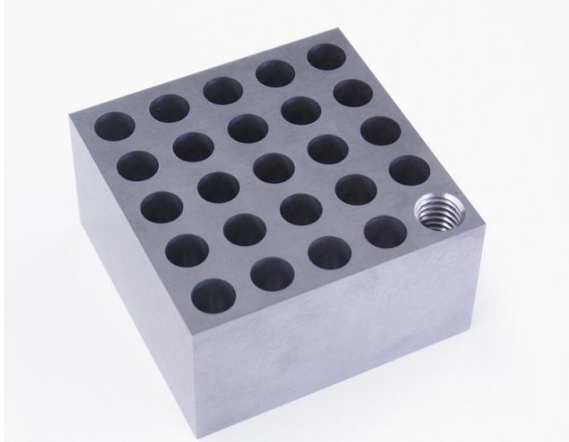


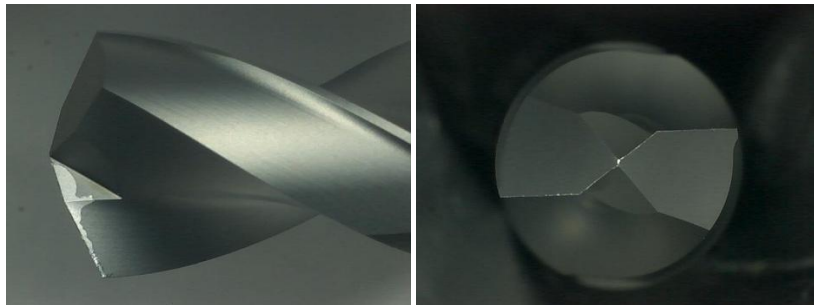
UDCMX Drilling Cemented Carbide

Drilling + Threading on Cemented Carbide UDCMX ($\phi 6.8$ x flute length 25mm) 25 holes + UDCT (M8) 1 hole



Work material:
Cemented carbide
VM-40 (90 HRA)

Work size:
50 x 50 x 25 mm



- More tool life left after drilling 25 holes with UDCMX 6.8mm.
- MRV=17,000 mm³ within 1 hour

Conditions		
Process	Single-shot drilling	Threading
Tool geometry	2-Flute Drill	2-Flute Thread Mill
Series / Size	UDCMX $\phi 6.8 \times 25$	UDCT M8xL24 (P1.25)
n (min ⁻¹)	4,000	3,500
Vf (mm/min)	12	20
Overhang L. (mm)	35	30
Coolant	Nozzle air blow	
Hole	Blind hole 20 mm depth x 25 holes	17.5 mm depth x 1 hole
Cycle time / hole	1 min 56 sec	5 min 36 sec