

## Hardened Stainless Steel 420 Work Sample

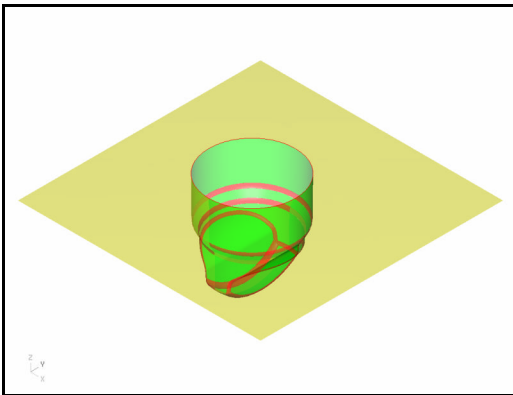
### Machine

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

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

**Part** (Blank size: 3" x 3" x 3")

Plastic injection mold cavity



### Specifications

Number of program: 3  
Number of cutting tool: 3  
Stock material: Harden Stainless steel 420 (HRC 52-54)

### Demo Summary

TOOLPATH	CUTTER	COATING	RPM	IPM	TIME (min)
Rough Cavity	3mm Ball EM	TIALN	30000	200	27.0
Finish Cavity	3mm Ball EM	TIALN	30000	120	20.5
Finish Corner	1.5mm Ball EM	TIALN	40000	60	5.
Total time					52.5