

Stainless Steel 17-4 PH Turbine Blade

Machine

VIBRA-FREE Ultra-High-Speed-Hard-Milling Center

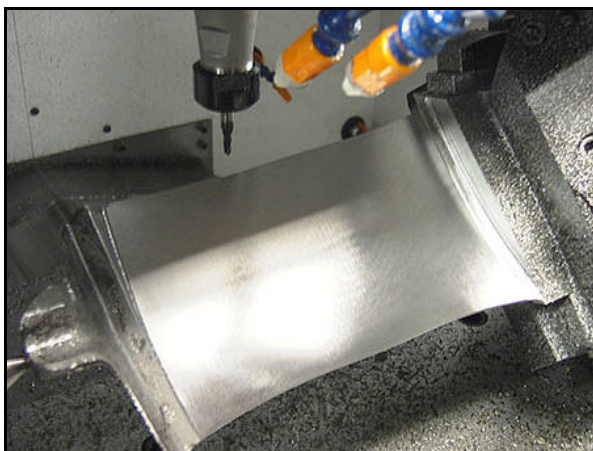
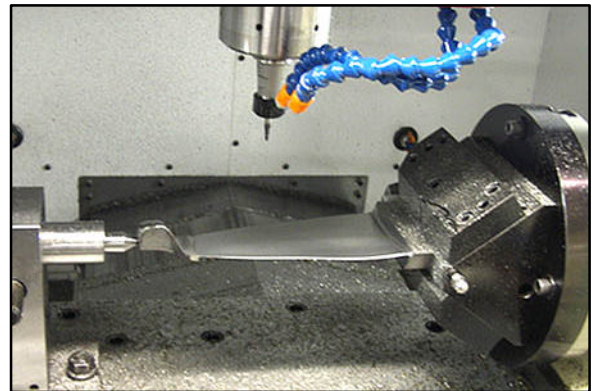
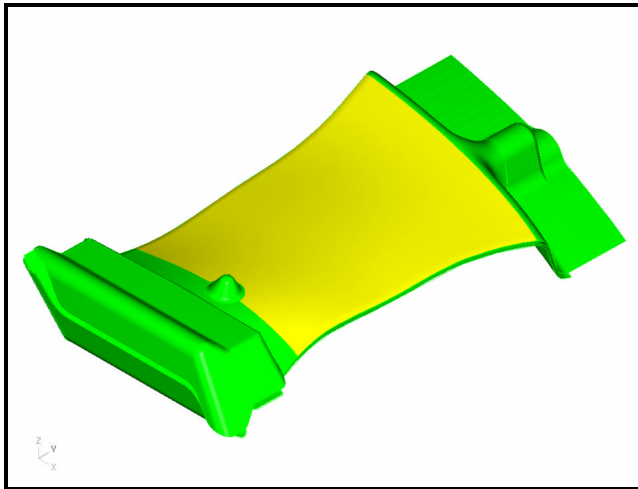


- Motorized High Speed Spindle With 42000 RPM
- Rigid Vibration-Free Solid Back Bridge Structure
- FANUC 16i CNC and Digital Servo System
- High Precision Contour Control (HPCC)
- 3D Cutting Feed-rate of 472 IPM
- Built-in 2 GB Hard Drive and Ethernet Connection
- Pre-Balanced and Double-Face-Contact Tooling System
- Fully Enclosed ATC with 18 tools

- Graphite Machining & Hard Milling
- Designed And Built In Japan

Part (Pre-Machined Forging Part 14.0”L x 7.0”W x 0.5”D)

Gas Turbine Blade



Specifications

Number of programs: 3
Number of cutting tools: 3
Material: Stainless Steel 17-4 PH

Summary

The high RPM and precision IPM of Vibra-Free make it practical to use small tools and light depths of cut. The machining process minimizes the deflection & chatter of the blade body during cutting, which produces highly accurate surface profiles and polish-free finishes.

TOOLPATH	CUTTER	COATING	RPM	IPM	TIME (Min.)
Semi-Finish Blade area	1/4" Ball EM	TiALN	28000	300	32
Finish Blade area	3/16" Ball EM	TiALN	36000	472	53
Finish Root area	6mm Ball EM	TiALN	32000	250.	20
Total time					105