



WHERE NEW THINKING  
TAKES SHAPE.

*Part: Speaker Grill*  
*Business: Plastic Injection Mold*  
*Industry: Consumer Goods*

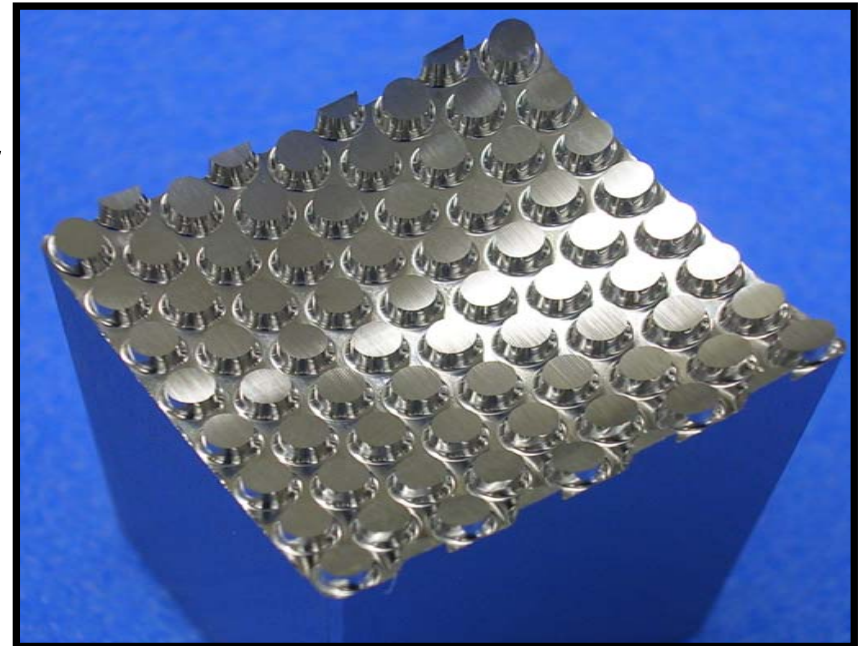
Machine: V22

Cycle Time: 1 hrs. 7 min. 54 sec.

Material: NAK80 (40Hrc)

Key Technologies: Processed Using High Performance  
Machining Techniques  
Unique Hybrid ATLM

Impact: Eliminates Sinker EDM Process  
Bench Free Surface Finish



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	
Dia 0.8x5deg Taper End Mill	40000	94.488189	2400	0.015748	0.4	0.00315	0.08	0:08:56
Dia 0.8x5deg Taper End Mill	40000	31.496063	800	0.004724	0.12	0	0	0:10:14
R0.3 BEM	40000	47.244094	1200	0.001181	0.03	0	0	0:08:30
Dia 0.8x5deg Taper End Mill	40000	47.244094	1200	0.000787	0.02	0	0	0:40:14
<b>Total Cycle Time:</b>								<b>1:07:54</b>

