

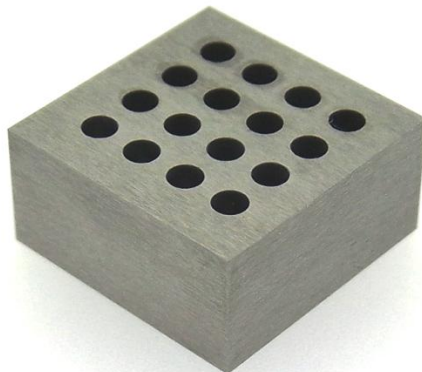
UDCT

Threading Cemented Carbide

Tool: 2-flute drill UDCMX 2250-100 (ϕ 2.5 x 10)
2-flute thread mill UDCT M3-0.5-6 (M3 x L6 P0.5)
Work material: Cemented carbide VM-40 (90HRA)

Process	Prepared hole	Threading
Spindle Speed	2,000 min ⁻¹	20,000 min ⁻¹
Feed Rate	5 mm/min	3 mm/min
Peck amount	0.5 mm	—
Coolant	Air blow (Nozzle)	Air blow (Nozzle)
Hole	Depth 8 mm x 16 blind holes	Depth 6 mm x 16 holes
Cycle time	32 min 39 sec / 16 holes (2 min 2 sec / 1 hole)	2 hr 28 min / 16 holes (9 min 15 sec / 1 hole)

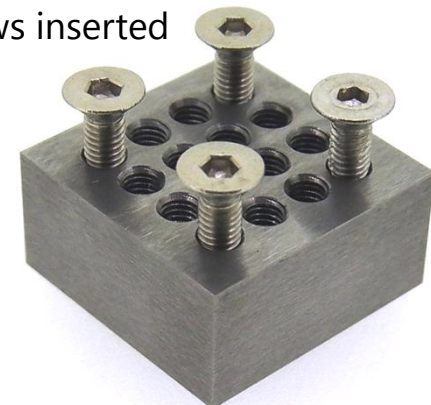
Prepared hole



Threading



Screws inserted



Work material: 20 x 20 x t 10mm

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Tool: Prepared hole process 2-flute long neck ball UDCLB 2060-1500 (R3 x L15)

2 for roughing, 1 for chamfering & finishing

Threading process 2-flute thread mill UDCT M8-1.25-16 (M8 x L16 P1.25)

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

Process	Prepared hole (Helical drilling)	Threading
Spindle Speed	8,000 min ⁻¹	5,300 min ⁻¹
Feed Rate	50 mm/min	30 mm/min
Z moving rate	Roughing: 0.1 mm/1 round Finishing (Zero cut): 0.3 mm/1 round	1.25 mm/1 round
Coolant	Air blow (Nozzle)	Air blow (Nozzle)
Hole	Through hole $\phi 6.8$ Depth 10 mm x 16 holes	Depth 10 mm x 16 holes
Cycle time	152 min /16 holes (9 min 30 sec / hole)	48 min / 16 holes (3 min / hole)

After prepared hole process



After threading process



Screws inserted



Work size: 50 x 50 x t 10 mm