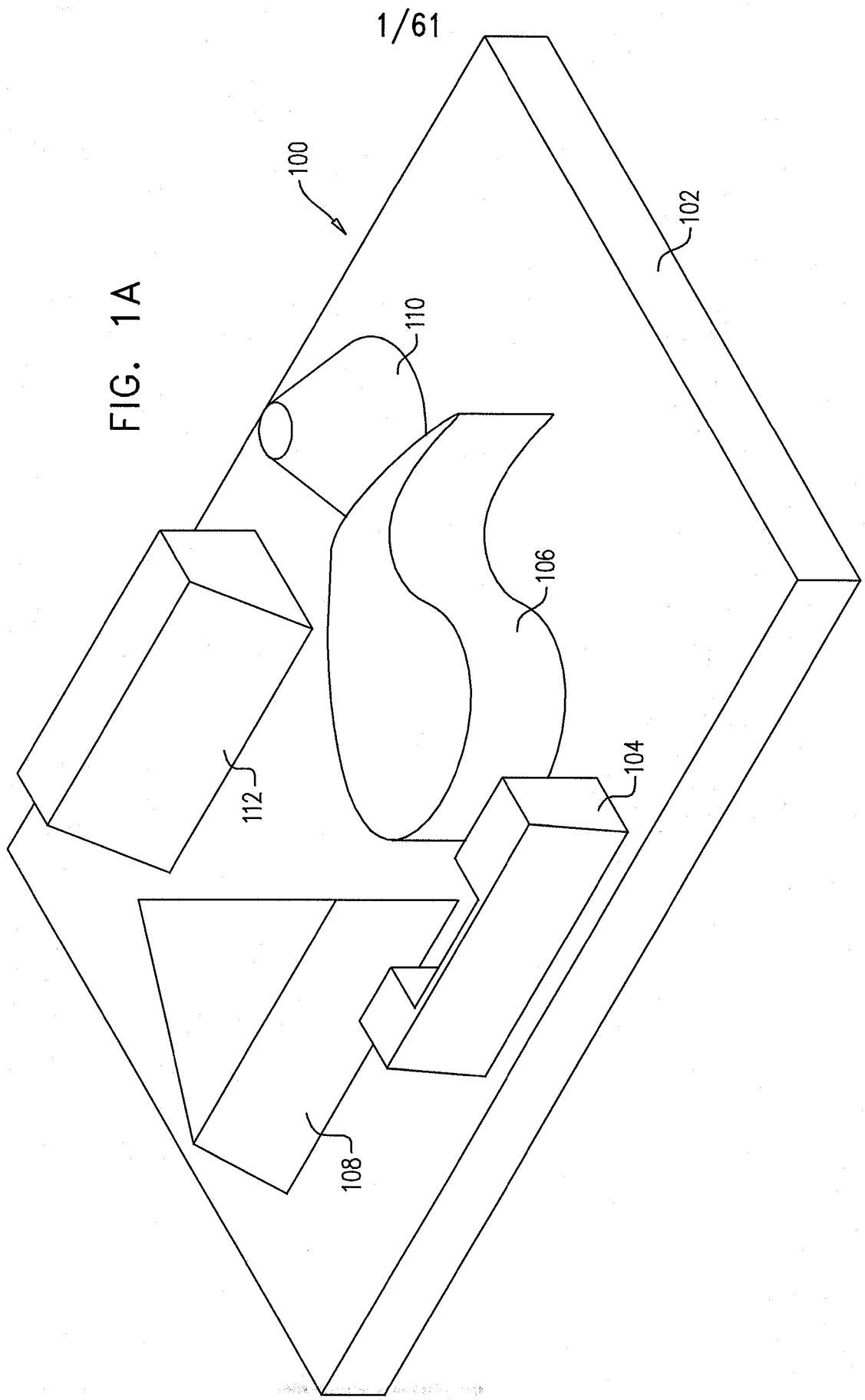


FIG. 1A



1/61

FIG. 1B

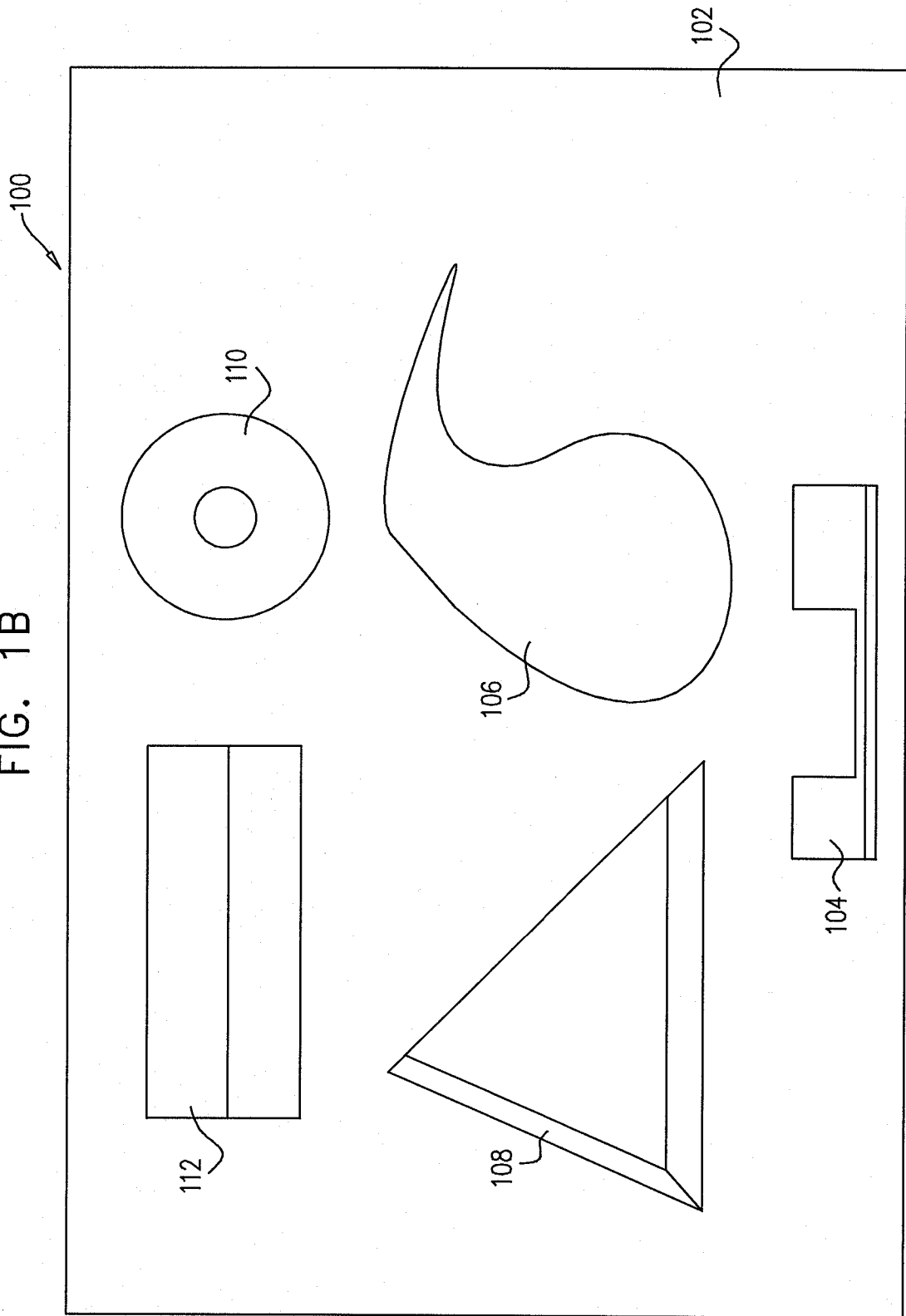


FIG. 1C

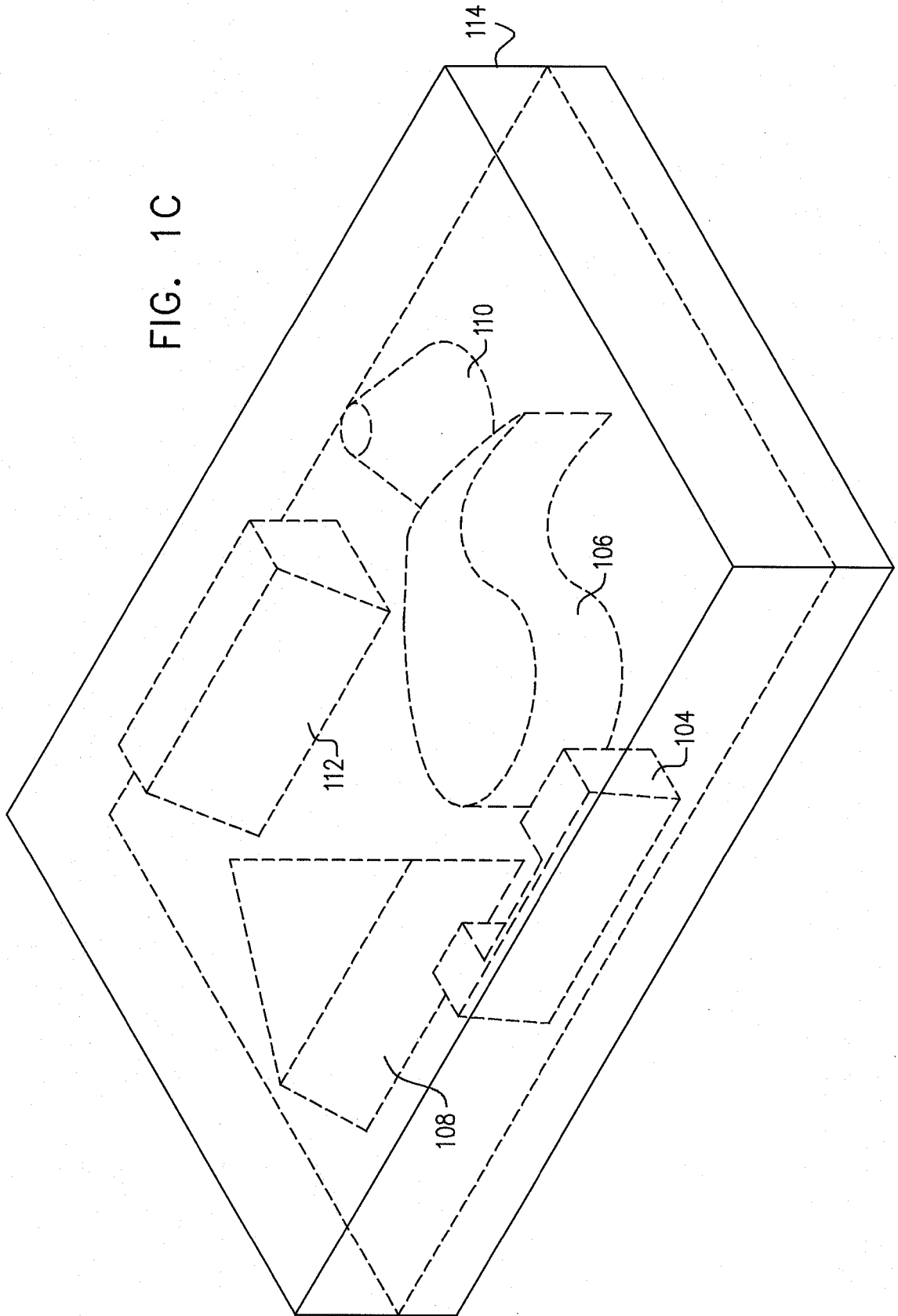


FIG. 1D

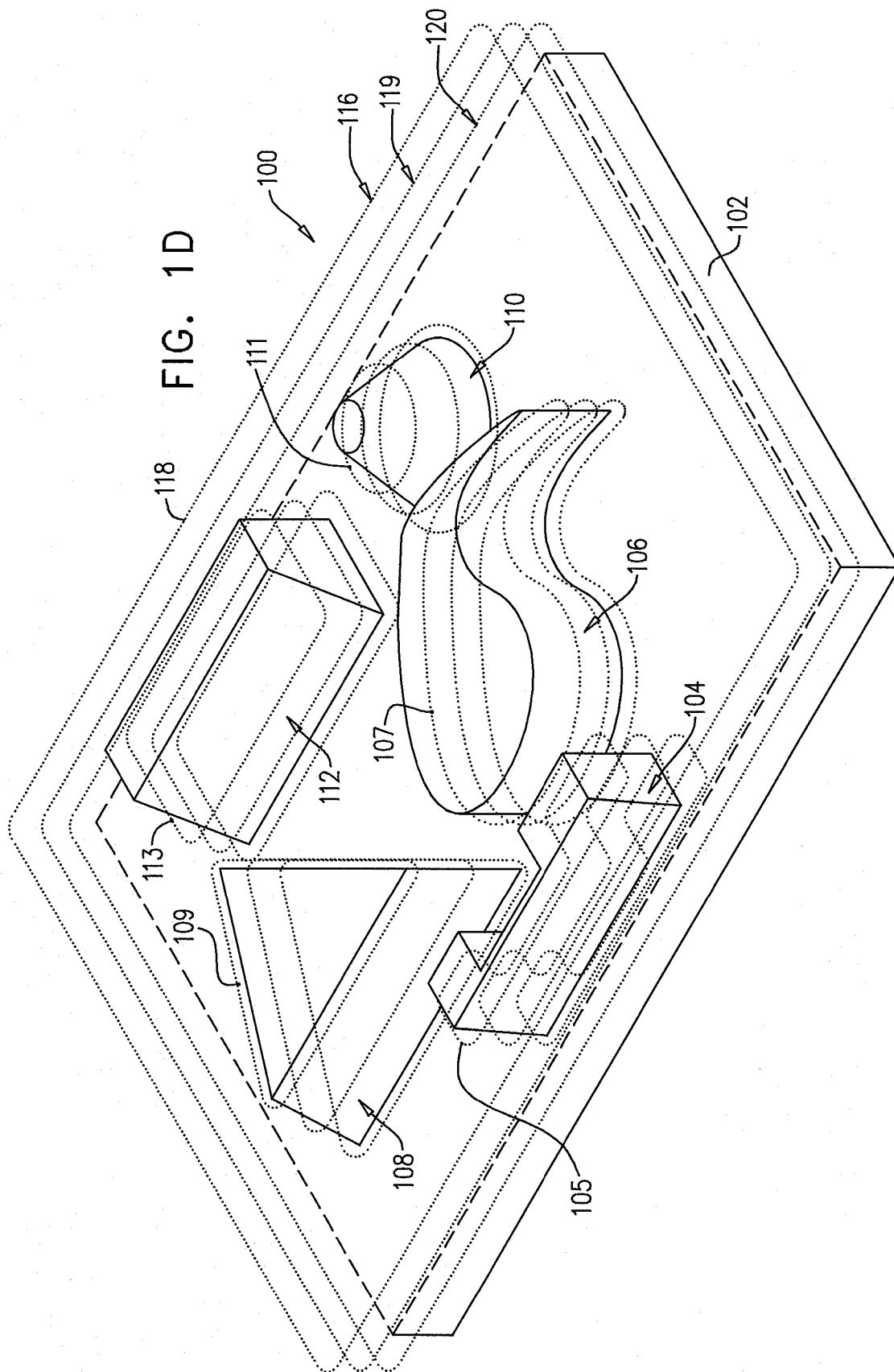


FIG. 1E-1

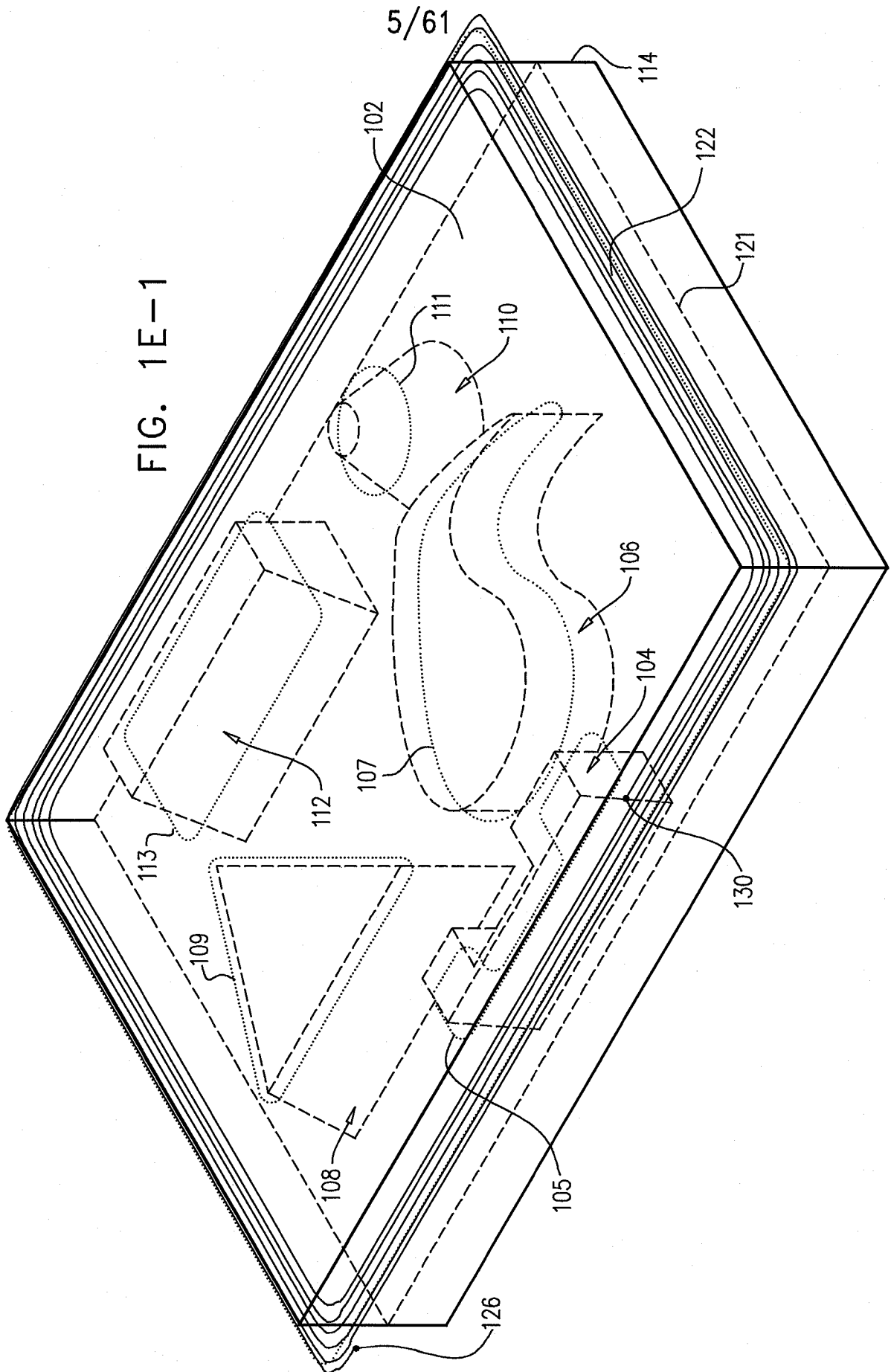


FIG. 1E-2

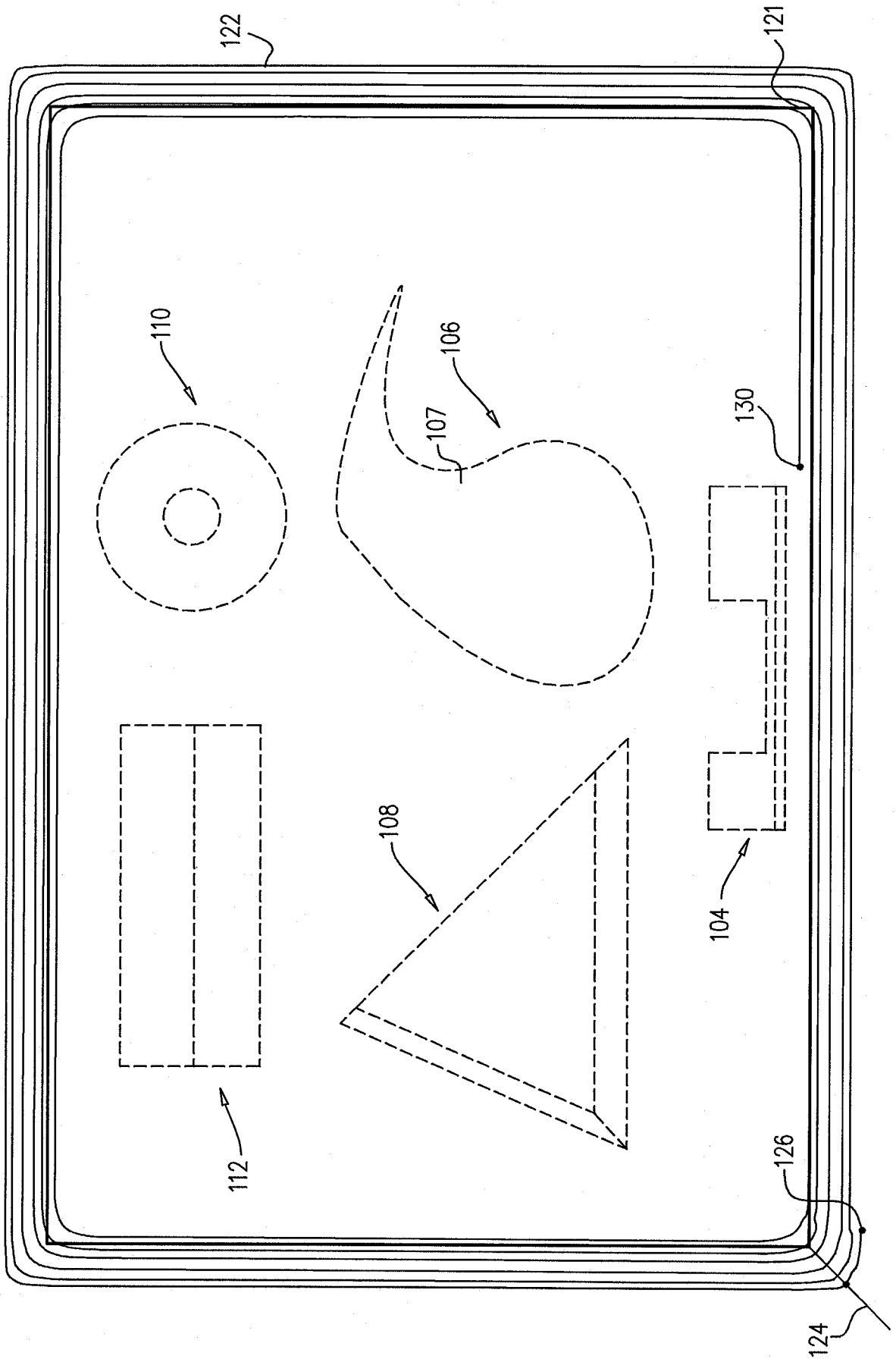


FIG. 1F-1

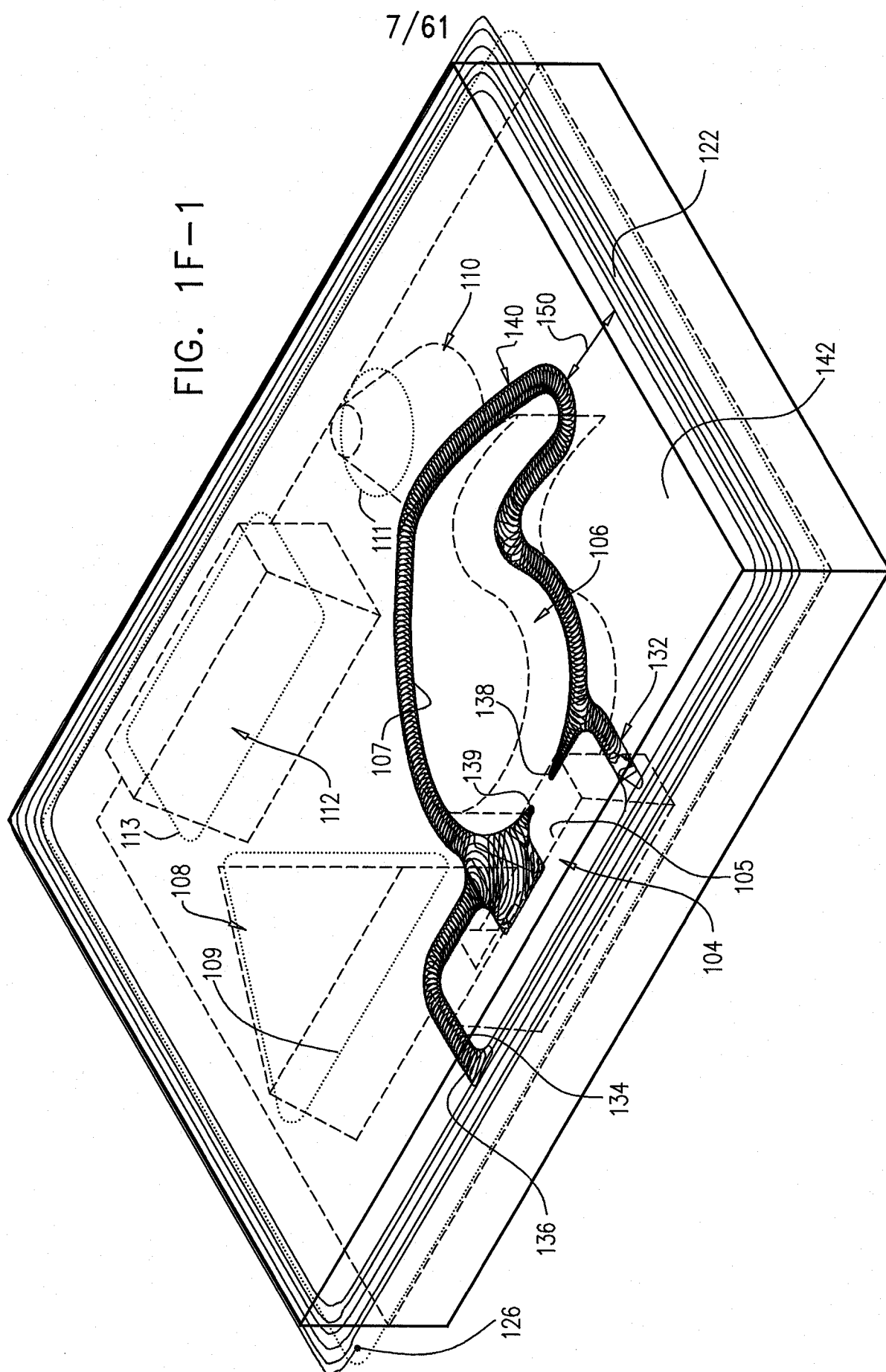
