



WHERE NEW THINKING
TAKES SHAPE.

Part: Stamping Sample
Business: Stamping Die
Industry: Commercial Goods

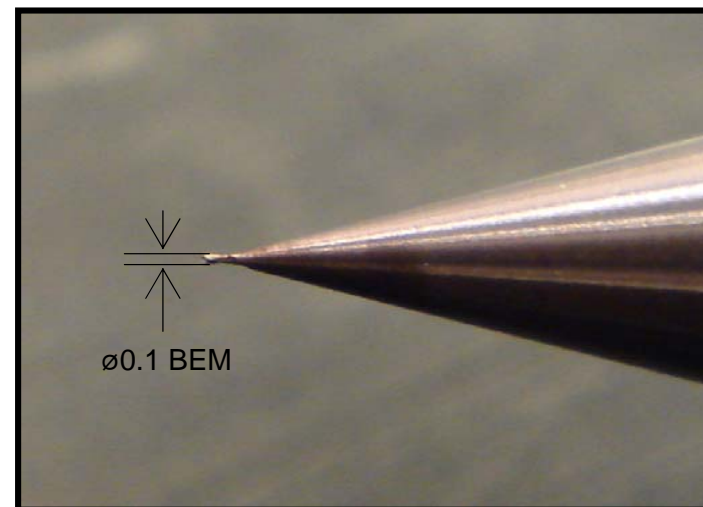
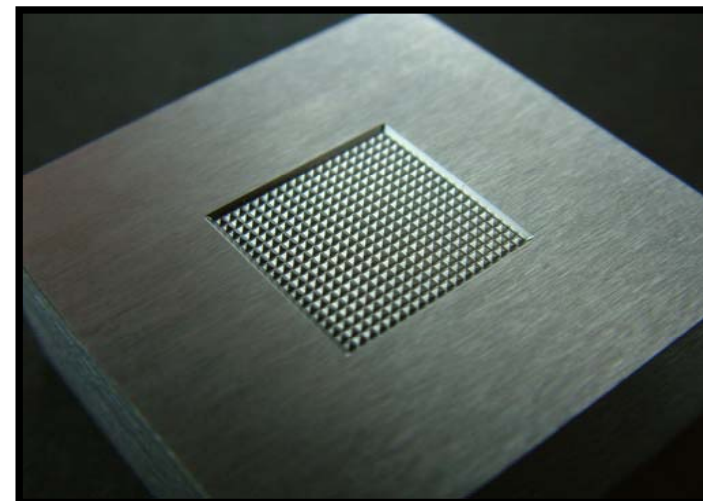
Machine: V22

Cycle Time: 6 hrs. 12 min. 50 sec.

Material: H-13 (50 Hrc)

Key Technologies: Unique Hybrid ATLM
Thermal Guard

Impact: Blending Capability with $\varnothing 0.1\text{mm}$ BEM to
Less Than 1μ (0.000039 inch)
Extended Tool Life With Thermally Stable
Work Zone.



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	
R0.25 BEM	40000	23.622047	600	0.029528	0.75	0.000984	0.025	0:48:20
R0.15 BEM	40000	19.685039	500	0.002362	0.06	0.000591	0.015	0:52:10
R0.15 BEM	40000	15.748031	400	0.000276	0.007	0.000276	0.007	1:32:00
R0.1 BEM	40000	11.811024	300	0.000276	0.007	0.000276	0.007	1:11:00
R0.05 BEM	40000	5.9055118	150	0.000236	0.006	0.000236	0.006	1:49:20
Total Cycle Time:								6:12:50