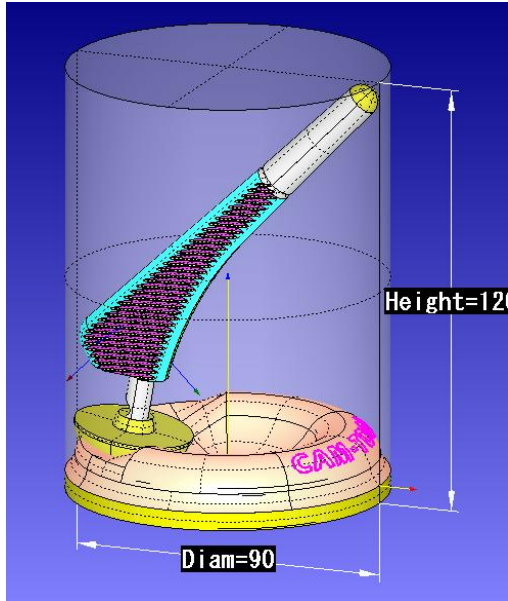


Ti Alloy Medical Part: Thighbone Implant Sample

UTCOAT
for low hardness material



- Work material : Titanium alloy Ti6Al4V
- Work size : φ90 mm x 120 mm
- Coolant : Oil-based cutting oil
- Total milling time : 9hr30min
- Machine : Mitsubishi Heavy Industries
Machine Tool μV1
- CAD/CAM : C&G Systems **CAM-TOOL**
- Tool holder : MST Corporation



Tool Used from the top	Tool Shape	Size	Spindle Speed (min ⁻¹)	Feed Rate (mm/min)
CNRS 4080-10-16	4-Flute Radius	φ8 x CR1 x 16	2,800	700
CFB 3060-0900	3-Flute Ball	R3 x 9	8,000	4,000
CFB 3040-0600	3-Flute Ball	R2 x 6	12,000	4,000
CSELB 2015-030	2-Flute Long Neck Ball	R0.75 x L3	26,000	1,560
CFB 3040-0600	3-Flute Ball	R2 x 6	12,000	4,000
CSELB 2040-120	2-Flute Long Neck Ball	R2 x L12	12,000	1,800
CFB 3030-0450	3-Flute Ball	R1.5 x 4.5	16,000	4,000
CSELB 2030-120	2-Flute Long Neck Ball	R1.5 x L12	16,000	1,600