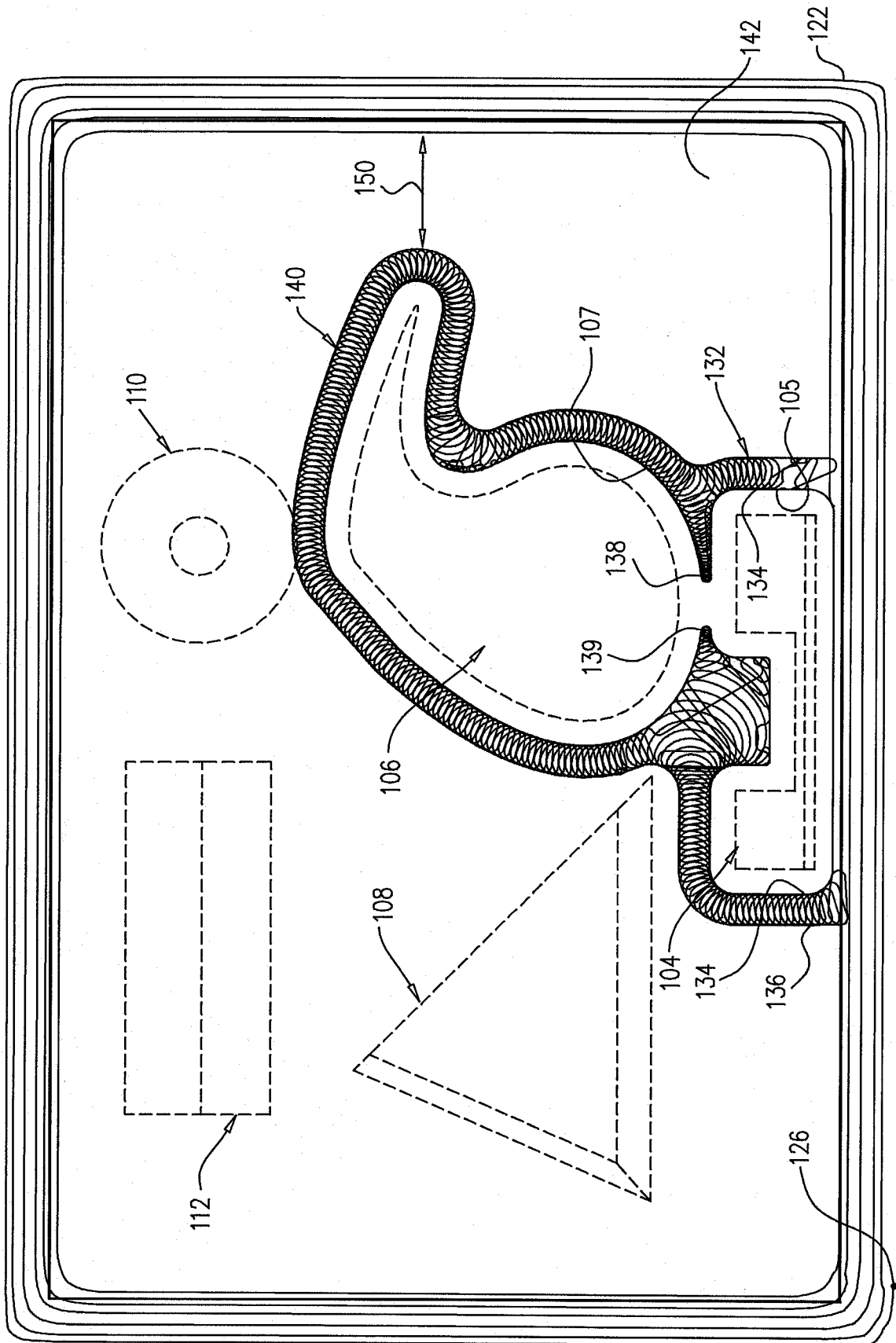


FIG. 1F-2



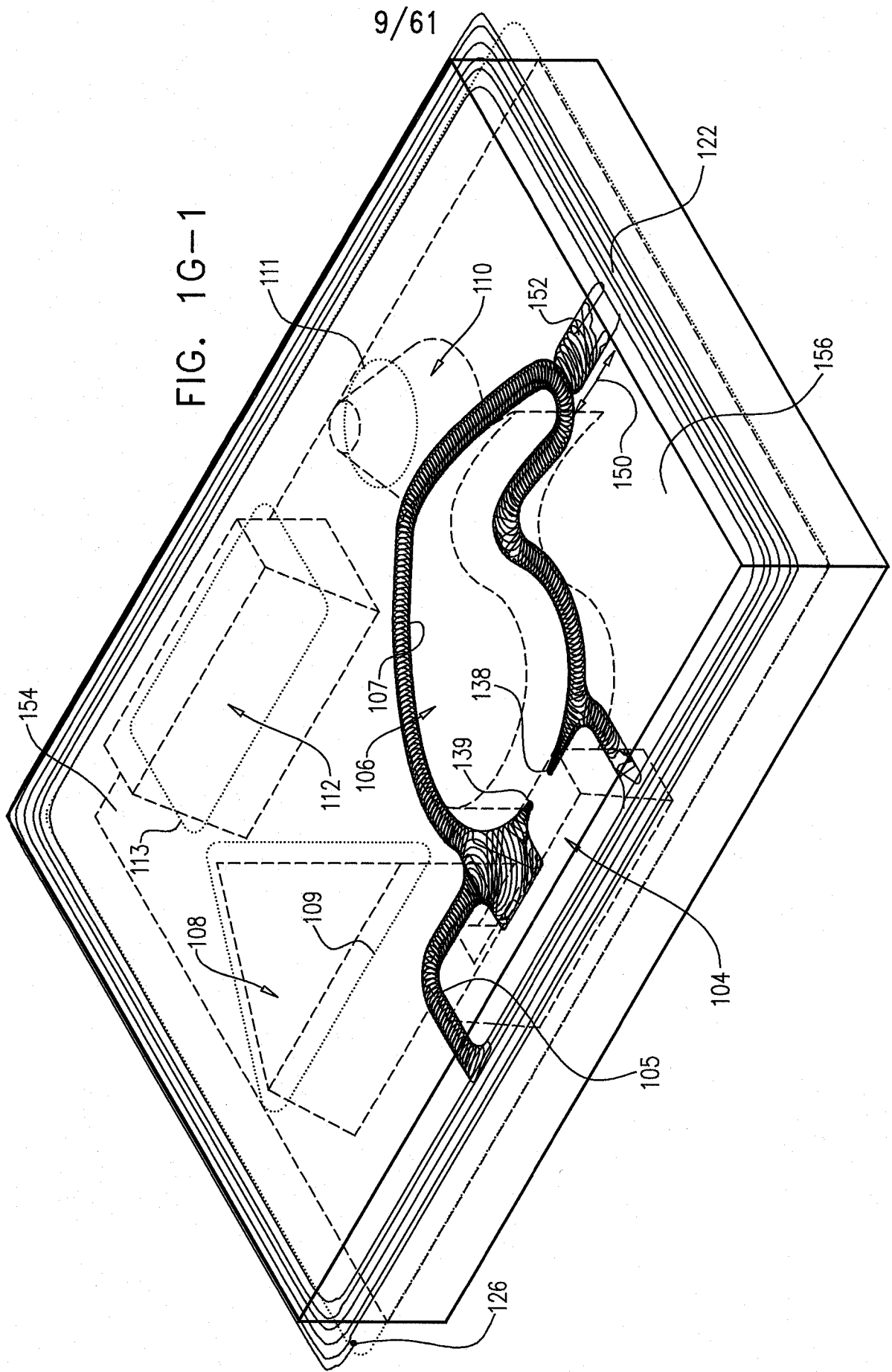
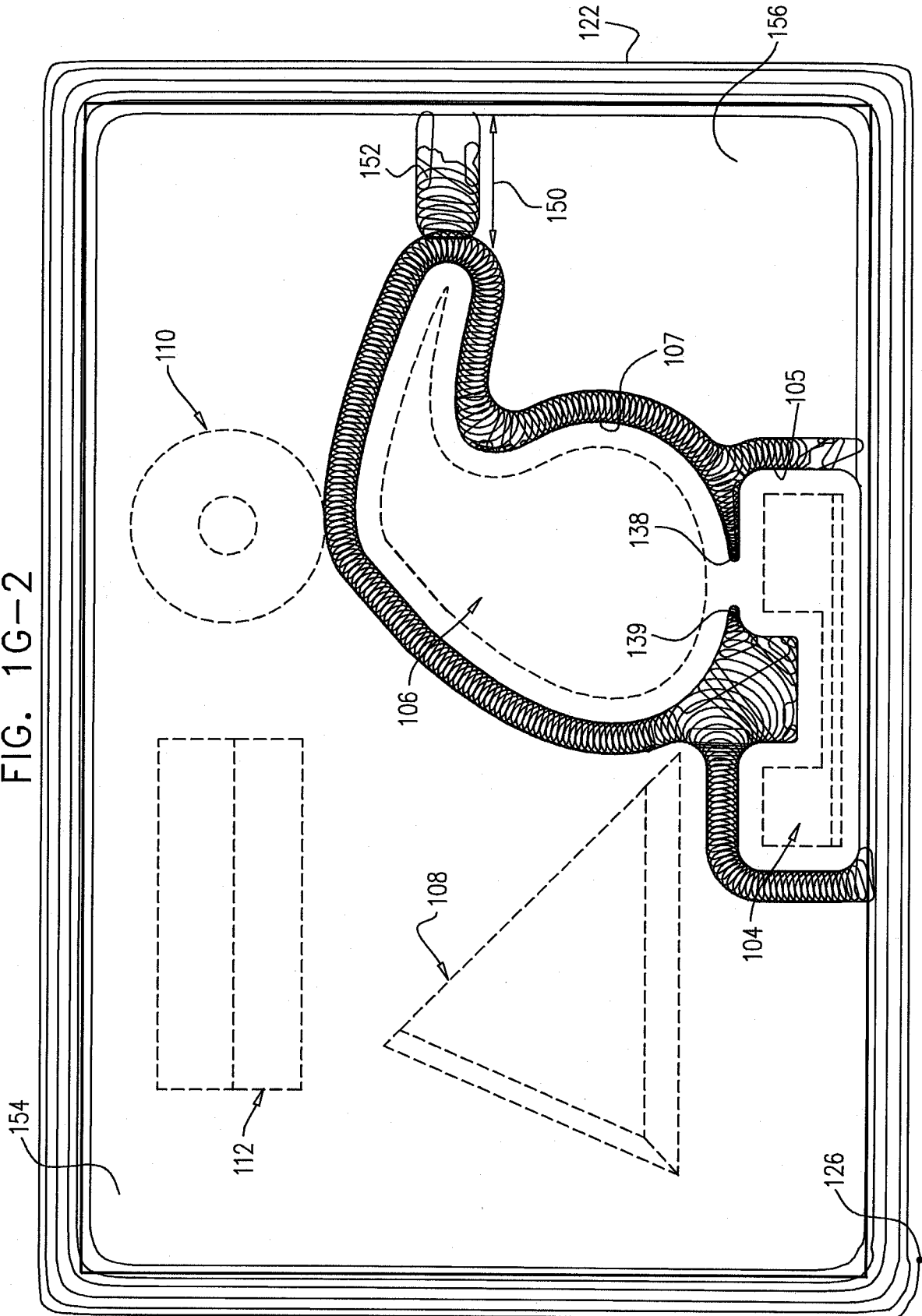
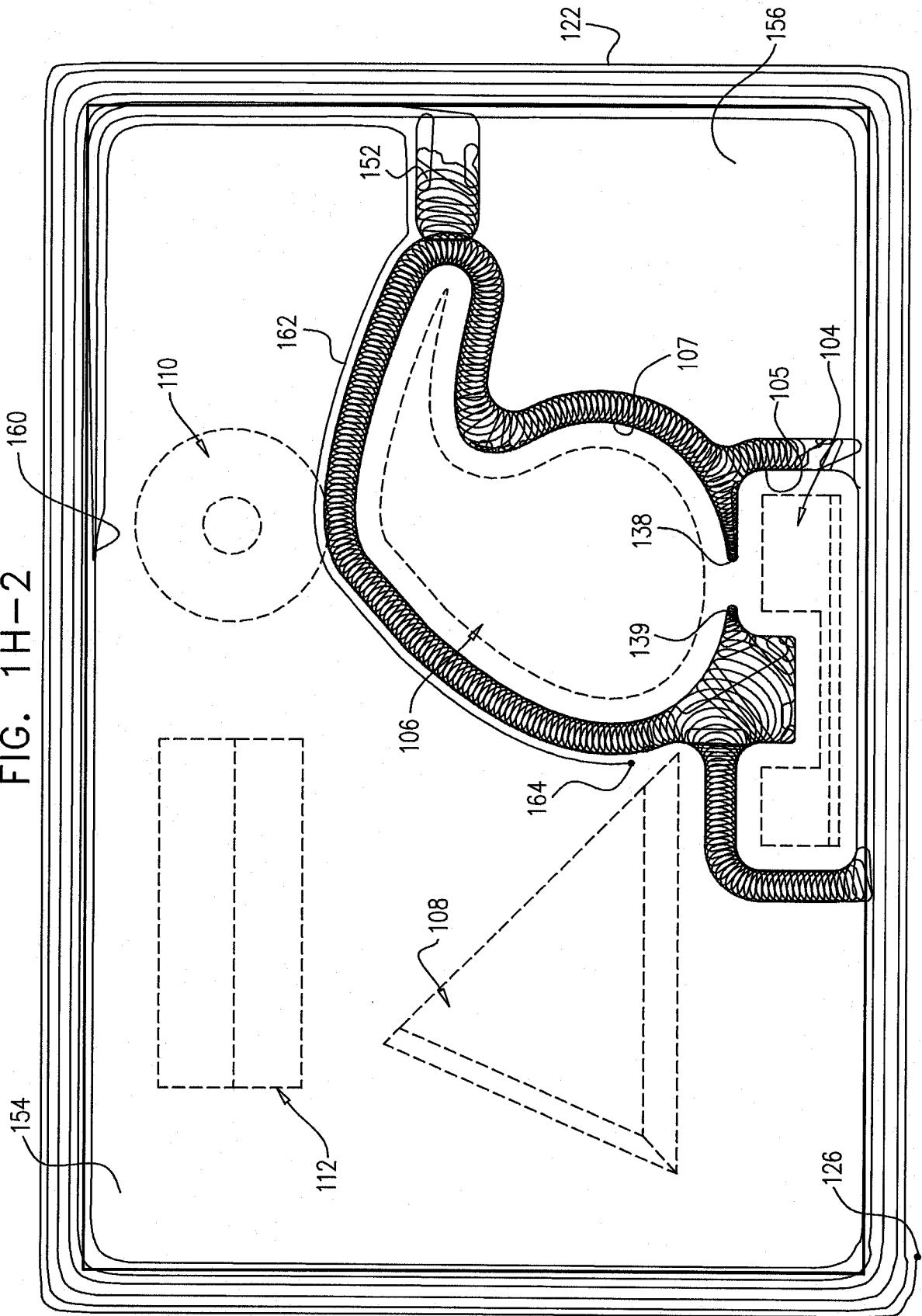


FIG. 1G-2



[illegible][illegible][illegible][illegible][illegible][illegible][illegible][illegible][illegible][illegible]

FIG. 1H-2



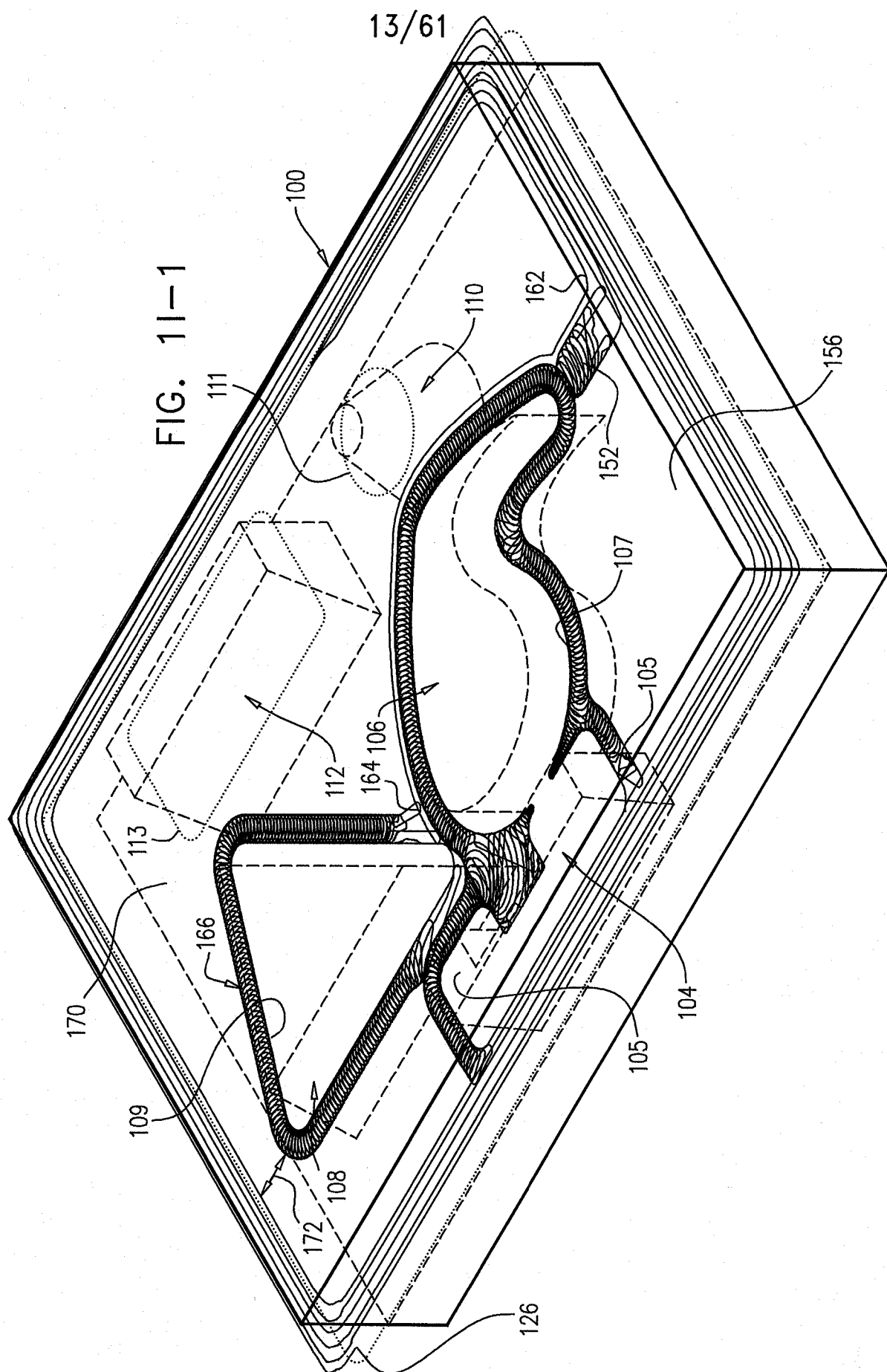
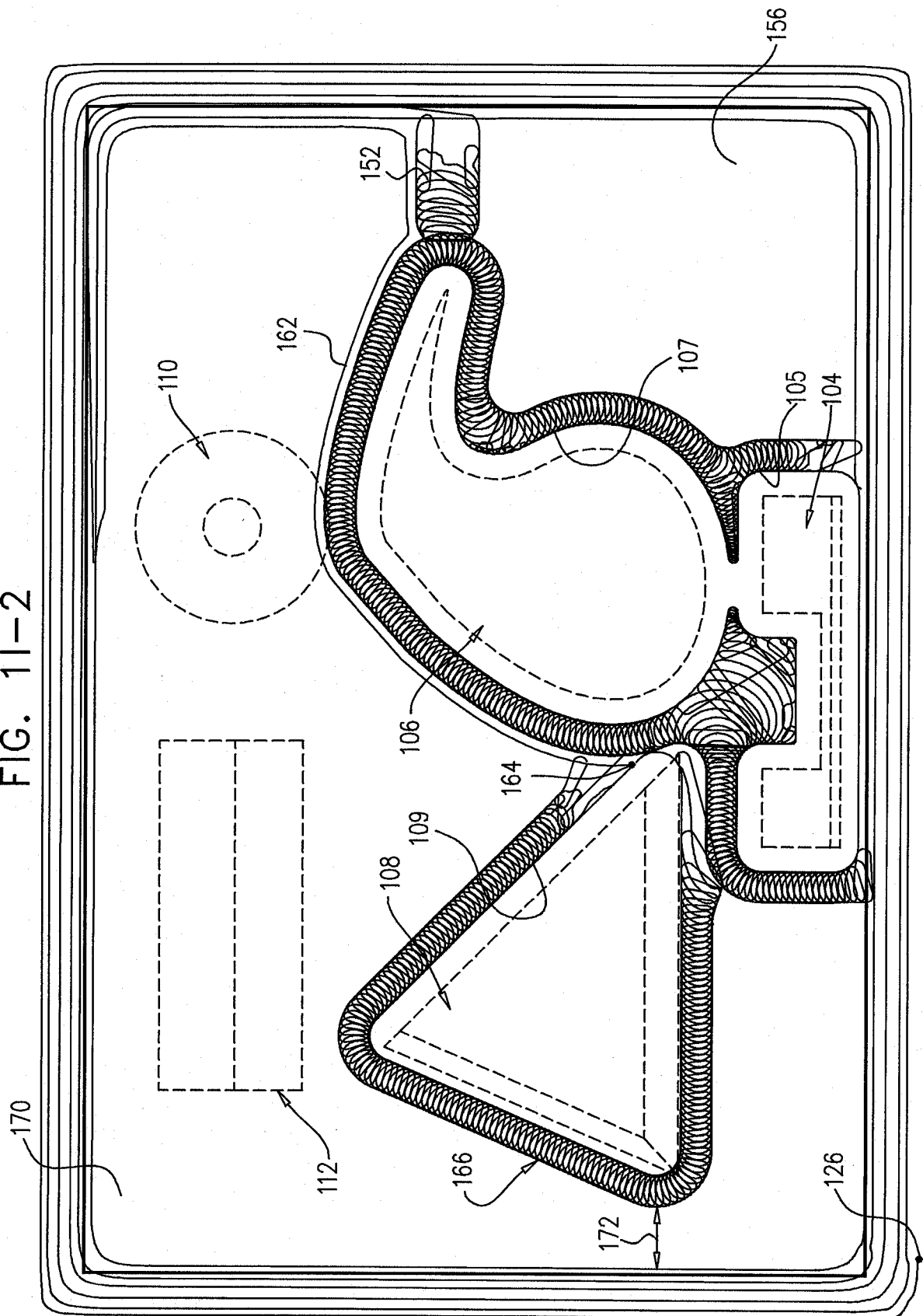


