

Benz Live Tool Duty Cycles

The maximum rpm is 6,000 rpm for 1 1/2 minutes and then an 8-minute cool down.
You can run a reduced rpm for 4 minutes at 4,500 rpm and then a 6-minute cool down.

**Parameters apply to both Benz BMT65 and VDI40 ER32 holders*

For longer periods, here are some direct contributing factors to the heat cycle:

- Material hardness
- Material machinability
- Coolant on vs. coolant off
- Coolant condition- lean or rich or dirty
- Chip load (SFM, DOC, and stepover)
- Cutting tool coating and recommended run parameters (cutting tool technologies)

Many times, longer cycles on a turning center are for 3D contouring or engraving. In these cases, we recommend high-speed live tool holders. This will also take the stress off the components linked to the mill drive kinematics of the machine tool if they stay under max limits.

Customers can also split the operation over more than one live tool if they have available stations on the turret. They can also check the temp of the holder during the first few parts to make sure the temp is stabilized. The max operating temp is 158° Fahrenheit.



EXSYS Eppinger Live Tool Duty Cycles

You can run a 75% duty cycle over a 1 min duration at max rpm (45 sec on, 15 sec off).

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- Material hardness
- Material machinability
- Coolant on vs coolant off
- Coolant condition - lean, rich, or dirty
- Chip load (SFM, DOC, and stepover)
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