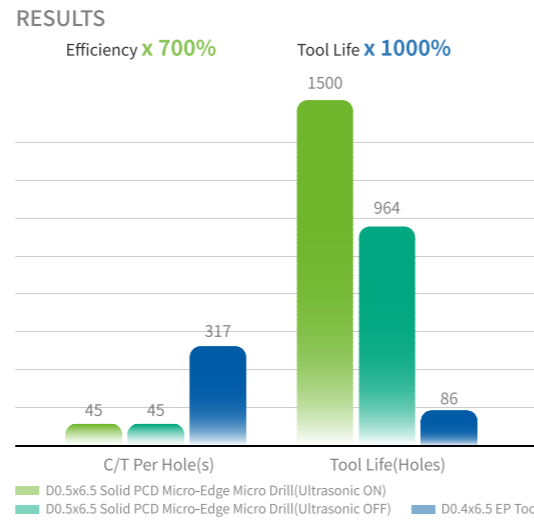


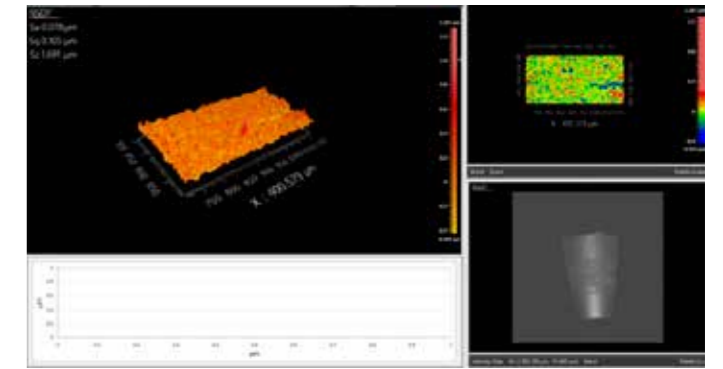
Machining GLASS (HOLES)

Conprofe Ultrasonic Tool holder +
Conprofe Solid PCD Micro Drill



Machining GLASS/SAPPHIRE (HOLES)

Through Hole Size (mm): D2.24*0.7



Machine	1	2	3	4	5	6	7	8	9	10	11	12	Average
Sa (nm)	65	78	79	68	65	76	67	68	67	70	66	67	69.7

Machining GLASS/SAPPHIRE (HOLES)

Workpiece

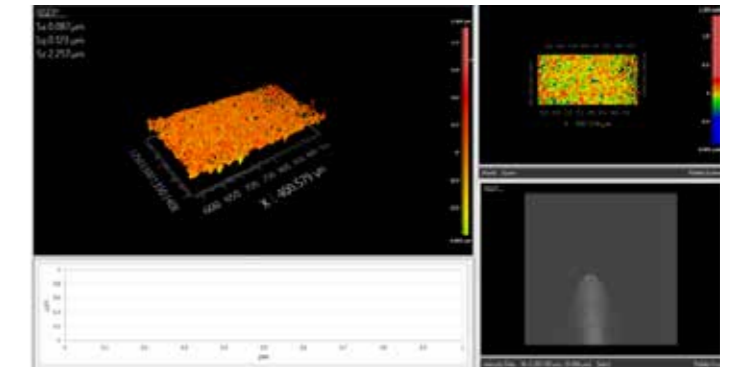


Tool



Conprofe Ultrasonic Tool Holder +
Conprofe Solid PCD Micro-edge Flat End Mill

Through Hole Size (mm): D2.24*0.7



D2.24x0.7mm

Machine	Tool	Material	Processing requirement	Machining Strategy						
				Machining parameters			Ultrasonic Parameters			C/T
UHB600	Solid PCD Multi-flute tool	Sapphire/Glass	D2.24*0.7 Hole finishing	28000	60	0.005/0.001	27630	40%	7	45s

Machine	1	2	3	4	5	6	7	8	9	10	11	12	Average
Sa (nm)	107	90	84	92	87	89	88	90	101	87	92	88	91.2