

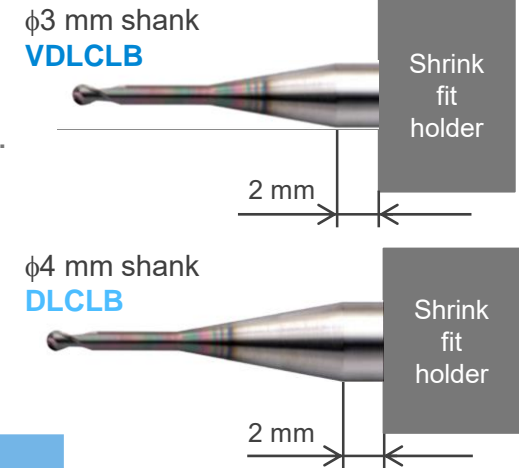
VDLCLB Copper electrode milling example

Tool : VDLCLB R1 x EL8 ($\phi 3$ mm shank)
 DLCLB R1 x EL8 ($\phi 4$ mm shank)
 Both models are set so that the overhang of shank is 2 mm.

Work material: Tough pitch copper C1100

Size : 20 x 20 x 8 mm

Coolant : Oil mist

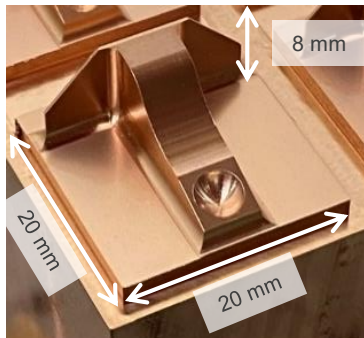


Milling condition

No.	Process	Spindle Speed (min ⁻¹)	Feed Rate (mm/min)	a _p (mm)	a _e (mm)	Allowance (mm)	Cycle Time / 1 pcs
1	Roughing	18,700	1,800	0.4	0.8	0.08	0:14:06
2	Semi-finishing	18,700	1,800	0.05	0.05	0.03	1:17:24
3	Finishing	18,700/ 30,000(Bottom)	900	0.03	0.03	0	1:17:00

1 for roughing to semi-finishing,
 1 for finishing,
 Total 2 ea.

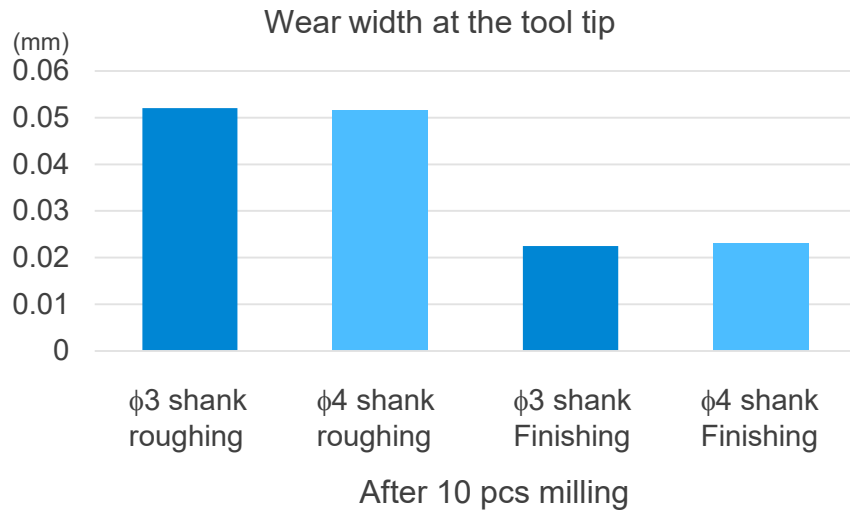
Milling shape



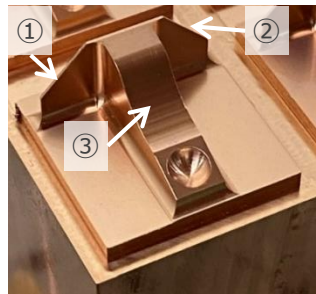
Milling application



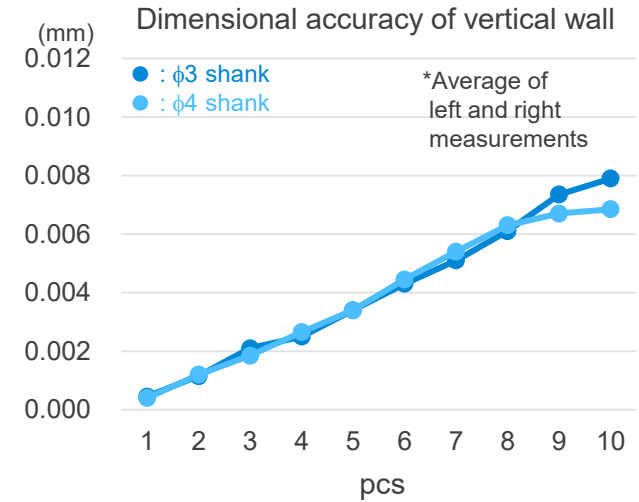
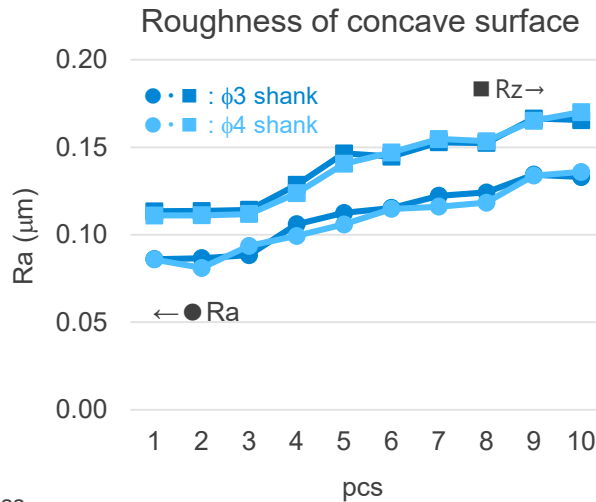
VDLCLB Copper electrode milling example



No difference of tool wearing with regard to the shank diameter gap.



- ①: Measuring position for dimensional accuracy (Left)
- ②: Measuring position for dimensional accuracy (Right)
- ③: Measuring position for roughness



Both the dimensional accuracy and roughness gave very similar results, with no difference with regard to the shank diameter gap.