

UDCT Threading Ceramics

Tool: 2-flute drill UDCMX 2330-120 (ϕ 3.3 x Flute length 12mm)
2-flute long neck ball UDCLB 2030-0600 (R1.5 x L6)
2-flute thread mill UDCT M4-0.7-8 (M4 x L8 P0.7)
Work material: Zirconia ZrO₂ (3Y)



Work size:
15.5 x 16 x t 10 mm

Process	Prepared hole	Chamfering	Threading
Tool	UDCMX 2330-120	UDCLB 2030-0600	UDCT M4-0.7-8
Spindle Speed (min ⁻¹)	1,500	20,000	15,500
Feed Rate (mm/min)	5	20	3
Peck amount (mm)	0.3	-	-
Depth (mm)	8 (Blind hole)	0.8	6
Coolant	Water-soluble (Nozzle)	Air blow (Nozzle)	Water-soluble (Nozzle)
Cycle time	2 min 51 sec / hole	2 min 59 sec / hole	9 min 58 sec / hole