

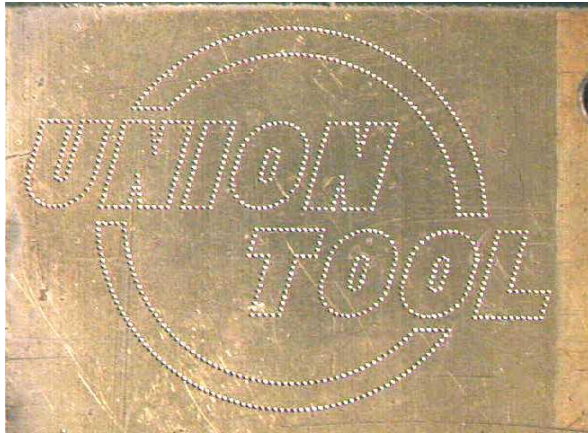
C-UMD 2015-020 Brass drilling example

Tool : 2 flute drill **C-UMD 2015-020 ($\phi 0.15 \times 2$)**
Work material : Brass
Coolant : Water soluble
No. of hole : 780 holes

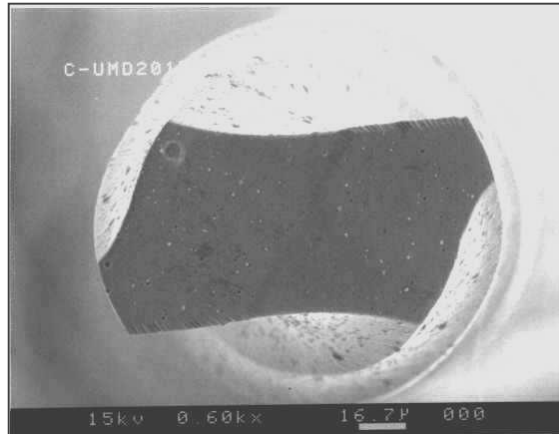
Drilling condition

Process	Tool	Spindle Speed (min^{-1})	Feed Rate (mm/min)	Peck Amount (mm/time)	Hole Depth (mm)	Cycle Time
Pilot hole + chamfer	NEV $\phi 0.25$	16,000	20	0.01	0.07	43min
Drilling	C-UMD $\phi 0.15$	16,000	20	0.03	1.00	2hr30min

Work after 780 holes



Tool after drilling



**Tool wear is small. Even after 780 holes, the tool was not broken.
There is no burr on the surface.**