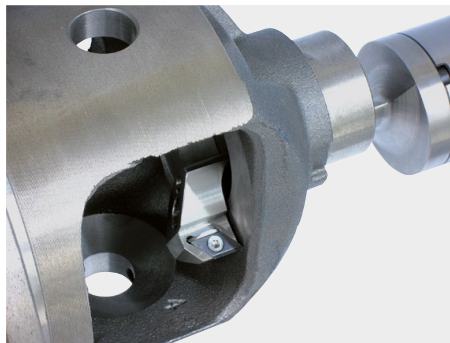
Machining: turning an inside radius

Cutting speed $v_c = 80 \text{ m/min}$
 Feed $f = 0,1 \text{ mm/rev.}$
 Cutting width 1st cut $a_p = 1,5 \text{ mm}$
 2nd cut $a_p = 0,2 \text{ mm}$
 Radial stroke 10 mm



Machining: rear planing

Cutting speed $v_c = 80 \text{ m/min}$
 Feed $f = 0,12 \text{ mm/rev.}$
 Cutting width $a_p = 0,3 \text{ mm}$
 Radial stroke 14,5 mm



Workpiece: medical hinged plate

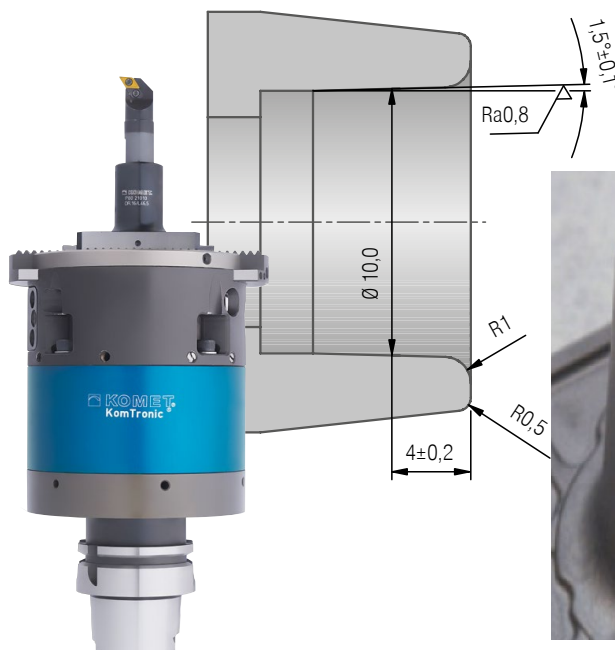
Machining: taper machining with radius contour

- ▲ Reduced processing time
- ▲ Reduced tool costs
- ▲ Reduced production time
- ▲ Higher quality and process reliability

Material: Titan

Cutting speed
 $v_c = 50 \text{ m/min}$

Feed
 $f = 0,05 \text{ mm/rev.}$



Workpieces can be completely machined with high precision and cycle time savings utilising these options for turning, undercutting, chamfering and generation of NC controlled contours.

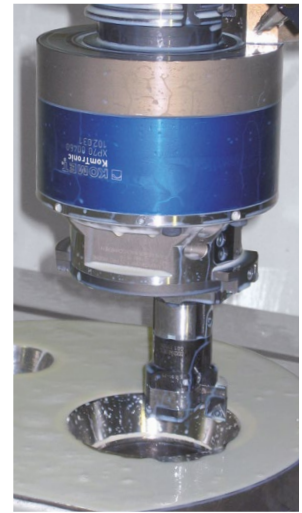
Workpiece: control block

Machining: turning an inside taper

- ▲ Replaces separate machining on a lathe and thus eliminates the need for a clamping device
- ▲ Reduced production times
- ▲ Increase in quality

The material Inconel 625 was applied to a tapered hole and machined in 2 cuts.

Cutting speed $v_c = 30 \text{ m/min}$
 Feed $f = 0,08 \text{ mm/rev.}$
 Cutting width 1st cut $a_p = 2,5 \text{ mm}$
 2nd cut $a_p = 0,5 \text{ mm}$

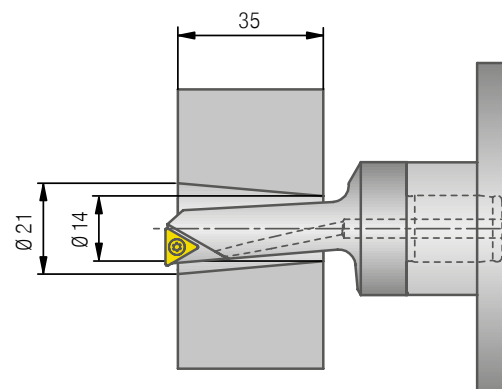
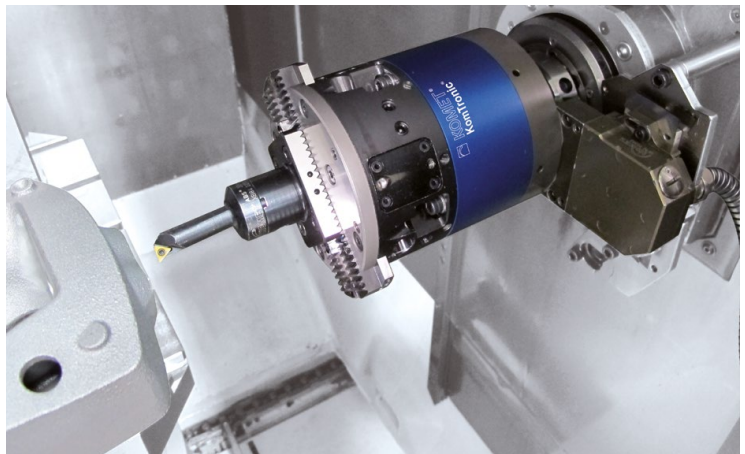


Workpiece: wheelmount

Machining: reverse taper machining

- ▲ Complete machining on one machine
- ▲ Replaces separate machining on a lathe and thus eliminates the need for a clamping device
- ▲ Reduced processing times
- ▲ Increase in quality

Cutting speed $v_c = 150 \text{ m/min}$
 Feed $f = 0,08 \text{ mm/rev.}$
 Taper angle $\alpha = 9,5^\circ_{-0,05^\circ}$
 Material: Cast aluminum



Workpieces can be completely machined with high precision and cycle time savings utilising these options for turning, undercutting, chamfering and generation of NC controlled contours.

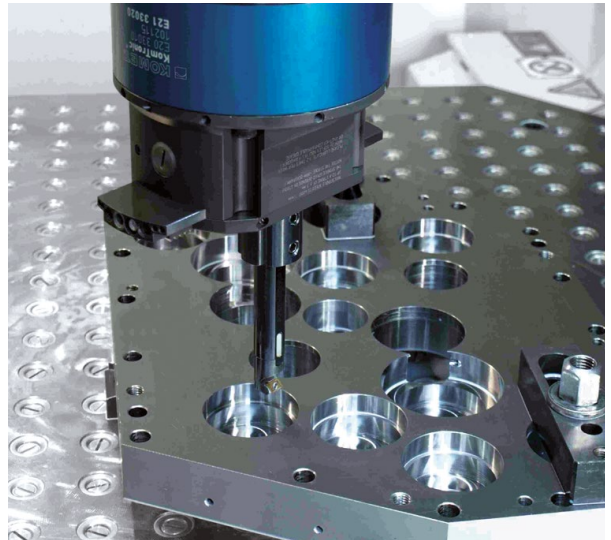
Workpiece: bearing plate

Machining: turning a bearing plate

- ▲ Reduced processing time
- ▲ Reduced tool change time
- ▲ Reduced tool costs
- ▲ Complete machining
- ▲ Flexibility
- ▲ Higher precision and process reliability

Material 42CrMo4

Variable diameter

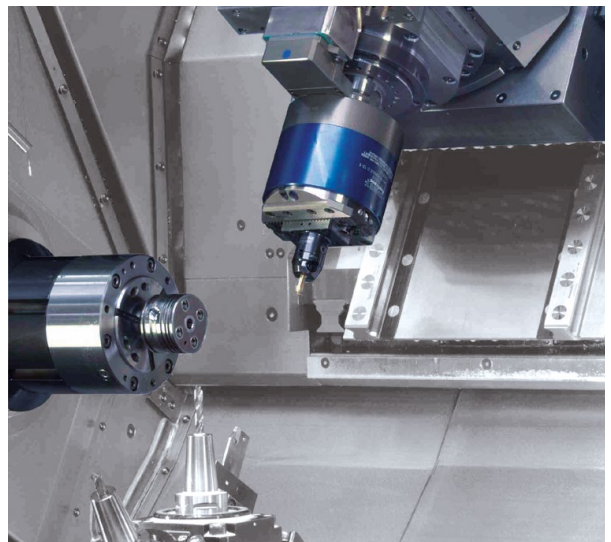


Workpiece: control block

Machining: complete machining on one turning/milling centre

- ▲ Reduced production time
- ▲ Reduced tool costs
- ▲ Flexibility
- ▲ Increase in quality

