

Hardened Stainless Steel 420 Work Sample

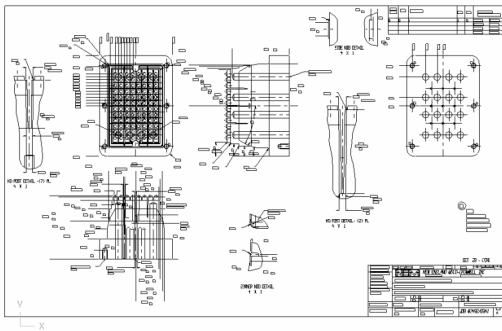
Machine

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: 7" x 5" x 4")

Plastic injection mold core



Specifications

Number of program: 3

Number of cutting tool: 3

Stock material: Hardened stainless steel 420 (HRC 52-54)

Demo Summary

TOOLPATH	CUTTER	COAT	RPM	IPM	TIME (min)
Rough	2mm Ball EM	TIALN	40000	120	135.
Semi finish	3mm 3° Taper EM	TIALN	40000	150	45.
Finish	3mm 3° Taper EM	TIALN	31000	150	15.
Total time					195.