

Rib Machining Sample

Machined on an Ultra-Precision VMC

Material: P20 Premium

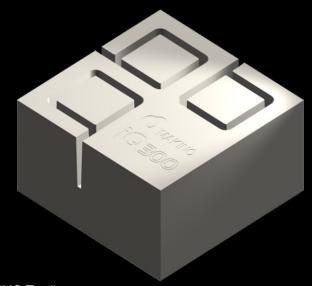
Hardness: 29-35 HRC

Part Size: 15mm x 30mm x 30mm

Rib Feature: 0.725mm x 7.5mm

Sidewall Roughness: 0.2 Ra (µm)

Tools Used: 1 cutter used for all ribs



Cutting Tool: 0.70mm x 8.0mm +1.0deg / (NS Tool)

Cycle Time: 1 hour 50 minutes each rib channel

Machine Used: Makino iQ300

Tool Path: Single pass, full depth, trochoidal / (Makino FFcam)

Trochoid Motion: Circular XY (0.0125mm per side) x 0.003mm step-over

