

CGE / DCB Graphite milling example

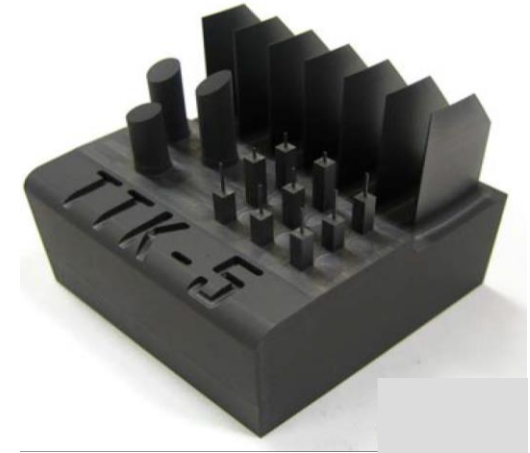
Work material : Graphite TTK-5 (Hs70)
 Work size : 50 x 50 x 50 mm
 Coolant : Air blow
 Cycle time : 2hr 59min

~ Tools ~

CGE (Non-coat square)



DCB (DIA ball)



Process	Tool	Spindle Speed (min ⁻¹)	Feed Rate (mm/min)	a _p (mm)	a _e (mm)	Cycle time
Roughing	CGE 4120 (φ12 x 5)	5,000	5,000	4	2	0:03:27
Block top finishing			1,500	-	6	0:00:22
Semi-roughing (both ends of the arch)	DCB 2060 (R3 x 30)	7,000	3,000	0.2	2	0:01:22
Semi-roughing			5,000	1	2	0:07:21
Pin-semi-roughing	DCB 2040 (R2 x 20)	7,000	2,000	0.5	2	0:05:56
Step-semi-roughing			3,000	0.5	1.5	0:00:56
Top of logo-finishing			3,000	-	0.1	0:02:58
Side of boss-finishing			2,000	0.1	-	0:07:49
Top of boss-semi-finishing	DCB 2010 (R0.5 x 5)	20,000	500	-	0.1	0:02:55
Top of boss-finishing			500	-	0.1	0:02:08
Rib-semi-finishing			3,000	0.2	2	0:26:14
Rib-finishing1(short)			3,000	0.1	-	0:14:24
Rib-finishing2(long)	DCB 2040 (R2 x 20)	7,000	2,000	0.1	-	1:22:10
Bottom of rib-finishing			800	-	0.2	0:08:23
Logo-roughing	DCB 2010 (R0.5 x 5)	20,000	1,000	0.1	0.3	0:11:09
Logo-finishing			1,000	-	0.1	0:01:53