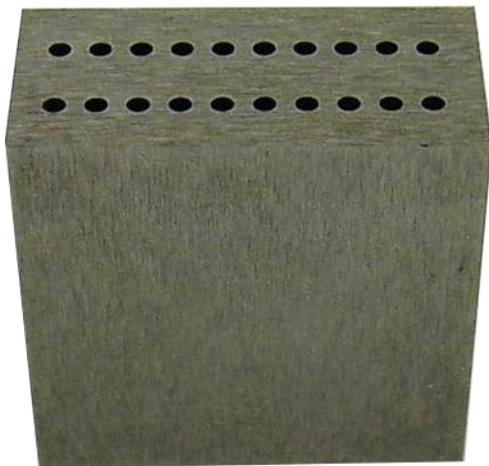


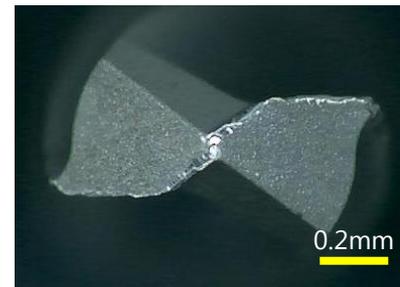
UDCMX Drilling on Cemented Carbide ($\phi 1.0$ Long Flute)

Tool: 2-flute drill UDCMX $\phi 1$ x 22 (Special)



Work size: 20 x 10 x t 20 mm

| | |
|---------------|--|
| Work material | Cemented carbide VM-40 (90HRA) |
| Spindle Speed | 5,000 min ⁻¹ |
| Feed Rate | 7.5 mm/min |
| Peck amount | 0.2 mm |
| Coolant | Air blow (Nozzle) |
| Hole | Depth 20 mm x 20 through holes |
| Cycle time | 1 hr 38 min / 20 holes (5 min / 1 hole) |



Tool after drilling 20 holes