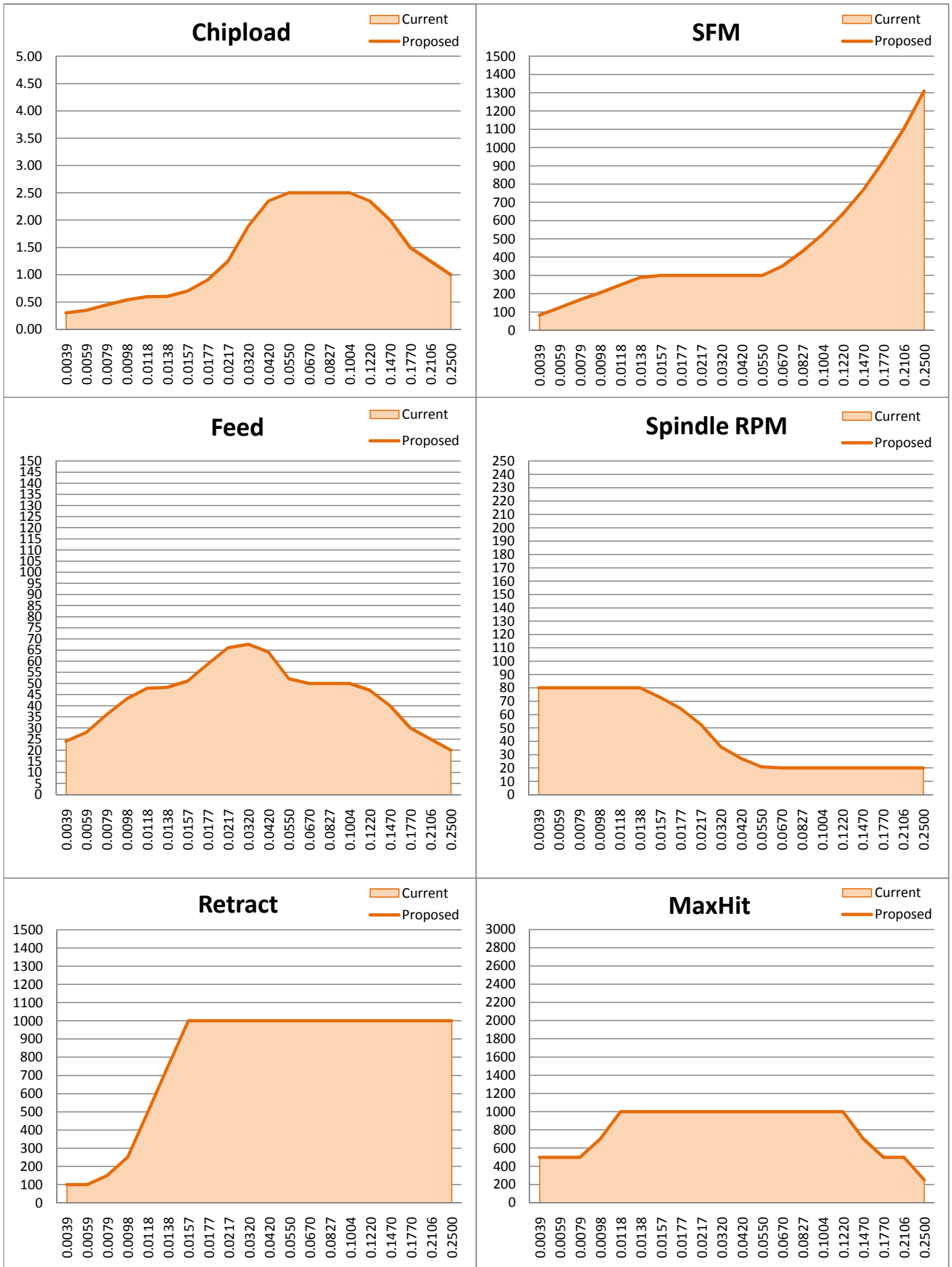




Application:	
Material Type:	Thermount
Drill Designs:	MDBT, UCMT/UCCP, WTCB

Process Parameters:	
Cutting Speed (SFM)	300
Maximum Chipload (0.001"/Revolution)	2.50
Maximum Hit Count	1000
Maximum Spindle RPM	80
Minimum Spindle RPM	20
Z-Offset (1-Point Clearance + Additional Depth; 2-Diameter)	1
Additional Depth (inch)	0.010
Maximum Drill Depth (Inch)	0.040

