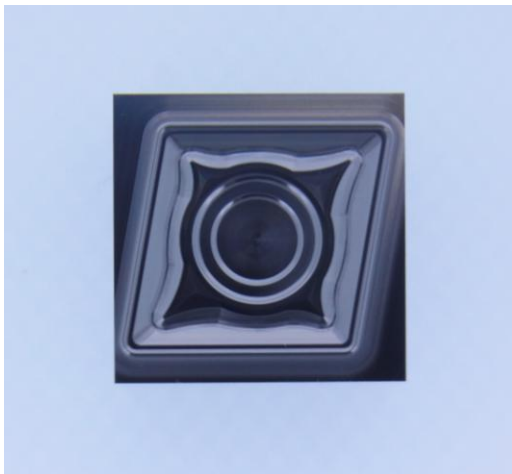
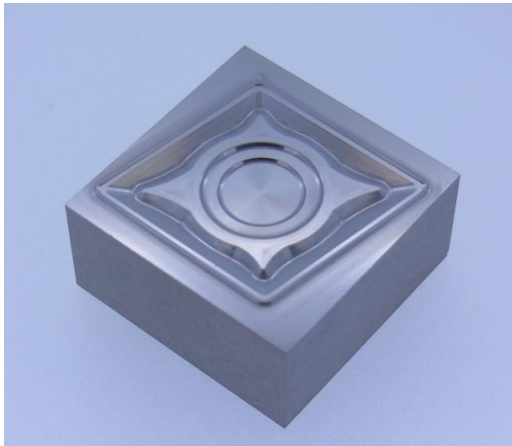


# UDCBF Cemented Carbide Carbide Insert

**Tool : 2-flute high-grade ball UDCBF 2010-0070 (R0.5 x 0.7)**  
**Work material : Cemented carbide VM-40 (90HRA)**



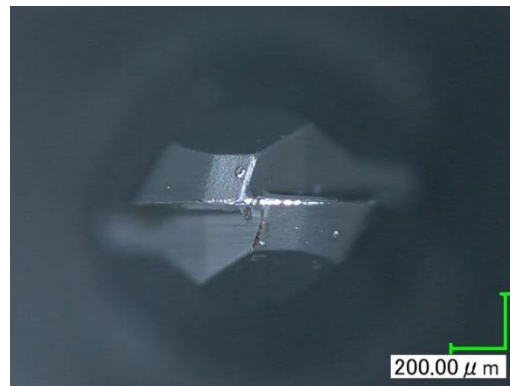
Work size: 20 x 20 x t 10 mm

Process	Roughing	Finishing
Tool	UDCBF R0.5 x 0.7	
Spindle Speed	30,000 min <sup>-1</sup>	
Feed Rate	300 mm/min	
Axial Depth	0.05 mm	0.028 mm
Radial Depth	0.25 mm	0.02 mm
Coolant	Air blow (Nozzle)	
MRV	86.3 mm <sup>3</sup>	12.0 mm <sup>3</sup>
Cycle time	43 min	2 hr 17 min

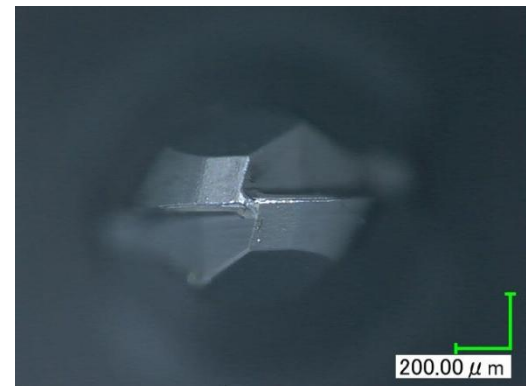
Total: 98.3 mm<sup>3</sup>

Total: 3 hr

Used single tool for each process



Tool after roughing



Tool after finishing