

# CPM (Crucible Particle Metallurgy) Cutting Demo

## Machine

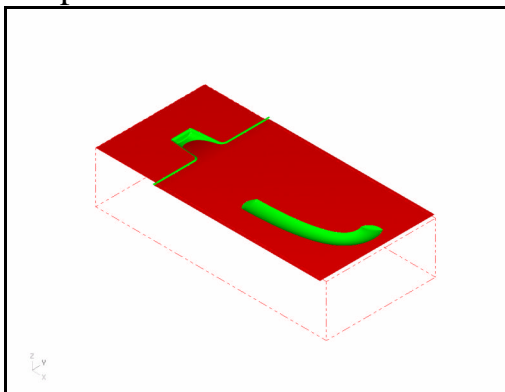
**VIBRA-FREE** high-speed machine center



- Cutting feed-rate 472 in/min
- Advanced FANUC 16i-MA CNC with High Precision Contour Control (HPCC)
- NURB interpolation
- Direct drive (motorized) Super-High-Speed spindle (42000RPM)
- Vibration-free rigid bridge type structure
- Compact ATC with 18 tools
- Graphite milling & harden tool steel milling (Up to HRC62) capability

Part (Blank size: 6." x 3." x 1.5")

Graphite Insert



## Specifications

Number of program: 5

Number of cutting tool: 5

Stock material: CPM (Crucible Particle Metallurgy)10V

## Demo Summary

TOOLPATH	CUTTER	COATING	RPM	IPM	TIME (Min.)
Rough	3mm Ball EM	TiALN	18000	150	30.
Semi - Finish	3mm Ball EM	TiALN	20000	150.	15.
Finish	4mm Ball EM	Special	18000	200.	65.
Left Over	2mm Ball EM	TiALN	30000	75.	5.
Pencil	1mm Ball EM	TiALN	40000	50.	5.
Total time					120.