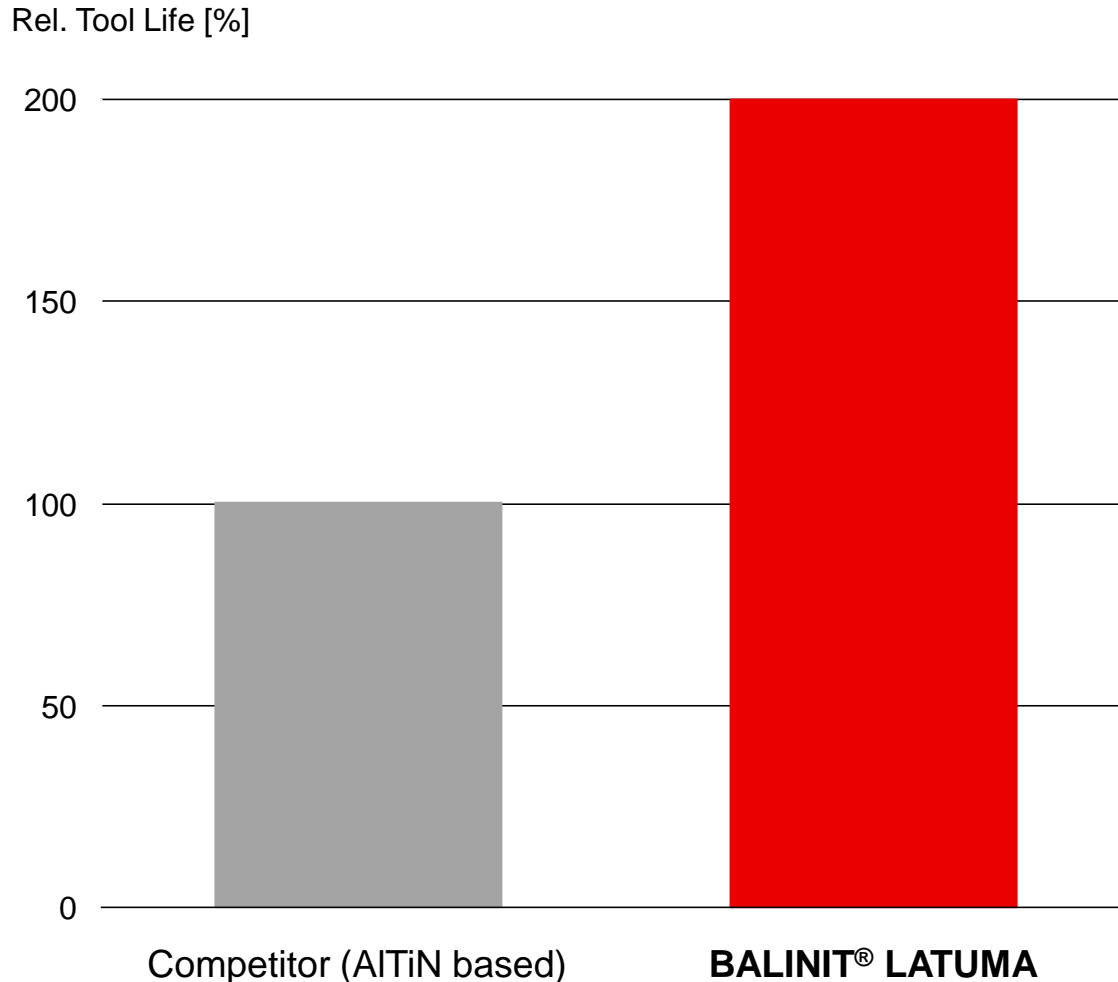


Drilling of steel (C45) also successful at moderate cutting conditions



Tool

Carbide drill
Ø 6.0 mm

Workpiece

Steel 1.0503 (AISI 1045, S45C)

Cutting parameters

$v_c = 80$ m/min
 $f_t = 0.25$ mm/rev
 $L_D = 4xD$
VB = 0.15 mm
Emulsion

Source

Tool Manufacturer