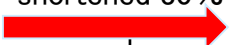


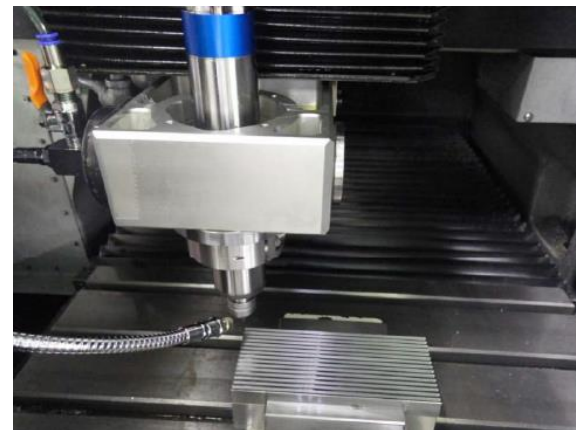
BMS-4020 ϕ 3.0mm End mill Application (S50C)

Motor Spindle BMS-4020
Machine Sodick MC (MC430L)
Tools OSG ϕ 3mm 2-Flute Carbide End mill
 WLX-1.5D-DE ϕ 3.0
Work Carbon steel S50C $\square$ 150 $\times$ 60
Cutting 15 Lines, Cutting length 2.25m/1 face
 12-Faces machining, Cutting length 27m
Coolant Non-water-soluble cutting oil

Cutting Condition

	OSG	NAKANISHI
Cutting Speed[m/min]	84	188
Spindle Speed [min ⁻¹]	8,900	20,000
Feed[mm/min]	230	1,000
Feed Rate[mm/tooth]	0.013	0.025
Depth of cut Ap $\times$ Ae [mm]	1.5 $\times$ 3	0.5 $\times$ 3 <u>$\times$ 3 times</u>
E4000Controller load meter	—	1 load meter lighting (continuous duty operation)
Processing Time[min]	127.6	89.2

shortened 30%




ϕ 3 slotting ,cutting length 27m
The processing time can be shortened by high speed milling.