LFV result for test cutting

Material : SUS304
Process : Front turning (rough)
ap : 1.5
Main spindle speed : S1732
Feed rate : F0.03
G165 argument : P1 Q2.0 D1.5

LFV result for test cutting

Material : SS400
Process : Front turning (rough)
ap : 1.5
Main spindle speed : S1850
Feed rate : F0.03
G165 argument : P1 Q1.5 D1.5

LFV result for test cutting

SUS316

drilling φ12.0 →

Boring →

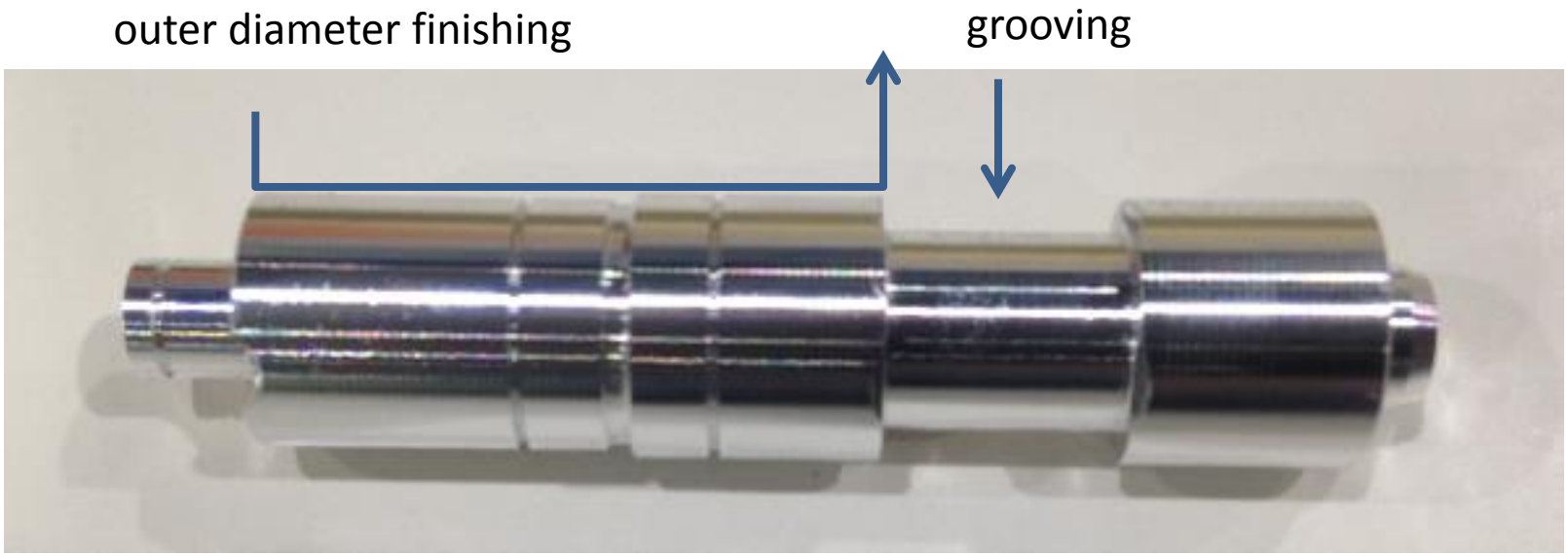
LFV result for test cutting

Material : SUS 316
Process : ϕ12 : insert OH drill
ϕ8.0 : hole size before threading
Main spindle speed : S689
Feed rate : F0.03
G165 argument : P1 Q1.75 D3.5
High pressure coolant (7MPa)
without stepping drilling

Material : SUS316
Process : Boring (rough)
ap : 0.875
Main spindle speed : S2531
Feed rate : F0.05
G165 argument : P2 E1.5 R0.6

