

# UDCLRS

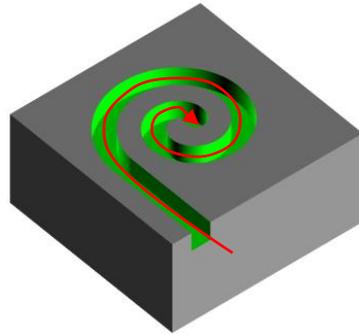
## Spiral Slotting on Cemented Carbide

### Milling shape

Slotting Milling depth: 2 mm  
Work size: 20 x 20 x Height 10 mm



### Milling path



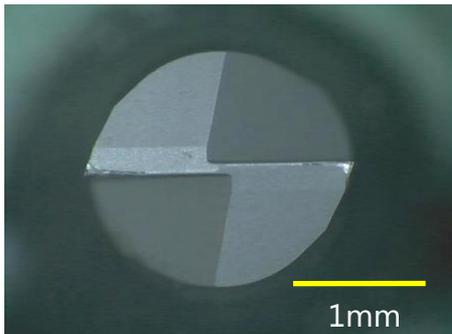
### Milling condition

Tool : 2-flute long neck radius  
UDCLRS  $\phi 2 \times CR0.05 \times L2$   
(Used 1 pc. each for roughing & finishing)  
Work material : Cemented carbide VM-40 (90HRA)

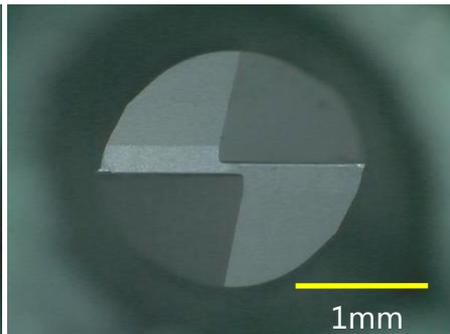
Process	Roughing	Finishing
Spindle Speed ( $\text{min}^{-1}$ )	20,000	20,000
Feed Rate (mm/min)	185	185
$a_p$ (mm)	0.02	0.01 (Bottom finishing allowance)
Coolant	Air blow	Air blow
MRV ( $\text{mm}^3$ )	196	
Cycle time (min)	33	

### Tool appearance

After roughing



After finishing



### Entering part appearance

