

Nanotech 250UPL^{v2} Objective

To characterize our Fast Tool Servo machining an electroless nickel plated toric insert in terms of both surface finish and form accuracy

Process

FTS Machining

Optional Accessory Item

NFTS-6000 Fast Tool Servo



Application Summary

Part Configuration

Material: EINi
 Diameter: 6 mm
 Radii: 8.6 / 13 mm
 Surface Type: CX Toric

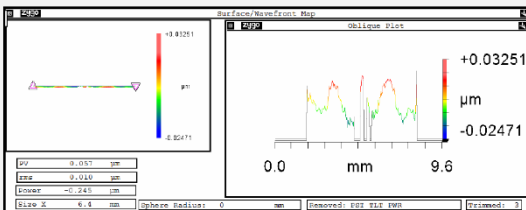
Tool Configuration

Radius: 0.76mm
 Top Rake: 0 Degree

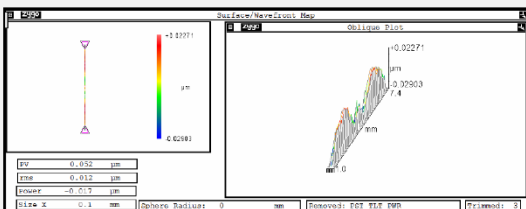
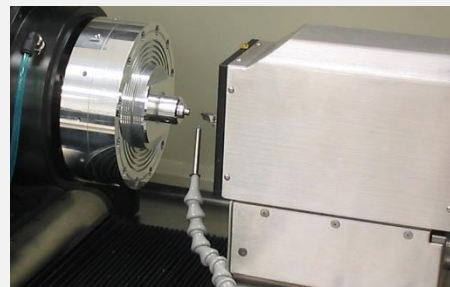
Machining Parameters

Spindle RPM: 1,000
 Finish Feedrate: 2 mm/min
 Finish Depth of Cut: 2 μ m
 Coolant: Odorless Mineral Spirits

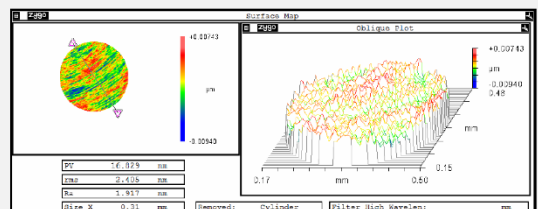
Metrology Results



Form Accuracy: PV = 0.057 μ m, 8.6 mm Rad



Form Accuracy: PV = 0.052 μ m, 13 mm Rad



Surface Finish: Ra = 1.917 nm