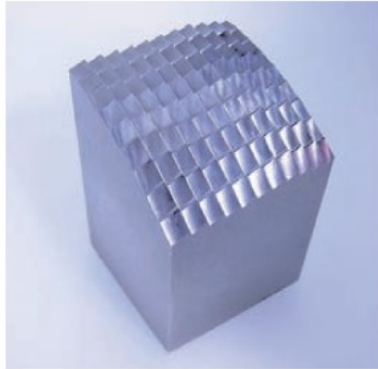


Reflector mold finishing
2 Flutes CBN-LBF R0.4 × EL2

STAVAX (52HRC)



CBN-LBF
Milling video of
reflector mold for
finishing



No	Process	Tool	Spindle Speed (min ⁻¹)	Feed Rate (mm/min)	a _p (mm)	a _e (mm)	Cycle Time (h:m:s)
1	Roughing	HRRS φ6 × CR1 × EL18	3,500	2,500	0.2	2	0:18:00
2	Semi-roughing	HRRS φ6 × CR1 × EL18	9,000	2,500	0.05	0.1	0:13:35
3	Semi-roughing	HRRS φ2 × CR0.3 × EL6	3,500	1,000	0.04	1	0:33:55
4	Semi-finishing	HSB R1.5	12,000	2,500	0.02	0.07	0:12:24
5	Semi-finishing	HSB R0.75	7,000	1,000	0.04	0.07	0:20:50
6	Semi-finishing	HSB R0.75	7,000	700	0.05	0.05	0:18:08
7	Semi-finishing	HSB R0.5	8,000	500	0.02	0.03	0:23:24
8	Semi-finishing	HSB R0.5	15,000	1,200	0.02	0.03	1:30:33
9	Finishing	CBN-LBF R0.4 × EL2	26,000	800	0.01	0.004	10:12:54
Total							14:03:43

Total 64 models

*Shank taper angle Bta is only for reference.

Unit (mm)

Model Number	Radius of Ball Nose R	Effective Length ℓ ₁	Length of Cut ℓ	Neck Diameter φ _d	Shank Taper Angle Bta	Overall Length L	Shank Diameter φ _d	Suggested Retail Price ¥	Effective Length by Inclined Angles									
									30°	1°	1°30'	2°	3°					
CBN-LBF 2001-003	R0.05	0.3	0.08	0.09	15°	50	4	42,400	0.30	0.30	0.30	0.30	0.33					
CBN-LBF 2001-005		0.5												0.50	0.50	0.51	0.53	0.57
CBN-LBF 20015-0045	R0.075	0.45	0.15	0.14	15°	50	4	42,400	0.45	0.45	0.46	0.48	0.51					
CBN-LBF 20015-0075		0.75												0.75	0.76	0.78	0.81	0.88
CBN-LBF 2002-003	R0.1	0.3	0.16	0.19	15°	50	4	28,800	0.30	0.30	0.30	0.30	0.32					
CBN-LBF 2002-006		0.6												0.60	0.60	0.62	0.64	0.69
CBN-LBF 2002-010		1												1.00	1.03	1.06	1.10	1.19
CBN-LBF 2003-005	R0.15	0.5	0.24	0.28	15°	50	4	28,800	0.51	0.53	0.54	0.56	0.60					
CBN-LBF 2003-0075		0.75												0.77	0.79	0.82	0.85	0.91
CBN-LBF 2003-009		0.9												0.91	0.94	0.96	1.00	1.06
CBN-LBF 2003-015		1.5												1.53	1.58	1.63	1.68	1.80
CBN-LBF 2004-005	R0.2	0.5	0.32	0.38	15°	50	4	27,700	0.51	0.52	0.54	0.55	0.58					
CBN-LBF 2004-0075		0.75												0.77	0.79	0.81	0.84	0.90
CBN-LBF 2004-010		1												1.03	1.06	1.09	1.13	1.21
CBN-LBF 2004-012		1.2												1.22	1.25	1.29	1.33	1.42
CBN-LBF 2004-020		2												2.04	2.10	2.17	2.24	2.40
CBN-LBF 2004-030		3												3.07	3.17	3.27	3.38	3.62
CBN-LBF 2005-010	R0.25	1	0.4	0.48	15°	50	4	27,700	1.02	1.05	1.08	1.12	1.19					
CBN-LBF 2005-015		1.5												1.53	1.57	1.62	1.66	1.78
CBN-LBF 2005-025		2.5												2.56	2.63	2.72	2.80	3.00
CBN-LBF 2005-035		3.5												3.59	3.70	3.82	3.94	4.22