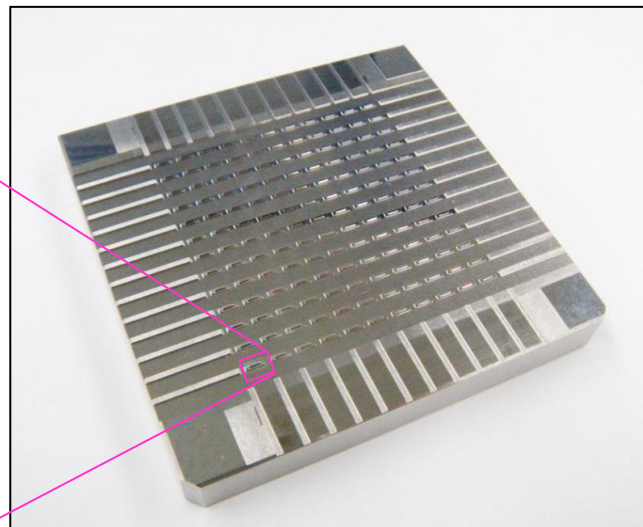
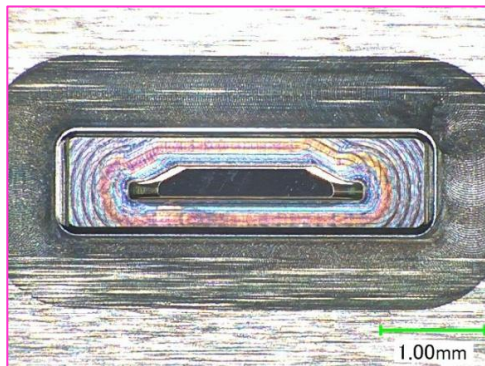


CBN-LRF ELMAX LED Mold Model



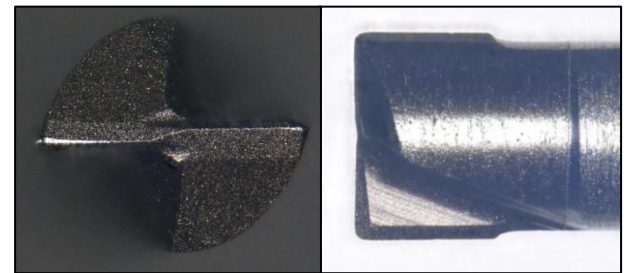
Tool : 2-flute high grade long neck radius **CBN-LRF $\phi 0.4 \times CR0.02 \times L1$**
 Model : LED mold
 Work material: ELMAX (62-64HRC)

Processed area by CBN-LRF



Work size: 80 x 80 x 10mm

Tool after finishing (Cycle time: 10 hr)



Process	Tool Geometry	Series / Size	Spindle Speed (min ⁻¹)	Feed Rate (mm/min)	Axial Depth a _p (mm)	Radial Depth a _e (mm)	Coolant	Cycle Time
Finishing	2-flute high grade long neck radius	CBN-LRF $\phi 0.4 \times CR0.02 \times L1$	38,000	600	0.01	0.01	Oil mist	10 hr