

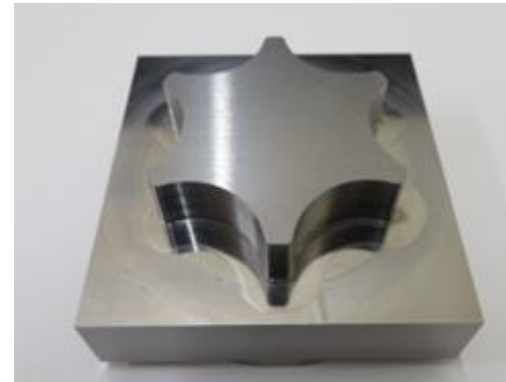
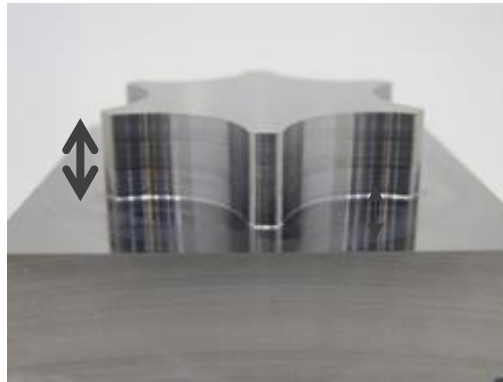
UDCRRS Punching die milling example

Tool : UDCRRS $\phi 4$ x CR0.2 x EL10
Work material : VM-40 (90HRA)
Size : 50 x 50 x 9 mm
Coolant : Air blow
Cycle time : 93 min

~ Milling condition ~

Spindle Speed (min ⁻¹)	Feed Rate (mm/min)	a_p (mm)	a_e (mm)
15,000	375	3	0.25

“ Depth 9 mm ”
Ap 3 mm × 3 times



~ Tool after milling ~



**Milling volume 15,953 mm³ with a single tool in 93 min.
Tool damage is limited and continuous cutting is possible.**