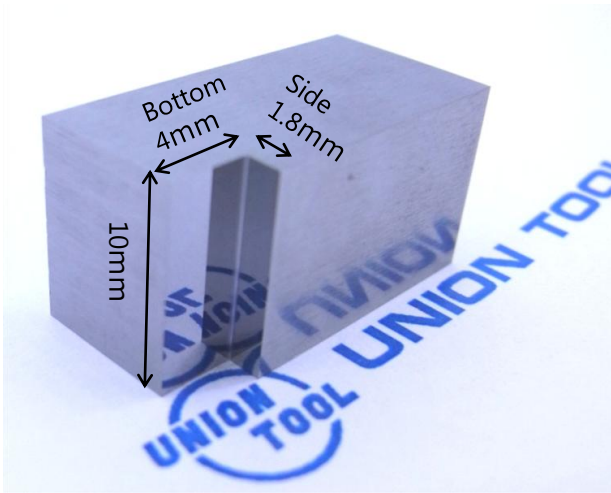


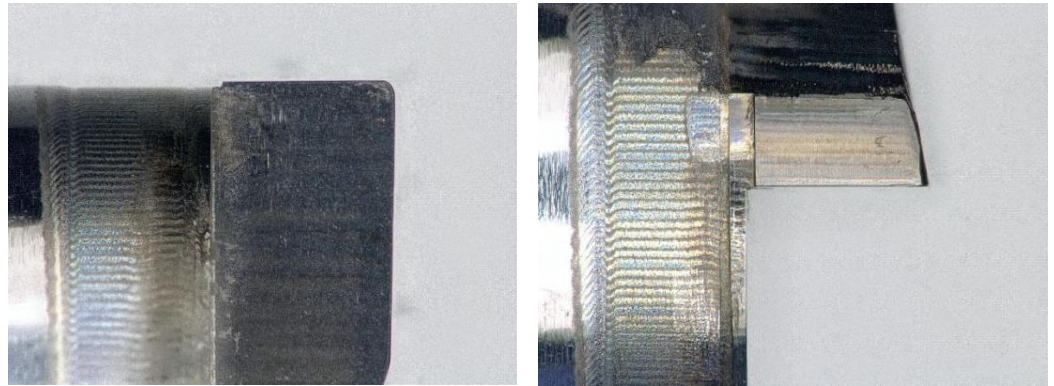
UPDLRS

Finishing on Cemented Carbide

Tool for finishing : Single-flute long neck radius **UPDLRS $\phi 2 \times CR0.05 \times L4$**
 Work material : Cemented carbide VF-20 (92.5HRA)



Tool after finishing



Milling area: 4 x 10 x Depth 1.8 mm
 (Work size: 10 x 10 x 20 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 long neck radius	UDCLRSF $\phi 2 \times CR0.05 \times L2$	20,000	400	0.9 x twice	0.01	0.005		54 min
Finishing (bottom)	Single-flute long neck radius	UPDLRS $\phi 2 \times CR0.05 \times L4$	40,000	600	0.01	0.005	0	Air blow	45 min
Finishing (side)			40,000	400	0.002	0.01	0		52 min