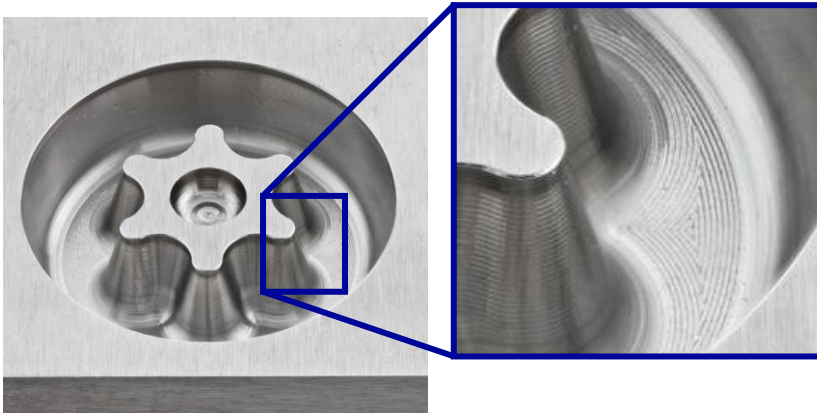


UDCB Cemented Carbide Hexalobular Shape

Model

Hexalobular shape

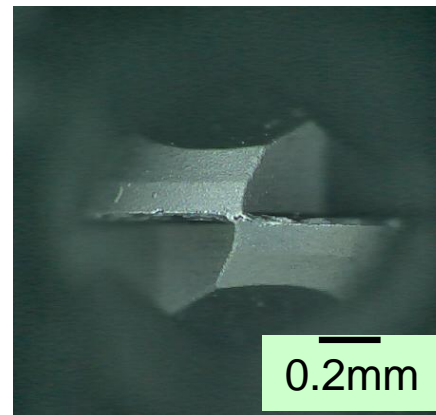
Size: $\phi 9$ x Depth 2.2 mm



Milling Condition

Tool	2-flute ball UDCB 2010-0070 (R0.5 x 0.7)
Work material	Super micro grain cemented carbide VF-20 (92.5HRA)
Spindle Speed	30,000 min ⁻¹
Feed Rate	300 mm/min
a_p	0.05 mm
a_e	0.30 mm (Bottom surface 0.05 mm)
Coolant	Oil mist
Cycle time	39 min
MRV	91.7 mm ³ (2.35 mm ³ /min)

Tool after milling



**MRV 0.091cc with
R0.5 tool!**