

BMS-4020 ϕ 2.1mm Drilling Application (SCM420)

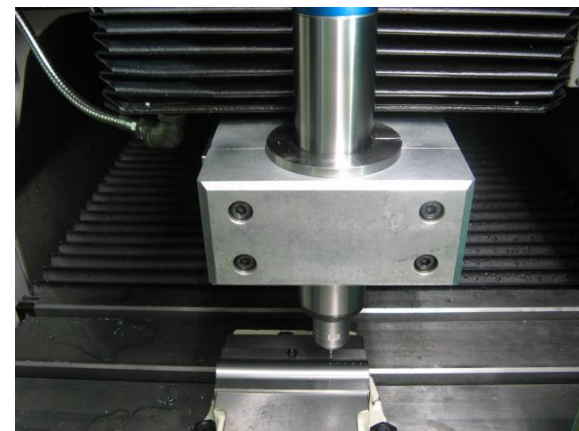
Motor Spindle BMS-4020
Machine Sodick MC (MC430L)
Tools IWATA TOOL Carbide SP Center 120° 120SPC4CB
 ATOM ϕ 2.1 Carbide Drill ADRS ϕ 2.1
Work SCM420 (ϕ 20 $\times$ ϕ 7 $\times$ 180mmL pipe shape)
Drilling ϕ 2.1 $\times$ 7L Drilling through hole $\times$ 5holes
Coolant Non-water-soluble cutting oil
Drilling Condition

	CURRENT	NAKANISHI
Cutting Speed [m/min]	9 40	66 79
Spindle Speed [min ⁻¹]	1,400 6,000	10,000 12,000
Feed Rate [mm/rev]	0.05 0.05	0.05 0.044
Feed [mm/min]	70 300	500 500
Step Feed [mm]	—	0.65 2.00
Processing Time [sec]	24	13

2times
→

2times
→

appx. 1/2
→



**Shortened processing time
by high speed feeding**