

SAMPLE PARTS

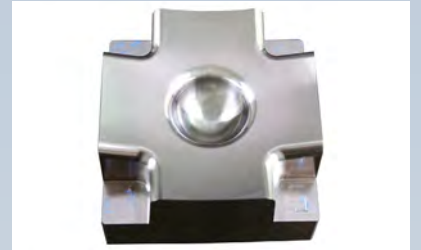
3-AXIS



Drone Propeller cavity



Headlight Test Piece High Polish



Mold Party line match



Jaguar Logo mold



Optical Light lense



Quenching Steel Testing

[VIEW](#)

[VIEW](#)

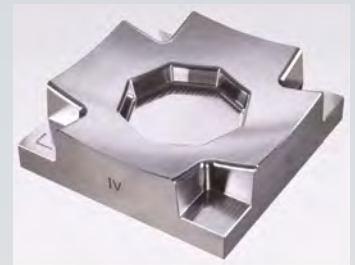
[VIEW](#)



Multi Cores standing



Fingert Spinner part SS



Precision Mold Fitting



Shaver Steel Mold piece



Casting Machining holes



**Precision Mold Fitting
w measurement points**

[VIEW](#)

[VIEW](#)

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SAMPLE PARTS

3-AXIS


Aircraft Propeller Mold Testing Pieces

Name	Aircraft Propeller Mold Testing Pieces			
Machine	JDHGT600_A13S			
Material	S136 (HRC52)			
Dimension	220x150x58 mm			
Finishing Cutter	R1/R0.3	Finishing Time	14h25min	

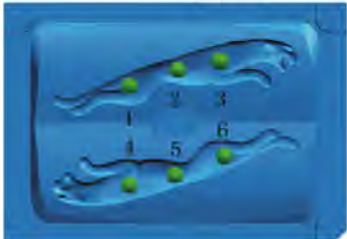
- Typical Points:**
1. On-line Measurement and Intelligent Correction technologies are applied to control the machining allowance of each process.
 2. Use On-line Measurement technology to measure the mold before unloading from machine.
 3. Connecting lines on the straight side wall of the inner cavity and the bottom are invisible.
 4. 3D Surface allowance tolerance < 0.01 mm.
 5. Inner cavity surface roughness Ra < 0.15 μ m

	Testing Report				
	Measured Position	1	2	3	4
	Actual Measured Error (mm)	0.0055	0.0062	0.0058	0.0068
	Actual Roughness Ra (μ m)	0.138	0.144	0.141	0.136
	Measuring Device	ZEISS CMM / Mitutoyo Roughmeter			

Cheetah Injection Mold Testing Piece

Name	Cheetah Injection Mold Testing Piece			
Machine	JDHGT600_A13S			
Material	S136 (HRC52)			
Dimension	220x160x45 mm			
Finishing Cutter	R1/R2/R0.5	Finishing Time	23h11min	

- Typical points:**
1. Use On-line Measurement and Intelligent Modification technologies to control cutting allowance.
 2. Connecting point on the vertical wall and bottom of the cavity is invisible.
 3. The residual tolerance of the whole surface is less than that of 0.01 mm.
 4. Inner cavity roughness Ra \leq 0.080 μ m.


	Testing Report						
	Measured Position	1	2	3	4	5	6
	Actual Measured Error (mm)	0.0055	0.0062	0.0058	0.0058	0.0053	0.0059
	Actual Roughness Ra (μ m)	0.053	0.064	0.058	0.065	0.063	0.072
	Measurement Device	ZEISS CMM / Mitutoyo Roughmeter					

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SAMPLE PARTS

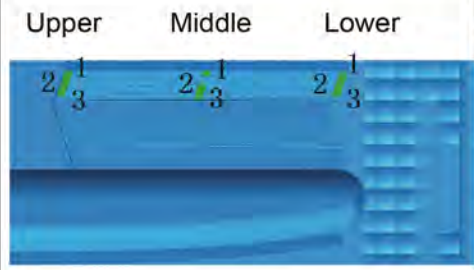
3-AXIS

Automobile Headlight Strip Testing Piece


Name	Automobile Headlight Strip Testing Piece			
Machine	JDHGT600_A13S			
Material	S136 (HRC48)			
Dimension	93x42x80 mm			
Finishing Cutter	R0.2/R0.15/R0.075	Finishing Time	26h52min	

