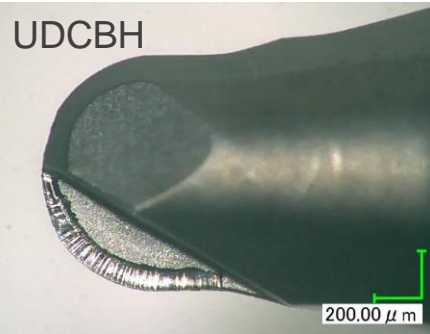
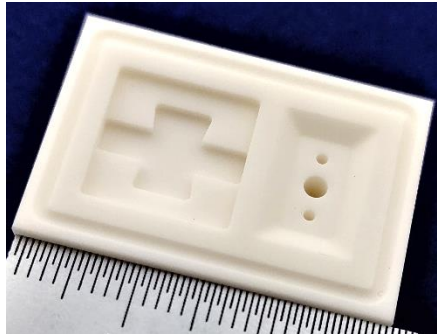


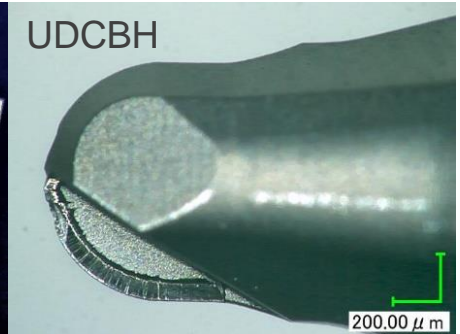
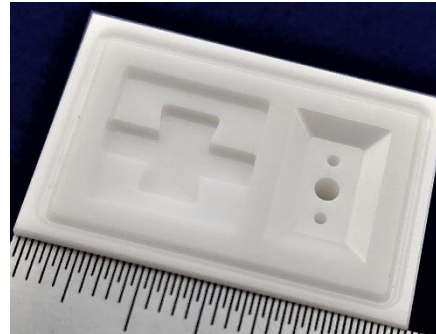
UDCBH Hard brittle materials electronic component assembly jig shaped milling

Work material : Alumina Al₂O₃ (99.5%), Zirconia ZrO₂ (94%)
 Work size : 30 x 20 x 10 mm
 Coolant : Water soluble

Alumina Al₂O₃ (99.5%)



Zirconia ZrO₂ (94%)



No.	Process	Tool	Spindle Speed (min ⁻¹)	Feed Rate (mm/min)	a _p (mm)	a _e (mm)	Allowance (mm)	Cycle time
1	Slotting and inclined pocket roughing	UDCBH 2010-0070 (R0.5 x 0.7)	30,000	300	0.05	0.25	0.01/0.03	0:36:29
2	Slot finishing						0	0:19:17
3	2-stage pocket roughing	UDCLBF 2010-0200 (R0.5 x EL2)	30,000	300	0.028	0.028	0.03	0:52:42
4	Re-machining	UDCLRSF 2008-005024 (φ0.8 x CR0.05 x EL2.4)	30,000	175	0.023	0.5	0.03	0:18:26
5	Semi-finishing				0.02	0.25	0.01	0:51:09
6	Finishing				0.014	0.25	0	1:12:32
7	Drilling	UDCMX 2200-100 (φ2 x 10)	2,400	5	0.15	-	-	0:03:15
8	Drilling	UDCMX 2100-100 (φ1 x 10)	5,000	7.5	0.05	-	-	0:10:44

Total 4:24:34