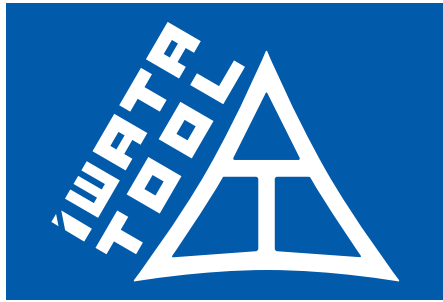


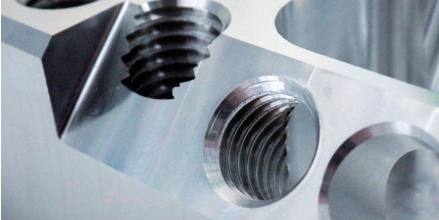
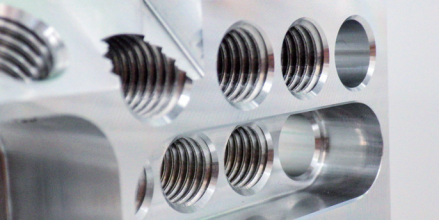
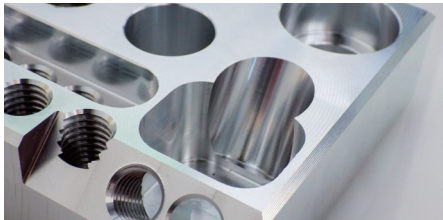


DRILLMILL MACHINING DEMONSTRATION

Work material: Aluminum A5052 / AlMg2 - Coolant: Emulsion

**MACHINING TIME OF ALL OPERATIONS
3 MINUTES**

Note the burr free cross hole and inclined half hole.



DrillMill Brochure

Machining Example
VIDEO

Brand	Product family	Product code	Ø	No of Cutting Edges	Operation	Machining Diameter	Depth of Machining	Speed	Feed	Feed Rate	Feed Speed	Feed Speed (Finishing)	Ramping Angle	Pitch
			mm	Z		mm	mm	rpm	mm/min	mm/z	mm/min	mm/min	deg	mm
IWATA TOOL	Drillmill	DMRSHC3D-WDC 16XR0.8	16	3	Hole	30.4	15	13000	653	0.200	3700	2400	10	7.977
			16	3	Hole	22	30	13000	653	0.293	3120	1800	15	5.051
			16	3	Hole	20.8	15	13000	653	0.222	2000	1200	15	4.041
			16	3	Inclined hole with 60 degree	21.9	23	13000	653	0.297	3120	1800	15	5.868
	Drillmill	DMRSHC3D-WDC 12XR0.6	12	3	Rectangular pocket	22.8	12	16000	603	0.148	3360	-	10	5.983
			12	3	Hole	19.23	30	10600	400	0.115	1380	1000	15	6.083
			12	3	Narrow - Rectangular pocket	-	12	13300	501	0.086	3450	2500	-	2.4
	Drillmill	DMRSHC3D-WDC 8XR0.4	8	3	Hole	11.15	18	16000	402	0.221	3000	800	20	3.597
			8	3	Inclined hole with 45 degrees	11.15	17	16000	402	0.221	3000	800	20	3.542
THIRD PARTY	Zero Chip Seamless Taflet	ZC-SL-TF M12X1.75 1.5C10	12	6	Blind hole tapping	M12	17	6000	226	-	-	-	-	-
			12	6	Amount passing through the exit 2.625+1	M12	21.625	6000	226	-	-	-	-	-
			12	6	45 degree amount passing through the exit 2	M12	19	6000	226	-	-	-	-	-
	Seamless Taflet	SL-TF M20X1.5 1.5C10	20	6	Amount passing through the exit 3+1	M20	34	636	40	-	-	-	-	-
	Nova E'z Disc	NED80-16	80	16	Face milling	-	0.05	10000	2513	0.050	8000	-	-	-
IWATA TOOL	Toglon Multi Chamfer	90TGMTCH12CBALT9Z	12	9	Maximum chamfering width 2	-	-	16000	603	0.050	7200	-	-	-
	Toglon Sharp SP	90TG6CBDLC	6	1	V grooving	-	1.5	16000	302	0.150	2400	-	-	-
	T. Multi Back Chamfer	90TGMBTCH10	10	5	Back chamfering width 0.5	-	-	16000	503	0.050	4000	-	-	-