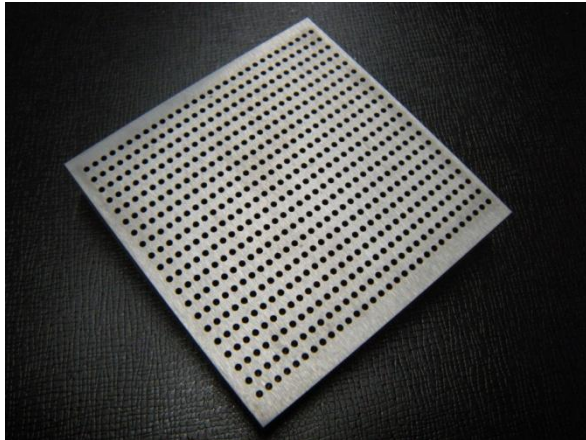


UDCMX Cemented Carbide 600 Holes Drilling ($\phi 1$)

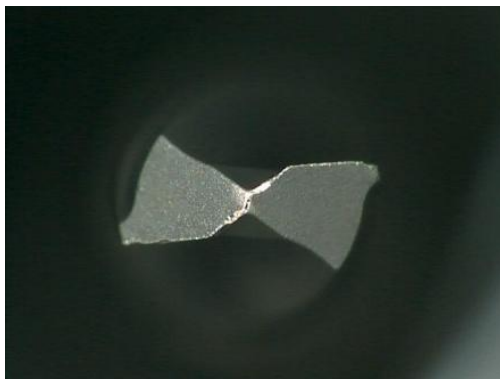
Tool : 2-flute drill UDCMX 2100-100 ($\phi 1$ x Flute length 10mm)
Work material : Cemented carbide VM-40 (90HRA)



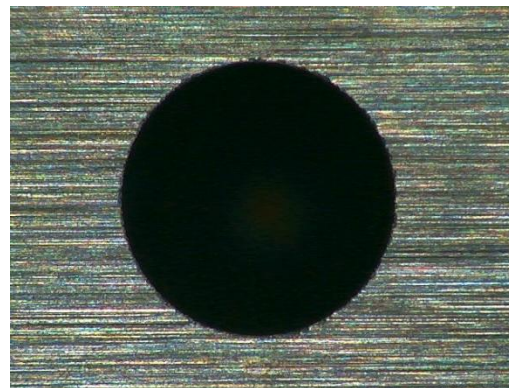
Work size: 50 x 50 x t 10 mm

Drilling detail	Single-shot drilling (200hole/tool)
Spindle Speed	5,000 min ⁻¹
Feed Rate	7.5 mm/min
Step	Single-shot drilling
Coolant	Air blow (Nozzle)
Hole	Depth 8 mm x 600 blind holes
Hole pitch	X 2.3 mm, Y 1.6 mm
Cycle time	11 hr 40 min / 600 holes (1min 10 sec / hole)

Used 3 tools for 600 holes

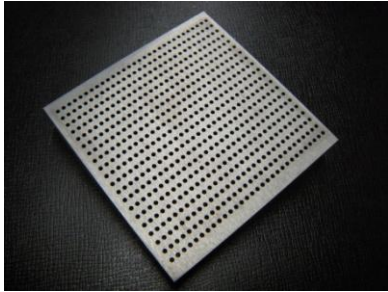


Tool after 200 holes



200th hole

UDCMX Cemented Carbide 600 Holes Drilling ($\phi 1$)

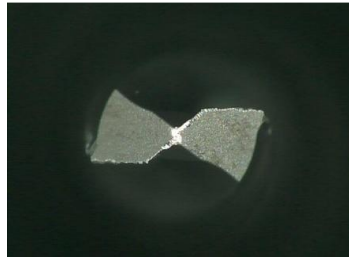


**Tool : 2-flute drill UDCMX 2100-100
($\phi 1$ x Flute length 10mm)**

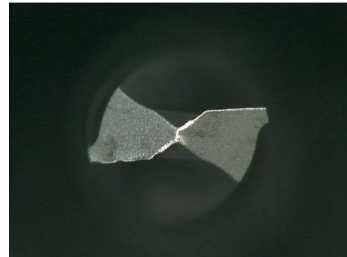
Work material : Cemented carbide VM-40 (90HRA)

Work size:
50 x 50 x t 10 mm

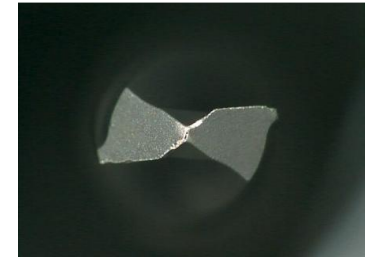
Drilling detail	Step drilling (100 holes / tool)	Single-shot drilling (100 holes / tool)	Single-shot drilling (200 holes / tool)
Spindle Speed (min^{-1})	5,000		
Feed Rate (mm/min)	7.5		
Peck amount (mm)	0.1	Single-shot	
Coolant	Air blow (Nozzle)		
Hole	Depth 8 mm x 600 blind holes		
Hole pitch	X 2.3 mm, Y 1.6 mm		
Cycle time	31 hr 10 min / 600 holes (3 min 7 sec / hole)	11 hr 40 min / 600 holes (1 min 10 sec / hole)	11hr 40min / 600 holes (1 min 10 sec / hole)
Qtys of used tool / 600 holes	6	6	3



Tool after 100 holes



Tool after 100 holes



Tool after 200 holes