Typical Points :

1. Small processing surface, the step surface changes from 1.5 mm to 0.3 mm, the smallest tool is R0.075 mm.
2. Using full closed-loop equipment, the small tool can be continuously and steadily cut for a long time (20h), cutting tool wearing is <0.005 mm, the consistency of the cutting marks is good and surface roughness $Sa \leq 0.3 \mu m$ with clear angularity.

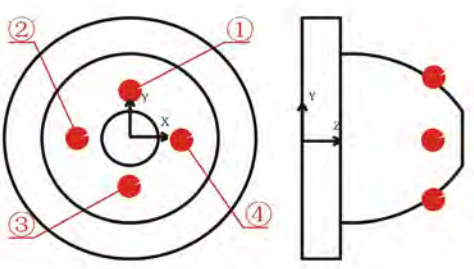
			Testing Report			
Upper	Middle	Lower	Testing Position	Upper Point	Middle Point	Lower Point
			1	0.222	0.250	0.245
			2	0.251	0.258	0.259
			3	0.225	0.224	0.245
			Measuring Device	Zygo White Light Interferometer		

Optical Light Mold Testing Piece

Name	Optical Light Mold Testing Piece			
Machine	JDHGT600_A13S			
Material	S136 (HRC52)			
Dimension	$\phi 85 \times 50$ mm			
Finishing Cutter	D6R1	Finishing Time	9h12min	

Typical Points:

1. On-line Measurement and Intelligent Modification technologies are applied to control every processing allowance.
2. Surface allowance tolerance is controlled within 0.008 mm.
3. Surface roughness $Ra < 0.070 \mu m$. Clear surface intersection.


		Testing Report			
		1	2	3	4
	Measured Position				
	Actual Measured Error (mm)	0.0042	0.0055	0.0044	0.0035
	Actual Roughness Ra (μm)	0.059	0.041	0.045	0.058
	Measuring Device	ZEISS CMM / Mitutoyo Roughmeter			

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3-AXIS

Precision Mold Fitting Testing Piece (Cavity)

Name	Precision Mold Fitting Testing Piece(Cavity)	
Machine	JDHGT600_A13S	
Material	H13	
Dimension	80x80x40 mm	
Machining time	9h36min	

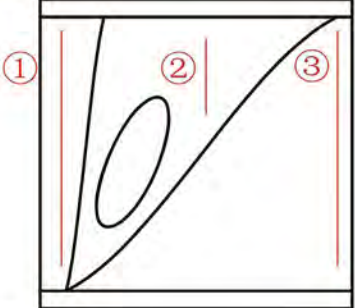
Typical Points: 1. JDCT600T_A15SH machine tool is applied in rough finish process.
2. Finish machining surface allowance tolerance is controlled within -5 μm.

		Testing Process										
		Roughness Sa										
Measured Position		1	2	3	4	5	6	7	8	9	10	11
	Accuracy	0.005										
	Actual measured error	0.109	0.111	0.104	0.115	0.074	0.101	0.089	0.162	0.16	0.154	0.157
Measuring Device		ZEISS						Mitutoyo Roughmeter				
Type		CONTURA 7106 aktiv						SJ-410				

Quenching Steel Cutting Tool Wearing Testing Piece

Name	Quenching Steel Cutting Tool Wearing Testing Piece			
Machine	JDHGT600_A13S			
Material	S136 (HRC52)			
Dimension	400x330x112 mm			
Finishing Cutter	R3	Finishing Time	24h22min	

Typical points : 1. Finishing cutter continuously cut in 24 hours which has small wearing, less than 0.005 mm, good consistency of surface roughness.
2. Surface error of the big surface is <0.005 mm.


