

UDCT Threading Cemented Carbide

Tool: Prepared hole process 2-flute long neck ball UDCLB 2060-1500 (R3 x L15)

2 for roughing, 1 for chamfering & finishing

Threading process 2-flute thread mill UDCT M8-1.25-16 (M8 x L16 P1.25)

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

Process	Prepared hole (Helical drilling)	Threading
Spindle Speed	8,000 min ⁻¹	5,300 min ⁻¹
Feed Rate	50 mm/min	30 mm/min
Z moving rate	Roughing: 0.1 mm/1 round Finishing (Zero cut): 0.3 mm/1 round	1.25 mm/1 round
Coolant	Air blow (Nozzle)	Air blow (Nozzle)
Hole	Through hole $\phi 6.8$ Depth 10 mm x 16 holes	Depth 10 mm x 16 holes
Cycle time	152 min /16 holes (9 min 30 sec / hole)	48 min / 16 holes (3 min / hole)

After prepared hole process



After threading process



Screws inserted



Work size: 50 x 50 x t 10 mm