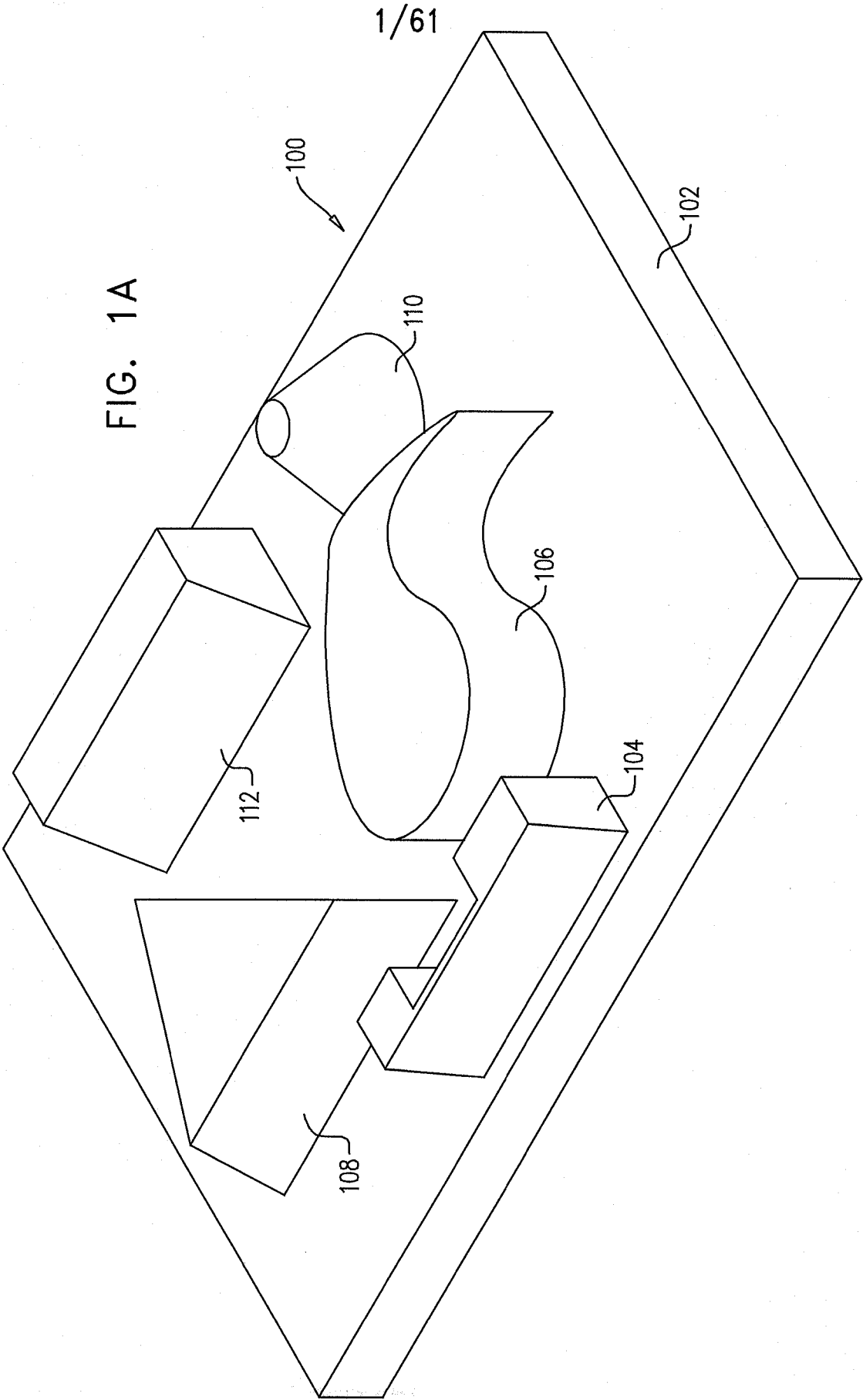
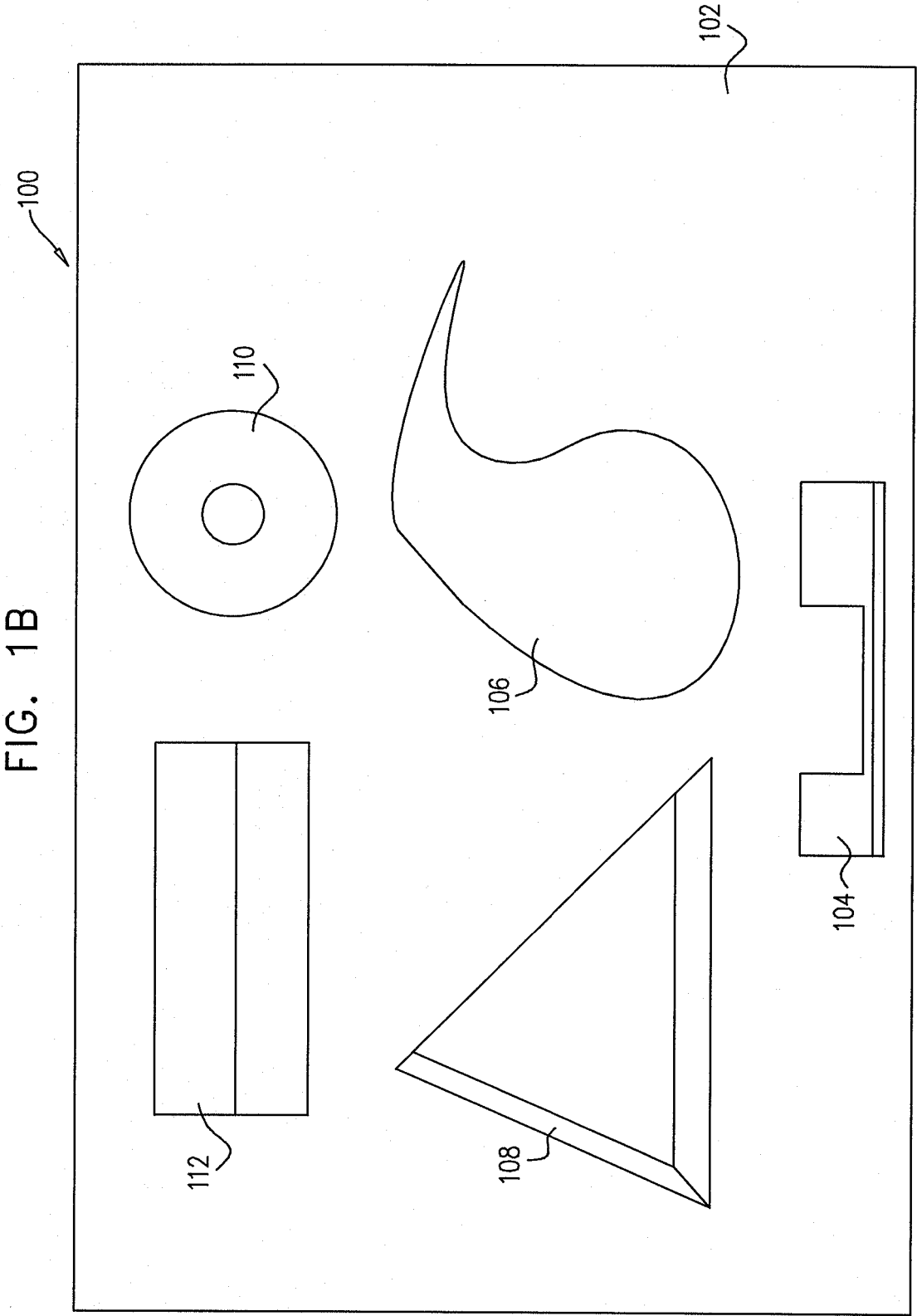


FIG. 1A

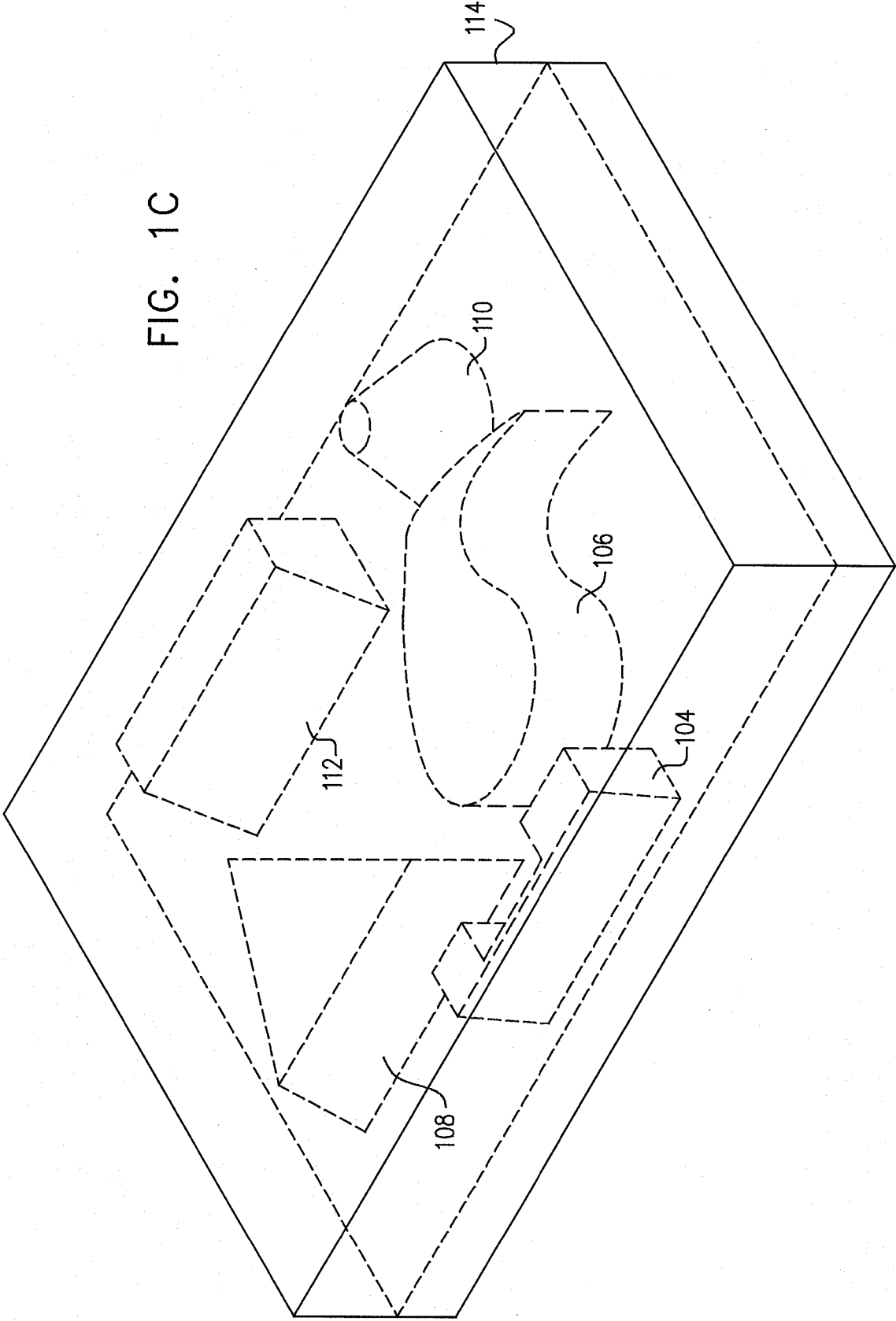


1/61

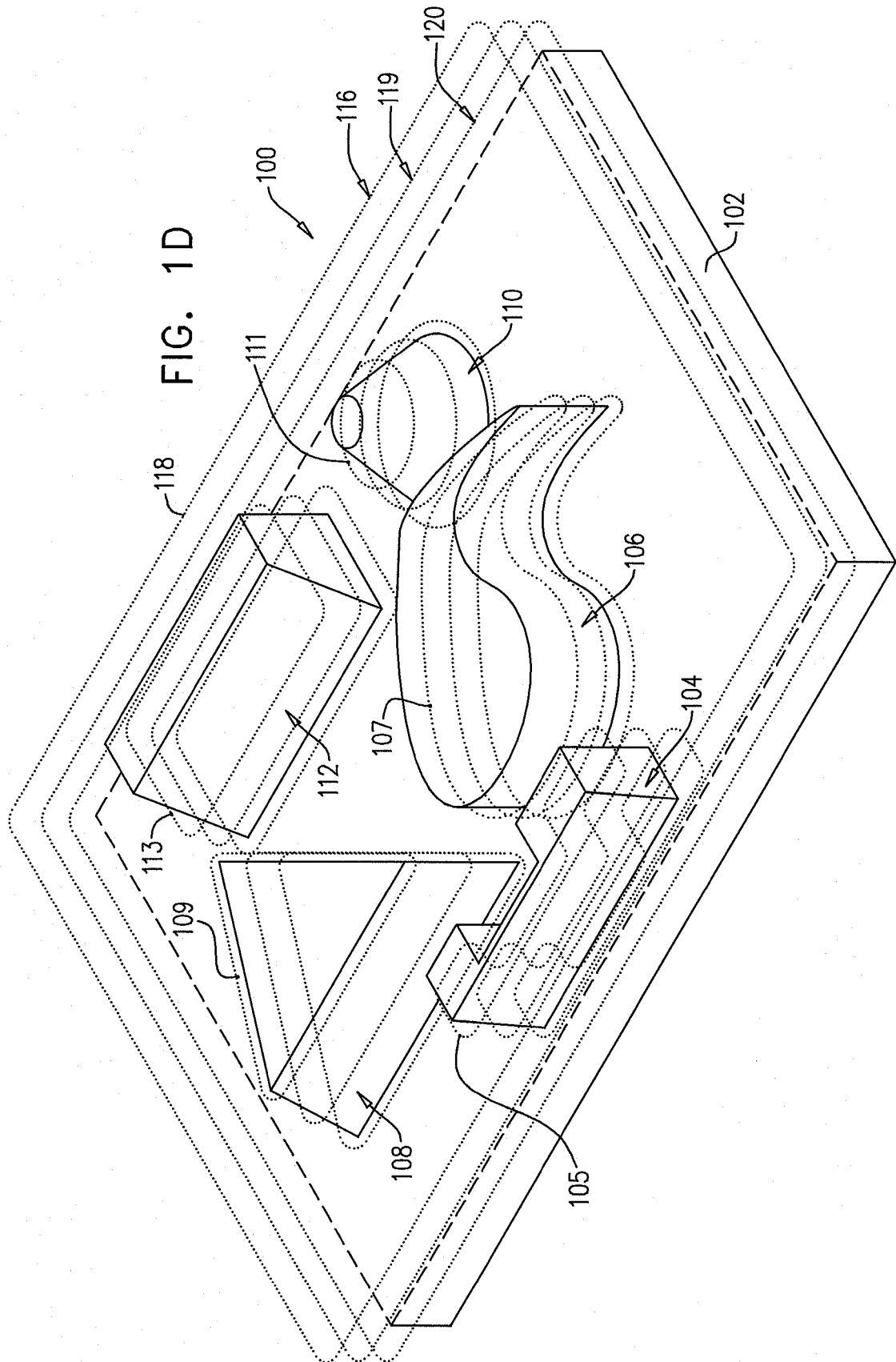


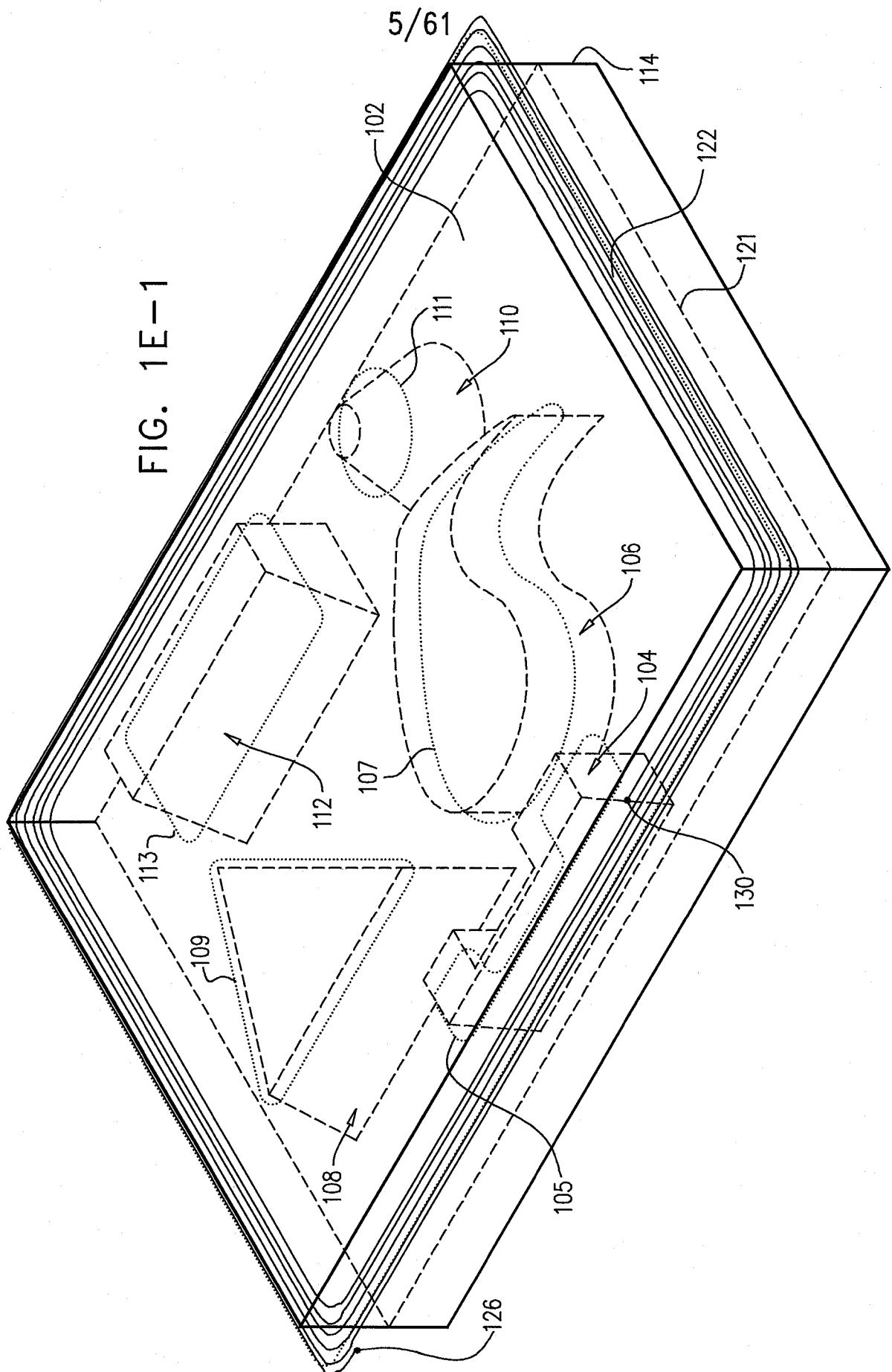
3/61

FIG. 1C



4/61





6/61

FIG. 1E-2

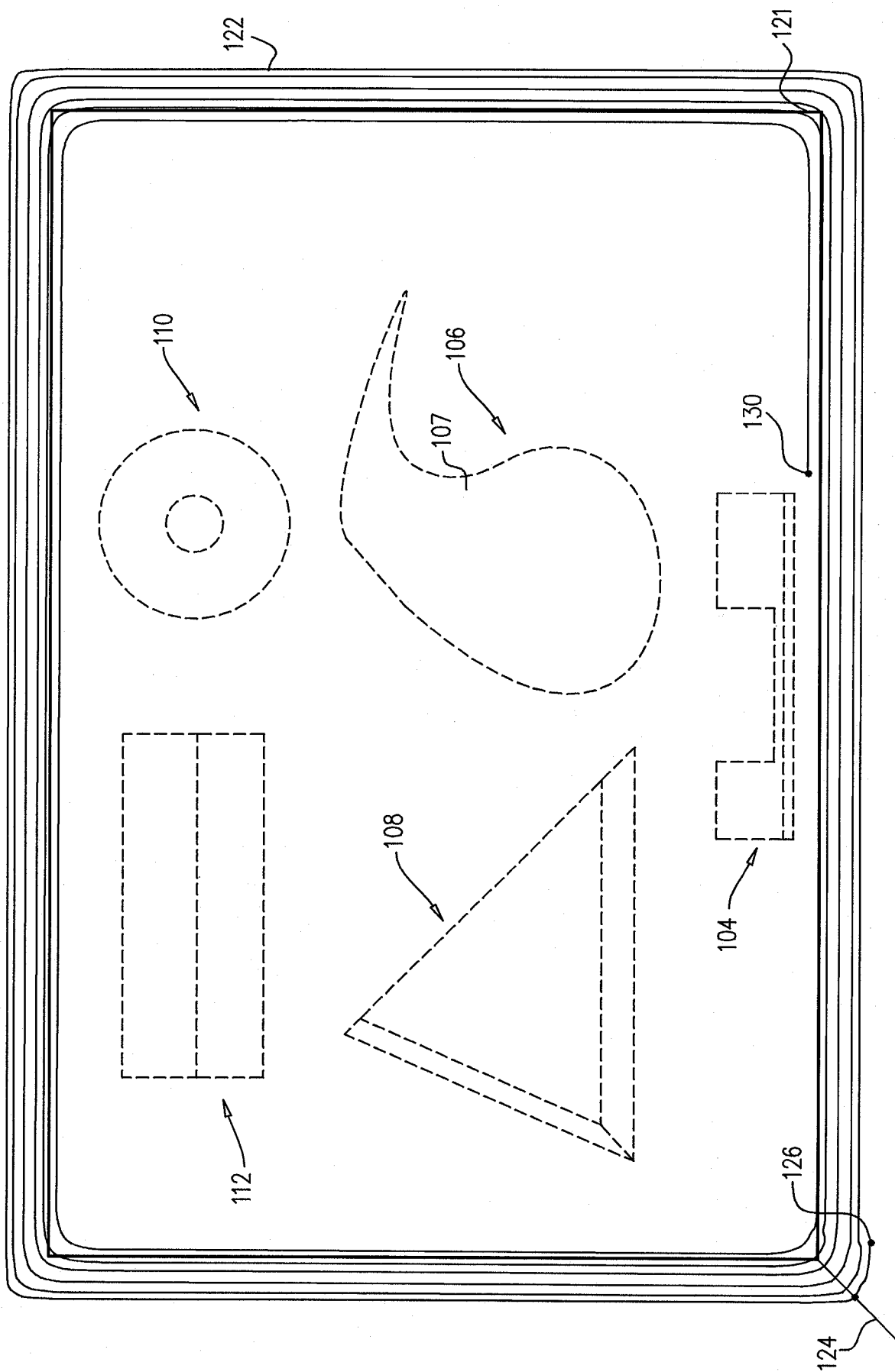
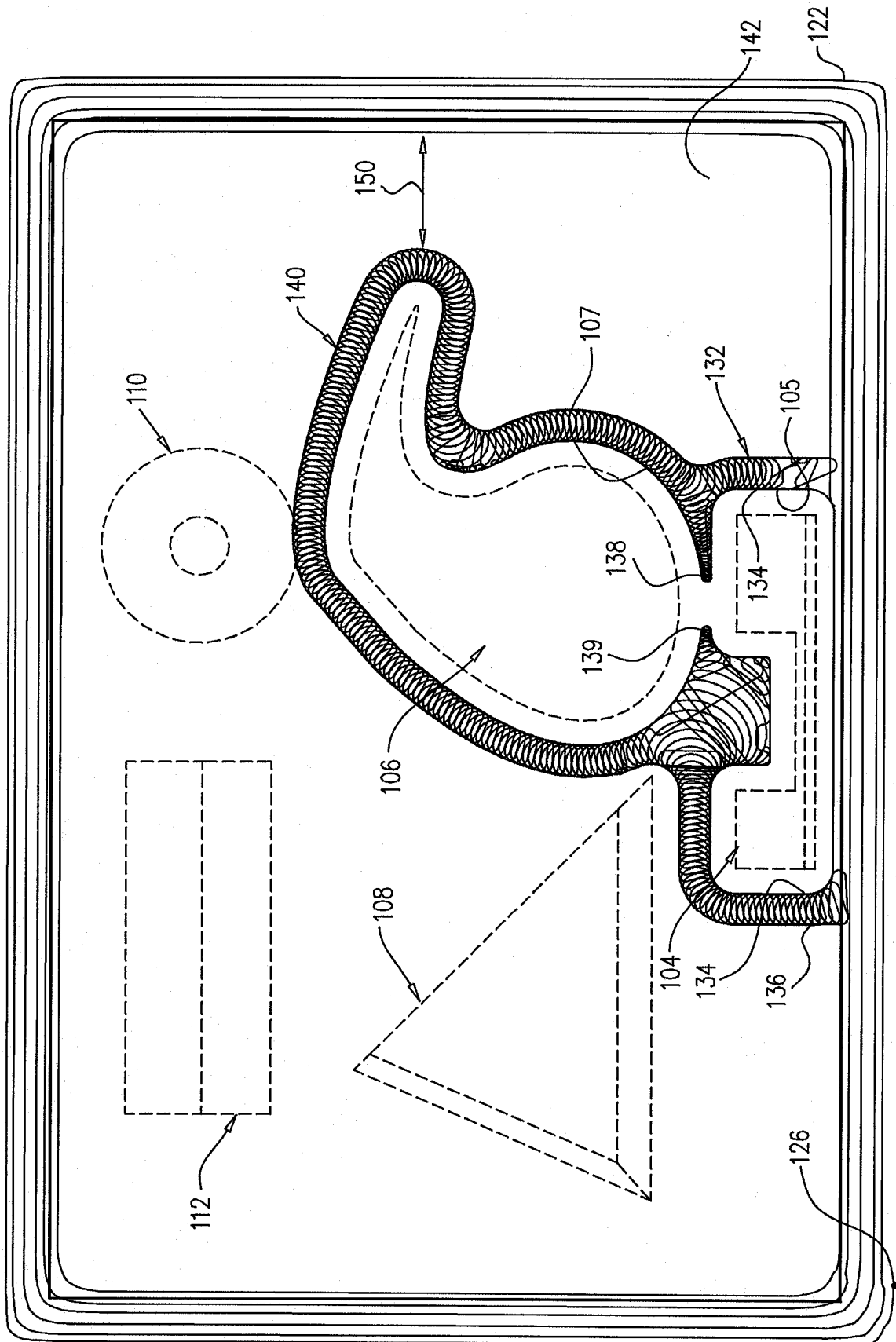
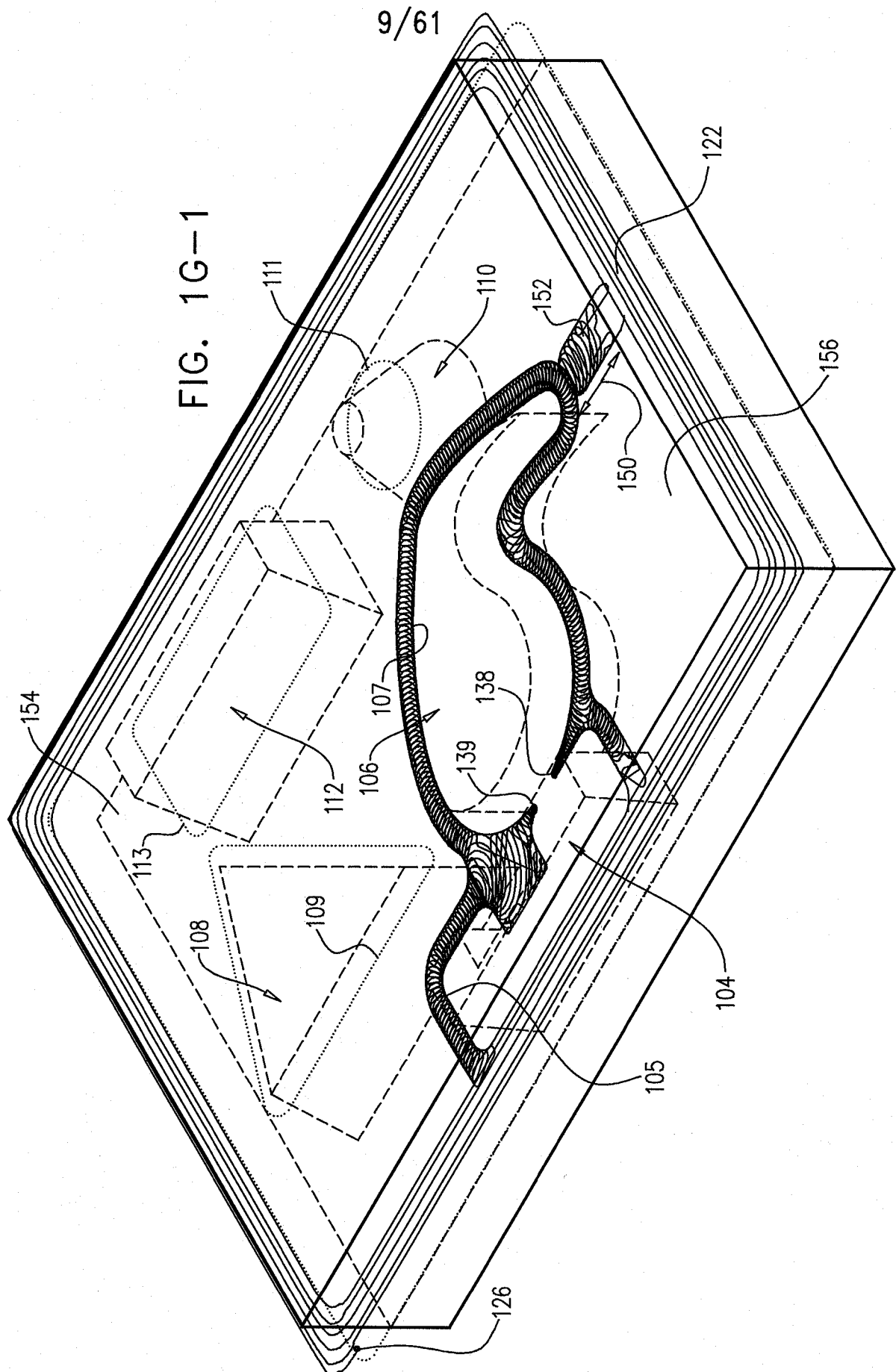


