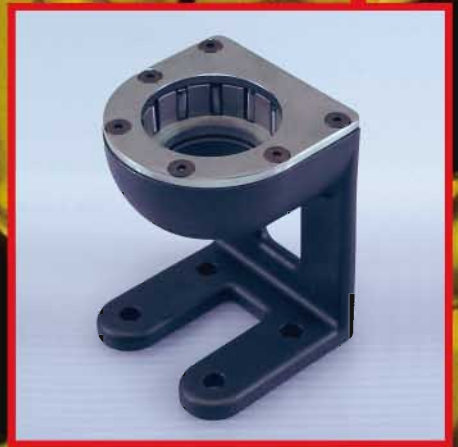


# CANELA

*Highlights*





# CANELA

Canela introduces the new Tool and Die High productivity indexable cutter series. This new series are specially specially designed to cover all tool and die milling needs. The large selection of tools allows all machining applications, medium to large die cavities, copy milling, shouldering, plunging, helical interpolation, face milling and ramping.





## TOOL & DIE

All cutter series incorporates the latest cutting insert geometry, netting the customer great productivity through freer cutting action and lower horsepower consumption, this fact combined with high precision inserts provides longer tool life and higher machining efficiency.



**GA**



**GN**



**GX**



## Tools for ceramic inserts

The Canela's ceramic system offers the possibility to mount two different clamping systems in the same basic holder. By replacing the Spare parts each insert can be assembled in a fast and easy way.

**CX** Notch clamping



**CD** Clamping element with thrust plate (for short-chip material)



## CF Geometry

CF chipbreakers are engineered for light finishing operations at high speeds in the 0.08 mm to 0.3 mm feed range at cutting depths ranging between 0.2 to 2.5 mm.

Main application area:

Cutting depth ( $A_p$ ): 0.2 2.5 mm

Feed ( $f$ ): 0.08 0.3 mm



## CM Geometry

CM chipbreakers provide a positive rake angle with land for high edge strength in medium duty applications on a wide range of materials. Recommended for general purpose use on all types of steel.

Main application area:

Cutting depth ( $A_p$ ): 1.0 3.5 mm

Feed ( $f$ ): 0.15 0.35 mm



## CS Geometry

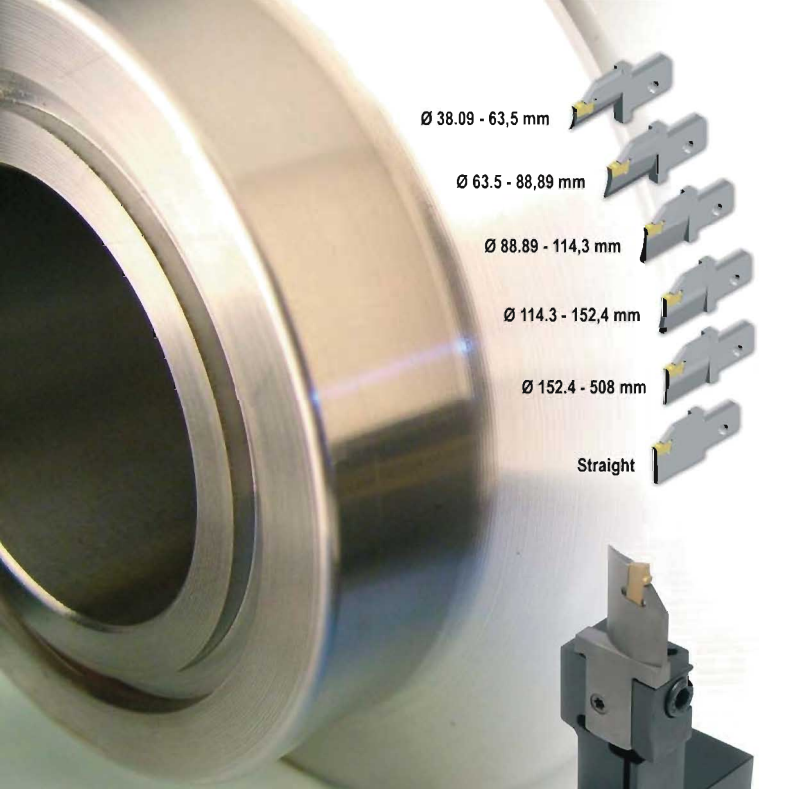
First choice for stainless steel. CS chipbreaker provides excellent chip control with low cutting forces.

