

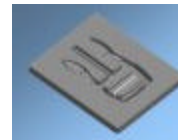
- CAD Data Conversion (IGES)
approx. 10 sec.



- Machining Condition Setting
approx. 50 min.



- CAM calculation
Xeon 2.2GHz
approx. 51 min.



- Sample Cutting
SKD61 (HRC50 equivalent)
processed by HSM
approx. 5hrs. 7 min.

Product : Buckle
(50mm x 40mm x 10mm)
Work : SKD61 (HRC50 equivalent)
CPU : Xeon 2.2GHz
Work Time : **Total 6 hrs. 48 min.**

Process Name	CAM-TOOL cutting mode	Tool Diameter	XY pitch (mm)	Z pitch (mm)	Along Plane	Finish stock (mm)	Distance (mm)	RPM	Feed (mm/min)	Cutting Time
Rough	Z-level high efficiency rough (Trochoid cutting)	1R BALL	0.8	0.12	-	0.05	12,643	18,000	1,620	9min 13sec
Middle rough remachine previous 1	Z-level high efficiency rough (Trochoid cutting)	0.5R BALL	0.35	0.06	-	0.05	27,007	18,000	1,260	40min 24sec
Middle rough remachine previous 2	Z-level rough, Z-level finish	0.4R BALL	0.2	0.02	-	0.05	54,908	18,000	800	1hr 15min 33sec
Middle rough remachine previous 3	Remachining, Scanning line area	0.4R BALL	0.2	0.02	-	0.05	42,554	18,000	800	1hr 5min 39sec
Side finish	Z-level finish	0.4R BALL	-	-	Rmax 1um	0	23,071	18,000	960	33min 47sec
Corner finish	Remachining	0.4R BALL	-	-	Rmax 1um	0	9,145	18,000	900	15min 16sec
Bottom finish	Scanning line	0.4R BALL	-	-	Rmax 1um	0	7,849	18,000	640	31min 31sec
Corner finish	Remachining	0.3R BALL	-	-	Rmax 10um	0.02	3,770	18,000	600	7min 28sec
Corner finish	Remachining	0.1R BALL	-	-	Rmax 5um	0.02	5,341	18,000	300	19min 7sec
Corner finish	Remachining	0.1R BALL	-	-	Rmax 1um	0	1,451	18,000	180	9min 21sec
Total							186,288	Total		5hrs 7min 19sec