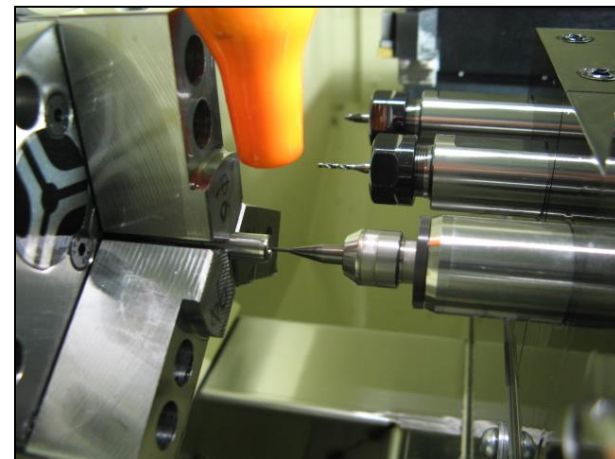


# BMJ-320 $\phi$ 1.3mm Thread Milling Application (SUS420J2)

Motor Spindle	BMJ-320
Machine	WASINO CNC Lathe G-07
Tool	M-Thread Mill, M1.7, NS TOOL
Work Material	Stainless Steel SUS420J2
Thread Size	M1.6 $\times$ 0.2
Depth of Thread	3 mm
Coolant	Non-water-soluble Cutting Oil

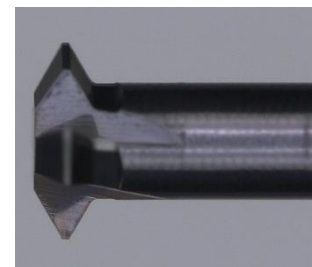


Machine: CNC Lathe

Tool	M-Thread Mill	Thread Cutter 2 Flutes
Cutting Speed	163 m/min	124 m/min
Tool Speed	40,000 min <sup>-1</sup>	30,000 min <sup>-1</sup>
Workpiece Speed	300 min <sup>-1</sup>	120 min <sup>-1</sup>
Feed per Revolution of Workpiece	0.2 mm/rev	0.2 mm/rev
Processing Time	6 – 7 sec	13 – 14 sec



Workpiece



Thread Cutter

**M-Thread Mill enable to shorten the processing time, which is close to rolling tap.**