

Auto Emblem Graphite Electrode

Machine

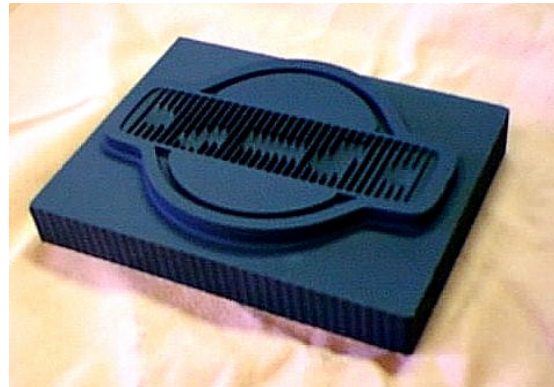
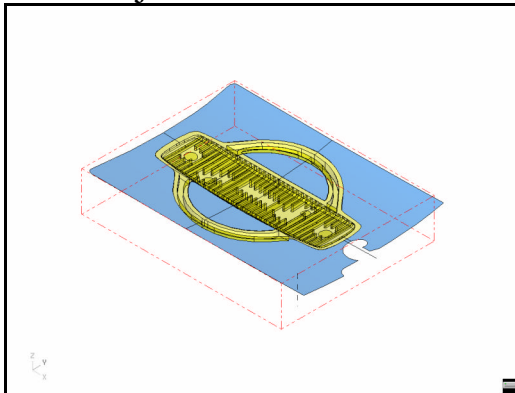
VIBRA-FREE high-speed machine center



- Cutting feed-rate 472 in/min
- Advanced FANUC 16i-MA CNC with High Precision Contour Control (HPCC)
- Direct drive (motorized) Super-High-Speed spindle (42000RPM)
- Vibration-free rigid bridge type structure
- Compact ATC with 18 tools
- Graphite milling & harden tool steel milling (Up to HRC62) capability

Part (Blank size: 6." x 5." x 1.")

Nissan Ejector Electrode



Specifications

Number of program: 7 (128ET1-7)

Number of cutting tool: 6 (T1-T6)

Stock material: Graphite

Demo Summary

TOOLPATH	CUTTER	COATING	RPM	IPM	TIME (Min.)
Rough Island	½" F-EM	None	20000	120	2.5
Rough Surface	½" B-EM	None	22000	120	14.0
Rough Wall	¼" B-EM	Diamond	35000	200	4.0
Finish Surface				160	21.
Finish Wall & Groove	1/8" B-EM	Diamond	35000	175.	7.
Finish Rib	1/16" B-EM	None	35000	145.	40.
Finish Rib	.040" B-EM	None	35000	100.	75.
Total time					2hr 44min

Comparison

Customer's traditional machine:

TOOLPATH	CUTTER	REMARK	TIME (Min.)
Rough Island	1" F-EM	+.020" Stock	
Rough Surface	1/2" B-EM	0 Stock	
Rough Wall	1/4" C-EM .03" corner	0 Stock	
Finish Surface	1/4" B-EM	-.010" Finish for over burn	
Finish Wall & Groove	1/8" B-EM	-.010" Finish	
Finish Rib	1/16" B-EM	-.010" Finish	
Finish Rib	.040" B-EM	-.010" Finish	
Total Time			6hr

OKK DGM 400/MITS 635

TOOLPATH	CUTTER	RPM	CHIP LOAD	IPM	TIME
Rough	1/2" F-EM	700	.0125	175	4'41"
Rough Top	1/4" B-EM	14000	.0071	200	8'8"
Finish Face	1/4" B-EM	14000	.0071	200	23'9"
Finish OD	1/4" F-EM		.0071	200	6'7"
Semi Finish	1/8" B-EM	20000	.003	120.	15'44"
Semi Finish	1/16" B-EM	20000	.003	120.	44'32"
Finish	.040" B-EM	20000	.0041	165.	1:43:39
Total Time					3:26:00

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