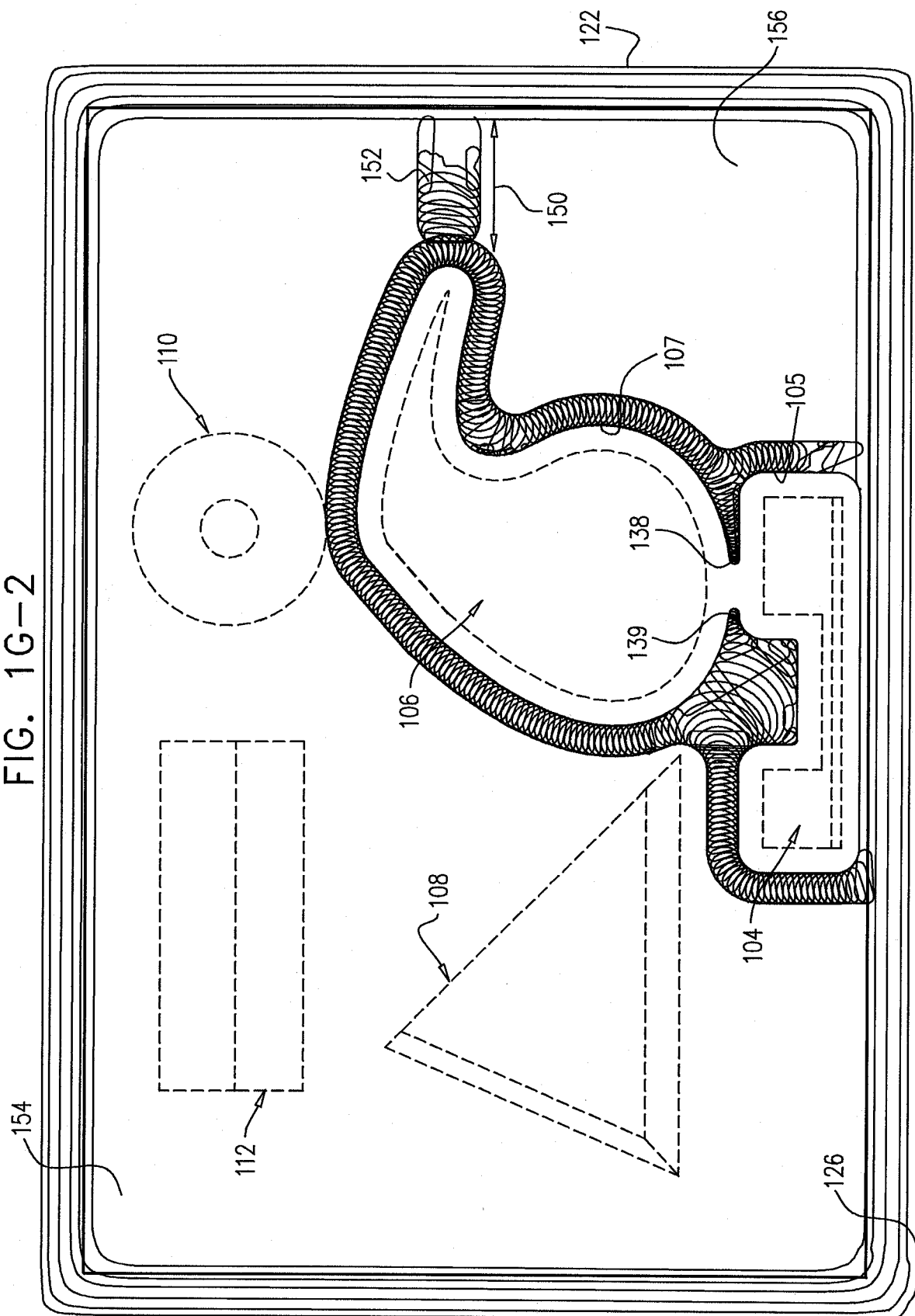
FIG. 1F-2

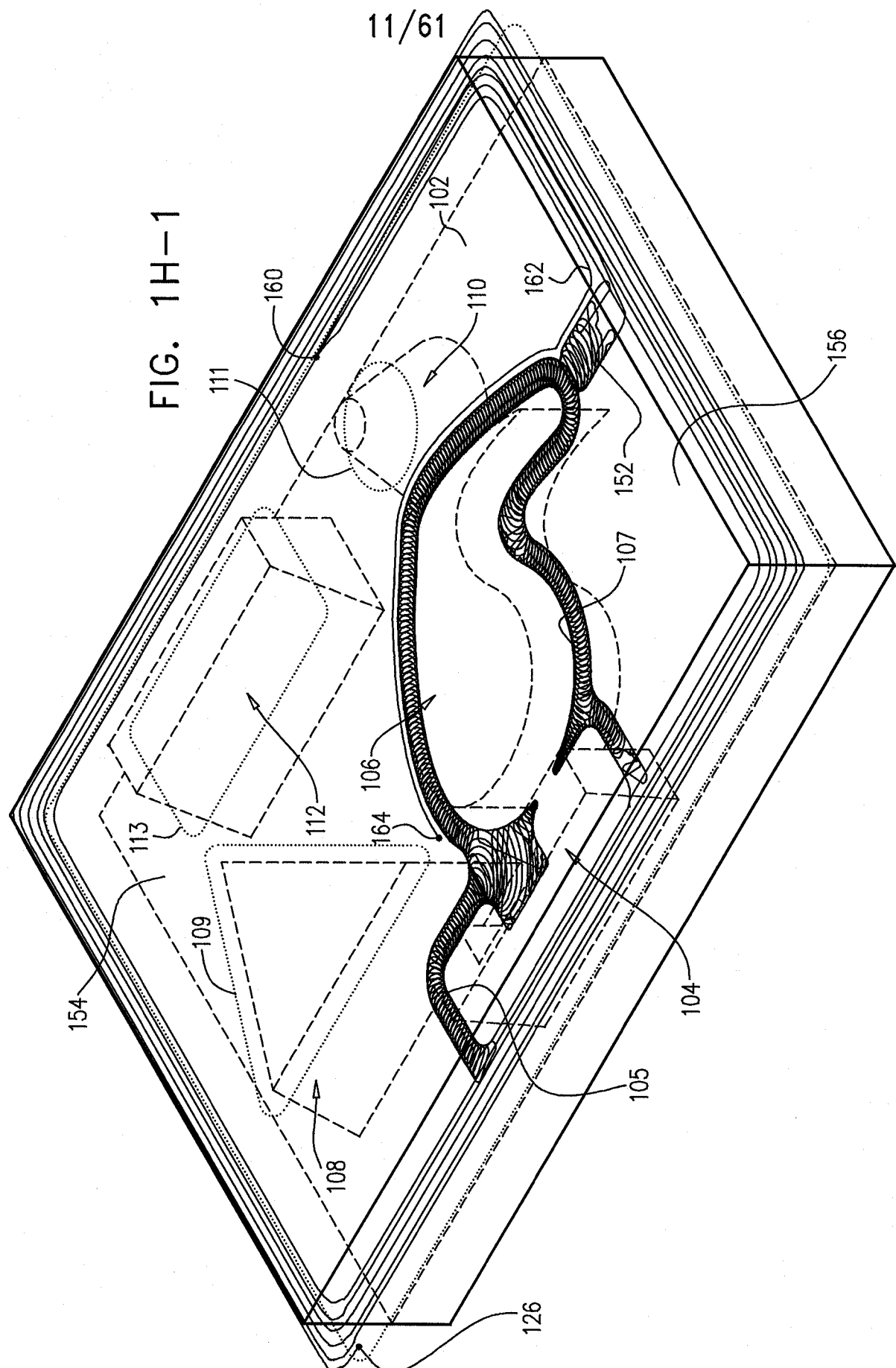




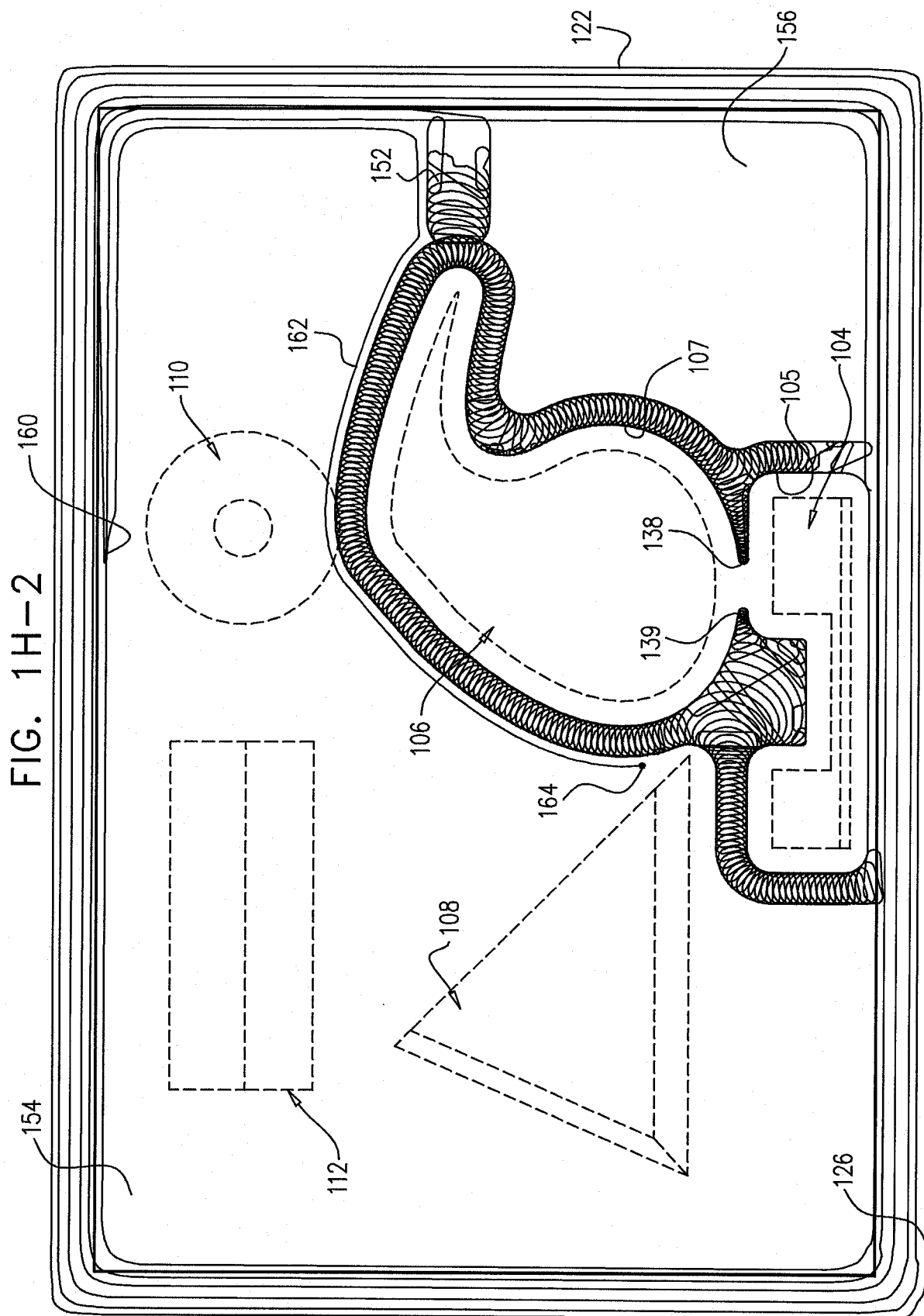
10/61

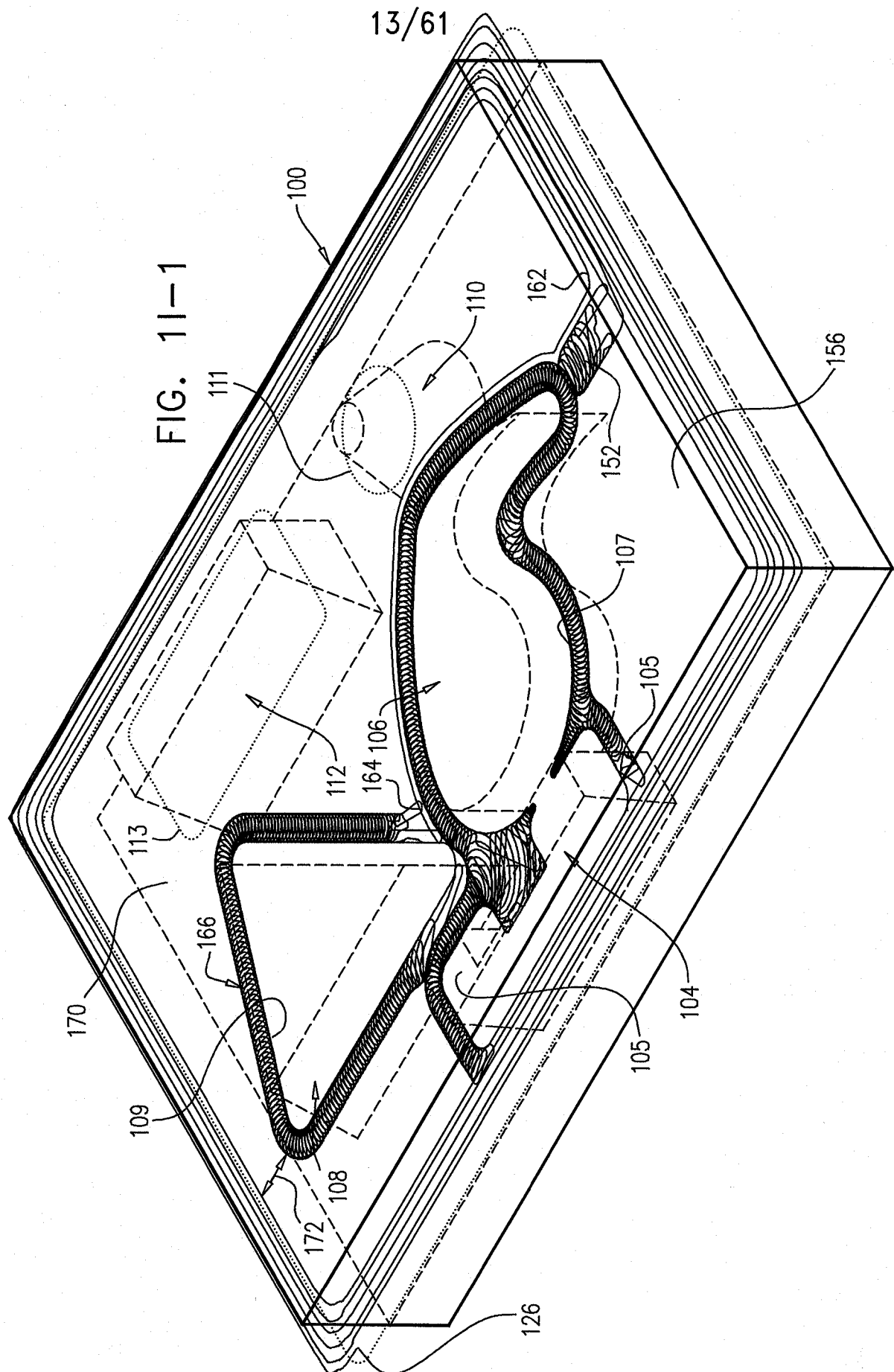
FIG. 1G-2





12/61





14/61

FIG. 11-2

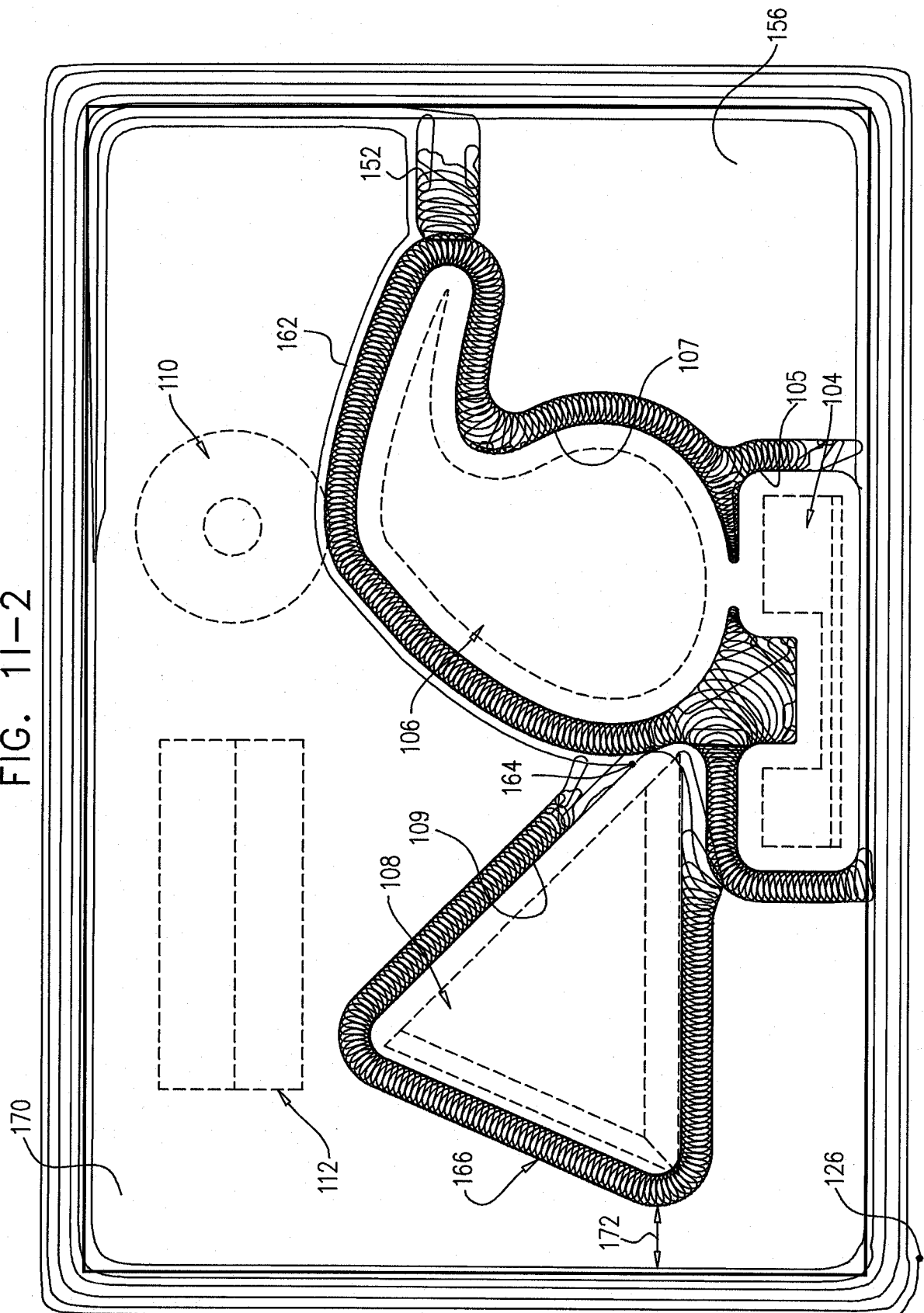
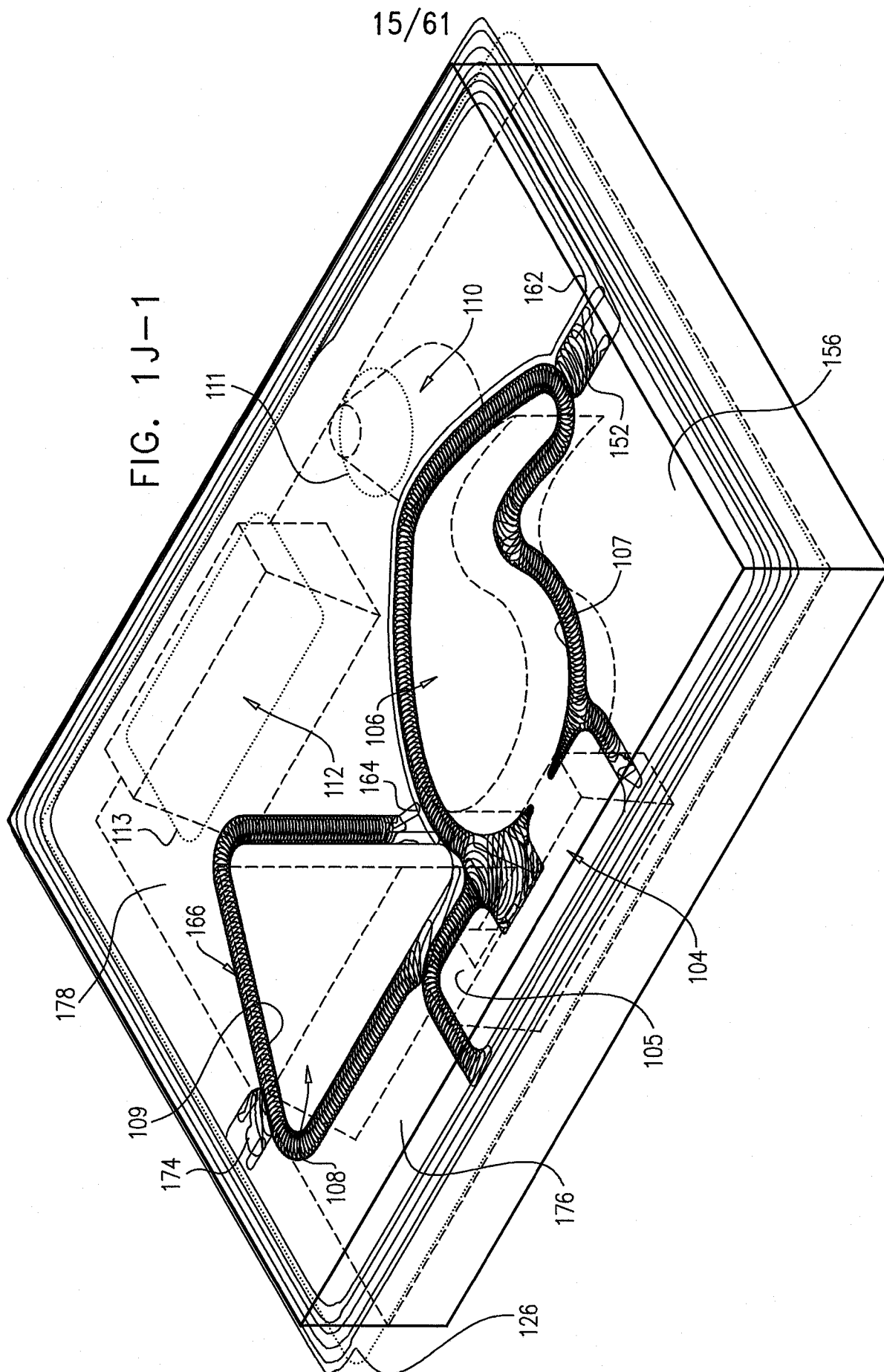
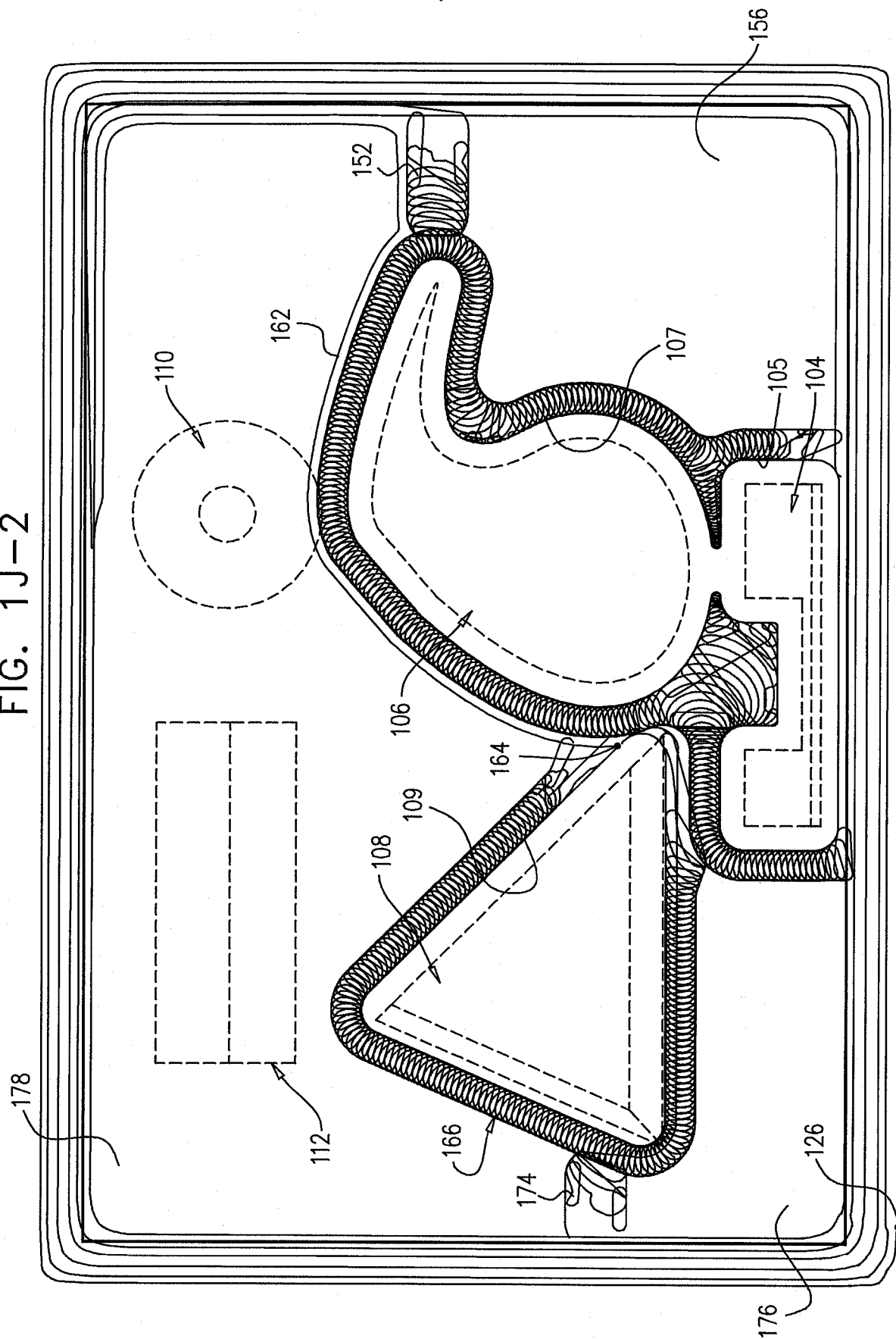


