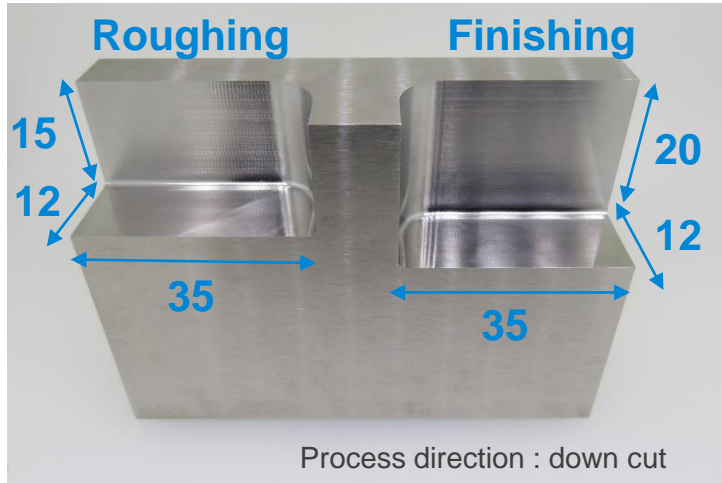


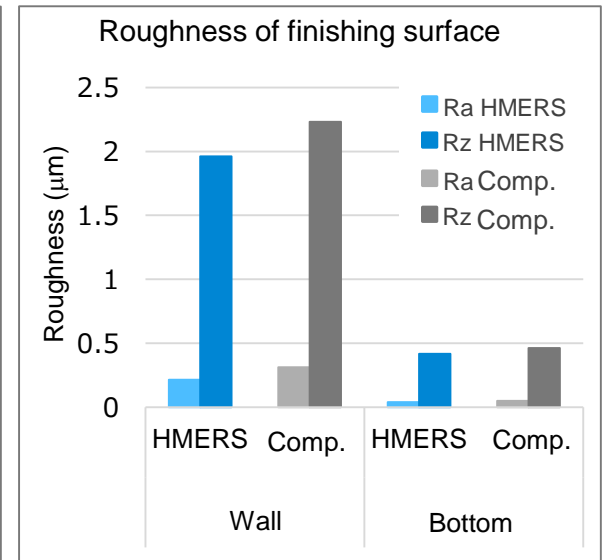
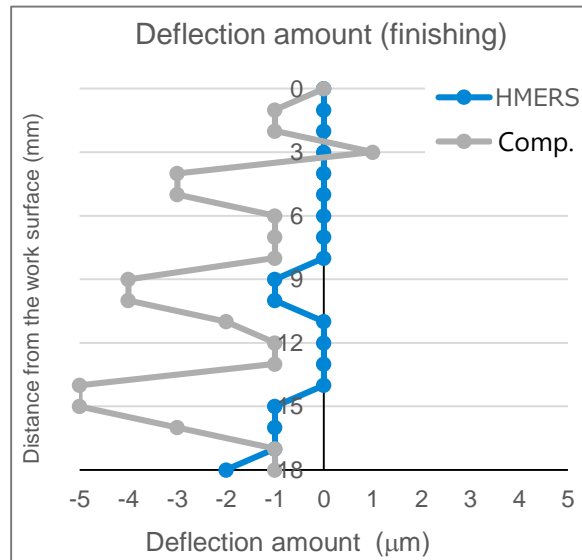
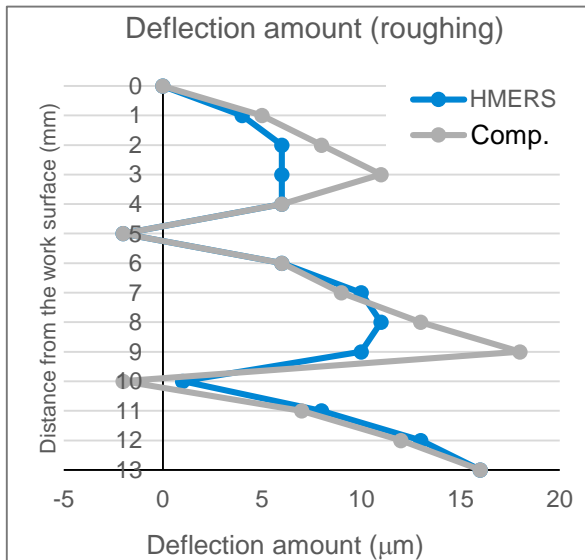
HMERS 6100-10-220 Milling example



