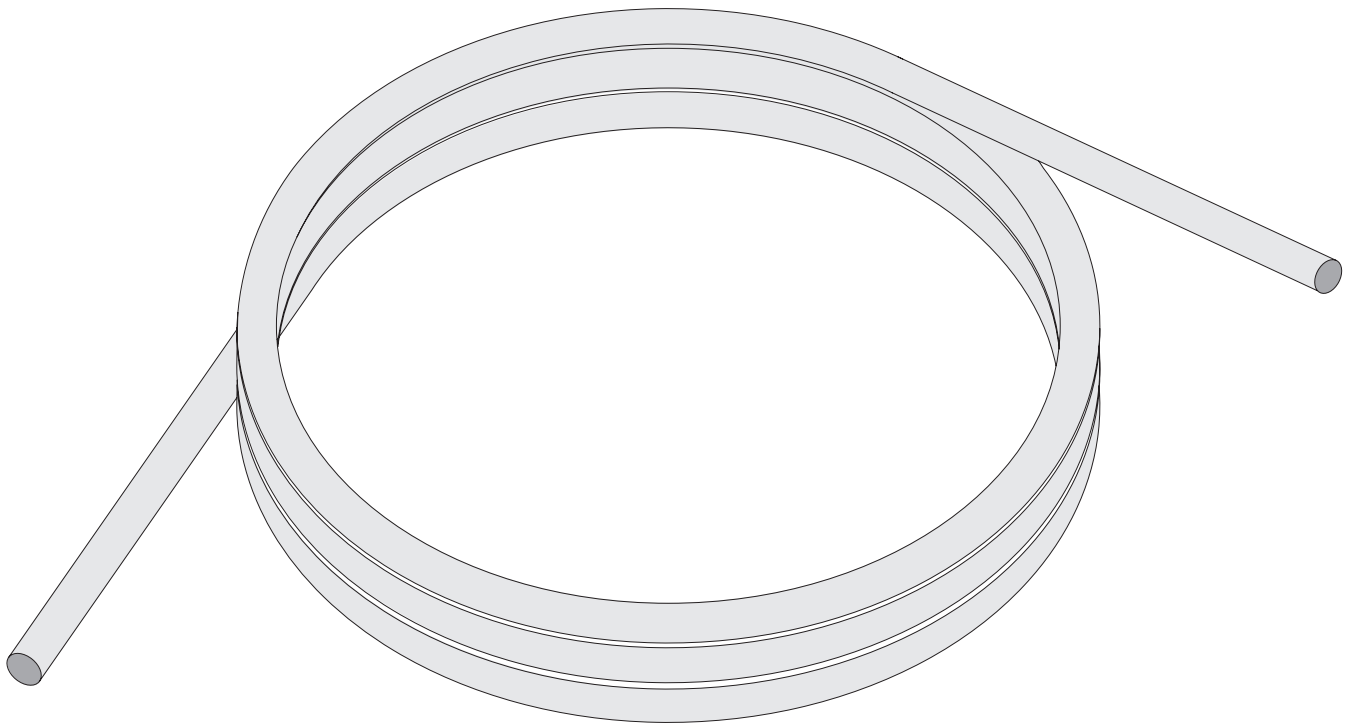
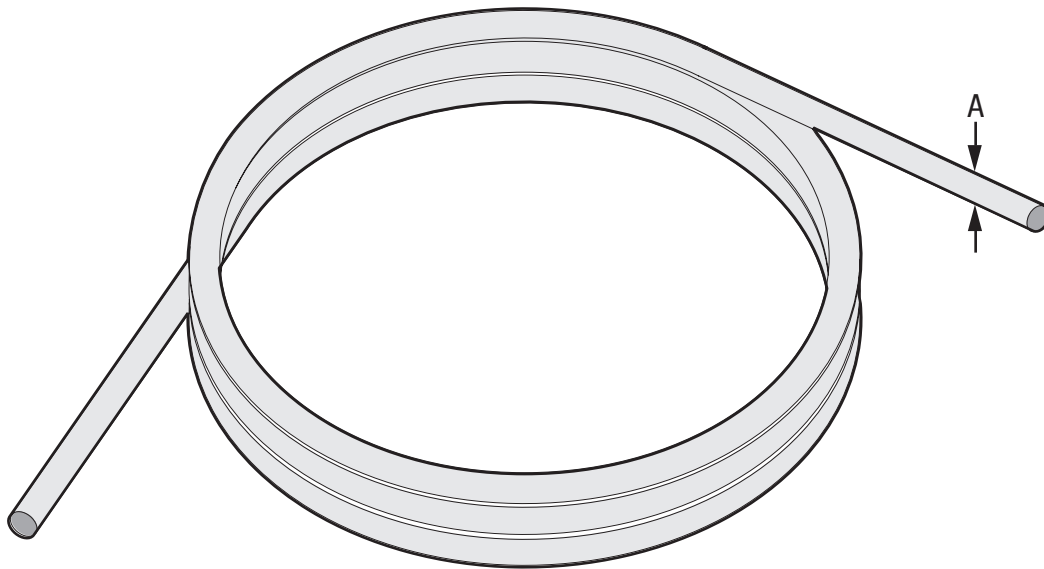