Main application area:

Cutting depth ( $A_p$ ): 0.5 4.0 mm

Feed ( $f$ ): 0.15 0.5 mm





Ø 38.09 - 63,5 mm



Ø 63.5 - 88,89 mm



Ø 88.89 - 114,3 mm



Ø 114.3 - 152,4 mm



Ø 152.4 - 508 mm



Straight



## CZGB & CZGF

THE BEST CHOICE FOR THE HIGHEST PRODUCTIVITY

The modular face grooving, cut off and OD grooving, covers multiple applications. By replacing the indexable blades.

The 120° ground bottom prism seating surface ensures an exceptional clamping rigidity and precise insert positioning. Deep grooving is possible due to its single side insert enhanced by PVD TiAlN grades.



# Automatic Lathe

The Canela's micro-tools series offers indexable inserts suitable for automatic CNC lathes. The indexable inserts replace conventional brazed tools lead to short set up time and elimination of re-grinding.

Indexable insert covers almost kind of machining of automatic CNC lathes, front turning, cut off, back turning, grooving, threading and boring are general applications. The holder shank can be selected from 8 to 16 mm.



43,8

15,1 8,3 20,4

DIN 2080



MAS BT

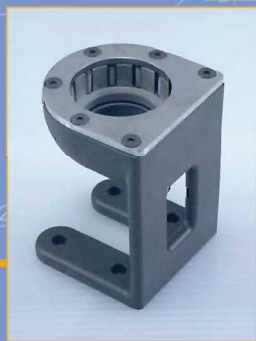


CAT



# ASSEMBLY FIXTURE

Unique patent pending self-lock assembly fixture system for assembling and dismantling all type of holders, there is no need to have different assembly fixture for each holder anymore, do it all in one.



REF.

Type

02.30.70 - 02.30.71

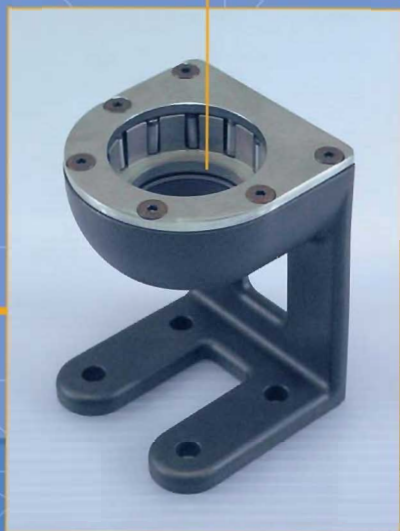
02.40.70 - 02.40.71

02.50.70 - 02.50.71

BT 40 - HSK 63 - DIN 2080 40 - DIN 69871/A 40 - CAPTO C6 - KM 63

DIN 2080 50 - DIN 69897/A 50

BT 50 - HSK 100



IU+220564A

R49.5

160

130

60

120°

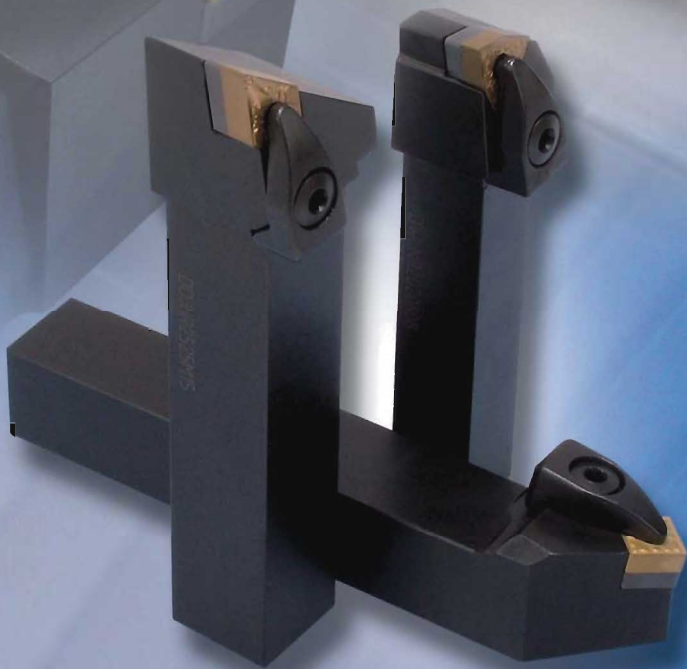
IU+220588

IU+220561

120

# Dimple Lock

The "D" clamping system prevents insert movement during high feed or heavily interrupted machining. This is due to its accurate indexing capability, which holds the insert securely clamped.



