



- Modeling

approx. 2 hours



- CAM Condition Setting

approx. 1 hour

- CAM Calculation

approx. 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

Product : Modular Cover
 Work Size : 30mm x 20mm x 10mm
 Cutting Tool : UNION TOOL CO.
 Tooling : MST Corporation
 CPU : Xeon 3.4GHz
 Process Time : approx. 8 hours



- Machining

NAK80 (HRC40) machined by HSM
 approx. 4 hr. 30 min.

Process	Cutting Mode	Tool Type (mm)	Step Over (mm)	Step Down (mm)	Cusp Height (µm)	Stock (mm)	Spin. Speed (RPM)	Feed Rate (mm/min.)	Cutting Length (mm)	Machining Time
Rough	Z-level Roughing	R1 BALL	0.8	0.1	-	0.04	20,000	1,600	45,090	37 min.
Semi Rough	Re-machining	R0.5 BALL	2.5	0.05	-	0.04	20,000	1,200	49,137	1 hr. 14 min.
Semi Finish	Z-level Finishing + Scanning-line Area	R0.5 BALL	-	-	Rmax 2.5	0.02	20,000	1,200	33,966	48 min.
Finish	Z-level Finishing + Scanning-line Area	R0.5 BALL	-	-	Rmax 1	0	20,000	1,000	50,503	1 hr. 37 min.
Semi Finish - Minute areas -	Re-machining	R0.3 BALL	-	-	Rmax 2.5	0.02	20,000	640	12,469	3 min.
Finish - Minute areas -	Re-machining	R0.3 BALL	-	-	Rmax 1	0	20,000	640	5,795	3 min.
Total									196,960	4 hr. 22 min.