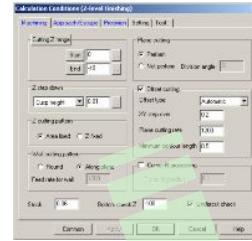




Product : Mini-Tire Wheel
Stock Size : 100mm x 100mm x 35mm
Cutting Tool : MITSUBISHI MATERIALS
 KOBE TOOLS CORP.
CPU : Xeon 3.4GHz
Process Time : approx. 8hr. 30min.



- CAM Condition Setting
 approx. 2 hours

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
 2 hr. 15 min.



- Machining
DC53 (HRC52) machined by HSM
 approx. 4 hours

Process	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
Roughing (1)	ZLR + Surface Finishing	D7 R1.5	2.5	0.3	0.1	6,900	5,000	111,360	47min.
Roughing (2)	Compound Cutting Along Plane	R1.5 BALL	0.15	0	0.1	20,000	2,000	108,050	55min.
Semi Roughing (PL)	Compound Cutting Along Plane	D3 R0.5	1	1	0.05	20,000	2,000	45,210	23min.
Finishing (PL)	Compound Cutting Along Plane	D3 R0.5	1	1	0.005	20,000	2,000	22,540	11min.
Finishing (1)	Surface Finishing	R1.5 BALL	0.15	0	0	20,000	2,000	88,910	57min.
Finishing (2)	Compound Cutting Along Plane	D3 R0.5	1	1	0	20,000	2,000	40,740	21min.
Semi Finishing (Fillet)	ZLF + CCAP	R0.5 BALL	0.08	0	0.025	20,000	2,000	21,040	22min.
Finishing (Fillet)	Re-machining	R0.5 BALL	0.08	-	0	20,000	1,200	17,090	14min.
Total								454,940	4hr. 10min.