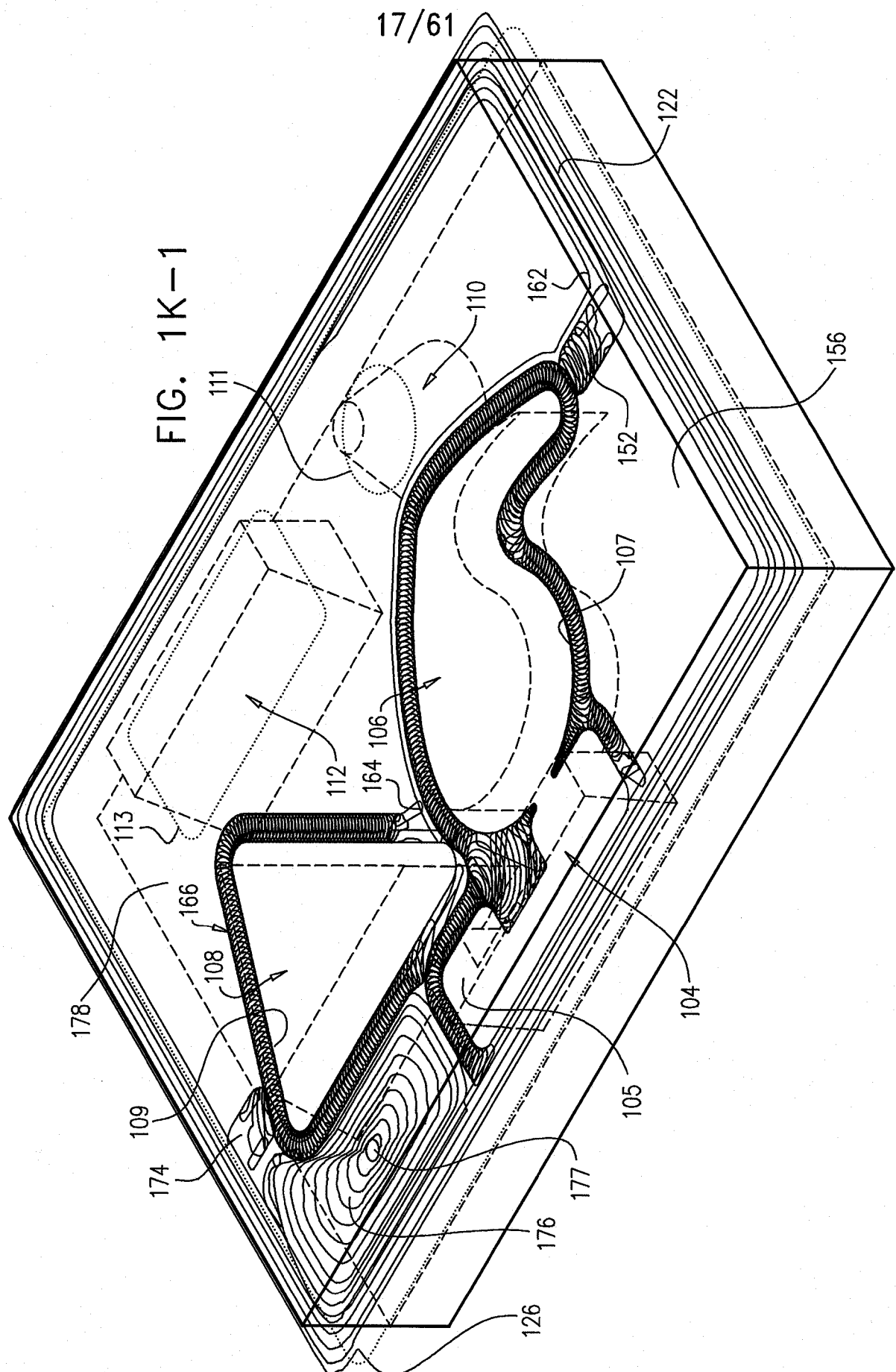
FIG. 1J-1



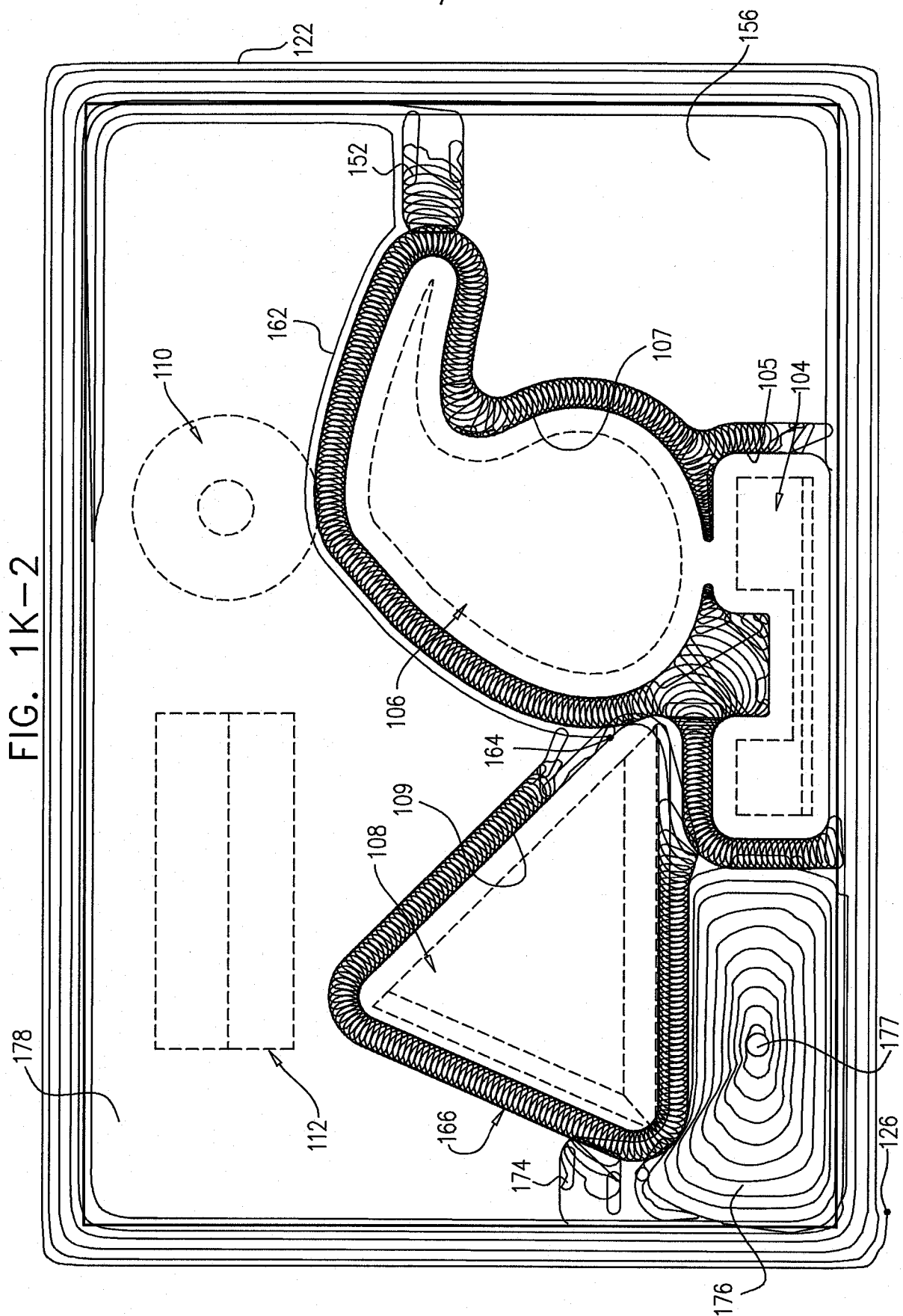
16/61

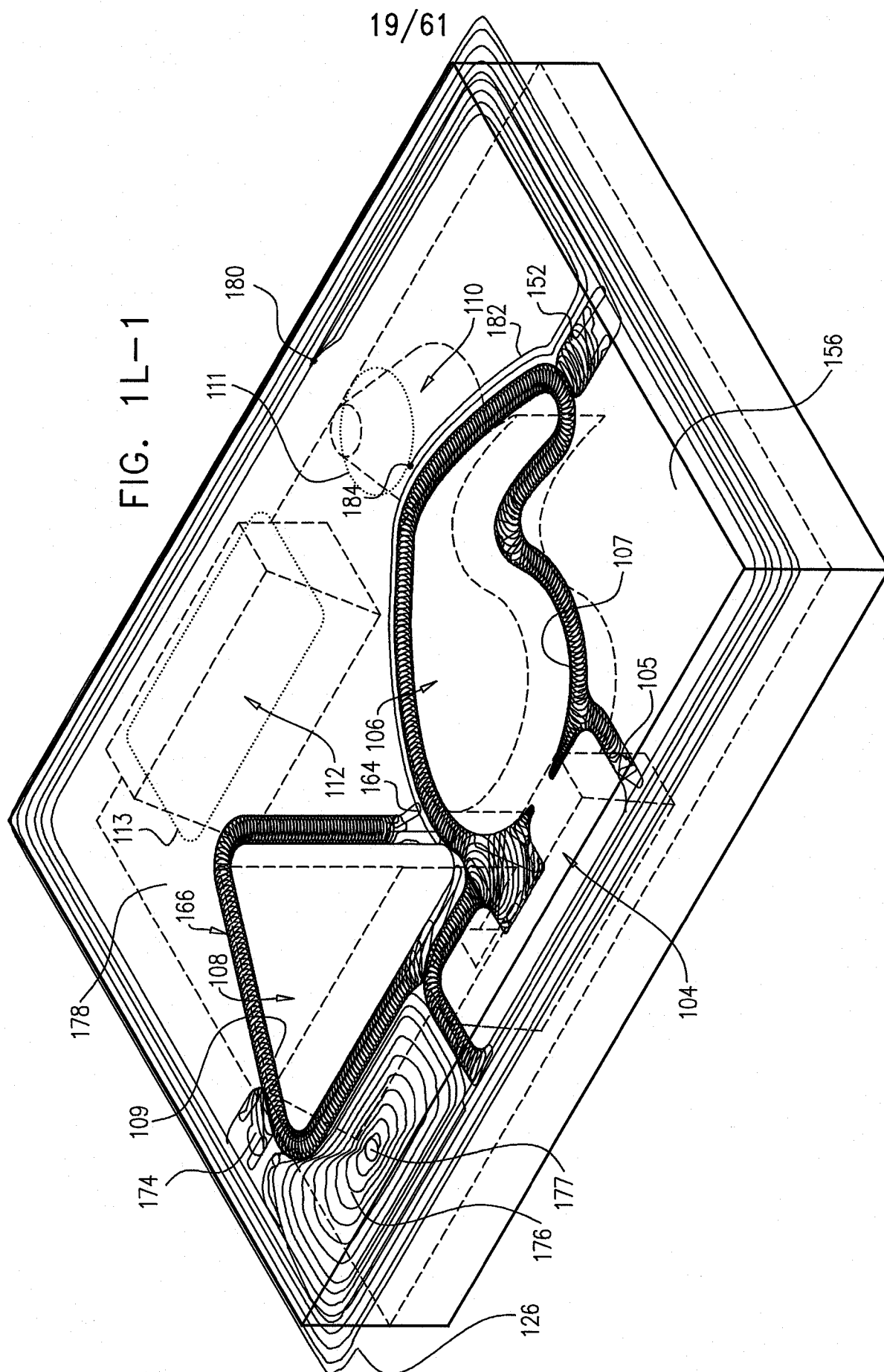
FIG. 1J-2



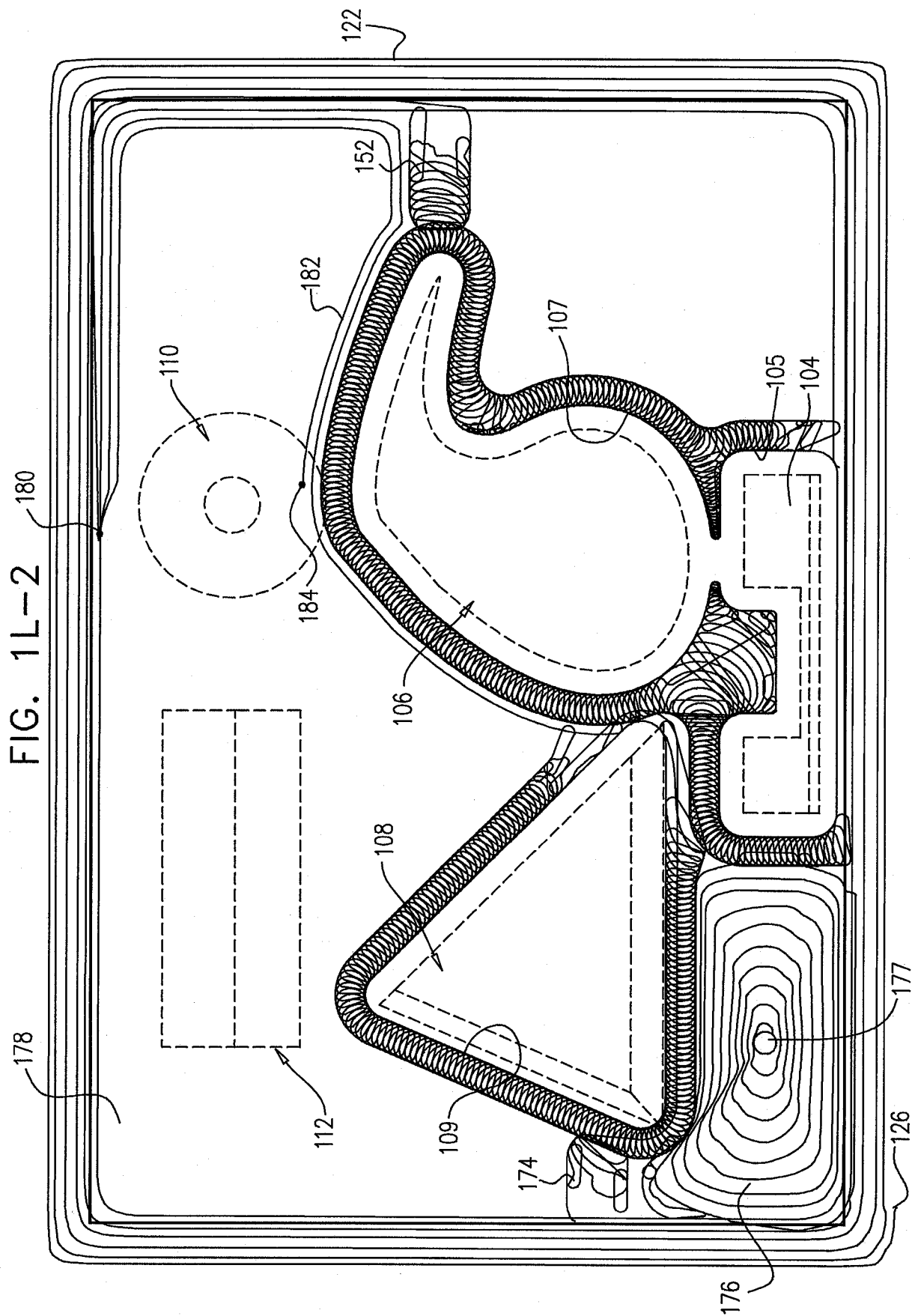


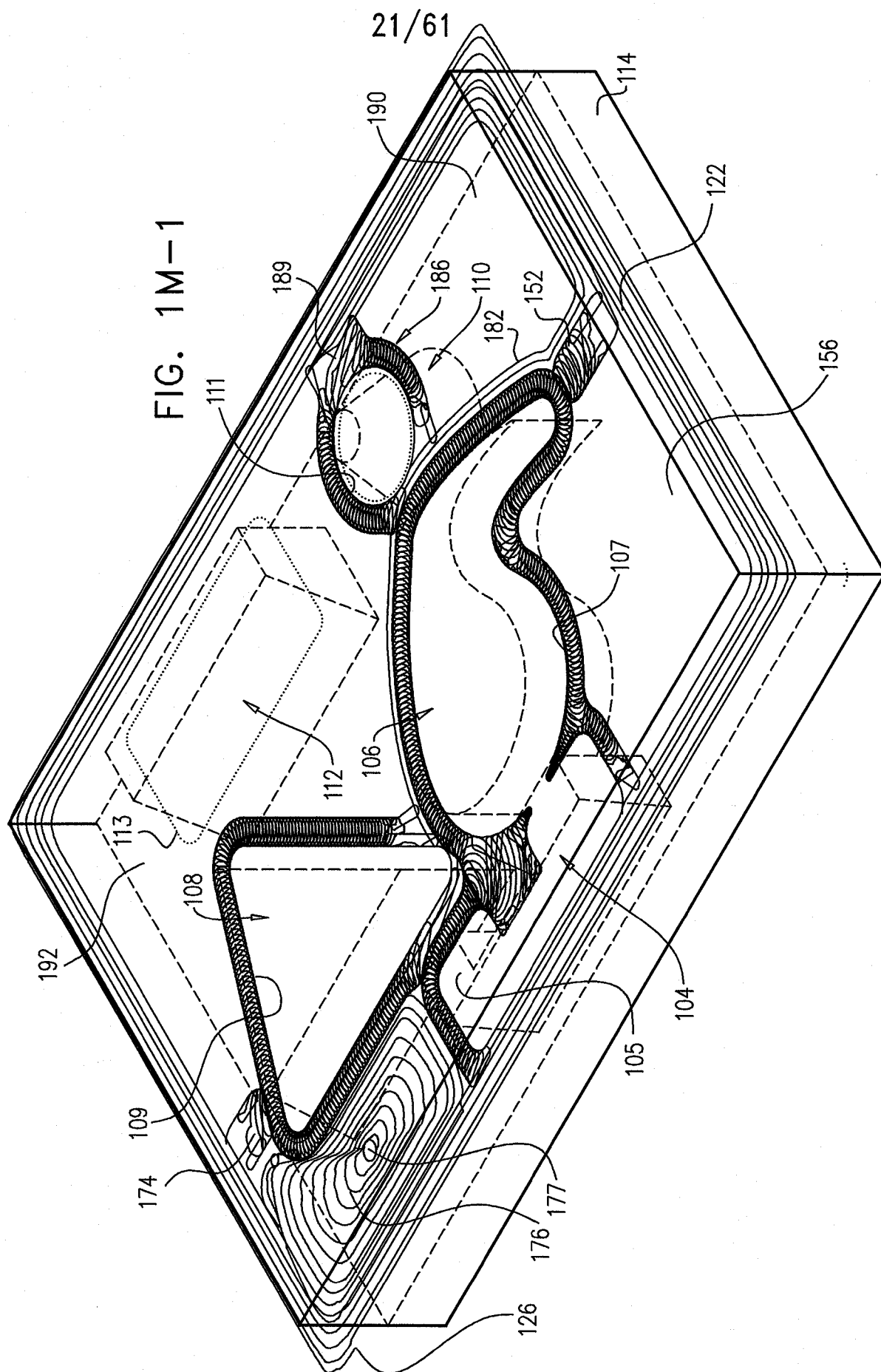
18/61



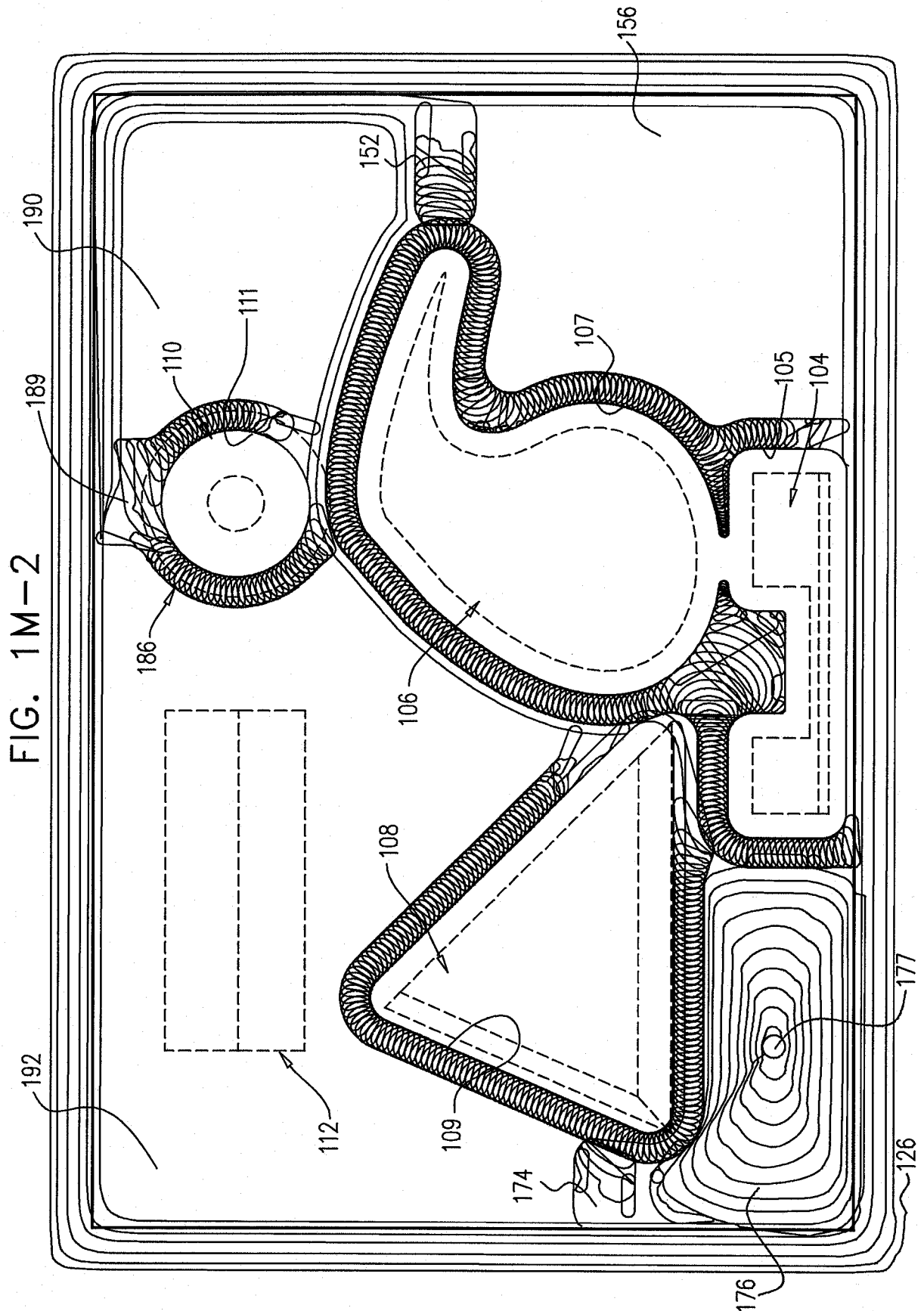


