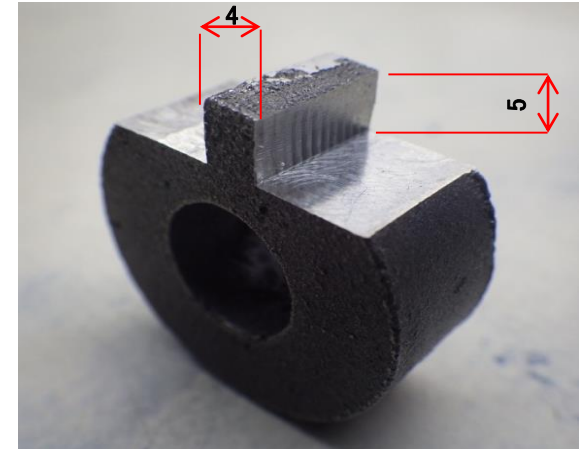


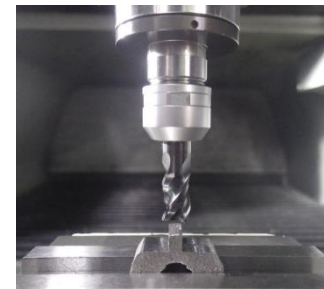
BMS-4020 ϕ 10.0mm End mill Application (Casting)

Motor Spindle BMS-4020
Machine Sodick MC (MC430L)
Tools NACHI ϕ 10mm three-flute carbide end mill
 GSXSLT-1.5D GSXSLT1000C-1.5D
Work Casting iron
Cutting Side Milling, Bottom milling, Max depth of cut:1mm
Coolant Non-water-soluble cutting oil
Cutting Condition

	NACHI	NAKANISHI
Cutting Speed [m/min]	88	314
Spindle Speed [min ⁻¹]	2,800	10,000
Feed [mm/min]	670	600
Feed Rate [mm/tooth]	0.079	0.02
Depth of cut Ap $\times$ Ae [mm]	15 $\times$ 0.05	4 $\times$ 1 1 $\times$ 4
E4000 Controller load meter	—	2 load meter lighting (continuous duty operation)



Side milling



Bottom milling