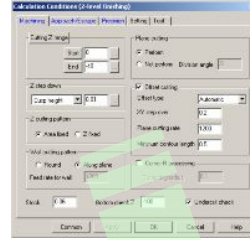




Product : Brake Caliper
 Stock Size : 180mm x 70mm x 50mm
 Cutting Tool : OSG CORPORATION
 CPU: : Xeon 3.4GHz
 Process Time : approx. 26 hours



- CAM Condition Setting

approx. 6 hr. 30 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

3 hr. 24 min.



- Machining

DAC (HRC50) machined by HSM

approx. 16 hours

| Process | Cutting Mode | Tool Type (mm) | Step Over (mm) | Step Down (mm) | Stock (mm) | Spindle SP. (rpm) | Feed Rate (mm/min) | Cutting Length (mm) | Machining Time |
|---------------------|-------------------------------------|----------------|----------------|----------------|------------|-------------------|--------------------|---------------------|---------------------|
| Roughing | ZLRMT + Scanning | D10 R0.5 | 4 | 0.12 | 0.15 | 2,500 | 1,650 | 264,570 | 3hr. 43min. |
| Semi Finishing (PL) | Surface Finishing + Contour Cutting | D10 FLAT | 2 | - | 0.02 | 4,800 | 380 | 11,450 | 38min. |
| Finishing (PL) | Contour Cutting | D6 FLAT | 0.04 | - | 0 | 4,000 | 400 | 12,470 | 02min. |
| Semi Roughing | ZLF + Contour Cutting | D6 R0.5 | - | 0.055 | 0.07 | 4,200 | 1,350 | 178,670 | 1hr. 46min. |
| Semi Finishing (1) | ZLF + ZLHER | D4 R0.5 | 0.05 | - | 0 | 10,000 | 1,200 | 18,608 | 2hr. 04min. |
| Semi Finishing (2) | Surface Finishing + Re-machining | R1 BALL | 0.06 | - | 0.03 | 12,000 | 880 | 46,580 | 1hr. 24min. |
| Finishing (1) | ZLF + ZLHER | D4 R0.5 | - | - | 0 | 10,000 | 1,200 | 20,400 | 2hr. 26min. |
| Finishing (2) | Surface Finishing + Re-machining | R1 BALL | 0.05 | - | 0 | 12,000 | 880 | 51,950 | 1hr. 49min. |
| Finishing (Fillet) | Surface Finishing | R0.4 BALL | 0.03 | - | 0 | 20,000 | 880 | 54,110 | 2hr. 06min. |
| Total | | | | | | | | 658,808 | 15hr. 58min. |