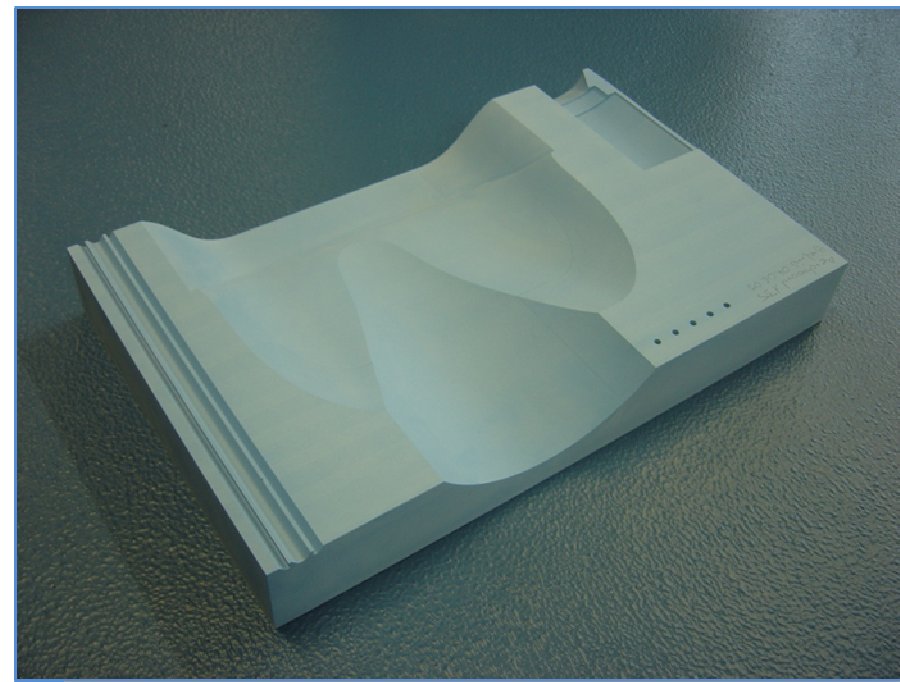
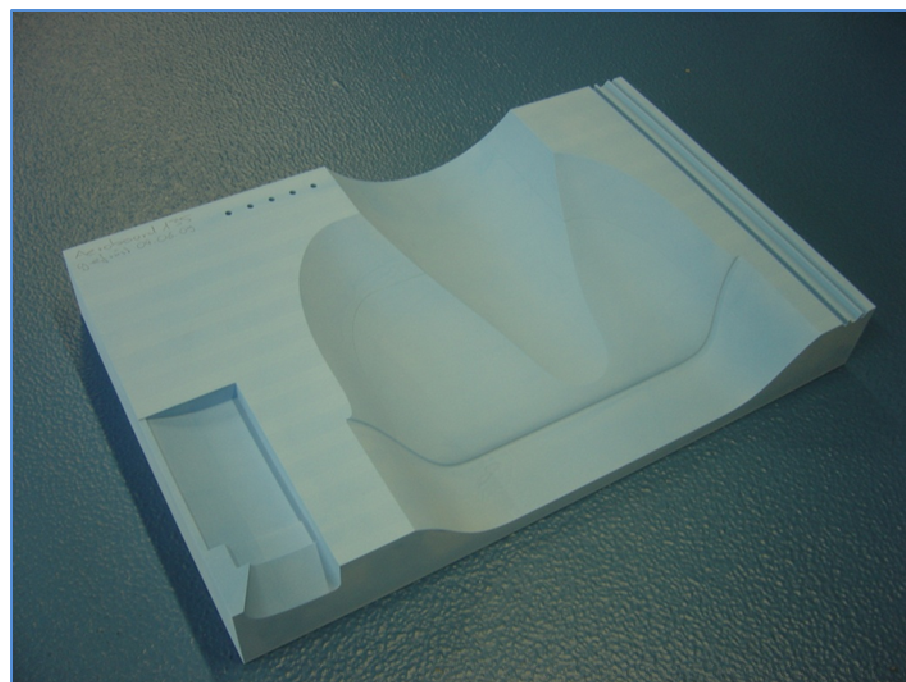


5 Axis Performance

Product	5-Axis Setup				Tool Temperature	Dust / Chips	Block Stability	Operator Risk	Machine Risk	Tool Wear	Surface Quality	Other
	Milling Tool	Spindle Speed	Feed Rate	Milling Depth								
AEROBOARD 135	Rough Cut Ø66mm	8,500 rpm	26,000 mm/min	8 mm	Low	No chips, very dusty but OK.	Same as TB650	None	None	Ok	Same as TB650	
	Semi Finish Ø25mm PKD Ball Nose	10,000 rpm	12,000 mm/min	N/A	Low	Same as TB650	Slightly better than TB650	None	None	Ok	Slightly better than TB650	
	Planar Finishing Ø42mm	12,000rpm	10,000 mm/min	N/A	Low	Slightly more dust than TB650	Slightly better than TB650	None	None	Ok	Slightly better than TB650	
	Finishing Ø20mm VHM Ball Nose	18,000 rpm	12,000 mm/min	N/A	Low	Same as TB650	Same as TB650	None	None	Ok	Same as TB650	
	Finishing Ø4mm VHM Ball Nose	18,000 rpm	7,000 mm/min	N/A	Low	Same as TB650	Same as TB650	None	None	Ok	Same as TB650	
	Finishing Ø1mm VHM Ball Nose	18,000 rpm	9,000 mm/min	N/A	Low	Same as TB650	Same as TB650	None	None	Ok	Same as TB650	
	Borer Ø6mm (Drilling)	2,000 rpm	700 mm/min	30mm	Low	Same as TB650	Same as TB650	None	None	Ok	Holes slightly undersize	



Distortion (from flat) = 0.29mm

Key:

- = Desirable Characteristic
- = Undesirable Characteristic
- = Highly Undesirable Characteristic