

Drilling example Titanium alloy(Ti-6Al-4V)

Tool : C-UMD $\phi 1.0 \times 10$
Work material : Ti-6Al-4V
Hole depth : 5 mm
Coolant : Water soluble

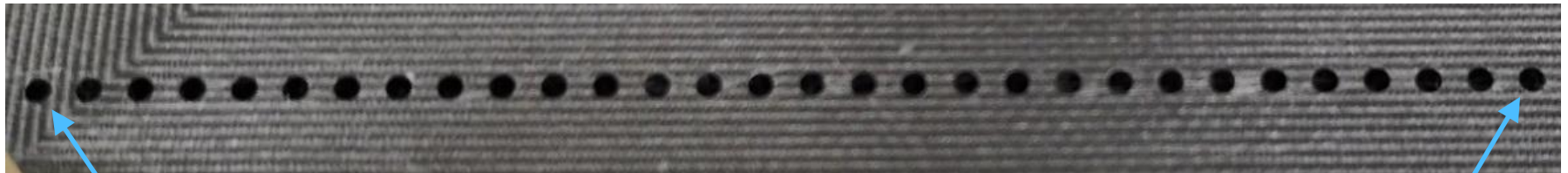
Drilling condition

Spindle Speed (min ⁻¹)	Feed Rate (mm/min)	Peck Amount (mm/time)	Chip Load (mm/rev)	No. of Hole	Cycle Time (min)
6,400	60	0.05	0.0938	30	17.2

*The catalog condition of alloy steels

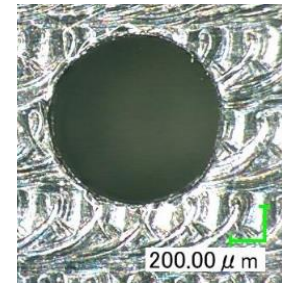
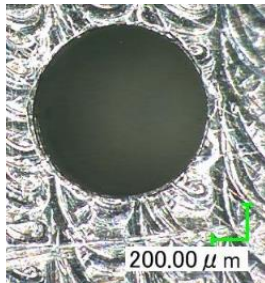
Result

Tool after 30 holes



1st hole

30th hole



**The tool was still available.
It is considered that about 100
holes can be drilled.**