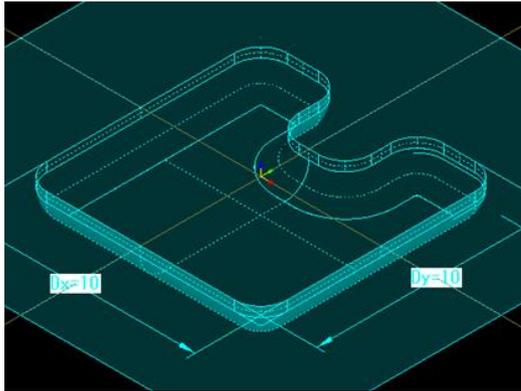


UDCB Milling Quartz Glass

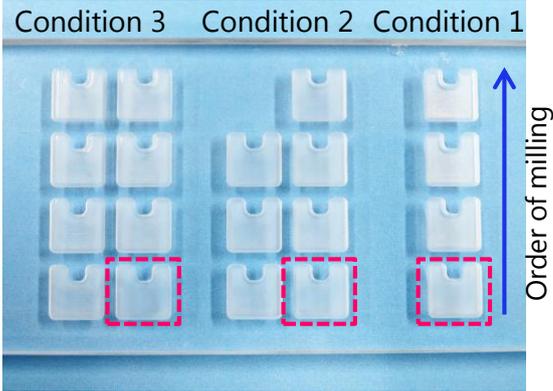


Tool : 2-Flute Ball **UDCB 2020-0140** (R1 x 1.4)
 Work material: Quartz glass
 Milling size : 10 x 10 x 1.4 mm
 Coolant : Water-soluble

Milling condition

Condition No.	Spindle Speed (min ⁻¹)	Feed Rate (mm/min)	a _p (mm)	a _e (mm)	Approx. milling time	Qty. of milled pocket	MRV (mm ³)
1	20,000	200	0.1	0.1	45 min	4	436
2	20,000	200	0.1	0.3	18 min	7	812
3	20,000	200	0.15	0.4	10 min	8	928

Over **800 mm³** by R1!



Finished surface of 1st pocket (applied water)



Condition 3

Condition 2

Condition 1

Tool appearance after milled 4th pocket under condition 3