		Testing Report		
Measured Position		1	2	3
	Measured Surface error (mm)	0.0031	0.0022	0.0028
	Roughness Ra (μm)	0.165	0.176	0.181
	Measuring Device	ZEISS CMM / Mitutoyo Roughmeter		

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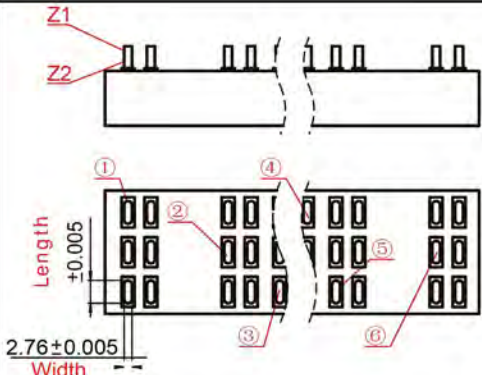
SAMPLE PARTS

3-AXIS


Multi-column Mold Testing Piece

Name	Multi-column Mold Testing Piece			
Machine	JDHGT600_A13S			
Material	S136(HRC52)			
Dimension	270x45x52 mm			
Finishing Cutter	D4R0.2	Finishing Time	42h	

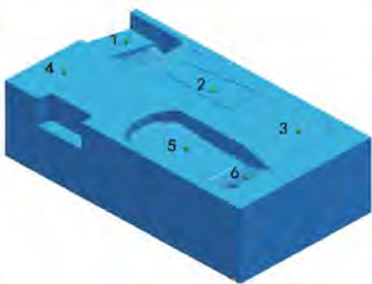
Typical Points: 1. On-line Measurement and Intelligent Modification technologies are applied to control every processing allowance.
 2. Dimensional accuracy of each column is controlled within ± 0.0050 mm.
 Uniform surface effect, $Ra < 0.1 \mu\text{m}$.

	Testing Report							
	Measured Position	1	2	3	4	5	6	
	Width 2.76 mm	Z1 Error	-0.0002	0.0015	0.0018	0.001	0.0035	0.0040
		Z2 Error	0.0035	0.0035	0.0040	0.0042	0.0043	0.0044
	Length 8.23 mm	Z1 Error	-0.0021	-0.0012	-0.0011	-0.0019	-0.0005	-0.0002
		Z2 Error	-0.0019	-0.0015	-0.0007	-0.0005	-0.0001	0.0006
	Roughness Ra (μm)	Z1Height	0.057	0.057	0.069	0.088	0.092	0.074
Z2Height		0.059	0.056	0.056	0.087	0.094	0.074	
Measuring Device	ZEISS CMM / Mitutoyo Roughmeter							

Shaver Steel Mold Testing Piece

Name	Shaver Steel Mold Testing Piece			
Machine	JDHGT600_A13S			
Material	S136(HRC52)			
Dimension	190x110x56 mm			
Finishing Cutter	R1	Finishing Time	7h21min	
Clean-up Cutter	R0.5/R0.3/R0.2	Clean-up Time	8h5min	

Typical points: 1. Eliminate small area spark discharge and shorten the manufacturing cycle of mold.
 2. On-line Measurement and Intelligent Correction technologies are applied to manage the separating area of mold and guarantee the qualified rate of batch production.

	Testing Report						
	Measured Position	1	2	3	4	5	6
	Actual Measured Error (mm)	0.0074	-0.0030	-0.0077	-0.0029	0.0037	0.0055
	Actual Roughness Ra (μm)	0.108	0.197	0.240	0.190	0.141	0.187
	Measuring Device	ZEISS CMM					

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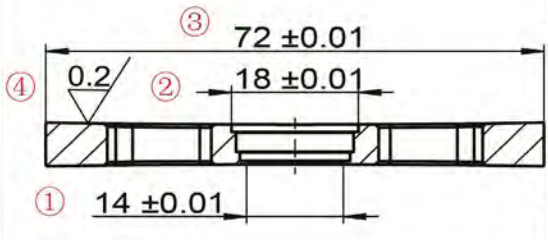
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3-AXIS

Finget Spinner Testing Piece

Name	Finget Spinner Testing Piece			
Machine	JDVT600T_DZ_A13S			
Material	Stainless Steel (304)			
Dimension	72x25x6.6 mm			
Grinding Wheel	Grinding Wheel D80	Machining Time	8min5s	

- Typical Points:**
1. Double spindle, double tool magazine, double rotatory-table, which can do duplex-position stainless steel milling & grinding.
 2. Use On-line Measurement and Intelligent Modification technologies to control the cutting allowance and ensure stable grinding.
 3. Grinding surface roughness Ra < 0.200 μ m.
 4. Dimension error of finished product is less than ± 0.010 mm, and it requires good symmetry and good balance after assembly.

