Drilling example   HAP10(65HRC)

Tool   : C-UMD ϕ1.0 x 10
Work material : HAP10 (65HRC)
Hole depth   : 5 mm
Coolant   : Water soluble

Drilling condition

Spindle Speed (min^{-1})	Feed Rate (mm/min)	Peck Amount (mm/time)	Chip Load (mm/rev)	No. of Hole	Cycle Time (min)
1,600	2	0.05	0.00125	10	111

*50% of spindle speed and 10% of feed rate from catalog condition
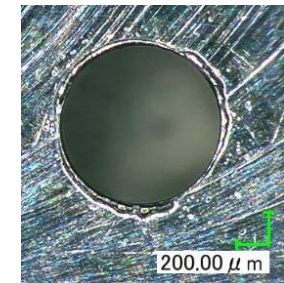 of pre-hardened steels / hardened steels.

Result

Tool after 10 holes

1st hole

10th hole

**Since the tool had large wear,
it is impossible to continue.
Tool life of 10 holes is reasonable.**

UNION TOOL CO.