

## P20 (HRC30-35) Mold Cavity Cutting Demo

### Machine

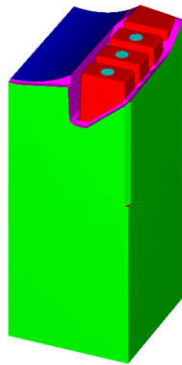
**VIBRA-FREE** high-speed machine center



- 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: 2.75" x 2.35" x 4.5")

Mold Cavity



### Specifications

Number of program: 6  
 Number of cutting tool: 3  
 Stock material: P20 (HRC30-35)

### Demo Summary

TOOLPATH	CUTTER	COATING	RPM	IPM	TIME (Min.)
Operation #1					
Rough	3 mm Ball EM	TiALN	30000	150.	3.5
Semi-Finish	2 mm Ball EM	TiALN	30000	150.	3.6
Finish	2 mm Ball EM	TiALN	30000	125.	5.5
Operation #2					
Rough	2 mm Ball EM	TiALN	30000	157.	21.
Semi-Finish	2 mm Ball EM	TiALN	30000	78.	21.
Finish	3mm Flat EM	TiALN	30000	157.	25.
Total time					79.6