

UDCBH Lens shaped milling example

Work material : VM-40 (90 HRA)
 Work size : 50 x 50 x 10 mm
 Pocket size : Top $\phi 10$ x depth 3.5 mm
 MRV : 160 mm³/Pocket
 Coolant : Air blow

UDCBH is...

7.5 times
efficiency

Over 4
times the
removal
volume

Milling condition

Tool	Spindle Speed (min ⁻¹)	Feed Rate (mm/min)	a _p (mm)	a _e (mm)
UDCBH 2020-0140 (R1 x 1.4)	12,000	6,000	0.6	3
UDCBF 2020-0140 (R1 x 1.4)	12,000	6,000	0.7	0.7

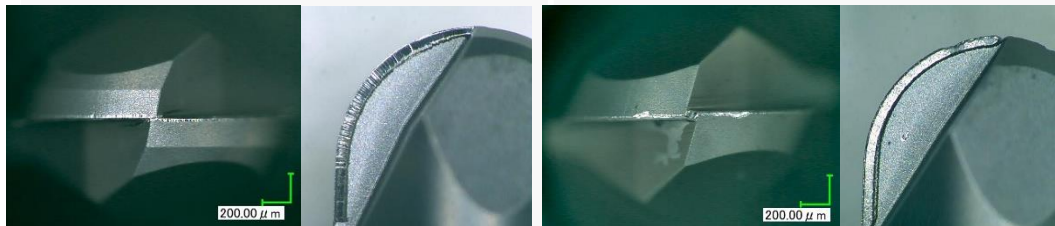
Result

1 side 16 pockets...

1 Tool milling time 76 sec

4 tool milling time 7 hr 28min

Tool after milling
4 pockets



Tool after milling
16 pockets

