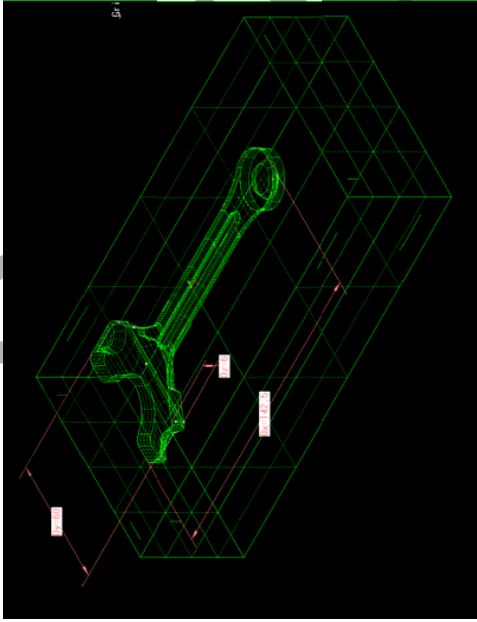


Connecting Rod Milling : Stavax 420S

CAD Design



Work Material



【Milling Condition】

Milling Model: Connecting Rod
 Material : Stavax 420S (58HRC)
 Overhang Length: 15mm
 Cycle Time/volume: 7min40sec/40”cu/min
 MC: Makino V33
 CAM:CAM-TOOL
 Coolant : Spindle Through Air Blow



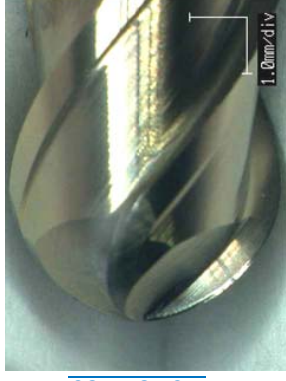
HFB

Tool Model	Spindle Speed (rpm)	Feed Rate (mm/min)	Feed Rate /Tooth (mm)	Axis Depth (mm)	Radial Depth (mm)
HFB4060-0900	12,800	5,000 (Slot)	0.097	0.5	0.5
		15,000 (Side)	0.313		

Tool Condition



Ball Nose



Rake Area



Cutting Edge