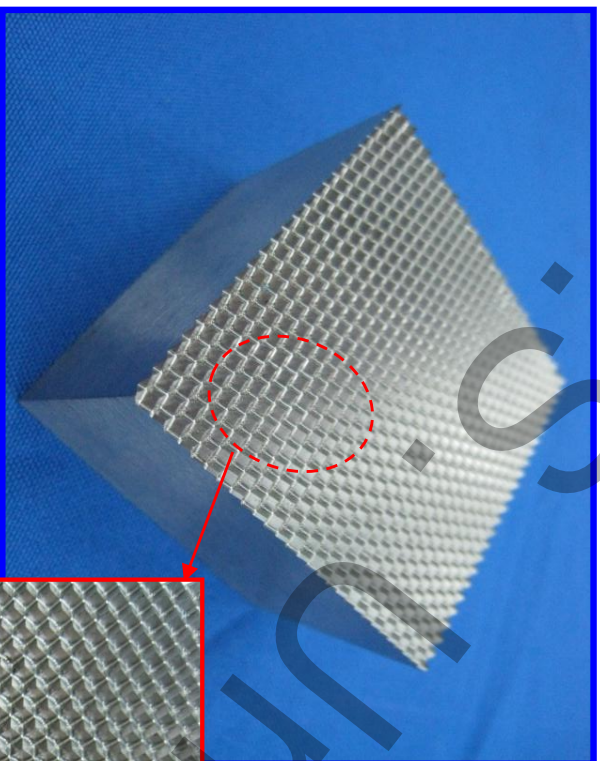


Reflector Lens : NAK80 (40HRC) Milling Data



【Milling Condition】

- ★Product Reflector Lens
- ★Work Material NAK80 (40HRC)
- ★Cycle Time 8hr 40min
- ★Milling Machine MAKINO V33
- ★CAD/CAM MAKINO FFCAM
- ★Coolant Type Airblow
- ★Tooling MST Corporation

【Milling Parameter】

Tool Model	Process	Spindle Speed (RPM)	Feed Rate (mm/min)	ap (mm)	ae (mm)	Cycle Time (min)
HB2015-0400	Roughing	30,000	2,000	1	6	72min
HB2010-0250	Roughing	30,000	1,500	0.08	0.4	55min
HB2010-0250	Semi-Roughing	30,000	1,000	-	0.5	96min
HLB2006-020	Semi-Roughing	30,000	800	-	0.03	34min
HLB2006-020	Finishing	30,000	800	-	0.02	68min
HLB2006-020	Finishing	30,000	800	-	0.03	195min
						8hr 40min