JV_VACUUMJET SEAL

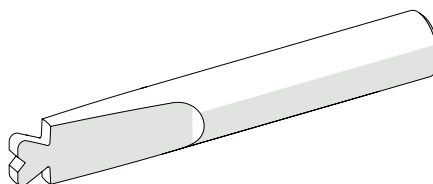


WHAT'S INCLUDED IN THE PACKAGE



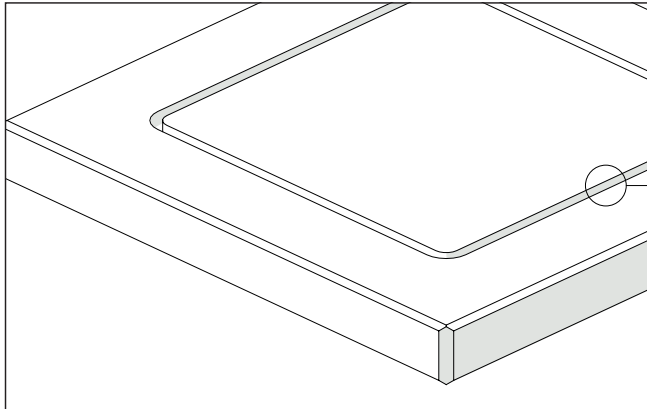
Ref.	A	Length
JV.030200	3	2.000
JV.050200	5	2.000

CUMSA Recommends **ST** tool to install **JV**

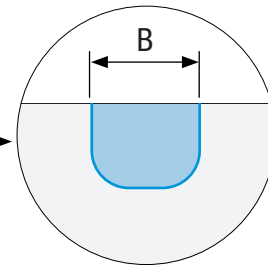


JV_INSTALLATION PROCESS USING ST TOOL

1

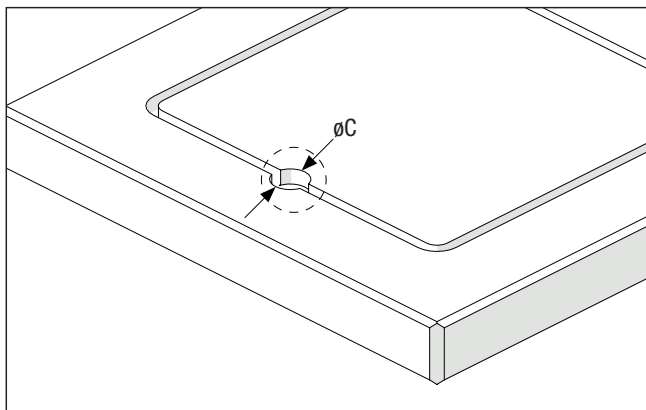


Mill with a cylindrical cutting tool



Ref.	B
JV.030200	1.5
JV.050200	3.2

2

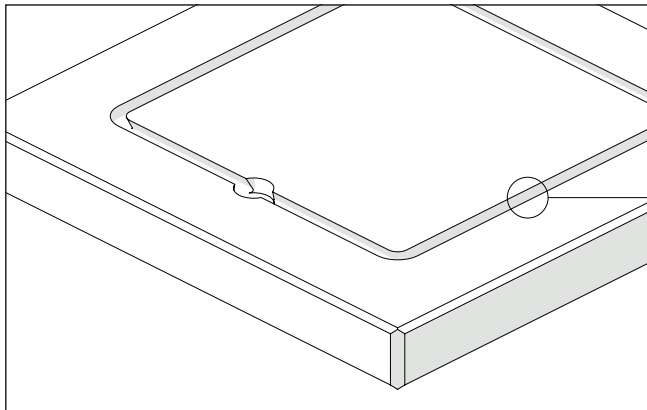


Mill an entrance for the **ST** tool.

Ref.	C
JV.030200	Min. 5
JV.050200	Min. 9

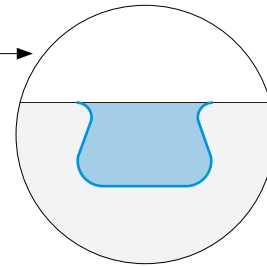
JV_INSTALLATION PROCESS USING ST TOOL

3



Mill with the

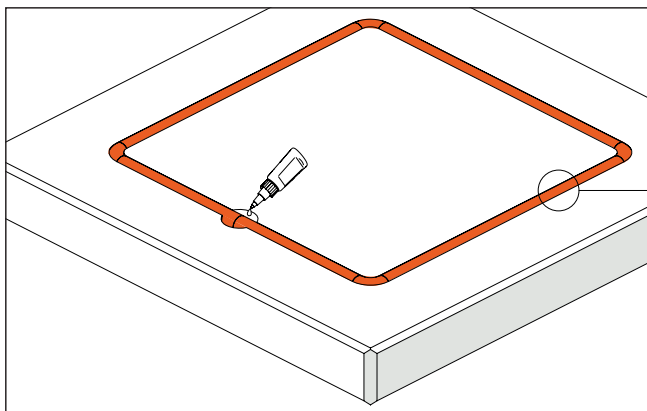
ST



ST Milling parameters

Material	JV.030200 (ST.030200)		JV.050200 (ST.050200)	
	AC 42CrMo4	AC.T. 100g	AC 42CrMo4	AC.T. 100g
Hardness	50 Hrc		50 Hrc	
Vc	50m/min	100m/min	50m/min	100m/min
rpm	7.900	15.800	4.500	9.000
fz	0,06mm/d	0,010mm/d	0,007mm/d	0,012mm/d
Vf	95mm/min	315mm/min	65mm/min	215mm/min
ae	0,9mm radial	0,9mm radial	1,65mm radial	1,65mm radial
ap	2,7mm	2,7mm	4,3mm	4,3mm

4



Use the silicon to joint the

JV

