

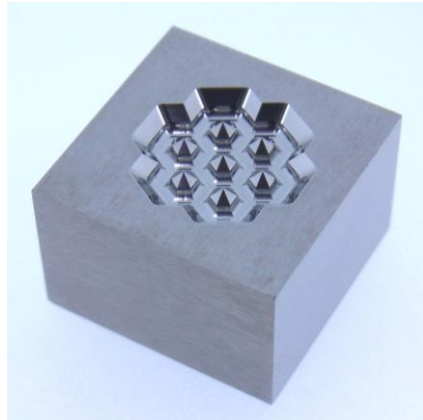
UPDLB

Finishing on Cemented Carbide

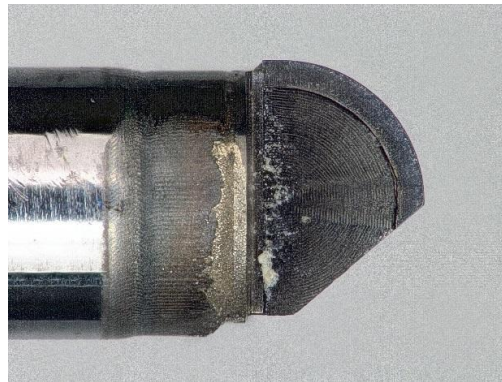
UPD Series



Tool for finishing : Single-flute long neck ball **UPDLB R0.5 x L2**
 Model : Hexagonal pyramid shape
 Work material : Cemented carbide VF-20 (92.5HRA)



Tool after finishing



Milling area: 10.2 x 10.2 x Depth 1.4 mm
 (Work size: 20 x 20 x 10 mm)

Process	Tool Geometry	Series / Size	Spindle Speed (min ⁻¹)	Feed Rate (mm/min)	a _p (mm)	a _e (mm)	Finishing Allowance (mm)	Coolant	Cycle Time
Roughing	2-flute high grade ball	UDCBF R0.5 x 0.7	30,000	300	0.05	0.25	0.005	Air blow	30 min
Semi-finishing			30,000	300	0.001 (Cusp height)	0.06321	0.005		12 min
Finishing	Single-flute long neck ball	UPDLB R0.5 x L2	40,000	400	0.0035	0.00495	0	Oil mist	1 hr 30 min