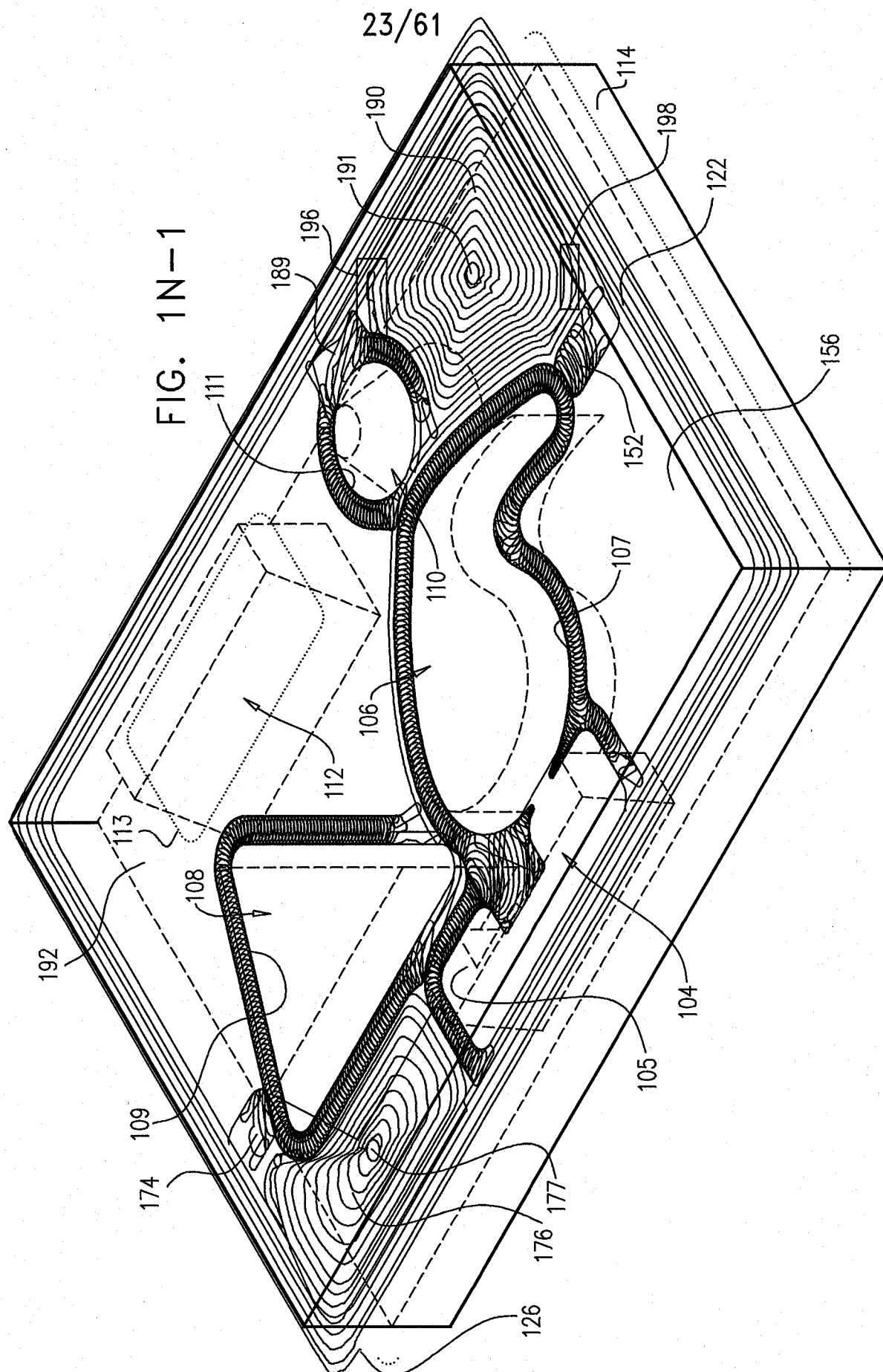
20/61



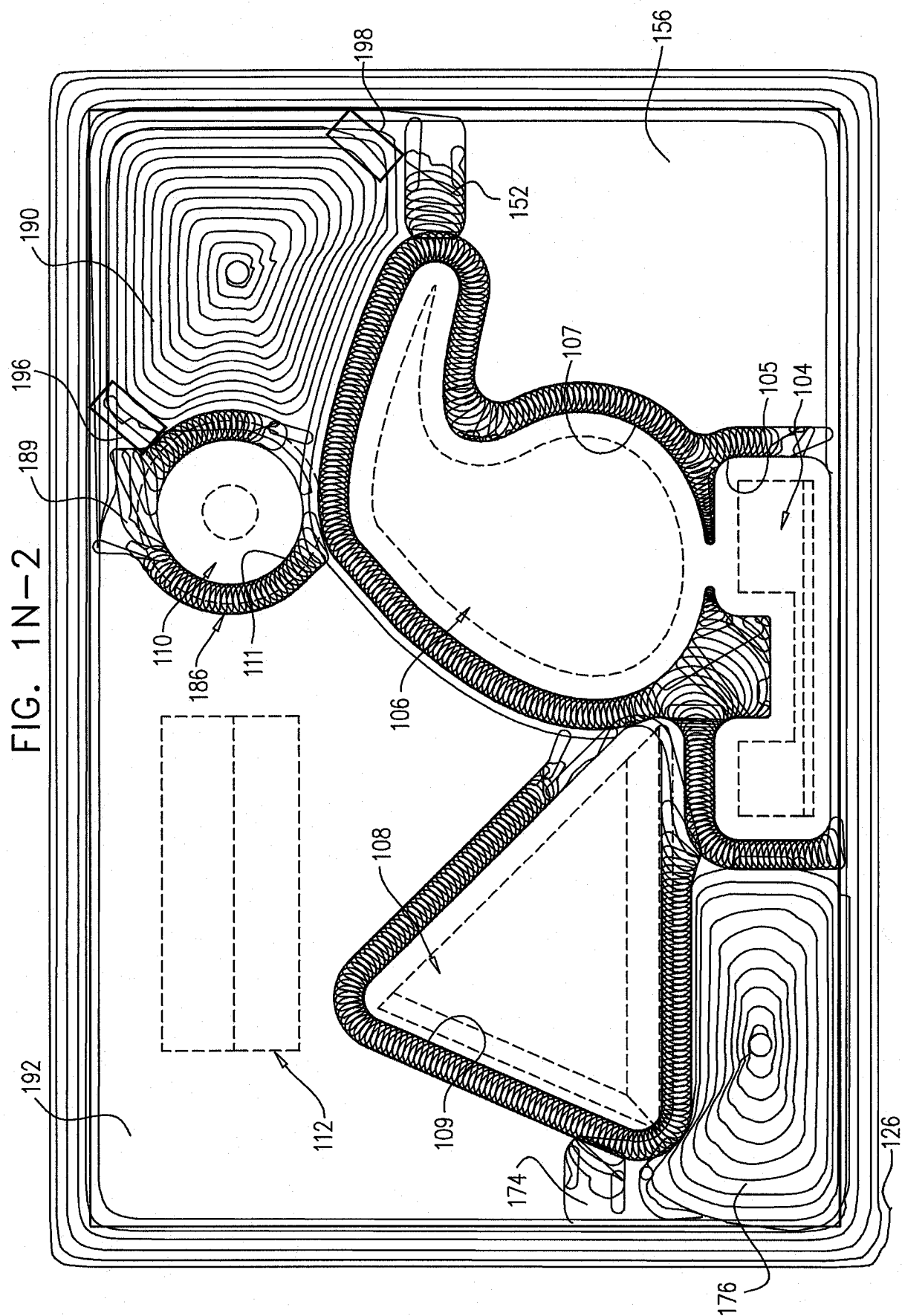


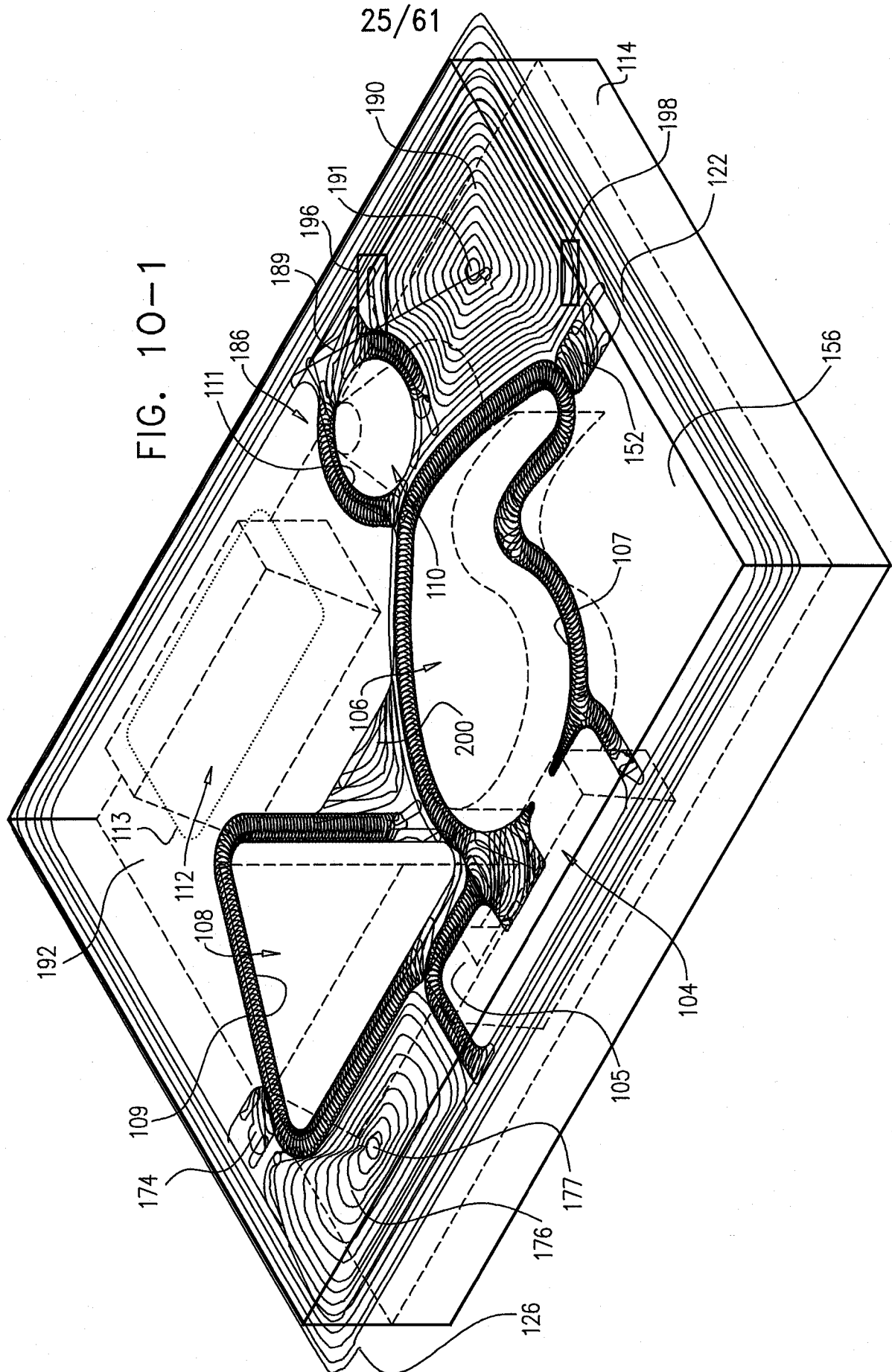
22/61



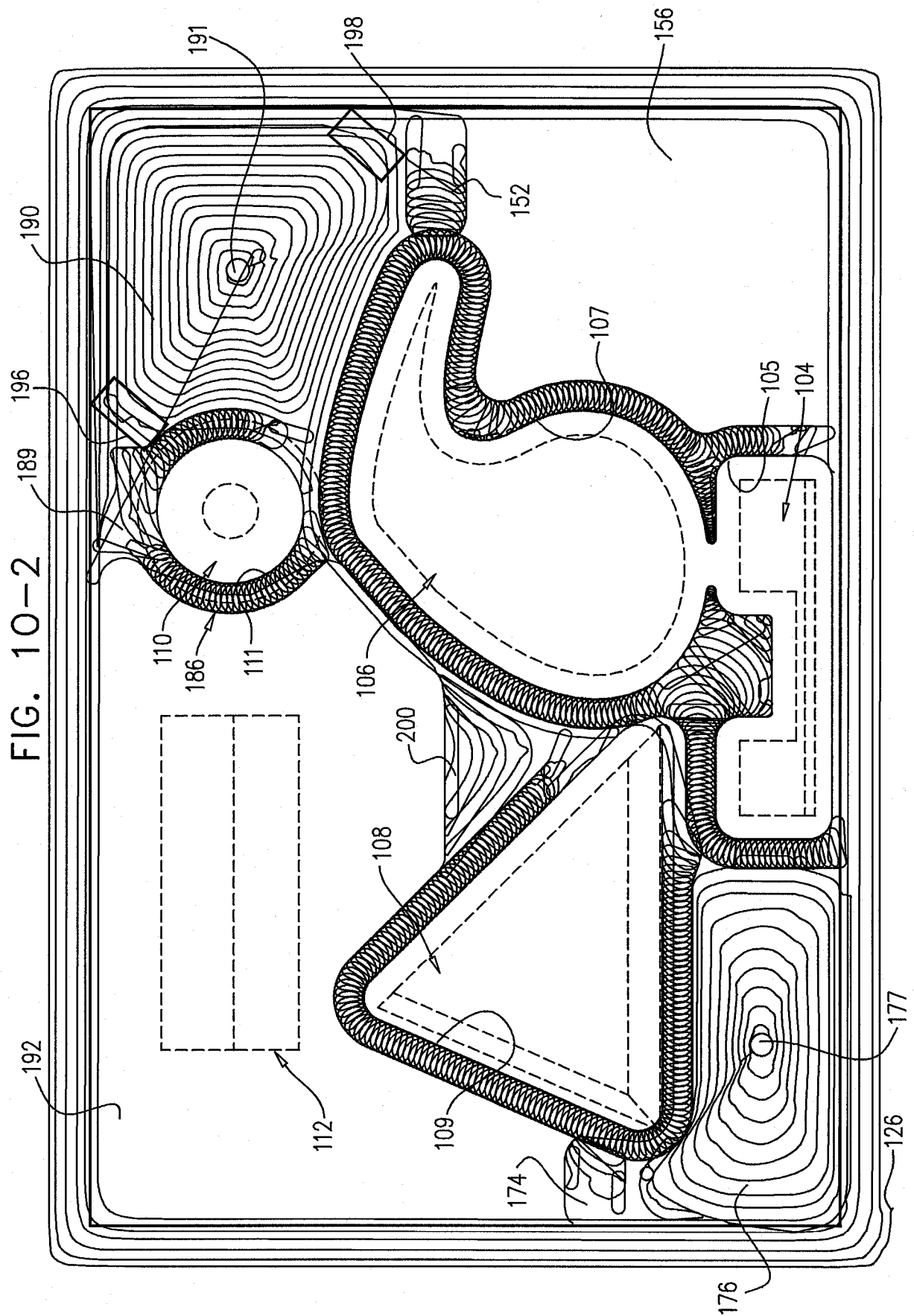


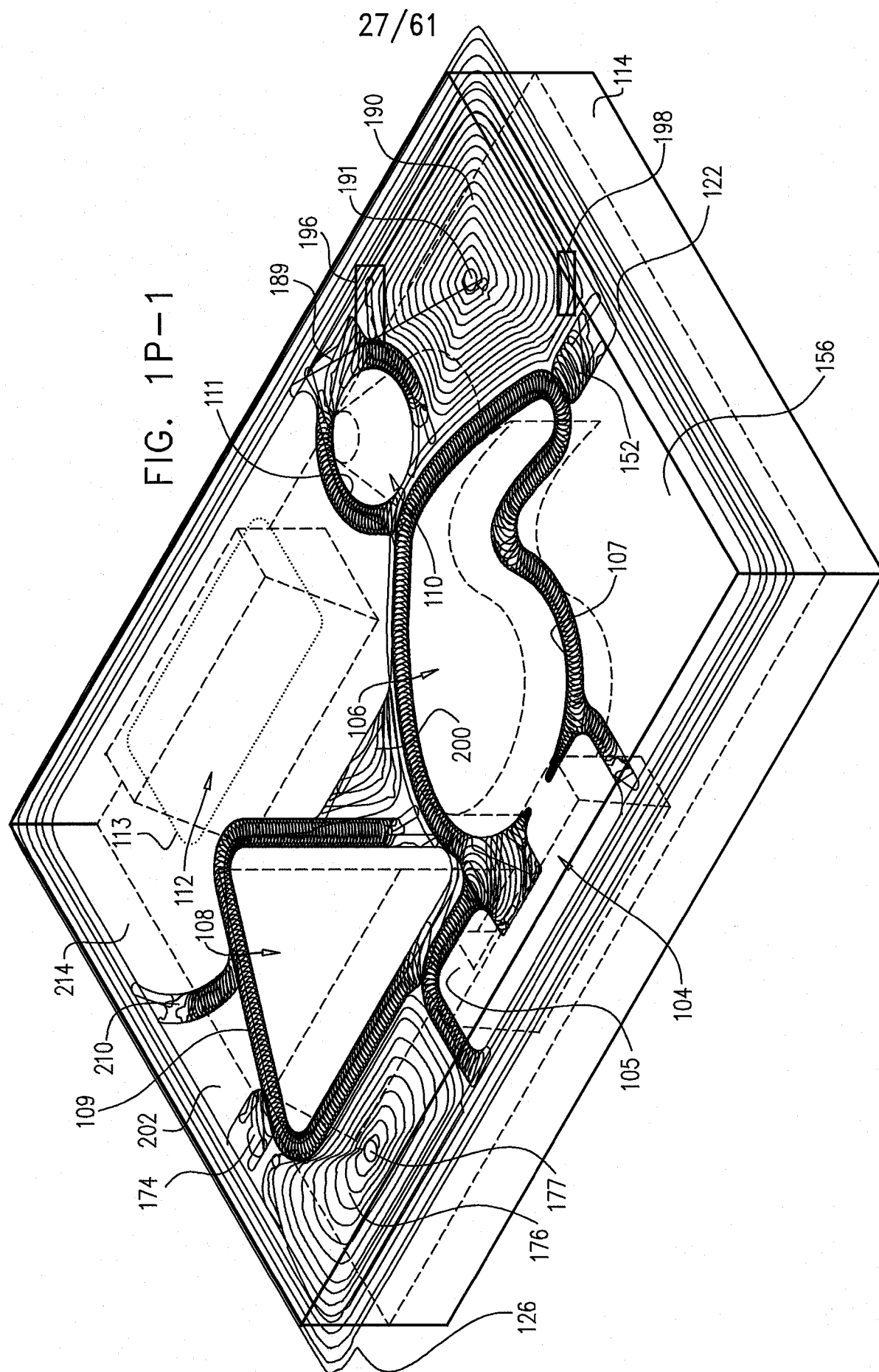
24/61

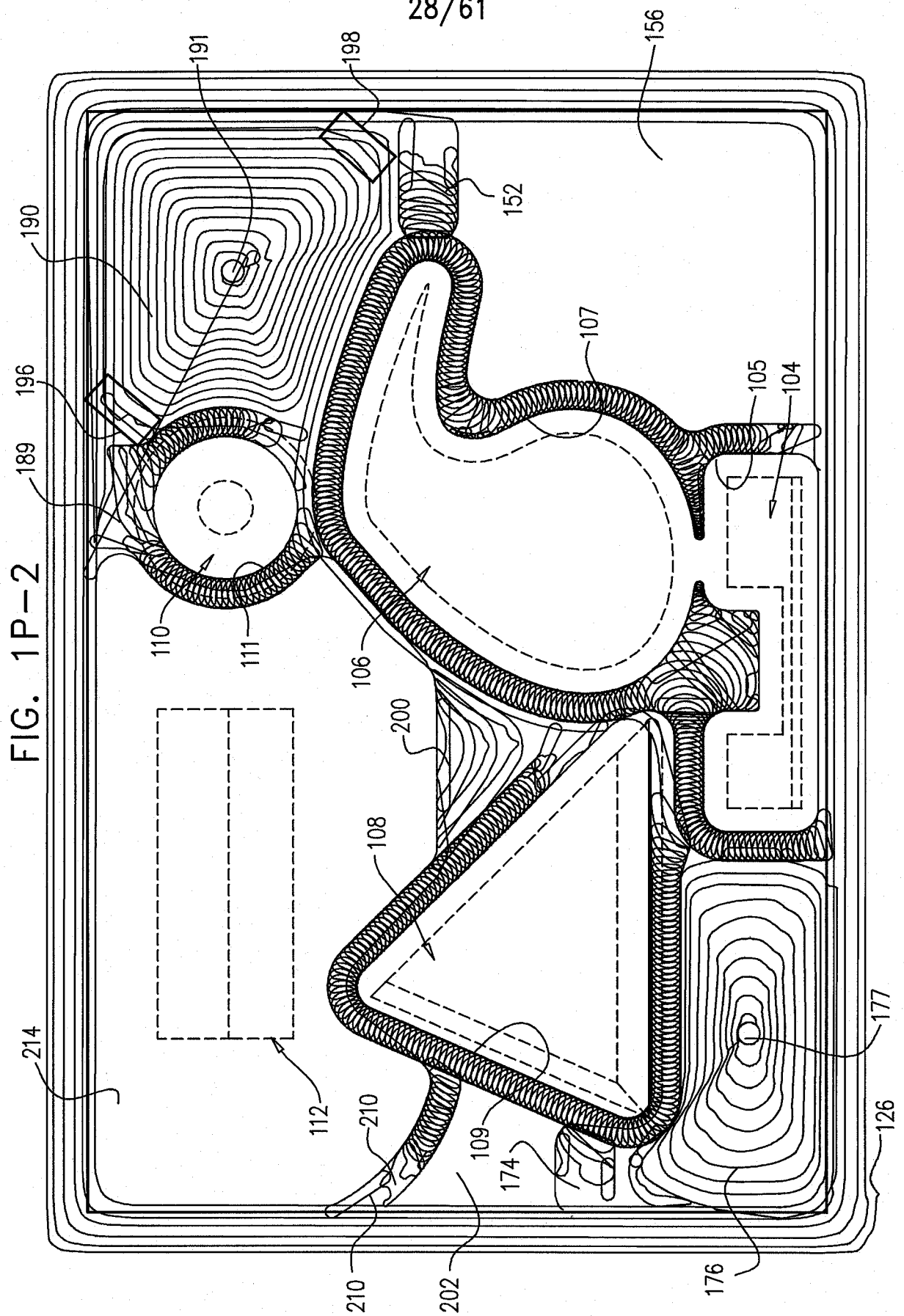


