

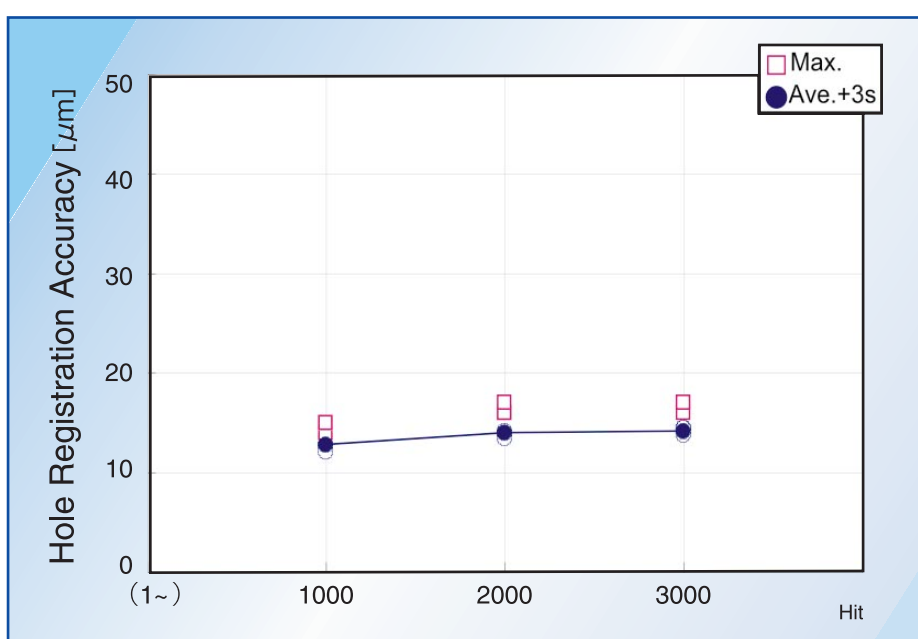
Ultra Micro-Hole Drilling with High Revolution

微細径ドリル高速回転加工事例 (φ0.05)

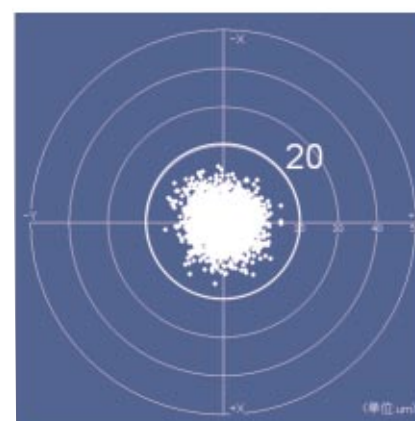
加工条件 [Drilling Conditions]

Work Material : BT CCL-HL832HS (6/6 μ mCu)
 t 0.1 (double-sided) x 2stacks
 N : 300krpm F : 1.5m/min f : 5 μ m/rev
 Set Life : 3,000hits B/B : t1.5Paper Phenolic Resin
 Drill : KMD 0.05x0.9

穴位置精度 [Hole Registration Accuracy]

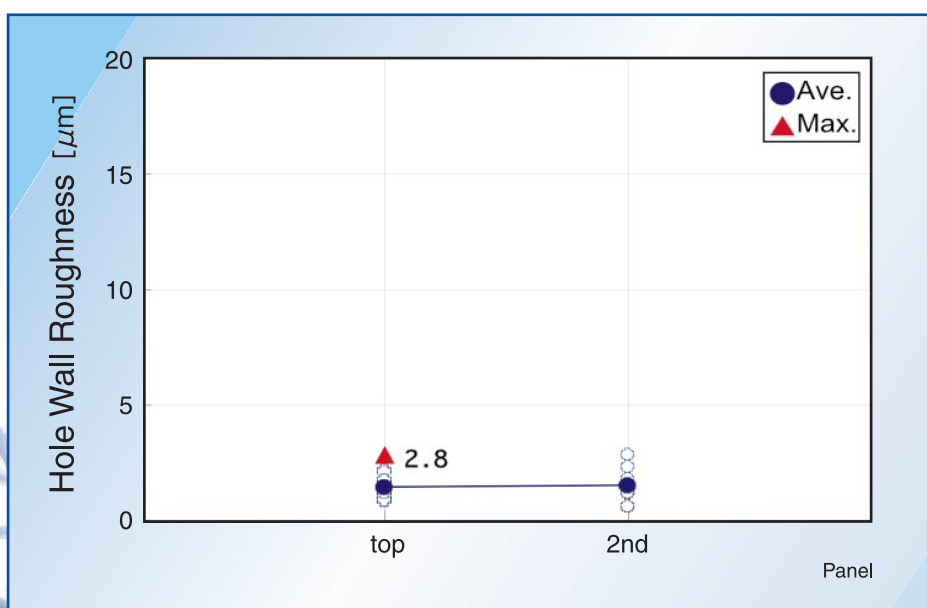


Max < 20 μ m

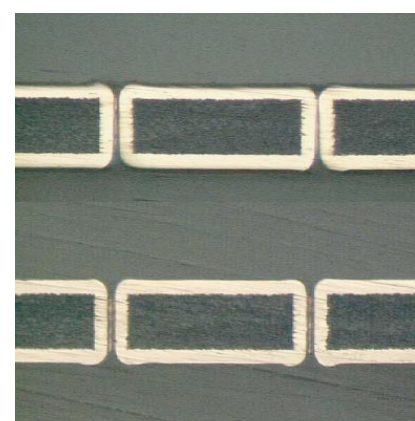


New Distribution Chart

内壁粗さ [Hole Wall Quality after 3,000hits]



Max < 3 μ m



Cross sectional pictures