Bluechip Tooling Ltd 203 Torrington Avenue Coventry CV4 9UT Tel. 024 7647 4819 Fax. 024 7647 4820 info@bluechiptooling.co.uk

ROLL MARKING

In-process part marking on CNC or conventional lathes and Machining Centres

Using Böni marking tools components can be marked on the periphery or face, in just a few seconds, on CNC lathes or machining centres.

It's easy

Manual or special purpose machine marking is usually complex, unreliable and work intensive. With Böni marking tools, the workpiece leaves the lathe or milling machine with a finished text. The inscription is identical throughout a production run, saving time and money.

Using segmented wheels the desired inscriptions can be made up at any time by changing individual letter, number or symbol elements. That means more flexibility. Available standard type heights: 2.5mm, 3mm and 4mm.

Standard marking wheels are engraved from solid and the text stands proud of the base. Special wheels can be supplied for any texts, logos, trademarks and type heights desired.

Radial marking on a periphery

With the spindle running (4 - 8 m/min) the text length is marked, in one pass, so it is impossible for the text to be overwritten. As soon as the text is completed and the tool has retracted, the spring loaded marking wheel automatically returns to its starting position. The marking tool is then ready for the next inscription.

Due to the short rolling motion of the marking wheel, workpieces of different diameters requiring the same text can be marked with the same wheel. Until now, a separate marking wheel was needed for each workpiece diameter. Furthermore, it is possible to place multiple or different texts on one marking wheel. When using the C-axis, text can be positioned accurately at any given point on the circumference.

Tangential marking on the periphery with a supporting wheel

Roll marking with supporting wheel; The supporting wheel is mounted opposite the marking wheel and prevents flex during the process. As the marking is done tangentially no pressure is exerted on the work and cross spindle bearings, the tool absorbs all operating forces.

The design and function of the marking wheels are identical to those used when radial marking

Axial marking on faces

When using the C-axis the text can be positioned accurately at any point on the required diameter of the workpiece face.

Axial marking on flat surfaces

On machining centres, the tool is advanced to marking depth with the spindle stopped, and then rolled along according to the length of the text.

Every tool is supplied with operating instructions

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CHOOSING A ROLL MARKING TOOL

It's simple; copy this page, fill in the details and fax it to Bluechip Tooling Ltd. We will then submit our quotation for your consideration.

Name _____ **Position** _____

Company _____

Address _____

Telephone _____ **Fax** _____

Email _____

Machine _____ **Description** _____

Lathe (tick appropriate boxes) **Marking on the circumference** ☐ **Marking on a face** ☐

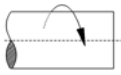
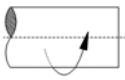
Toolholder required **RH** ☐ **LH** ☐ **Shank** _____ **mm square** **Marking diameter** _____ **mm**

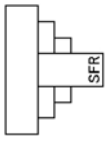
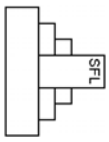
Up to a shoulder? **Yes** ☐ **No** ☐ **If in a groove: Width**_____**mm x Depth**_____**mm**

Does the text require exact positioning on the circumference of the workpiece? **Yes** ☐ **No** ☐

If Yes do you have either of the following? **C-axis** ☐ **Indexing spindle** ☐

If you do not have a C-axis or indexing spindle you will require startdots.

Rotation of spindle **Right Turn**  ☐ **Left Turn**  ☐

Text Direction **Base to right**  ☐ **Base to left**  ☐

Text Height _____ **mm** **Text required** _____

Marking on a machining centre ☐ **Toolholder Shank** _____**mm diameter**

Marking with exchangeable segments **Text Height** **2.5 mm** ☐ **3.0mm** ☐ **4.0mm** ☐

Material _____ **Hardness** _____

Please attach a sketch of the application or a workpiece drawing plus additional details (logo etc., If required)