



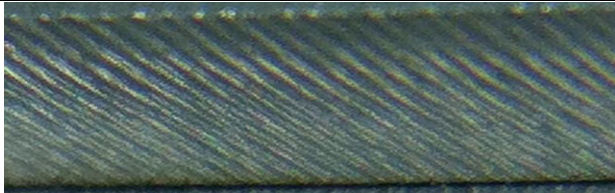


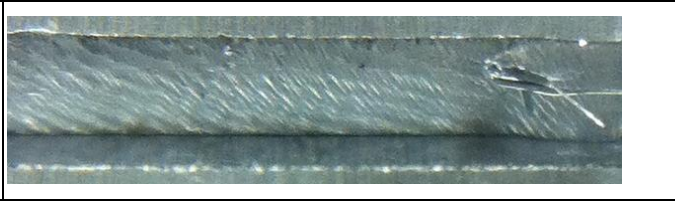



Surface Finishing Vs Feed Rate for Alu Routing

Stages	Feed Rate	Comments	Surface Finishing
1	<ul style="list-style-type: none"> • Too low 	<ul style="list-style-type: none"> • Alu dust stick on surface • Smooth surface 	
2	<ul style="list-style-type: none"> • At low side 	<ul style="list-style-type: none"> • Helical lines appear with breakage in between • Fair surface finishing 	
3	<ul style="list-style-type: none"> • Just enough 	<ul style="list-style-type: none"> • Dim helical lines formed • Acceptable finishing 	
4	<ul style="list-style-type: none"> • Bingo! You got the right feed rate 	<ul style="list-style-type: none"> • A perfect finishing with uniformed helical line (the pitching may varies depends on bd thickness) 	
5	<ul style="list-style-type: none"> • On high side 	<ul style="list-style-type: none"> • Helical lines become coarsely and slanting • Acceptable finishing 	
6	<ul style="list-style-type: none"> • At the top end 	<ul style="list-style-type: none"> • Helical lines start to drift • Acceptable finishing 	

7	<ul style="list-style-type: none"> • Too high • User should back-off from here 	<ul style="list-style-type: none"> • Dragging lines appear along the routing path • Cutting edge starts to have burrs roll back effect • Fair finishing 	
8	<ul style="list-style-type: none"> • At the limit 	<ul style="list-style-type: none"> • Aluminum chip starts to appear with burrs on the edge • Bad finishing 	
9	<ul style="list-style-type: none"> • Super high 	<ul style="list-style-type: none"> • Aluminum chips become more and worse • Very bad finishing 	
10	<ul style="list-style-type: none"> • Extremely high • Do not go beyond from here 	<ul style="list-style-type: none"> • Aluminum burrs and chips worsen • Finishing is extremely bad. <p><i>Note : Alu chips also appear on low feed rate but with no roll back effect on the edges</i></p>	