

- Data Translation (IGES)

approx. 08 sec.



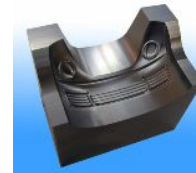
- CAM Condition Setting

approx. 50 min.

Z-level Rough Cutting	D6 R3	0.1
Z-level Finishing	D2 R1	0.06
Scanning-line Area	D2 R1	0.06
Re-machining	D1 R0.5	0.04

- CAM Calculation

approx. 48 min.



- Machining

NAK80 (HRC40) machined by HSM

approx. 8 hrs. 06 min.

Product : Toy (RCC FrontGrille)  
 Work Size : 80mm x 50mm x 50mm  
 Cutting Tool : UNION TOOL CO.  
 Tooling : MST Corporation  
 CPU : Xeon 3.4GHz  
 Process Time : Total 9hrs 34min

Process	Cutting Mode	Tool Type (mm)	Step Over (mm)	Step Down (mm)	Cusp Height (µm)	Stock (mm)	Length of Cut (mm)	Spin. Speed (RPM)	Feed Rate (mm/min.)	Machining Time
Rough	Z-level Roughing	3R BALL	2.8	0.35	-	0.2	117,334	9,500	2,500	1hr. 29min. 46sec.
Finish (PL)	Surface Finishing	3R BALL	-	-	Rmax 1	0	43,539	16,000	2,100	1hr. 12min. 30sec.
Semi Finish (Concave corners)	Re-machining	1R BALL	-	-	Rmax 10	0.04	15,855	16,000	1,600	11min. 55sec.
Semi Finish (Concave corners)	Re-machining	0.5R BALL	-	-	Rmax 10	0.05	9,645	20,000	2,000	27min. 16sec.
Semi Finish	Z-level Finishing + Scanning-line Area	0.5R BALL	-	-	Rmax 1	0	71,438	19,000	1,900	1hr. 00min. 51sec.
Finish	Z-level Finishing + Scanning-line Area	0.5R BALL	-	-	Rmax 1	0	182,122	12,700	1,020	2hrs. 28min. 07sec.
Finish (Concave corners)	Re-machining	0.3R BALL	-	-	Rmax 1	0	26,595	10,600	640	45min. 15sec.
Finish (Concave corners)	Re-machining	0.3R BALL	-	-	Rmax 1	0	14,303	10,600	640	30min. 07sec.
						Total	480,831		Total	8hrs. 06min. 27sec.