

*Part: Staple Core*  
*Business: Plastic Injection Mold*  
*Industry: Medical*

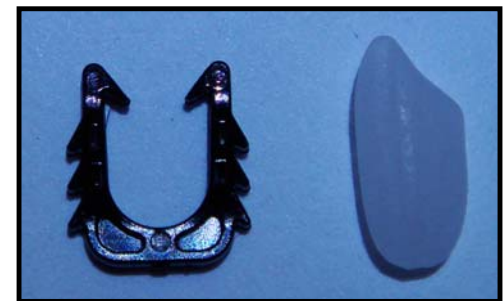
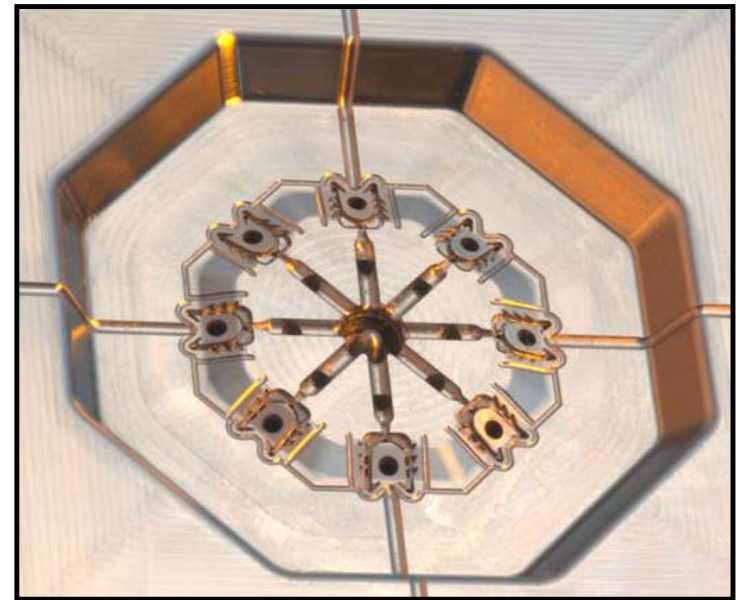
Machine: V22

Cycle Time: 21 hrs. 19 min. 15 sec. (Eight Cavities)  
2hrs. 39min. 54 sec. (Per Cavity)

Material: Stavax ( 50 HRc )

Key Technologies: Hybrid ATLM  
40k Spindle

Impact: Tool to tool bends less than 0.001mm (0.00003937")  
Replace EDM Process with Micro – Hard Milling



Plastic  
Staple

White  
Rice

**Competitive Advantage:** The Hybrid ATLM on the V22 provides the ability to achieve tool to tool blending of less than 0.001mm (0.000039"). When combined with Makino's 40k Patented Core Cooled spindle the EDM process, benching and polishing were eliminated from the processing of this mold. These unique features set a new standard of predictability in the Micro – Mold market.

**Machine:** V22

**Spindle:** 40,000RPM

**Material:** Stavax 420 Stainless Steel

**Hardness:** 50HRc

**Part Size:** 89.0 x 89.0 x 25.4mm ( 3.5" x 3.5" x 1" )

**Surface Finish:** 0.03 Ra  $\mu$ meters ( 1.18 Ra  $\mu$ inch )

**Cycle Time:** 21 hr. 19 min. 15 sec. (8 Cavities)  
2 hr. 39 min. 54 sec. (Per Cavity)

Plastic staple validates the accuracy of mold.

