Star CNC’s Newest Revolutionary Software Technology

Star’s latest software technology is a fitting addition to assist with chip control where chip breaking is difficult in materials such as 17-4 Stainless Steel, 316 Stainless Steel, 360 Brass, Aluminum, and Black Delrin. This software enables intermittent cutting on any linear axis which will disperse “stringy” chips into more workable, smaller chips.

**HFT Benefits:**
- Increased productivity with less operator intervention
- Extended tool life
- Lower machining temperatures
- Reduced risk of built-up edge
- Suitable for difficult-to-chip materials including aluminum, brass, stainless steel, copper, plastic, etc.
- Can be used in conjunction with FANUC’s canned cycles
- Can be used on any linear axis
- Can be used for profile turning (with tool nose radius compensation)
- Can easily be added to any program with two additional lines of code
- Can be retrofitted (machine model and CNC control dependent)

**HFT Machining Geometries**
Star’s HFT software is suitable for a wide range of machining techniques including:

**Z-axis: Turning & ID Hole Making Cycles**
HFT can be used for any rough or finish turning operation in the Z+ or Z- direction. HFT can also be used on both the main and subspindles simultaneously.

**X-axis: Facing, Grooving, Cut-off & Cross Hole Making Cycles**
HFT can be used to control chip breakage during facing, grooving and parting off operations. HFT cutting parameters can also be changed “on-the-fly” to control the chips at any diameter.

**Y-axis: Milling & Slotting**
HFT can be used in the Y axis on the main spindle or sub-spindle, the software also works in conjunction with any Fanuc hole making cycle.

**Taper**
HFT can be used on any tool path, for profiles that include tapers and chamfers, either the X or Z axis can be specified as the master “HFT” axis.

**Radius**
HFT can be used on any tool path, for profiles that include arcs the software interrupts both axes to break-up the chips.

**Drilling**
HFT can be used in conjunction with any hole making cycle including peck drilling (full retract) or hi-speed peck drilling.