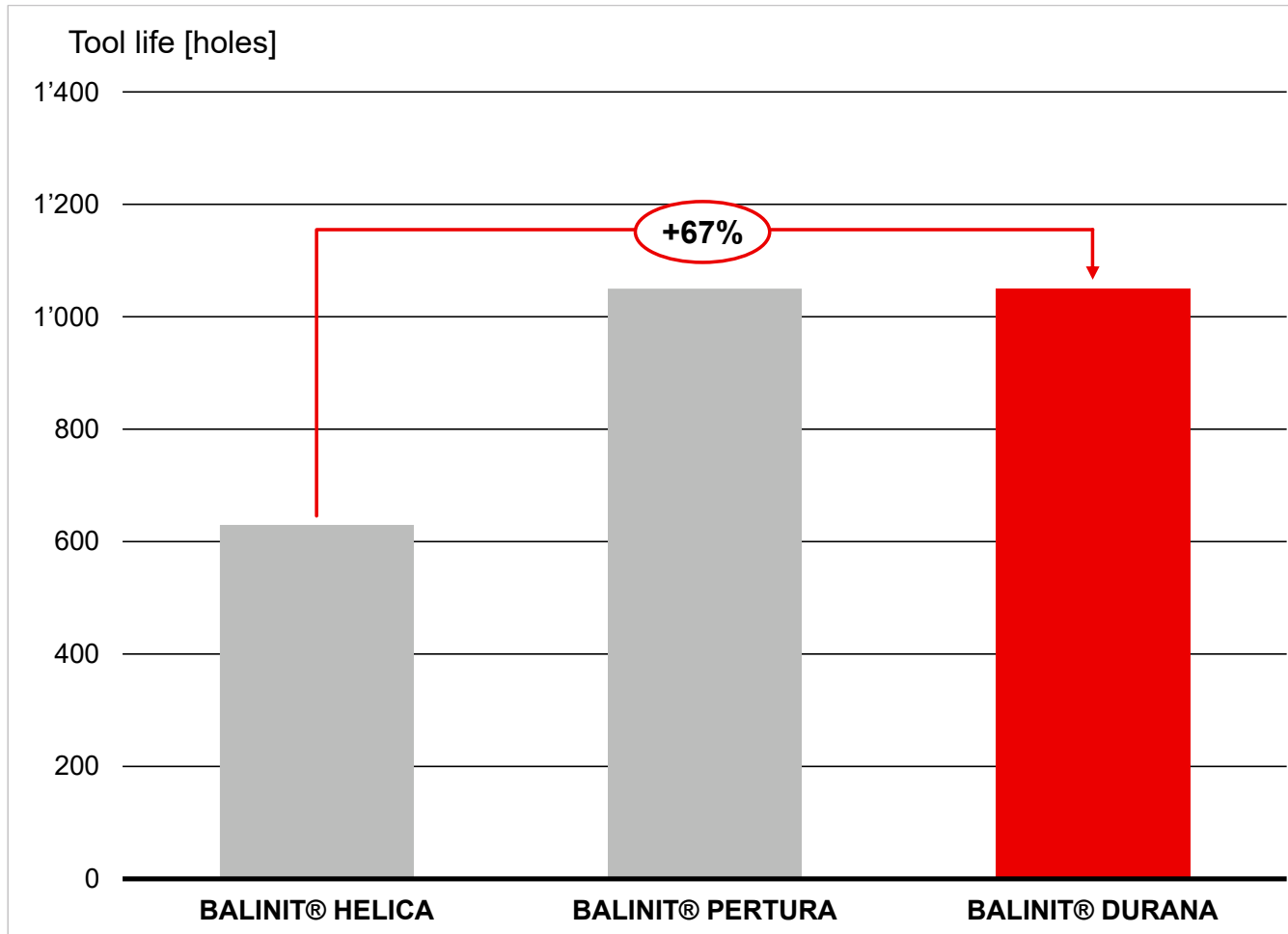


BALINIT DURANA

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