Material 42CrMo4

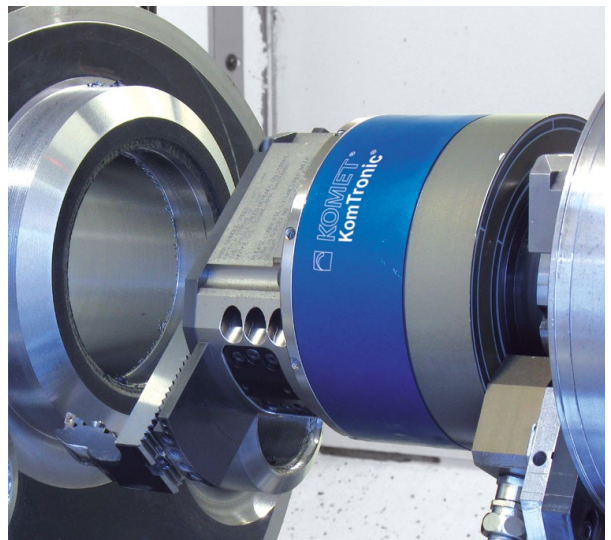


Workpiece: control block

Machining: turning an outer contour

- ▲ Complete machining on one machining centre
- ▲ Replaces separate machining on a lathe and thus eliminates the need for a clamping device
- ▲ Reduced production times
- ▲ Increase in quality

Material: Inconel



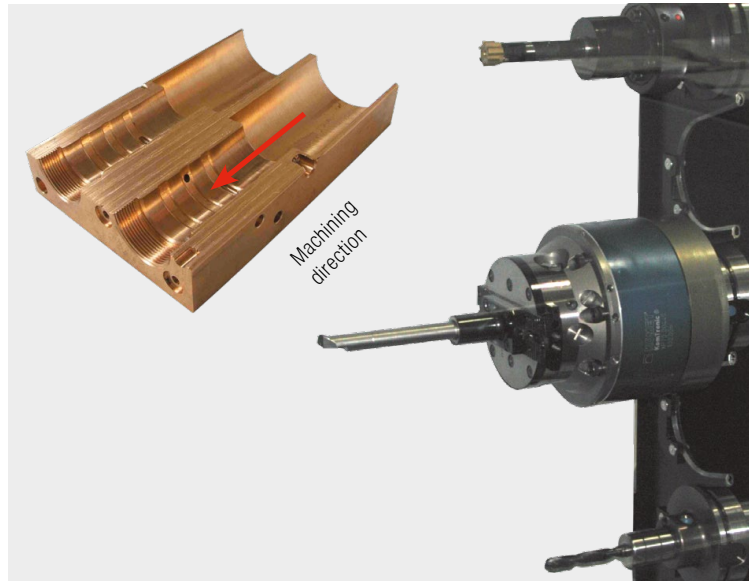
Workpiece: hydraulic cylinder

Machining: springing valves
Boring inner contours and recesses with
2 U-axis systems

- ▲ Reduced processing times
- ▲ Reduced tool change times
- ▲ Reduced tool costs
- ▲ Reduced additional costs
- ▲ Flexibility

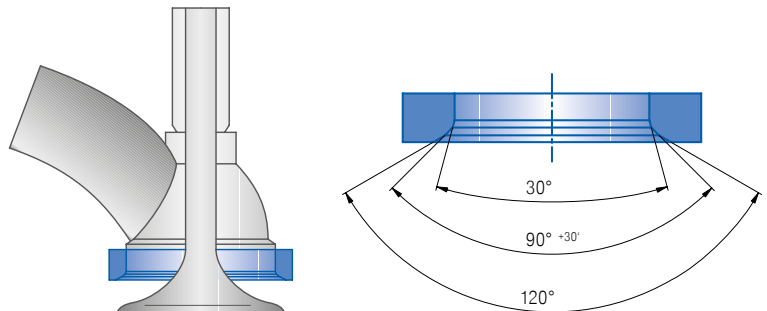
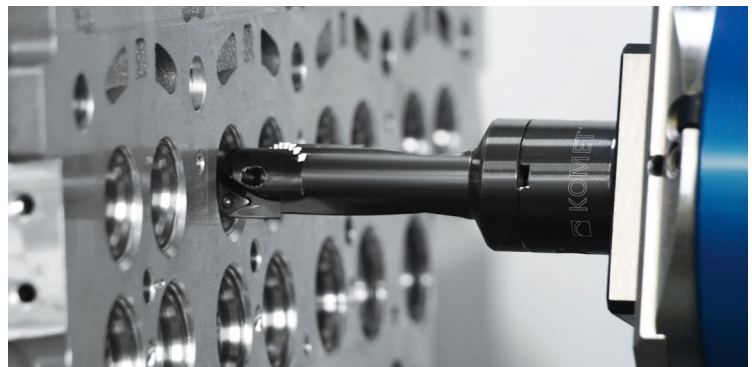
Feed $f = 0,1-0,15 \text{ mm/rev.}$

Spindle speed $n = 2000 \text{ min}^{-1}$



Valve seat machining

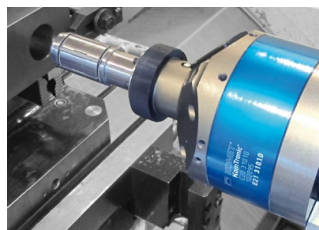
- ▲ Machining on standard machines instead of special purpose machinery
- ▲ Prototype production, engine reconditioning
- ▲ Turning contours in a large range, in one large operation
- ▲ Increase in quality
- ▲ Increase in productivity



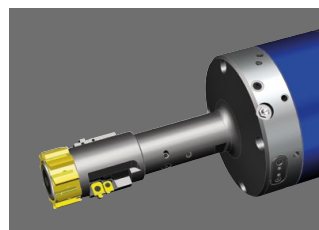
YOUR job – OUR solution



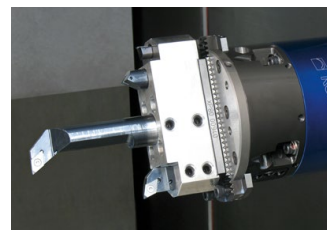
Fine boring



Honing

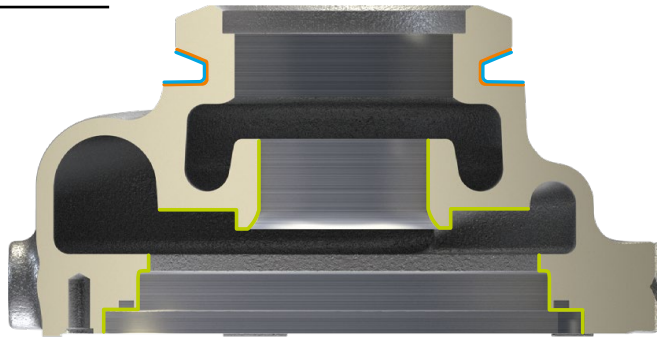


Reaming and grooving



Flexible, modular tool design

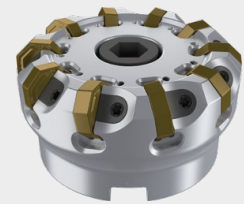
Complete machining of turbochargers



MaxiMill 275 arbor face-milling cutter for machining of turbo chargers Ø 50 – 125 mm

With double-sided octagonal indexable inserts with 16 usable cutting edges.

- ▲ Robust design, stable and secure position in the basic body
- ▲ Special cutting material suitable for the toughest thermomechanical requirements
- ▲ Defined, stable cutting edge guidance
- ▲ Maximum productivity, process reliability and cost-efficiency guaranteed



Pre-machining of V-belt outer diameter – interpolation grooving and turning tool

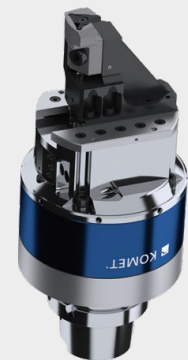
- ▲ Extremely stable tool design
- ▲ Special adaptation of the cutting edge geometry to the machining process with regard to machining time and stability
- ▲ Internal coolant supply directly to the tool's cutting edge



Finish machining of V-belt outer diameter – KOMtronic U-axis systems

With 3D-printed snap-on tool and indexable inserts in special designs, with three cutting edges with ground recess geometry and flute.

