Milling Conditions and Layout
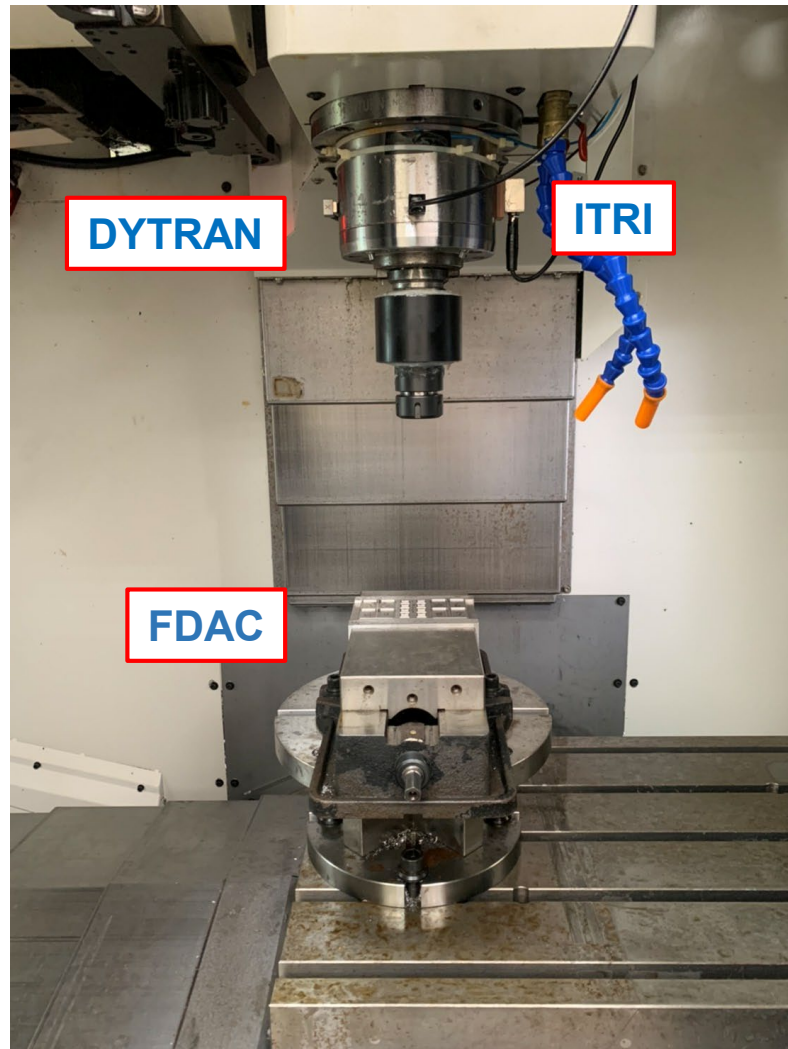
Layout in the CNC machine

Item	Content		
Source	**Machine:** CNC Milling (TMV-720A)		**Controller:** Syntec 21MA
	Sensor: **ITRI-LNAXI332** (sample rate: 2048 Hz), **Dytran-3293A** (sample rate: 2048 Hz), **CTL-10-CLS** (sample rate: 1000 Hz),		**Collector:** Raspberry Pi 4*2 PC*1
Condition	**Machining Condition:** Spindle Speed (rpm): 3000 Feed Rate (mm/min): 800 Workpiece: FDAC Tool Type: Milling Tool Diameter (mm): 6 No. of Flutes: 4		**Experiment Condition:** Time: 2020/6/10 No. of Tools: 1-4

IESSC

1. Start from each center
2. Side milling

Process 1

Process 2