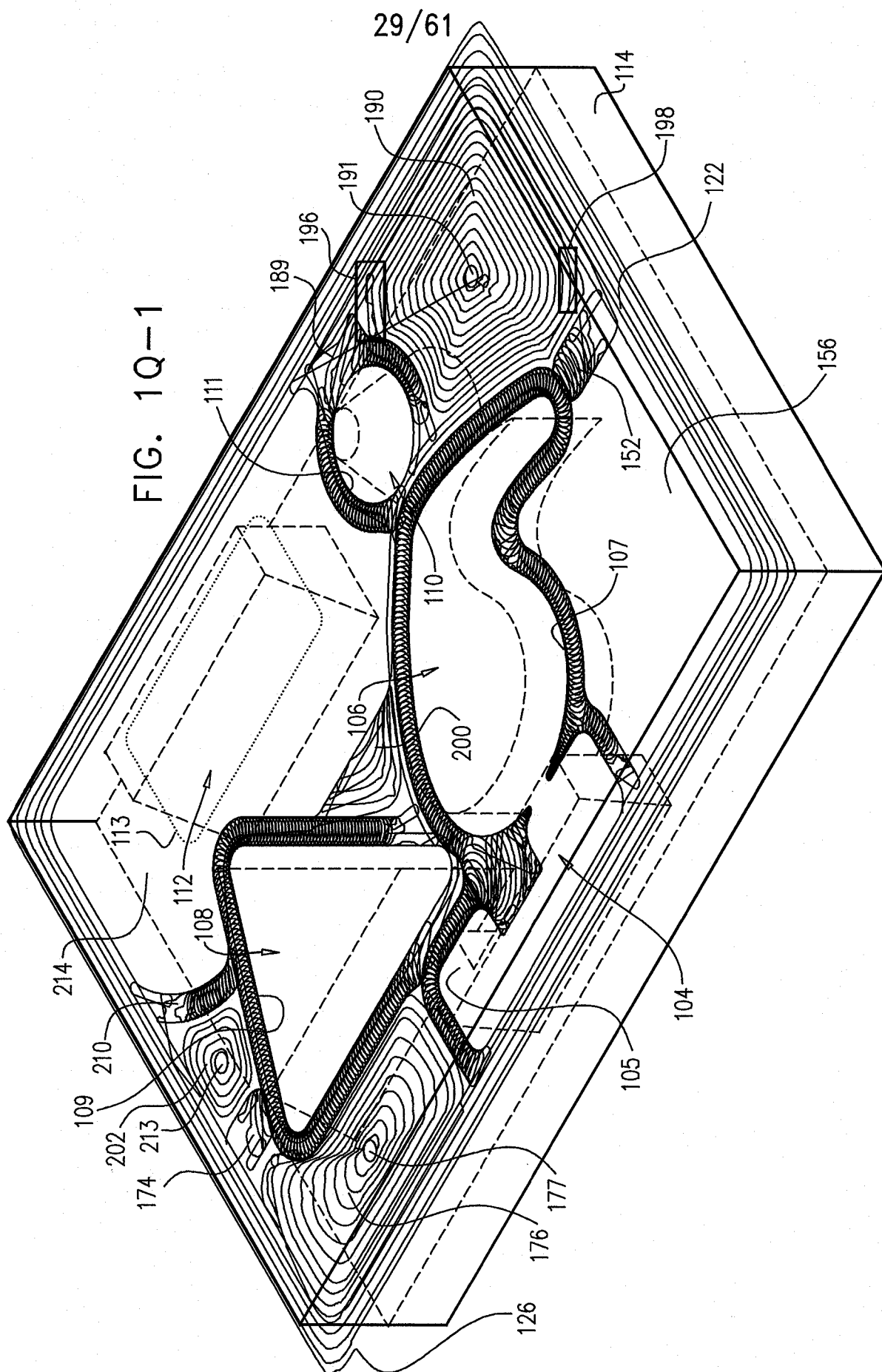


26/61

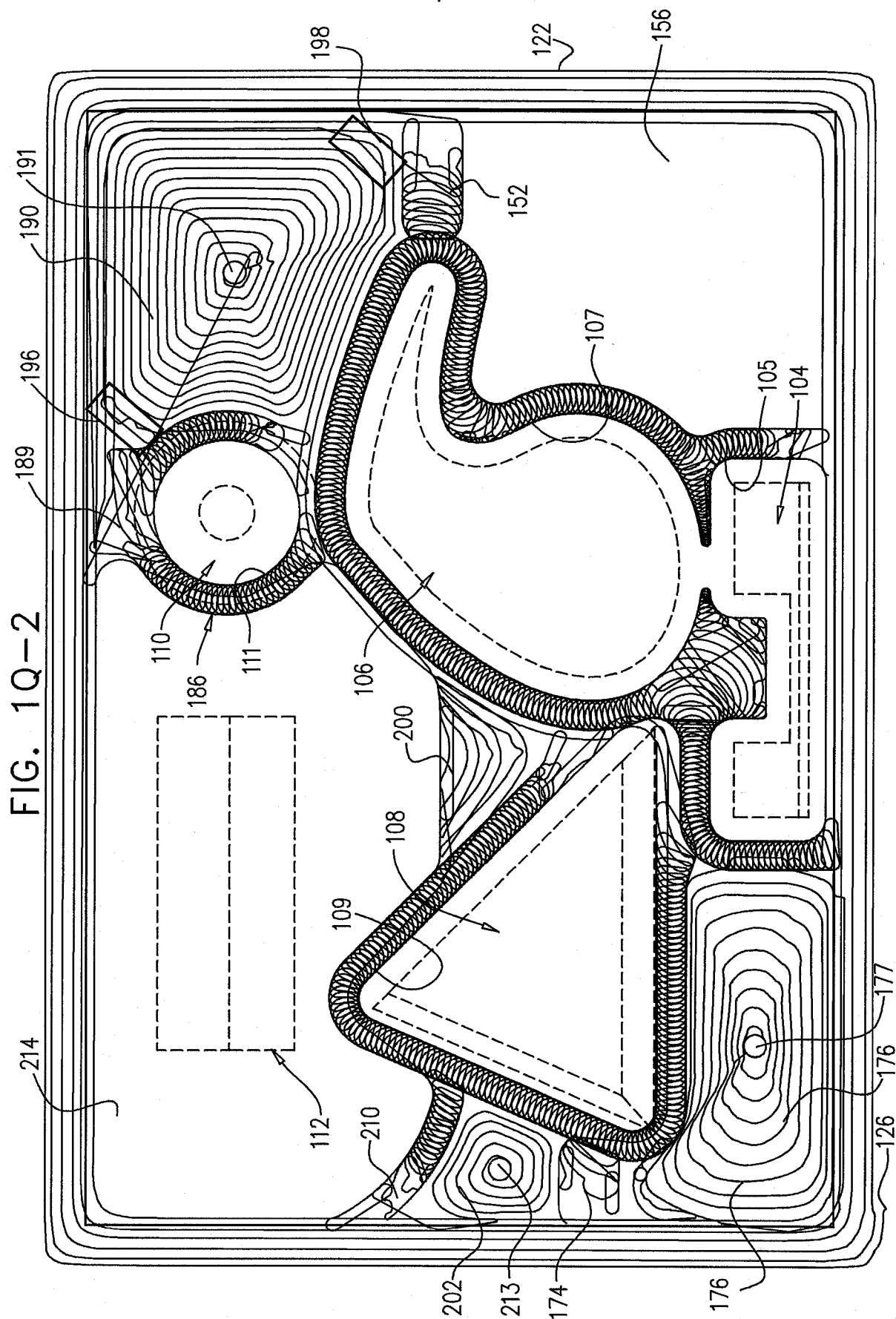


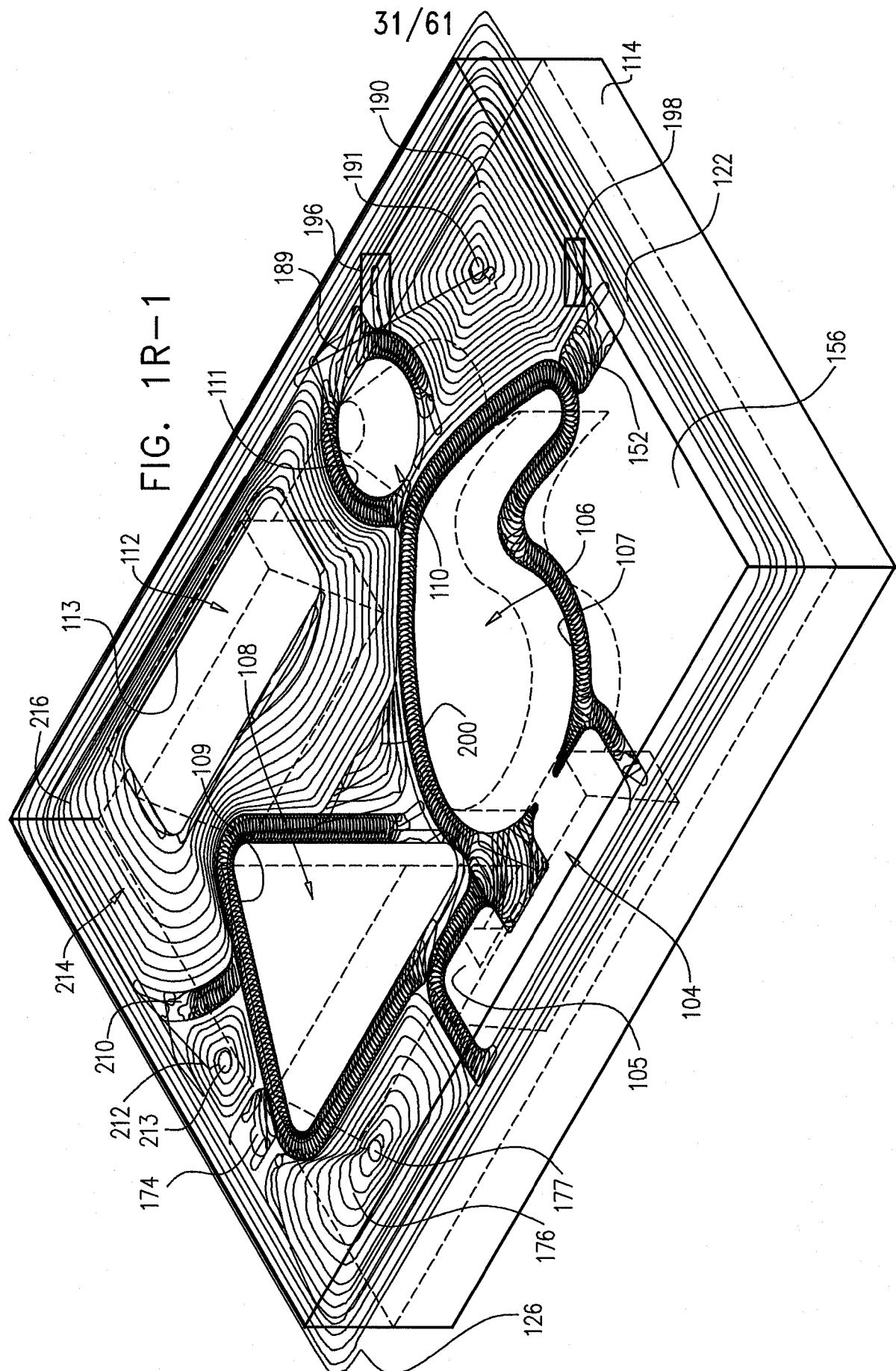




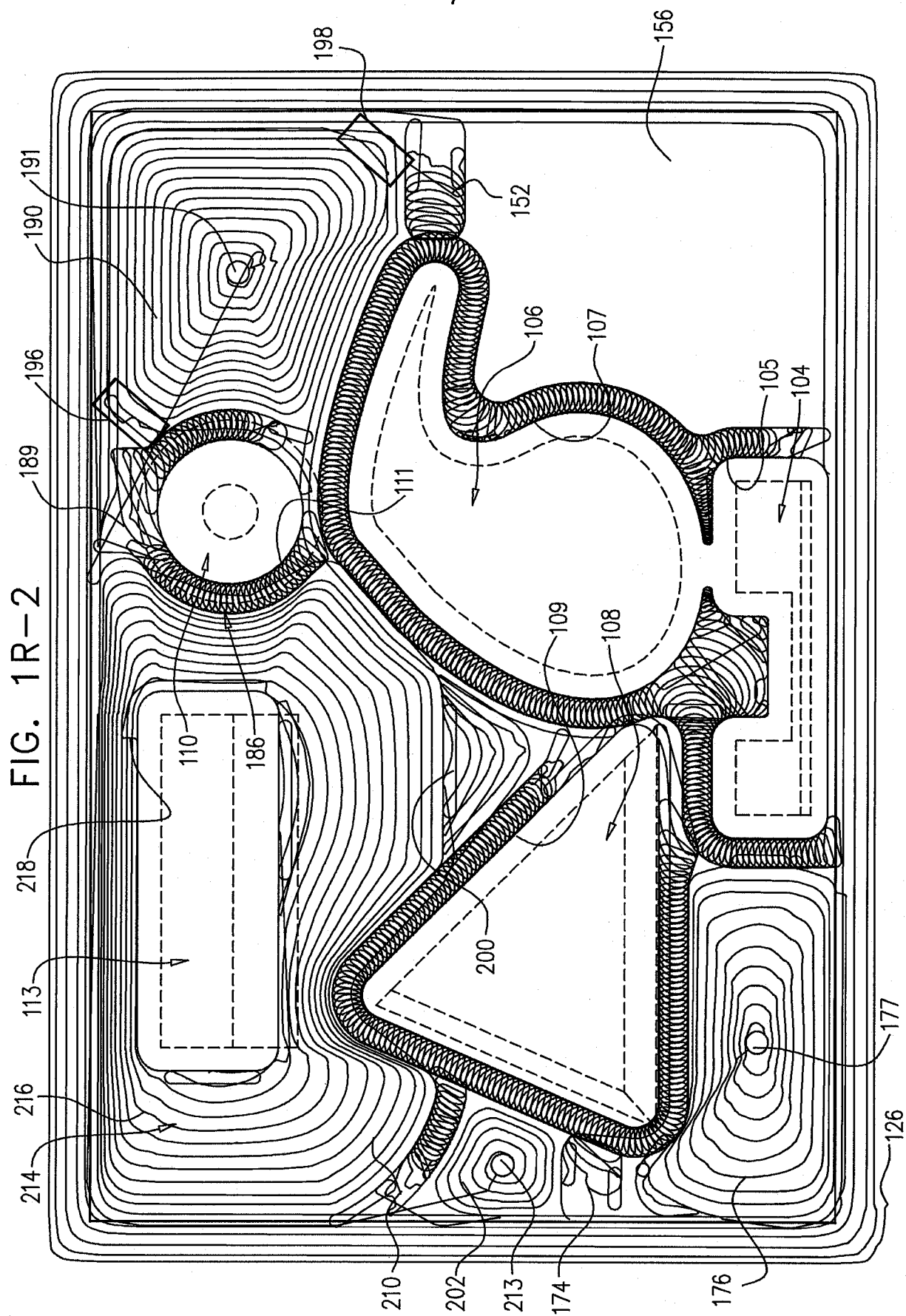


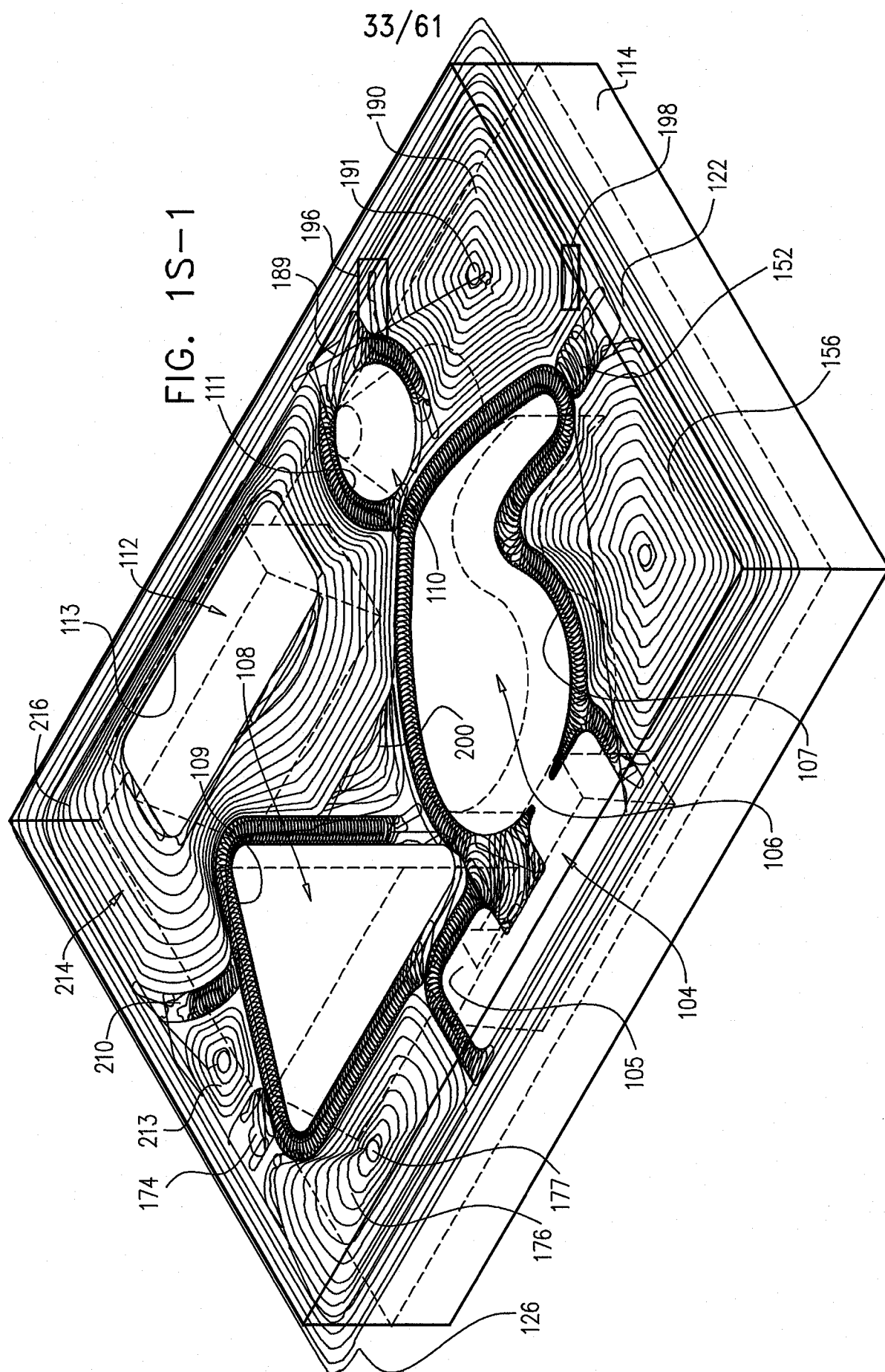
30/61

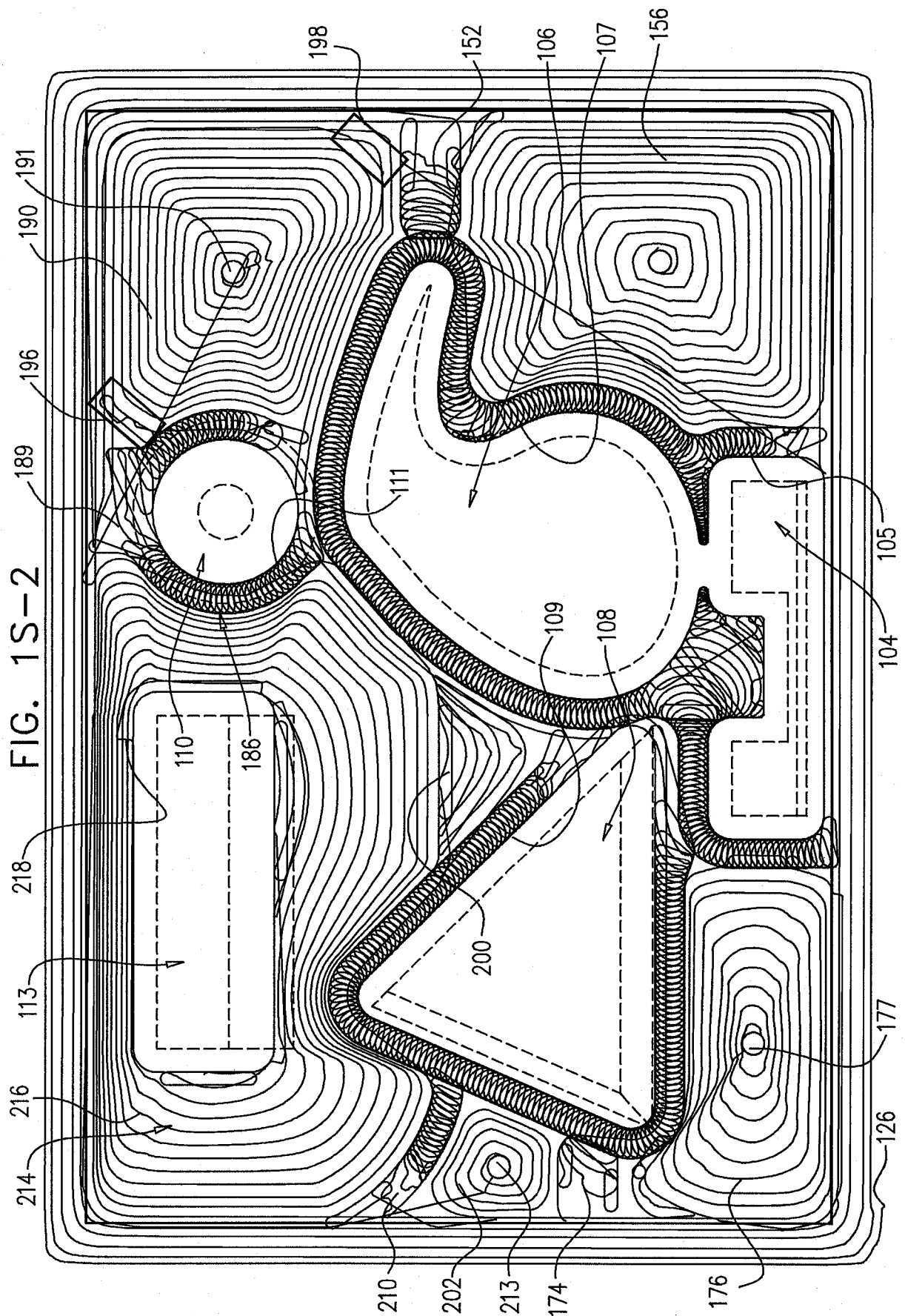




32/61

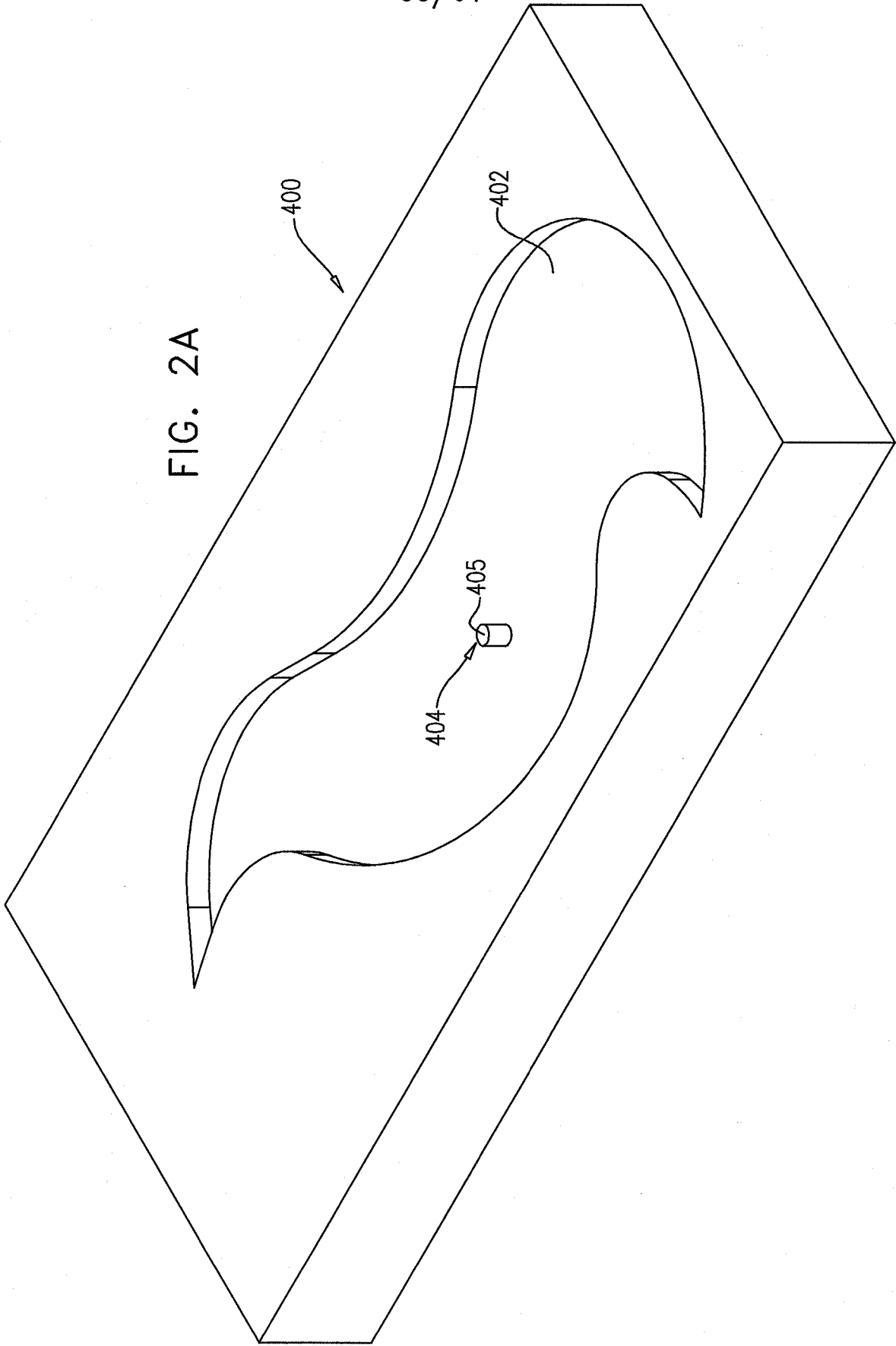