FIG. 11-2



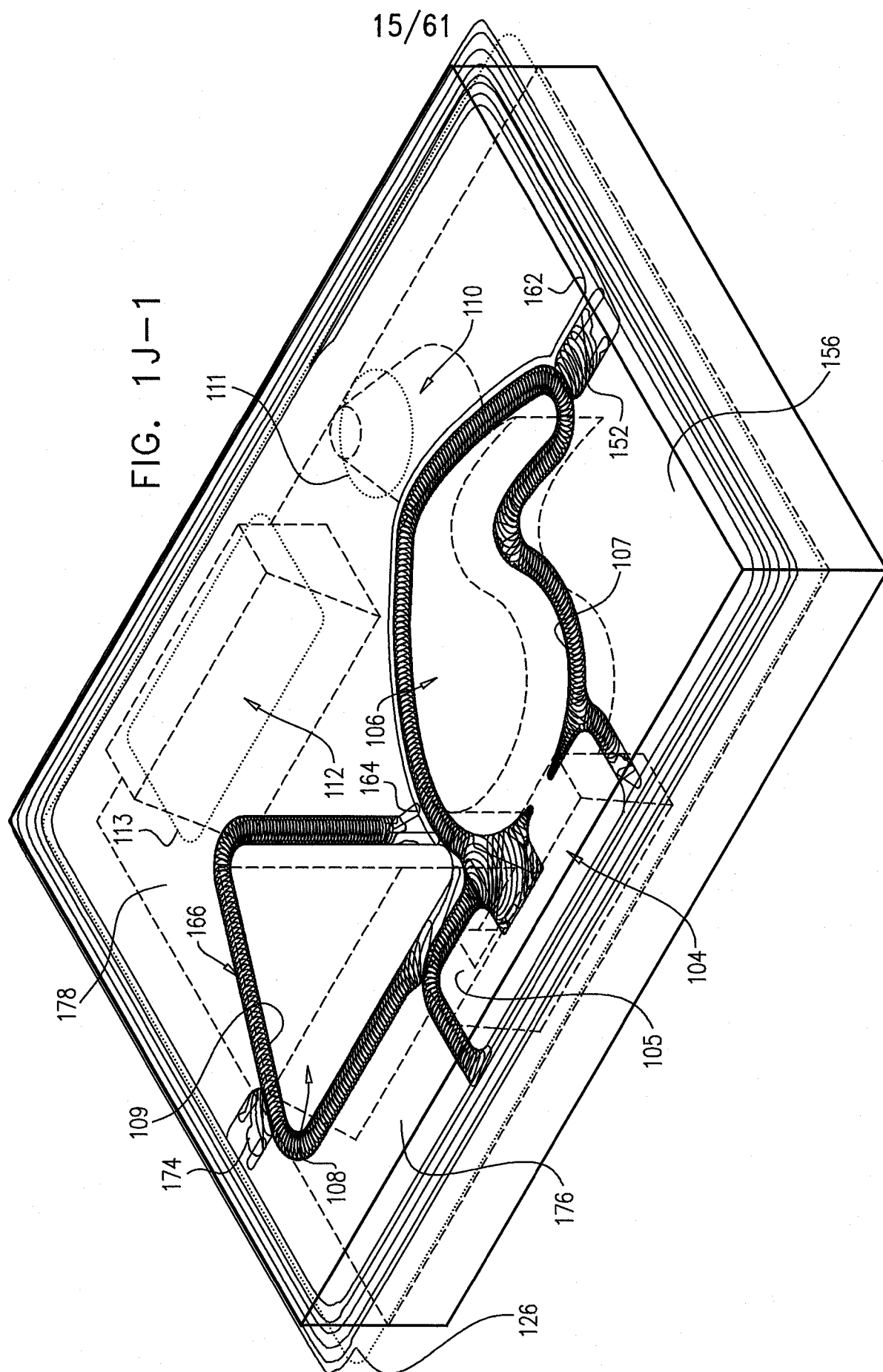


FIG. 1J-1

15/61

FIG. 1K-1

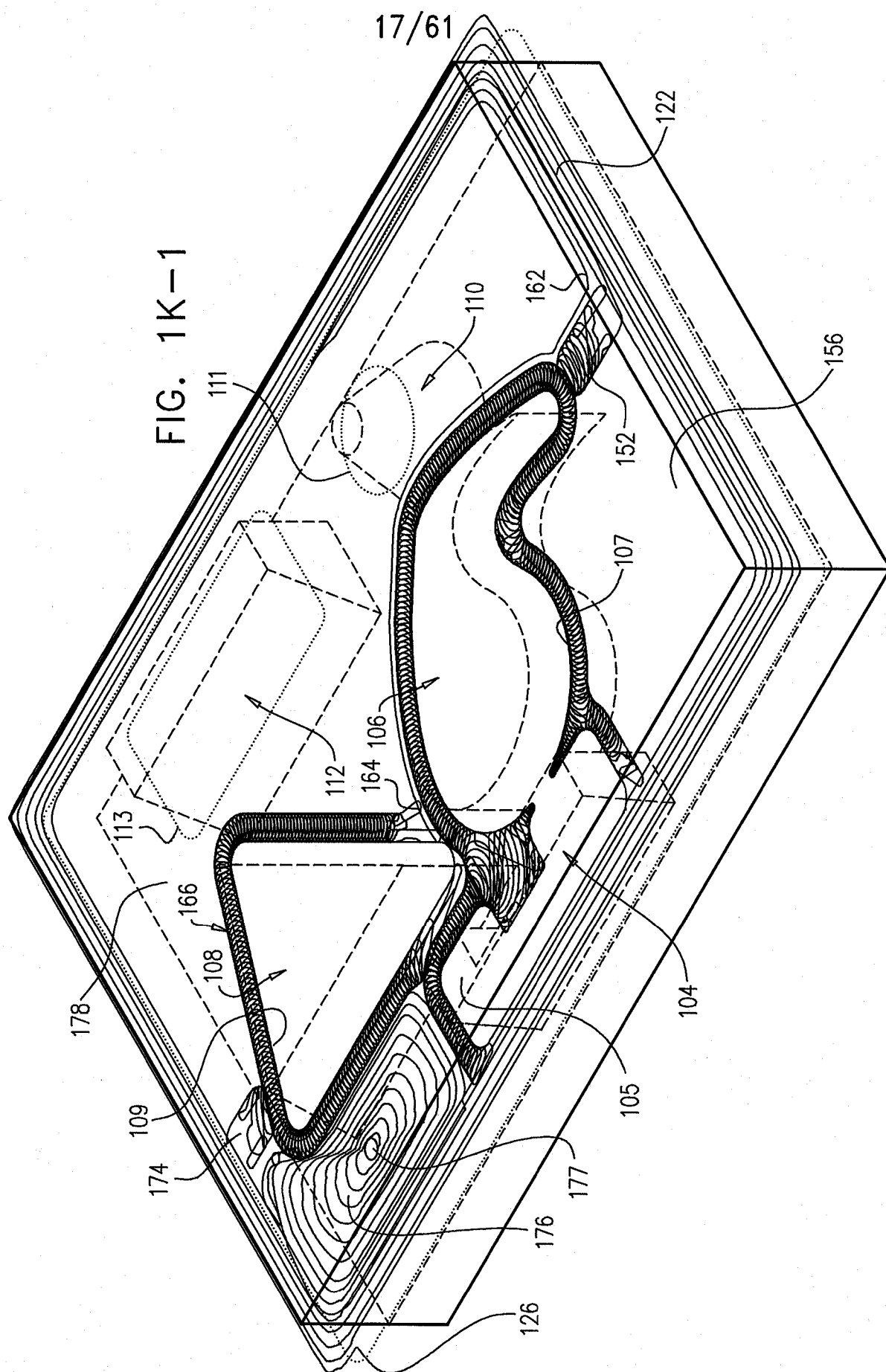
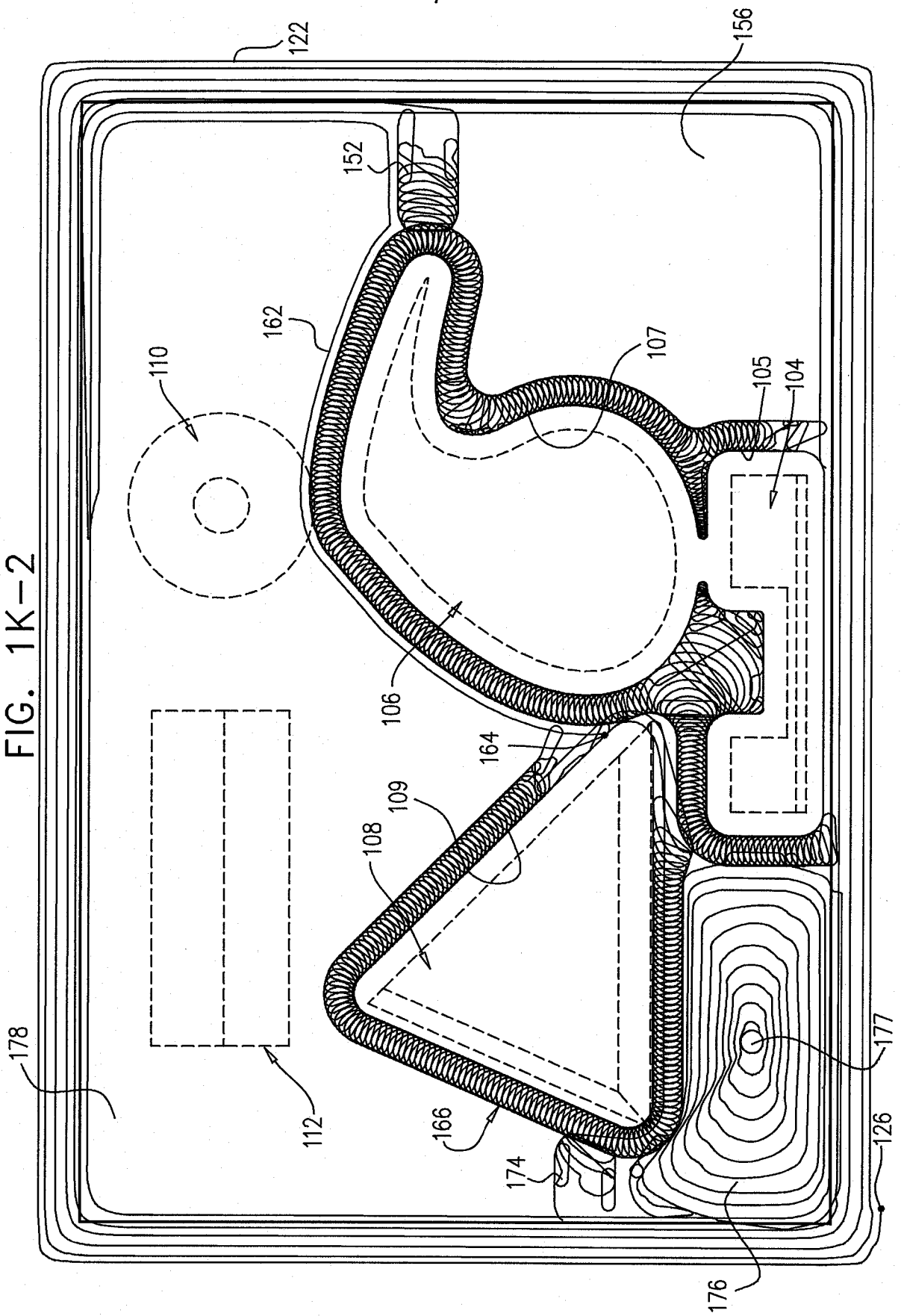
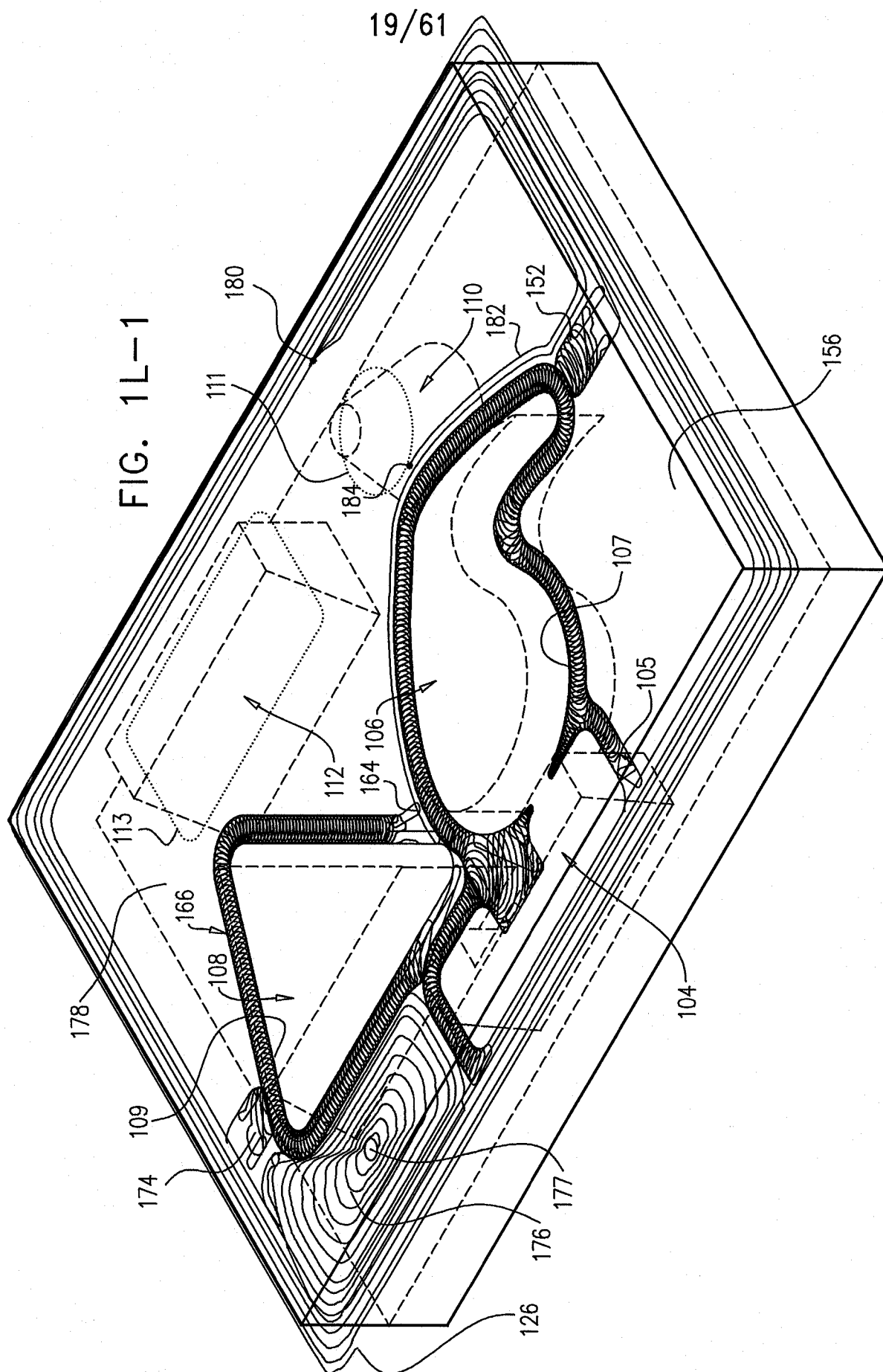


FIG. 1K-2





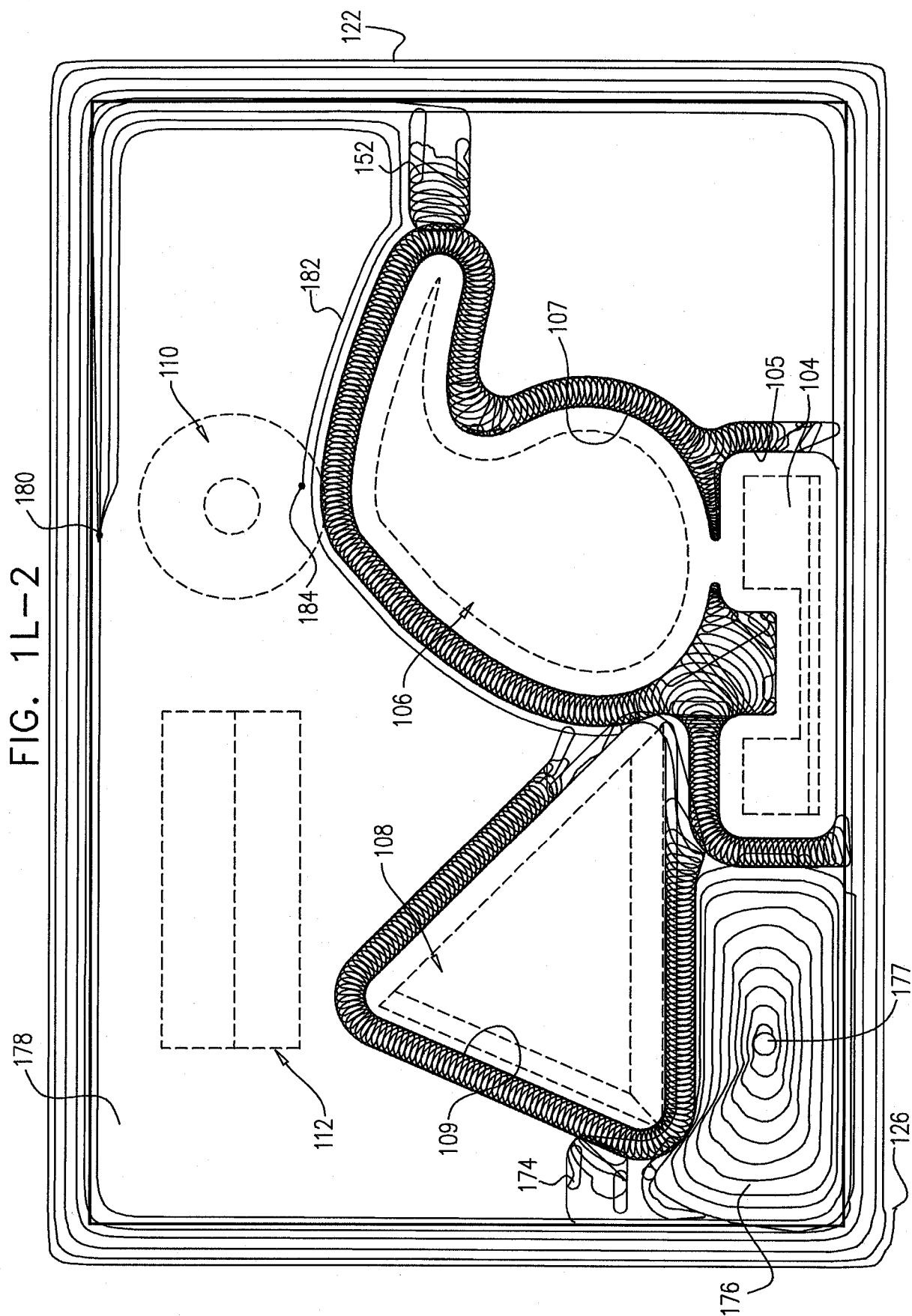


FIG. 1M-1

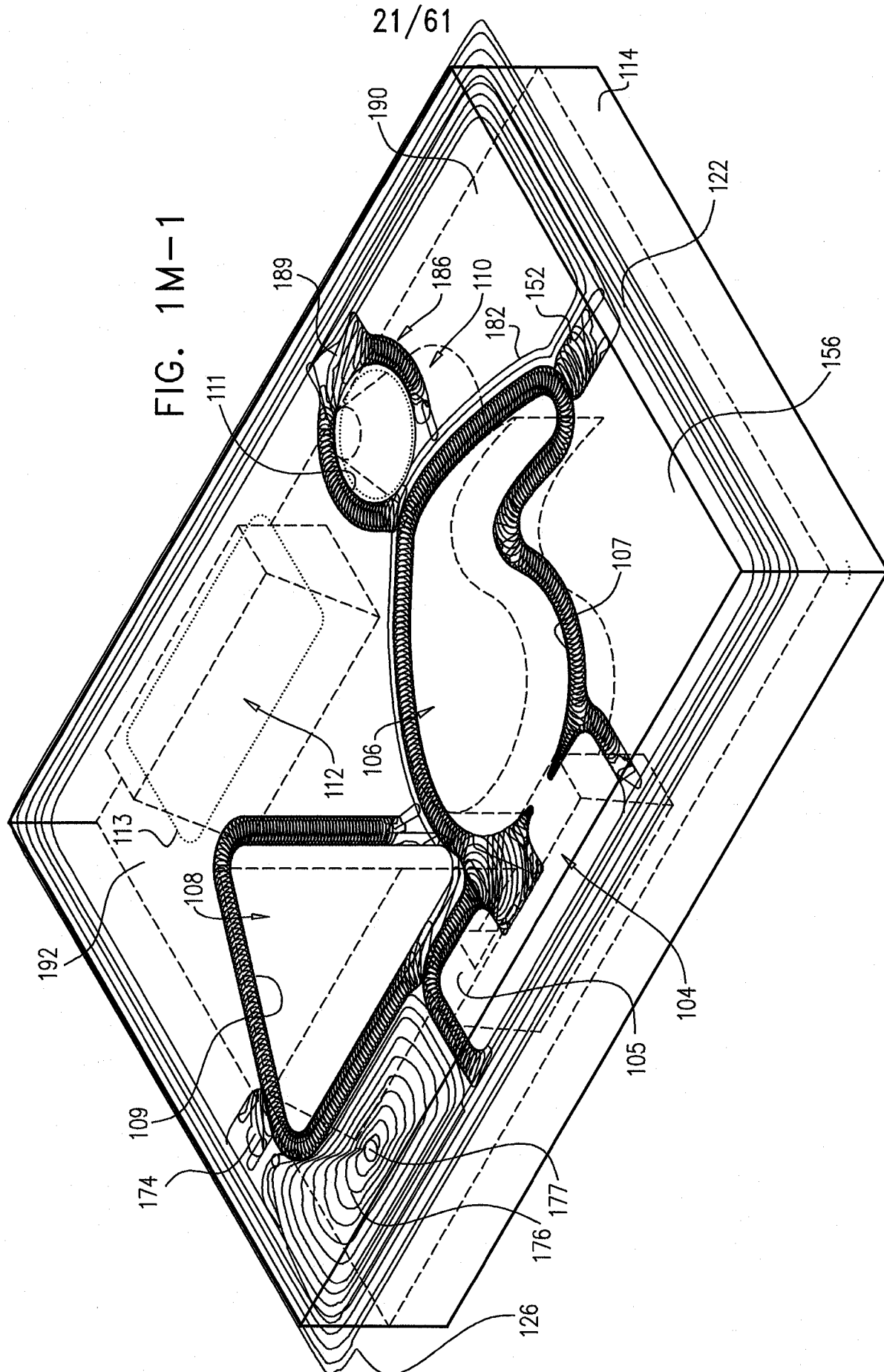
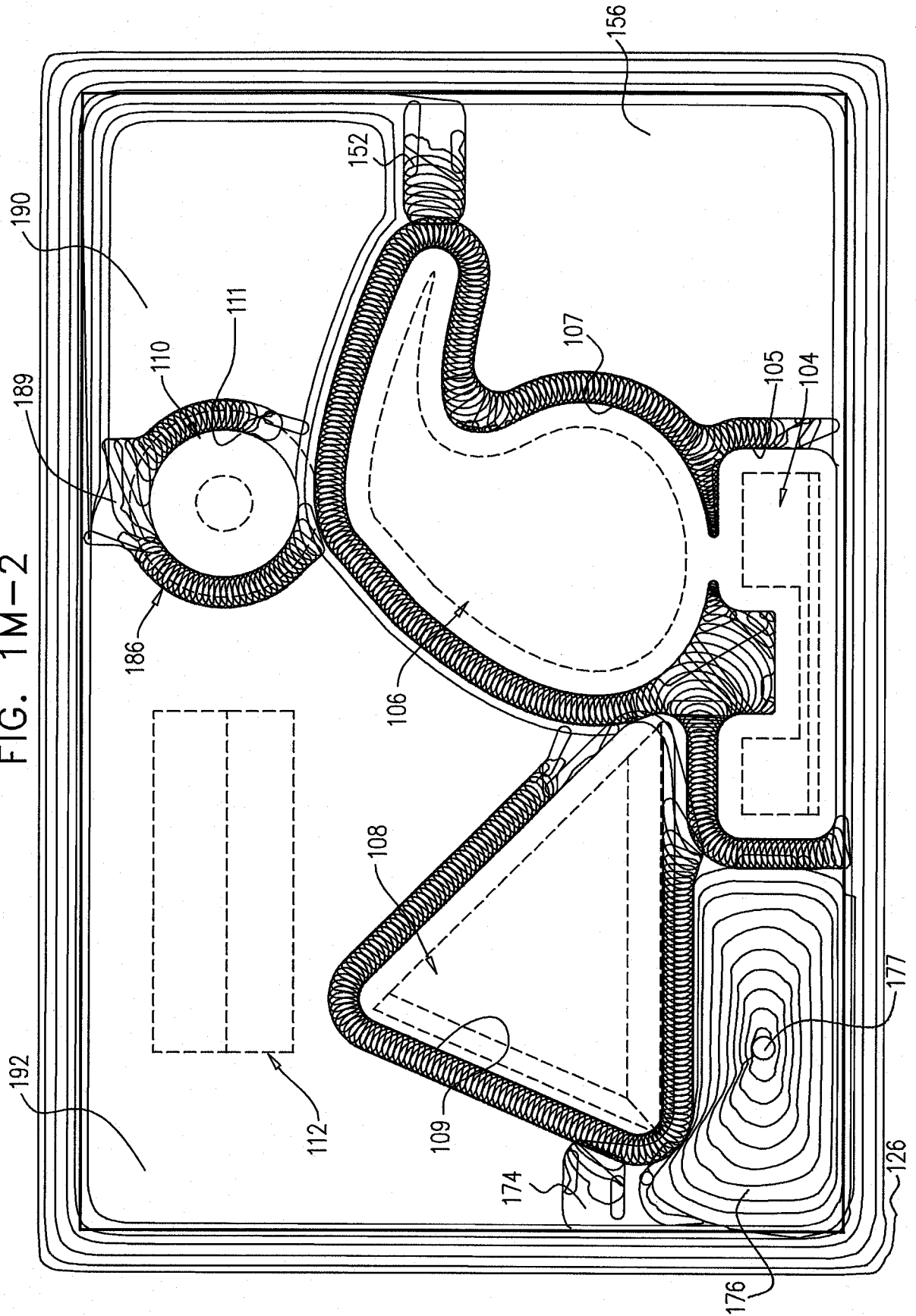
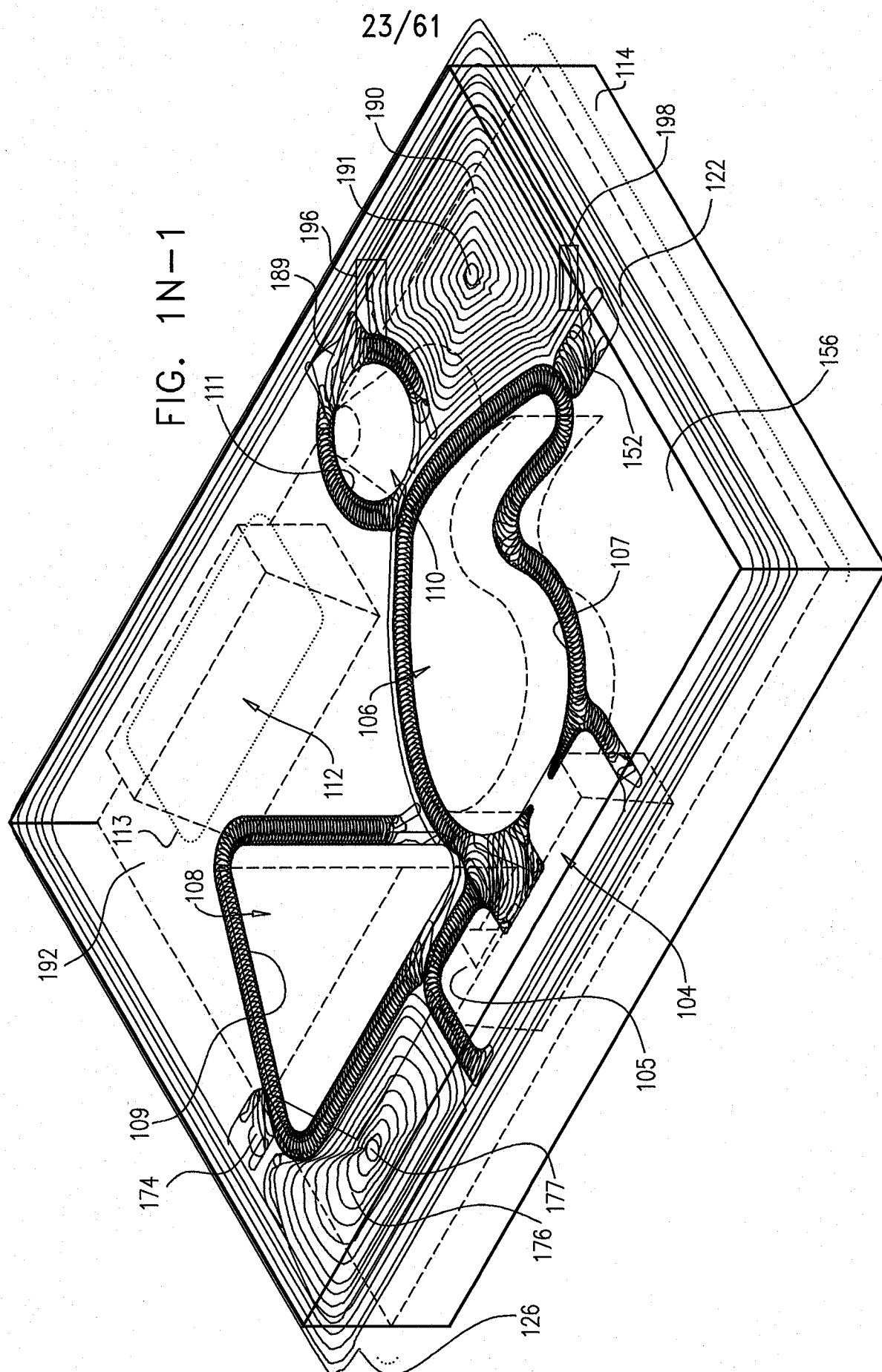


