



WHERE NEW THINKING
TAKES SHAPE.

Part: Insert Cavity
Business: Injection Mold
Industry: Automotive

Machine: V33

Cycle Time: 3 hrs. 16 mins.

Material: H13 (50 HRc)

Key Technologies: Cutting to Negative Stock
Makino Process

Impact: Complete Shut -off of Mating Surfaces
Spotting is Eliminated



Ask a Makino representative for more information.

Competitive Advantage: The V33 with Core Cooling and the correct process approach completely eliminated hand work from this insert / cavity. The insert half was cut to "0" stock while the core half was cut to -5μ ($-0.0002''$). Resulting in one to one matching.

Machine: V33

Spindle: 30,000RPM

Material: H13

Hardness: 50HRc

Part Size: 62 x 76 x 76mm
(2.95" x 1.97" x 3.54")

Surface Finish: 0.38 Ra μ meters
(14.96 Ra μ inch)

Cycle Time: 3 hr. 16 min.

Surfaces Match one to one

