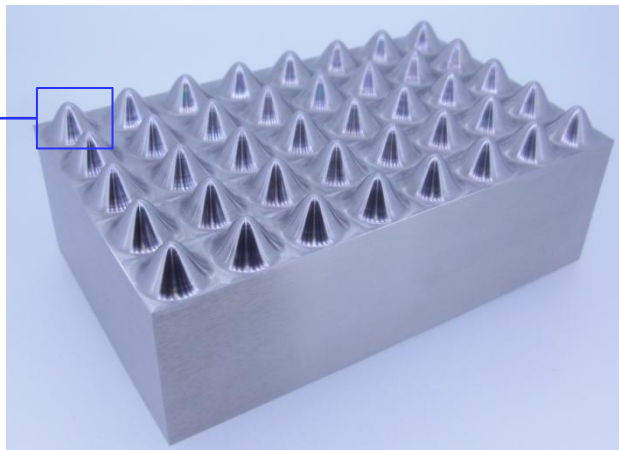


CBN-LBF Finishing - STAVAX

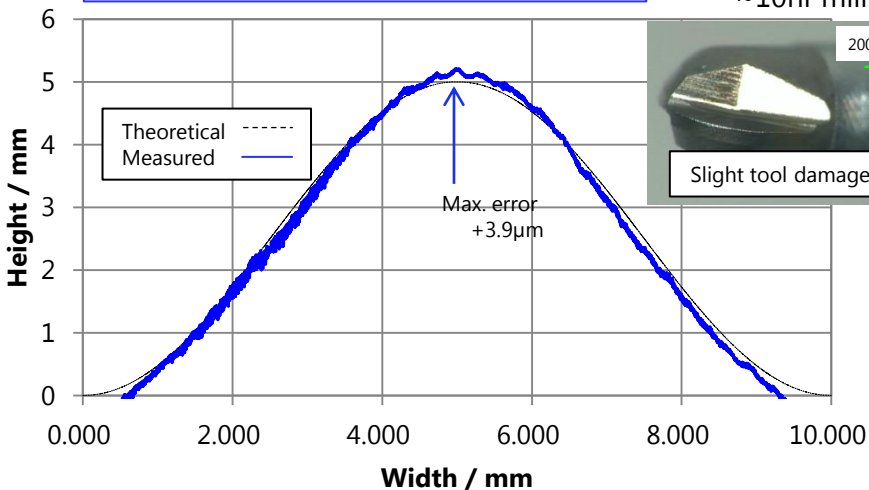
CBN Series



Tool: 2-Flute cBN Long Neck Ball **CBN-LBF 2006-015 (R0.3xL1.5 φ4 shank)**
 Work material: STAVAX(52HRC) Work size: 80 x 50 x t30 mm

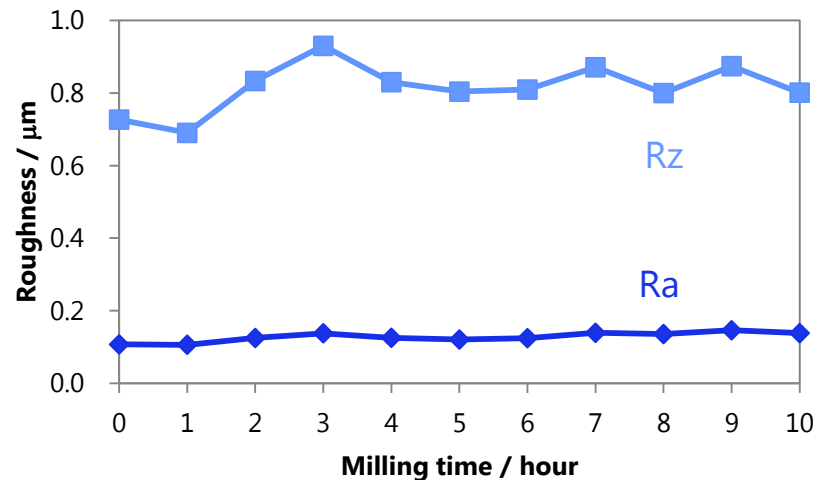
Details of milling	Contour spiral milling
Spindle Speed min^{-1}	30,000
Feed Rate mm/min	800
Axial depth(ap) mm	0.0001 (cusp height)
Radial depth(ae) mm	0.015
Coolant	Oil mist
Cycle Time	9hr48min2sec

Measuring shape after ~10hr milling



Tool damage after ~10hr milling

Surface roughness per hour



- Excellent finishing profile after milling 10 hours !
- Maintain outstanding surface roughness for long lead time!