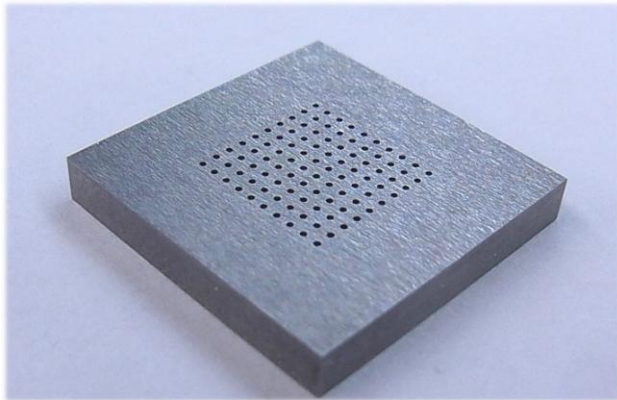


UDCMX

Single-shot Drilling to Cemented Carbide

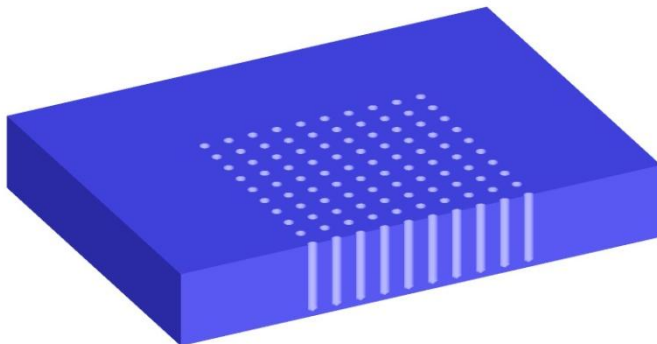
Tool: 2-flute drill UDCMX 2040-040 ($\phi 0.4 \times 4$)



Work size: 20 x 20 x Thickness 3mm

Work material	Cemented carbide VM-40 (90HRA)
Spindle Speed	20,000 min ⁻¹
Feed Rate	5 mm/min
Peck amount	Single-shot
Coolant	Air blow (Nozzle)
Hole	Depth 2.8 mm x 100 blind holes
Hole pitch	1 mm
Cycle time	100 holes / 1 hour (36 sec / 1 hole)

Sectioned image



Tool after drilling 100 holes

