



powered by water



The waterdriven backspotfacer developed by Granlund Tools

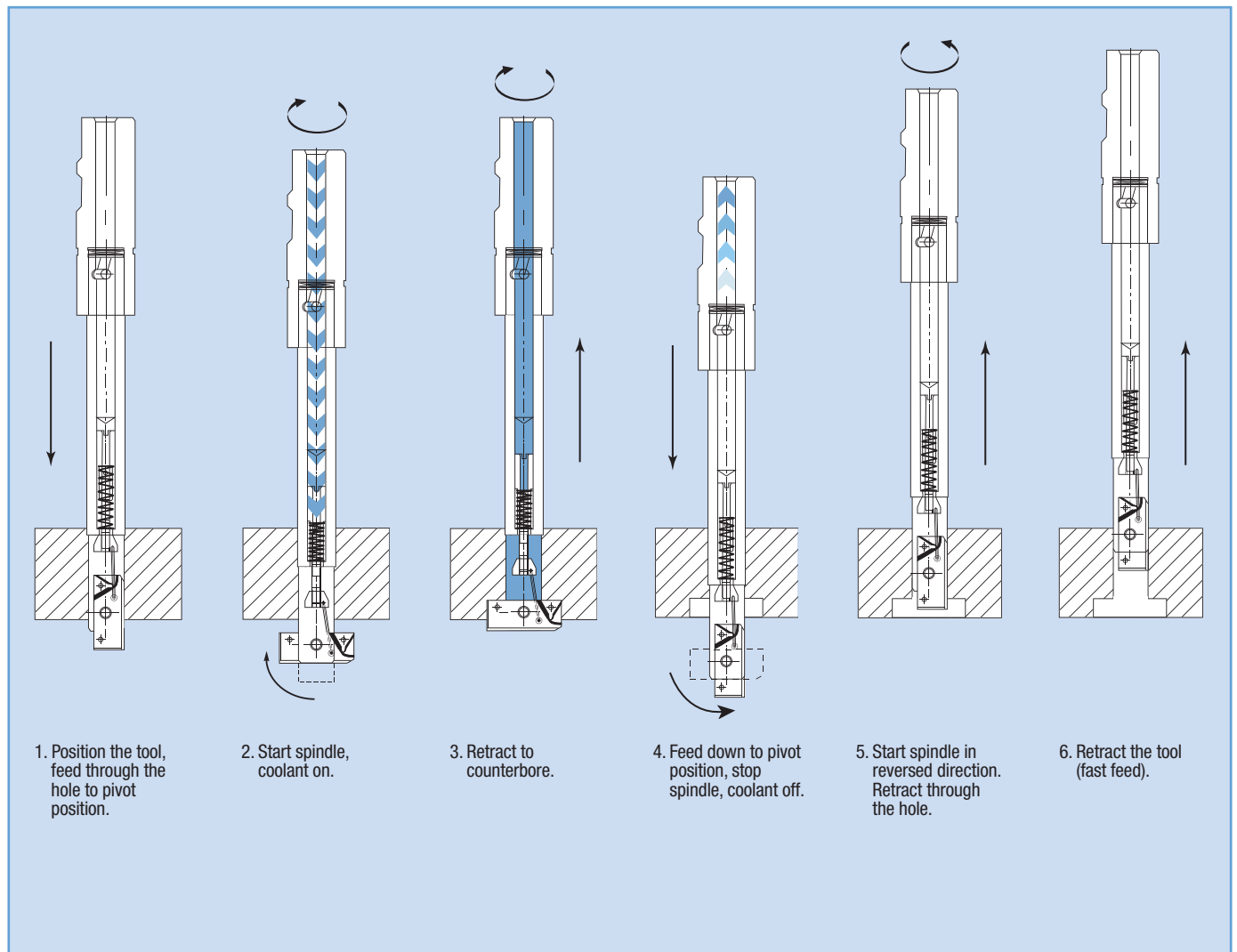
With the Neptune backspotfacer you can produce spotfaces of up to 2 times the diameter of the hole. As a special the tool can be manufactured for an even wider range.

Neptune is powered by coolant through the spindle. It operates using a piston in the shank, which pushes the insert holder out.

The Neptune is a combination tool, where you can strip, and clean the parts, change insert holder for another dimension etc.

The tool is also equipped with an “emergency” function. The shank separates from the holder in case the insert holder doesn’t retract properly. The spindle needs to be reversed during retraction after the spotfacing to ensure that the emergency function operates.

All friction parts are coated with a low friction coating to ensure the function of the tool.



Cutting data for backspotfacer type NE

Workpiece	Speed	Feed
Steel <450 N/mm	50-100 m/min	0,05-0,15 mm/rev.
Steel <600 N/mm	60-110 m/min	0,05-0,15 mm/rev.
Steel <1000 N/mm	50-100 m/min	0,05-0,15 mm/rev.
Cast iron	80-100 m/min	0,10-0,15 mm/rev.
Cast aluminium	80-150 m/min	0,05-0,15 mm/rev.

Operating reversed during retraction

Speed	Feed
400 rpm	500 mm/min

N240 G73 Z600 M5
 N250 G73 X710
 N260 M6
 N270 G57 H901
 N280 G43 Z100. H3 S770
 N290 X0 Y0
 N300 Z50.
 N310 G1 Z-50. F500
 N320 M50
 N330 M3
 N340 G1 Z-33. F200
 N350 G1 Z-27. F77
 N360 G0 Z-50. M9
 N370 G4 P5
 N380 S400 M4
 N390 G1 Z50. F500
 N400 G73 Z600 M5
 N410 M60
 N420 G53
 N430 M30
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Application example:

Tool:
NE-17,0/33,0
 Workpiece:
SS 1672 t=33 mm
 Spotface: 3 mm

Sparepart kit

Type	1 set contains:	
NESK-13	2 x Link	1 x Distributor
NESK-15		
NESK-17		
NESK-19		
NESK-21	1 x Spring	1 x Screw
NESK-23		
NESK-25		
NESK-33	2 x Axle	4 x Nut

CAUTION!

Do not operate the tool as single flute. If going into a slope, feed should be reduced to at least 50%.



NEPTUNE

Part No.	Inserts	Screws	d_1	D	L_1	L_2	L_3	Shank Weldon
NE-13,0/26,0	TPMT-07T	SSK-20-S	13	26	90	10	26	25
NE-15,0/30,0		SSK-20-S	15	30	90	10	30	25
NE-17,0/26,0		SSK-20	17	26	110	10	26	25
NE-17,0/33,0	TPMT-10T	SSK-22-S	17	33	110	10	33	25
NE-19,0/36,0		SSK-22-S	19	36	110	10	36	25
NE-21,0/33,0		SSK-22	21	33	110	10	33	25
NE-21,0/40,0		SSK-22	21	40	110	10	40	25
NE-23,0/43,0		SSK-22	23	43	110	10	43	32
NE-25,0/40,0	TPMT-17T	SSK-22	25	40	125	15	40	32
NE-25,0/48,0		SSK-40	25	48	125	15	48	32
NE-33,0/61,0		SSK-40	33	61	140	30	61	40

Important!

- Coolant through the spindle or by means of a coolant adapter is required to operate the tool. For reliable operation the pressure should be ≥ 3 bars and the flow ≥ 30 l/min. Before using the tool, make sure that the insert holder pivots freely, lubricate and clean if necessary.

