

TQ - Additional Details

Enquiry	Through CP	If CP Customer, CP Name :	Mascot CNC				Customer Acceptance/Change during Trial								
		If other remarks :					Change in Parameters		Allowed						
Customer Registered	No	If Yes, Customer Code :					Change in Cutting Method		Allowed						
		If No :	<i>Please register the customer</i>				Change in Tool Diameter		Allowed						
Industry Type	General Engg	If other remarks :	New Development Case				If other remarks:								
Business Type	Batch production	If other remarks :													
Tool Consumption :	05-Jan	/Month	If Other remarks :				Existing Tool Details								
Competitor Tool Life	No. of Component	25	Business Potential	One Time	Rs.										
	In Minutes	210		Per Year	Rs.										
Other remarks :	Technically we need to get life 25+ Components					Existing make									
						End Mill Type		D1	R	L2	L3	L1	Z		
						Flat		16							
Competitor Tool Price in Rs.					If Others :										
Enquiry for Quotation / Trials	Trial to be Conducted				If Others :										
Tool Acceptance Criteria	Tool Life (Qty/Minutes)				If Others :										
Trial Tool Request Terms	Trial PO with Terms				If Others :										
Present Cutting Method					Brief points upon Application Details										
Cutting Method / Strategy					<p>Main focus on tool life.</p> <p>Can apply any milling strategy.</p> <p>Currently uses Blood and Shining make Endmill.</p> <p>Finishing Operation on Face, OD and ID.</p> <p>Need t remove stock of 0.1-0.2 mm from sides.</p> <p>Roughing or stock removal before finishig is done with Inserted tool.</p> <p>Existing Life - 22 to 25 Components.</p> <p>Milling Cycle time - 11 min.</p> <p>Cycle time for machining complete component - 1 hr 30 min.</p>										
Programming method													CAM Programming		
Name Of CAM if used													Fanuc		
Total Stock-In Depth		0.1-0.2 m	mm												
Total Stock-In Width		60-80 mn	mm												
Step 01	Face Milling	a_p	0.1	mm											
		a_e	16	mm											
Step 02	Circular Interp.	a_p	4	mm											
		a_e	0.1	mm											
Step 03	Circular Interp.	a_p	4	mm											
		a_e	0.1	mm											
Step 04	---Select---	a_p		mm											
		a_e		mm											
Remarks (if any) :															