	Diameter		Chipload	SFM	Retract	MaxHit
1	0.0039	0.10MM	0.30		100	500
2	0.0059	#97 - 0.15MM	0.35		100	500
3	0.0079	#92 - 0.20MM	0.45		150	500
4	0.0098	0.25MM	0.54		250	700
5	0.0118	0.30MM	0.60		500	1000
6	0.0138	0.35MM	0.60		750	1000
7	0.0157	0.40MM	0.70		1000	1000
8	0.0177	0.45MM	0.91		1000	1000
9	0.0217	0.55MM	1.25		1000	1000
10	0.0320	#67	1.89		1000	1000
11	0.0420	#58	2.35		1000	1000
12	0.0550	#54	2.50		1000	1000
13	0.0670	#51	2.50		1000	1000
14	0.0827	2.10MM	2.50		1000	1000
15	0.1004	2.55MM	2.50		1000	1000
16	0.1220	3.10MM	2.35		1000	1000
17	0.1470	#26	2.00		1000	700
18	0.1770	#16	1.50		1000	500
19	0.2106	5.35MM	1.25		1000	500
20	0.2500	1/4 - 6.35MM	1.00		1000	250





Thermount MDBT, UCMT/UCCP, WTCB

Series	Diameter		Feed	Speed	Retract	MaxHit	Z-offset	SFM	Chipload
	(in.)		(IPM)	(K-RPM)	(IPM)		(in.)		(0.001"/Rev.)
MDBT	0.0039	0.10MM	24	80	100	500	-0.011	82	0.30
	0.0051	0.13MM	26	80	100	500	-0.011	107	0.33
	0.0059	#97 - 0.15MM	28	80	100	500	-0.011	124	0.35
	0.0063	#96	30	80	110	500	-0.011	132	0.37
	0.0067	#95	31	80	120	500	-0.012	140	0.39
	0.0071	#94	33	80	130	500	-0.012	149	0.41
	0.0075	#93	34	80	140	500	-0.012	157	0.43
UCMT / UCCP	0.0079	#92 - 0.20MM	36	80	150	500	-0.012	165	0.45
	0.0083	#91	37	80	171	550	-0.012	174	0.47
	0.0087	#90	39	80	192	600	-0.012	182	0.49
	0.0091	#89	40	80	213	650	-0.012	191	0.51
	0.0095	#88	42	80	234	675	-0.012	199	0.52
	0.0098	0.25MM	43	80	250	700	-0.012	205	0.54
	0.0100	#87	44	80	275	750	-0.012	209	0.54
	0.0105	#86	45	80	338	825	-0.012	220	0.56
	0.0110	#85	46	80	400	900	-0.013	230	0.57
	0.0115	#84	47	80	463	975	-0.013	241	0.59
	0.0118	0.30MM	48	80	500	1000	-0.013	247	0.60
	0.0120	#83	48	80	525	1000	-0.013	251	0.60
	0.0125	#82	48	80	588	1000	-0.013	262	0.60
	0.0130	#81	48	80	650	1000	-0.013	272	0.60
	0.0135	#80	48	80	713	1000	-0.013	283	0.60
	0.0138	0.35MM	48	80	750	1000	-0.013	289	0.60
	0.0145	#79	49	77	842	1000	-0.013	293	0.64
	0.0156	1/64	51	73	987	1000	-0.014	299	0.69
	0.0157	0.40MM	51	73	1000	1000	-0.014	300	0.70
	0.0160	#78	52	72	1000	1000	-0.014	300	0.73
	0.0177	0.45MM	59	65	1000	1000	-0.014	300	0.91
	0.0180	#77	59	64	1000	1000	-0.014	300	0.93
	0.0197	0.50MM	63	58	1000	1000	-0.015	300	1.08
0.0200	#76	63	57	1000	1000	-0.015	300	1.10	
MDBT	0.0210	#75	65	55	1000	1000	-0.015	300	1.19
	0.0217	0.55MM	66	53	1000	1000	-0.015	300	1.25
	0.0225	#74	66	51	1000	1000	-0.015	300	1.30
	0.0236	0.60MM	66	49	1000	1000	-0.016	300	1.37



