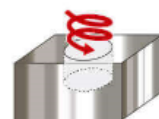


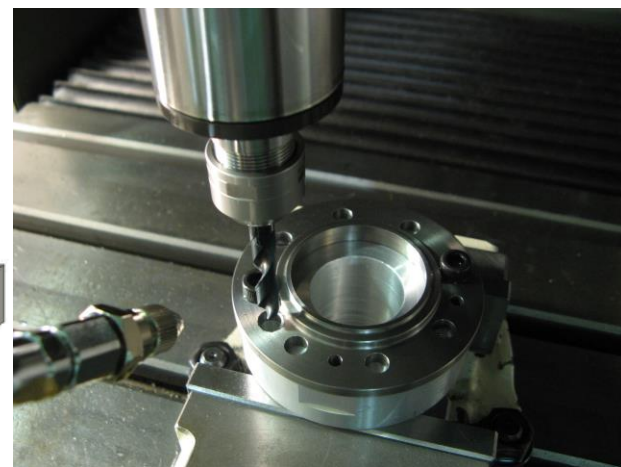
BMS-4020 ϕ 4.0mm Helical processing Application

(Gray cast iron)

Motor Spindle BMS-4020
Machine Sodick MC (MC430L)
Tools NS TOOL ϕ 4.0 3-Flute MUGEN-COATING
 POWER“Z”End Mill MSZ345 ϕ 4
Work Gray casting iron
Cutting Φ 6.8 $\times$ 8.15L Drilling through hole $\times$ 8 holes
 ϕ 4.0 $\times$ 8.15L Drilling through hole $\times$ 2 holes
 ϕ 4mm End mill Helical processing
 Non-water-soluble cutting oil

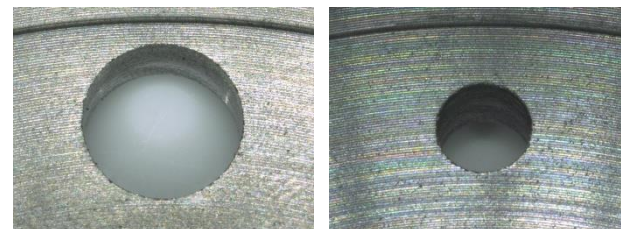


Helical
processing



Coolant Cutting Condition

	NS TOOL	NAKANISHI
Cutting Speed[m/min]	75(ϕ 6.8) 57(ϕ 4.0)	251
Spindle Speed [min ⁻¹]	3,500(ϕ 6.8) 4,500(ϕ 4.0)	20,000
Drilling Feed[mm/min]	300(0.085mm/rev) 400(0.089mm/rev)	600
Helical processing Feed[mm/min]	-	1,000 pitch1.2
Processing Time(sec)	13.4	15.8



Helical processing of ϕ 6.0 and ϕ 4.8
holes by ϕ 4 End mill



Good finishing surface