



WHERE NEW THINKING
TAKES SHAPE.

Part: Lens Sample
Business: Plastic Injection Mold
Industry: Automotive

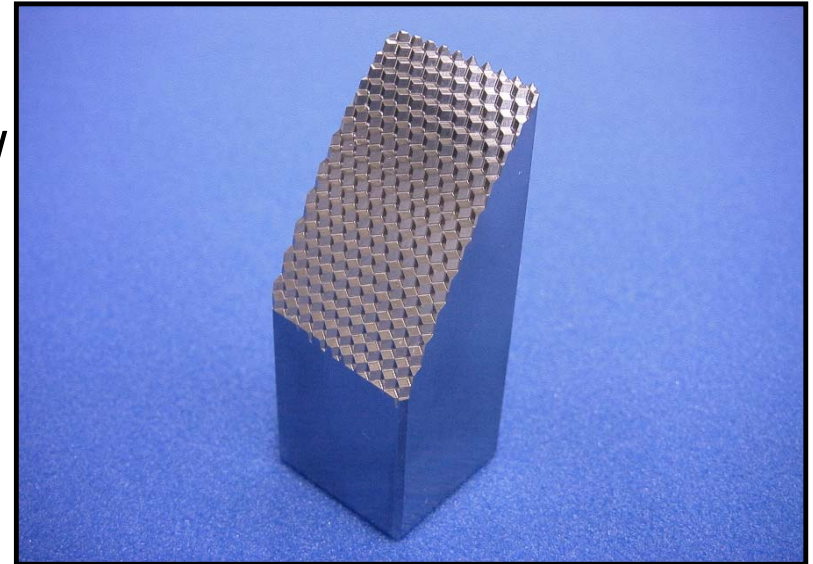
Machine: V22

Cycle Time: 3 hrs. 12 min. 19 sec.

Material: Stainless Steel (52 Hrc)

Key Technologies: 50nanometer Closed Loop Moiré Scale Feedback
Consistent Spindle Torque throughout RPM Range

Impact: Bench Free Surface Finish
Reduction of Manufacturing Time Due to Elimination of EDM Process



Ask a Makino representative for more information.

Test Cut Parameters

Tool Description	RPM	Feed Rate		Step Over		Step Down		Cycle Time(H:M:S)
		inch/min	mm/min	inch	mm	inch	mm	
R2.0 BEM	20000	236.22047	6000	0.07874	2	0.015748	0.4	0:05:28
R2.0 BEM	20000	157.48031	4000	0.015748	0.4	0		0:01:24
R1.0 BEM	30000	118.11024	3000	0.007874	0.2	0		0:04:06
R0.5 BEM	30000	55.11811	1400	0.00315	0.08	0		0:22:27
R0.3 BEM	30000	47.244094	1200	0.00189	0.048	0		0:43:50
R0.3 BEM	30000	35.433071	900	0.001181	0.03	0		1:55:04
Total Cycle Time:							3:12:19	

