

Part: Engine Cover
Business: Plastic Injection Mold
Industry: Automotive

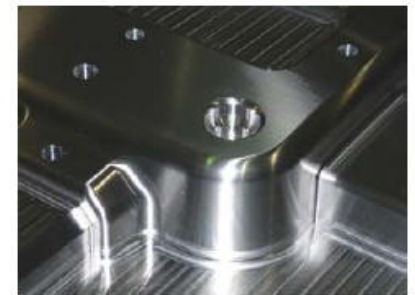
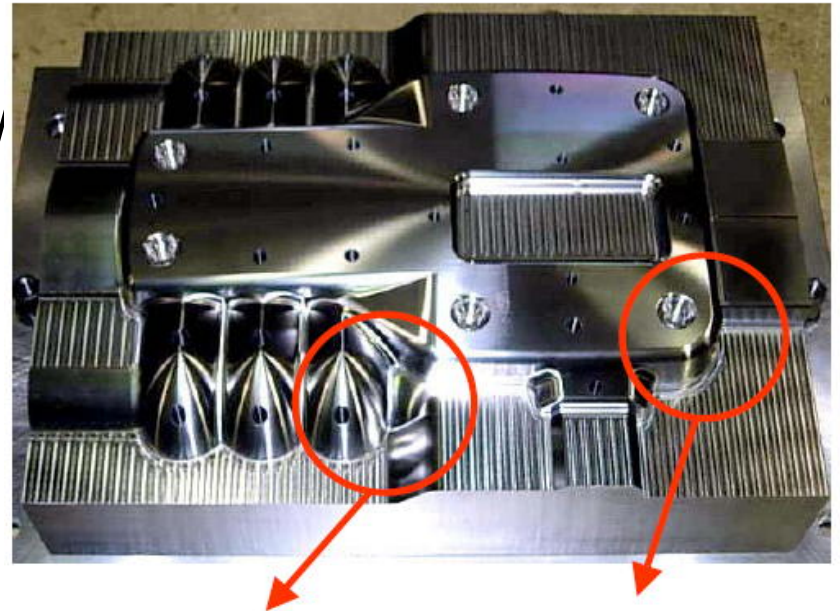
Machine: V56

Cycle Time: 22 hrs. 13 min.

Material: Stavax (50 HRc)

Key Technologies: Automatic Tool Length Measurement
Thermal Stability

Impact: Superior Tool to Tool Blending
Exceptional Surface Finish



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	
32mm Insert Mill	1990	177.16535	4500	0.728346	18.5	0.019685	0.5	5:07:00
12mm R2 Bullnose End Mill	4860	236.22047	6000	0.23622	6	0.047244	1.2	3:19:00
8mm R0.5 Bullnose End Mill	6000	94.488189	2400	0.137795	3.5	0.019685	0.5	0:15:00
8mm R0.5 Bullnose End Mill	4800	77.165354	1960	0.019685	0.5	0.019685	0.5	0:30:00
6mm R0.5 Bullnose End Mill	5760	68.110236	1730	0.007087	0.18	0.007087	0.18	0:13:00
6mm R0.5 Bullnose End Mill	4200	49.606299	1260	0.007087	0.18	0.007087	0.18	0:05:00
3mm R0.5 Bullnose End Mill	6000	70.866142	1800	0.003937	0.1	0.003937	0.1	0:22:00
3mm R0.5 Bullnose End Mill	5000	55.11811	1400	0.003937	0.1	0.003937	0.1	0:09:00
12mm R2 Bullnose End Mill	9000	118.11024	3000	0.015748	0.4	0.008661	0.22	6:22:00
8mm R0.5 Bullnose End Mill	12000	94.488189	2400	0.003937	0.1	0.003937	0.1	1:40:00
8mm R0.5 Bullnose End Mill	4000	47.244094	1200	0.003937	0.1	0.003937	0.1	1:47:00
3mm R0.5 Bullnose End Mill	4000	31.496063	800	0.003937	0.1	0.003937	0.1	1:12:00
3mm R0.5 Bullnose End Mill	3500	23.622047	600	0.003937	0.1	0.003937	0.1	1:12:00
Total Cycle Time:							22:13:00	

