

UDCLB/UDCLBF Cemented Carbide Mold



Cemented carbide mold (Bevel gear)

- Work material : Cemented carbide **RT55** (83HRA, CIS Standard: VU-70)
- Milling size : $\phi 44 \times 12.75$ mm
- Coolant : Air blow
- Machine : YASDA YBM640V Ver.III
- CAD/CAM : C&G SYSTEMS **CAM-TOOL**

**Used 16 pcs
Completed in 15hr**

Process	Tool Geometry	Series / Size	Spindle Speed (min ⁻¹)	Feed Rate (mm/min)	Axial Depth a _p (mm)	Radial Depth a _e (mm)	Stock (mm)	No. of pcs	Milling Time
Roughing 1	2-Flute Long Neck Ball	UDCLB R2xL8	8,250	300	0.5	0.2	0.03	3	2:12:31
	"	UDCLB R2xL10	8,250	300	0.5	0.2	0.03	2	0:29:24
Roughing 2	"	UDCLB R1.5xL6	11,000	280	0.38	0.15	0.03	1	0:22:33
	"	UDCLB R1.5xL10	11,000	280	0.3	0.15	0.03	1	0:23:27
Semi-finishing	"	UDCLB R1.5xL10	11,000	280	(0.005)	—	0.015	1	1:08:35
	"	UDCLB R1.5xL10	11,000	280	(0.002)	—	0.005	1	1:36:52
Corner finishing	"	UDCLB R1xL6	16,500	420	0.12	0.05	0.015	1	0:52:28
	"	UDCLB R1xL8	16,500	420	0.12	0.05	0.015	1	0:49:56
	"	UDCLB R1xL8	16,500	420	0.09	—	0.005	1	1:09:32
Finishing	2-Flute High-Grade Long Neck Ball	UDCLBF R1xL8	20,000	200	—	0.12	0	1	0:41:20
	"	UDCLBF R1xL8	20,000	200	(0.001)	—	0	2	3:39:54
	"	UDCLBF R1xL8	20,000	200	0.09	—	0	1	0:34:00
	"	UDCLBF R1xL8	20,000	200	—	0.08	0	1	1:04:00

Total 16 15:04:32

Cooperation with: **CAM-TOOL**
CAD/CAM System for Molds & Dies