

Stainless Steel 420 (RHC50) Mold Insert Cutting Demo

Machine

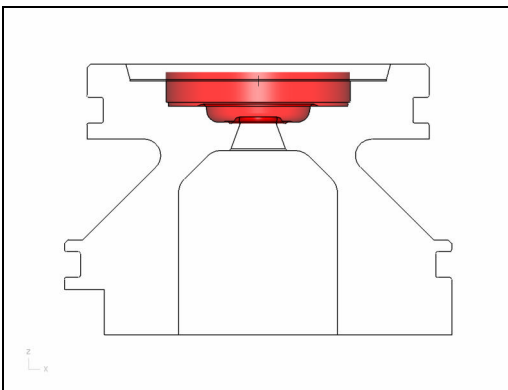
VIBRA-FREE high-speed machine center



- 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: 3.75" x 3." x 1.")

Mold Insert



Specifications

Number of program: 5 (aba1,aba22,aba3,aba4,aba66)

Number of cutting tool: 5 (T1 ~ T5)

Stock material: Stainless Steel 420 HRC50

Demo Summary

TOOLPATH	CUTTER	COATING	RPM	IPM	TIME (Min.)
Rough	2mm Ball EM	TiALN	40000	200	13.0
Finish	2mm Ball EM	TiALN	40000	100	7.0
Left over #1	.8mm Bal EM	TiALN	40000	25	2.7
Left over #2	.4mm Ball EM	TiALN	40000	7	5.4
Corner clean up	3mm with .2m Cr	TiALN	36000	12	2.1
Total time					30.2

Programming Summary

Cam Software used: MasterCAM level 3.0

Programming Time: 3 hr