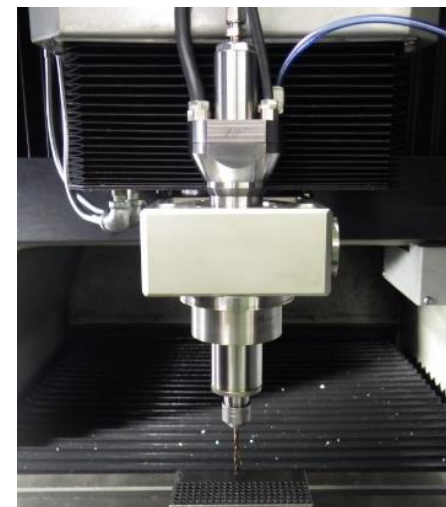


BMS-4020-MQL ϕ 4mm Drilling Application (S50C)

Motor Spindle	BMS-4020-MQL
Machine	Sodick MC (MC430L)
Tools	Mitsubishi Material WSTAR Drill with through coolant holes ϕ 4.0 (L/D=5) MVS0400X05S040
Work	Carbon Steel (S50C)
Hole depth	20mm (L/D=5) Blind hole
Coolant	Non-water-soluble cutting oil (1MPa) Internal coolant
Condition	Cutting Speed : 125.6 m/min Spindle Speed : 10,000 min ⁻¹ Feed rate : 0.05 mm/rev Feed : 500 mm/min Processing : non-step drilling



BMS-4020-MQL Internal coolant

E4000 controller : Four load meter lighting (allowable operation time : 30sec.)

Maximum Drilling depth without step drilling

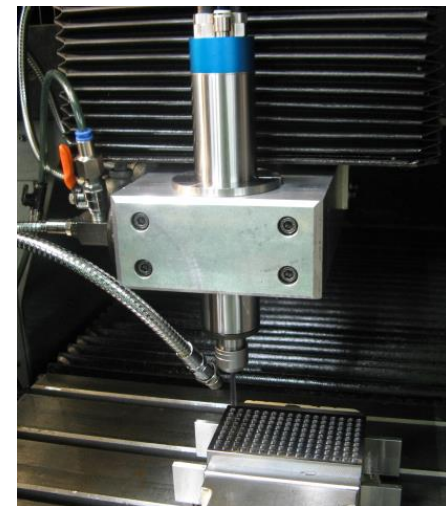
BMS-4020-MQL with internal coolant = depth 20 mm

BMS-4020 with external coolant = depth 10 mm



- ① High efficiency deep hole drilling
- ② Improved chip evacuation

BMS-4020/4040-MQL is suitable for deep hole drilling with high efficiency.



BMS-4020 External coolant