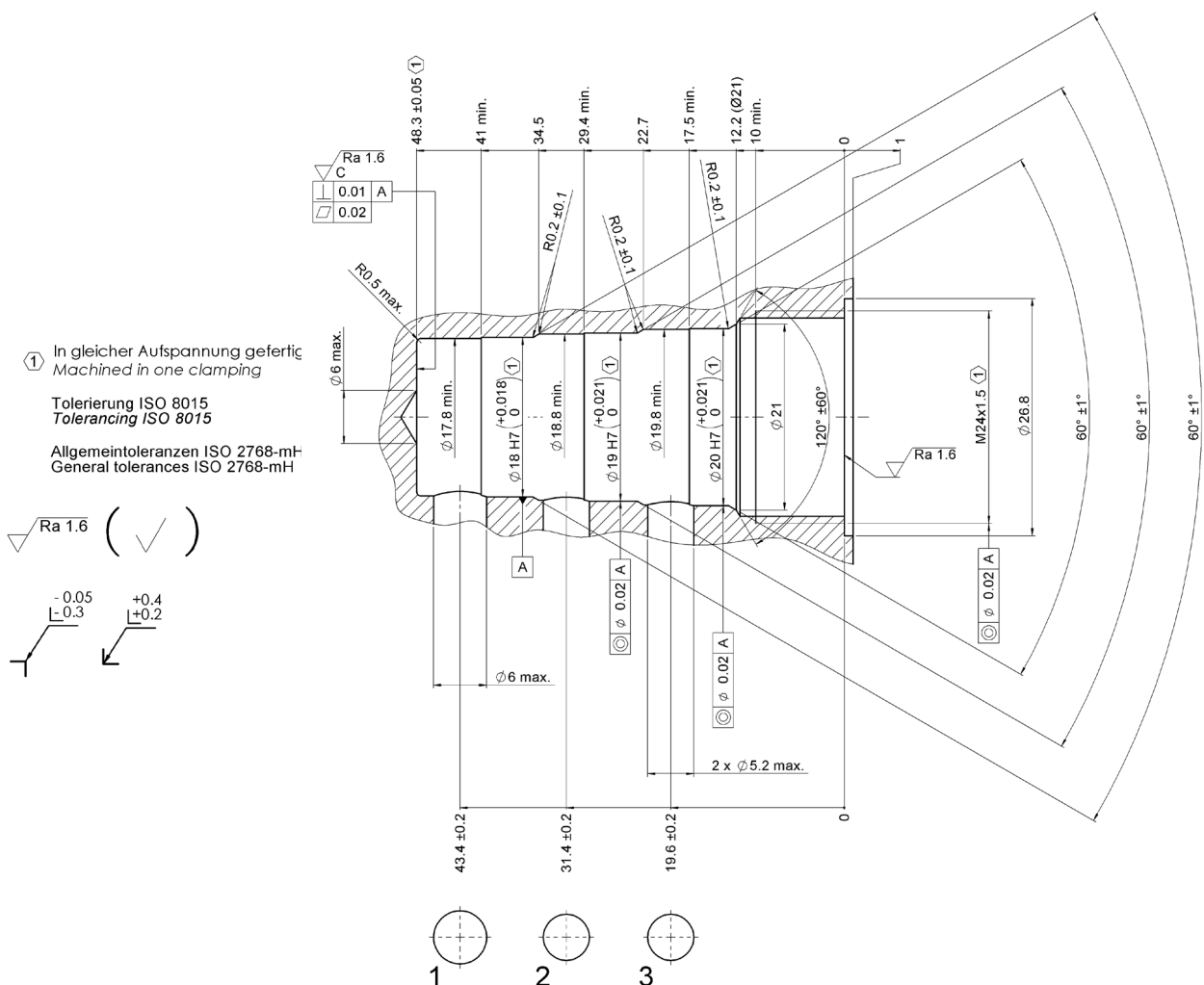


Manufacturing Process and tools

3/2 - way cavity

1. Drill max. $\varnothing 17.5$ for pre-drilling up to and including calotte $\varnothing 6$ max.
2. A solid carbide step drill part no. 4652678*. For the floor, $\varnothing 17.8$, $\varnothing 18.8$ with 60° slopes up to $\varnothing 19.8$
3. A solid carbide step milling cutter for circular milling part no. 4652679**. For the 60° bevel from $\varnothing 20H7$ to $\varnothing 21$, thread core hole with chamfer and $\varnothing 26.8$
4. Thread milling cutter 1.5 mm , manufactured in the same clamping as point 2. (stepdrill)
5. Standard reamers or a standard end mill for circular milling for $\varnothing 18 H7$, $\varnothing 19H7$ and $\varnothing 20H7$
6. Deburring



* Gühring-No.: 377010335

** Gühring-No.: 377010334

Bieri disclaims any liability in case of incorrectly manufactured cavity.