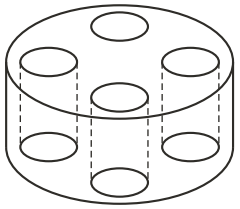
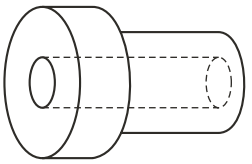
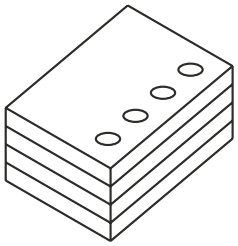
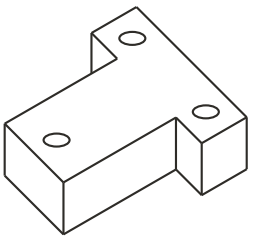
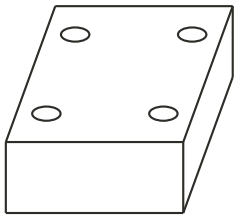
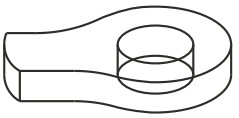
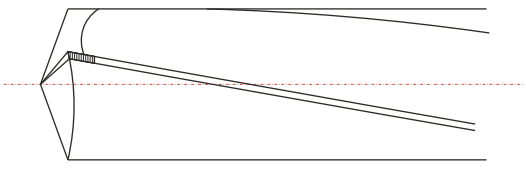
Speed Examples, Maximum Wear

Cutting speed examples for different workpieces by Yes Carbide drills

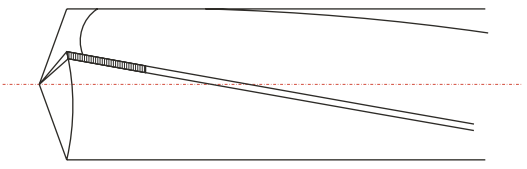
 Φ13 x depth 10mm	**FCD45** **YCD 130** N=1592rpm V=65m/min F=318mm/min f=0.2mm/rev	 Φ20 x depth 70mm	**S50C** **YTDI 200 P** N=876rpm V=55m/min F=263mm/min f=0.3mm/rev
 Φ24 x depth 63mm	**SS41** **YTDI 240 T** N=796rpm V=60m/min F=239mm/min f=0.3mm/rev	 Φ12 x depth 12mm	**SCM440** **YSD 120** N=1194rpm V=45m/min F=179mm/min f=0.15mm/rev
 Φ10 x depth 15mm	**SUS304** **YSDC 100** N=1115rpm V=35m/min F=112mm/min f=0.1mm/rev	 Φ15 x depth 8mm	**FC25** **YTD 150** N=1592rpm V=75m/min F=557mm/min f=0.35mm/rev

How to find maximum wear

1. When long and stringy chip formation without broken chip, require to change new tool or regrinding
2. Below pictures show the time of regrinding



Need to change new tool or regrinding



Excessive wear