

BMS-4020 $\phi 5.0\text{mm}$ Drilling Application (SUS303)

Motor Spindle BMS-4020

Machine Hasegawa CNC lathe H30

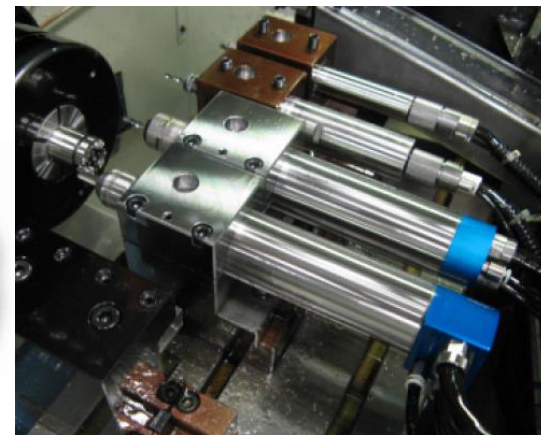
Tools IWATA TOOL 60SPC 1 $\times$ 3CB

TUSA $\phi 5.0$ carbide drill SD $\phi 5.0$

Work Stainless steel (SUS303)

Drilling $\phi 5 \times 5\text{L}$ Drilling through hole $\times$ 5 holes

Coolant Non-water-soluble cutting oil



Drilling condition

	IWATA TOOL	NAKANISHI
Cutting Speed[m/min]	30-60	94
Spindle Speed [min ⁻¹]	2,000-4,000	6,000
Feed Rate[mm/rev]	0.06	0.025
Feed[mm/min]	120-240	150
Step	-	2.5
Processing Time [sec]	-	3