Tool : $\phi 10$ HMERS LOC 22 x CR1
Comp. LOC 20 x CR1

Work material : SKD11 (59HRC)
Work size : 70 x 20 x 50 mm
Coolant : Air blow

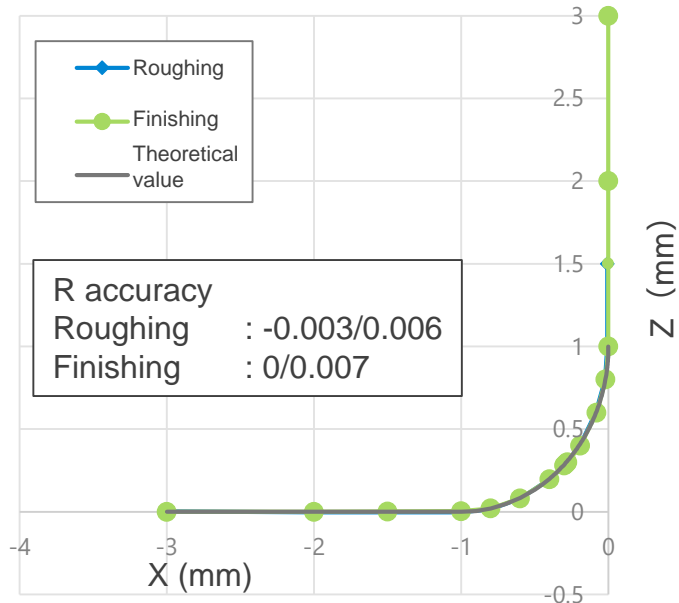
	No.	Process	Spindle Speed (min ⁻¹)	Feed Rate (mm/min)	a _p (mm)	a _e (mm)	Allowance (mm)	Cycle Time (h:m:s)
Left	1	Roughing	2,580	1,160	15.0	0.1	0	0:05:22
	1	Roughing		1,160	20.0	0.05	0.05	0:10:38
Right	2	Semi-roughing	2,580	580	20.0	0.04	0.01	0:25:11
	3	Finishing			20.0	0.01	0	1:40:43
Right total								2:16:32



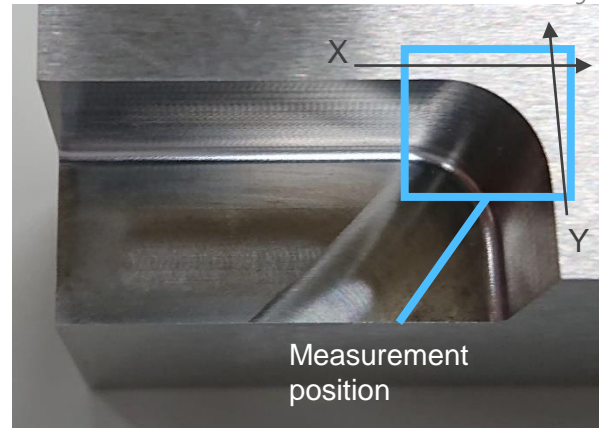
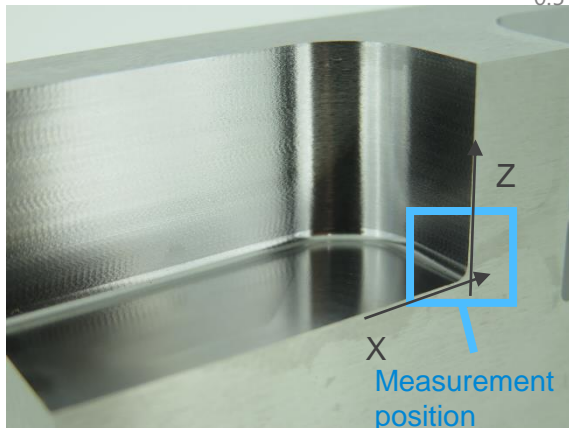
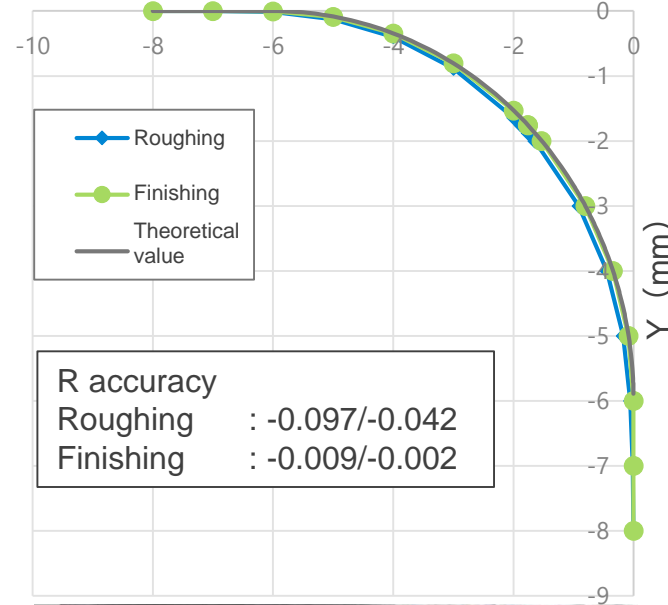
HMERS 6100-10-220 Milling example

HMERS 6100-10-220 Measurement of R accuracy of the work piece

Corner R1



Corner R6



Achieves good R accuracy

Measuring instrument:
Tool microscope