Thermount MDBT, UCMT/UCCP, WTCB

Series	Diameter (in.)		Feed (IPM)	Speed (K-RPM)	Retract (IPM)	MaxHit	Z-offset (in.)	SFM	Chipload (0.001"/Rev.)
MDBT	0.0240	#73	66	48	1000	1000	-0.016	300	1.39
	0.0250	#72	67	46	1000	1000	-0.016	300	1.45
	0.0256	0.65MM	67	45	1000	1000	-0.016	300	1.49
	0.0260	#71	67	44	1000	1000	-0.016	300	1.52
	0.0276	0.70MM	67	42	1000	1000	-0.016	300	1.62
	0.0280	#70	67	41	1000	1000	-0.017	300	1.64
	0.0292	#69	67	39	1000	1000	-0.017	300	1.72
	0.0295	0.75MM	67	39	1000	1000	-0.017	300	1.73
	0.0310	#68	68	37	1000	1000	-0.017	300	1.83
	0.0312	1/32	68	37	1000	1000	-0.017	300	1.84
	0.0315	0.80MM	68	36	1000	1000	-0.017	300	1.86
	0.0320	#67	68	36	1000	1000	-0.017	300	1.89
	0.0330	#66	67	35	1000	1000	-0.018	300	1.94
	0.0335	0.85MM	67	34	1000	1000	-0.018	300	1.96
	0.0350	#65	66	33	1000	1000	-0.018	300	2.03
	0.0354	0.90MM	66	32	1000	1000	-0.018	300	2.05
	0.0360	#64	66	32	1000	1000	-0.018	300	2.07
	0.0370	#63	66	31	1000	1000	-0.019	300	2.12
	0.0374	0.95MM	66	31	1000	1000	-0.019	300	2.14
	0.0380	#62	65	30	1000	1000	-0.019	300	2.17
	0.0390	#61	65	29	1000	1000	-0.019	300	2.21
	0.0394	1.00MM	65	29	1000	1000	-0.019	300	2.23
	0.0400	#60	65	29	1000	1000	-0.019	300	2.26
	0.0410	#59	64	28	1000	1000	-0.020	300	2.30
	0.0413	1.05MM	64	28	1000	1000	-0.020	300	2.32
	0.0420	#58	64	27	1000	1000	-0.020	300	2.35
	0.0430	#57	63	27	1000	1000	-0.020	300	2.36
	0.0433	1.10MM	63	26	1000	1000	-0.020	300	2.37
	0.0441	1.12MM	62	26	1000	1000	-0.020	300	2.37
	0.0453	1.15MM	60	25	1000	1000	-0.021	300	2.39
	0.0465	#56	59	25	1000	1000	-0.021	300	2.40
	0.0469	3/64	59	24	1000	1000	-0.021	300	2.41
0.0472	1.20MM	59	24	1000	1000	-0.021	300	2.41	
0.0492	1.25MM	57	23	1000	1000	-0.021	300	2.43	
0.0512	1.30MM	55	22	1000	1000	-0.022	300	2.46	



Thermount MDBT, UCMT/UCCP, WTCB

Series	Diameter		Feed	Speed	Retract	MaxHit	Z-offset	SFM	Chipload
	(in.)		(IPM)	(K-RPM)	(IPM)		(in.)		(0.001"/Rev.)
MDBT	0.0520	#55	54	22	1000	1000	-0.022	300	2.47
	0.0531	1.35MM	53	22	1000	1000	-0.022	300	2.48
	0.0550	#54	52	21	1000	1000	-0.023	300	2.50
	0.0551	1.40MM	52	21	1000	1000	-0.023	300	2.50
	0.0571	1.45MM	52	21	1000	1000	-0.023	309	2.50
	0.0591	1.50MM	51	21	1000	1000	-0.024	317	2.50
	0.0595	#53	51	20	1000	1000	-0.024	319	2.50
	0.0610	1.55MM	51	20	1000	1000	-0.024	325	2.50
	0.0625	1/16	51	20	1000	1000	-0.025	332	2.50
	0.0630	1.60MM	51	20	1000	1000	-0.025	334	2.50
	0.0635	#52	51	20	1000	1000	-0.025	336	2.50
	0.0650	1.65MM	50	20	1000	1000	-0.025	342	2.50
	0.0669	1.70MM	50	20	1000	1000	-0.026	350	2.50
	0.0670	#51	50	20	1000	1000	-0.026	351	2.50
	0.0689	1.75MM	50	20	1000	1000	-0.026	361	2.50
	0.0700	#50	50	20	1000	1000	-0.026	367	2.50
	0.0709	1.80MM	50	20	1000	1000	-0.027	371	2.50
	0.0728	1.85MM	50	20	1000	1000	-0.027	381	2.50
	0.0730	#49	50	20	1000	1000	-0.027	382	2.50
	0.0748	1.90MM	50	20	1000	1000	-0.027	392	2.50
	0.0760	#48	50	20	1000	1000	-0.028	398	2.50
	0.0768	1.95MM	50	20	1000	1000	-0.028	402	2.50
	0.0781	5/64	50	20	1000	1000	-0.028	409	2.50
	0.0785	#47	50	20	1000	1000	-0.028	411	2.50
	0.0787	2.00MM	50	20	1000	1000	-0.028	412	2.50
	0.0807	2.05MM	50	20	1000	1000	-0.029	423	2.50
	0.0810	#46	50	20	1000	1000	-0.029	424	2.50
	0.0820	#45	50	20	1000	1000	-0.029	429	2.50
	0.0827	2.10MM	50	20	1000	1000	-0.029	433	2.50
	0.0846	2.15MM	50	20	1000	1000	-0.030	443	2.50
	0.0860	#44	50	20	1000	1000	-0.030	450	2.50
	0.0866	2.20MM	50	20	1000	1000	-0.030	453	2.50
	0.0886	2.25MM	50	20	1000	1000	-0.031	464	2.50
0.0890	#43	50	20	1000	1000	-0.031	466	2.50	
0.0906	2.30MM	50	20	1000	1000	-0.031	474	2.50	



