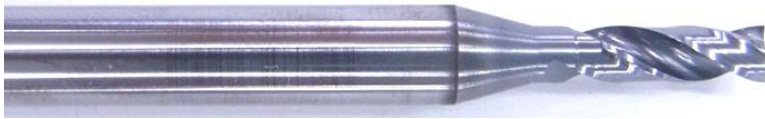


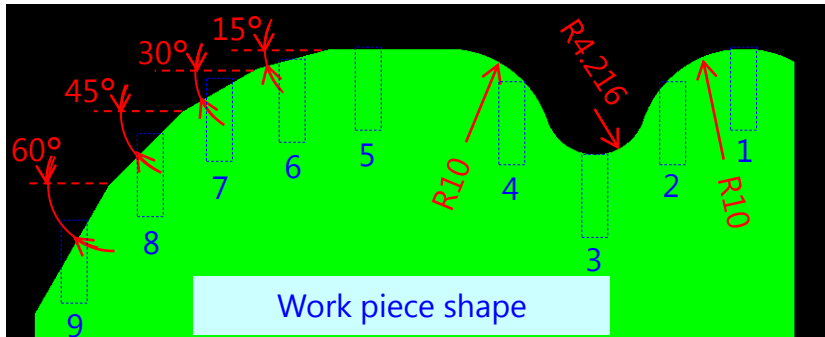
UTDF Drilling on Structural Steel – SS400

UTCOAT
for low hardness material

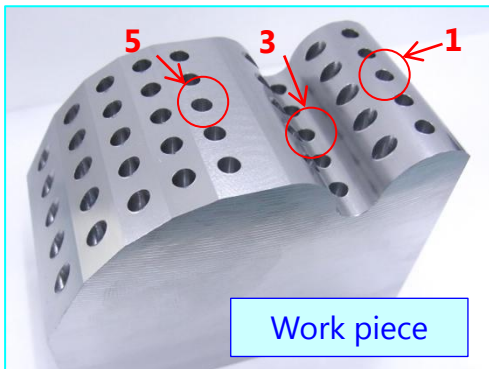


Tool : 2-flute flat drill UTDF
 φ3.5 x Flute length 14mm
 Work material : Rolled structural steel SS400
 Coolant : Water-soluble cutting oil (Nozzle)

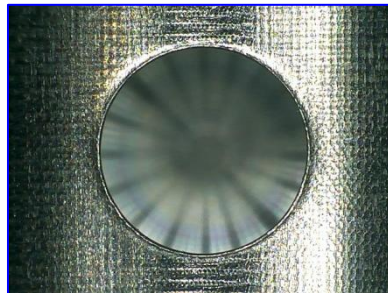
Drilling on flat, inclined and curved surface of SS400
 >> Excellent drilling performance with less burr



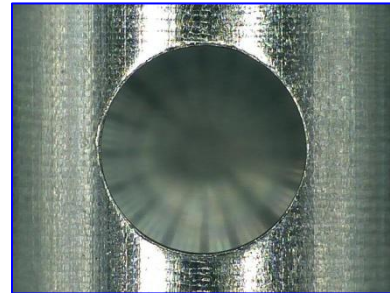
Drilling spot	Surface	Spindle speed min ⁻¹	Feed rate mm/min	Milling depth (the deepest spot) mm
1	Convex surface (the apex)	7000	450	7
2	Curved surface (45°)		270	
3	Concave surface (the apex)		450	
4	Curved surface (45°)		270	
5	Flat surface		450	
6	Curved surface (15°)		320	
7	Curved surface (30°)		320	
8	Curved surface (45°)		270	
9	Curved surface (60°)		225	



Hole No.1



Hole No.3



Hole No.5

