

UDCBF Cemented carbide Indexable insert mold milling

Tool : UDCBF 2010-0070
(R0.5 x 0.7)

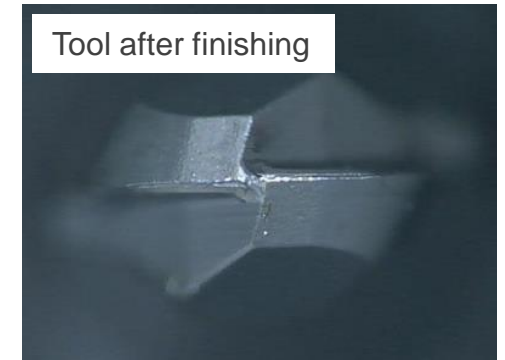
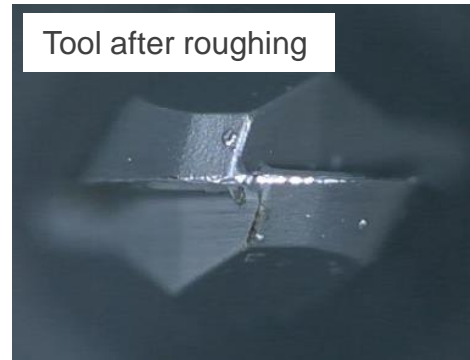
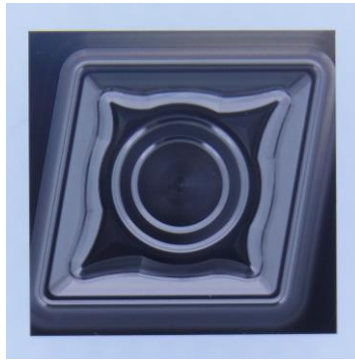
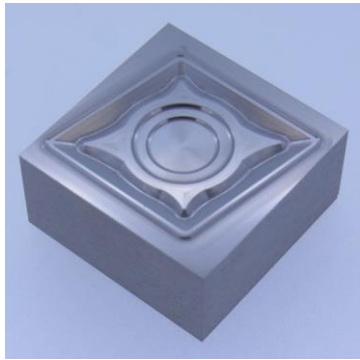
Material : VM-40 (90HRA)

Work size : 20 x 20 x 10 mm

Coolant : Air blow

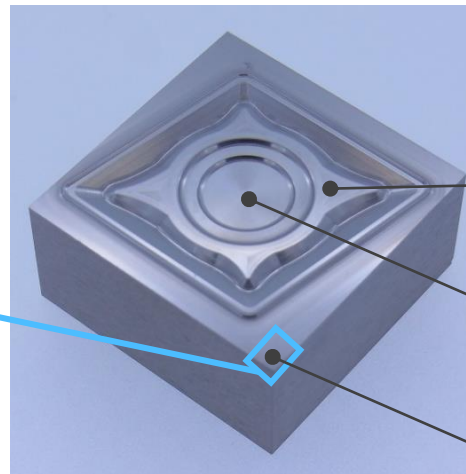
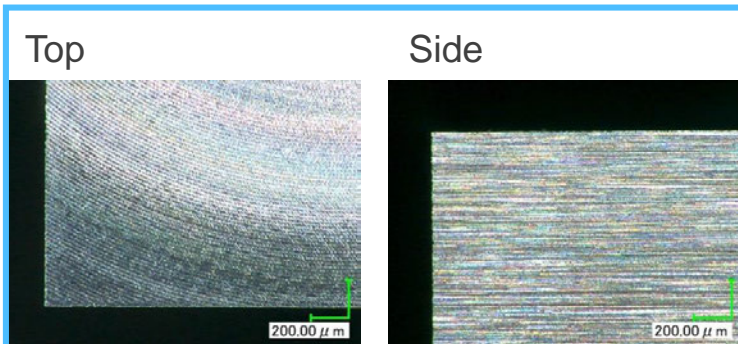
Process	Spindle Speed (min ⁻¹)	Feed Rate (mm/min)	a _p (mm)	a _e (mm)	Cycle time (h:m)	MRV (mm ³)
Roughing	30,000	300	0.05	0.25	0:43	86.3
Finishing	30,000	300	0.028	0.02	2:17	12.0

※One End Mill for both roughing and finishing processes Total 3:00



~ Work sample after finishing ~

Minimized edge chipping



“Excellent surface quality”

Ra: 0.051 μm
Rz: 0.399 μm

Ra: 0.068 μm
Rz: 0.520 μm

Ra: 0.054 μm
Rz: 0.408 μm