

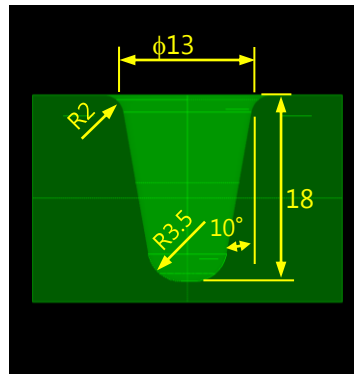
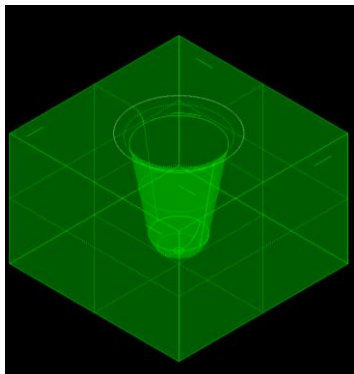
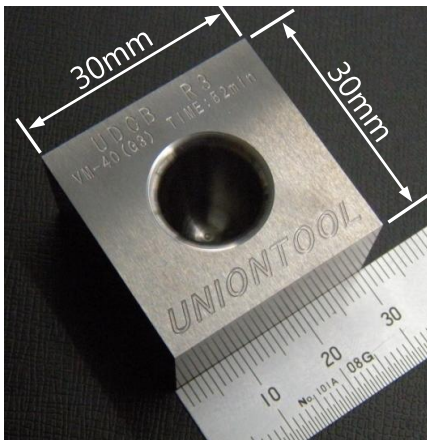
UDCB Cemented Carbide Deep Pocket

Model

Tapered circular pocket

Size: $\phi 13$ x Depth 18 mm Draft: 10°

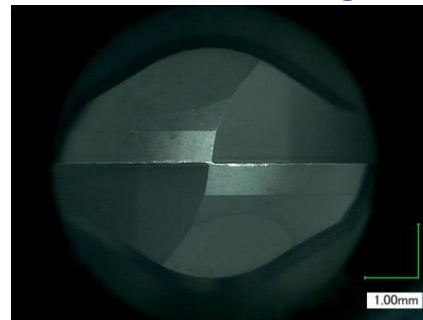
Upper surface: R2 Bottom surface: R3.5



Milling Condition

Tool	2-Flute ball UDCB 2060-0420 (R3 x 4.2)
Work material	Cemented carbide VM-40 (90HRA)
Spindle Speed	20,000 min ⁻¹
Feed Rate	200 mm/min
a _p	0.2 mm
a _e	0.4 mm
Coolant	Air blow
Cycle time	52 min
MRV	1,400 mm³ (1.4cc) 26.9 mm ³ /min

Tool after milling



Removed 1.4cc with one tool!