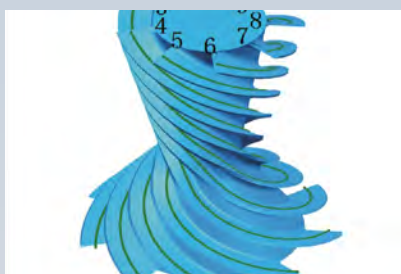


SAMPLE PARTS

5-AXIS



**Alluminum
Impeller**

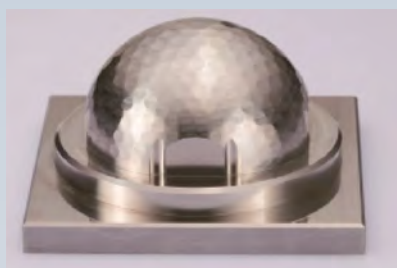


**Double Spiral
Impeller**

[VIEW](#)

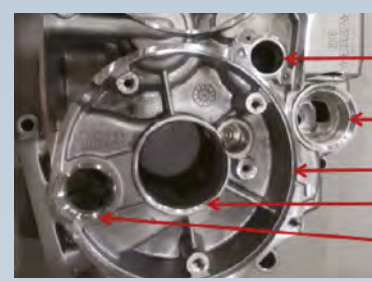


**Automobile
Headlight**

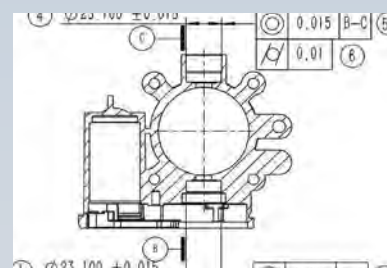


**Lamp mold golf
ball looks**

[VIEW](#)



**Aluminum
Throttle Valve**



**Throttle Valve
Case Test**

[VIEW](#)



**Micron Polished
7 levels**



**Mirror finish
picture**

[VIEW](#)



**SS
Communication**



**Titanium /
Accuracy**

[VIEW](#)



**Turbine
Blade**

[VIEW](#)




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SAMPLE PARTS


5-AXIS

Turbocharger Impeller

Name	Turbocharger Impeller			
Machine	JDGR200_A15SH			
Material	Aluminium Alloy 7075			
Dimension	60×35 mm			
Finishing Cutter	10°-R1	Finishing Time	7min37s	

Typical Point:

1. The JDGR200_A15SH machine tool adopts the full closed loop control technology, which can effectively guarantee the accuracy of the impeller.
2. It reflects the machining accuracy, machining stability and reliability of the Jingdiao machining center.


	Testing Report					
	Measured Position	1	2	3	4	5
	Roughness Ra (μm)	0.15				
	Measuring Device	Zygo White Light Interferometer				

VIEW

VIEW

VIEW

Double Spiral Impeller Testing Piece

Name	Double Spiral Impeller Testing Piece			
Machine	JDGR400_A15SH			
Material	Al 6061			
Dimension	Φ288x350 mm			
No.	Process	Cutter	Machining Time	
1	Semi-Finishing	R4	19h37min	
2	Finishing	R4	42h47min	

Typical Points :

1. 5 axes simultaneous machining, there is no shaking pattern on the lateral of testing piece.
2. The profile dispersion error of spiral line is less than 0.003 mm.

Testing Report									
Measured Position	1	2	3	4	5	6	7	8	9
Front Profile Error (mm)	0.0616	0.0732	0.0737	0.0830	0.0742	0.0817	0.0852	0.07501	0.0707
Back Profile Error (mm)	0.0565	0.0555	0.0552	0.0542	0.0559	0.0551	0.0554	0.05440	0.0520
Measuring Device	ZEISS CMM								

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SAMPLE PARTS

5-AXIS

Automobile Headlight Strip (5 Axes) Testing Piece

Name	Automobile Headlight Strip (5 Axes) Testing Piece			
Machine	JDGR400_A13S			
Material	S136 (HRC52)			
Dimension	190x25x80 mm			
Finishing Cutter	R0.1	Finishing Time	44h30min	



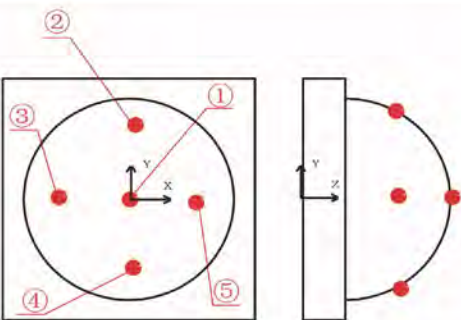
Typical Points:

1. R1 ball-end cutter continuously and stable cutting in 44h30min, good consistency cutting marks and clear edges and angles.
2. By using High Speed 5 Axes Machining Center, it can effectively solve the problem of big tool length-radius ratio in 3 axes machine.

