

# Graphite Cutting Demo

## Machine

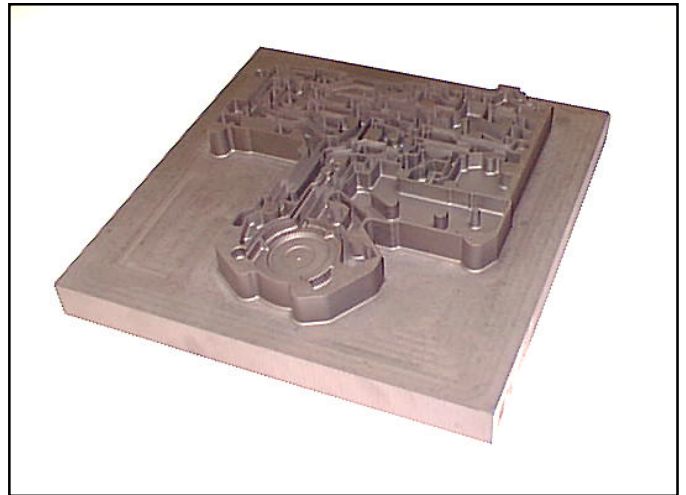
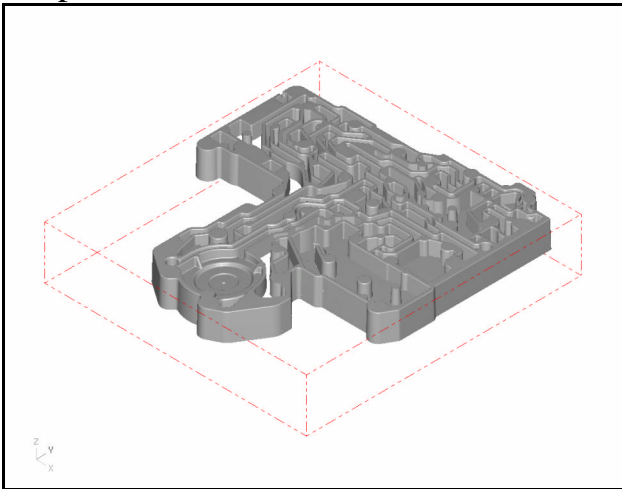
**VIBRA-FREE** high-speed machine center



- Cutting feed-rate 472 in/min
- Advanced FANUC 16i-MA CNC with High Precision Contour Control (HPCC)
- NURB interpolation
- 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: 12." x 12." x 2.")

Graphite Electrode



## Specifications

Number of program: 7  
Number of cutting tool: 4  
Stock material: Graphite

### Demo Summary

| TOOLPATH                | CUTTER        | COATING | RPM   | IPM  | TIME (Min.) |
|-------------------------|---------------|---------|-------|------|-------------|
| Rough *                 | .5" Flat EM   | TiCN    | 30000 | 300. | 28.         |
| Rough<br>Re-machine     | .25" Ball EM  | Diamond | 38000 | 250. | 25.         |
| Semi Finish -<br>wall   | 3/16" Ball EM | Diamond | 40000 | 200. | 58.         |
| Semi Finish -<br>Bottom |               |         |       | 100. | 32.         |
| Semi Finish -<br>wall   | 1/8" Ball EM  | Diamond | 40000 | 150. | 93.         |
| Finish - wall           |               |         |       | 160. | 185.        |
| Finish - bottom         |               |         |       | 150. | 54.         |
| Total time              |               |         |       |      | 7 hr 55 min |