



Product : Micro Connector
 Stock Size : 4mm x 3.2mm x 3mm
 Material : HPM31 (HRC59)
 Machining Time : Total 3hr. 30min.

Process	Cutting Mode	Tool Type (mm) / Neck Taper (°) / Neck Length (mm)	Step Over (mm)	Step Down (mm)	Rmax (µm)	Stock (mm)	Spindle Speed (rpm)	Feed Rate (mm/min)	Cutting Length (mm)	Machining Time
Roughing	Z-level Roughing	R0.15 BALL / 1.5 / 1.25	0.1	0.01	-	0.012	30,000	480	11,648	1hr. 40min.
Finishing (PL)	Surface Finishing	R0.15 BALL / 1.5 / 1.25	-	-	1	0	30,000	840	808	03min.
S-Rough + S-Finish	Re-machining	R0.1 BALL / 1.5 / 1.25	0.05	0.005	-	0.006	30,000	400	12,120	1hr. 21min.
Finishing	ZLF + SCL + REM	R0.1 BALL / 1.5 / 1.25	-	-	1	0	30,000	400	7,013	26min.
Total									31,589	3hr. 30min.