5 Axes LED Lamp-cup Testing Piece

Name	5 Axes LED Lamp-cup Testing Piece			
Machine	JDGR200_A10SH			
Material	S136 (HRC52)			
Dimension	100x100x50 mm			
Finishing Cutter	D2R1	Finishing Time	12h10min	

- Typical Points :**
1. Manage-control the cutting stock by Online Measurement and Intelligent Correction technologies.
 2. The surface stock deviation is controlled within ± 0.01 mm.
 3. The surface roughness $Sa < 0.08$ μm .


	Testing Report					
	Measured Position	1	2	3	4	5
	Actual Measured Error (mm)	-0.0089	-0.0065	-0.0073	0.0069	-0.0082
	Actual Roughness Ra (μm)	0.071	0.077	0.076	0.068	0.079
	Measuring Device	ZEISS CMM / ZYGO White Light Interferometer				

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SAMPLE PARTS

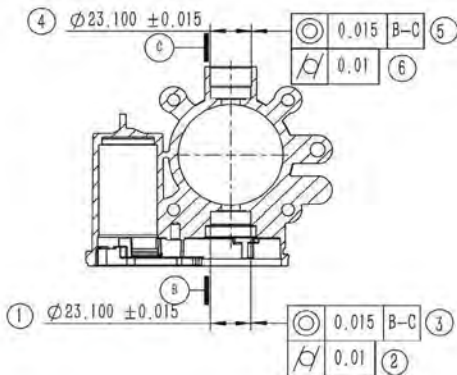
5-AXIS

Motorcycle Gearbox

Name	Throttle Valve Casting Testing Piece	
Machine	JDGR400_A15SH	
Material	Aluminum Alloy	
Dimension	240x200x100 mm	
Machining Time	34min	
Typical Points: 1. Quick change saves clamping time; 2. Processing benchmarks can be determined and corrected intelligently; 3. Tapping, surface milling with disc cutter, boring, can reflect the machining ability of machine tools; 4. Use On-line Measurement technology to measure the mold before unloading from machine and guarantee one-time success rate.		

Testing Report								
Measured Position		Diameter						
		1	2	3	4	5	6	7
Data (mm)	Tolerance	$\varnothing 42^{+0.1}_{+0.005}$	$\varnothing 36^{+0.1}_{+0.005}$	$\varnothing 25^{+0.1}_{+0.005}$	$\varnothing 36^{+0.1}_{+0.005}$	$\varnothing 120^{+0.1}_{+0.005}$	$\varnothing 60^{+0.1}_{+0.005}$	$\varnothing 36^{+0.1}_{+0.005}$
	Actual Measured Error	42.07	75.08	25.08	36.08	120.07	60.08	36.08
Measuring Device		3D Family Image Mapping Apparatus						
Type		NV 400						

Throttle Valve Casting Testing Piece

Name	Throttle Valve Casting Testing Piece	
Machine	JDGR400_A15SH	
Material	Casting Aluminium	
Dimension	133.5x112.9x71.2 mm	
Cutters	D80 /D35.8 /D57 /D23 /1D3.3 /M4 /D6	
Machining Time	5min30s	
Typical Points: 1. With JDGR400_A15SH CNC Machining Center, multiple-step machining including milling, drilling, tapping, boring and other complex machining can be performed through one time clamping. 2. Use On-line Measurement and Manufacturing-inspecting Integration technologies to guarantee one-time success rate.		

No.	Measuring Content	Tolerance (mm)	Actual Measured Error (mm)				
			1	2	3	4	5
1	Coaxiality: Right Handed Circle D23.1 Common Datum	0.01	0.0031	0.0019	0.0024	0.0032	0.0028
			6	7	8	9	cpk
			0.0026	0.0018	0.0027	0.0026	1.79
			1	2	3	4	5
2	Coaxiality: Left Handed Circle D23.1 Common Datum	0.01	0.0026	0.0019	0.0019	0.0025	0.0029
			6	7	8	9	cpk
			0.0026	0.0019	0.0034	0.0017	1.39
			1	2	3	4	5

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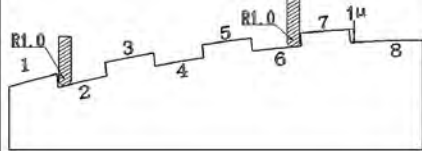
SAMPLE PARTS

5-AXIS

Micron Cutting Testing Piece

Name	Micron Cutting Testing Piece			
Machine	JDGR200_A10SH			
Material	STAVAX (HRC50)			
Dimension	75x30x40 mm			
Finishing Cutter	D2R1(PCD Cutter)	Finishing Time	12h45min	

- Typical Points:**
- 0.1 μ feeding, 1 μ cutting, micron cutting control.
 - 'Clear' seam, the height difference between each section is 0.001 mm.
 - High roughness, the surface roughness is less than 0.005 μ m.

