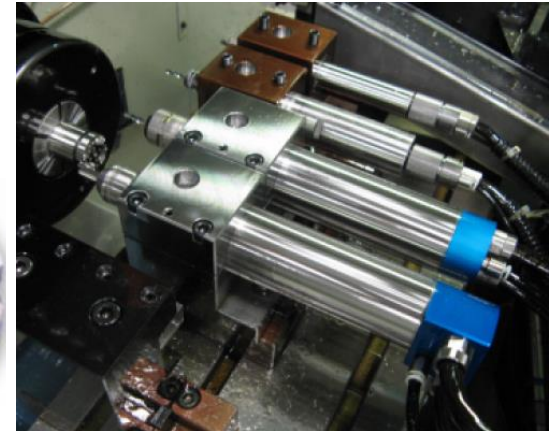


BMS-4040 ϕ 6.0mm End mill Application (SUS303)

Motor Spindle BMS-4040
Machine Hasegawa CNC lathe H30
Tools NS TOOL ϕ 6.0 2-Flute MUGEN-COATING
 LEAD25 End Mill MX225 ϕ 6.0
Work Stainless steel (SUS303)
Cutting ϕ 6 $\times$ depth 3mm $\times$ 4 holes
Coolant Non-water-soluble cutting oil



Cutting Condition

	NS TOOL	NAKANISHI
Cutting Speed [m/min]	50 -70	188
Spindle Speed [min ⁻¹]	3,200	10,000
Bottom Feed C-axis Feed [mm/min]	85	30 600
Feed Rate [mm/tooth]	0.013	0.032
Depth of cut Ap $\times$ Ae [mm]	6 $\times$ 6	0.3 $\times$ 6 <u>$\times$ 10times</u>
Processing Time [sec]	-	80

