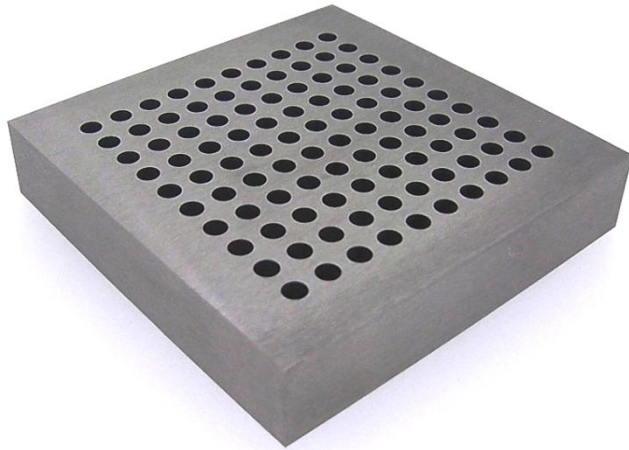
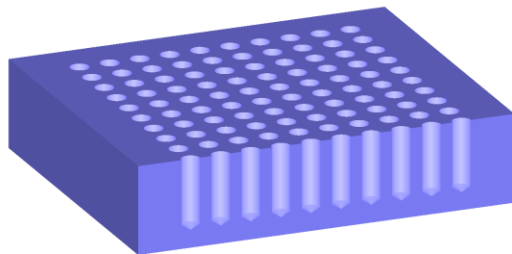


UDCMX Drilling Cemented Carbide ($\phi 2.5$)

Tool: 2-flute drill UDCMX 2250-100 ($\phi 2.5 \times 10$)

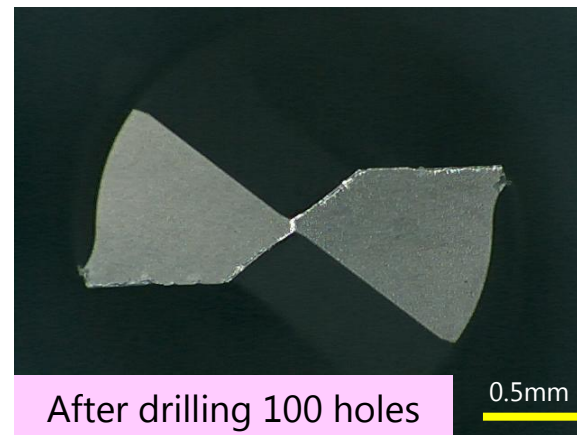


Work size: 50 x 50 x t 10mm



Sectioned image

Work material	Cemented carbide VM-40 (90HRA)
Spindle Speed	2,000 min ⁻¹
Feed Rate	5 mm/min
Peck amount	0.5 mm
Coolant	Air blow (Nozzle)
Hole	Depth 8 mm x 100 blind holes
Hole pitch	4 mm
Cycle time	3 hr 23 min / 100 holes (2 min 2 sec / 1 hole)



After drilling 100 holes

0.5mm