

BMS-4020 ϕ 5.0mm Drilling Application (S55C)

Motor Spindle	BMS-4020
Machine	Sodick MC (MC430L)
Tools	MISUMI ϕ 5.0 TiAlN coat carbide drill TAC-RESDBA ϕ 5.0
Work	Carbon steel (S55C)
Drilling	ϕ 5 $\times$ 5L Blind hole $\times$ 150 holes
Coolant	Non-water-soluble cutting oil
Drilling condition	Cutting Speed : 157m/min Spindle Speed : 10,000min ⁻¹ Feed Rate : 0.06mm/rev Feed : 600mm/min non-step E4000 Controller: 5 load meter Lighting (acceptable intermittent load)
Processing Time	2 min10 sec

