

Bottle Mold Cutting Demo

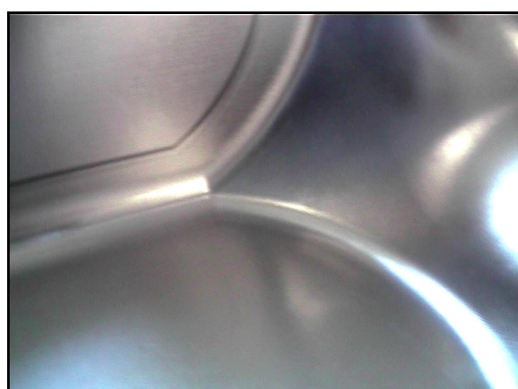
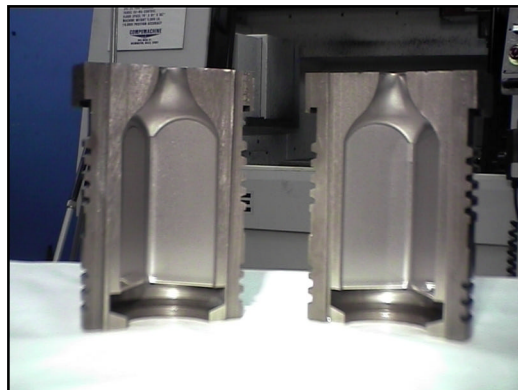
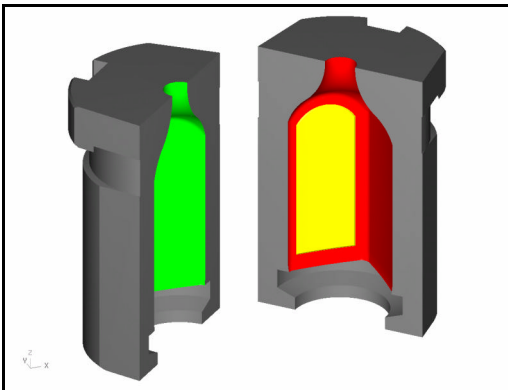
Machine

VIBRA-FREE Ultra-High-Speed-Hard-Milling machine center



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

Part (Blank size: 8." x 5." x 3.")



Specifications

Number of program: 8
Number of cutting tool: 4
Stock material: Cast Iron

Demo Summary

MaMa Mold

TOOLPATH	CUTTER	COATING	RPM	IPM	TIME (Min.)
Rough	6mm Ball EM	TiALN	13000	150	27.
Semi - Finish		TiALN	15000	150.	11.
Finish	6mm Ball EM	TiALN	20000	125.	65.
Left Over	2mm Ball EM	TiALN	30000	60.	6.
Pencil	.8mm Ball EM	TiALN	40000	35.	6.
Total time					115.

PaPa Mold

TOOLPATH	CUTTER	COATING	RPM	IPM	TIME (Min.)
Rough	6mm Ball EM	TiALN	13000	150	27.
Semi - Finish		TiALN	15000	150.	11.
Finish	6mm Ball EM	TiALN	20000	125.	75.
Total time					113.