	Testing Report								
	Measured Position	1	2	3	4	5	6	7	8
	Actual Roughness Sa(μ m)	0.004	0.005	0.003	0.004	0.005	0.004	0.004	0.005
	Measuring Device	ZYGO White Light Interferometer							



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AND HIGH ACCURACY MANUFACTURING SOLUTIONS

SAMPLE PARTS

5-AXIS

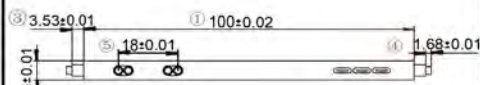
Communication Device Testing Piece

Name	Communication Device Testing Piece			
Machine	JDGR200_A10SH			
Material	Stainless Steel (304)			
Dimension	30x30x145 mm			
Finishing Cutter	Grinder D35	Finishing Time	8min30s	

Typical Points:

1. The requirement of product dimension is in ± 0.01 mm. Geometric tolerance is in 0.01 mm.
2. There is no burrs when inspect with 30 times magnifier.
3. Use On-line Measurement and Intelligent Modification technologies to control cutting allowance.

		Testing Report				
Measured Position		1	2	3	4	5
Dimension (mm)	Tolerance	± 0.02	± 0.01	± 0.01	± 0.01	± 0.01
	Measured Value	100.0088	6.006	3.5356	1.6723	18.0072
Measured Value		ZEISS CMM				




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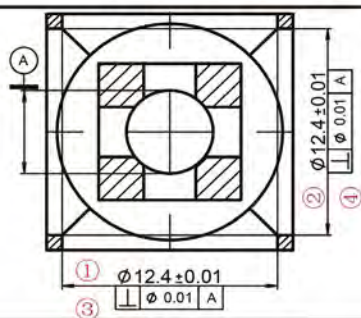
Titanium Alloy Precision Part Testing Piece

Name	Titanium Alloy Precision Part Testing Piece			
Machine	JDGR200_A10H			
Material	Titanium Alloy (TC4)			
Dimension	14.2x14.2x17.7 mm			
Finishing Cutter	Grinding Wheel D125	Finishing Time	6min30s	

Typical Points:

1. This product made by indexing process with JDGR200_A10H, the positioning accuracy of the machine ensures the product TOP and perpendicularity.
2. The hollow product is easily deformed, the cutting stability of machine is the basic condition to ensure the product deformity.
3. This product is made by grinding and milling composite process, controll grinding allowance accurately. Surface roughness Ra 0.2 μ m.
4. Adopted Jingdiao On-line Measurement and Intelligent Modification technologies to ensure product yield.

		Testing Report			
Measured Position		1	2	3	4
Dimension (mm)	Measured Value	12.4016	12.4046	/	/
	Perpendicularity (mm)	$\phi 0.01$	/	/	0.0082
Measuring Device		ZEISS CMM			



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SAMPLE PARTS


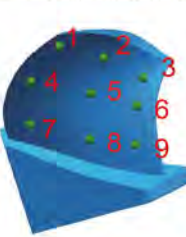
5-AXIS

Generator Blade Testing Piece

Name	Generator Blade Testing Piece			
Machine	JDGR400_A15SH			
Material	Al 6061			
Dimension	215.765x164.051x216.105 mm			
Finishing Cutter	R3	Finishing Time	4h30min	

Typical Points:

1. No chatter marks on the surface of the testing piece.
2. On-line Measurement and Intelligent Correction technologies are applied to control cutting allowance.
3. 3D surface allowance tolerance < 0.01 mm.

Front Surface	Back Surface	Testing Report										
		Measured Position	1	2	3	4	5	6	7	8	9	
		Actual Measured Error (mm)	Front	0.0261	0.0324	0.0374	0.0306	0.0422	0.0274	0.0423	0.0301	0.0274
			Back	0.0354	0.0351	0.0525	0.0427	0.0519	0.0519	0.0540	0.0440	0.0209
		Measuring Device	ZEISS CMM									

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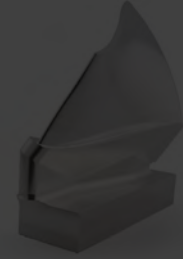
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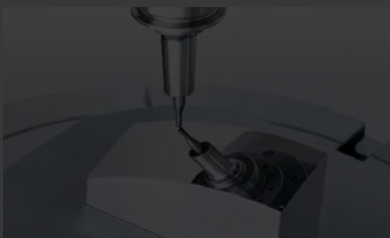
**Micron Polished
7 levels**



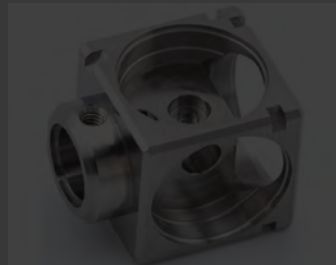
**SS
Communication**



**Turbine
Blade**



**Mirror finish
picture**



**Titanium/
Accuracy**

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