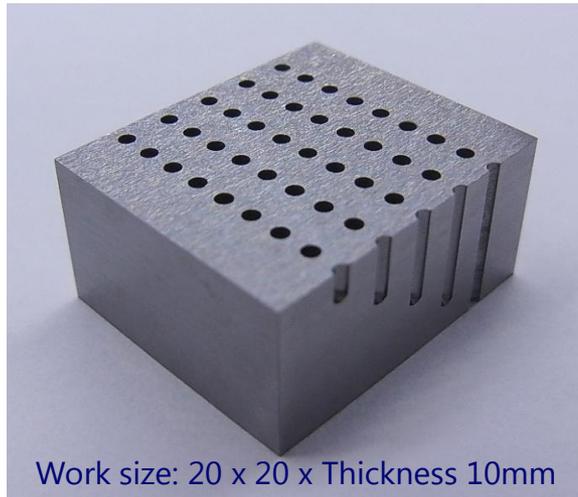


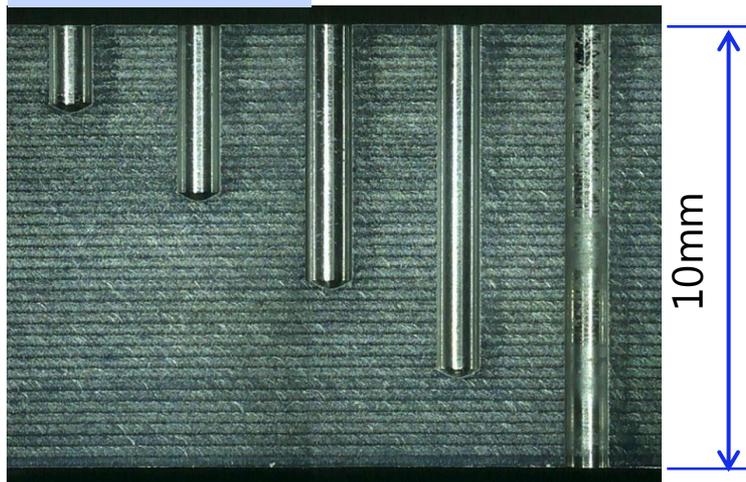
UDCMX Drilling Cemented Carbide ($\phi 1$)

Tool: 2-flute drill UDCMX 2100-100 ($\phi 1 \times 10$)



Work material	Cemented carbide VM-40 (90HRA)
Spindle Speed	20,000 min ⁻¹
Feed Rate	7.5 mm/min
Peck amount	0.1 mm
Hole	Depth: 2, 4, 6, 8 mm and through hole (Drilled 5 holes on each depth with single tool. Total 25 holes.)
Coolant	Air blow (Nozzle)
Cycle time	25 holes / about 43 min 50 holes / about 1 hr 26 min

Cross section



Tool after drilling 25 holes

