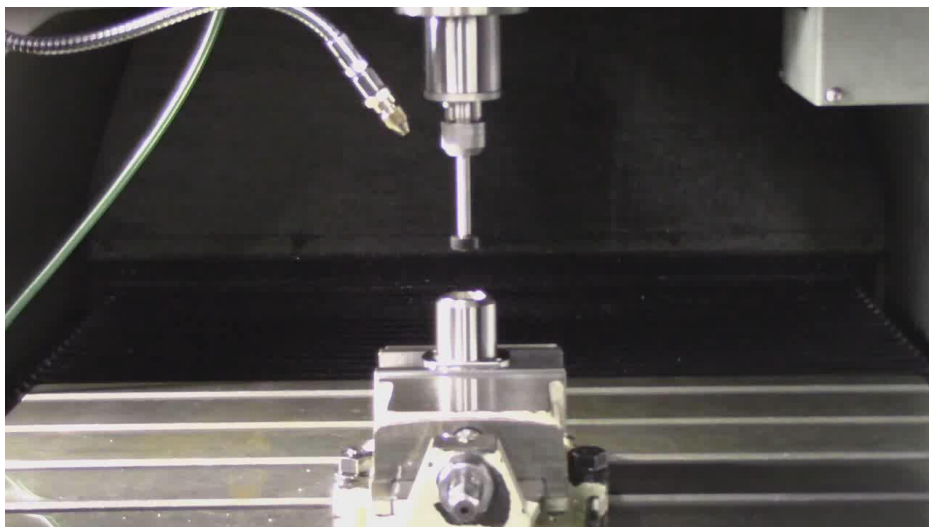


BMS-4020-MQL ϕ 15mm Internal Grinding Application (SUS420)

Motor Spindle	BMS-4020-MQL
Machine	Sodick MC (MC430L)
Tools	NAKANISHI 14880 CBN Grindstone ϕ 15 $\times$ 6t #180 Φ 0.7 $\times$ 2Hole as penetration oil hole was added.
Work	Stainless (SUS420) I.D. ϕ 19 $\times$ Depth 20mm
Processing	Internal Grinding (Helical Processing)
Coolant	Non-water-soluble cutting oil (1.0MPa) Internal coolant
Drilling Condition	Cutting Speed : 942m/min Spindle Speed : 20,000min ⁻¹ Helical Processing Pitch : 0.5mm E4000 Controller: One load meter lighting (continuous duty area)



Good Effects by Internal Coolant System.

- * Discharge of cutting dust
- * Prevention of blocking
- * The finish is good
- * Improvement of the tool life