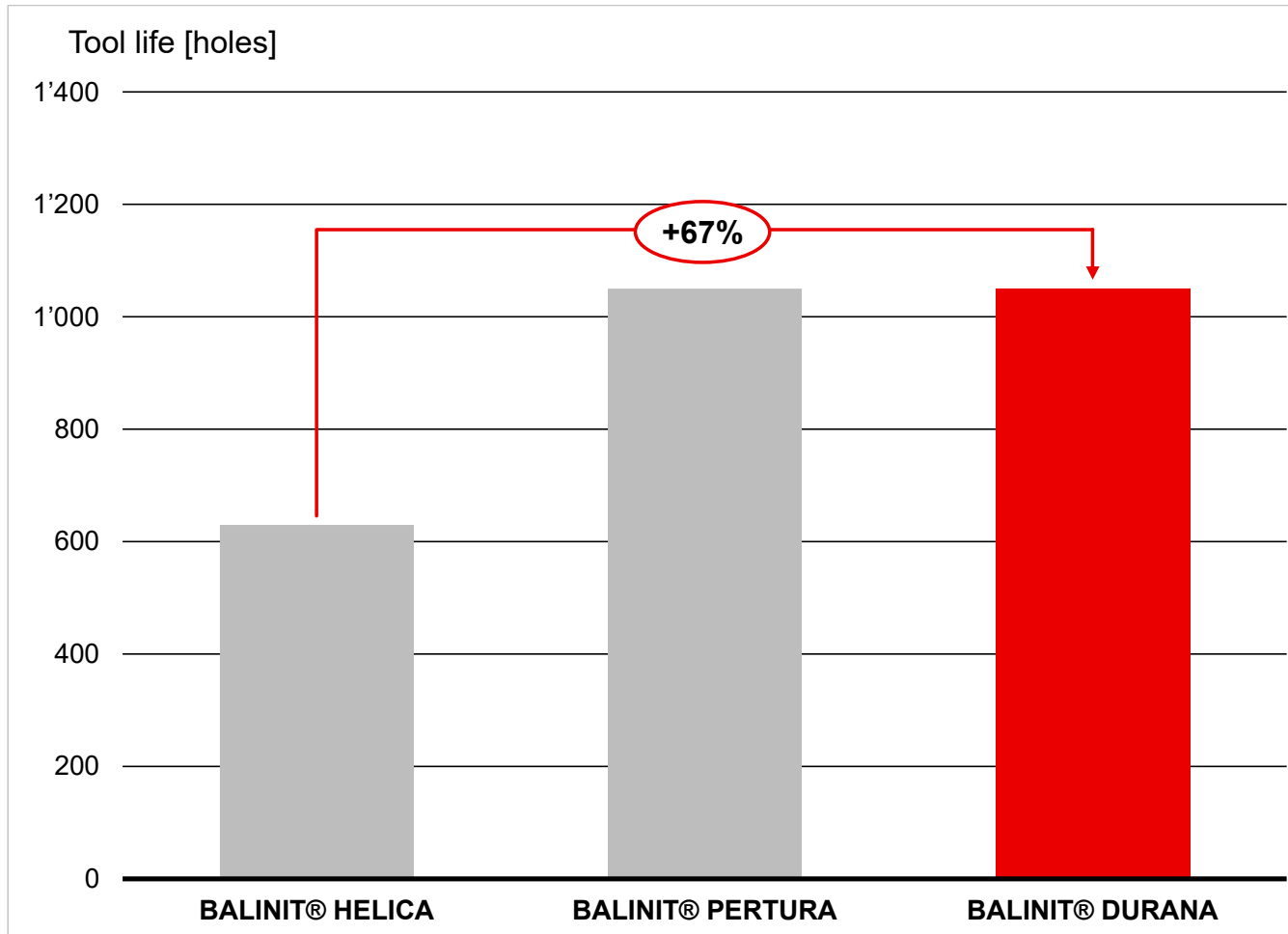


# BALINIT DURANA

## Deep hole drilling in low alloyed steel (1.7225)

**oerlikon**  
balzers



**Tool:**  
Solid carbide drill Ø 8.5 mm

**Workpiece:**  
Steel 1.7225, 42CrMo4 (AISI4140, SCM440)

**Cutting data:**  
 $v_c = 160$  m/min  
 $f = 0.260$  mm/rev  
 $a_p = 40$  mm  
Internal coolant  
Trough hole

**Benefit:**  
Increased tool life

**Source/Customer:**  
Oerlikon Balzers Cutting  
Laboratory