- ▲ Considerably higher cutting values than with conventional machining
- ▲ Integrated position measuring system
- ▲ Short, stable tool design thanks to optimal compact connection



Finish machining of counter bearing conical hole – KOMtronic U-axis systems

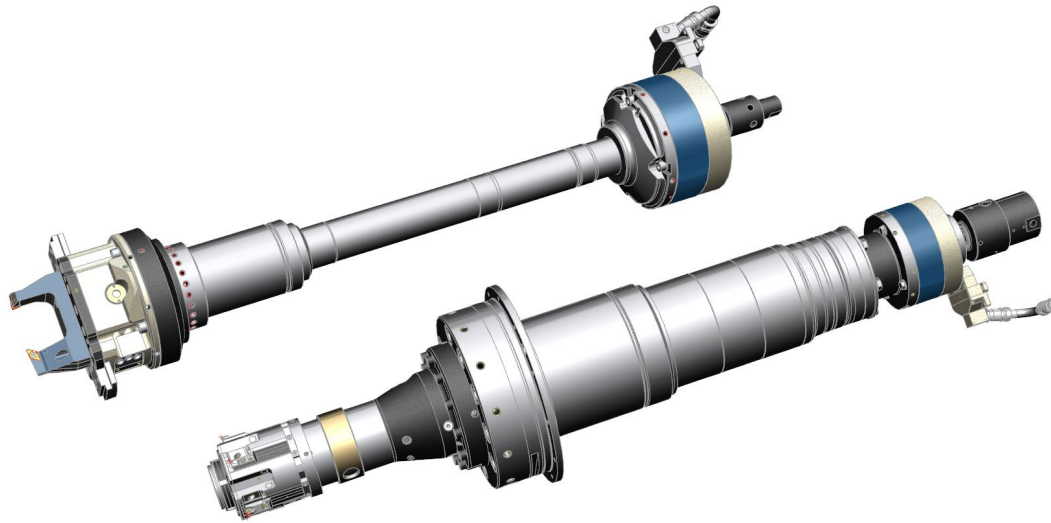
With stepped snap-on tool with four indexable inserts.

- ▲ Complete finish machining with a single tool
- ▲ Enables maximum precision to be achieved
- ▲ 99% use of standard indexable inserts
- ▲ Direct coolant supply to the individual cutting edges
- ▲ Integrated position measuring system
- ▲ Short, stable tool design thanks to optimal compact connection



KOMtronic SMS / UAC / UAD

Facing heads with integrated measuring system and KOMtronic U-axis systems for spindle integration



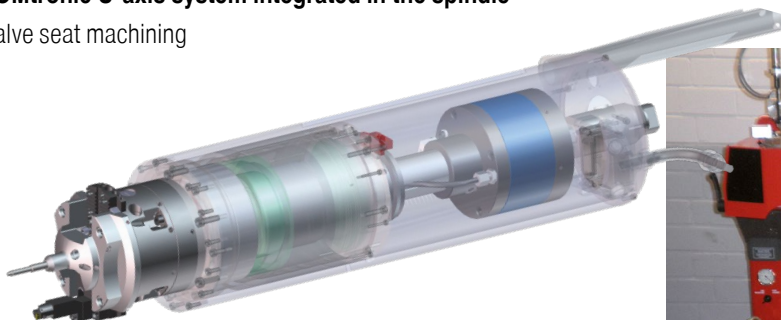
Produce turning contours economically when working with a stationary workpiece

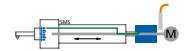
Based on decades of experience producing facing heads for special purpose machines, KOMET is expanding its product range to include KOMtronic systems for spindle integration for different installation and usage requirements for facing heads.

- ▲ Facing heads with direct encoder on the slide
- ▲ KOMtronic systems for spindle integration with own drive

KOMtronic U-axis system integrated in the spindle

Valve seat machining



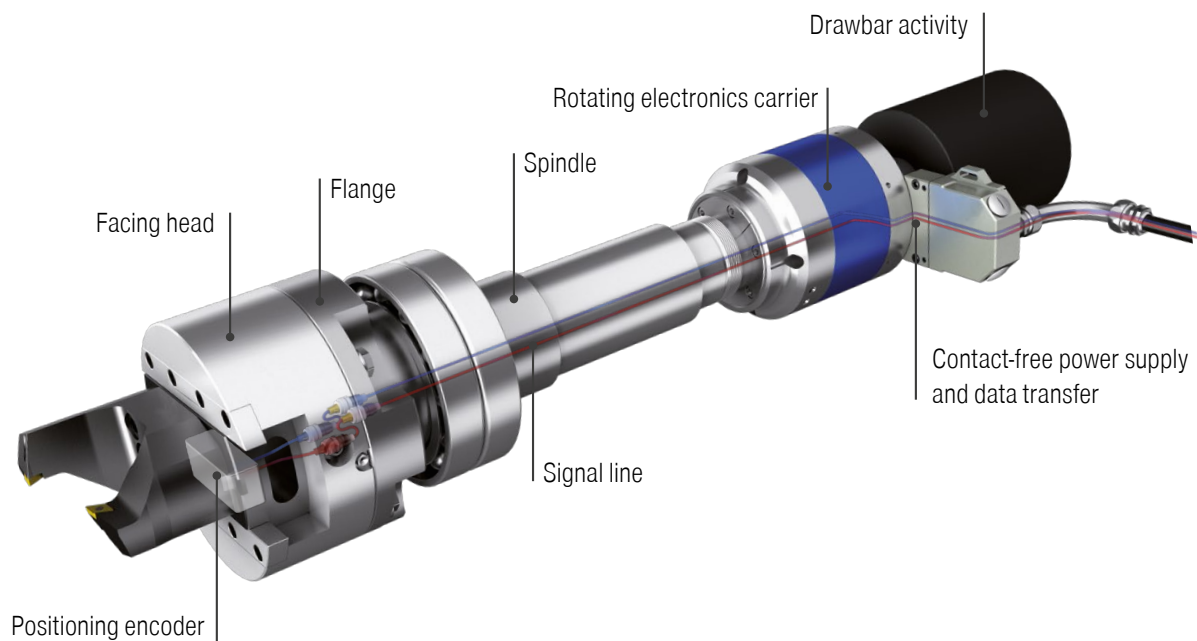


KOMtronic SMS

Slide Measurement System

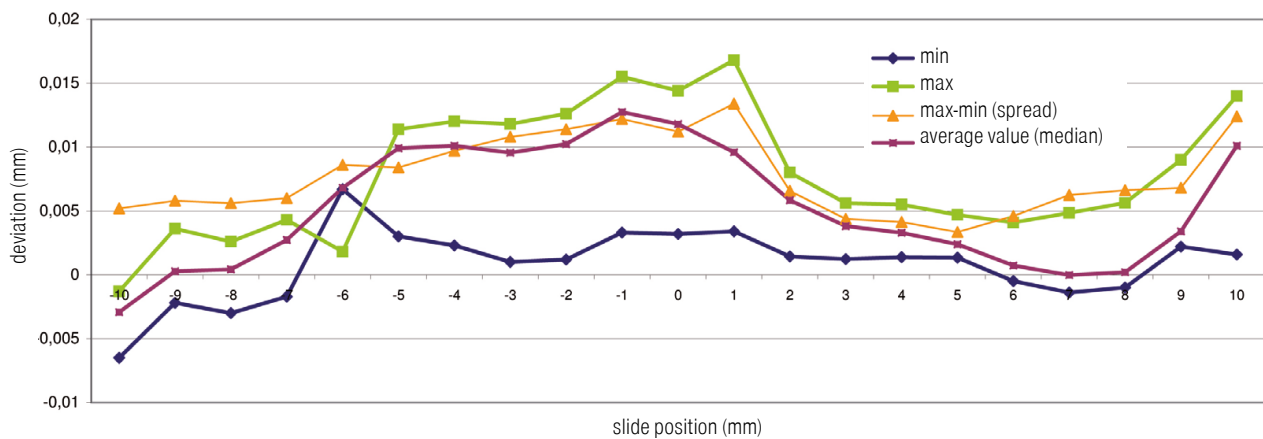
Conventional facing heads with direct encoder (SMS)

- ▲ Direct measuring system on slide increases positioning accuracy and thus machining quality
- ▲ Suppression of backlash, even in the case of wear-related change
- ▲ Reduced influence of wear on machining quality
- ▲ Possible to compensate for heat cycle of draw bar drive
- ▲ Process capability is improved

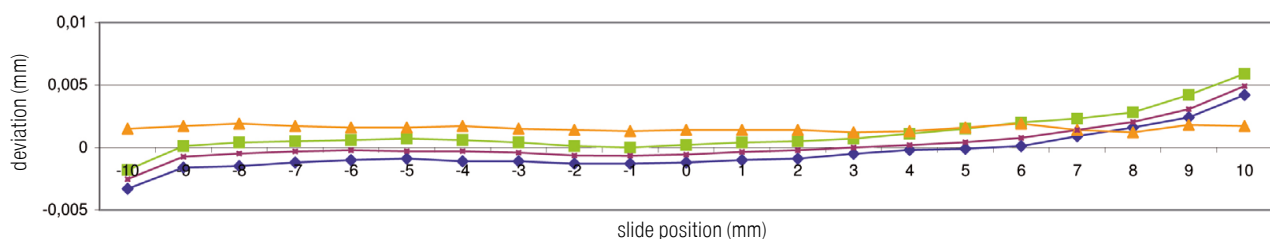


Example:

