

BALINIT MAYURA – Aluminum machining

oerlikon

Tool:

Solid Carbide Step Drill
(diameter: 9.5mm)

Workpiece:

Aluminium Alloy (Si content 8%)

Cutting data:

Cutting Speed: 110 m/min,
Feed: 0.42 mm
Hole depth: 15.5 mm
No. of holes / comp: 6
Coolant: Water
(cutting oil concentration is 4 to 6 %)

Benefit:

Achieve 50% more tool life.

Source:

Automotive OEM India