FIG. 1M-2





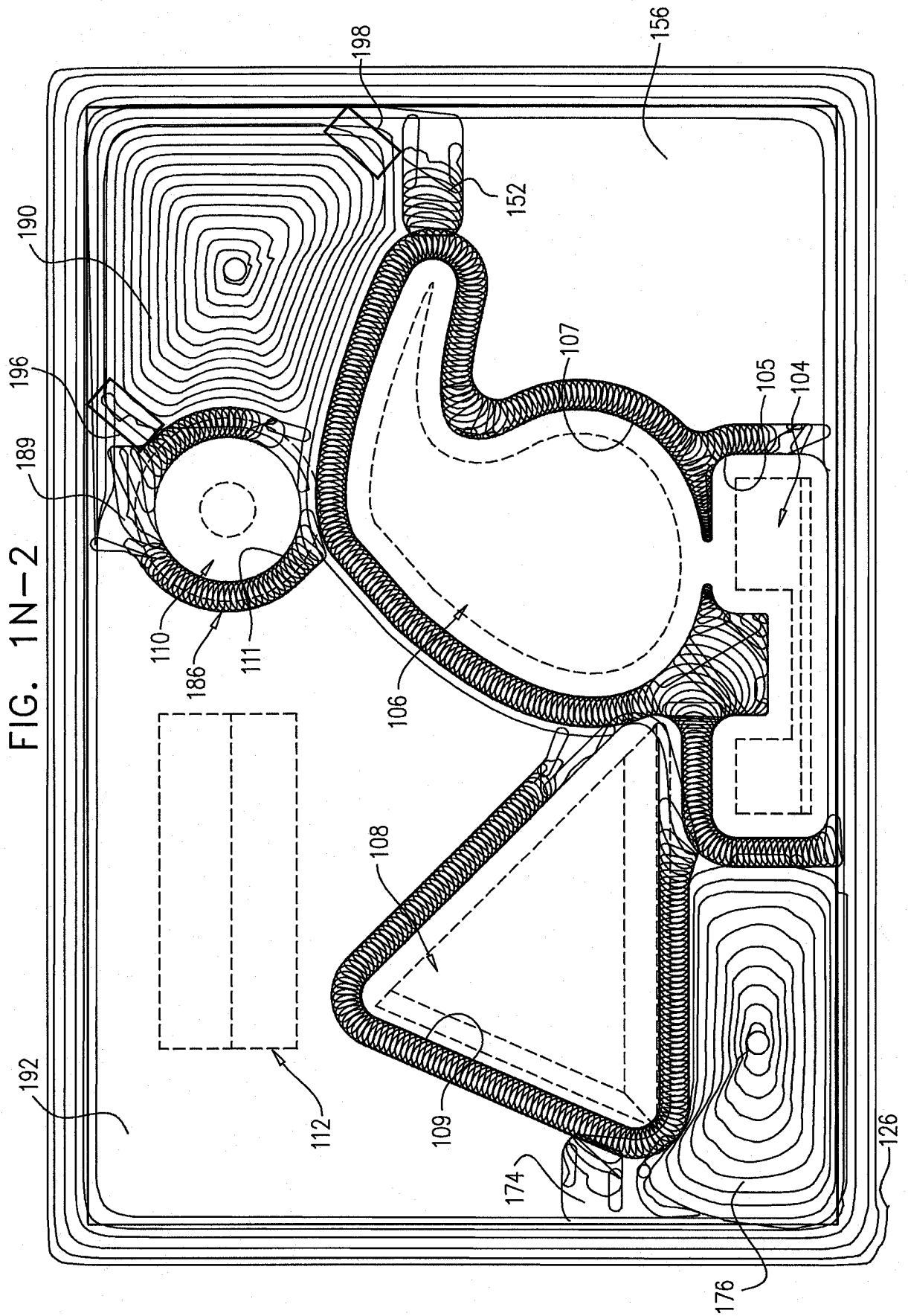
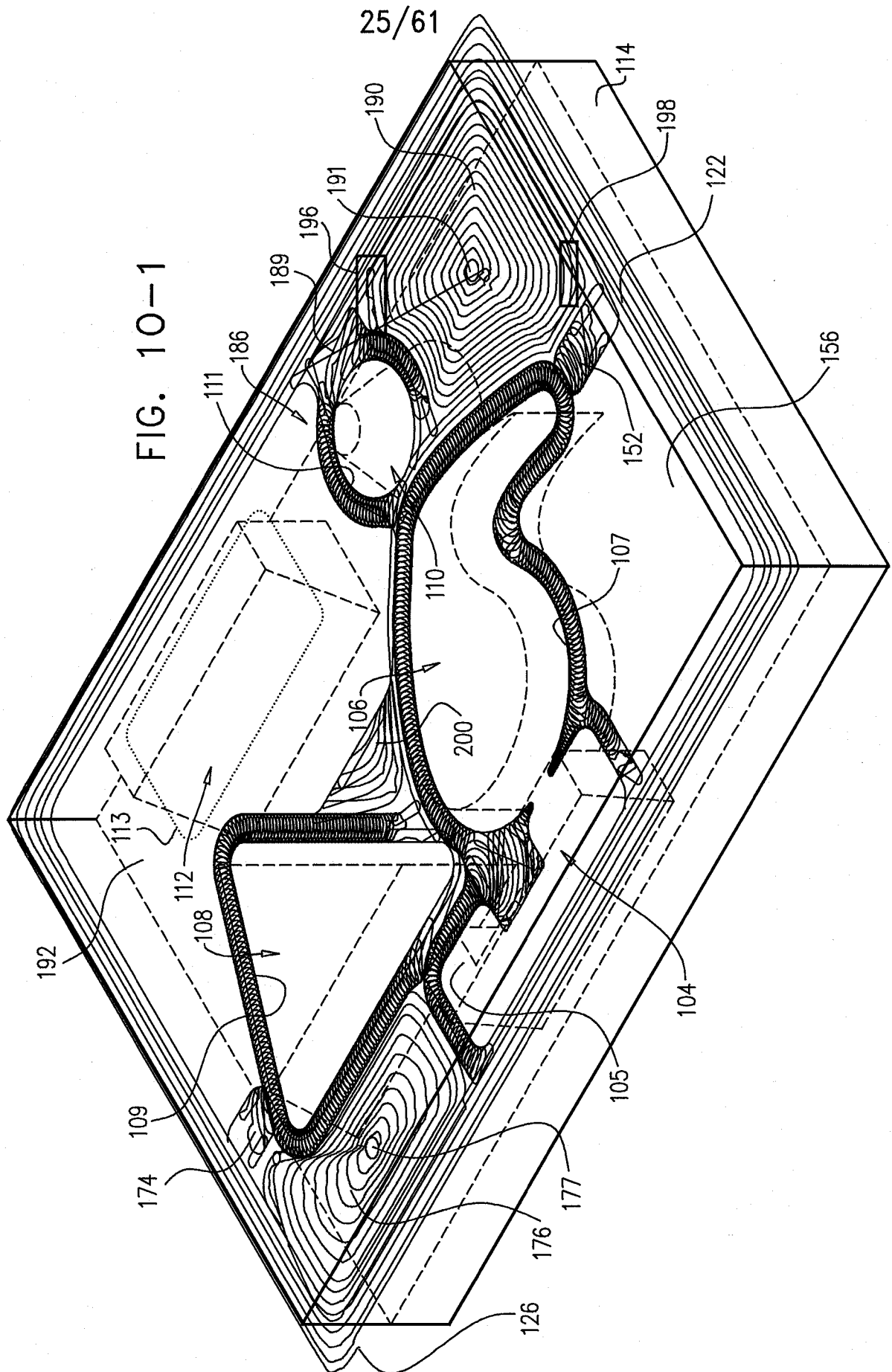


