

UDCLB Cemented Carbide Hexalobular Shape

Milling Condition

No.	Process	Tool Geometry	Series / Size	Spindle Speed (min ⁻¹)	Feed Rate (mm/min)	a _p (min)	a _e (min)	Milling Depth	Milling Time	MRV
1	Roughing	2-Flute Long Neck Ball	UDCLB R0.5 x L2.5	30,000	300	0.05	0.30	to 3.5mm	58 min	152.8 mm ³
2	Roughing	2-Flute Long Neck Ball	UDCLB R0.5 x L5			0.05	0.25	to 5.997mm	64 min	120 mm ³
3	Finishing					0.03	Finishing allowance 0.005	-	34 min	1.6 mm ³
								Total	156 min	274.4 mm³
									(Roughing	2.2 mm³/min)

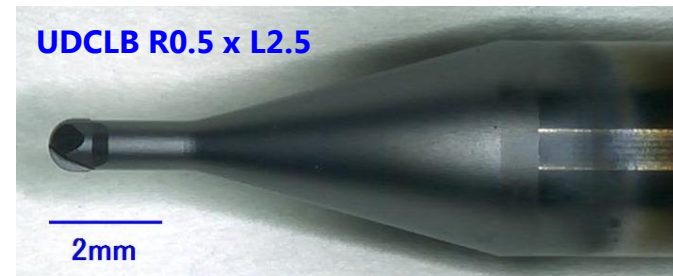
Work material : Super micro grain cemented carbide VF-20 (92.5HRA)

Coolant : Air blow

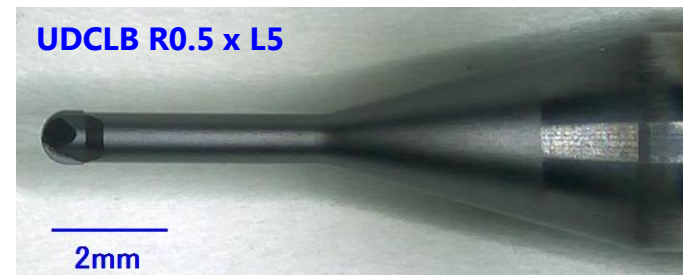
Model

Hexalobular shape

Size: φ9 x Depth 6 mm



•Used L2.5 mm tool for Roughing to depth 3.5mm.



•Used L5 mm tool for Roughing & Finishing.