LFV result for test cutting

A6061



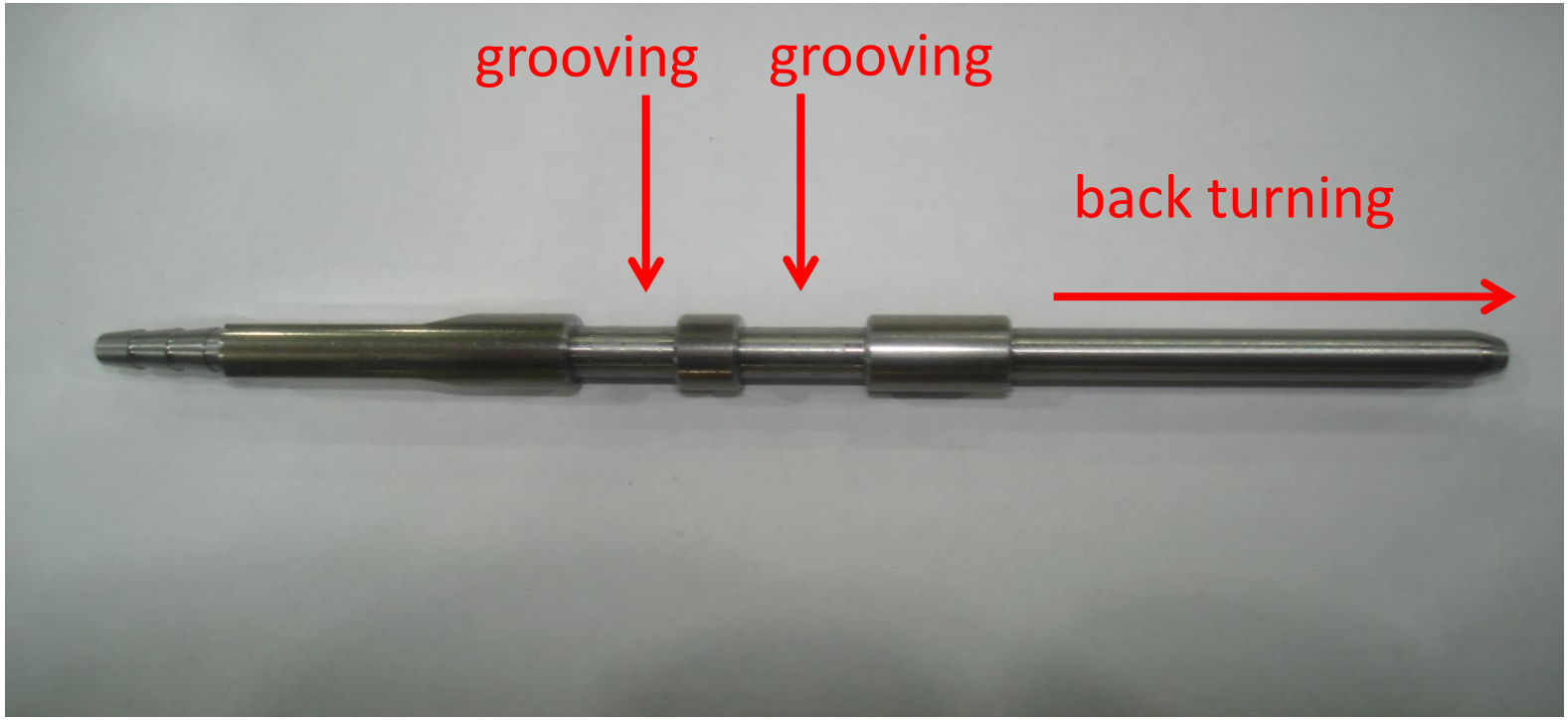
LFV result for test cutting

Material : A6061
Process : Front turning
ap : 0.2
Main spindle speed : S8438
Feed rate : F0.04
G165 argument : P2 E3.5 R0.5

Material : A6061
Process : Grooving
ap : ϕ9.0→ϕ6.4
Main spindle speed : S6750
Feed rate : F0.04
G165 argument : P2 E2.0 R0.5

LFV result for test cutting

S15C



CITIZEN

LFV result for test cutting

Material : S15C
Process : grooving + back turning
ap : 1.5
Main spindle speed : S3972
Feed speed : F0.03
G165 argument : P1 Q1.5 D0.5