Thermount MDBT, UCMT/UCCP, WTCB

Series	Diameter		Feed	Speed	Retract	MaxHit	Z-offset	SFM	Chipload
	(in.)		(IPM)	(K-RPM)	(IPM)		(in.)		(0.001"/Rev.)
MDBT	0.0925	2.35MM	50	20	1000	1000	-0.032	484	2.50
	0.0935	#42	50	20	1000	1000	-0.032	490	2.50
	0.0938	3/32	50	20	1000	1000	-0.032	491	2.50
	0.0945	2.40MM	50	20	1000	1000	-0.032	495	2.50
	0.0960	#41	50	20	1000	1000	-0.032	503	2.50
	0.0965	2.45MM	50	20	1000	1000	-0.032	505	2.50
	0.0980	#40	50	20	1000	1000	-0.033	513	2.50
	0.0984	2.50MM	50	20	1000	1000	-0.033	515	2.50
	0.0995	#39	50	20	1000	1000	-0.033	521	2.50
	0.1004	2.55MM	50	20	1000	1000	-0.033	526	2.50
	0.1015	#38	50	20	1000	1000	-0.034	531	2.49
	0.1024	2.60MM	50	20	1000	1000	-0.034	536	2.49
	0.1040	#37	50	20	1000	1000	-0.034	545	2.48
	0.1043	2.65MM	49	20	1000	1000	-0.034	546	2.47
	0.1063	2.70MM	49	20	1000	1000	-0.035	557	2.46
	0.1065	#36	49	20	1000	1000	-0.035	558	2.46
	0.1083	2.75MM	49	20	1000	1000	-0.035	567	2.45
	0.1094	7/64	49	20	1000	1000	-0.036	573	2.44
	0.1100	#35	49	20	1000	1000	-0.036	576	2.43
	0.1102	2.80MM	49	20	1000	1000	-0.036	577	2.43
	0.1110	#34	49	20	1000	1000	-0.036	581	2.43
	0.1122	2.85MM	48	20	1000	1000	-0.036	587	2.42
	0.1130	#33	48	20	1000	1000	-0.036	592	2.41
	0.1142	2.90MM	48	20	1000	1000	-0.037	598	2.40
	0.1160	#32	48	20	1000	1000	-0.037	607	2.39
	0.1161	2.95MM	48	20	1000	1000	-0.037	608	2.39
	0.1181	3.00MM	48	20	1000	1000	-0.038	618	2.38
	0.1200	#31	47	20	1000	1000	-0.038	628	2.36
	0.1201	3.05MM	47	20	1000	1000	-0.038	629	2.36
	0.1220	3.10MM	47	20	1000	1000	-0.038	639	2.35
0.1240	3.15MM	46	20	1000	1000	-0.039	649	2.32	
0.1250	1/8	46	20	1000	975	-0.039	654	2.31	
WTCB	0.1260	3.20MM	46	20	1000	975	-0.018	660	2.29
	0.1280	3.25MM	45	20	1000	950	-0.018	670	2.27
	0.1285	#30	45	20	1000	925	-0.018	673	2.26



