

# Graphite Electrode Cutting Demo

## Machine

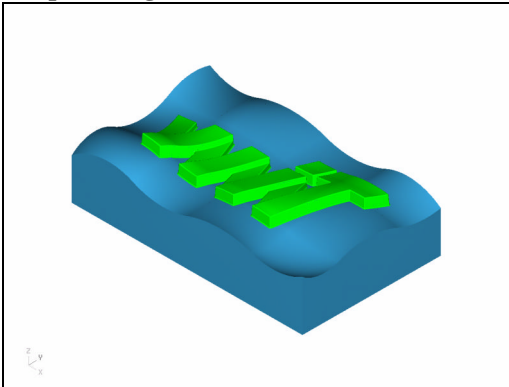
**VIBRA-FREE** high-speed machine center



- 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: 2.5" x 1.5" x 1.")

**Graphite Logo Electrode Insert**



### Specifications

Number of program: 4  
Number of cutting tool: 3  
Stock material: Graphite (POCO 3)

### Demo Summary

TOOLPATH	CUTTER	COATING	RPM	IPM	TIME (Min.)
Rough	2.0 mm Ball EM	TiALN	40000	236.	16.
Semi-finish	1.0 mm Ball EM	TiALN	40000	236.	16.
Finish	1.0 mm Ball EM	TiALN	40000	200.	19.
Corner clean up	0.5mm Ball EM	TiALN	40000	30.	10.
Total time					61.

File: wit-test\_cut.mc8