

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 the tooling used during Rough milling ($r=3-6\text{mm}$)

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



At UTP we offer 3D Plate roughing for all complex Cavity and Core Plates.

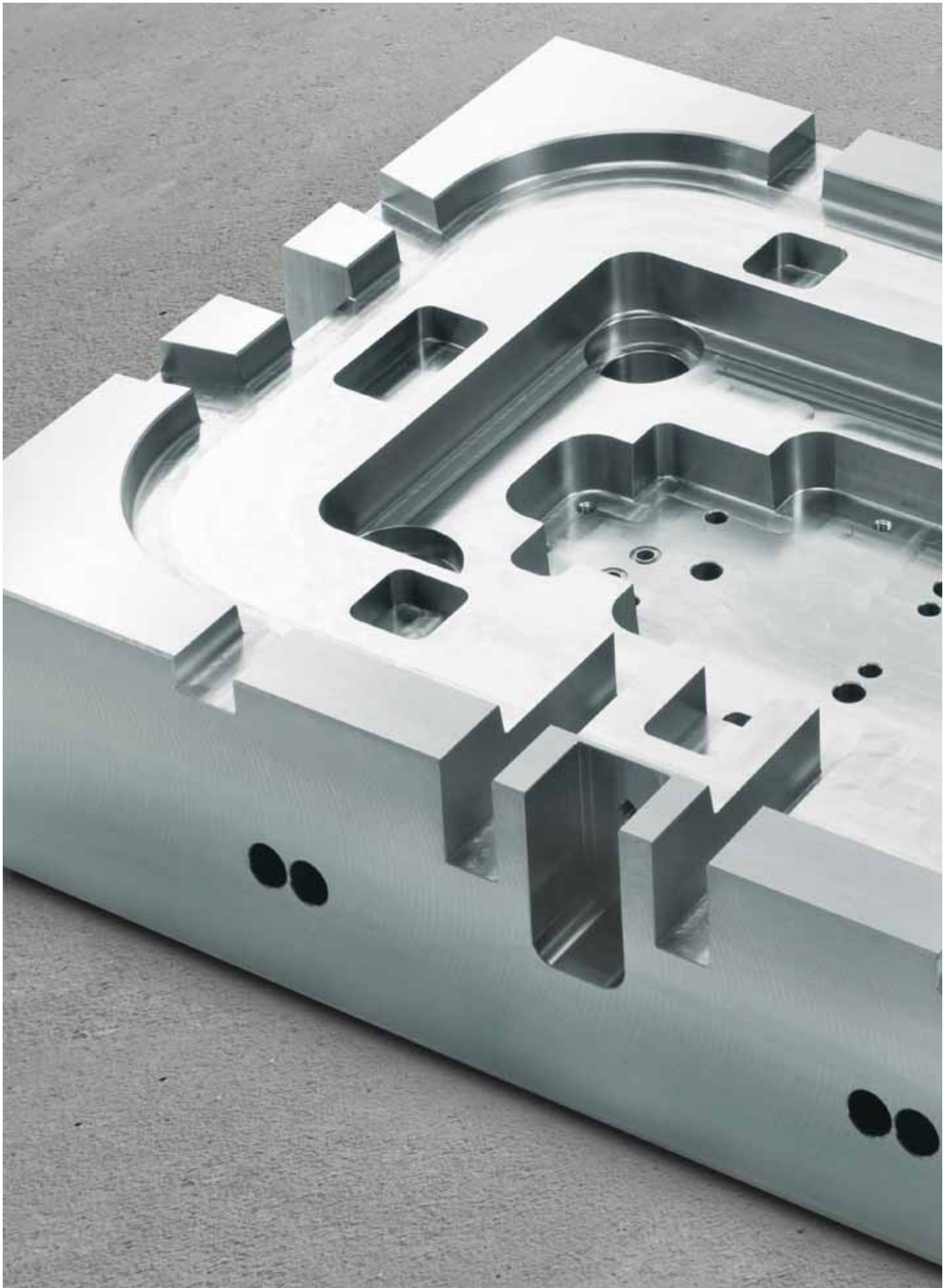
Maximum size: 1200 x 2000 x 600mm

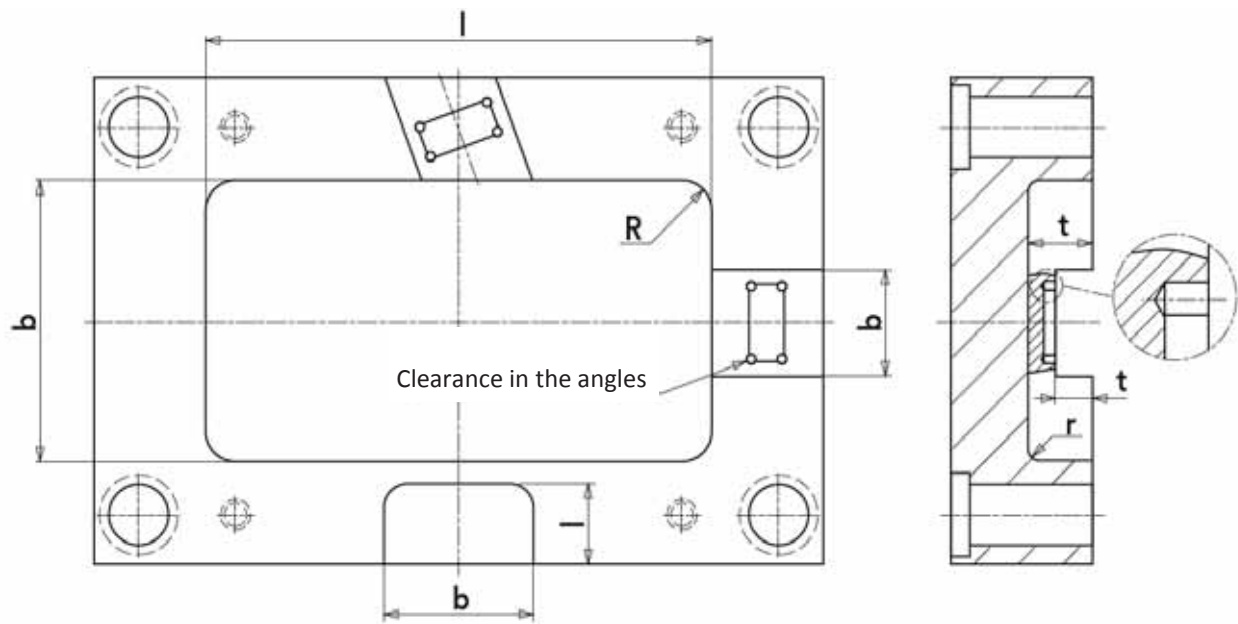
Maximum mass: 300Kg per plate

Stress Relieve: We offer stress relieving after machining and regrinding of the bottom surface before delivery
guide pillar and bush bores can be pre-machined leaving 0.3mm for final machining

Data format: Step or Parasolid

Data Export: We provide Edgecam Path File Data for further machining if required.





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.

Higher machining costs can occur at maximum depth milling.

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