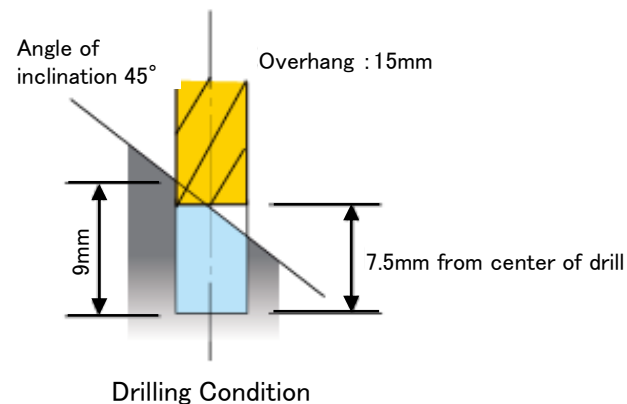


BMS-4020-MQL-CHK ϕ 3mm Drilling Application (A7075)

Motor Spindle BMS-4020-MQL-CHK
 Machine Sodick MC (MC430L)
 Tools NACHI Aqua drill EX flat oil hole
 L/D=3 ϕ 3 AQDEXZOH3D0300
 Work Aluminum alloy (A7075)
 Hole depth 9mm (L/D=3) Blind hole Non-step
 Drilling condition processing
 Coolant Non-water-soluble cutting oil (1.5MPa)
 Internal coolant



	NACHI	NAKANISHI
Cutting Speed [m/min]	70.7 $\xrightarrow{2 \text{ times}}$	141.3
Spindle Speed [min ⁻¹]	7,400 $\xrightarrow{2 \text{ times}}$	15,000
Feed Rate [mm/rev]	0.071	0.066
Feed [mm/min]	532 $\xrightarrow{2 \text{ times}}$	1,000

E4000 controller : Two load meter lighting (continuous duty area)
 This CHK-type slim spindle head can get close to the work,
 the tool over hang can be minimized.
 The processing efficiency is improved by 2 times on the grounds that
 Spindle speed and feed can be increased.



The minimized tool overhang enables precise processing.
 The tool life improves due to efficient chip evacuation.

