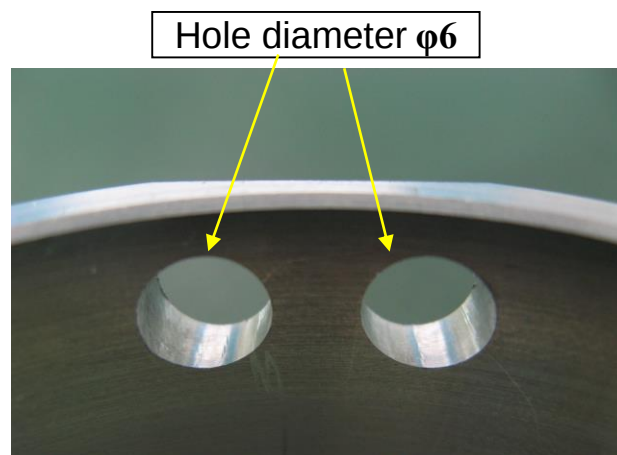
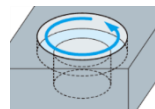


BMS-4040 $\phi 4.0\text{mm}$ Contouring Application (Aluminum)

Motor Spindle BMS-4040
Machine Sodick MC (MC430L)
Tools NS TOOL $\phi 4.0$ 3-Flute Power "Z" End Mill for Aluminum ALZ345 $\phi 4 \times 12\text{L}$
Work Aluminum casting
Cutting $\phi 6 \times 4\text{L}$ Drilling through
 $\phi 4$ End mill Contouring processing
Coolant Non-water-soluble cutting oil
Cutting Condition



- Burr-free by Contouring processing
- Good finishing surface

	NS TOOL	NAKANISHI
Cutting Speed[m/min]	230	502
Spindle Speed [min ⁻¹]	18,300	40,000
Drilling Feed[mm/min]	200	500
Side milling Feed[mm/min]	2,300	1,200 1,600
Depth of cut Ap × Ae [mm]	4 × 1.2	4 × 0.6 4 × 0.4
Processing Time	—	1.5sec/hole