PKE 160-25-101-SMS / Motor-encoder positioning / 100 repetitions per mm / Measuring range ± 10 mm



PKE 160-25-101-SMS / Direct linear scale positioning / 100 repetitions per mm / Measuring range ± 10 mm





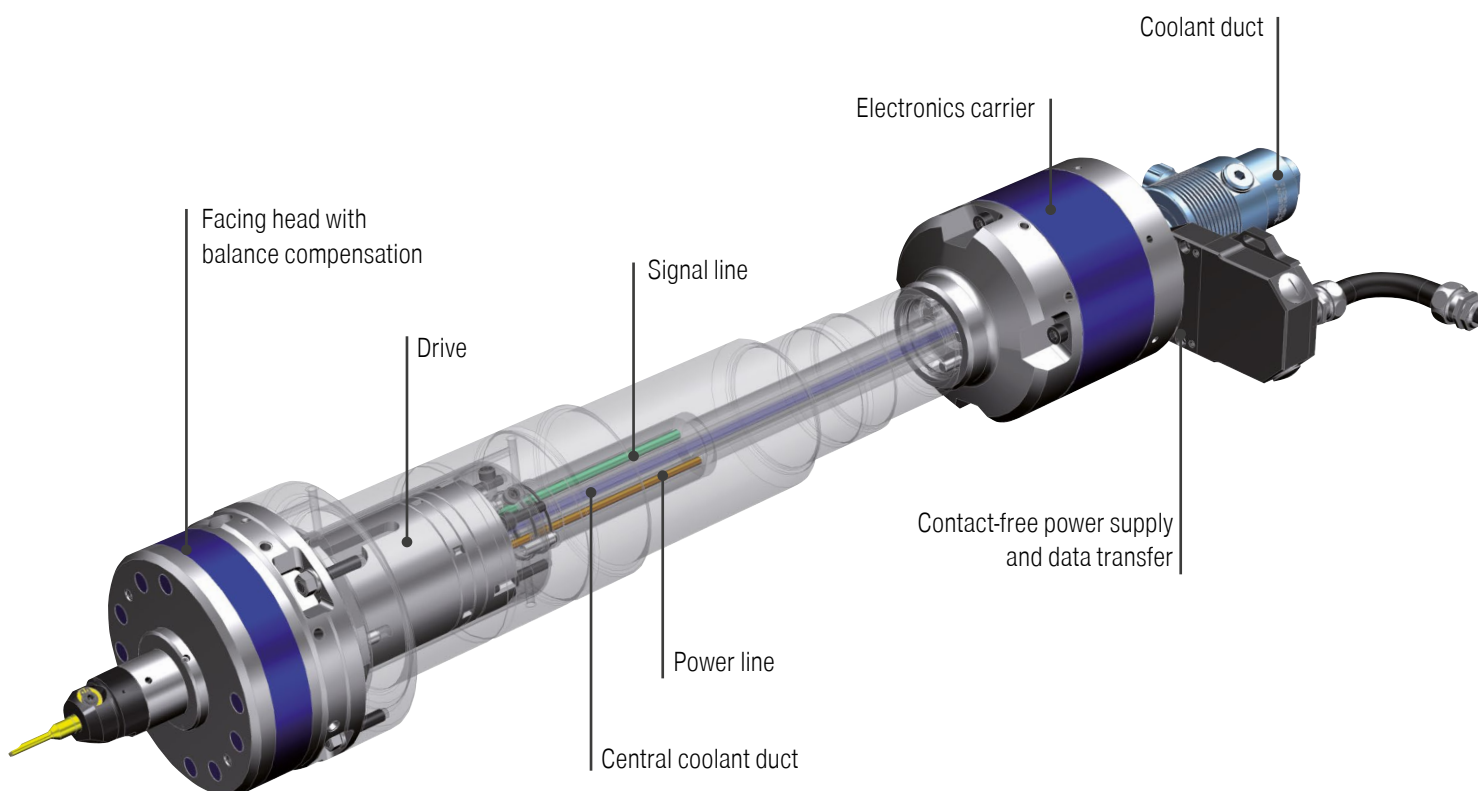
KOMtronic UAC

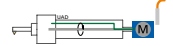
U Axis Cartridge

KOMtronic UAC system for spindle integration

- ▲ KOMtronic drive on the facing head integrated in the front side of the spindle
- ▲ No drive elements through the spindle (hollow centre, makes it easier for the media, e.g. MQL, to flow through), as a result bearing points are also not required.
- ▲ Short projection, maximum rigidity, special spindle design (bearings)
- ▲ Optionally available with direct encoder on the slide for increased accuracy requirements
- ▲ Simple installation of the draw bar tool with drive unit
- ▲ Suitable for higher speeds (for facing heads with balancing compensation)
- ▲ No positioning movement is introduced into the rotating spindle from outside, therefore there is no additional stress on spindle connection design

Adaption into machine tool control and spindle see page 30.





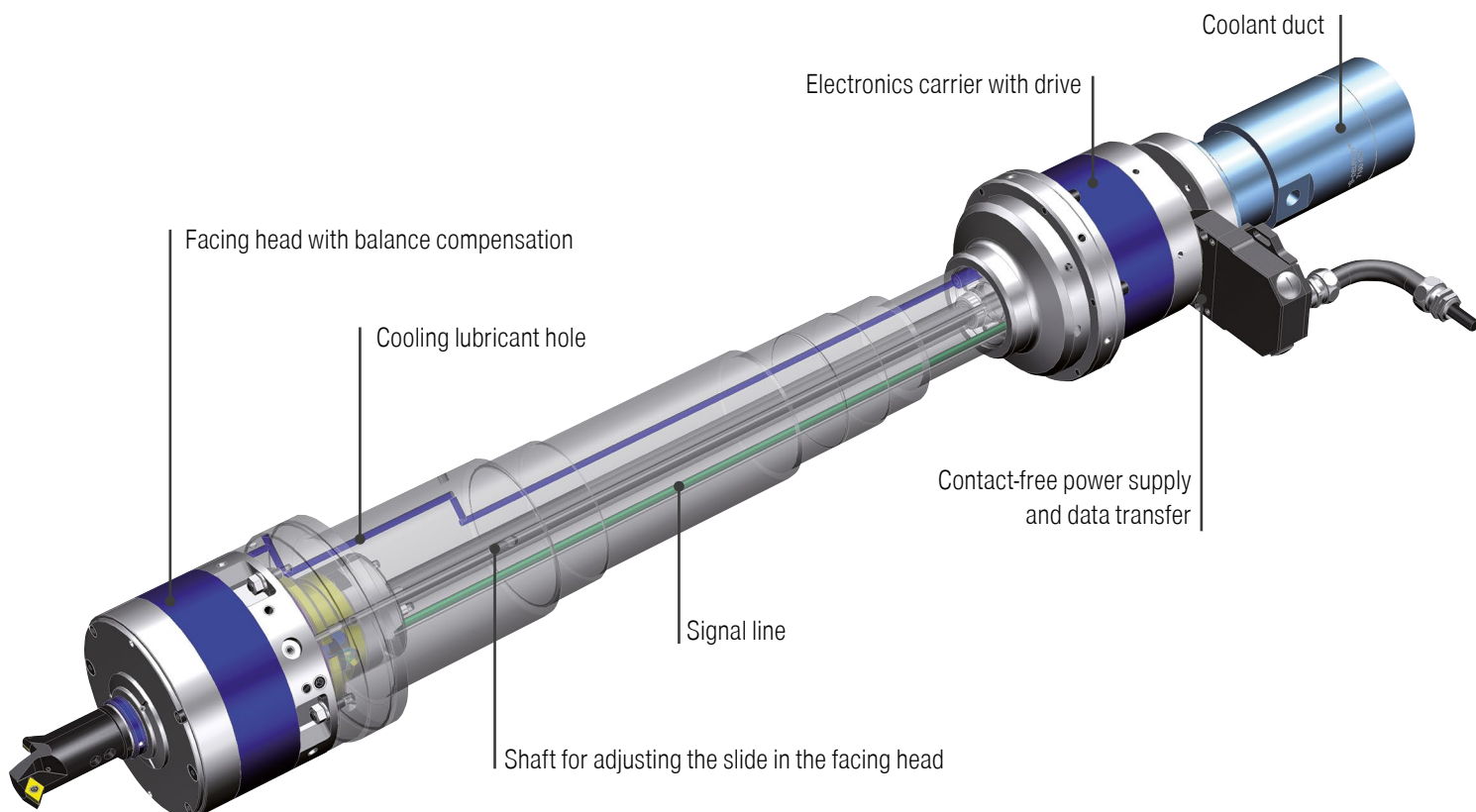
KOMtronic UAD

U Axis Drive

KOMtronic UAD system for spindle integration

- ▲ Electronics carrier with integrated servo motor (also rotating on the spindle end)
- ▲ No adjustment movements introduced into the spindle from outside. As a result, loads on the spindle system are reduced. The integrated electric servo drive on the spindle end also rotates and is supplied with electrical energy via a transformer that is also rotating. The data is also exchanged contact-free via the transformer that is also rotating.
- ▲ Well suited for "slide boring bars". The rotation of the shaft is converted in the slide boring bar into a translational movement.
- ▲ Optionally available with direct encoder on the slide for increased accuracy requirements
- ▲ Only a signal line through the machine spindle is required
- ▲ Small spindle bearing diameter possible

Adaption into machine tool control and spindle see page 30.

