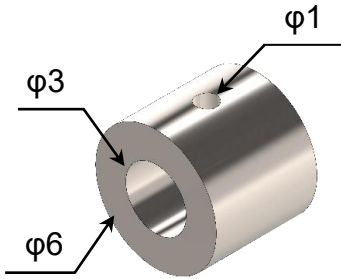
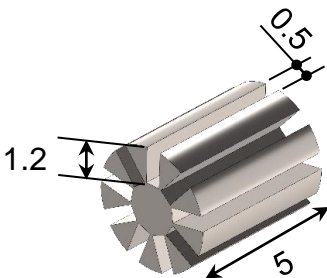


Examples (i)



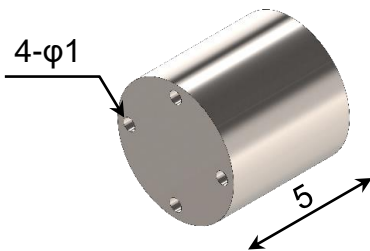
Method	Material
φ1 cross drilling	SUY-1

	Standard Spindle	IB-Spindle
O/D	φ1	
Tool material	Carbide drill	
RPM	4,000min ⁻¹	16,000min ⁻¹
Feed per Speed	F20	F80
Cycle Time	60sec	30sec



Method	Material
Slit milling	Titanium

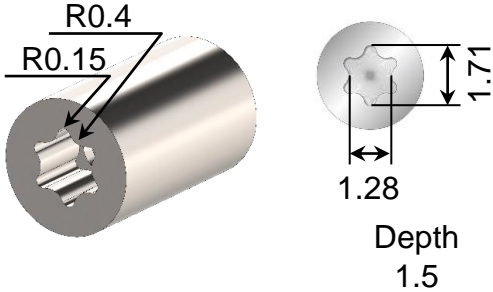
	Standard Spindle	IB-Spindle
O/D	φ0.5	
Tool material	Carbide EM	
RPM	6,000min ⁻¹	24,000min ⁻¹
Feed per Speed	F20	F80
Cycle Time	86min	29min



Method	Material
Eccentricity drilling	SUY-1

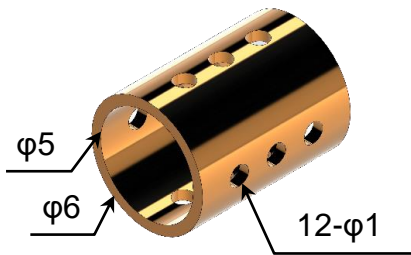
	Standard Spindle	IB-Spindle
O/D	φ1	
Tool material	Carbide drill	
RPM	4,000min ⁻¹	16,000min ⁻¹
Feed per Speed	F20	F80
Cycle Time	10min	5min

Examples (ii)



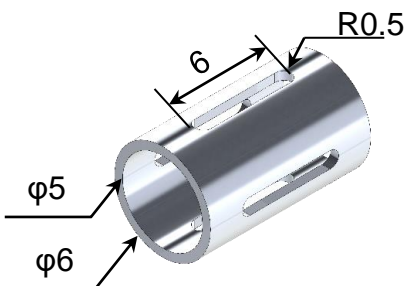
Method	Material
Torx	Titanium

	Standard Spindle	IB · Spindle
O/D	Φ0.3	
Tool material	Carbide EM	
RPM	6,000min ⁻¹	24,000min ⁻¹
Feed per Speed	F24	F60
Cycle Time	8min	3min



Method	Material
Cross drilling	Brass

	Standard Spindle	IB · Spindle
O/D	Φ1	
Tool material	Carbide drill	
RPM	6,000min ⁻¹	24,000min ⁻¹
Feed per Speed	F150	F600
Cycle Time	18sec	9sec



Method	Material
Cross milling	Aluminum

	Standard Spindle	IB · Spindle
O/D	Φ1	
Tool material	Carbide EM	
RPM	6,000min ⁻¹	24,000min ⁻¹
Feed per Speed	F60	F240
Cycle Time	36min	20min