

BMS-4020 ϕ 3.2mm Drilling Application (SCM435)

Motor Spindle BMS-4020
Machine Sodick MC (MC430L)
Tools IWATA TOOL Carbide SP Center 90SPC 2.0 $\times$ 6CB
 Nachi ϕ 3.2 Carbide Drill AQDS ϕ 3.2
Work SCM435 unhardened steel
Drilling ϕ 3.2 $\times$ 11L Drilling through hole /overhang 22mm
Coolant Non-water-soluble cutting oil

Drilling Condition

	IWATA/NACHI	NAKANISHI
Cutting Speed [m/min]	60	90
Spindle Speed [min ⁻¹]	6,000	9,000
Feed Rate [mm/rev]	0.083	0.08
Feed [mm/min]	500	720
Step Feed	—	7.0/13.0
E4000 Controller load meter	—	4 load meter lighting (acceptable intermittent load)

