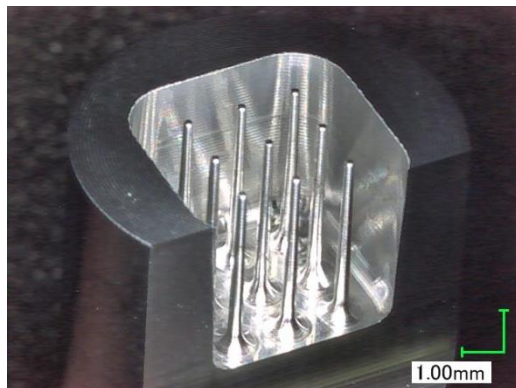
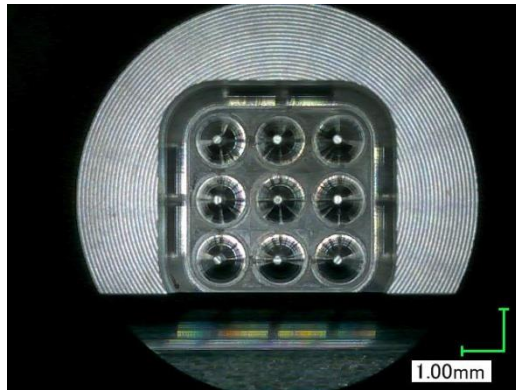


UDCLB Cemented Carbide Micro Needles

Model

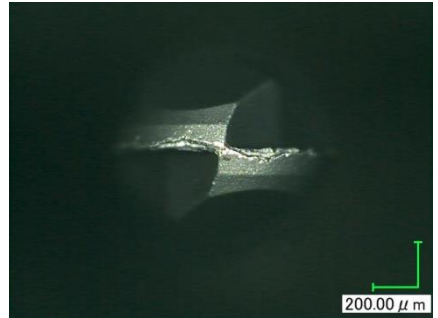
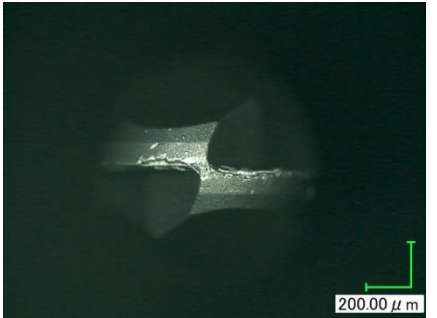
Micro needles

Size: 6 x 6 x Depth 5.0 mm



Milling Condition

Work material: Super micro grain cemented carbide VF-20 (92.5HRA)

No.	1 (To depth 2.5 mm)	2 (To depth 5.0 mm)
Tool	2-Flute Long Neck Ball UDCLB 2010-0500 (R0.5 x L5) Used 1 pc. each for No. 1 & 2, total 2 pcs.	
Spindle Speed n	30,000 min ⁻¹	
Feed Rate Vf	300 mm/min	
a _p	0.1 mm	
a _e	0.05 mm	0.05 mm (Bottom surface 0.02 mm)
Milling Time	52 min	39 min
MRV	80.1 mm ³	76.5 mm ³
Coolant	Air blow	
Tool after milling		

Note: Used 1 pc. of UDCLB 2030-0800 (R1.5 x L8) to cut off and remove the wall.
Milling time: 29 min n=27,500 min⁻¹ Vf=275 mm/min a_p=0.125 mm a_e=0.33 mm