FIG. 10-1



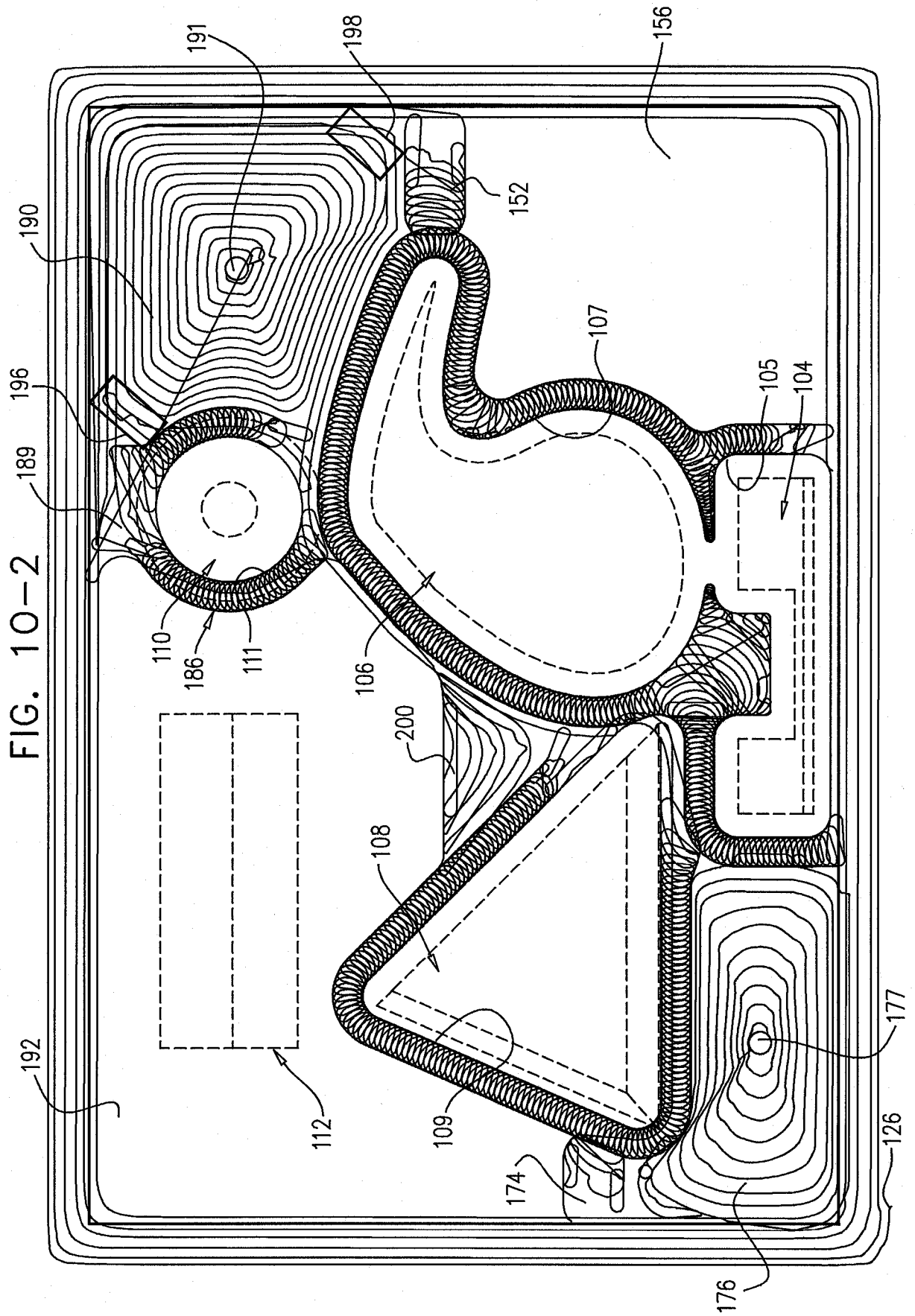


FIG. 1P-1

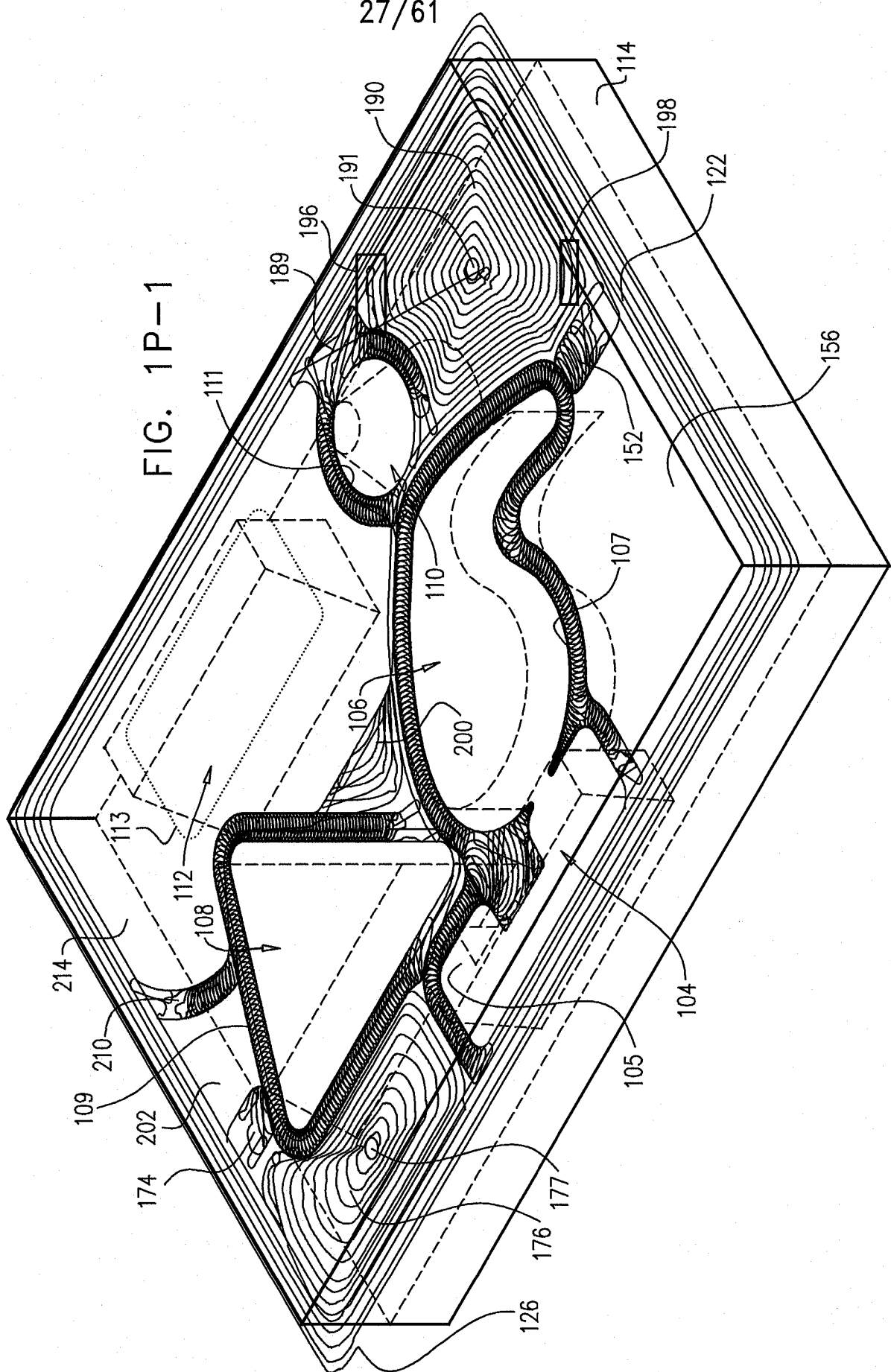


FIG. 1P-2

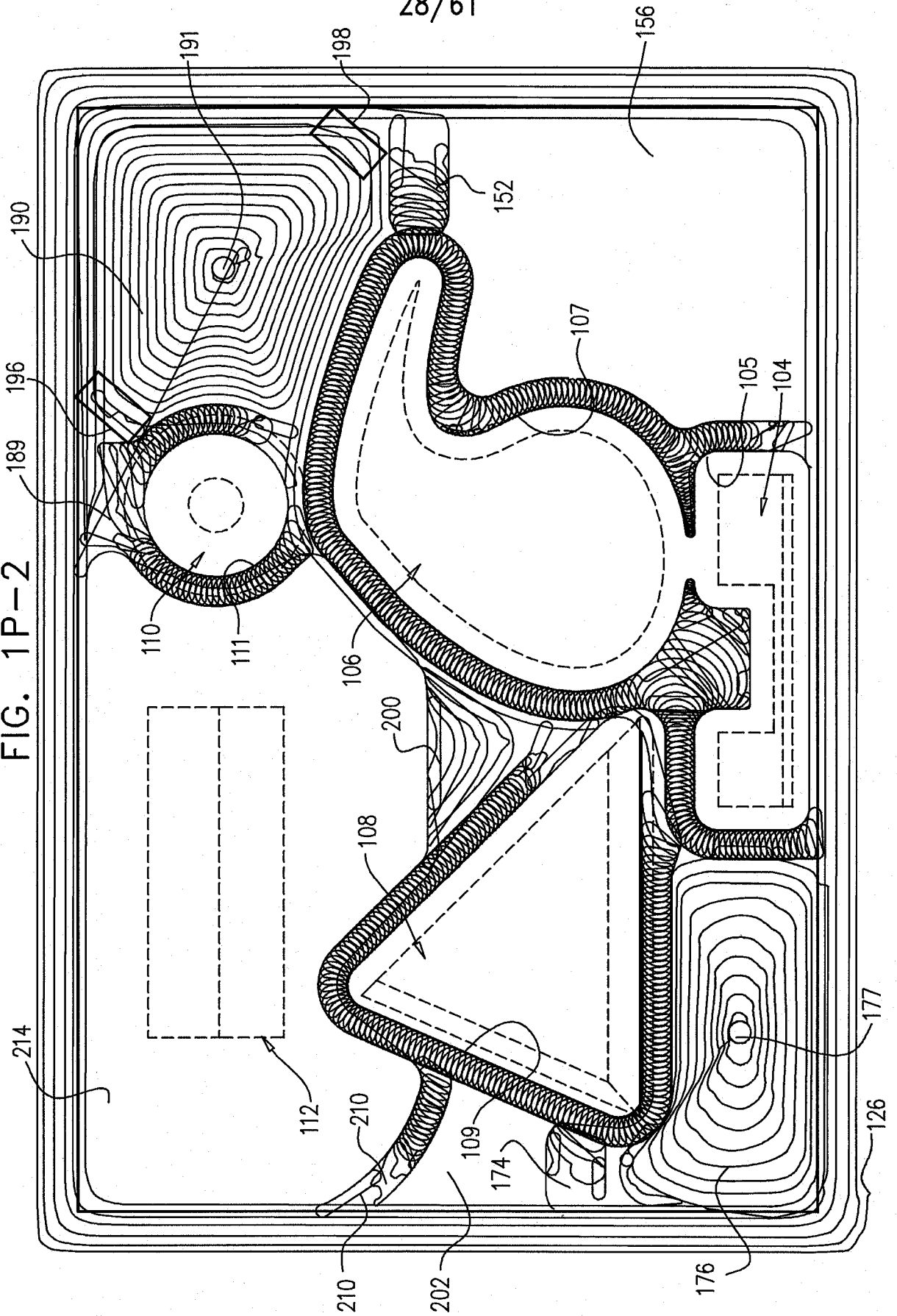
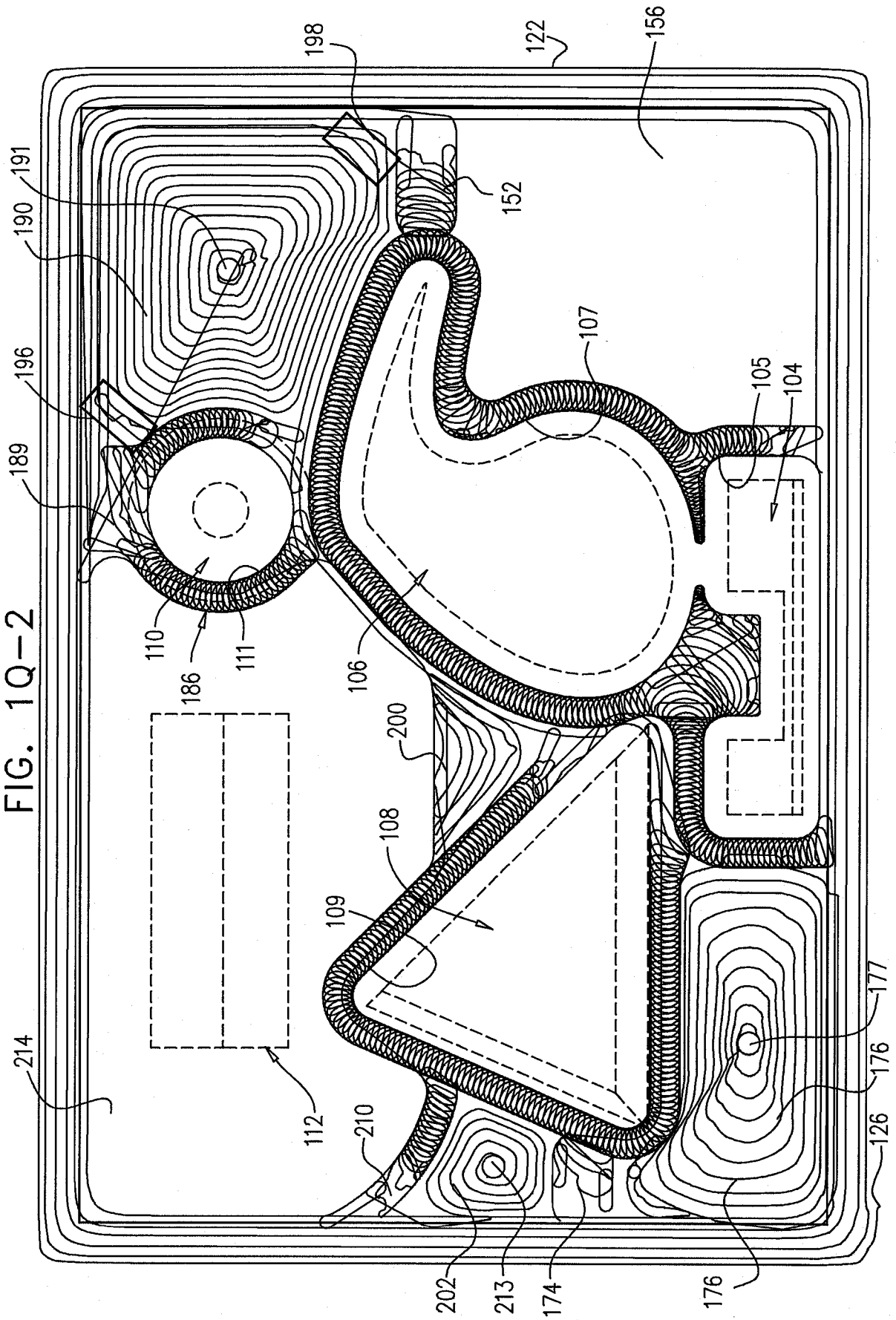
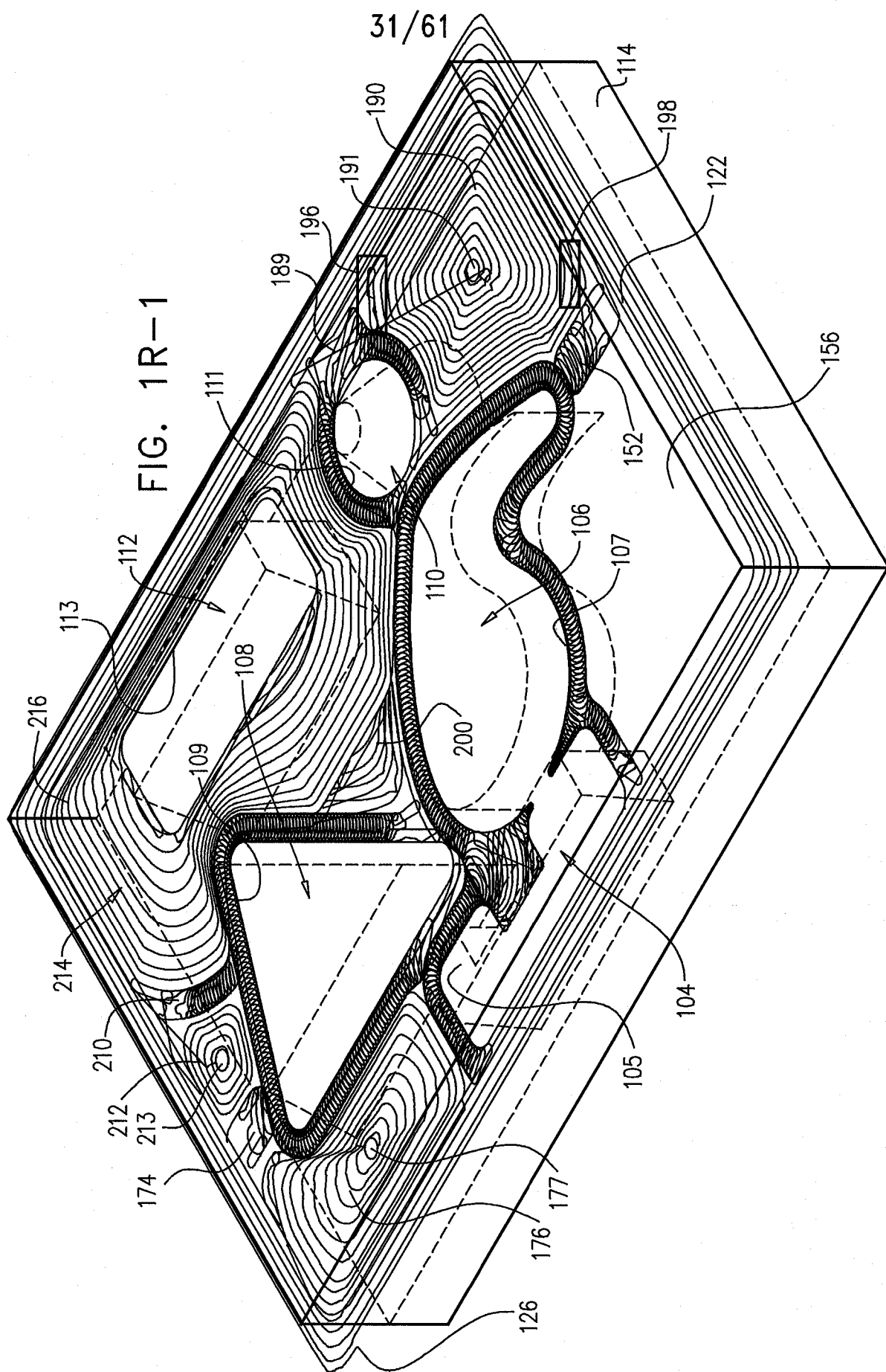
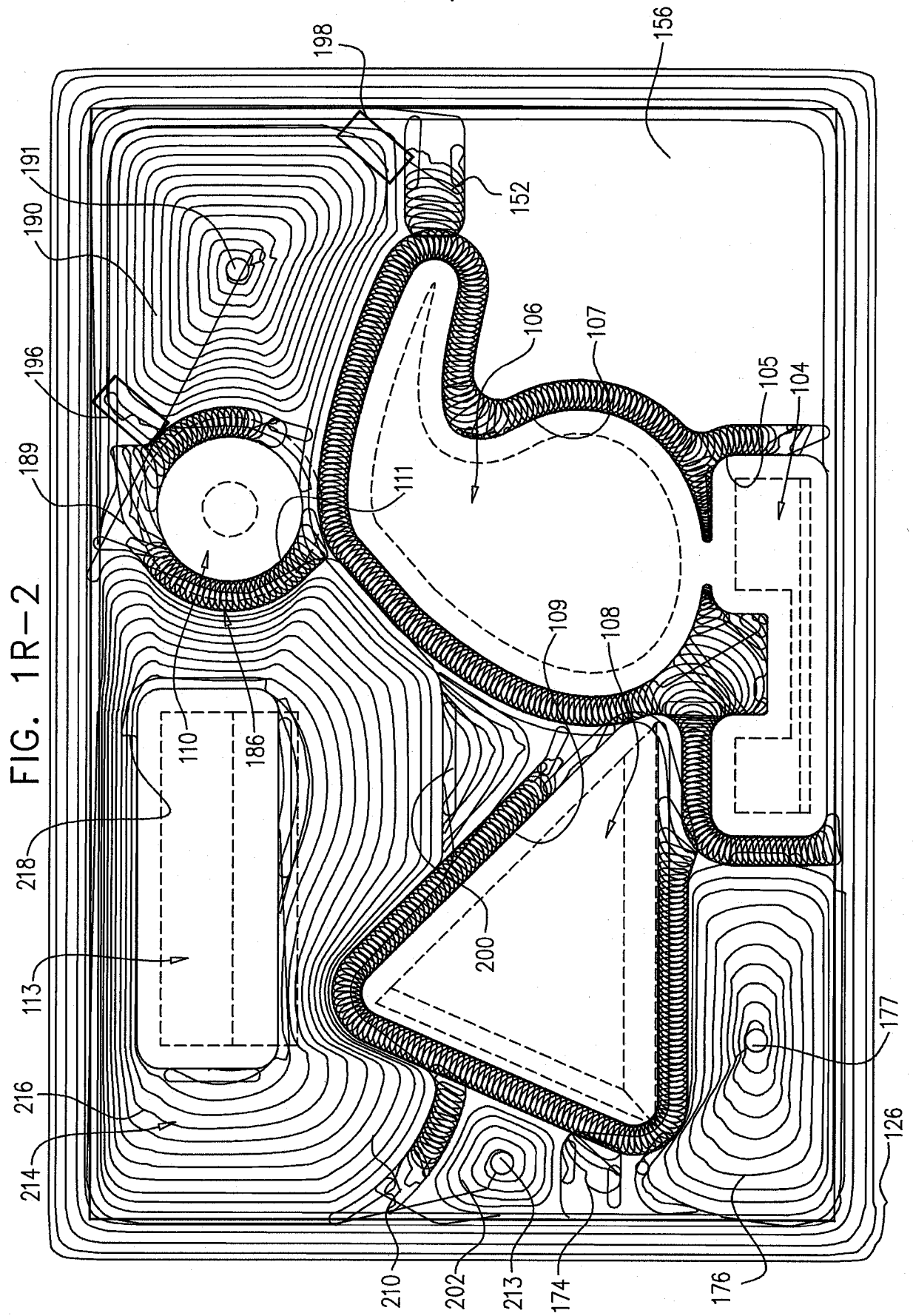