	Testing Report				
	Measured Position	1	2	3	4
	Actual Measured Error (mm)	14.005	18.003	71.994	/
	Actual Roughness (μ m)	/	/	/	0.171
	Measuring Device	ZEISS CMM / Mitutoyo Roughmeter			



Testing Report													
NO.	Measuring Content (mm)	Nominal Value (mm)	Tolerance (mm)	1	2	3	4	5	6	7	8	9	cpk
1	Diameter-right handed D23.1	23.1	± 0.015	23.1075	23.0992	23.0976	23.0981	23.0984	23.0972	23.0975	23.0976	23.0963	1.37
2	Roundness-right Handed D23.1		0.01	0.0048	0.0044	0.0036	0.0048	0.004	0.0036	0.004	0.0046	0.0041	
3	Coaxiality--right Handed D23.1-Common Basis		0.01	0.0031	0.0019	0.0024	0.0032	0.0028	0.0026	0.0018	0.0027	0.0026	1.79
4	Diameter-left Handed D23.1	23.1	± 0.015	23.0983	23.1057	23.0977	23.0972	23.0966	23.0962	23.0971	23.0962	23.0961	1.42
5	Coaxiality-left Handed D23.1-Common Basis		0.01	0.0026	0.0019	0.0019	0.0025	0.0029	0.0026	0.0019	0.0034	0.0017	1.39
6	Roundness-left Handed D23.1		0.01	0.0034	0.0064	0.0024	0.004	0.0021	0.0061	0.0028	0.0062	0.0027	

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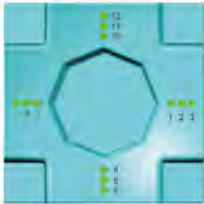
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3-AXIS

Precision Mold Fitting Testing Piece (Cavity)

Name	Precision Mold Fitting Testing Piece(Cavity)	
Machine	JDHGT600_A13S	
Material	H13	
Dimension	200x200x60 mm	
Machining time	26h43min	


- Typical Points:**
1. JDCT800T_A15SH machine tool is applied in rough finish process
JDHGT600-A13S machine tool is applied in finish process.
 2. Finish machining surface allowance tolerance is controlled within $-10\ \mu\text{m}$.

	Testing Process													
	Measured Position	Roughness Sa												
		1	2	3	4	5	6	7	8	9	10	11	12	
	Data (mm)	Accuracy	0.01											
		Actual measured error	0.166	0.175	0.165	0.180	0.172	0.152	0.139	0.76	0.181	0.172	0.177	0.178
Measuring Device	ZEISS						Mitutoyo Roughmeter							
Type	CONTURA 7106 aktiv						SJ-410							

Precision Mold Fitting Testing Piece(Cavity)

Name	Precision Mold Fitting Testing Piece(Cavity)	
Machine	JDCT800_A15SH	
Material	H13	
Dimension	200x200x60 mm	
Machining time	30h30min	

- Typical Points:**
1. JDCT800T_A15SH machine tool is applied in rough, semi-finish and finish process.
 2. The mold surface allowance tolerance is less than $-5\ \mu\text{m}$, and the surface roughness is less than $0.15\ \mu\text{m}$.

	Testing Process													
	Measured Position	Roughness Sa												
		1	2	3	4	5	6	7	8	9	10	11	12	
	Data (mm)	Accuracy	0.015											
		Actual measured error	0.18	0.17	0.163	0.170	0.175	0.168	0.201	0.187	0.177	0.186	0.188	0.199
Measuring Device	ZEISS						Mitutoyo Roughmeter							
Type	CONTURA 7106 aktiv						SJ-410							

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