# SPMT<sub>TL40</sub>



SPMT

The new inserts SPMT with sizes 06, 07, 09 and 12 are more positive than WCMX and WCMT inserts. The new grade TL40 has been introduced for general applications on a wide range of materials. The new drills are available with a boring depth of 3xD and with diameters from 15 to 45.





## CCKT

1. Multiple applications - Side milling, drilling and face milling.
2. Less time in tool changing on both conventional and M/C machines.
3. Economical and efficient in machining.
4. Easily able to machine in roughing and finishing applications because of the high rake geometry and high helix which reduce cutting forces for a smoother cut.
5. Longer tool life may be expected because of the low cutting forces generated.
6. Improved performance will be seen in comparison to conventional en mills and mill-drills, especially when ramp milling, drilling, contouring, helical interpolation of bores pockets or normal profiling.



# TIN28

## The Stainless Steel specialist

Micrograin carbide grade enhanced with multiyer PVD coating that offers a lower friction coefficient and a sharper cutting edge. Tin28 is Canela's first choice for Stainless and alloy steels at low to medium cutting speeds and for unstable machining conditions.

The sharp cutting edge achieved by the PVD coating gives the workpiece an excellent surface finish.



SPKR 1203 EDR  
TIN28



SPKN 1203 EDTR  
TIN28



SEKR 1203 AFN  
TIN28



SEMT 1204 AF TN  
TIN28



APKT1003 P'DR  
TIN28



APKT1604 PDR  
TIN28



APKT16041S  
TIN28





# **LOW COST** **High Feed**

Canela is pleased to introduce the conventional face cutter of the new millenium. 9440 series enables to increase the feed per tooth up to 5 times using the same insert as before. This new mill series offer an extraordinary metal removal rates and dramatically lower face roughing times. Cost efficiency is a must, and the 9440 series achieve it using inexpensive inserts with four usable cutting edges that achieve deeps of cut up to 2,5 mm.

## **Standard Type**



6Kw NC milling machine

Mill Ø: 3"

5 teeth

Vc 200 m/min

rpm. 800

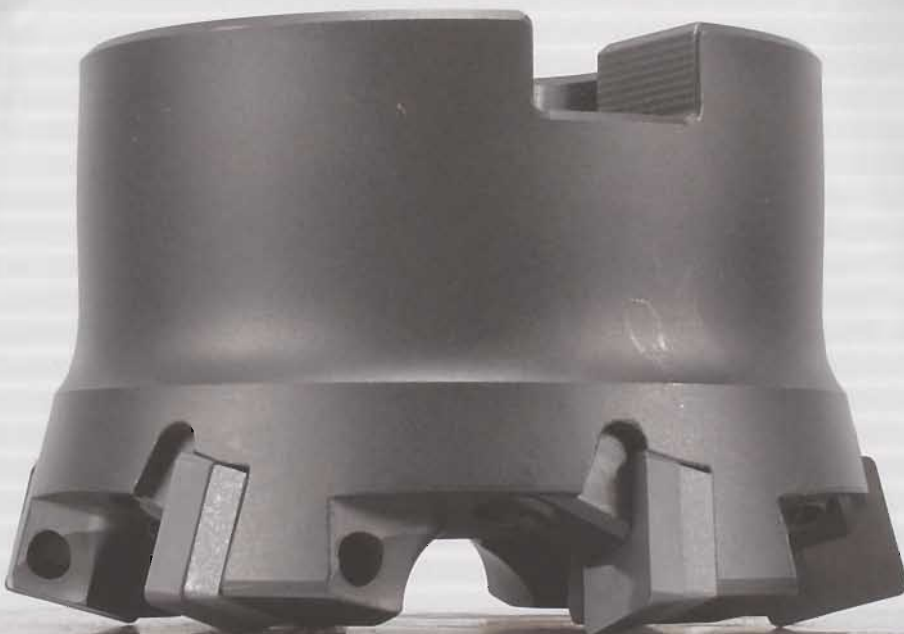
fz 0,2 mm/tooth

Vf 795 mm/min

doc 1,5 mm.

# Cutters

## **CANELA Type**



6Kw NC milling machine

Mill Ø: 3"

5 teeth

Vc 200 m/min

rpm. 800

fz 1 mm/tooth

Vf 4000 mm/min

doc 1,5 mm.

**Five times faster  
than standard type**

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