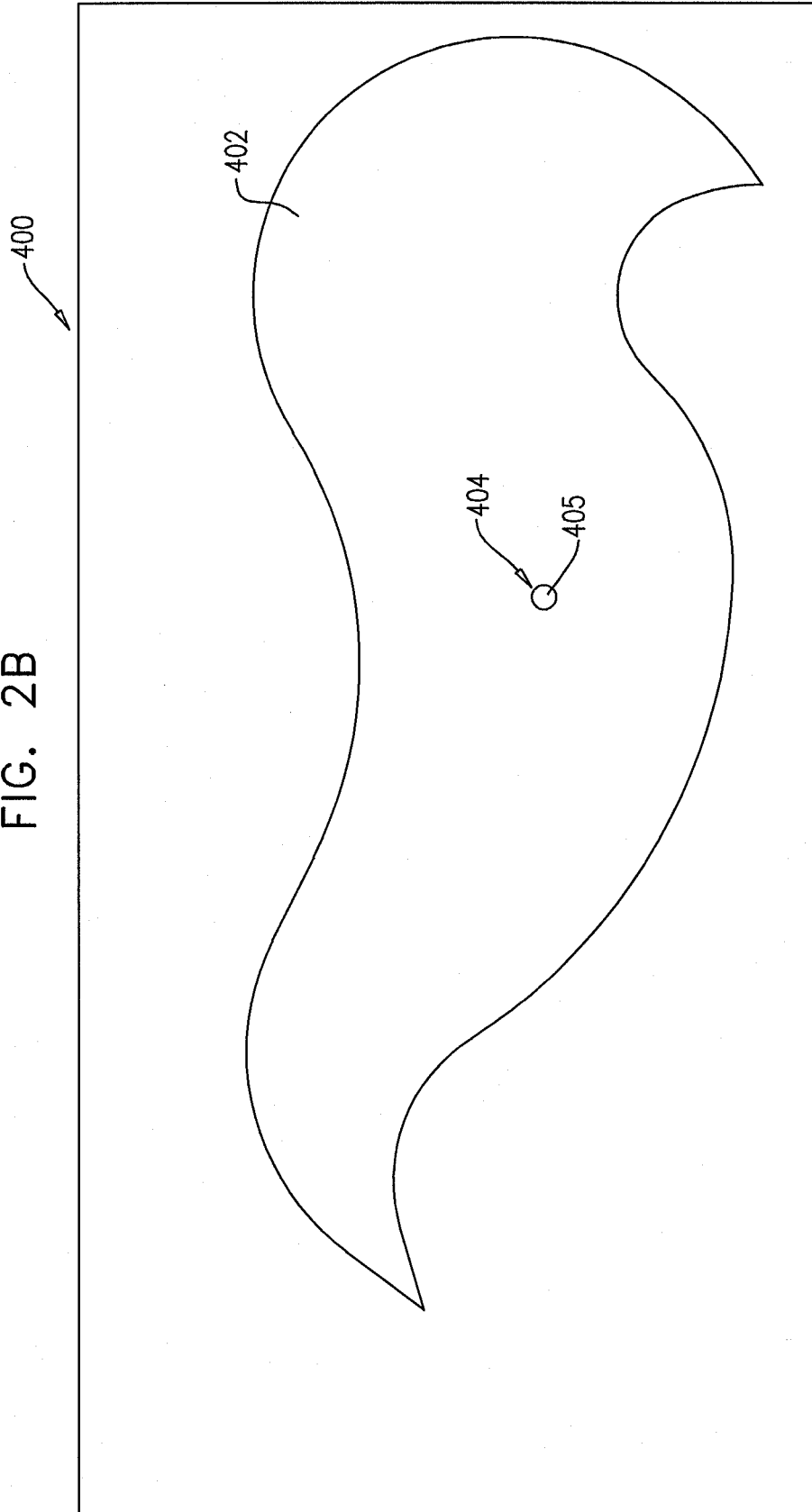
35/61

FIG. 2A



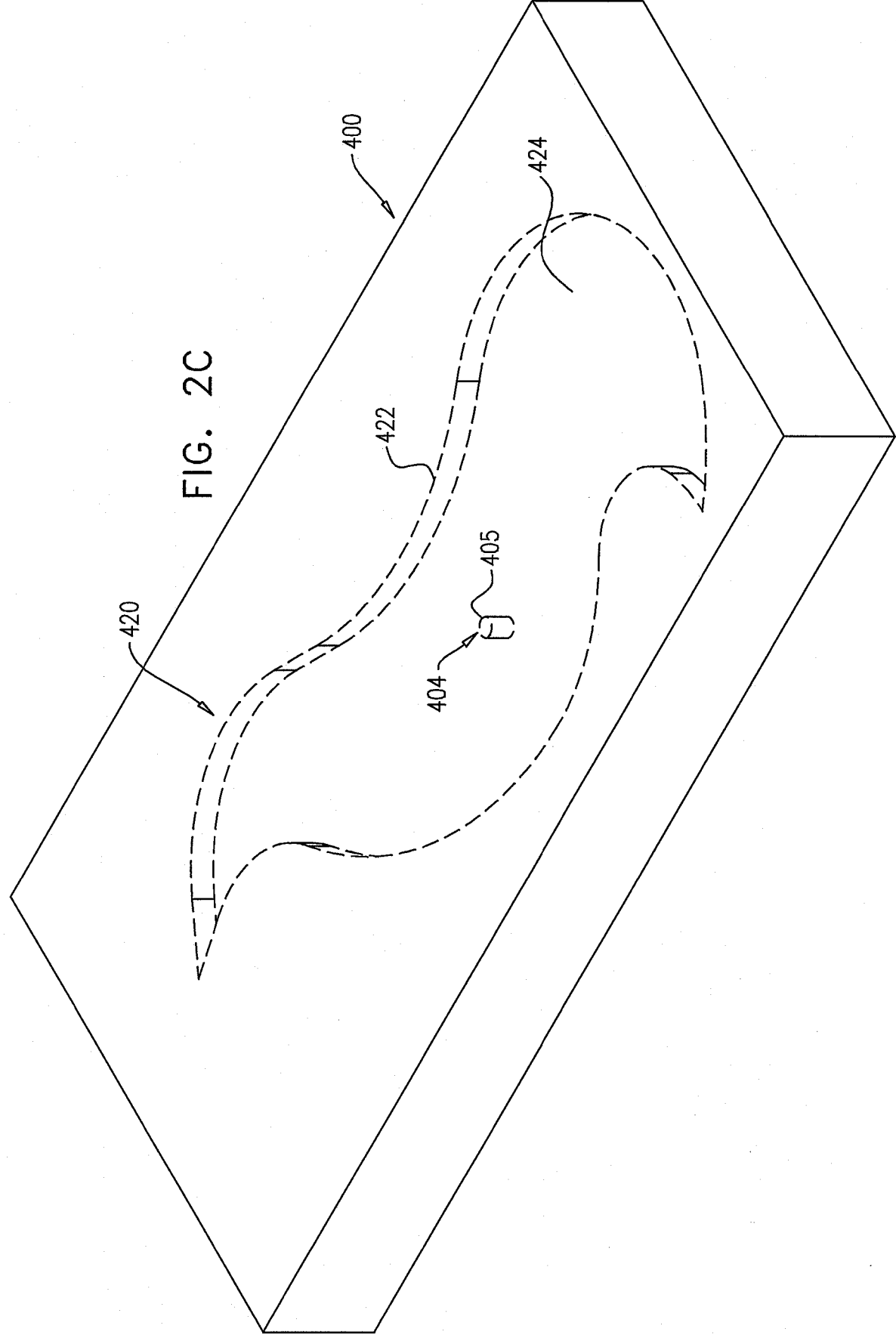
36/61

FIG. 2B



37/61

FIG. 2C



38/61

FIG. 2D-1

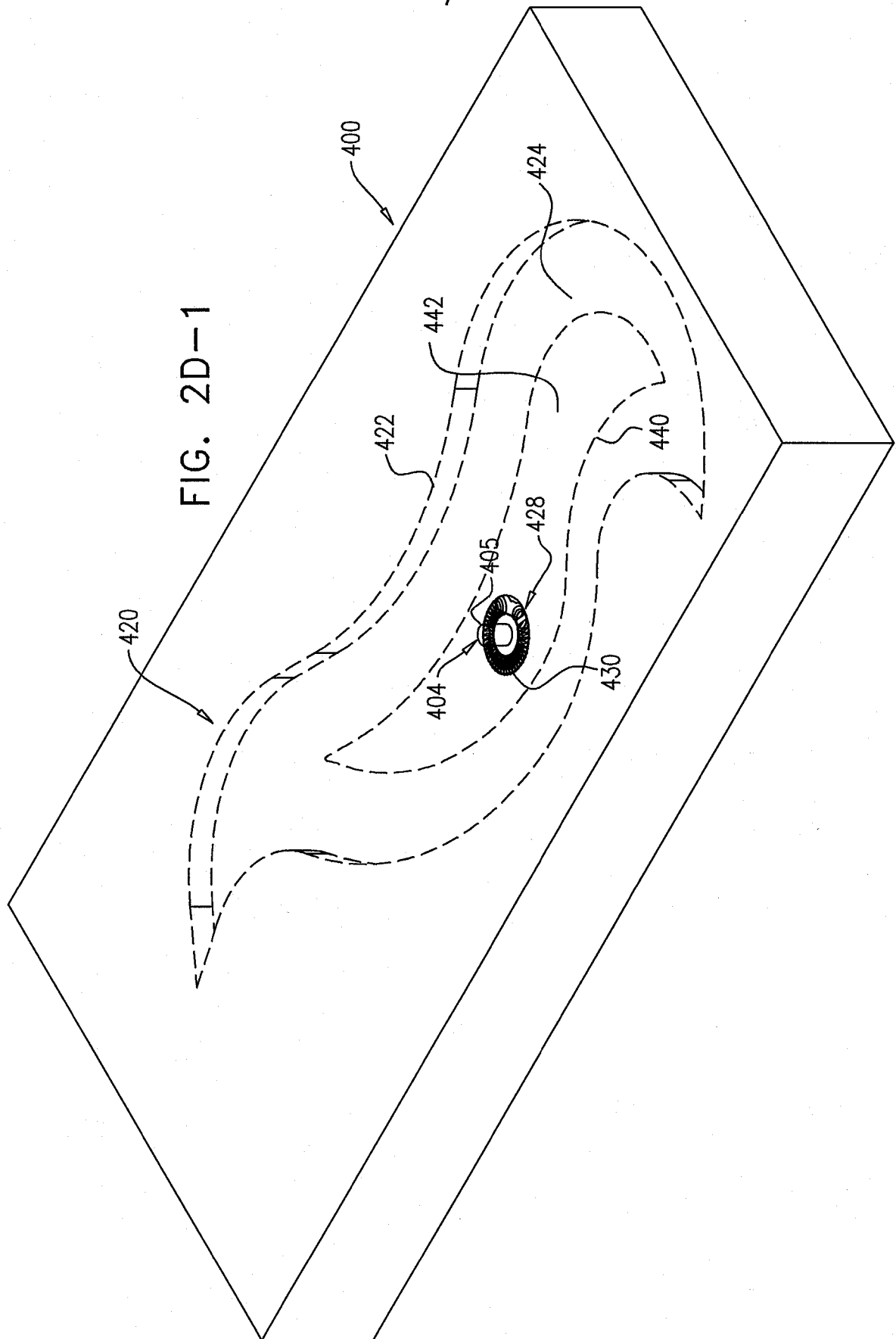
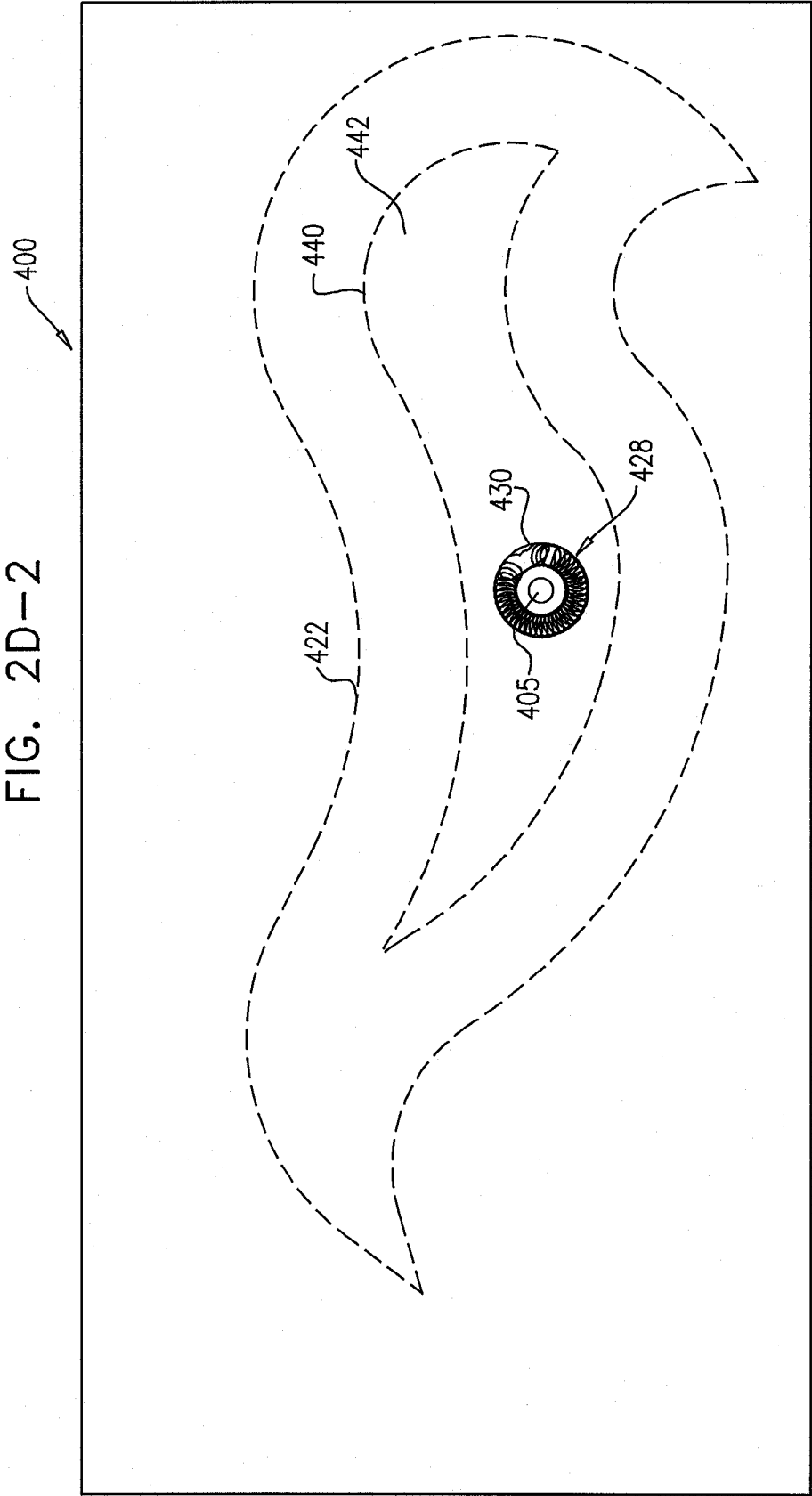
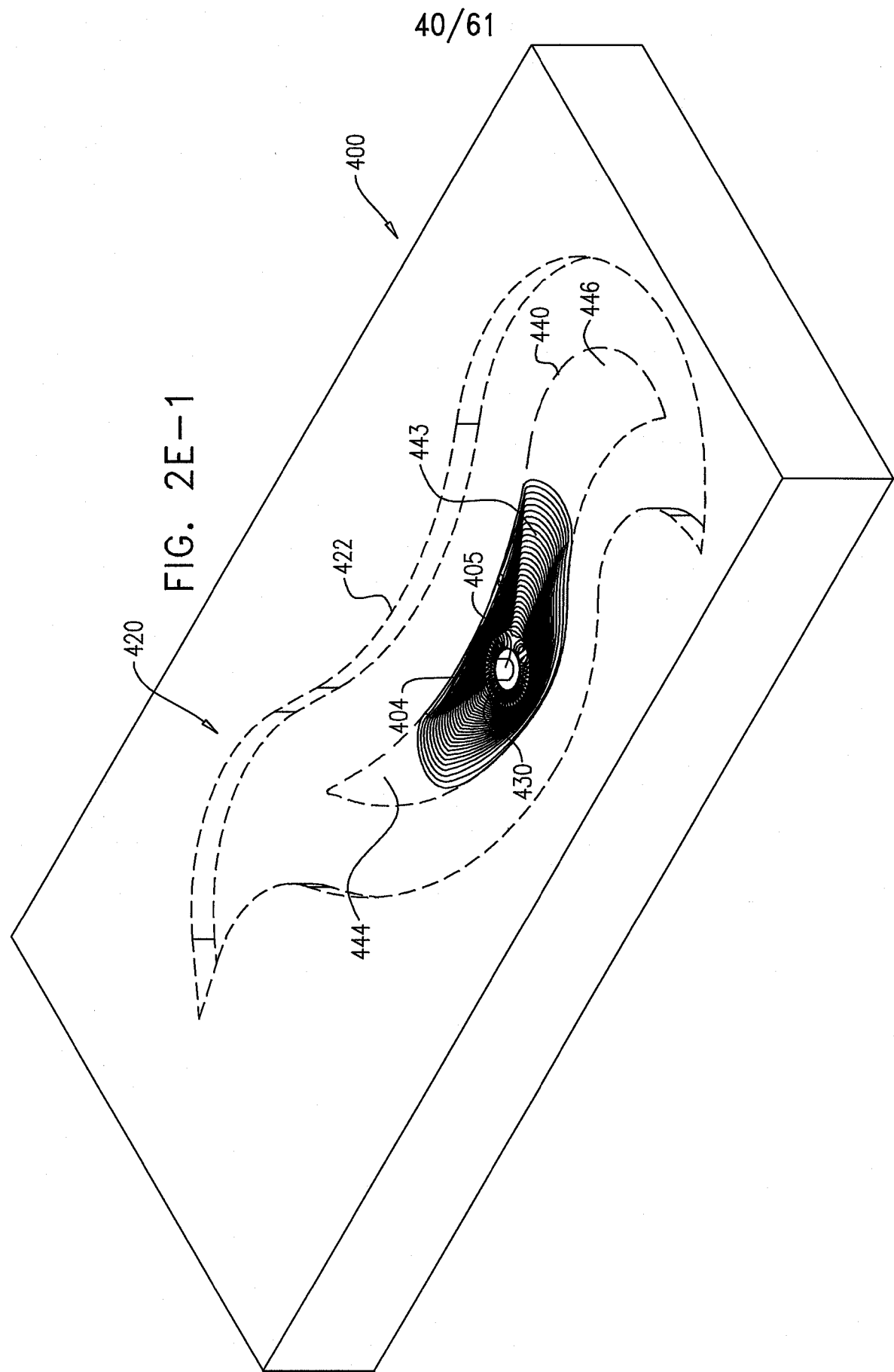


