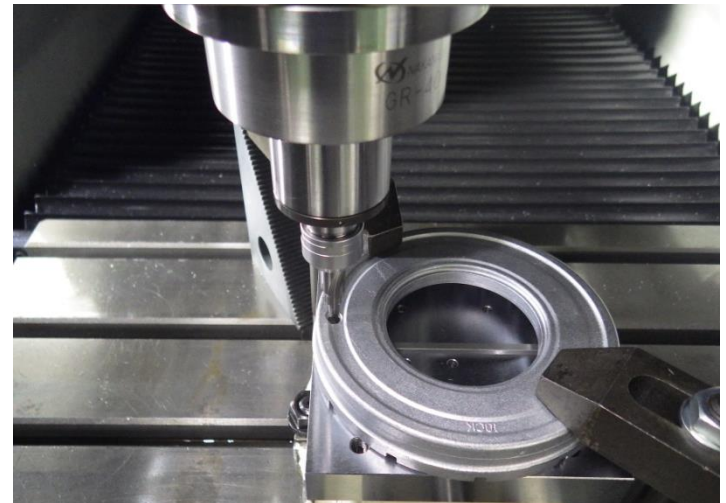
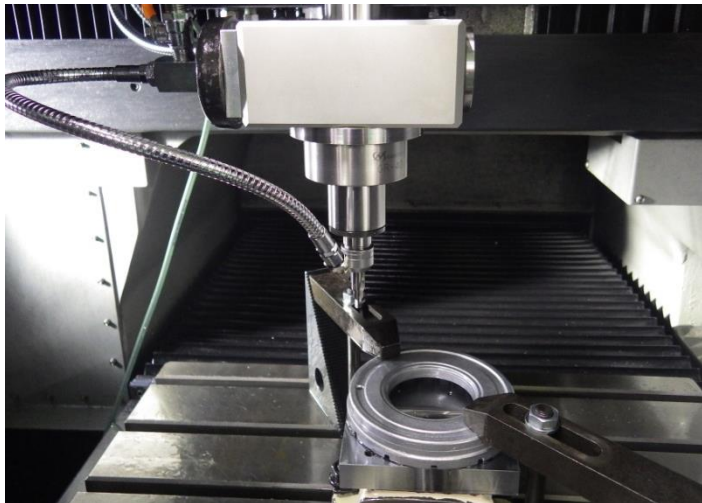
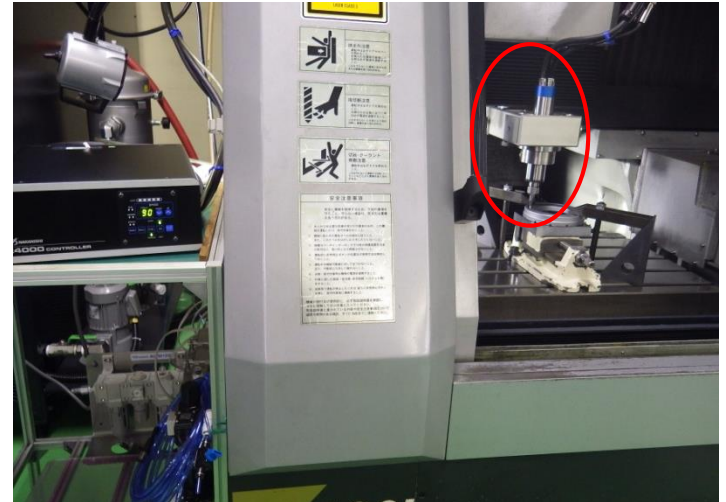


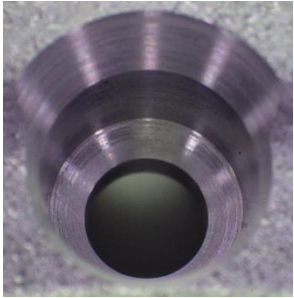
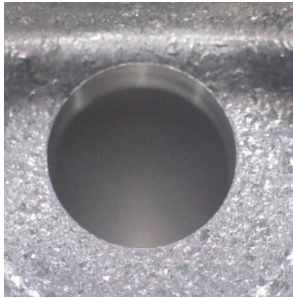
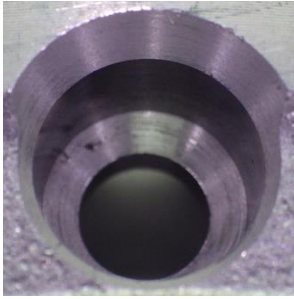
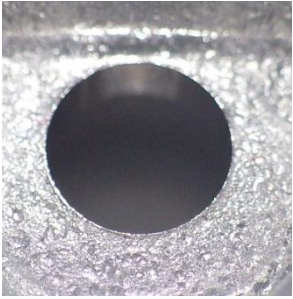
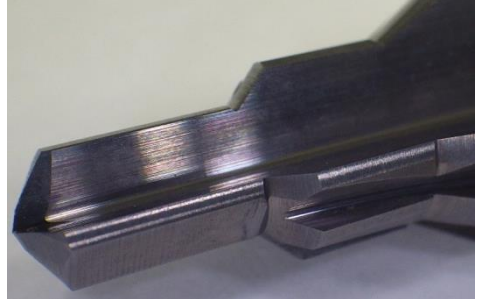
BMS-4020 $\phi 4.8\text{mm}$ Drilling Application(ADC12)

Motor Spindle	BMS-4020
Machine	Sodick MC (MC430L)
Tools	$\Phi 4.8 \times \Phi 7.22$ stepped drill
Work	Aluminum Cast (ADC12)
Drilling	Drilling after $\Phi 4.0$ prepared hole drilling
Coolant	Non-water-soluble cutting oil
Drilling condition	Cutting Speed : 150 mm/min Spindle Speed : 10,000 min ⁻¹ Feed Rate : 0.1 mm/rev Feed : 1,000 mm/min E4000 load meter : 5 load meter Lighting (acceptable intermittent load)



BMS-4020 ϕ 4.8mm Drilling Application(ADC12)

Result

Drilling condition	Processing Time	Finishing surface	Back side	Tools
E4000 10,000min ⁻¹ 0.1mm/rev (1,000mm/min) 5 Load meter Lighting	1 sec			
Previously 2,500min ⁻¹ 0.1mm/rev (250mm/min)	4 sec			

Good finishing surface. The drilling efficiency is improved by 4 times.