

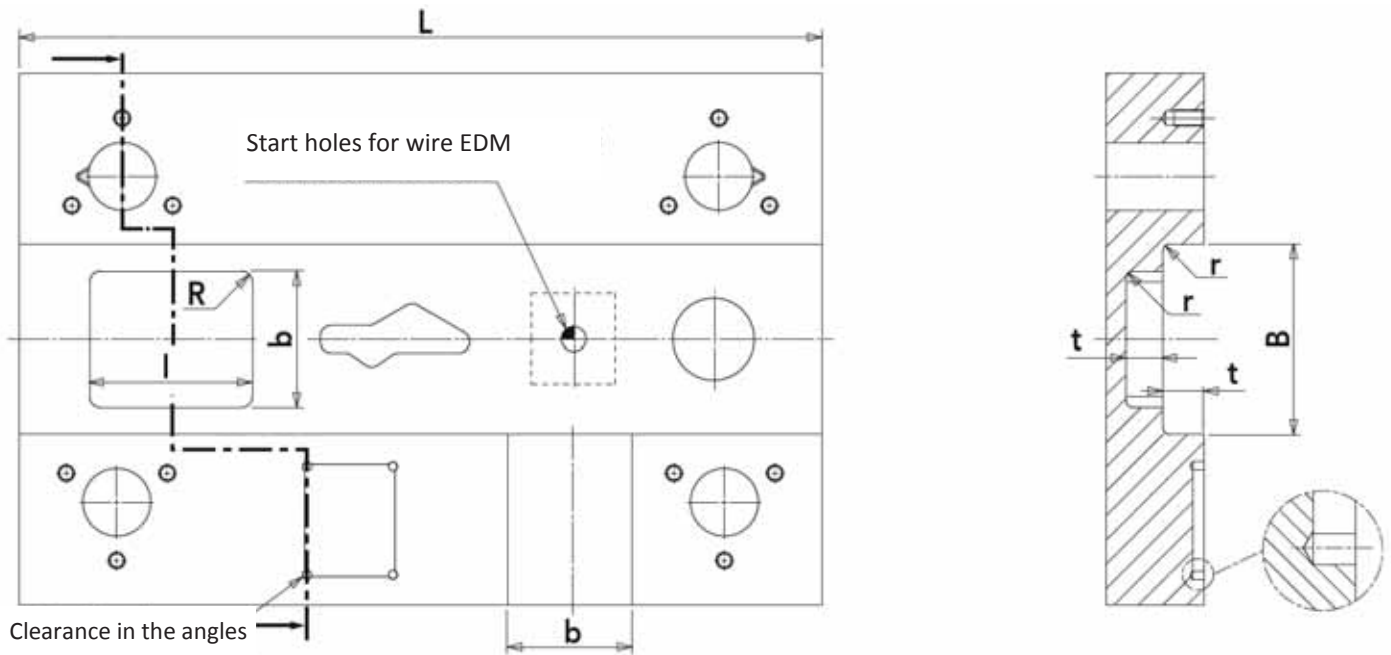
Standard Corner Radius & Maximum Depth

b/l	R	t	Max t
< 100 / 100	17.5	-100	-140
< 300 / 300	26	-150	-220
>300 / 300	33	-210	-270

Higher machining costs can occur at maximum depth milling.

The bottom radius r is dependant on tooling used during Rough milling (r=3-6mm)

Please supply 2D PDF drawings for complex forms and Solid in Parasolid or STEP format



Corner Radius and Depth

Pocket Depth (T)	Corner Radius Min	Bottom Radius
35mm	4	0, 1, 2
45mm	5	0, 1, 2, 4
55mm	4	0, 1, 2, 4
80mm	8	0, 1, 2, 4
90mm	10	0, 1, 2, 4
100mm	12	0, 1, 2, 4, 6
105mm	16	0, 1, 2, 4, 6
125mm	20	0, 1, 2, 4, 6
150mm	25	0, 1, 2, 4, 6
200mm	32	0, 1, 2, 4, 6
250mm	35	0, 1, 2, 4, 6

Pocket Tolerances

Pocket Size b/l	Tolerance b/l	Tolerance t
<200	+0.04	+0.00
	+0.01	-0.02
<400	+0.05	+0.00
	+0.01	-0.02
<600	+0.06	+0.00
	+0.01	-0.04
>600	+0.07	+0.00
	+0.01	-0.04

Pockets with radii smaller than 4 mm will be drilled deeper for clearance purposes..

Avoid pockets with maximum depth to reduce the cost of machining.

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