FIG. 1Q-2







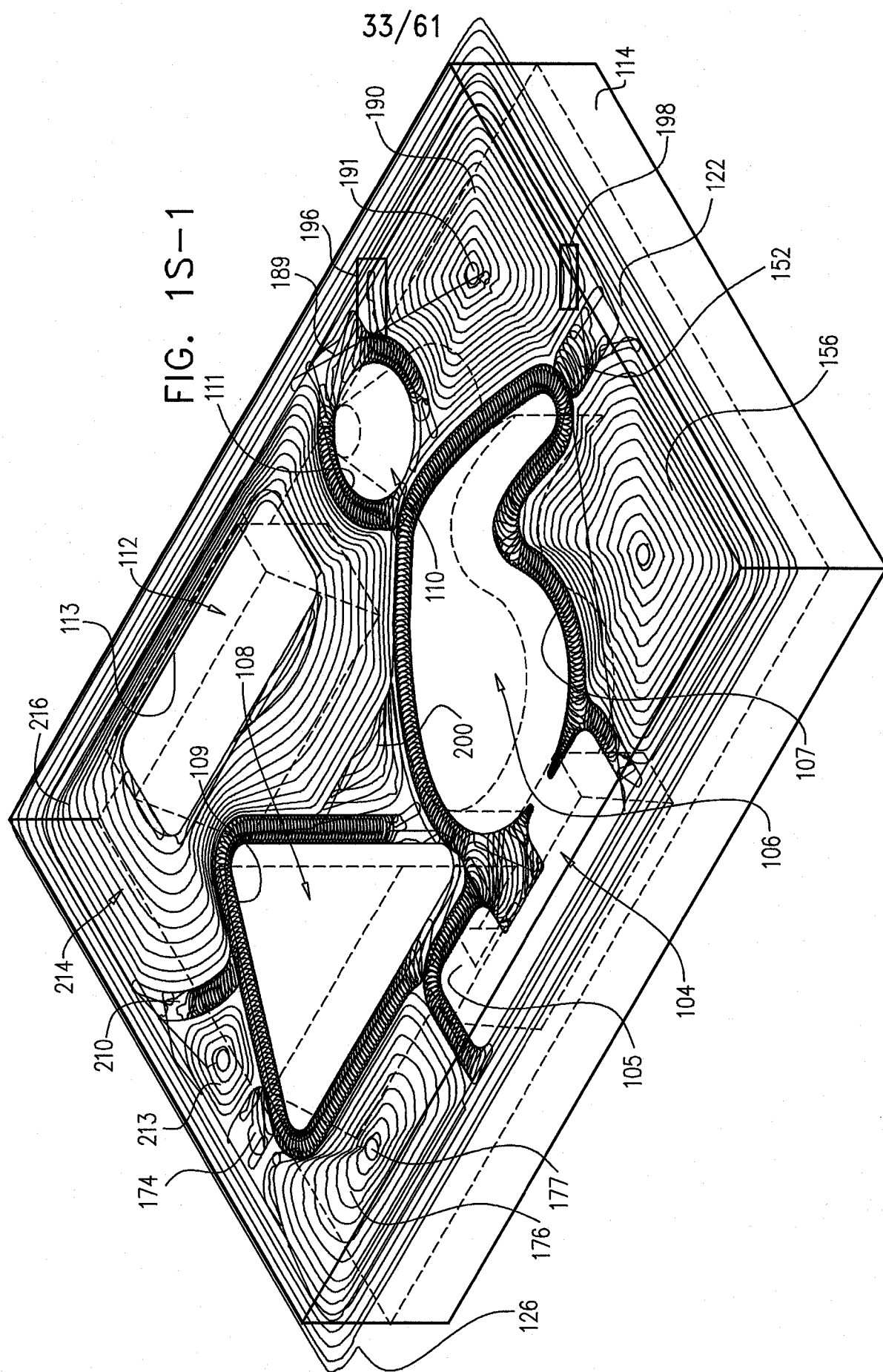


FIG. 1S-1

33/61

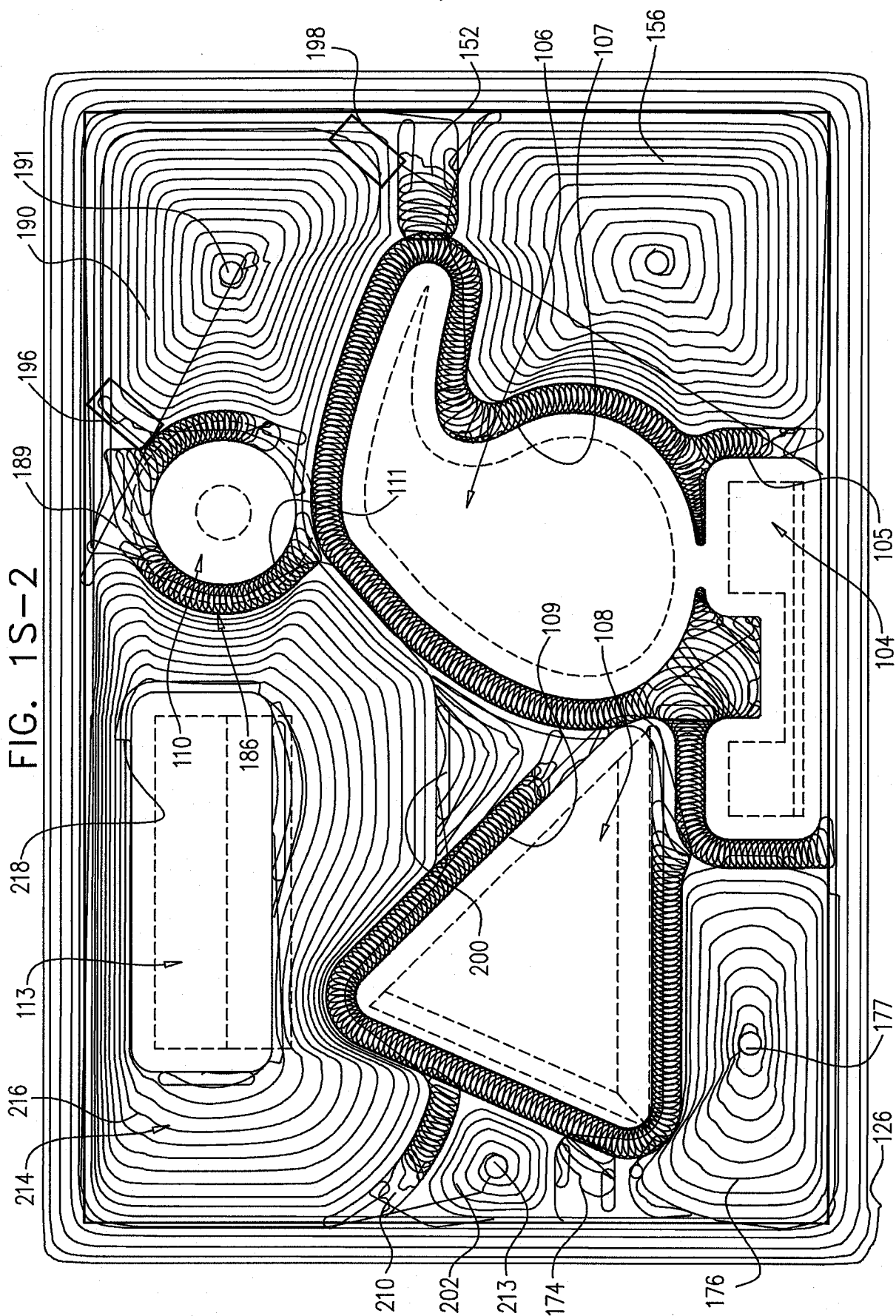


FIG. 2A

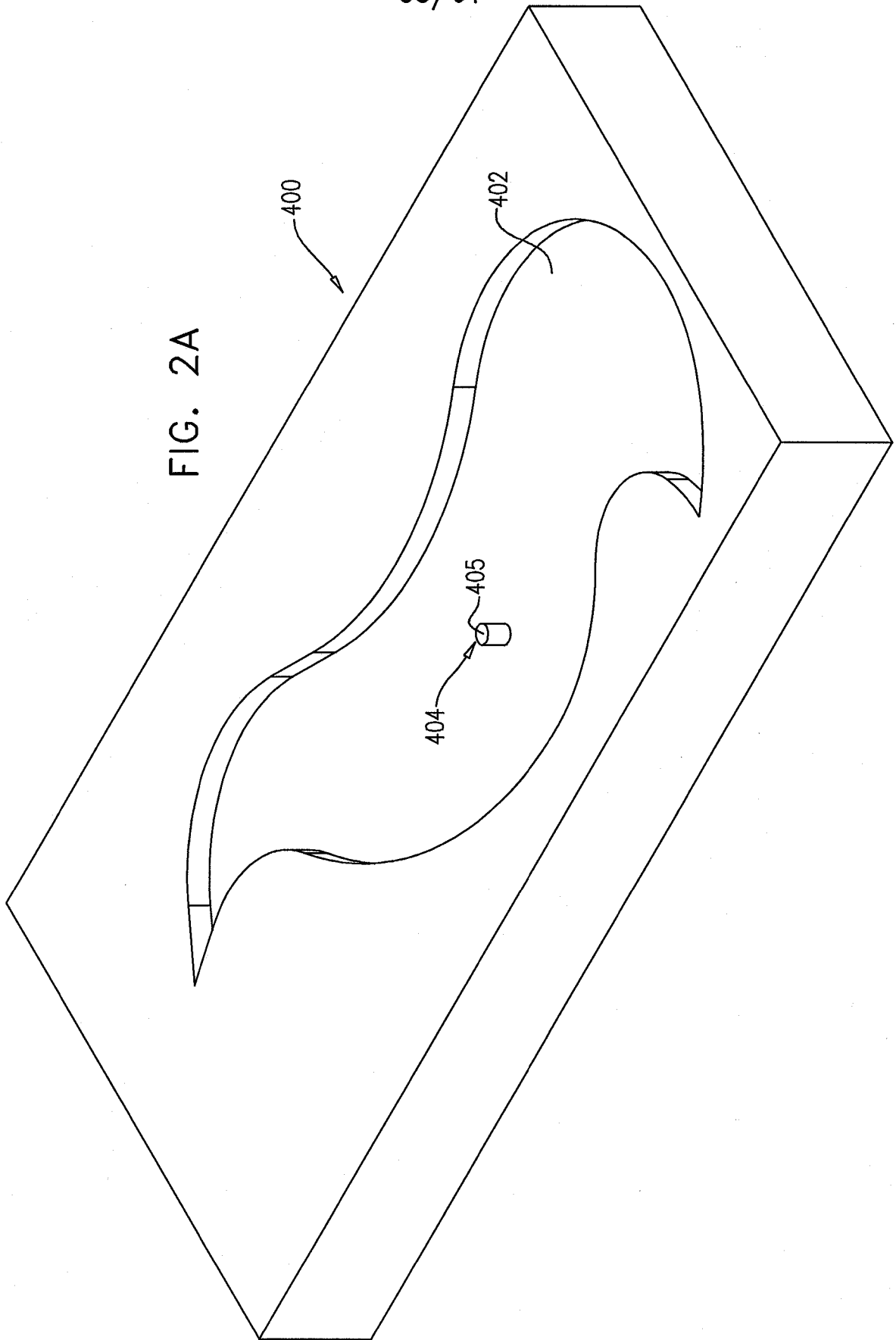


FIG. 2B

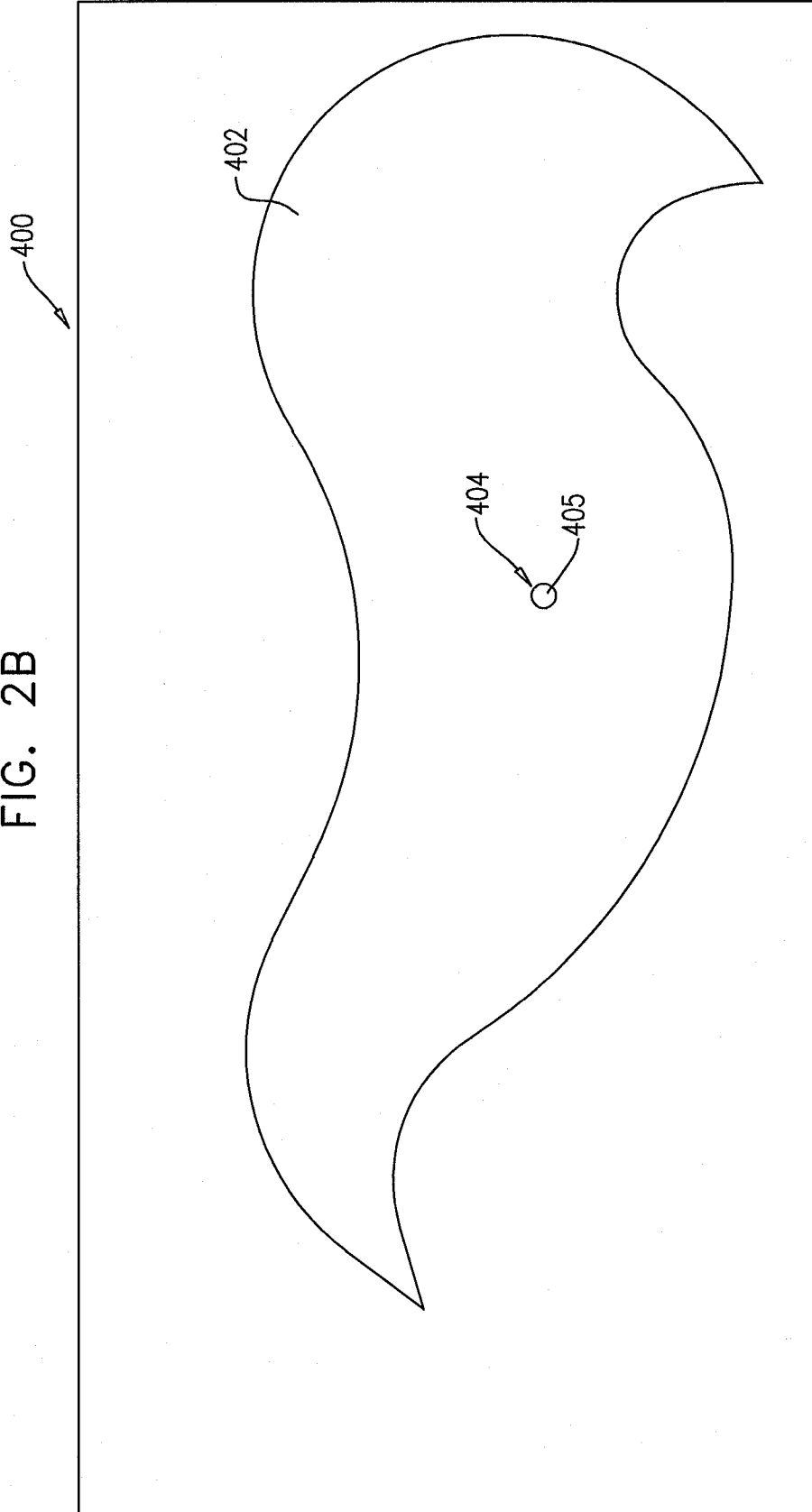


FIG. 2C

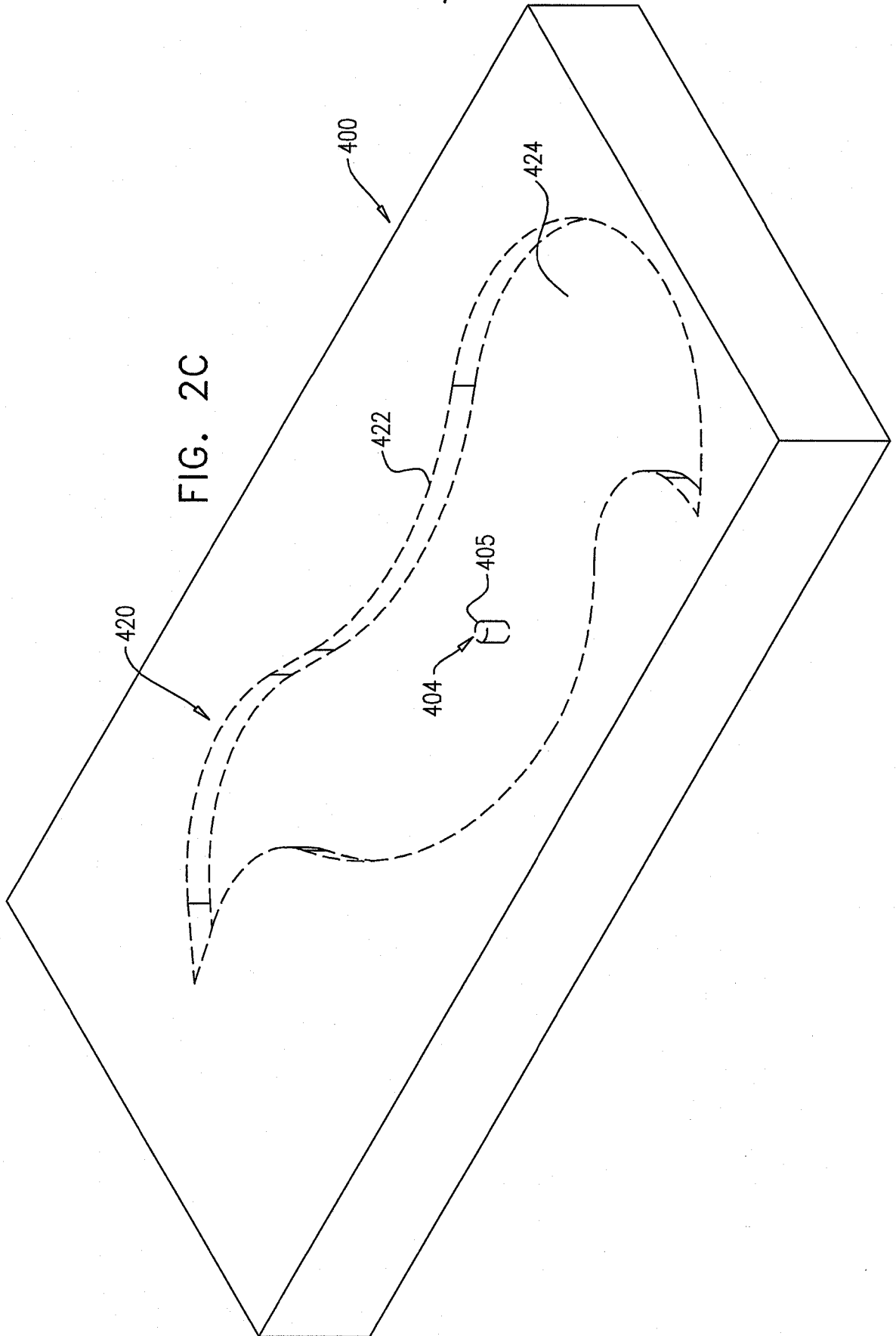


FIG. 2D-1

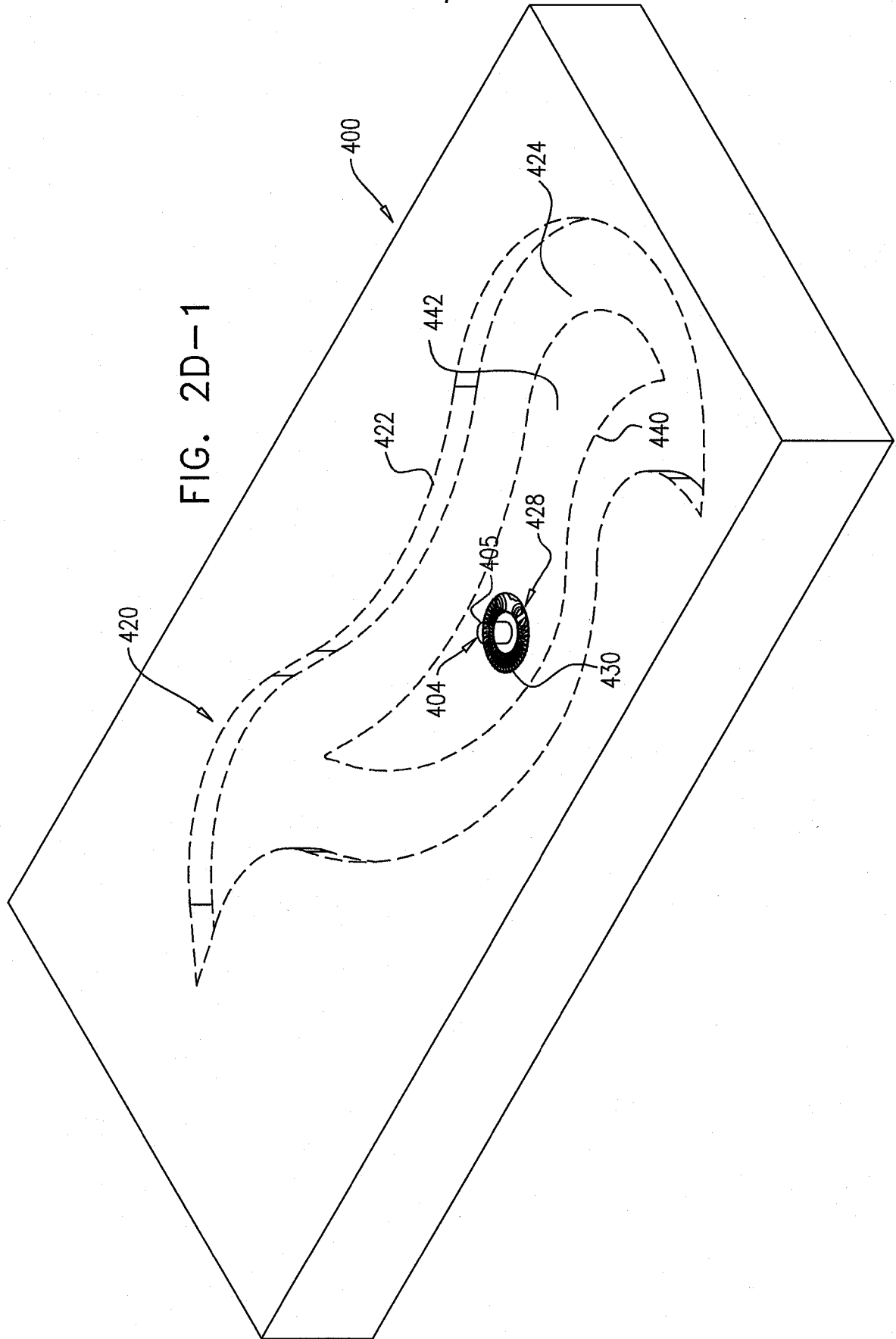


FIG. 2D-2

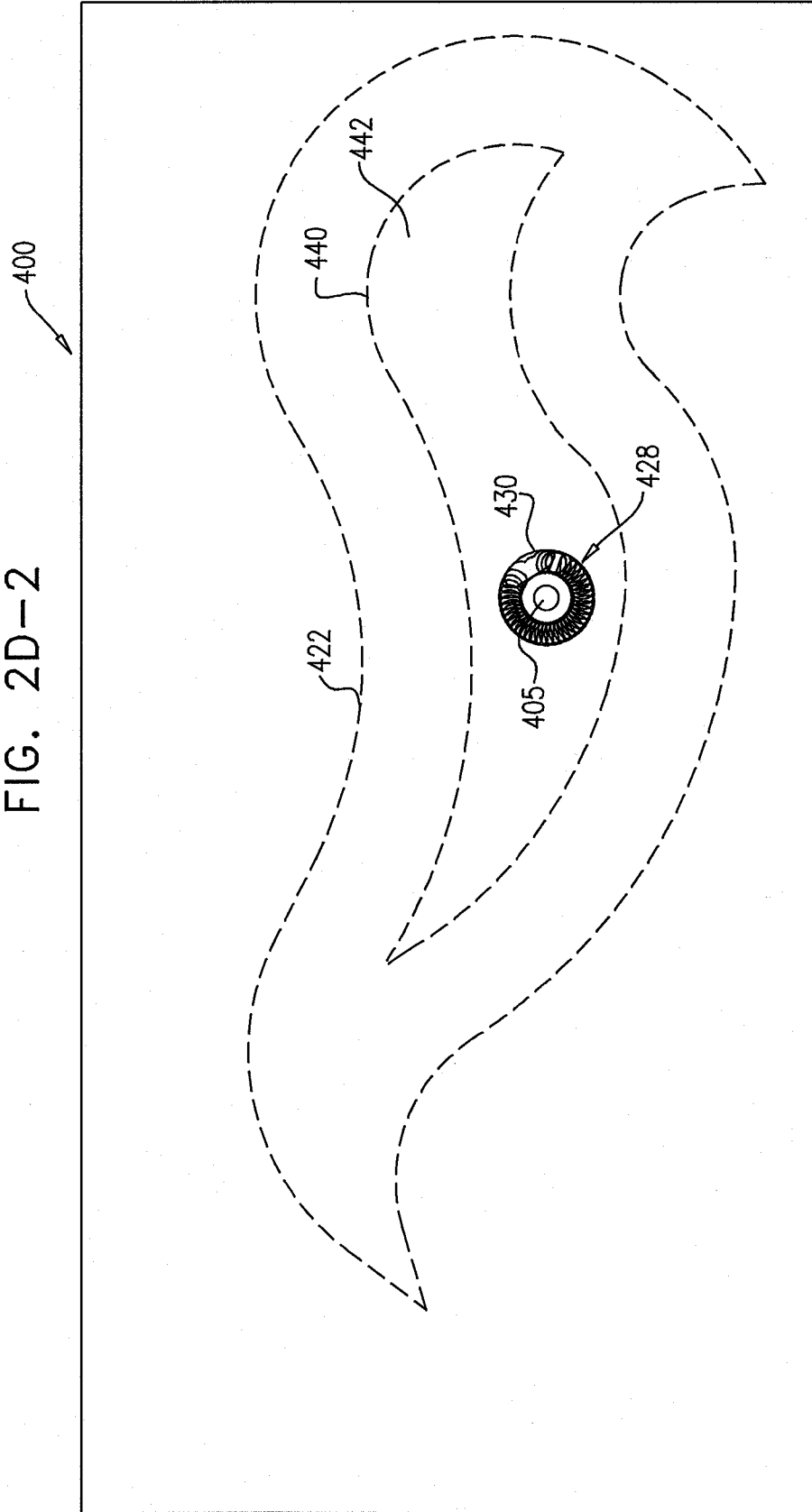
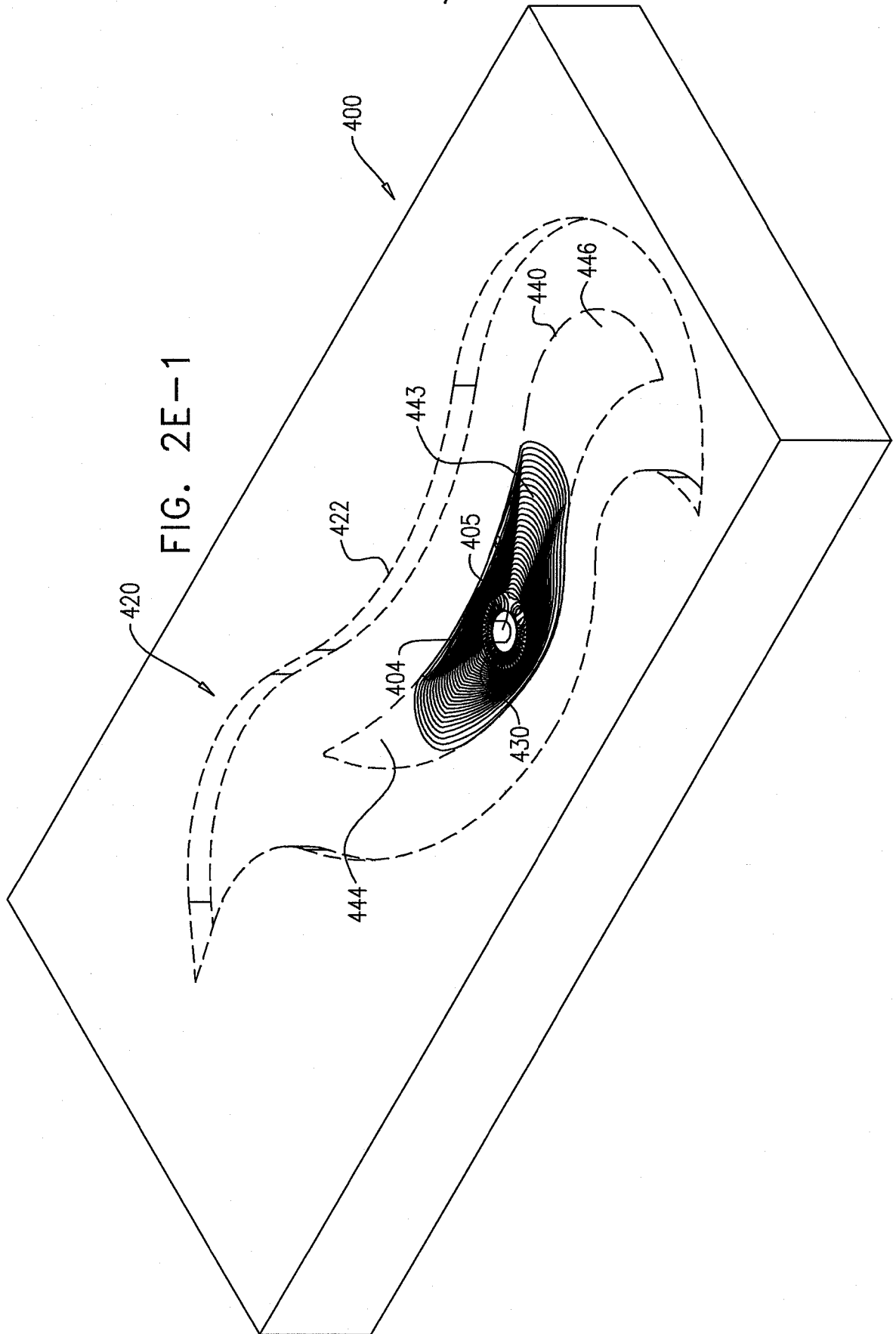


FIG. 2E--1



400

FIG. 2E-2

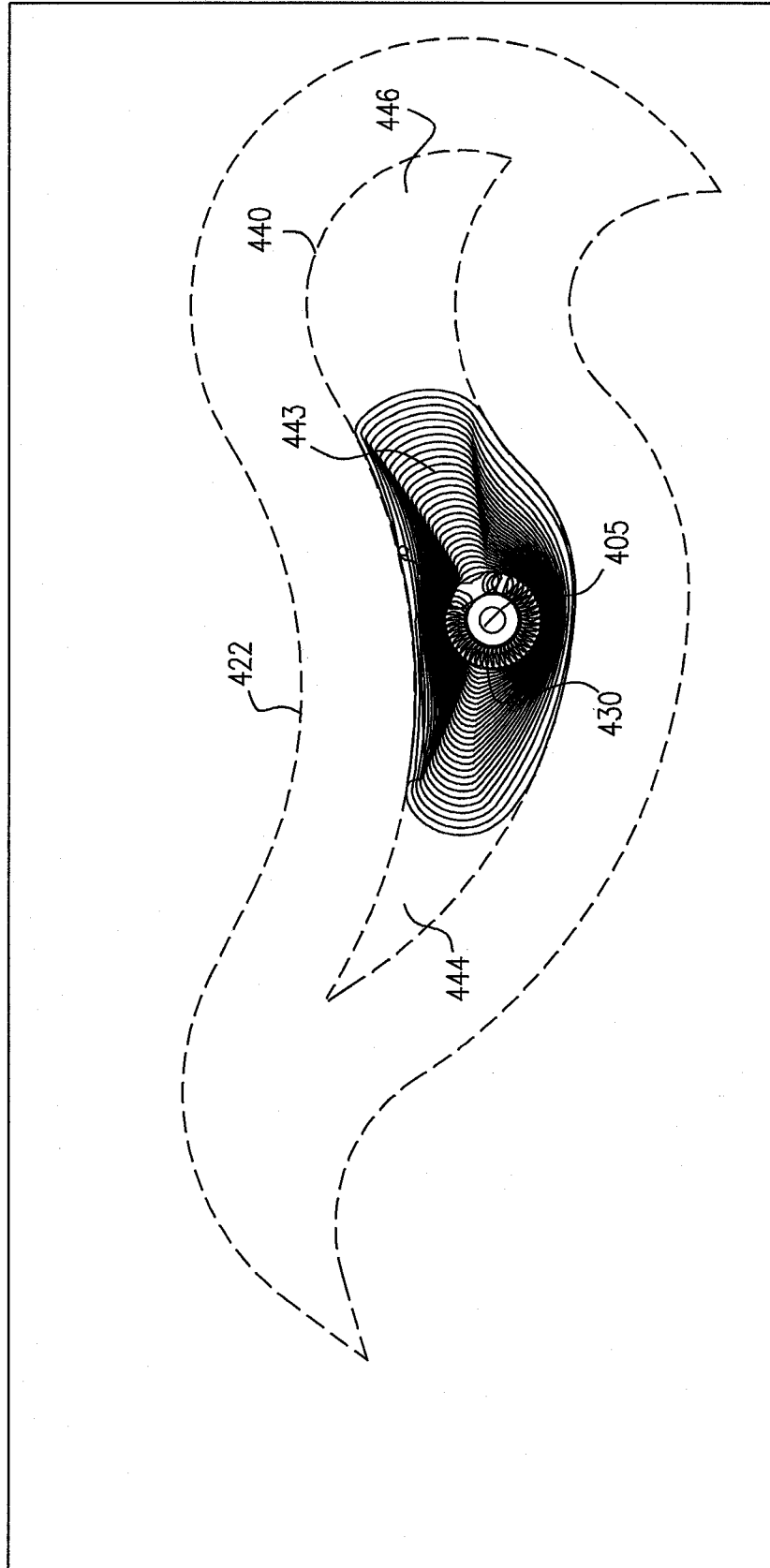
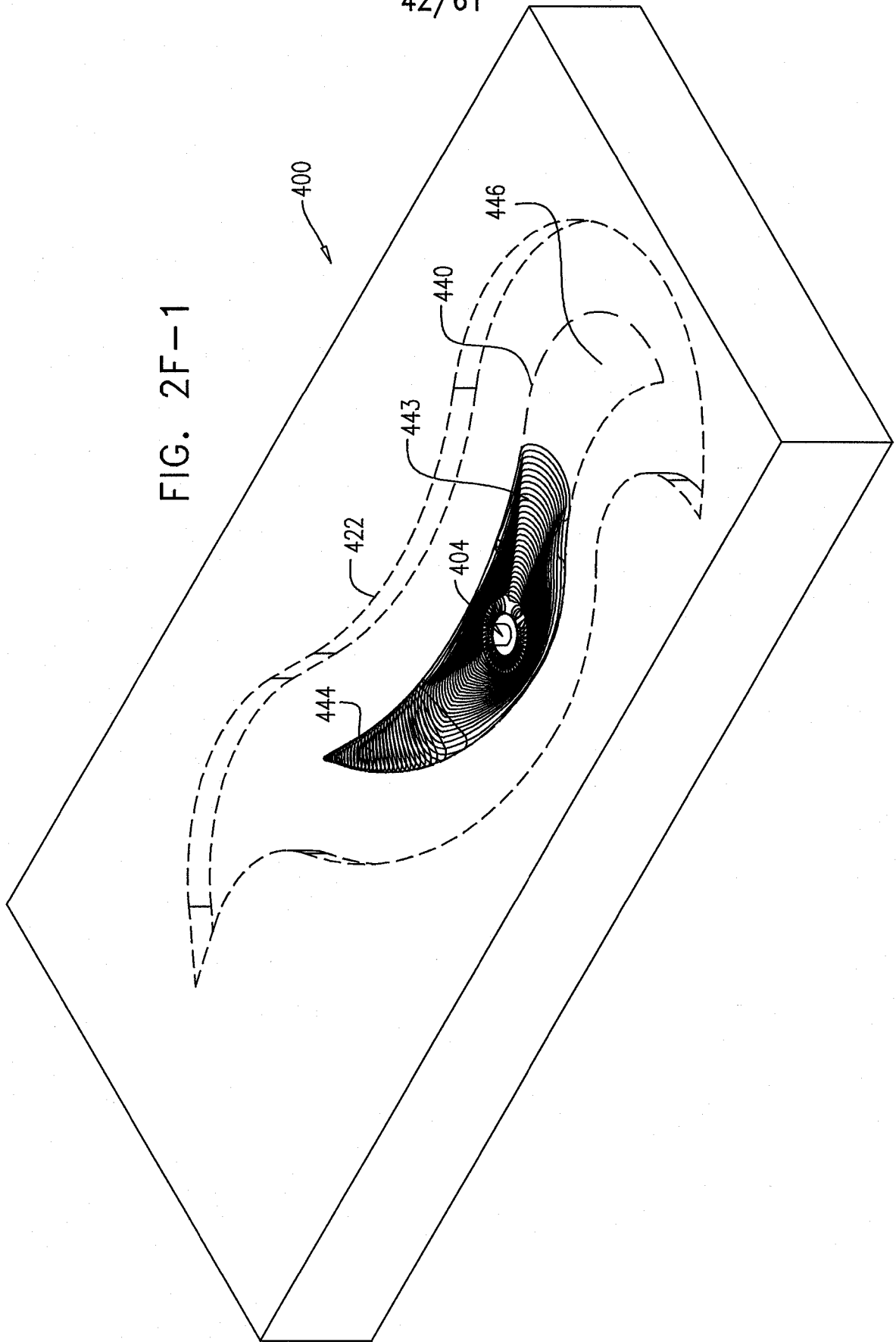


