**Application:**
Milling a lens array in Electroless Ni mold insert.

**Process:**
Using 3 axes of contouring motion (X,Z,C or X,Y,Z) in combination with a high speed milling spindle, mill aspheric concave lenses into Ni plated substrate.

**Part Configuration:**
2mm Diameter with 1mm sagittal depth, 3 X 3, aspheric lenslet array on 3mm pitch. The part is held with vacuum on the C-Axis Chuck.

**Machining Parameters:**
- Tooling Spindle Speed: 35,000 rpm
- Linear federate: 25mm/min
- Depth of cut: Variable

**Tool Configuration:**
0.5mm radius, single flute, diamond, ball, end mill.

**Form Accuracy**
Deviation of lenslets on position in the array, 0.35µ P/V (14 µ” P/V) (graph scale in mm)

**Surface Roughness**
2.2 nm Ra