

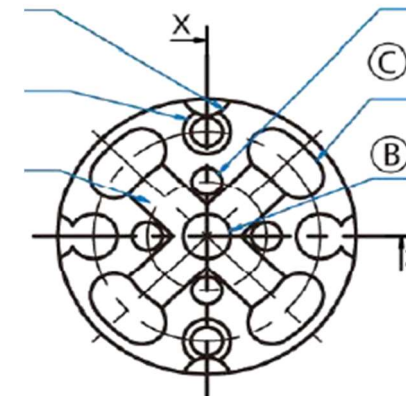
EM20-S6000 $\phi 4.0\text{mm}$ Drilling Application (SUS303)

Motor Spindle	EM20-S6000/E3000
Machine	Hasegawa CNC lathe H30
Tools	IWATA TOOL 60SPC 1 $\times$ 3CB TUSA $\phi 3.0$ Carbide Drill SD $\phi 3.0$
Work	Stainless (SUS303)
Drilling	$\phi 3 \times 4.6\text{L}$ Through hole drilling $\times 5$ holes
Coolant	Non-water-soluble cutting oil

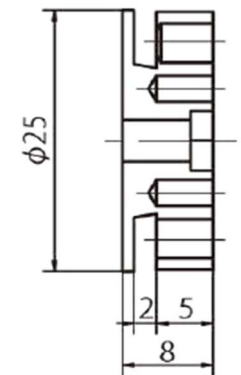


Drilling condition

	IWATA TOOL	NAKANISHI
Cutting Speed [m/min]	30-60	289
Spindle Speed [min ⁻¹]	2,000-4,000	23,000
Feed Rate [mm/rev]	0.06	0.004
Feed [mm/min]	120-240	100
Step	-	1.0
Processing time [sec]	-	17



B: 5- $\phi 4.0$



Cross Section X-X