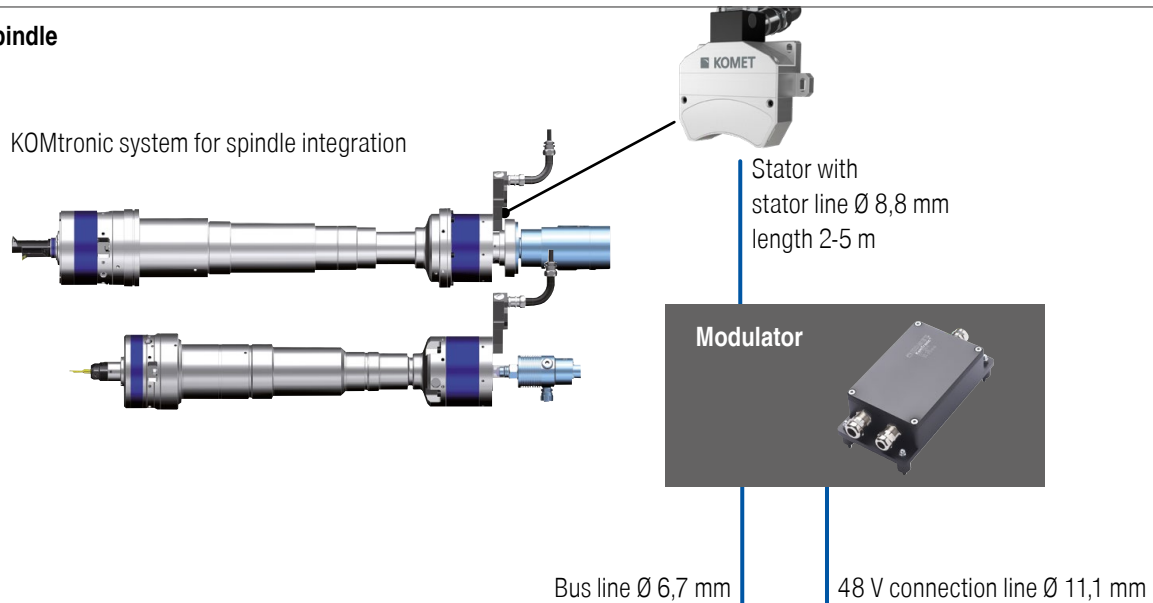




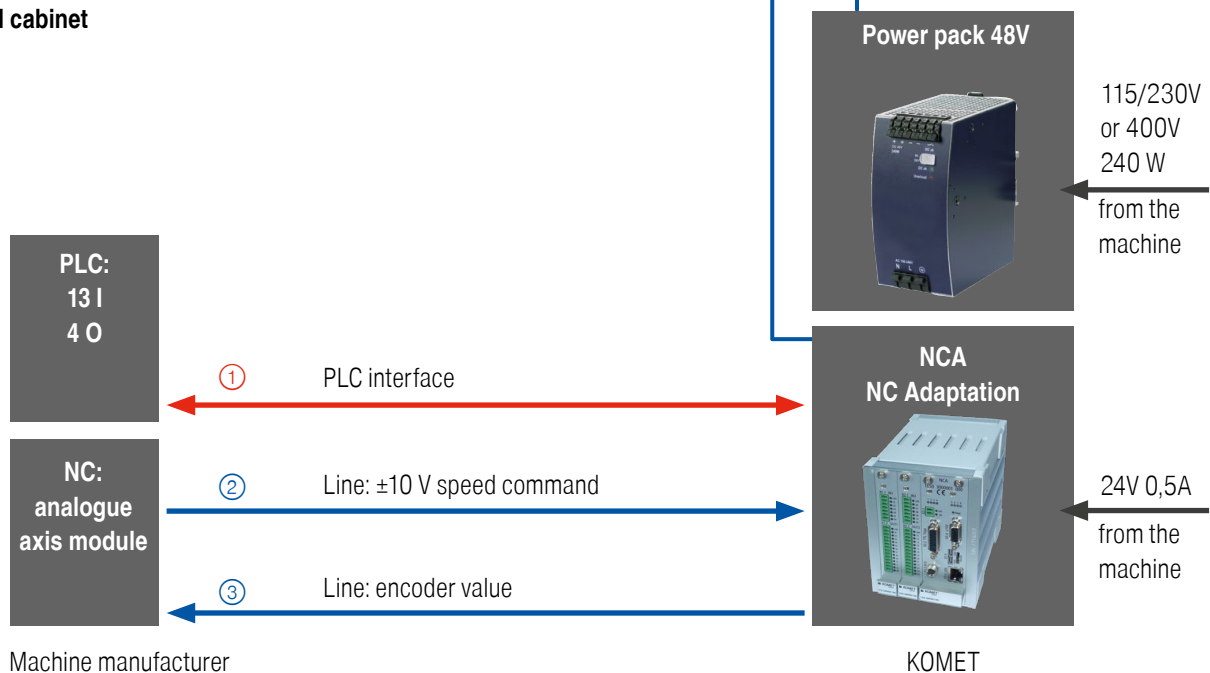
Adaptation into machine tool control and spindle (schematic overview)

Detailed schematic overview will be created based on the specific project.

Machine / spindle



Electrical cabinet



① PLC connection

13 inputs and 4 outputs are required on the PLC. 3 M-commands are required for selecting u-axis functions.

② Nominal value requirement

± 10 V nominal speed value from analogue axis module of NC control to the KOMET NCA.

③ Incremental actual position value

The current position is transmitted from the KOMET NCA to the analogue axis module for the NC control.

The following signal forms are available:

- ▲ TTL level (5 V) in acc. with RS 422, interpolated, square signal form
- ▲ 1 Vpp (1 V peak to peak), sine signal form

The KOMtronic u-axis system does not need a power unit on the NC control.

Questions and answers regarding U-axis tools

1. What level of accuracy can be achieved with the KOMtronic U-axis?

Without a measuring system on the slide ± 0.01 mm for the diameter, with a measuring system ± 0.005 mm for the diameter. The measuring system has a resolution of $< 1 \mu\text{m}$ (the level of accuracy that can be achieved depends on other machining influences, such as tool change errors, cutting edge wear, etc.).

2. How can the cutting insert position be corrected?

Each cutting edge can be corrected via the tool management area of the NC control system. Settings can also be made in this way for tools with short clamping holders.

3. Does the U-axis always need to be re-measured each time the inserts are changed?

No, the U-axis or slide is always in the same position. The insert position can be corrected directly in the machine via an in-process measurement.

4. Does the KOMtronic U-axis have to be removed from the machine to measure the tool?

No, it can easily be released using an interface connection (optional).

5. What is the RPM limit?

When the snap-on tool is mounted centrally on the slide so that the weight distribution is completely balanced the speed is max. 4000 rpm, stroke-dependent actuation.

6. Can the KOMtronic U-axis also be used for roughing?

A variety of machining processes can be used (finishing and roughing). The slide has a maximum power of 4000 N and a permissible torque of 200 Nm. However, the possible usage data depends on the overall length of the tool and the U-axis.

7. How is the U-axis driven?

The U-axis is driven by a servo motor. Slides in the UAS115/160 series are driven by a low-backlash roller screw drive.

8. What workpiece diameters can be machined?

The range of application is 0.5 – 500 mm, taking into consideration the relevant projection length and attachment point.

9. How many different diameters and cutting edges are possible?

There are several possible cutting edges depending on the NC control system and tool design.

10. How is the tool system set?

The U-axis is always changed in the central position. This enables the snap-on tool to be measured on a dummy in the presetting device. In addition, post-process measurement with automated cutting edge correction is possible via the tool management.