FIG. 2D-2





41/61

FIG. 2E-2

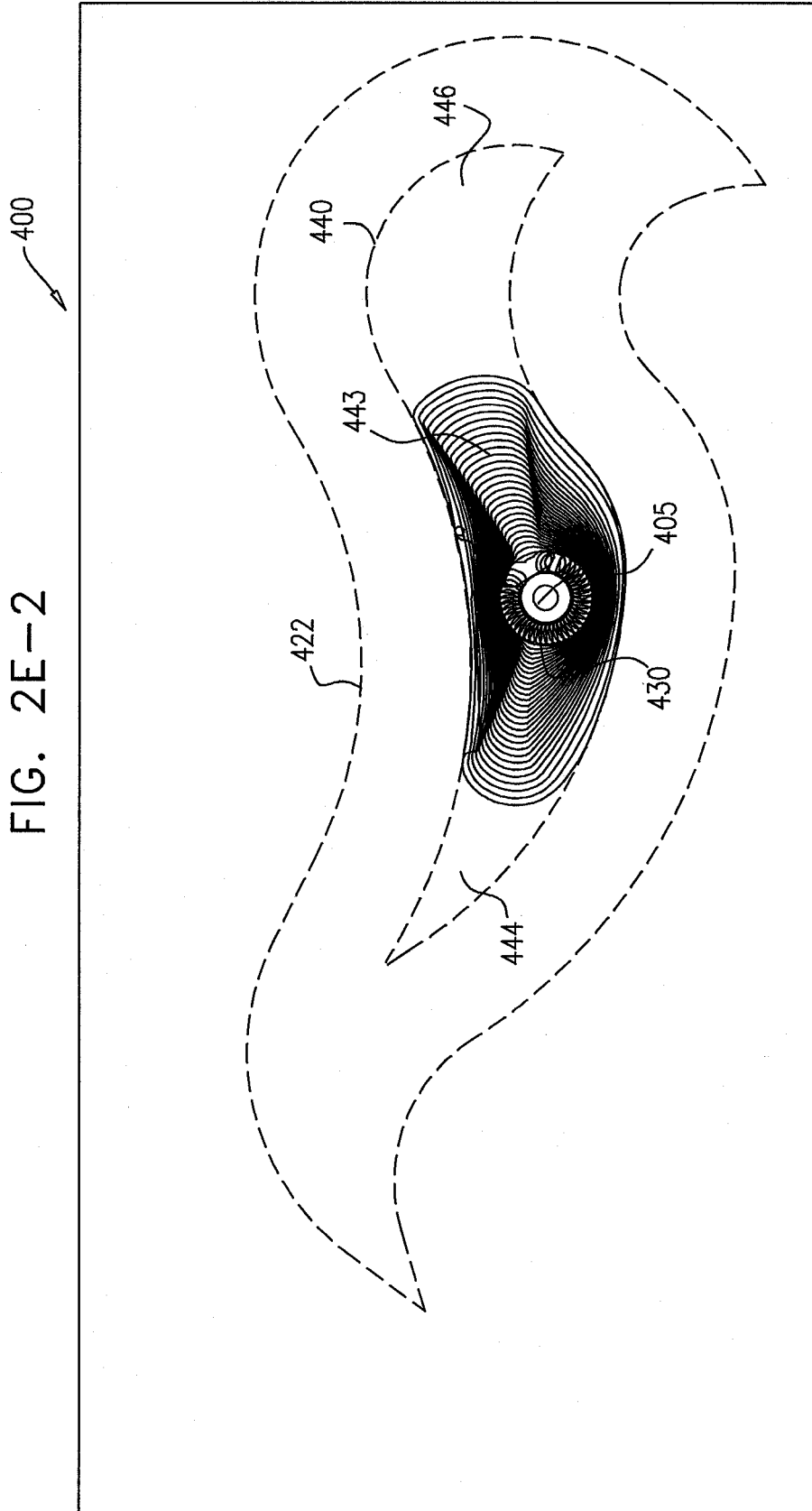


FIG. 2F-1

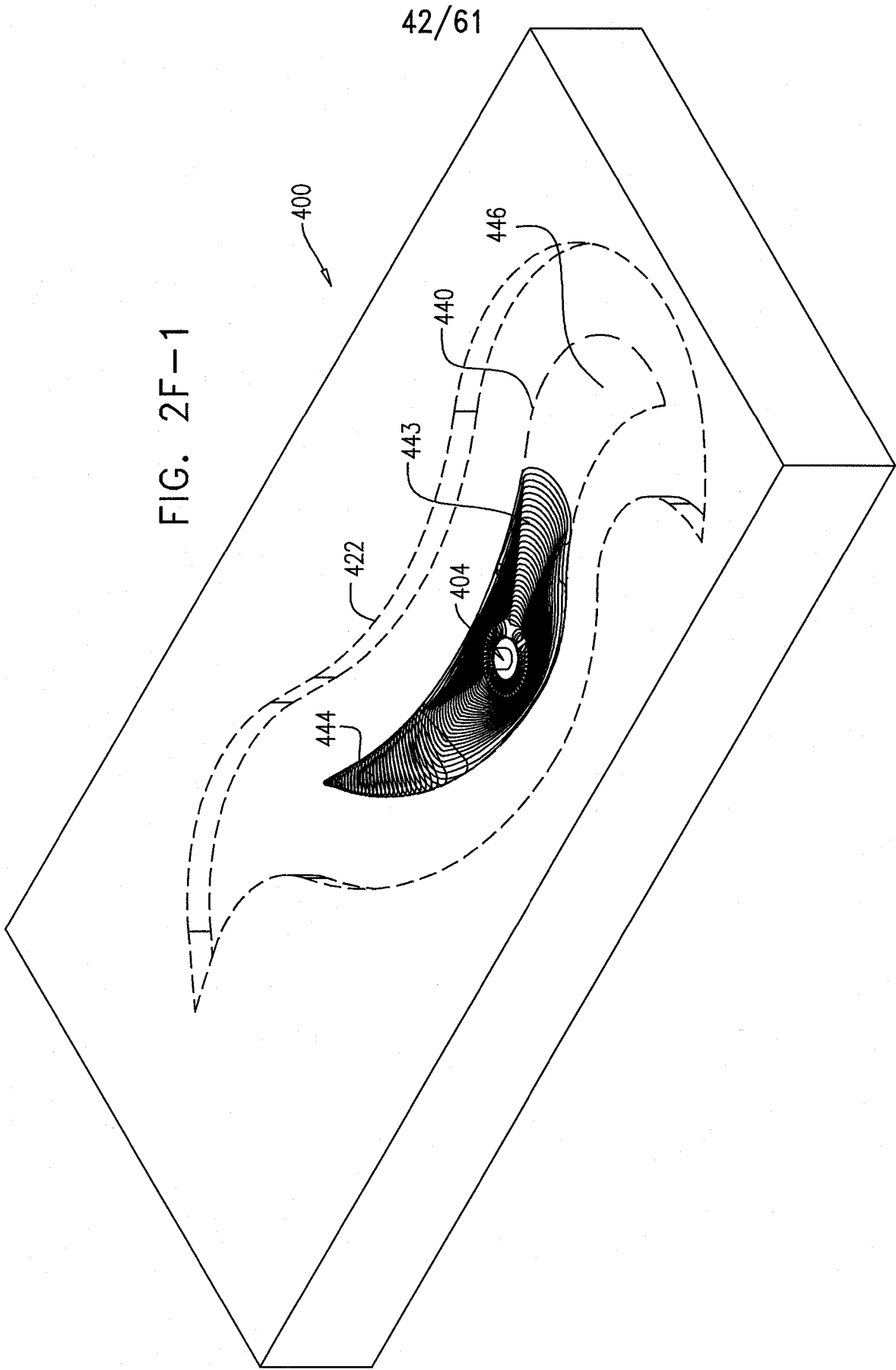


FIG. 2F--2

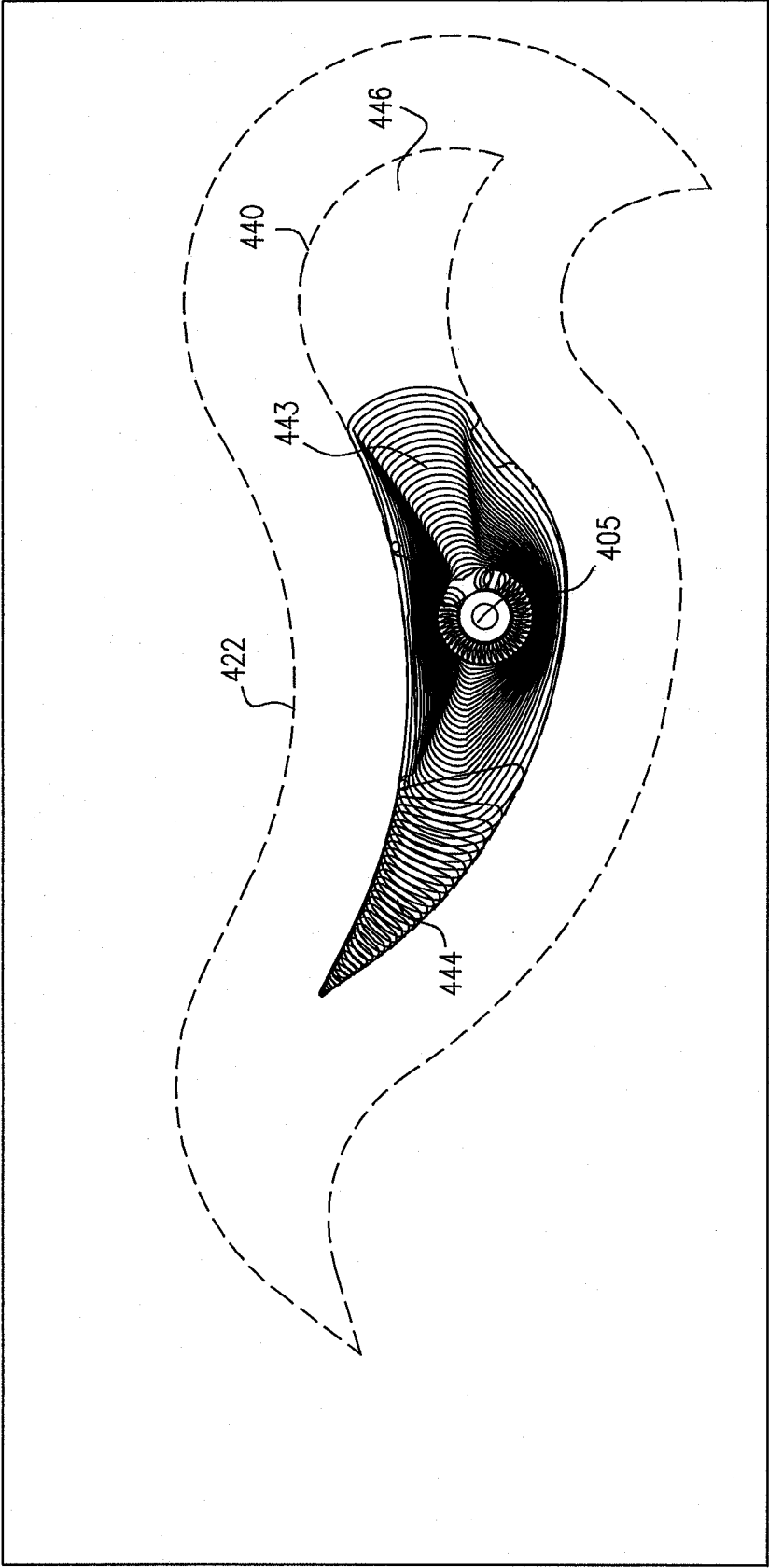
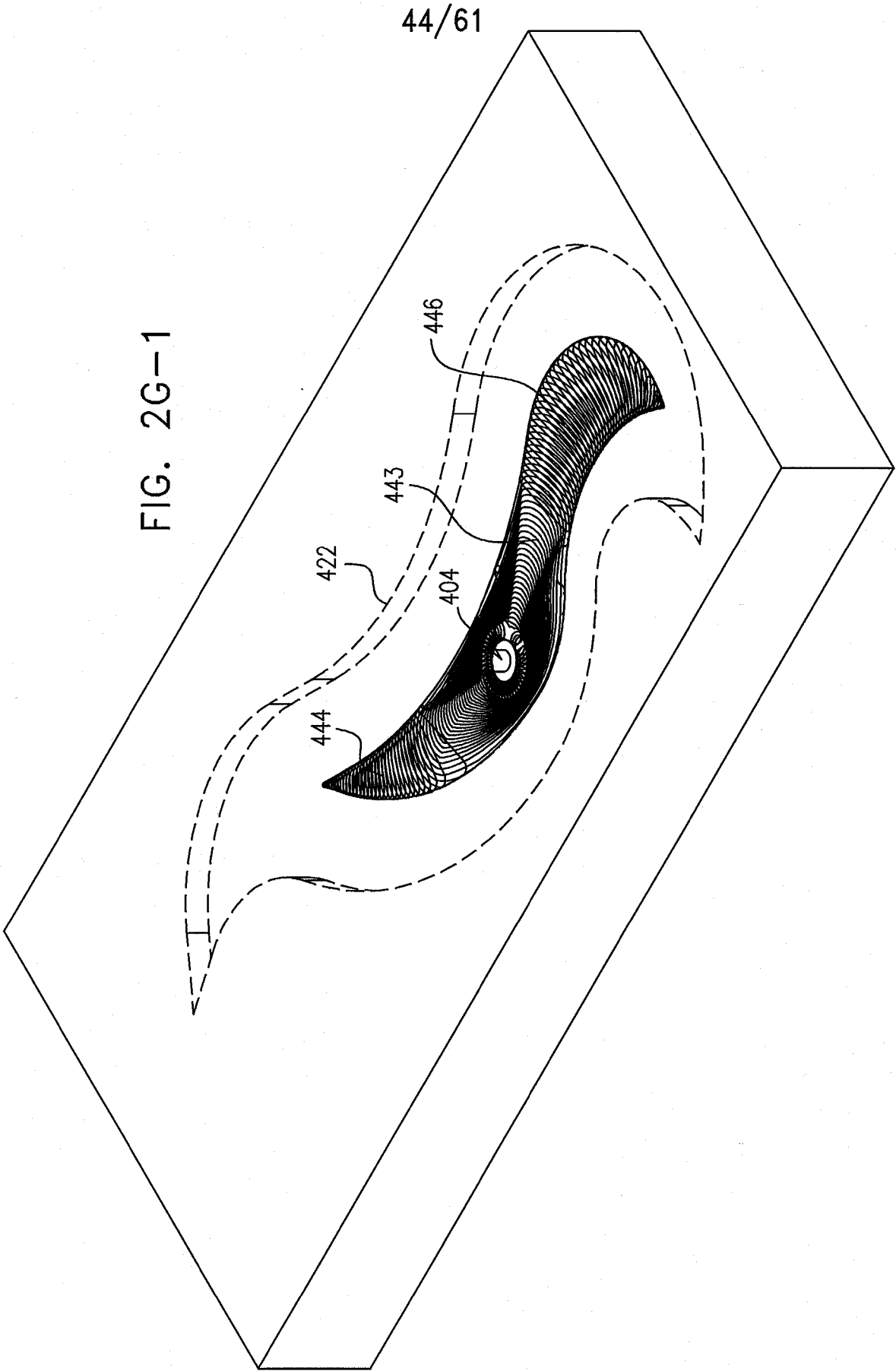


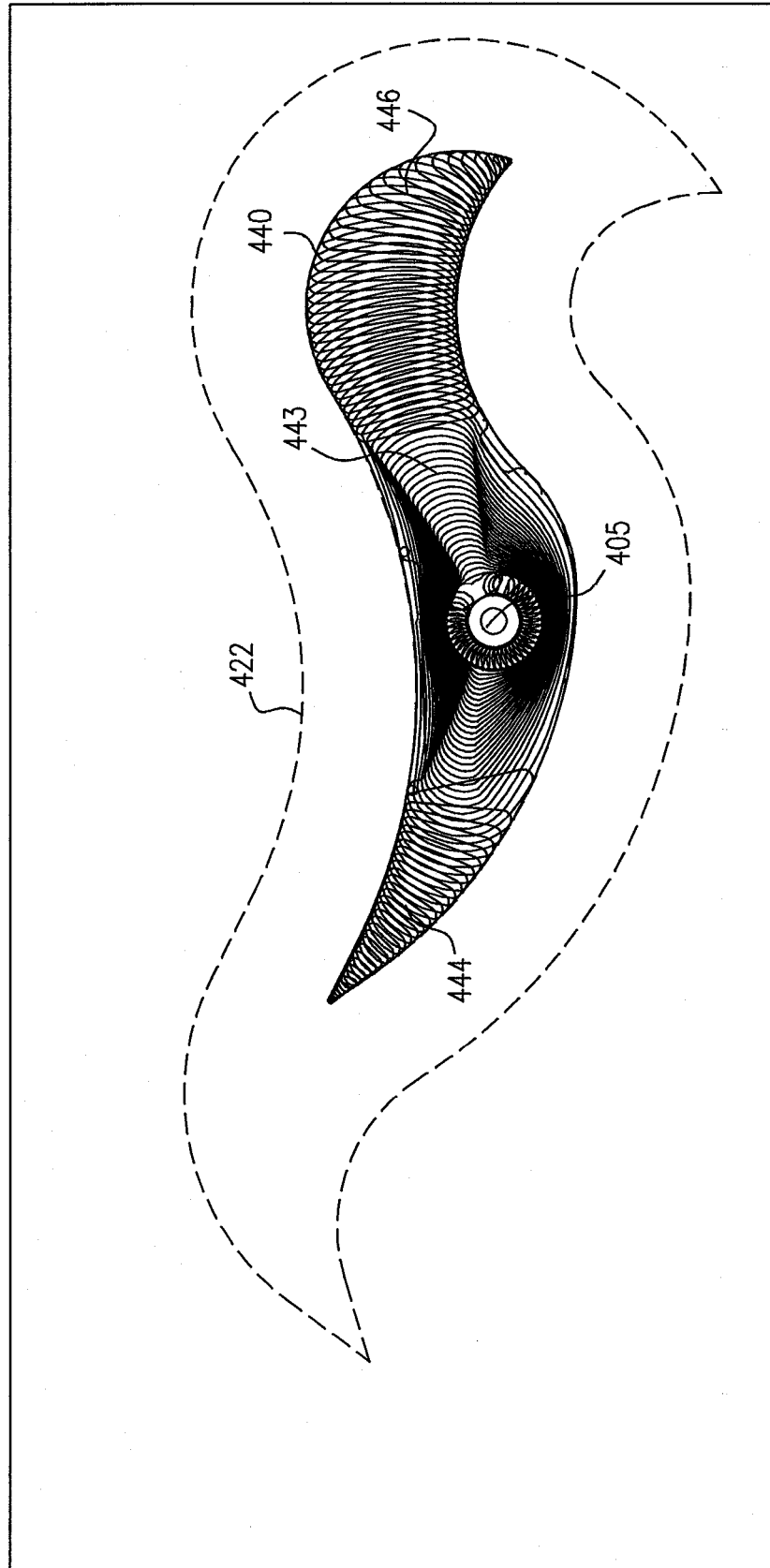
FIG. 2G-1



45/61

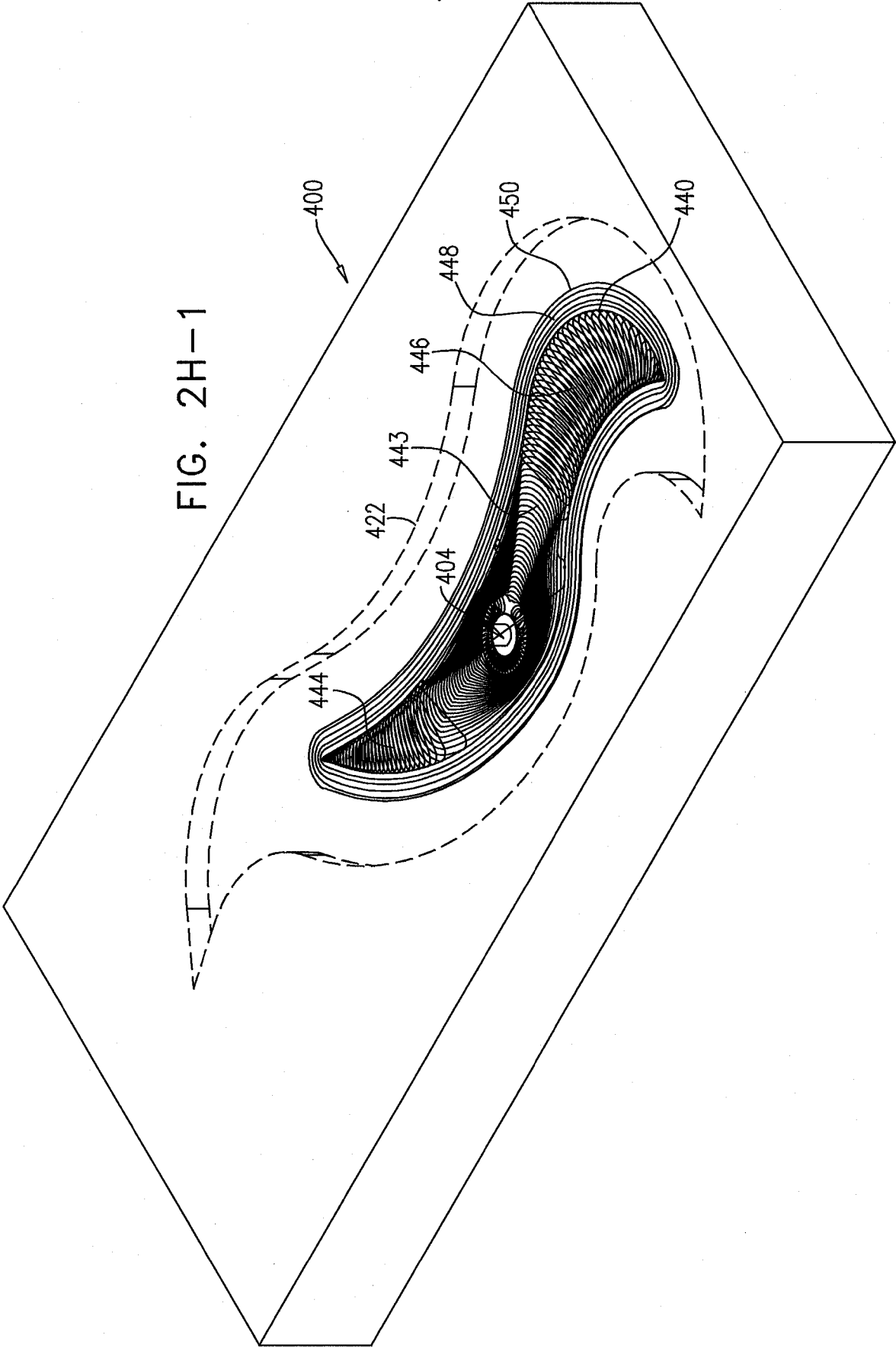
FIG. 2G-2

400



46/61

FIG. 2H-1



47/61

FIG. 2H-2

400

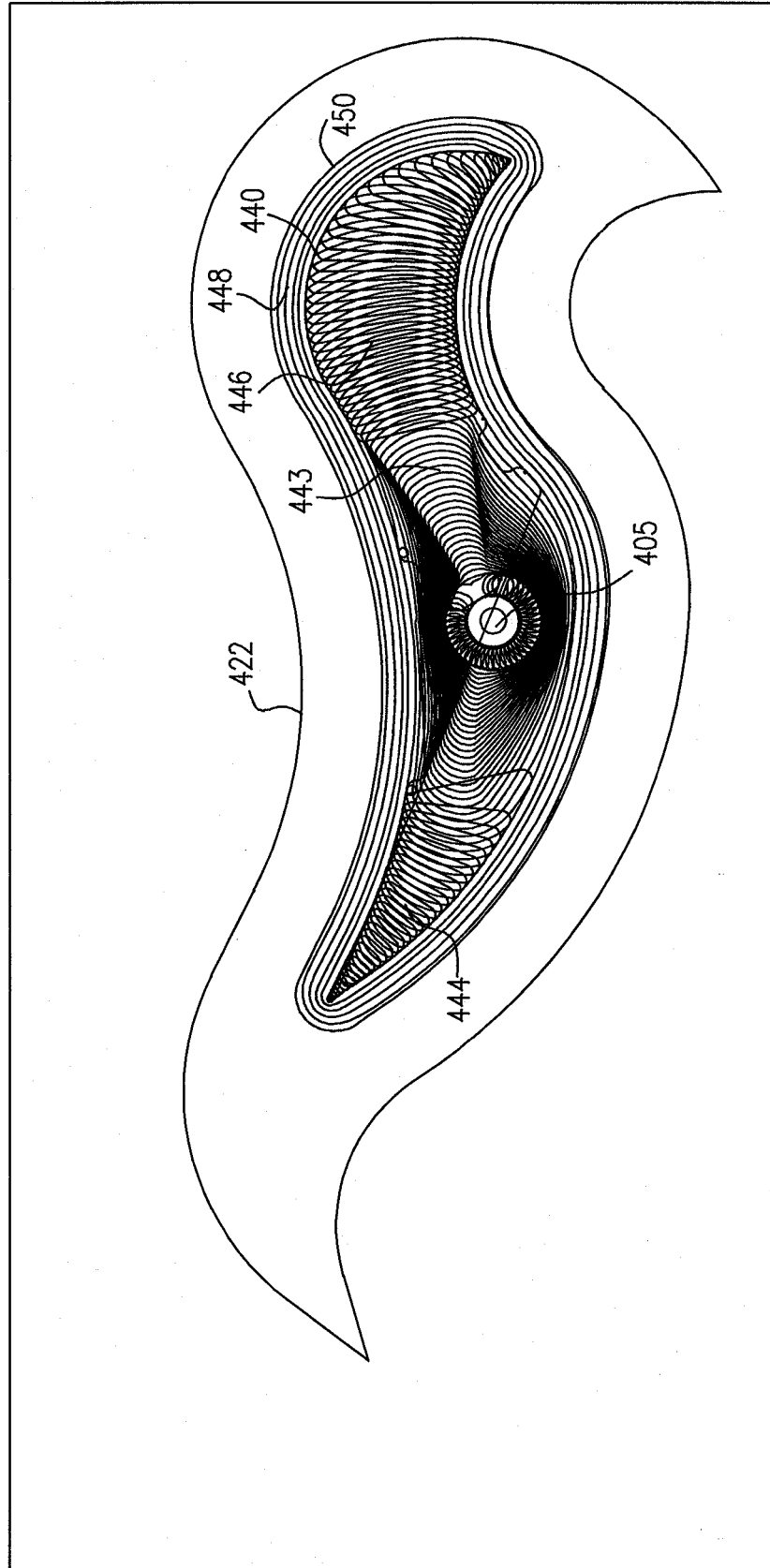
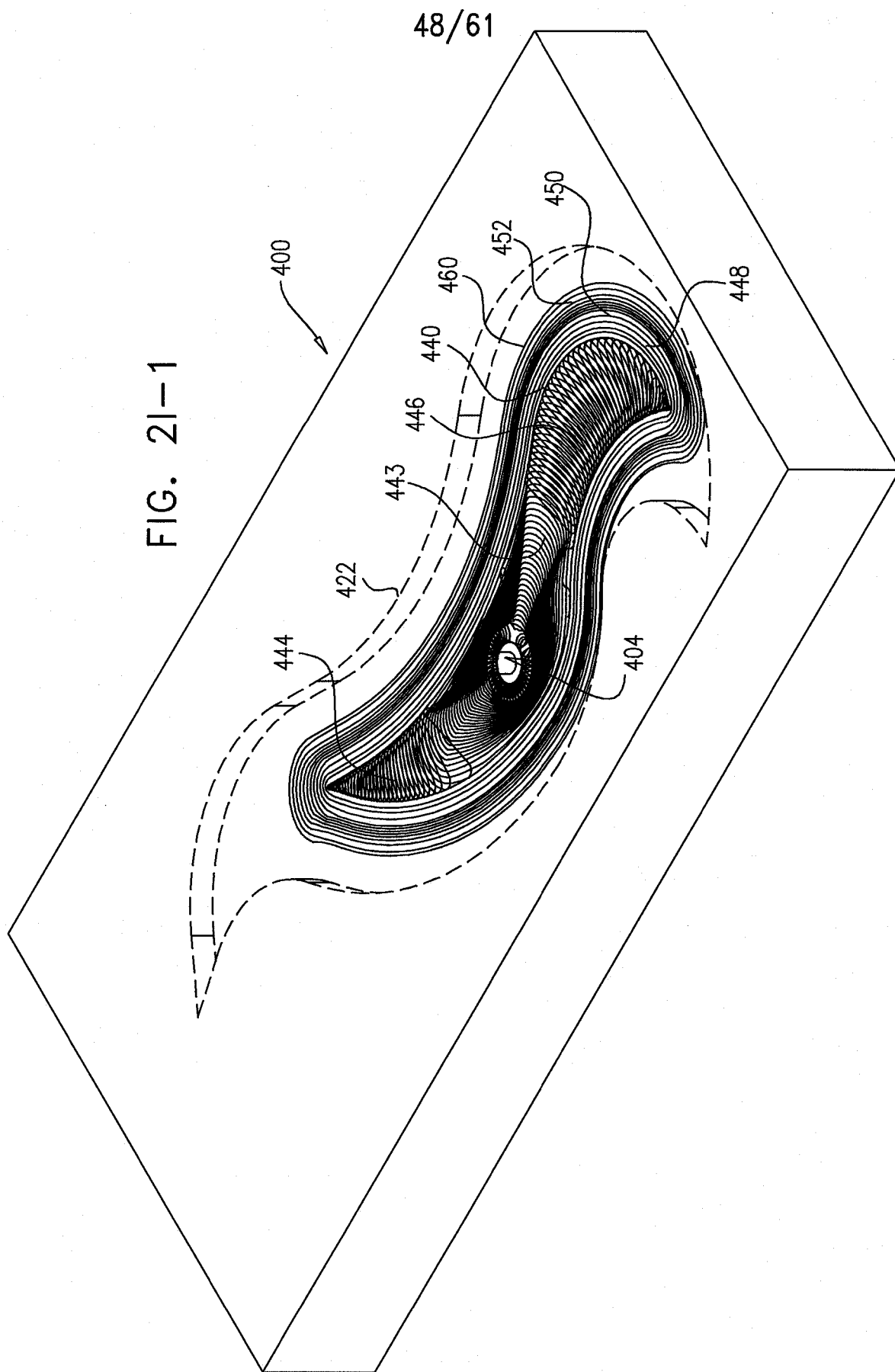


