



**DATRON DYNAMICS, INC.**  
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## Application Notes

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**Part:** ..... Medical Container Lid  
**Material:** ..... 0.090" Redal  
**Machine Used:** ..... M5 - 4750  
**Features Utilized:** ..... "Z" Probe, Automatic Tool Changer, Tool Length Measurement & HF Spindle  
**Software Used:** ..... PrimCam / G-Code  
**Total Cycle Time:** ..... 207 seconds (3:27)



### Machining Details:

Tool 1: 129 seconds - Drilling of holes with .080" end mill

Tool Change: 17 seconds

Tool 2: 12 seconds – Perimeter profile cut with a .120" end mill

Tool Change: 17 seconds

Z Probe: 22 seconds – Probe surface for bevel

Tool 3: 10 seconds – Bevel the perimeter edge

### Summary of the Application:

We are able to offer a substantial savings in machining time compared to the customer's current production methods. The large 30" x 40" working volume also would offer better cycle times by amortizing tool changes and "Z" probing times over numerous parts. For example for 20 parts (4 x 5) the total production time would be approximately 2 minutes and 55 seconds per part.