FIG. 2F-1



400

FIG. 2F--2

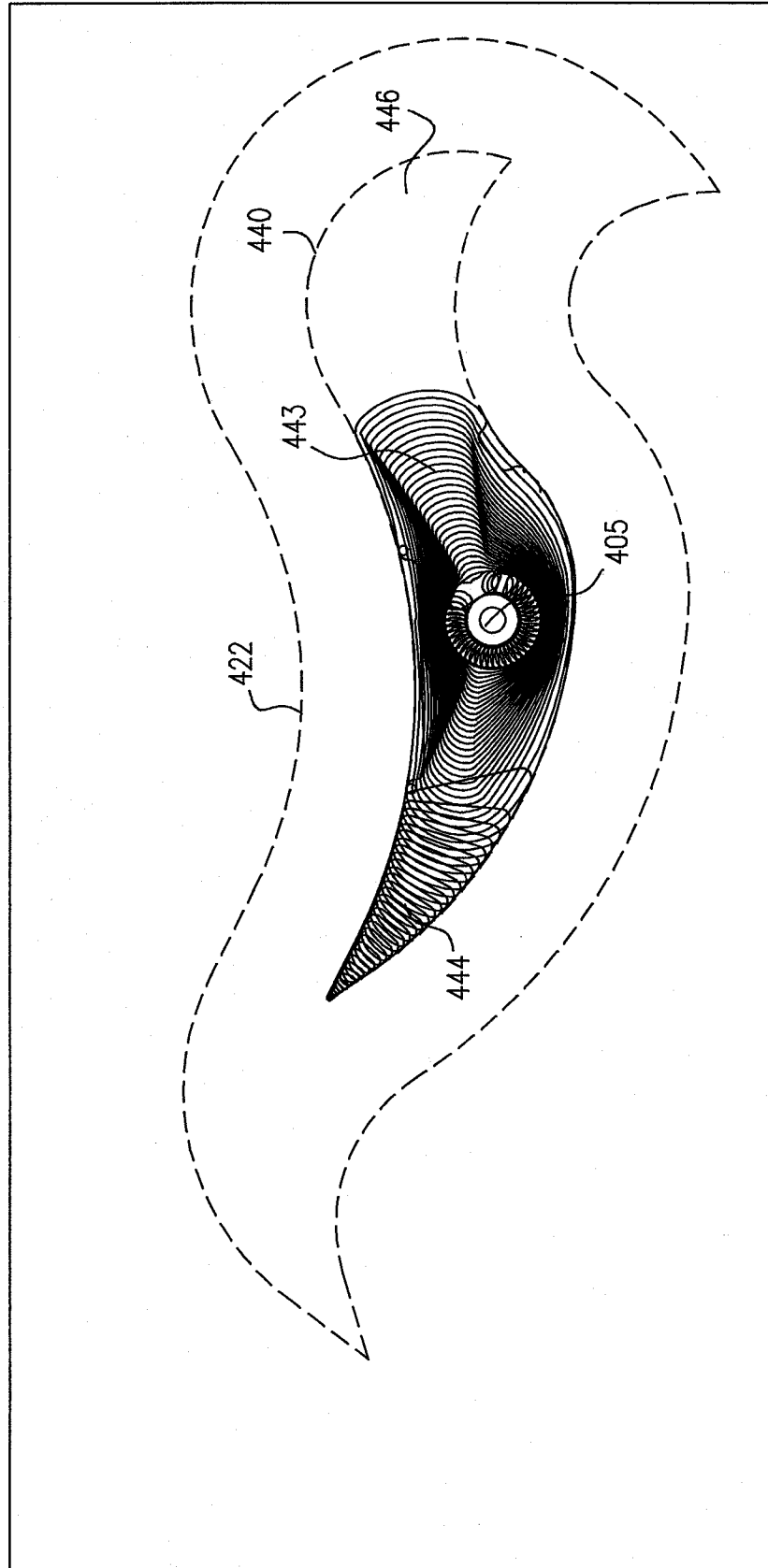
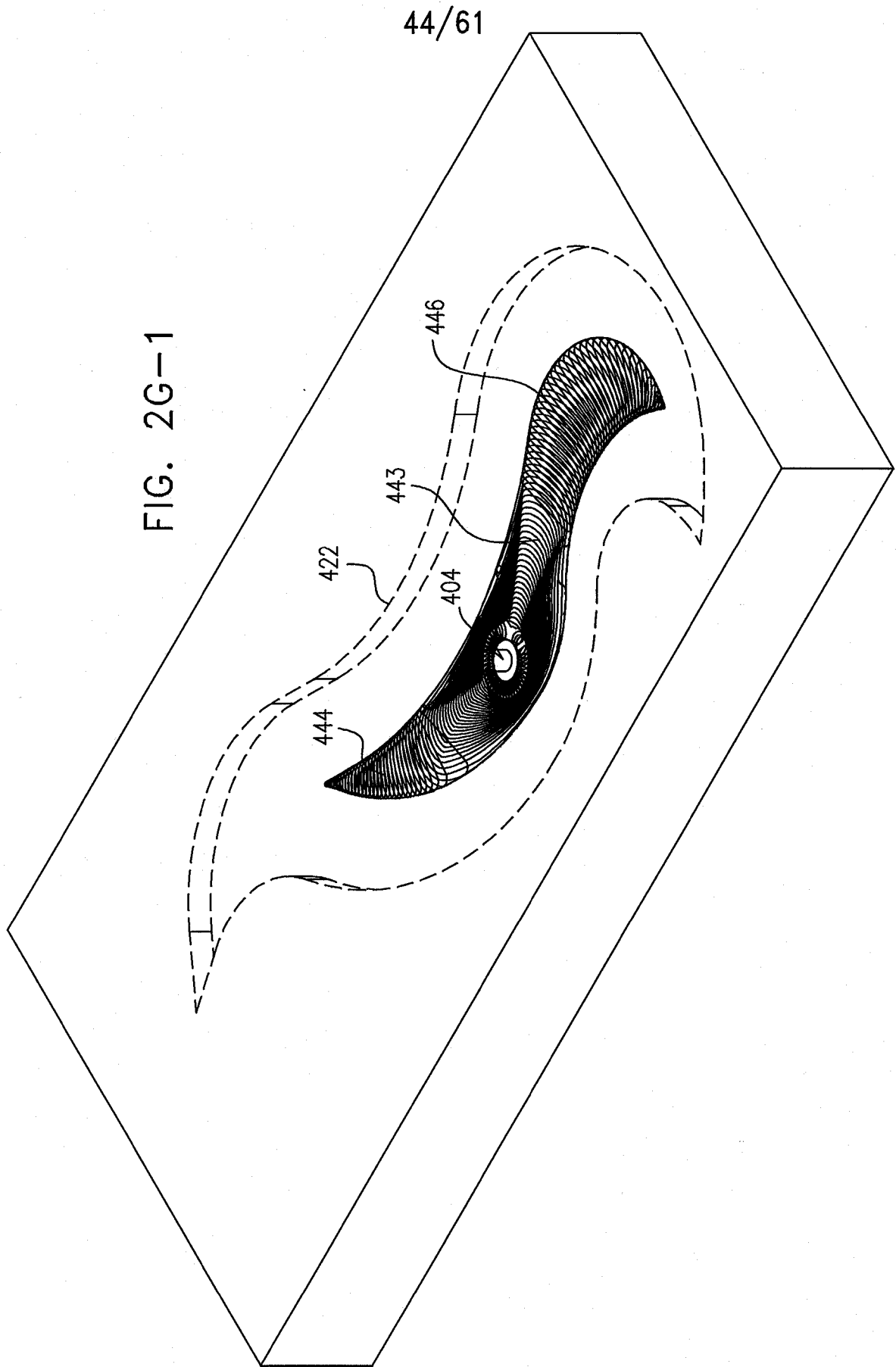


FIG. 2G-1



400

FIG. 2G-2

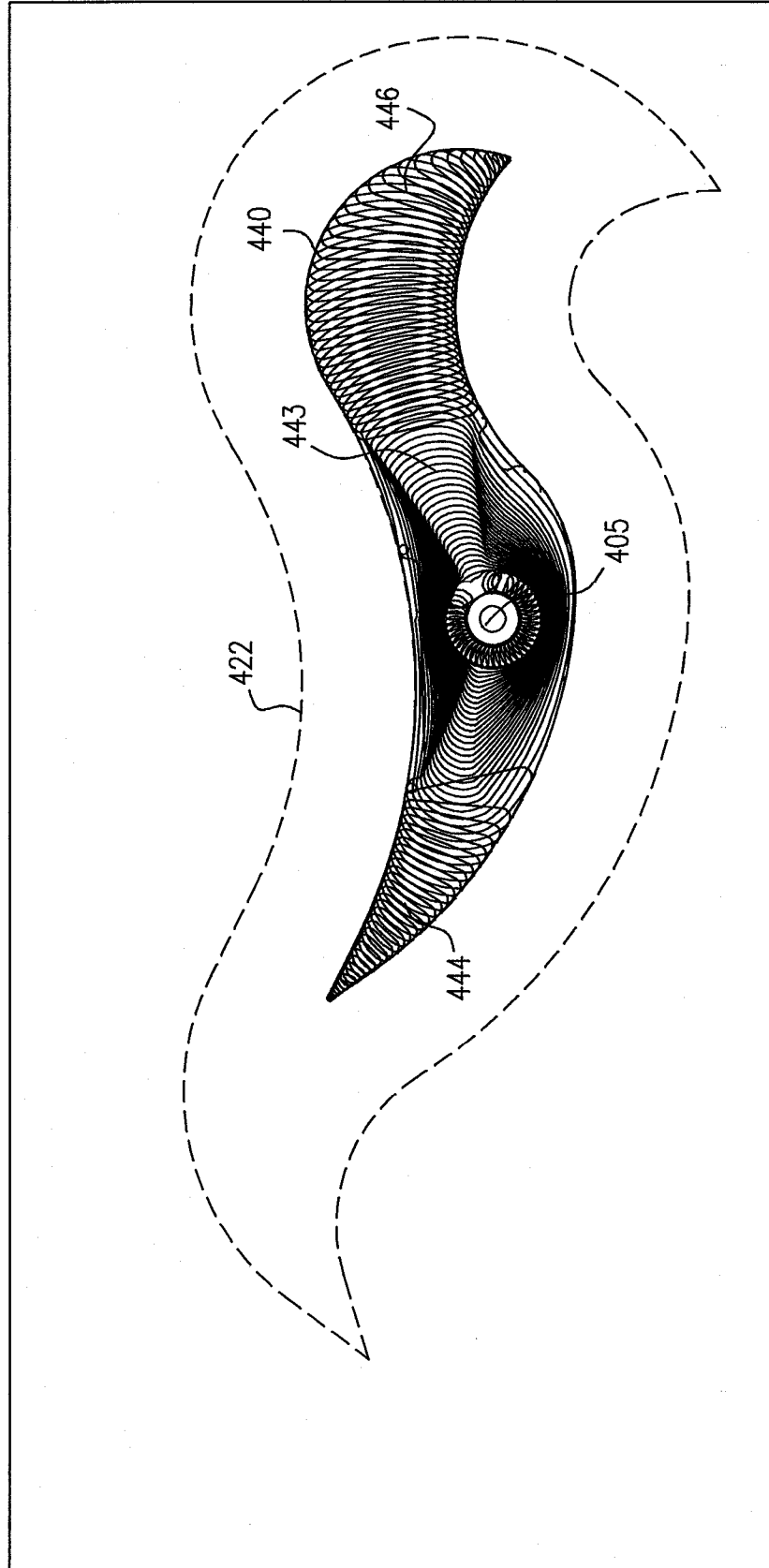


FIG. 2H-1

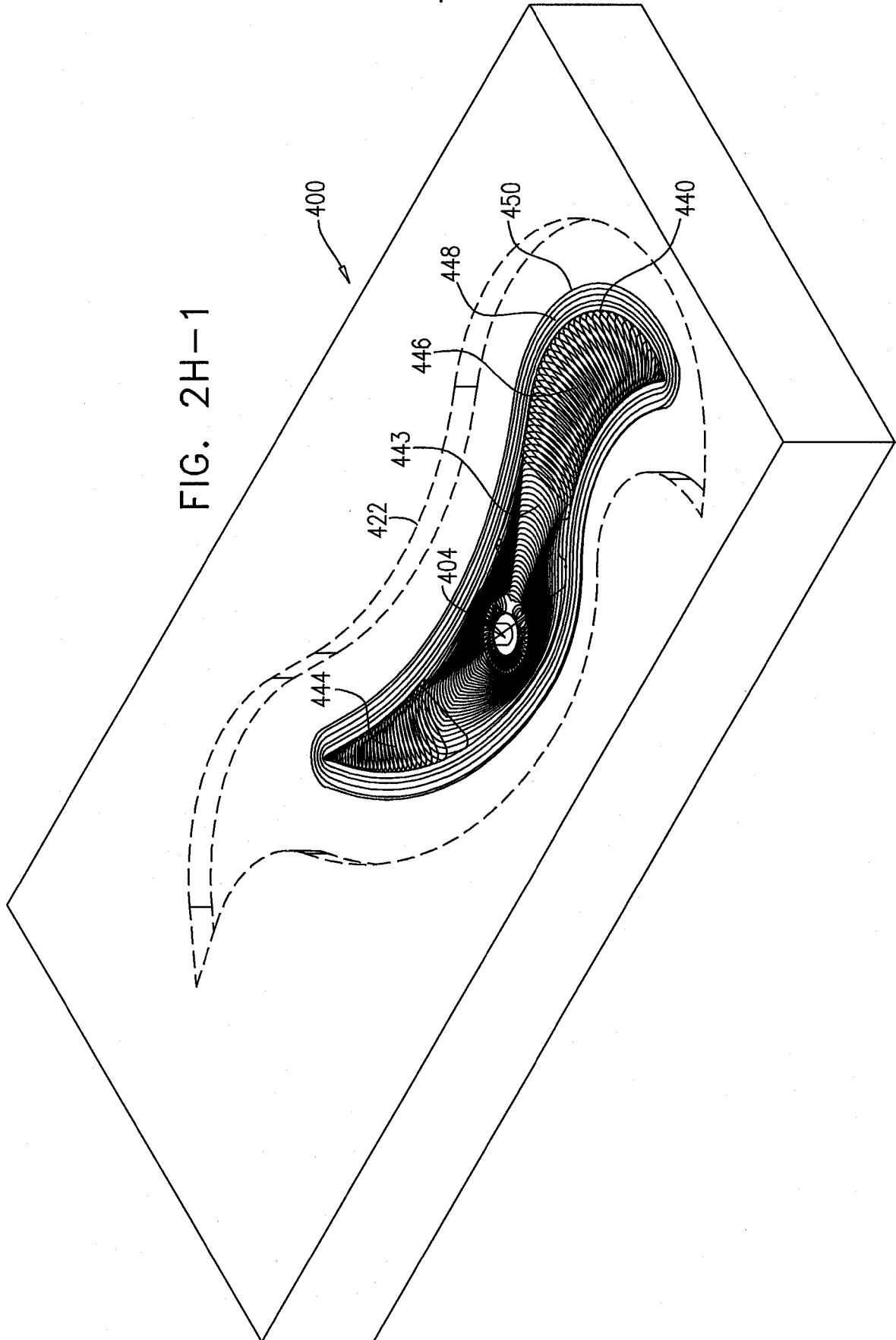
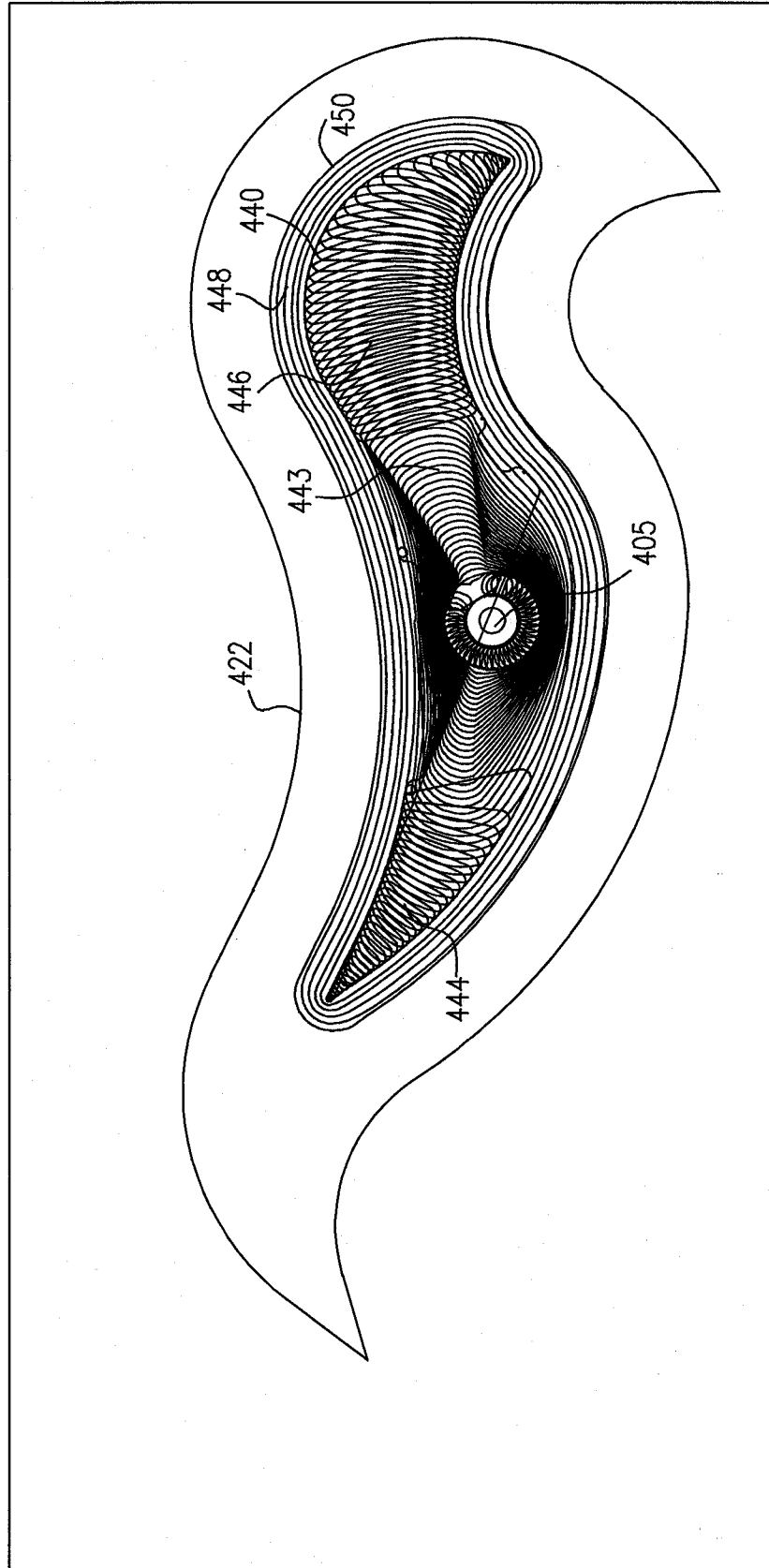