Thermount MDBT, UCMT/UCCP, WTCB

Series	Diameter		Feed	Speed	Retract	MaxHit	Z-offset	SFM	Chipload
	(in.)		(IPM)	(K-RPM)	(IPM)		(in.)		(0.001"/Rev.)
WTCB	0.1299	3.30MM	45	20	1000	925	-0.019	680	2.24
	0.1319	3.35MM	44	20	1000	900	-0.019	691	2.21
	0.1339	3.40MM	44	20	1000	875	-0.019	701	2.18
	0.1358	3.45MM	43	20	1000	850	-0.019	711	2.16
	0.1360	#29	43	20	1000	850	-0.019	712	2.15
	0.1378	3.50MM	43	20	1000	825	-0.019	722	2.13
	0.1398	3.55MM	42	20	1000	800	-0.019	732	2.10
	0.1405	#28	42	20	1000	800	-0.019	736	2.09
	0.1406	9/64	42	20	1000	800	-0.019	736	2.09
	0.1417	3.60MM	41	20	1000	775	-0.019	742	2.07
	0.1437	3.65MM	41	20	1000	750	-0.019	752	2.05
	0.1440	#27	41	20	1000	750	-0.019	754	2.04
	0.1457	3.70MM	40	20	1000	725	-0.020	763	2.02
	0.1470	#26	40	20	1000	700	-0.020	770	2.00
	0.1476	3.75MM	40	20	1000	700	-0.020	773	1.99
	0.1495	#25	39	20	1000	700	-0.020	783	1.96
	0.1496	3.80MM	39	20	1000	700	-0.020	783	1.96
	0.1516	3.85MM	38	20	1000	675	-0.020	794	1.92
	0.1520	#24	38	20	1000	675	-0.020	796	1.92
	0.1535	3.90MM	38	20	1000	675	-0.020	804	1.89
	0.1540	#23	38	20	1000	675	-0.020	806	1.88
	0.1555	3.95MM	37	20	1000	650	-0.020	814	1.86
	0.1562	5/32	37	20	1000	650	-0.020	818	1.85
	0.1570	#22	37	20	1000	650	-0.020	822	1.83
	0.1575	4.00MM	37	20	1000	650	-0.020	825	1.83
	0.1590	#21	36	20	1000	625	-0.020	833	1.80
	0.1594	4.05MM	36	20	1000	625	-0.020	835	1.79
	0.1610	#20	35	20	1000	625	-0.021	843	1.77
	0.1614	4.10MM	35	20	1000	625	-0.021	845	1.76
	0.1634	4.15MM	35	20	1000	600	-0.021	856	1.73
	0.1654	4.20MM	34	20	1000	600	-0.021	866	1.69
	0.1660	#19	34	20	1000	575	-0.021	869	1.68
0.1673	4.25MM	33	20	1000	575	-0.021	876	1.66	
0.1693	4.30MM	33	20	1000	575	-0.021	886	1.63	
0.1695	#18	33	20	1000	550	-0.021	887	1.63	



