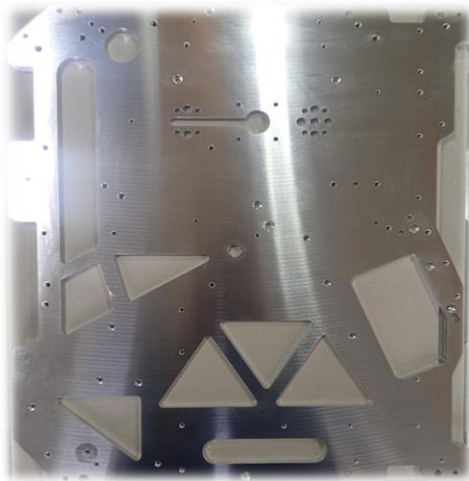


Customer : LOMAN - #1 Aluminium plate chamfering



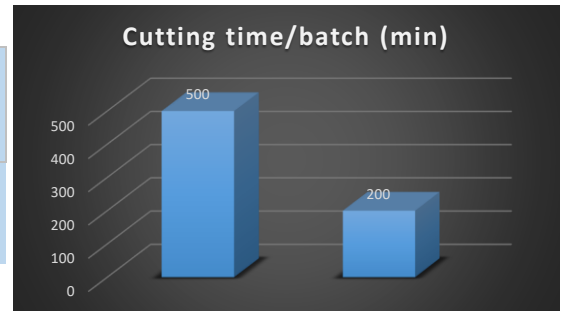
| Machine | |
|------------------|-----------------------------|
| Name | Doosan NHP5000 |
| Type | Horizontal machining center |
| Coolant pressure | 60bar |

| Workpiece | |
|------------------|--------------------------|
| Material | 3.3547 (Aluminium alloy) |
| Plate dimensions | 513x585x8 |
| PCS per shift | 18 |
| PCS per batch | 200 |

| Operation | Chamfering | |
|--------------------------|-------------------------------|-----------------------|
| Test Data | Machine Spindle | TJS GJET |
| Cutting tool | indexable 45° chamfer endmill | SC chamfering endmill |
| Diameter | 12 | 6 |
| Teeth | 4 | 4 |
| Cutting depth | 0,2 | 0,2 |
| RPM (rev/min) | 8000 | 40000 |
| Table feed (mm/min) | 3000 | 15000 |
| Feed (mm/tooth) | 0,094 | 0,094 |
| RESULTS | Machine Spindle | TJS GJET |
| Cutting time/pc (min) | 2:30 | 1 |
| Cutting time/batch (min) | 500 | 200 |

Time saving

60%



#2 Stainless steel slotting

| Workpiece | |
|-----------|-----------------|
| Material | stainless steel |

| Operation | Slotting | |
|-----------------------|------------------------|-----------------|
| Test Data | Machine Spindle | TJS GJET |
| Cutting tool | SC Endmill | SC Endmill |
| Diameter/Width of cut | 1 | 1 |
| Teeth | 3 | 3 |
| Cutting depth | 0,5 | 0,5 |
| RPM (rev/min) | 11500 | 26000 |
| Table feed (mm/min) | 50 | 450 |
| Feed (mm/tooth) | 0,001 | 0,006 |
| RESULTS | Machine Spindle | TJS GJET |
| Cutting time/pc (min) | 15:52 | 2:25 |

Time saving

85%