FIG. 2H-2

400



400

FIG. 21-2

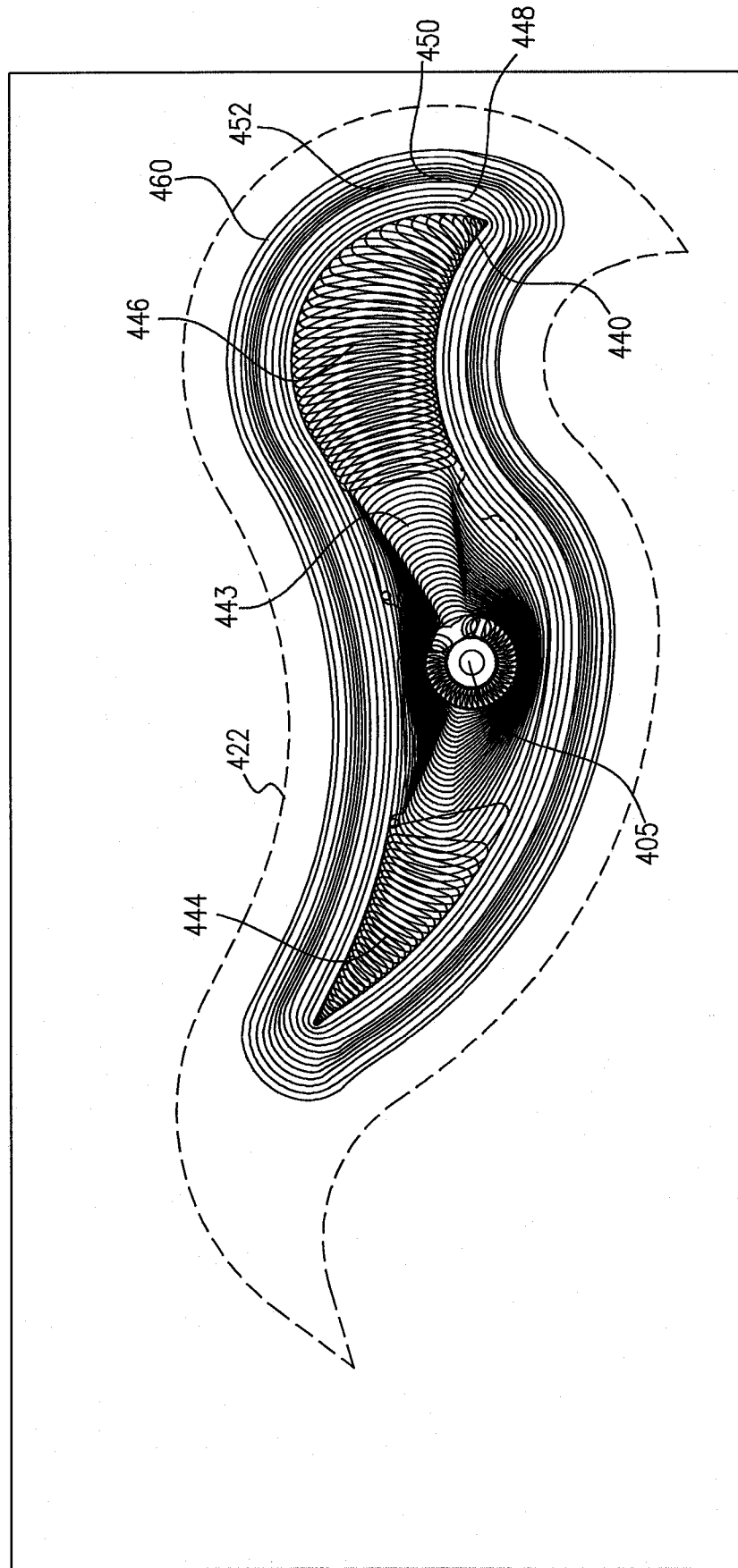


FIG. 2J-1

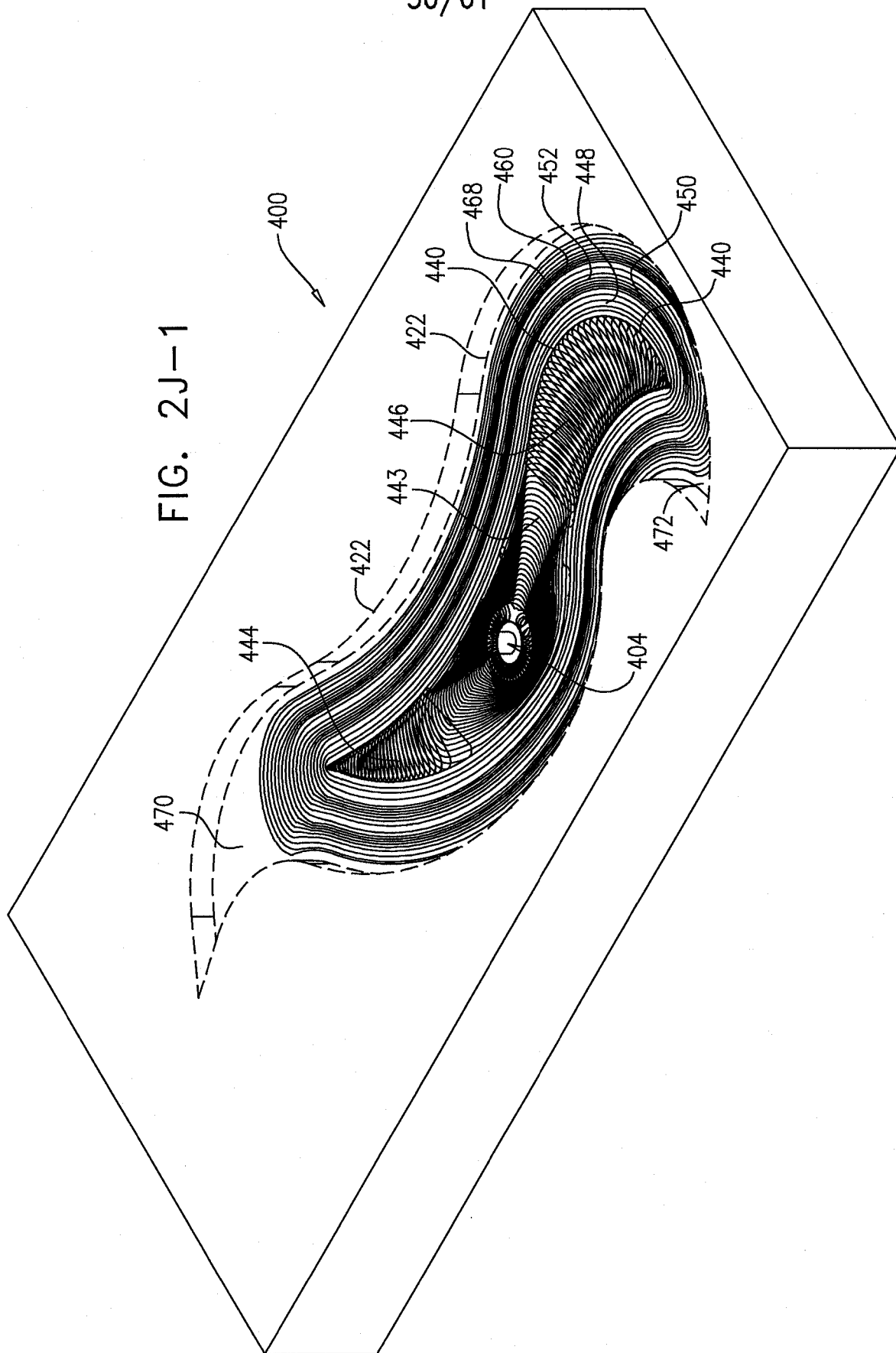


FIG. 2J-2

400

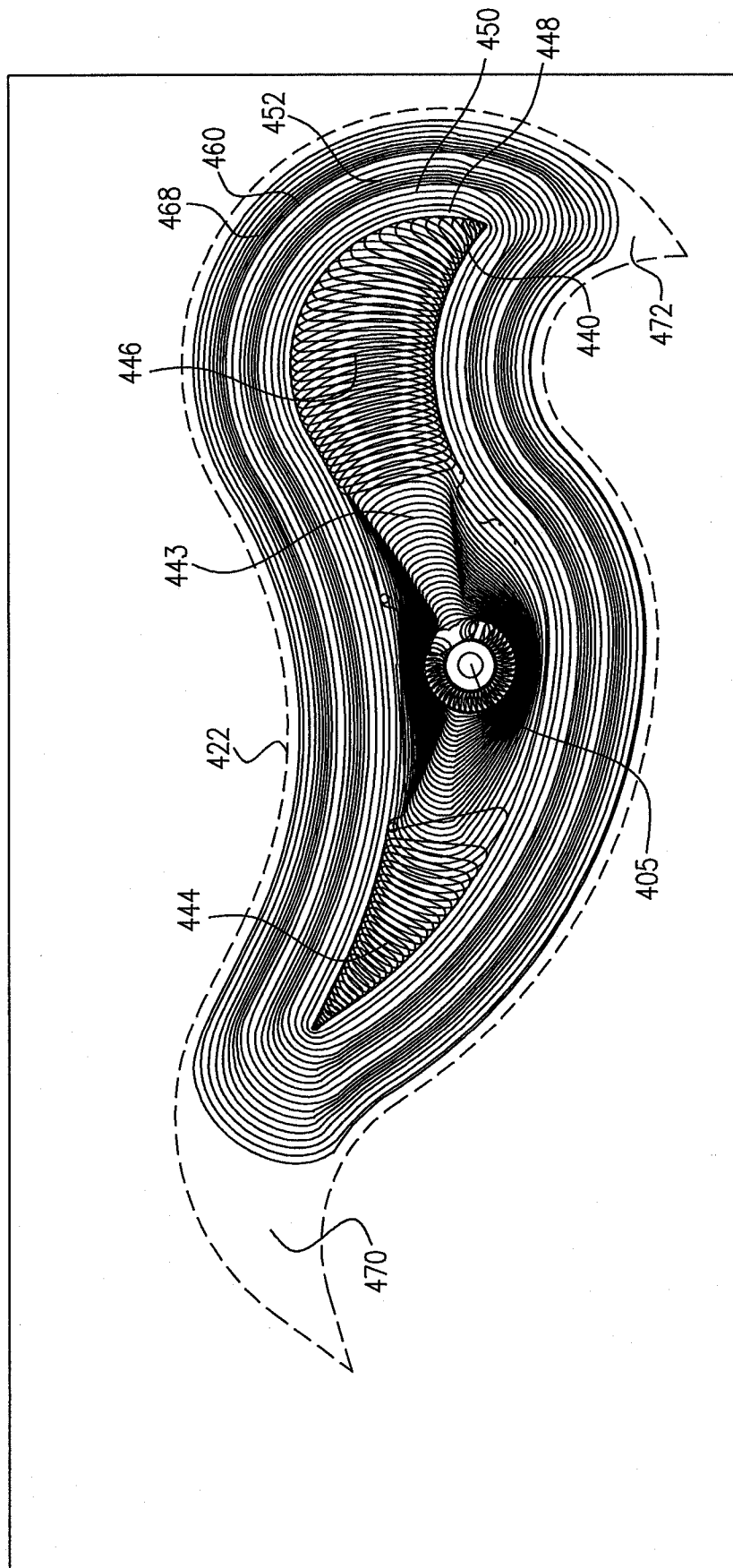


FIG. 2K-1

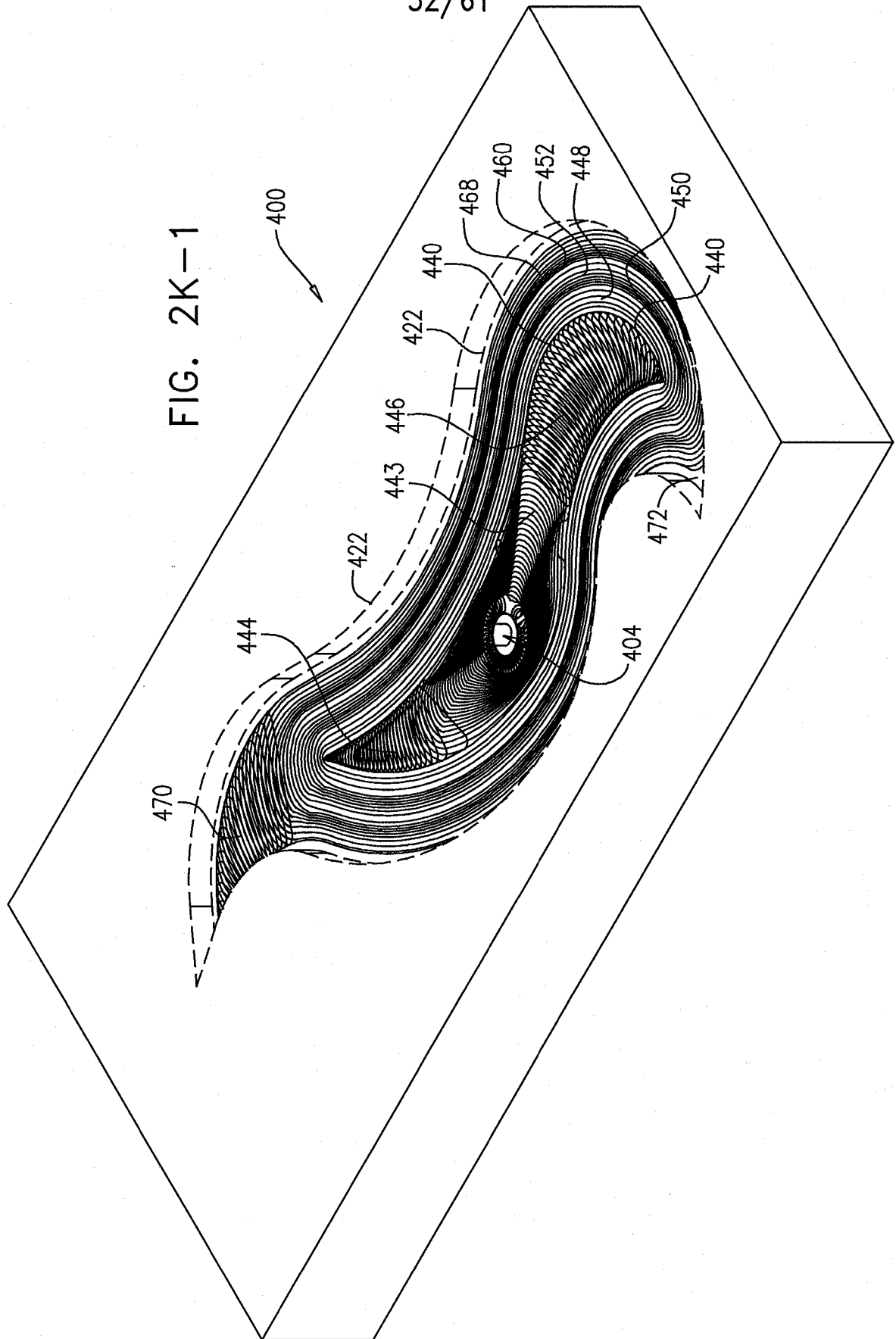


FIG. 2K-2

400

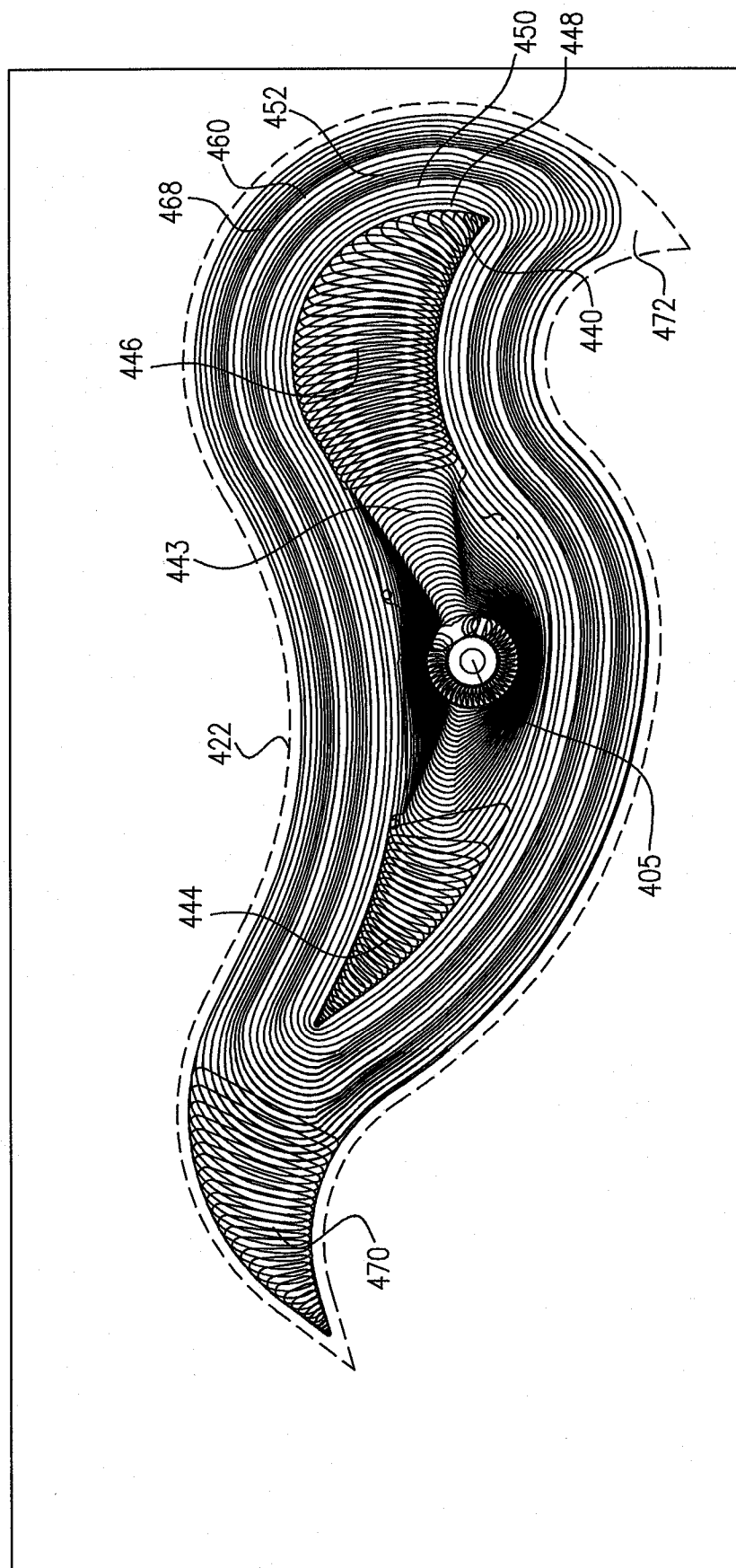
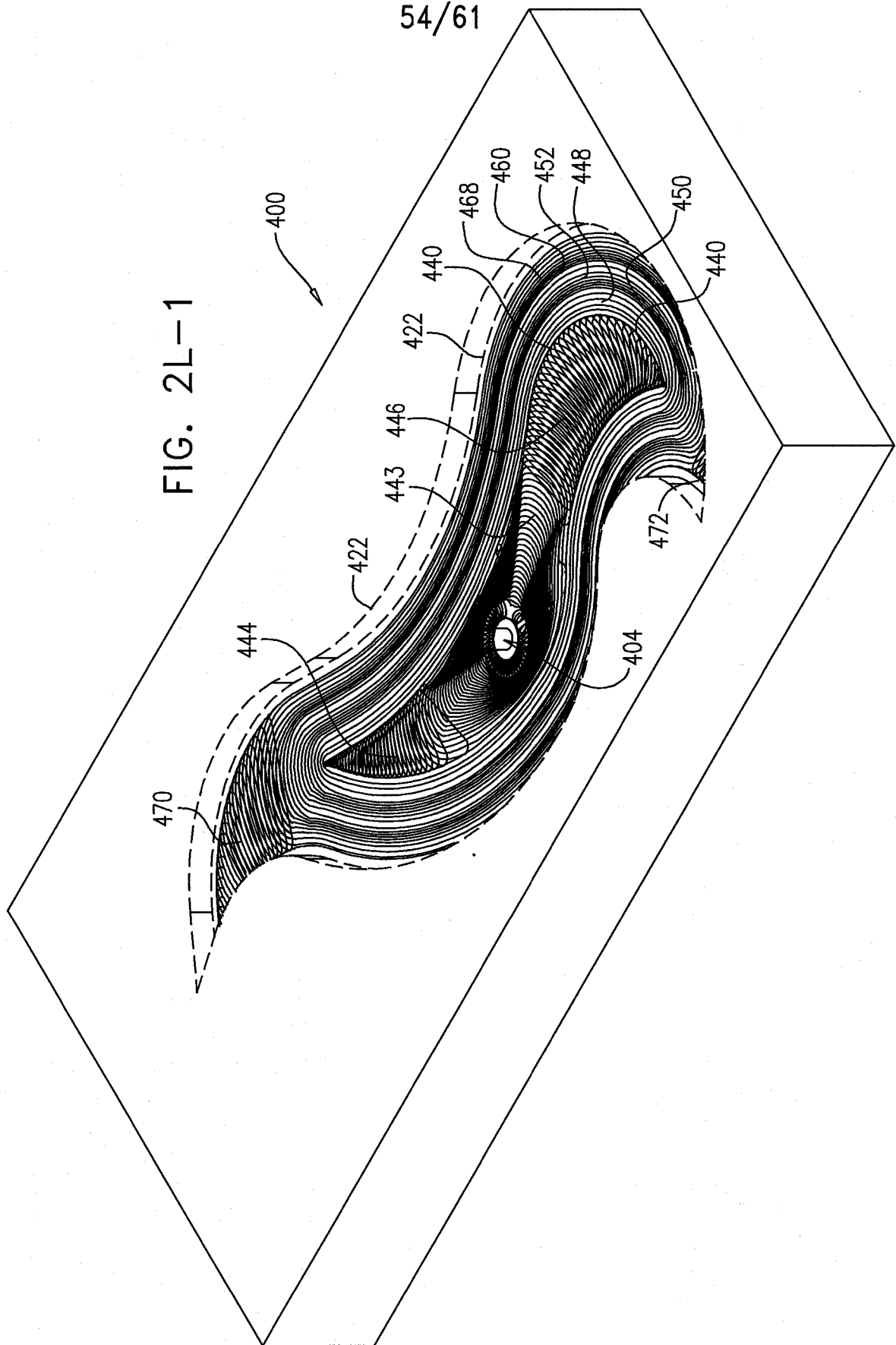
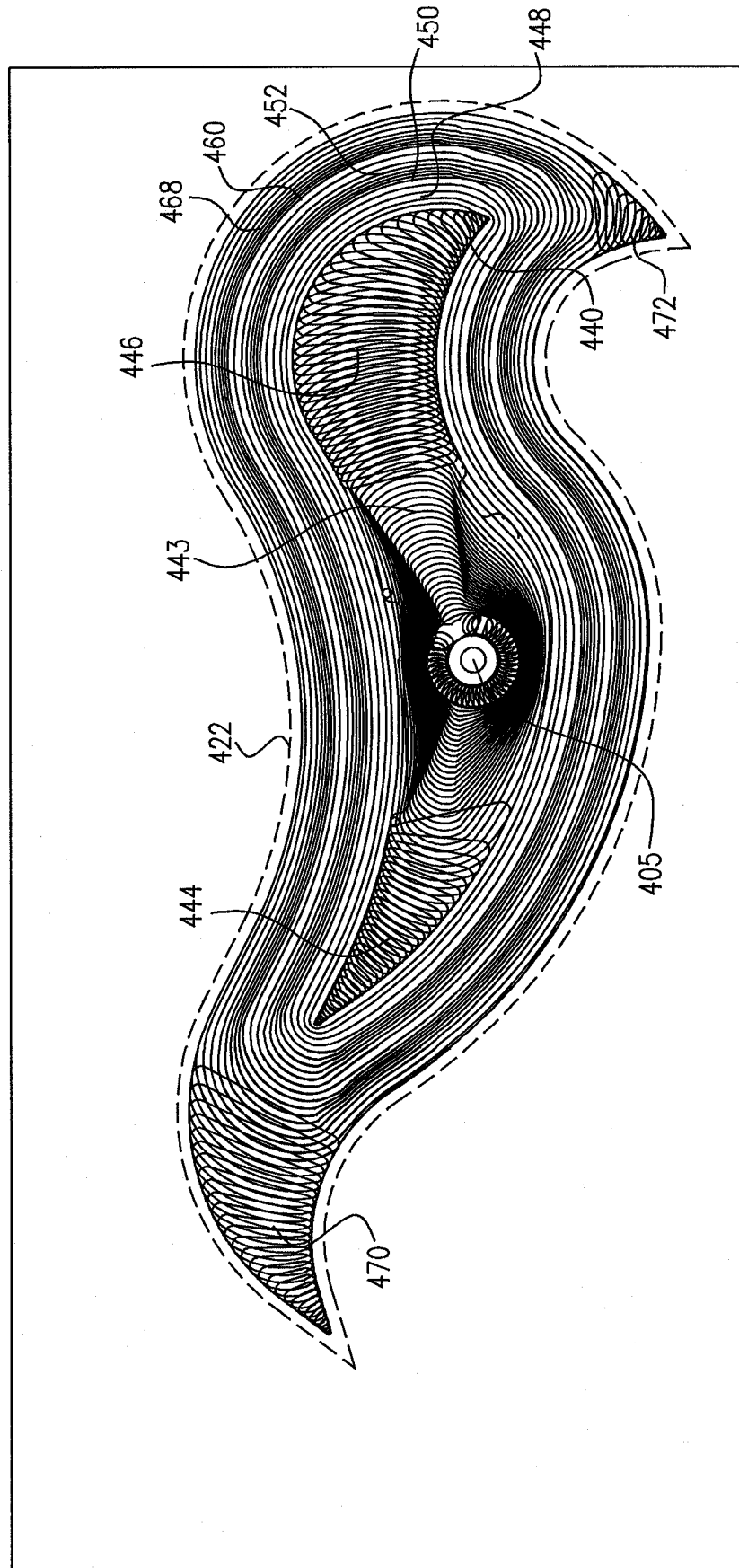


FIG. 2L-1



400

FIG. 2L-2



MachiningOperation

Technology: **iRough** | Operation name: **IM contour1 T5-2A 1** | Template: 

Cutting conditions | Modify cutting conditions

1. Select depth

Depth	ACPs
☐ 9.4248	☐ 2.0000
☐ 18.8496	☐ 3.0000
☒ 24.0000	☒ 3.5465

2. Select Level

Safe

Output Cutting data

☒ Actual ☐ General
 S (rpm):
 F (mm/min):
 Step over (max):
 Step over (min):

Apply

Save **Save & Calculate** **Simulate** **GCode** **Save & Copy** **Exit**

FIG. 3A

MachiningOperation

Technology: **iRough** | Operation name: **IM contour1 T5-2A 1** | Template:  

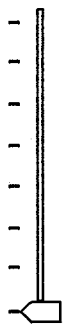
Cutting conditions | Modify cutting conditions

1. Select depth

Depth	ACPs
☐ 9.4248	2.0000
☐ 18.8496	3.0000
☒ 24.0000	3.5465

2. Select Level

Safe



Output Cutting data

☒ Actual ☐ General

V (m/min):

Fz (mm/tooth):

CA (max):

CA (min):

Apply

Save **Save & Calculate** **Simulate** **GCode** **Save & Copy** **Exit**

Geometry **Tool** **Levels** **Technology Wizard** **Technology** **Link** **Misc. parameters**

FIG. 3B

MachiningOperation

Technology: **iRough** | Operation name: **11M contour1 T5-2A 1** | Template: 

Cutting conditions | Modify cutting conditions

1. Select depth

Depth	ACPs
☐ 9.4248	2.0000
☐ 18.8496	3.0000
☒ 24.0000	3.5465

2. Select Level

Moderate



Output Cutting data

☒ Actual ☐ General

S (rpm): **7500**

F (mm/min): **3199.53**

Step over (max): **2.032**

Step over (min): **0.362**

Apply

Save **Save & Calculate** **Simulate** **GCode** **Save & Copy** **Exit**

FIG. 3C

FIG. 3D

MachiningOperation

Technology

iRough ▼

Operation name

IM contour1 T5-2A 1 ▼

Template

Cutting conditions | Modify cutting conditions

1. Select depth

Depth	ACPs
☐ 9.4248	2.0000
☐ 18.8496	3.0000
☒ 24.0000	3.5465

2. Select Level

Aggressive

...

Output Cutting data

☒ Actual

☐ General

S (rpm):

1200

F (mm/min):

5119.24

Step over (max):

2.032

Step over (min):

0.362

Apply

Geometry

Tool

Levels

Technology Wizard

Technology

Link

Misc. parameters

Save

Save & Calculate

Simulate

GCode

Save & Copy

Exit

59/61

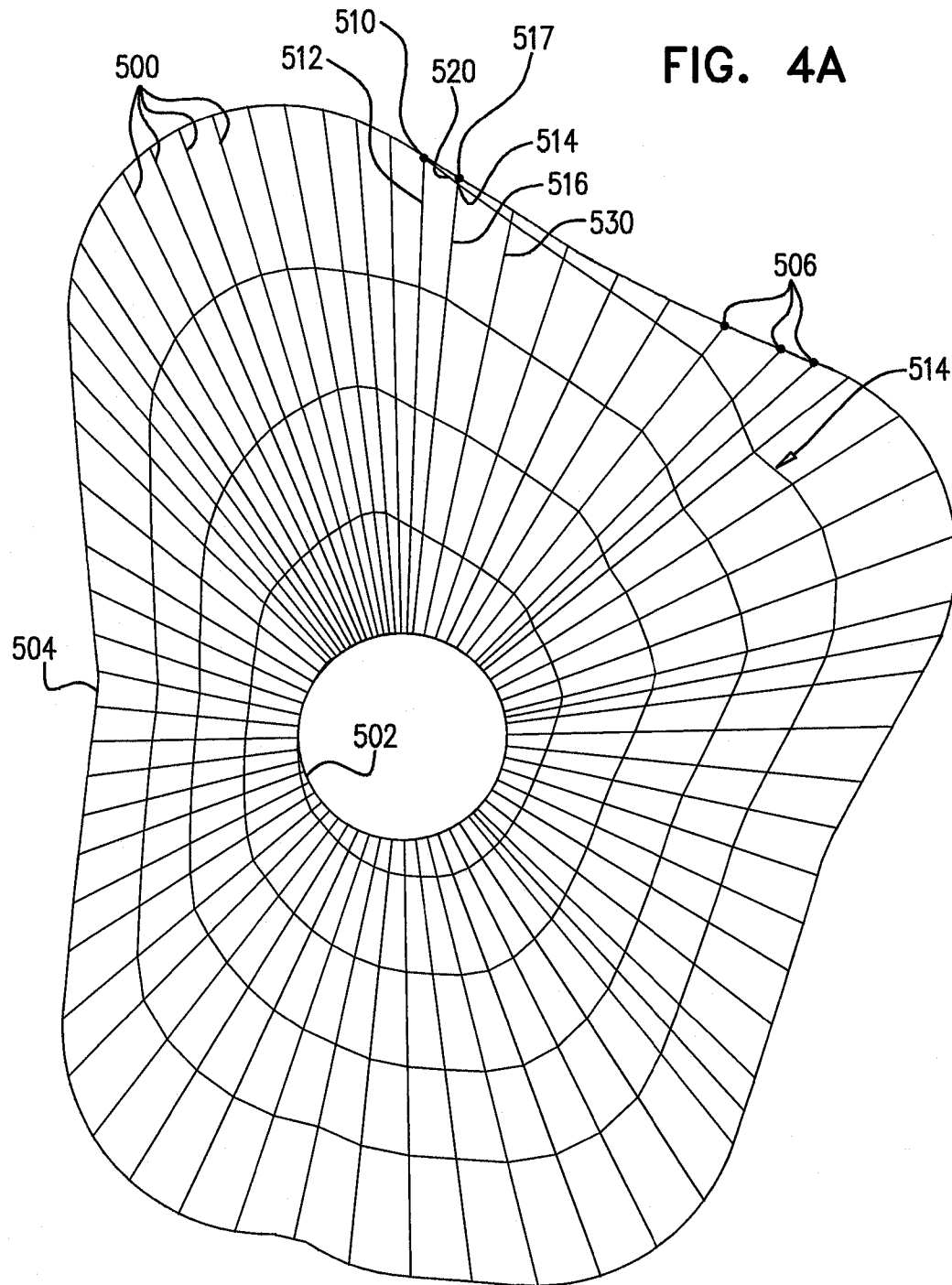


FIG. 4B

