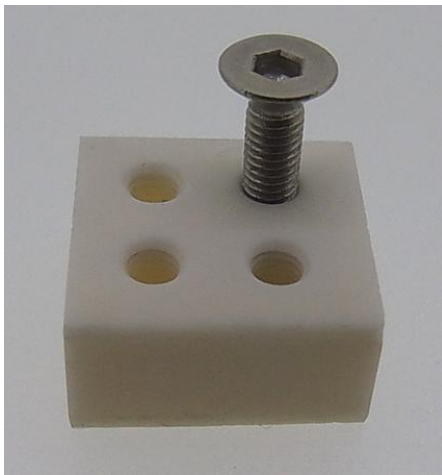


UDCT Threading Ceramics

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: Alumina (Al_2O_3)



Work size: 20 x 20 x t 10mm

Process	Prepared hole	Threading
Spindle Speed	2,000 min ⁻¹	20,000 min ⁻¹
Feed Rate	5 mm/min	3 mm/min
Peck amount	0.1 mm	—
Coolant	Water-soluble	Water-soluble
Hole	Depth 6 mm x 4 blind holes	Depth 6 mm x 4 holes
Cycle time	3 min 27 sec / 1 hole	8 min 30 sec / 1hole