

ELLIOTT INTERNAL RECESSING UNIT

IRU

The Internal Recessing Unit is the most efficient method of machining single or multiple grooves in one operation. The Elliott system is comprised of an operating head, pilot, carrier arm and replaceable form ground cutter.

ZERO DEFLECTION

Due to the unique design, the cutter is supported along its entire length by the pilot. This eliminates deflection and ensures precise feature machining with consistent repeatability.

OPERATING PROCEDURE

The recess system feeds into the work-piece with the pilot locating within the component bore. The operating head or optional nose piece makes contact with either the component face or a fixture plate. While feeding forward, the system is actuated, lifting the cutter exactly perpendicular to the axis of rotation at a 2:1 ratio. This machines all features simultaneously, with perfect concentricity. Radial cut depth can be controlled by the limiting nut bottoming out or by the CNC program controlling the tool's feed-depth.

