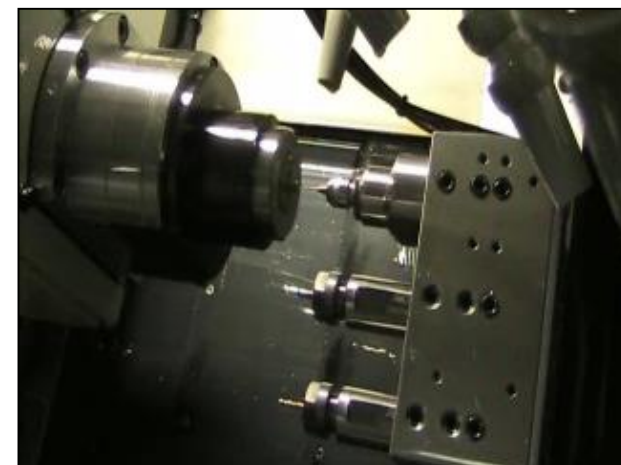


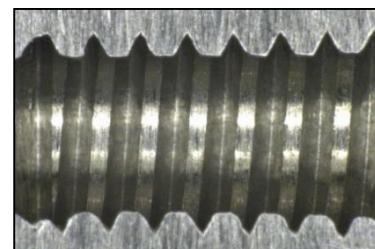
BM-319F ϕ 2.3mm Thread Milling Application (SUS420J2)

Motor Spindle	BM-319F
Machine	Cincom M16
Tool	TiAlN coated Thread Cutter, 6 Flutes, ϕ 2.3
Work Material	Stainless Steel SUS420J2
Thread Size	M3 $\times$ 0.6
Depth of Thread	5.5 mm
Coolant	Non-water-soluble Cutting Oil
Processing Time	16 sec/hole

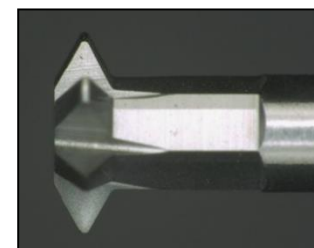


Machine: CNC Lathe

Tool	6 Flutes	2 Flutes
Tool Speed	30,000 min ⁻¹	30,000 min ⁻¹
Workpiece Speed	60 min ⁻¹	40 min ⁻¹
Feed per Revolution of Workpiece	0.6 mm/rev	0.6 mm/rev
Processing Time	16 sec/hole	18 sec/hole
Number of Processed Thread Holes	6,000 holes	3,000 holes



Workpiece



Thread Cutter

- shorten the processing time
- improve the tool life