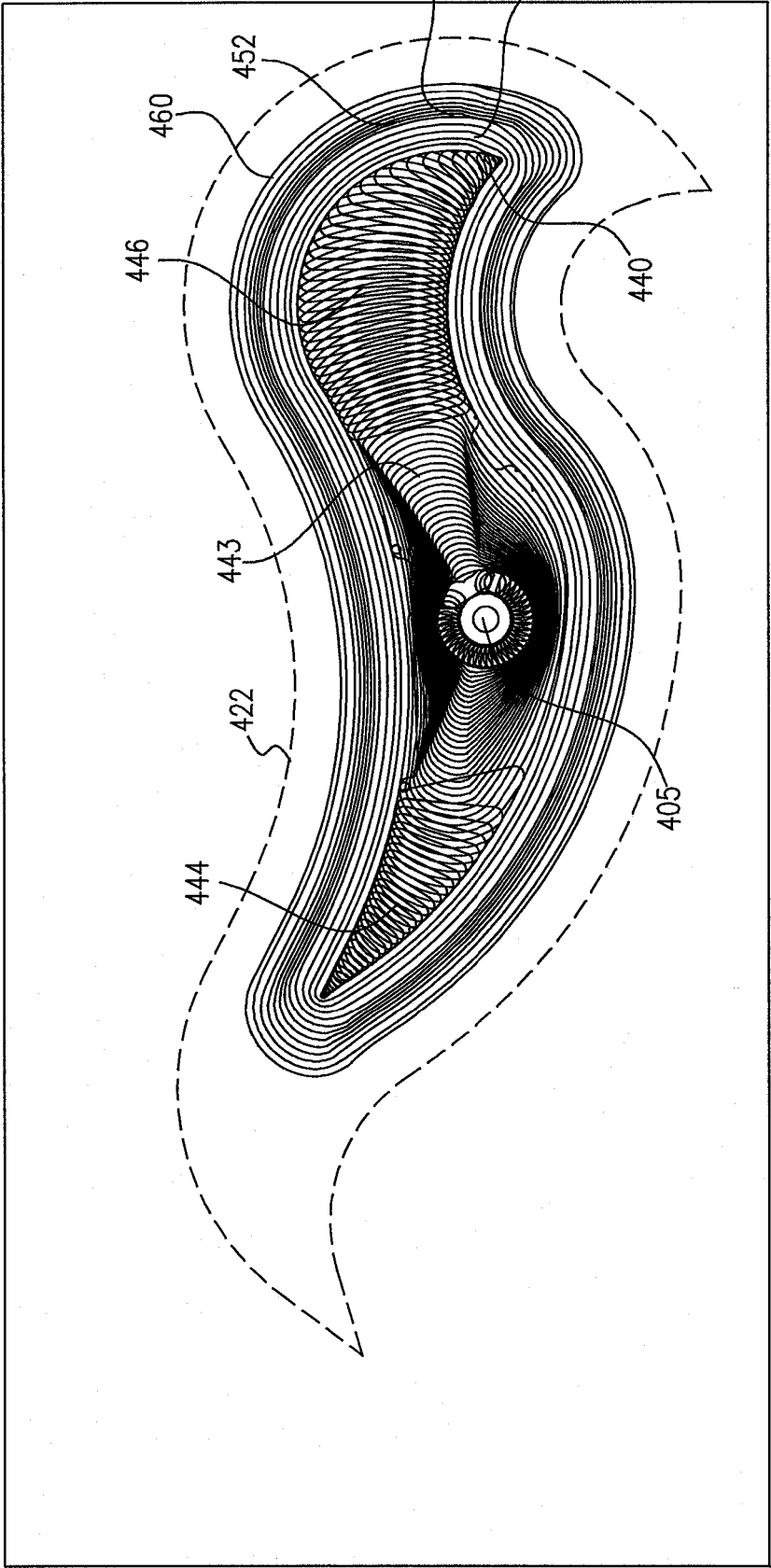
FIG. 21-1



49/61

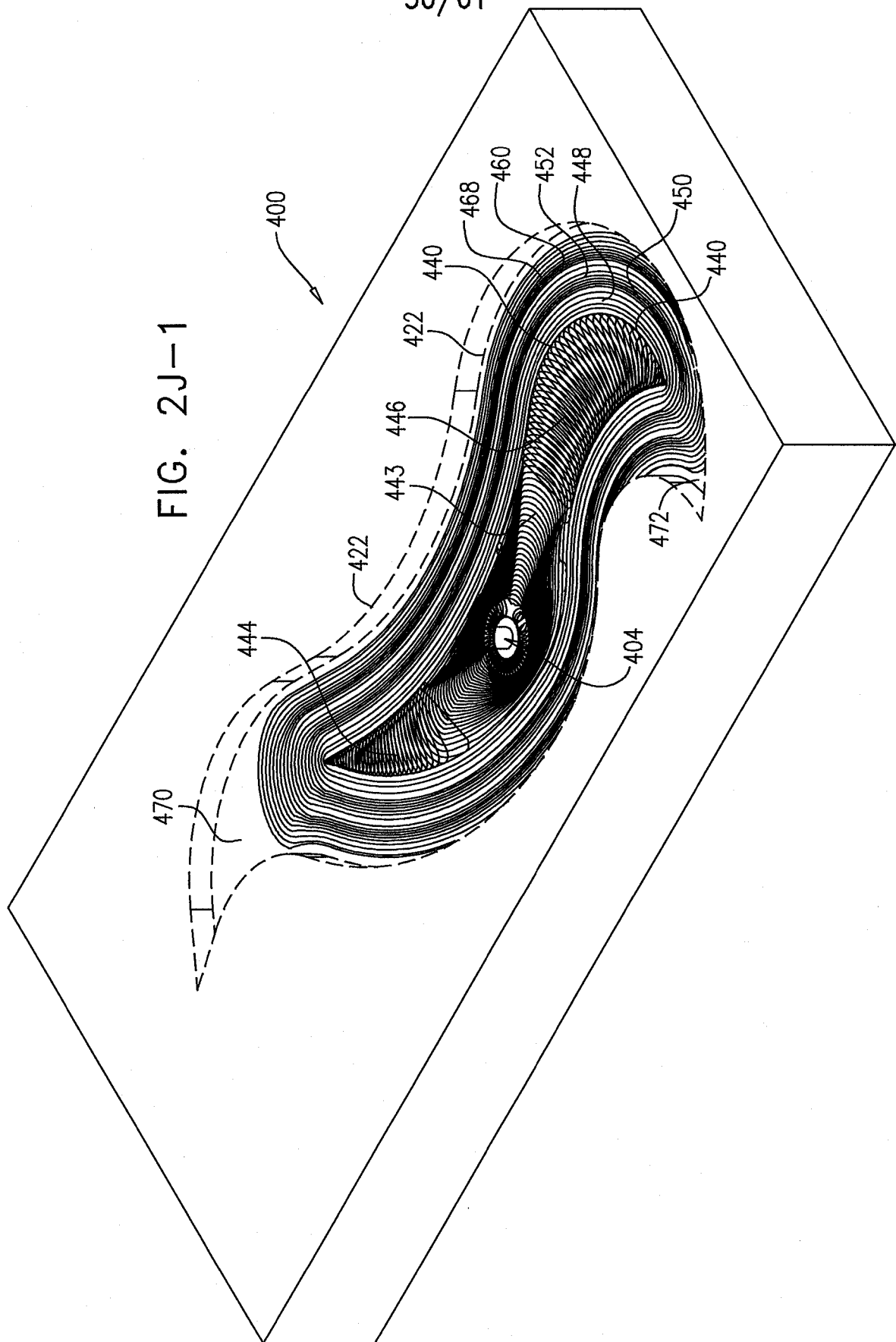
400

FIG. 21-2



50/61

FIG. 2J-1



51/61

400

FIG. 2J-2

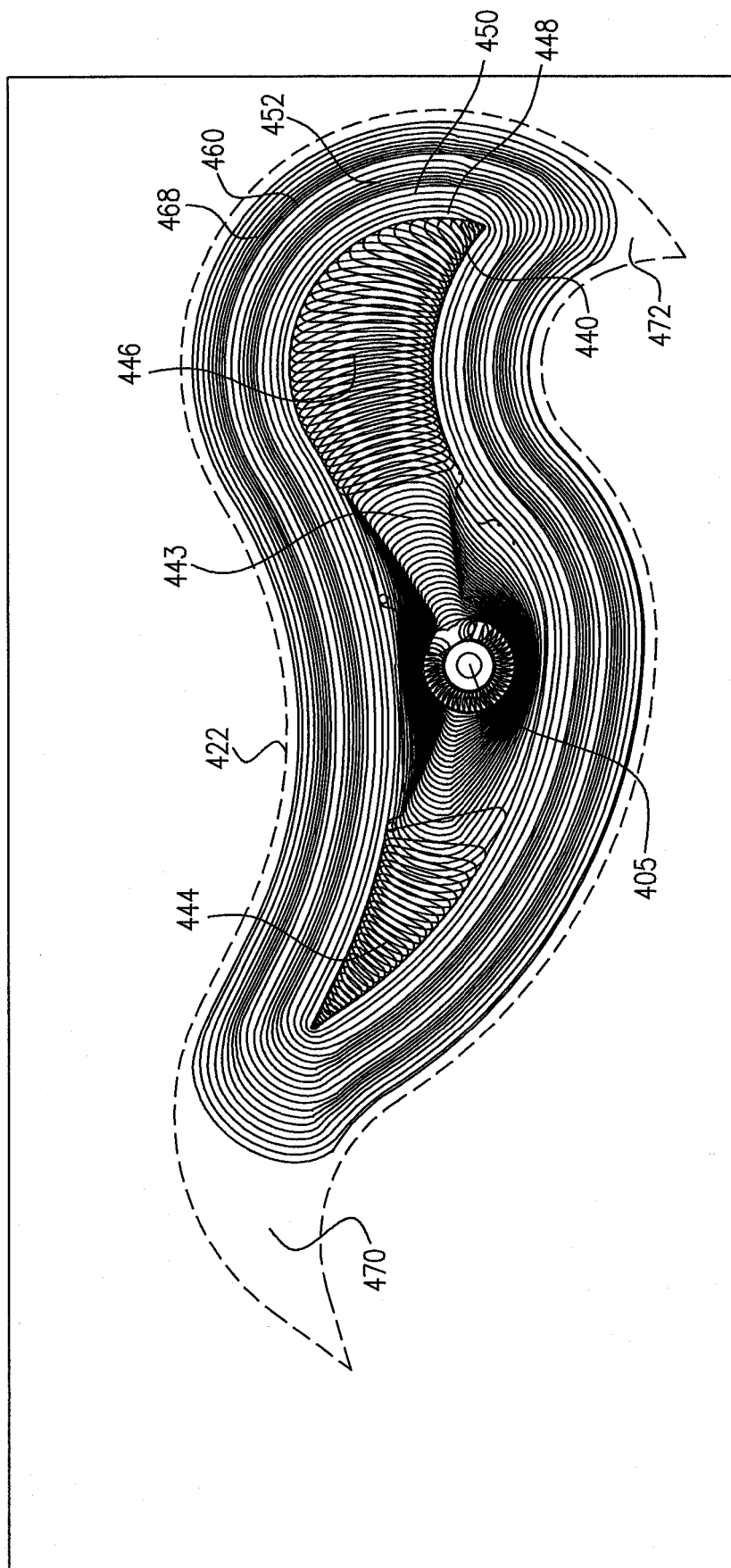
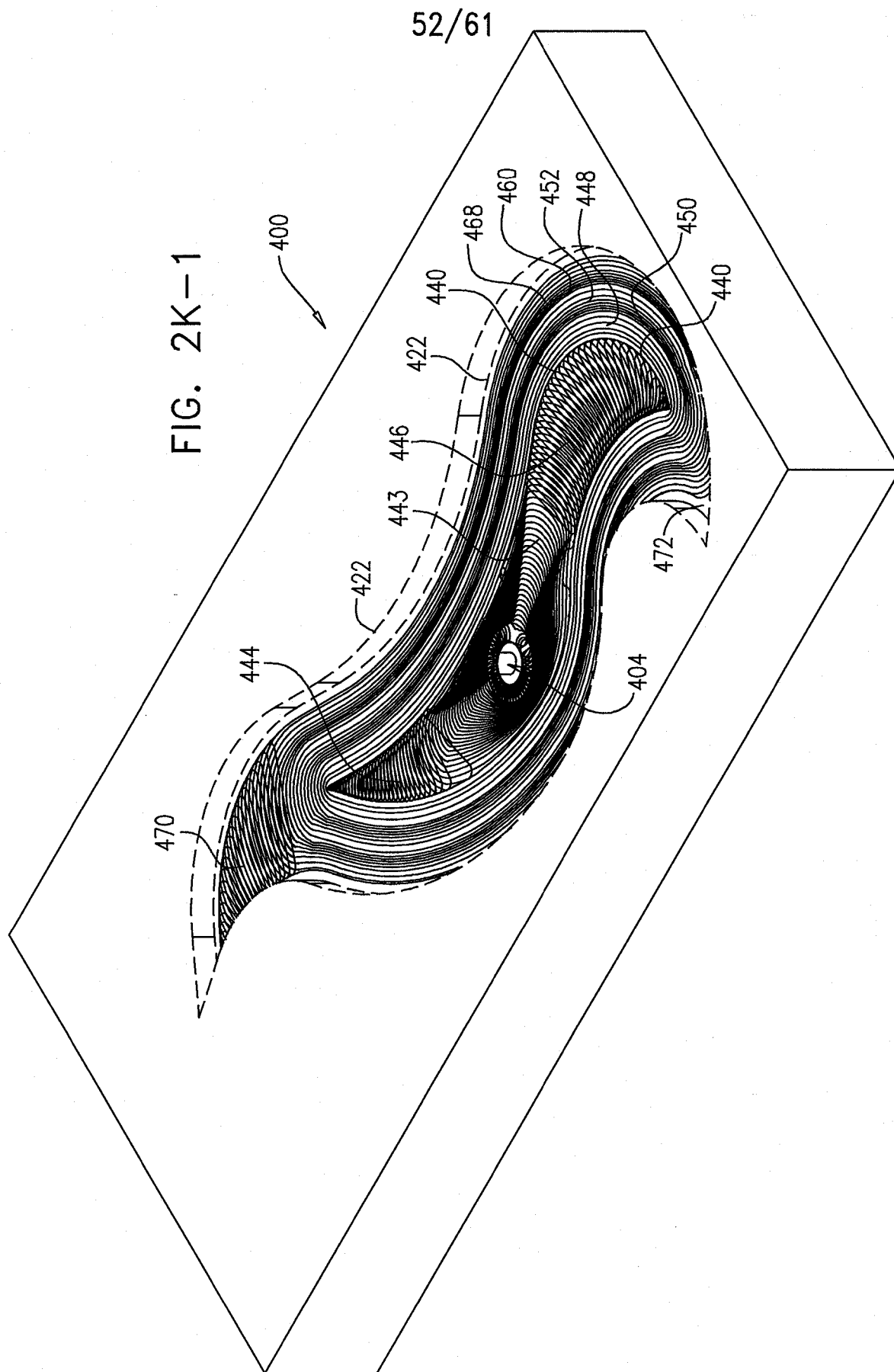


FIG. 2K-1



53/61

400

FIG. 2K-2

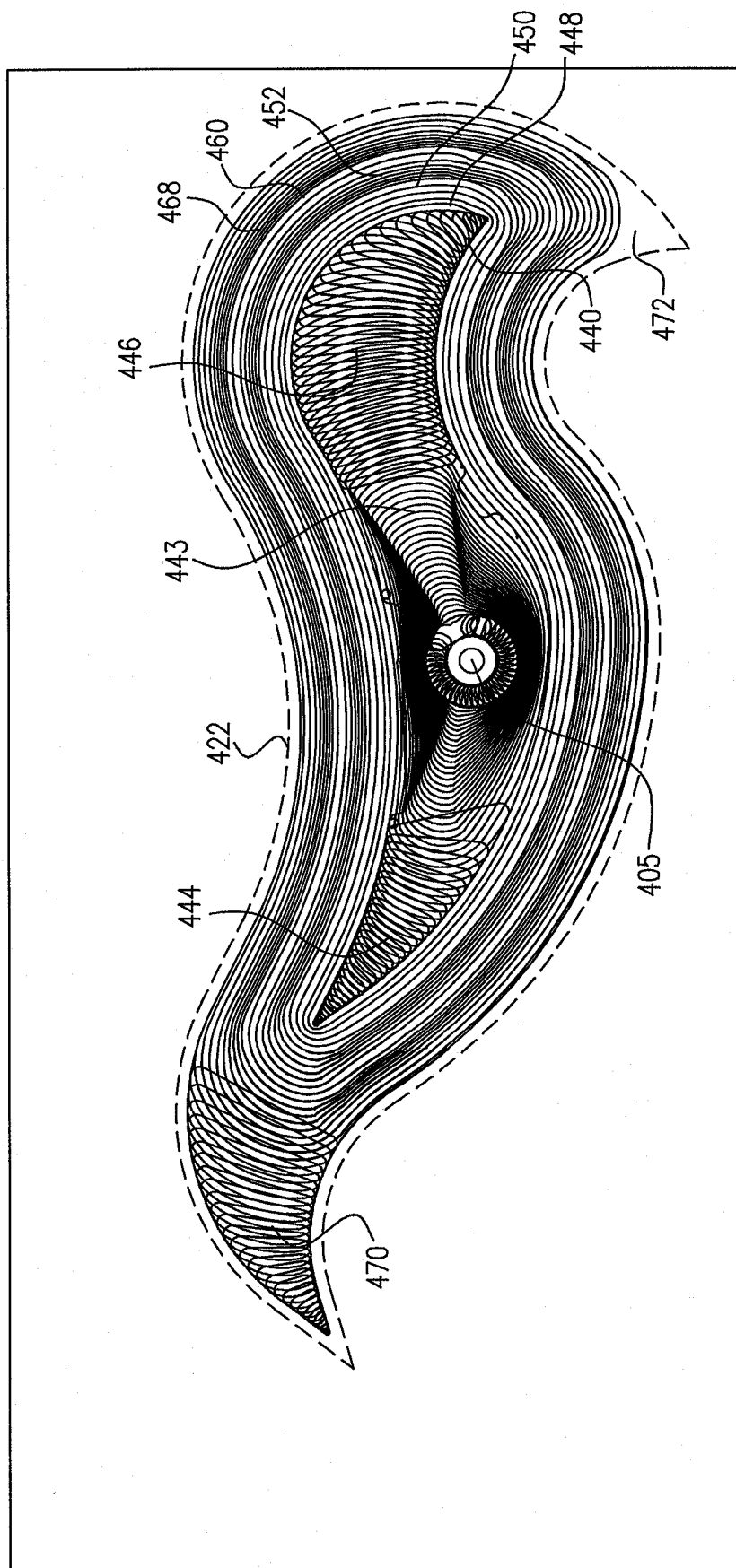
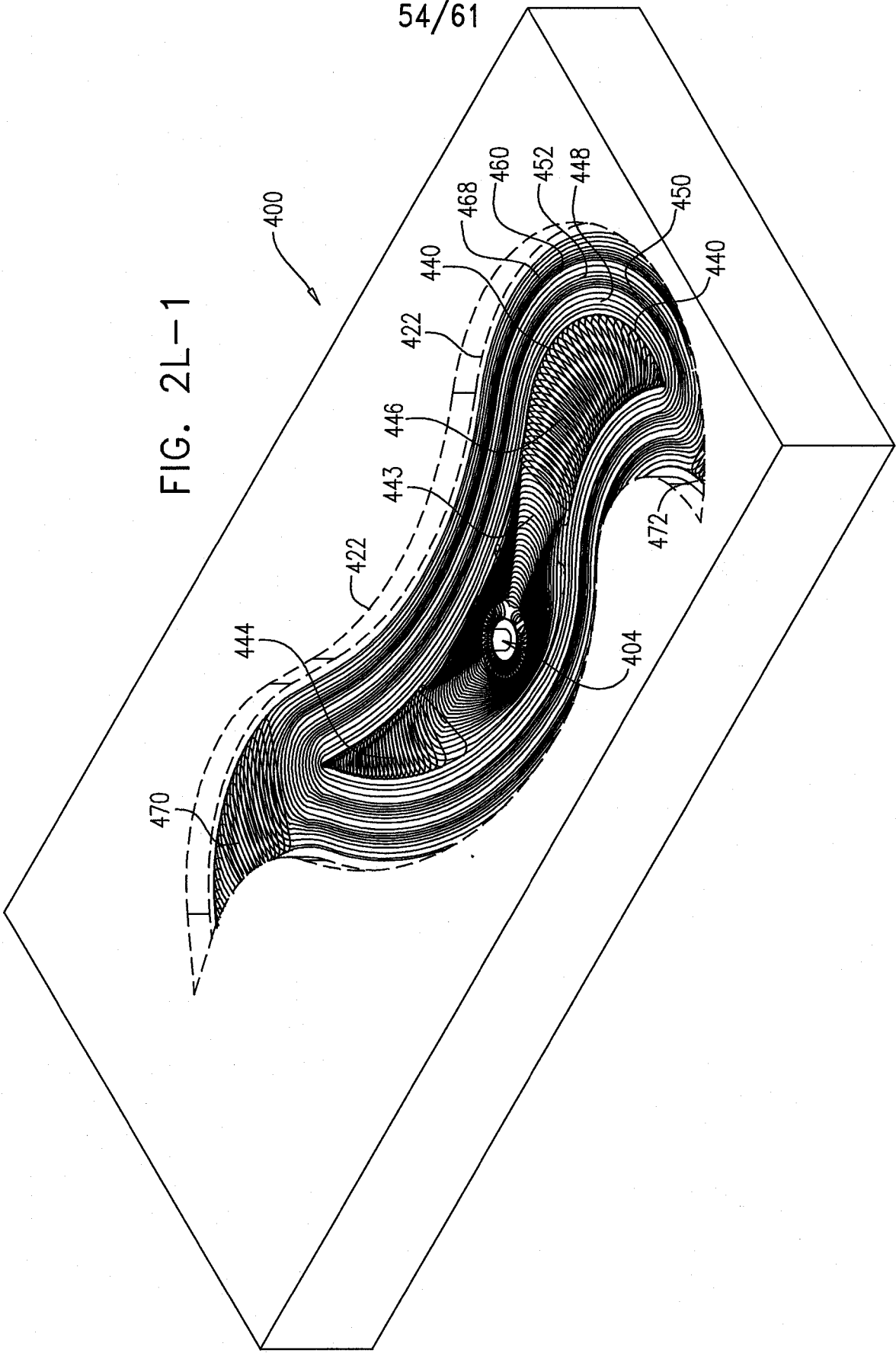


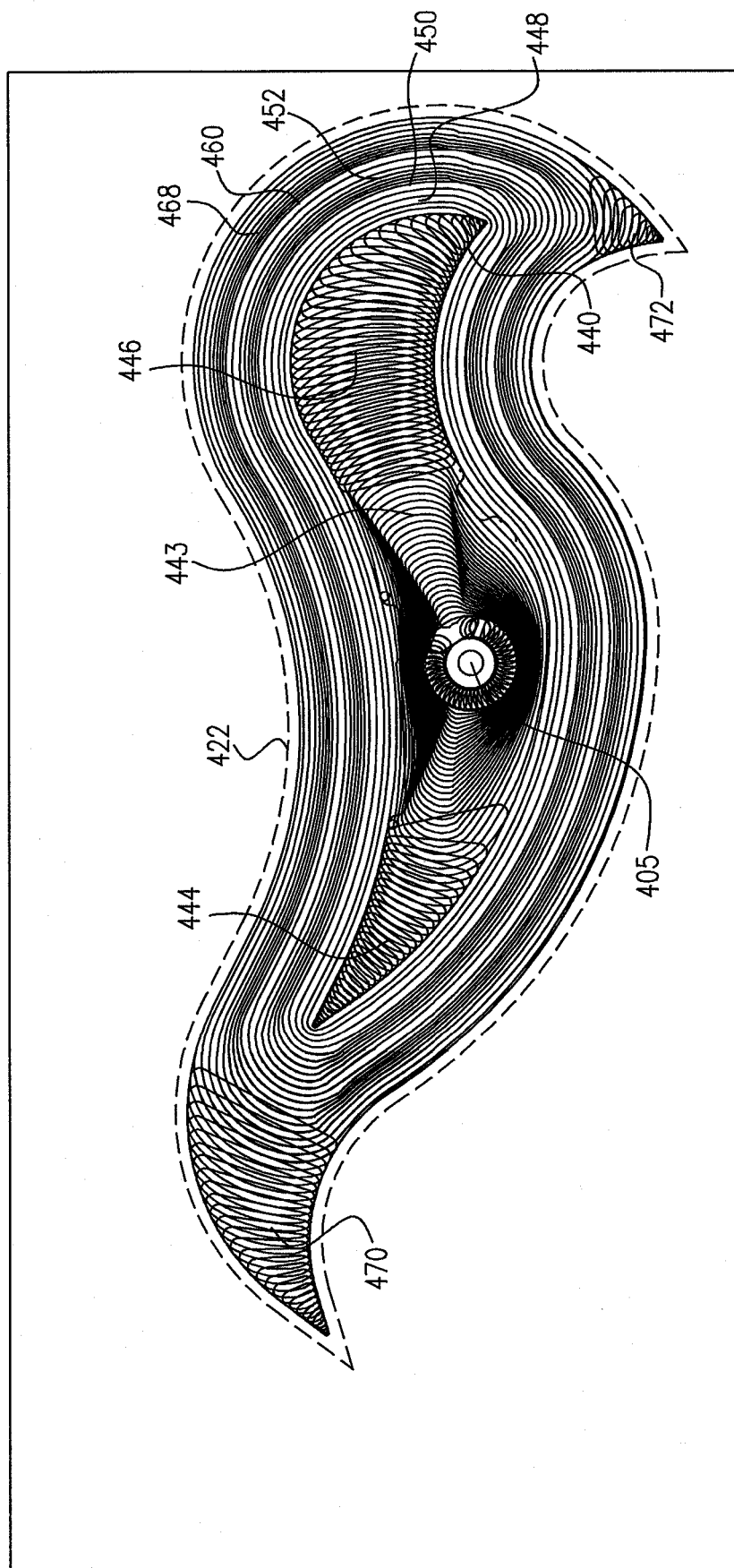
FIG. 2L-1



55/61

400

FIG. 2L-2



56/61

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): **2528**

F (mm/min): **1617.68**

Step over (max): **0.804**

Step over (min): **0.362**

Apply

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

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

FIG. 3A

57/61

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

58/61

MachiningOperation

Technology iRough

Operation name

11M contour1 T5-2A 1

Template

Geometry

Tool

Levels

Technology Wizard

Technology

Link

Misc. parameters

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

59/61

+

×

!

MachiningOperation

Technology

iRough

Operation name

IM contour1 T5-2A 1

Template

Geometry

Tool

Levels

Technology Wizard

Technology

Link

Misc. parameters

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

Save

Save & Calculate

Simulate

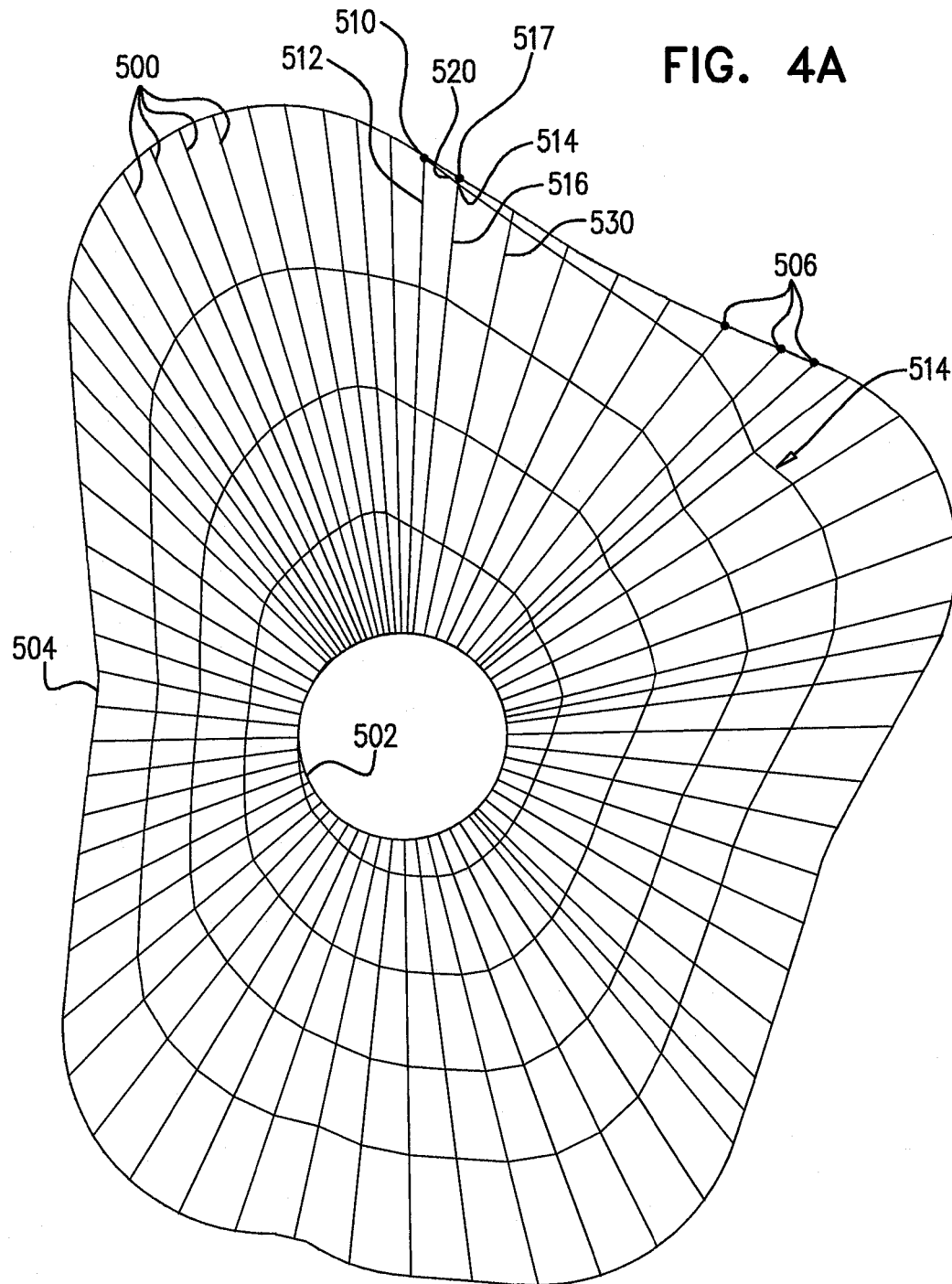
GCode

Save & Copy

Exit

FIG. 3D

60/61



61/61

FIG. 4B

