

NAK mold



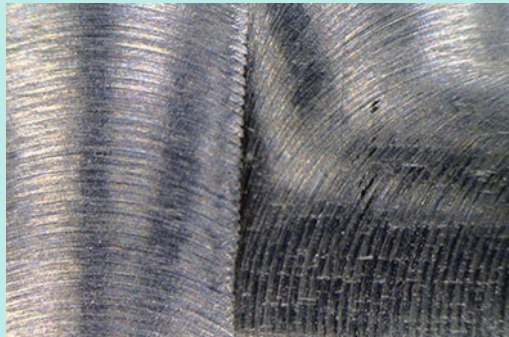
Workpiece information

Industry	Mold
Part name	NAK Mold
Material type	NAK
Cutting process	End mill processing

Processing conditions

Tool	XEBEC Brush for Surface (A31-CB25M+A11-CB25M)
Processing detail	Removal of cutter marks and polishing after end milling process Tool used : A31-CB25M, Rotation speed : 5000min ⁻¹ , Feed : 500 mm/min, Depth of cut : 0.3mm and Tool used : A11-CB25M, Rotation speed : 5000min ⁻¹ , Feed : 500mm/min, Depth of cut : 0.2mm
Spindle Speed (min ⁻¹)	5,000
Table Feed (mm/min)	500
Depth of cut (mm)	0.3
Machining time (sec)	50

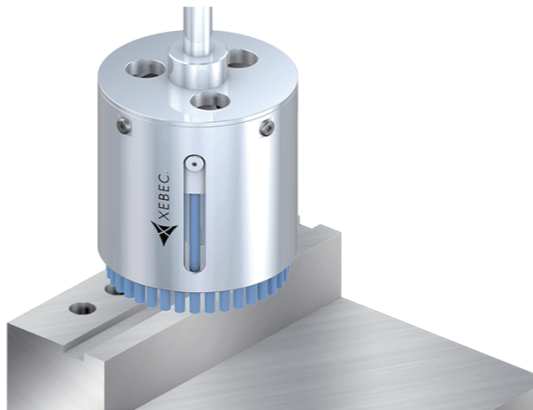
Before



After



Tool	XEBEC Brush for Surface (A31-CB25M+A11-CB25M)
Problem	Surface roughness improved from Ra 1.4μm, Rz 6.1μm to Ra 0.029μm, Rz 0.337μm respectively.



Deburring after face-milling, end-milling and drilling
Cutter mark removal and polishing on surface

Tool XEBEC Brush™ Surface

Ideal for deburring, cutter mark removal and polishing on surface

