

EM20-S6000 ϕ 1.0mm Drilling Application (SUS304)

Motor Spindle EM20-S6000/E3000
 Machine Sodick MC (MC430L)
 Tools Nachi ϕ 1.0 Carbide Drill AQUA Drills Regular
 AQDR ϕ 1.0
 Work Stainless steel SUS304
 Cutting ϕ 1.0 $\times$ 2.0L Blind hole drilling
 Coolant Non-water-soluble cutting oil
 Cutting Condition

	Nachi	NAKANISHI
Cutting Speed [m/min]	57	47
Spindle Speed[min^{-1}]	18,000	15,000
Feed Rate[mm/rev]	0.02	0.01
Feed [mm/min]	400	150
Step	—	0.2
E3000 Controller load meter	—	Continuous duty operation

0.38 times
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