Thermount MDBT, UCMT/UCCP, WTCB

Series	Diameter		Feed	Speed	Retract	MaxHit	Z-offset	SFM	Chipload
	(in.)		(IPM)	(K-RPM)	(IPM)		(in.)		(0.001"/Rev.)
WTCB	0.1713	4.35MM	32	20	1000	550	-0.021	897	1.60
	0.1719	11/64	32	20	1000	550	-0.021	900	1.59
	0.1730	#17	31	20	1000	550	-0.021	906	1.57
	0.1732	4.40MM	31	20	1000	550	-0.021	907	1.56
	0.1752	4.45MM	31	20	1000	525	-0.022	917	1.53
	0.1770	#16	30	20	1000	500	-0.022	927	1.50
	0.1772	4.50MM	30	20	1000	500	-0.022	928	1.50
	0.1791	4.55MM	30	20	1000	500	-0.022	938	1.48
	0.1800	#15	30	20	1000	500	-0.022	942	1.48
	0.1811	4.60MM	29	20	1000	500	-0.022	948	1.47
	0.1820	#14	29	20	1000	500	-0.022	953	1.46
	0.1831	4.65MM	29	20	1000	500	-0.022	959	1.45
	0.1850	4.70MM	29	20	1000	500	-0.022	969	1.44
	0.1870	4.75MM	29	20	1000	500	-0.022	979	1.43
	0.1875	3/16	28	20	1000	500	-0.022	982	1.42
	0.1890	#12 - 4.80MM	28	20	1000	500	-0.022	990	1.41
	0.1909	4.85MM	28	20	1000	500	-0.023	1000	1.40
	0.1910	#11	28	20	1000	500	-0.023	1000	1.40
	0.1929	4.90MM	28	20	1000	500	-0.023	1010	1.38
	0.1935	#10	28	20	1000	500	-0.023	1013	1.38
	0.1949	4.95MM	27	20	1000	500	-0.023	1020	1.37
	0.1960	#9	27	20	1000	500	-0.023	1026	1.36
	0.1969	5.00MM	27	20	1000	500	-0.023	1031	1.35
	0.1988	5.05MM	27	20	1000	500	-0.023	1041	1.34
	0.1990	#8	27	20	1000	500	-0.023	1042	1.34
	0.2008	5.10MM	26	20	1000	500	-0.023	1051	1.32
	0.2010	#7	26	20	1000	500	-0.023	1052	1.32
	0.2028	5.15MM	26	20	1000	500	-0.023	1062	1.31
	0.2031	13/64	26	20	1000	500	-0.023	1063	1.31
	0.2040	#6	26	20	1000	500	-0.023	1068	1.30
	0.2047	5.20MM	26	20	1000	500	-0.023	1072	1.29
	0.2055	#5	26	20	1000	500	-0.024	1076	1.29
0.2067	5.25MM	26	20	1000	500	-0.024	1082	1.28	
0.2087	5.30MM	25	20	1000	500	-0.024	1093	1.26	
0.2090	#4	25	20	1000	500	-0.024	1094	1.26	



Thermount MDBT, UCMT/UCCP, WTCB

Series	Diameter (in.)		Feed (IPM)	Speed (K-RPM)	Retract (IPM)	MaxHit	Z-offset (in.)	SFM	Chipload (0.001"/Rev.)
WTCB	0.2106	5.35MM	25	20	1000	500	-0.024	1103	1.25
	0.2126	5.40MM	25	20	1000	500	-0.024	1113	1.24
	0.2130	#3	25	20	1000	500	-0.024	1115	1.23
	0.2146	5.45MM	24	20	1000	475	-0.024	1124	1.22
	0.2165	5.50MM	24	20	1000	475	-0.024	1134	1.21
	0.2185	5.55MM	24	20	1000	450	-0.024	1144	1.20
	0.2188	7/32	24	20	1000	450	-0.024	1146	1.20
	0.2205	5.60MM	24	20	1000	450	-0.025	1155	1.19
	0.2210	#2	24	20	1000	450	-0.025	1157	1.18
	0.2224	5.65MM	24	20	1000	450	-0.025	1164	1.18
	0.2244	5.70MM	23	20	1000	425	-0.025	1175	1.16
	0.2264	5.75MM	23	20	1000	400	-0.025	1185	1.15
	0.2280	#1	23	20	1000	400	-0.025	1194	1.14
	0.2283	5.80MM	23	20	1000	400	-0.025	1195	1.14
	0.2303	5.85MM	23	20	1000	375	-0.025	1206	1.13
	0.2323	5.90MM	22	20	1000	375	-0.025	1216	1.11
	0.2340	#A	22	20	1000	375	-0.025	1225	1.10
	0.2343	5.95MM	22	20	1000	350	-0.025	1227	1.10
	0.2344	15/64	22	20	1000	350	-0.025	1227	1.10
	0.2362	6.00MM	22	20	1000	350	-0.026	1237	1.09
	0.2380	#B	22	20	1000	350	-0.026	1246	1.08
	0.2382	6.05MM	21	20	1000	325	-0.026	1247	1.07
	0.2402	6.10MM	21	20	1000	325	-0.026	1258	1.06
	0.2420	#C	21	20	1000	325	-0.026	1267	1.05
	0.2421	6.15MM	21	20	1000	325	-0.026	1268	1.05
	0.2441	6.20MM	21	20	1000	300	-0.026	1278	1.04
	0.2460	#D	21	20	1000	300	-0.026	1288	1.03
	0.2461	6.25MM	20	20	1000	275	-0.026	1289	1.02
	0.2480	6.30MM	20	20	1000	275	-0.026	1299	1.01
	0.2500	1/4 - 6.35MM	20	20	1000	250	-0.026	1309	1.00