



WHERE NEW THINKING
TAKES SHAPE.

Part: Speaker grill
Business: Plastic Injection Mold
Industry: Automotive

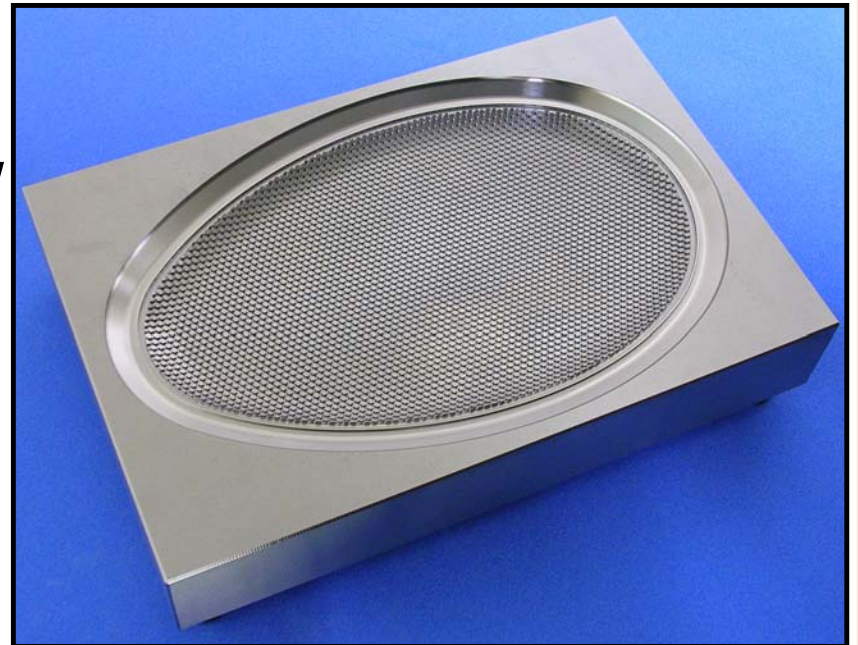
Machine: V33 Hyper

Cycle Time: 52hrs. 13min.

Material: Stavax (50 HRc)

Key Technologies: Hyper 40k Spindle
Direct Clamping of Tool

Impact: Tool \varnothing 0.6mm (0.23")
Cutting Tool Life = 28 hrs.
EDM (Graphite Cutting not included) = 4 hrs. Longer than Cutting



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	
Ø0.8×5° Taper Ball End Mill	40000	94.49	2400	0.015748	0.4	0.00315	0.08	6:01:00
Ø0.8×5° Taper Ball End Mill	40000	31.5	800	0.004724	0.12	0		7:12:00
Ø0.6 Ball End Mill	40000	47.24	1200	0		0.001181	0.03	4:12:00
Ø0.6×5° Taper Ball End Mill	40000	47.24	1200	0		0.000787	0.02	28:49:00
Total Cycle Time:								46:23:00