11. What about maintenance intervals and servicing?

Recommended 1x year or every 2 years at the latest.

12. How long is the expected service life?

With regular maintenance and care and the replacement of wear parts, a service life of >6500 operating hours is realistic, corresponding to approximately 10 years.

13. Can KOMtronic U-axes be used on multi-spindle machines?

Yes, taking into account the usual specifications for tools in multi-spindle machines.

14. What is the maximum size that can be machined with HSK63 or HSK100?

KOMtronic UAS-115: Up to dia. approx. 250 mm

KOMtronic UAS-160: Up to dia. approx. 500 mm

taking into consideration the relevant projection length and attachment point.

15. Are U-axes better suited to vertical machining rather than horizontal machining?

U-axes are used vertically and horizontally. Compare with the advantages and disadvantages of a conventional tool (centrifugal forces).

Installation support

In order to ensure that the KOMtronic U-Axis system is correctly incorporated into the machine and is able to carry out the required functions, the customer must provide clarification and comply with the necessary requirements:

1. Fitting the stator for non-contact power and data transmission to the KOMtronic U-Axis system. Care should be taken to ensure that no conflict occurs with other parts of the machine, the tool changer or similar units. KOMET's obligations do not include provision of the adaptor element for the stator unit.

2. The customer will supply the inputs and outputs required for the KOMtronic U-Axis system on the machine side. The analogue axis unit required for operation with the U-Axis must be provided and configured for the machine control system by the customer.

3. The customer must carry out the necessary software adjustments for the machine sequence control before the installation.

4. Function clarification: Process requirements must be met with reference to machine and processing concept. For example cycle times and machining data must be clarified. The tool changer must be designed for the tool weight and the tool must fit into the tool magazine.

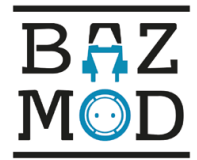
KOMET will provide the necessary assistance for clarification of the tasks as stated.

KOMtronic HSK-i

Research project BaZMod

Component-compliant machine configuration in manufacturing using cyber-physical additional modules.

KOMET has successfully led and completed the BaZMod research project with partners from industry and research. The BaZMod research project has resulted in the standardisation proposal of the HSK-i.



What is the significance of BaZMod?

To expand the machining spectrum in modern machining centres, an increased number of intelligent tools (cyber-physical modules – CPM) are being utilised that need to be supplied with additional data, energy or media.

Integrating transmission components into the tool spindle and the hollow shaft cone tool holder (HSK 63 form A) is intended to enable the transfer of these parameters via the machine/tool interface. Consequently, a standard is to be created for the future that will allow for manufacturer-independent, standardised connection of intelligent tools and/or CPMs.

As part of the BaZMod project (www.bazmod.de), the existing HSK interface has been expanded to include contacts on the end face for transferring data and energy.

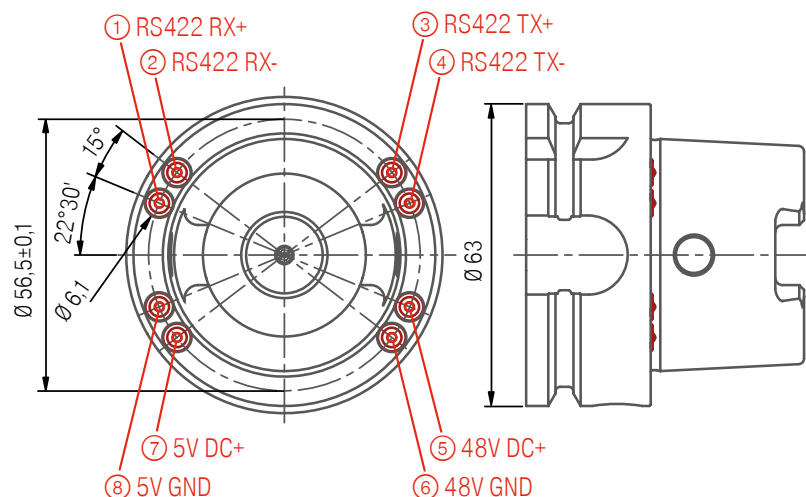
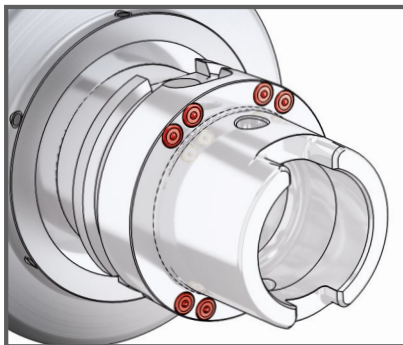
Aim of the standardisation proposal

The aim of the standardisation proposal is to establish the contact arrangement on the end face of the HSK interface and the basic specifications of the transmission. This should be implemented in the form of an expansion to the existing standards for the HSK interface. The precise position of the contact arrangement may differ from the positions shown here due to the ongoing standardisation process.

HSK-i

tool/machine interface

Status of the illustration: project completion



Contact allocation

There are provisions for eight contacts with the following signal assignment:

① RX+	Receive, input on the spindle side
② RX-	Receive, input on the spindle side
③ TX+	Transmit, output on the spindle side
④ TX-	Transmit, output on the spindle side
⑤ +48 V	High power supply
⑥ GND (48 V)	High power supply ground, not galvanically isolated
⑦ +5 V	Low power supply
⑧ GND (5 V)	Low power supply ground, not galvanically isolated

Data transfer

As per standard RS 422; 10 Mbit data rate with 8N1 (8 data bits, 1 start and 1 stop bit). Labelling must be made with regard to TX and RX.

Energy transfer

+48 V with max. 12.5 A; (max. 600 W)
 (±10% with ≤5% peak-to-peak ripple for outputs in the range between 50 W–400 W as well as ±20% with ≤5% peak-to-peak ripple for outputs in the ranges 0 W–50 W and 400 W–600 W)
 +5 V with max. 6 A (±5% with ≤2.5% peak-to-peak ripple)

Source

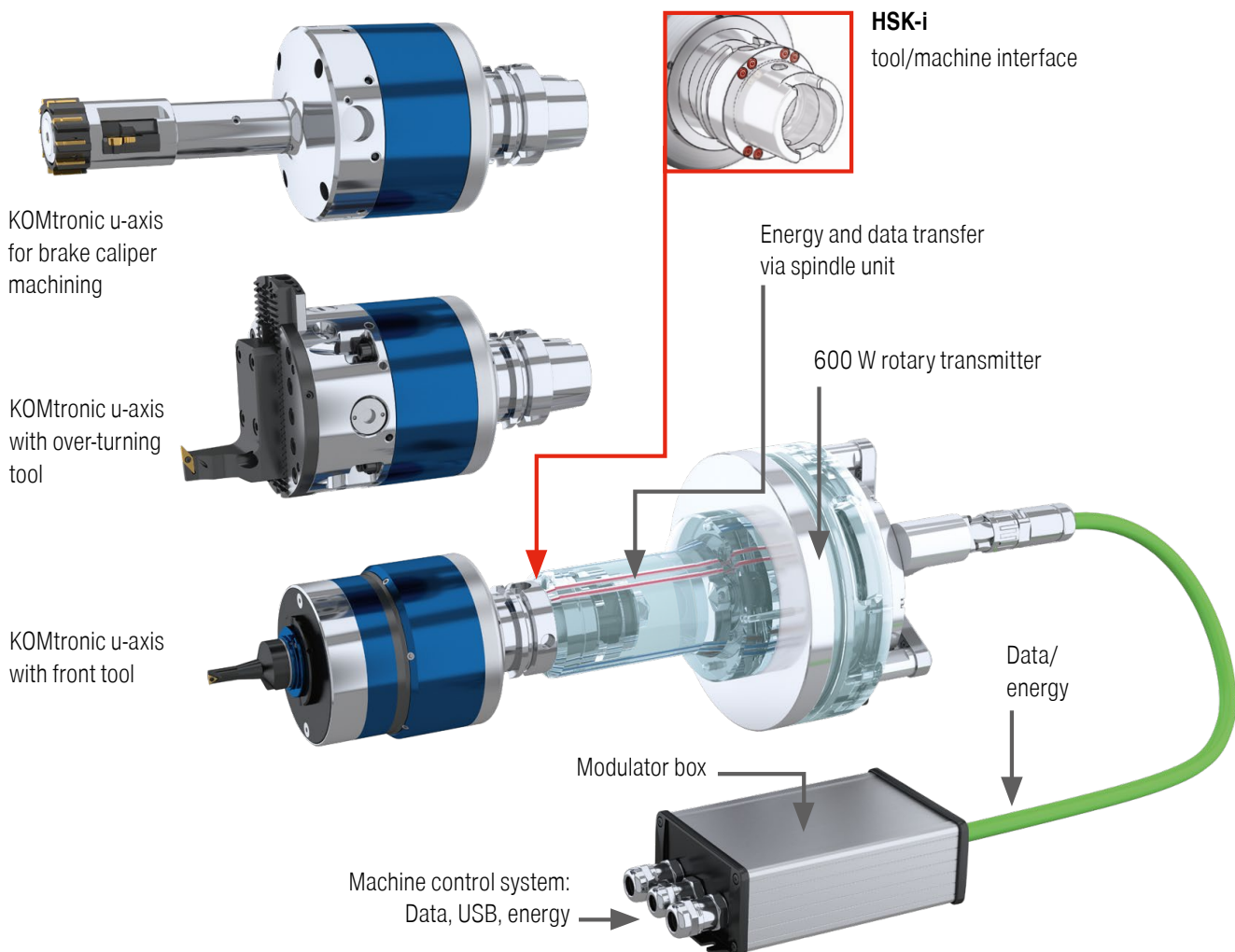
http://www.bazmod.de/img/FuE-Abschlussbericht_BaZMod.pdf

