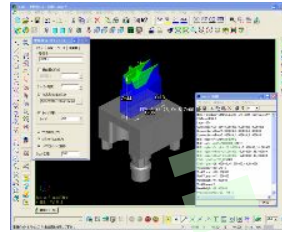


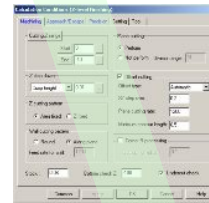
Product : Copper Electrode
 Stock Size : 40mm x 20mm x 60mm
 CPU : Xeon 3.4GHz
 Process Time : approx. 4 hours



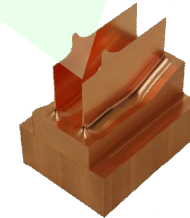
- Modeling by Electrode Option
 approx. 15 min.

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 Condition Setting
 approx. 20 min.



- CAM Calculation
 approx. 10 min.



- Machining
 Copper Material Machined by HSM
 approx. 3 hours

Cutting Mode	Tool Type (mm)	Step Over (mm)	Step Down (mm)	Stock (mm)	Spindle Speed (rpm)	Feed Rate (mm/min)	Cutting Length (mm)	Machining Time
Contour Cutting	D8 - FLAT	5	3	0	3,000	500	2,160	05min.
Z-level Roughing	R3 - BALL	0.15	0.05	0	11,200	1,600	271,970	3hr. 07min.
Total							274,130	3hr. 12min.