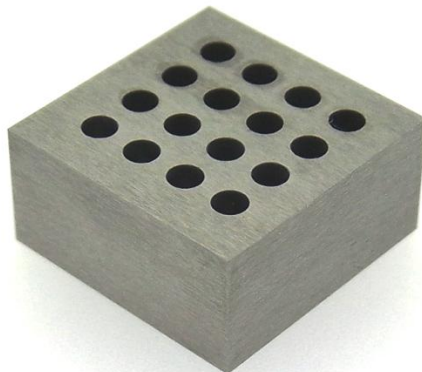


UDCT Threading Cemented Carbide

Tool: 2-flute drill UDCMX 2250-100 ($\phi 2.5 \times 10$)
2-flute thread mill UDCT M3-0.5-6 (M3 x L6 P0.5)
Work material: Cemented carbide VM-40 (90HRA)

Process	Prepared hole	Threading
Spindle Speed	2,000 min ⁻¹	20,000 min ⁻¹
Feed Rate	5 mm/min	3 mm/min
Peck amount	0.5 mm	—
Coolant	Air blow (Nozzle)	Air blow (Nozzle)
Hole	Depth 8 mm x 16 blind holes	Depth 6 mm x 16 holes
Cycle time	32 min 39 sec / 16 holes (2 min 2 sec / 1 hole)	2 hr 28 min / 16 holes (9 min 15 sec / 1 hole)

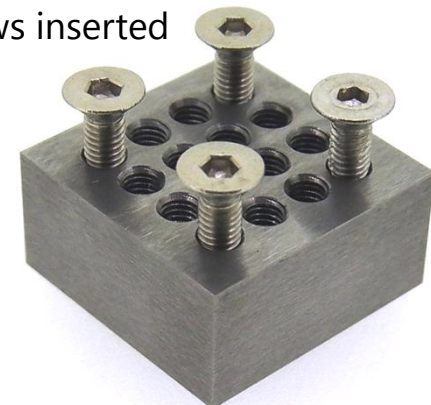
Prepared hole



Threading



Screws inserted



Work material: 20 x 20 x t 10mm