KOMtronic HSK-i

Standardisation of the communications peripherals with the machine control system and the CPS (cyber-physical system)



- ▲ Standardised HSK-i 63 interface
- ▲ CPS fitted with sensor and actuator for process monitoring
- ▲ Contact-free data and energy transfer at the spindle end
- ▲ Up to 600 W power transferable
- ▲ Can be switched between +5 V and +48 V
- ▲ Data transfer speed of 10 Mbit/s
- ▲ Transfer reliability through differential RS422 transfer
- ▲ Full duplex operation possible



Interested?

All the BaZMod technology from the machine equipment to the tool can be obtained from KOMET. Interested parties have the opportunity to inspect the project machine for themselves. Contact: Offer.Actuatingtools@ceratizit.com

KOMlife

Autonomous acquisition of
production data accurate to
the second



Autonomous acquisition and processing of production data directly on the respective tool

Advantages Benefits

- ▲ **Planned, preventative maintenance**
Regular, advance maintenance planning can increase tool service life and ensure workpiece quality at all times.
- ▲ **Digital production data acquisition**
Through a patented, dynamic QR code and the KOMlife app.
- ▲ **Assessment of tool use**
Conclusions can be drawn about the status and load of the cutting edge by gathering data on tool use.
- ▲ **Not dependent on tool manufacturer**
KOMlife can be easily integrated into new and existing linear and rotating systems, irrespective of the tool manufacturer.

Technical data

Lithium battery	CR2032
Battery life	Approx. 2 years
Min. acceleration	1,5 g
Min. tool diameter	50 mm

Actuating tools

Application

Special tools



cuttingtools.ceratizit.com/gb/en/komlife

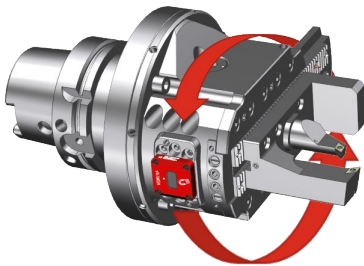


Ergonomic display unit

- ▲ Number of operating hours
- ▲ Current status of the maintenance interval
- ▲ Dimensions: 30 x 30 x 11 mm



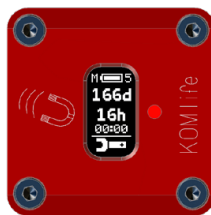
KOMlife
deactivated



Tool rotates



KOMlife
activated



Maintenance interval
reached

Customer-specific adaptation

- ▲ Adjustable maintenance interval depending on the application
- ▲ Visualisation of the necessary tool maintenance with a red, flashing LED



QR code
screen



Digital display of
production data

Patented, dynamic QR code

- ▲ Digital acquisition and export of production data via smartphone and KOMlife app
- ▲ Display of serial number and production data



**Try me out with the
KOMlife app!**

Free KOMlife app in the App Store
for iOS devices

KOMflex

Combined system with precision adjustment head and BLUM measuring probe technology

Unique, automated compensation system

In conjunction with the BLUM measuring probe, the KOMflex enables automated diameter correction for precision holes in unmanned closed-loop operation. The KOMflex precision adjustment head communicates with the BLUM wireless machine equipment.

Compensation of cutting edge wear, e.g. in the case of steel

System usage

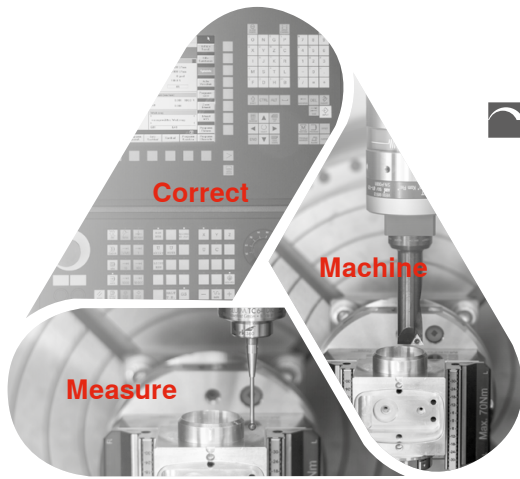
Temperature compensation, e.g. in the case of aluminium

Advantages Benefits

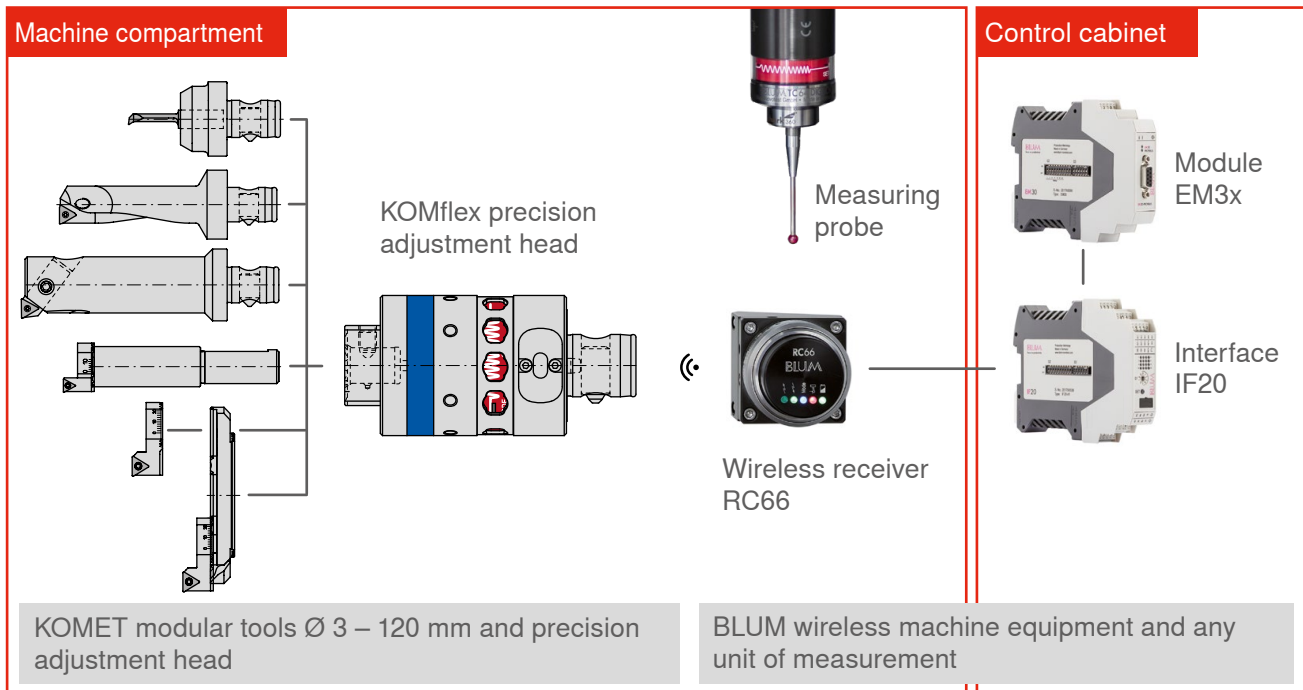
- ▲ **Automated production of precision holes**
Thanks to closed-loop operation, the KOMflex guarantees process-secure machining, even in the case of unmanned operations.
- ▲ **Significant time savings**
Thanks to automated measurement with the BLUM measuring probe and correction with the precision adjustment head.
- ▲ **Ensures the defined quality requirements for the workpiece are met**
Thanks to accurate movement of the precision adjustment head for µm-precise machining with closed-loop operation.

