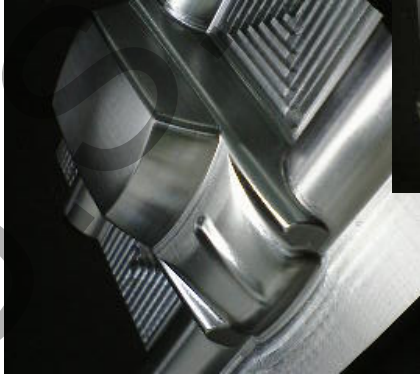


Mini Car Milling (NAK80 40HRC)



HLRS 《 Long Neck Radius 》



HLB 《 Long Neck Ball 》



HTNB 《 Taper Neck Ball 》



- ★Product : Mini Car
(Size 90mm × 80mm × 30mm)
- ★Work Material : NAK80
- ★CAD/CAM **toolsV3**
Graphic Products INC.
- ★Cycle Time : Total 8h 54min 51Sec
- ★Milling Machine
Makino V33 (Max 30,000 rpm)
- ★Coolant: Oil Mist

Process	Tool Model	Tool Specification	Speed (min-1)	Feed (mm/min)	Rd (mm)	Ad (mm)	Finishing Allowance (mm)	Cycle Time
Roughing	HLRS2060-10-240	Φ6 Radius (R0.1/Effective Length24)	11,000	2,200	4.8	0.3	0.3	1:07:47
Semi-Roughing	HLRS2030-10-240	Φ3 Radius (R0.1/Effective Length24)	13,500	1,650	1.2	0.15	0.1	0:37:22
Flat Finishing	HLRS2060-10-240	Φ6 Radius (R0.1/Effective Length24)	16,200	3,480	2	0	0	0:00:50
Semi-finishing Finishing	HLB2040-080-4	R2 Long Neck (Effective Length8)	20,000	3,100	0.2	0.2	0.05	0:32:38
				2,000	0.08	0.08	0	1:03:39
Finishing	HTNB2020-160-2	R1Taper (Half Angle 1° E Length16)	30,000	600	0.05	0.05	0	3:41:24
Finishing	HTNB2010-120-2	R0.5Taper(Half Angle1° E Length12)		600	0.02	0.02	0	1:51:11
Total								8:54:51