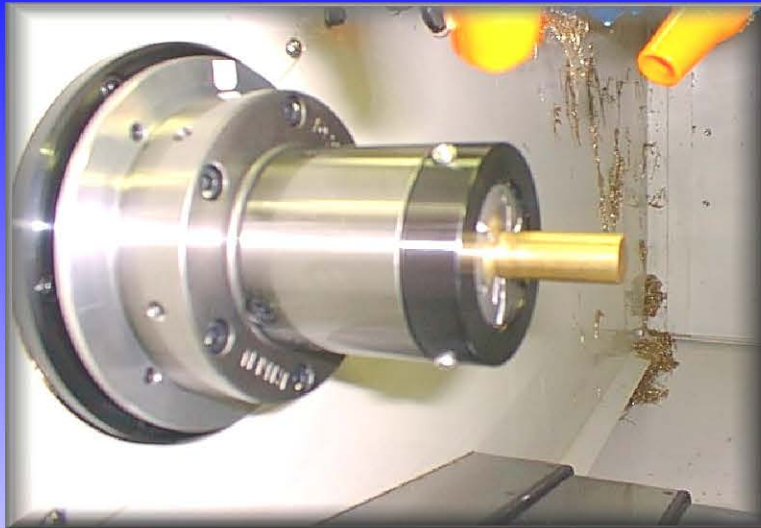




Continuous machining 100 brass workpieces Tolerance $1\mu\text{m}$ Cp1.62

SNC-35HP 100 continuous machining Inside diameter ($\phi 3$) dimensional changing data



Testing specifications
100 continuous machining after idling
Workpiece material $\phi 15\text{mm} \times 800\text{mm}$ brass bar
Processing condition
Spindle speed : 8000rpm
Feeding : 0.03mm/rev
Finishing allowance : $\phi 0.05\text{mm}$
Finishing cutting tool R0.3 R0.3 Natural diamond
Coolant Cutting oil
Cycle time 80sec
Inside diameter surface roughness
 $0.4\mu\text{mRmax}$

