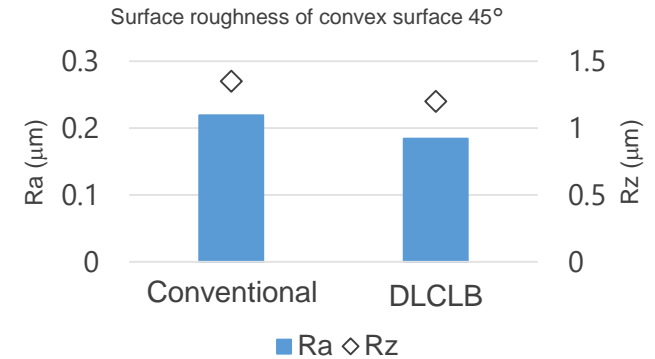
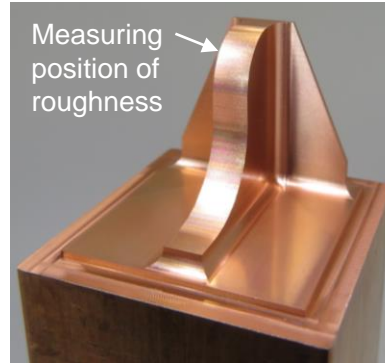


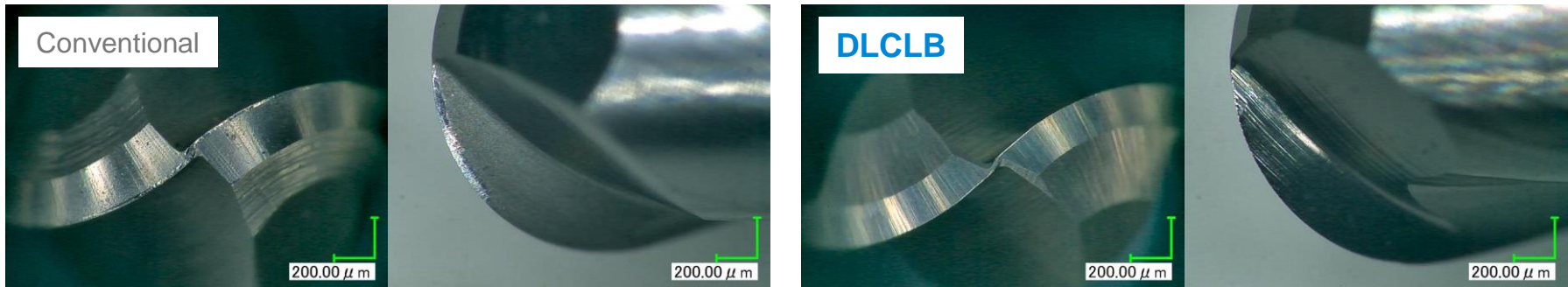
DLCLB Tough pitch copper milling example

Tool : DLCLB 2020-160 (R1 x EL16)
Work material : Tough pitch copper C1100
Work size : 20 x 20 x 16 mm
Coolant : Oil mist
Cycle time : 4hr 18min 40sec



No.	Process	Method	Spindle Speed (min ⁻¹)	Feed Rate (mm/min)	a _p (mm)	a _e (mm)	Cycle time
1	Roughing		10,800	1,090	0.25	0.5	1:31:59
2	Semi-finishing	Z-level process	10,800	1,090	0.05	0.05	1:31:15
3	Finishing		13,090	545	0.0001 (Cusp height)	0.03	1:15:26

Tool after milling



DLCLB has less wear and damage after 4 hours of milling,
And enables stable milling throughout the long cycle time.