Technical data

Adjustment accuracy	1 µm in radius
Adjustment range	± 0.25 mm
Boring range	Ø 1 – 120 mm
Outer diameter	63 mm
Height	100 mm
Max. RPM	8,000 rpm in centre position
Combined tool interface	ABS 32 / dia. 16 mm / teeth
Interface	ABS 50



**Combines the production steps
from machining to quality
assurance in a closed-loop
system**



The ongoing automation of our production processes will enable us to continue to manufacture our products cost-effectively in future. The KOMflex is the ideal solution for closed-loop operation. This is where we need innovative, forward-thinking partners like CERATIZIT.

Michael Renz, Head of the Actuating Tools product line at KOMET Deutschland GmbH (left),
Alexander Schweiher, Senior Manager at Schweiher Werkzeugbau GmbH & Co. KG (right)



Service & Maintenance

for actuating tools KOMdrive / KOMtronic

Our SERVICE

- ▲ Visual inspection
- ▲ Disassembly and cleaning
- ▲ Analysis of the current state
- ▲ Replacement of all sealing elements
- ▲ Assembly, functional testing and creation of a test log
- ▲ In the event that repairs are necessary, we will create a fair offer with a binding delivery date

Our SERVICE PLUS

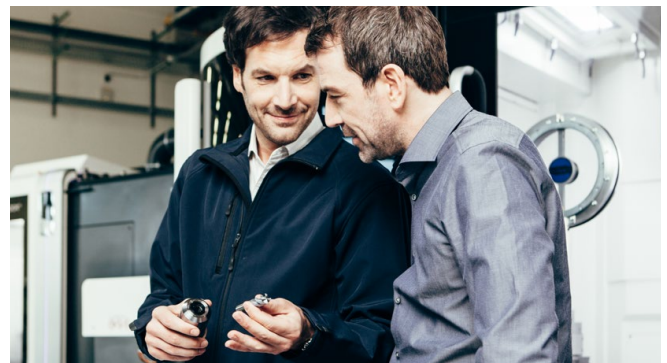
We offer service agreements designed to match the specific requirements of our users:

Expanded SERVICE PLUS with:

- ▲ Provision of defined wear parts
- ▲ Short-term repairs thanks to our Express Service for corrective maintenance of actuating tools

And if repairs do become necessary: No problem.

Repair or maintenance work on head and base elements should only be repaired or serviced at the CERATIZIT location in Besigheim, Germany (KOMET). All actuating tools are in a mechanically as-new condition when they leave our assembly department. In order to prevent production downtimes, we recommend procurement of a replacement tool.

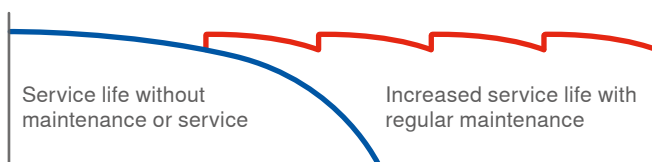


Maintenance recommendations

Precision tools are often subject to difficult operating conditions in the machining process, where swarf, dirt, cooling lubricants and mechanical stresses lead to high levels of wear, compromising the quality of the finished end product and often causing reduced process capacity.

Regular maintenance prevents expensive repairs. Planning maintenance at an early stage significantly reduces the risk of machine downtimes.

Conclusion: Regular maintenance increases the service life of actuating tools and the cost-effectiveness of the system as a whole.



An initial assessment is carried out at a set time. An individual maintenance plan will be developed on the basis of the operating conditions.

Maintenance intervals

These guideline values may vary depending on the specific application.

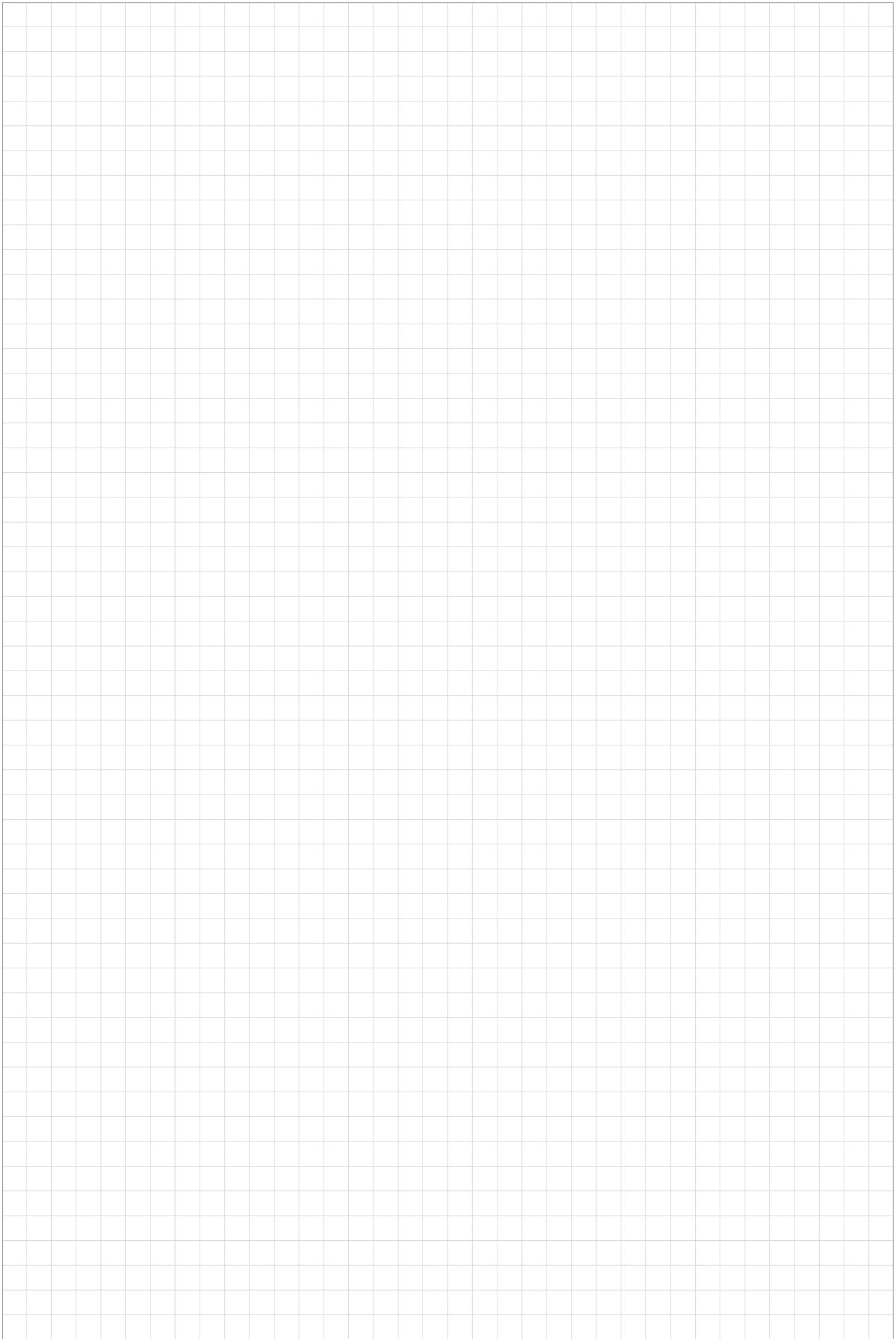
Tool	Lubrication	Maintenance intervals
KOMtronic U-axis systems	Permanent	6000 – 8000 operating hours at least once every two years
Facing heads with draw bars	Central, automatic lubrication cycle	8000 – 10000 operating hours 7 million strokes
Contact actuation tools	Manual	3000 – 4000 operating hours
Slide boring bars	Manual	8000 – 10000 operating hours

New KOMlife maintenance system

Autonomous acquisition of production data accurate to the second

The operating data will be provided via dynamic QR Code. It can be used on various systems.





UNITED. EXPERIENCED. METAL CUTTING.



**SPECIALIST FOR INDEXABLE INSERT TOOLS
FOR TURNING, MILLING AND GROOVING**

The product brand CERATIZIT stands for high-quality indexable insert tools. The products are characterized by their high quality and contain the DNA of many years of experience in the development and production of carbide tools.



**THE QUALITY LABEL FOR
EFFICIENT BORE PRODUCTION**

High-precision drilling, reaming, countersinking and boring is a matter of expertise: efficient tooling solutions for drilling and mechatronic tools are therefore part of the KOMET brand name.



**EXPERTS FOR ROTATING TOOLS,
TOOL HOLDERS AND CLAMPING SOLUTIONS**

WNT is synonymous with product diversity: solid carbide and HSS rotating tools, tool holders and efficient workholding solutions are all part of this brand.



**CUTTING TOOLS
FOR THE AEROSPACE INDUSTRY**

Solid carbide drills specially developed for the aerospace industry bear the product name KLENK. The highly specialised products are specifically designed for machining lightweight materials.