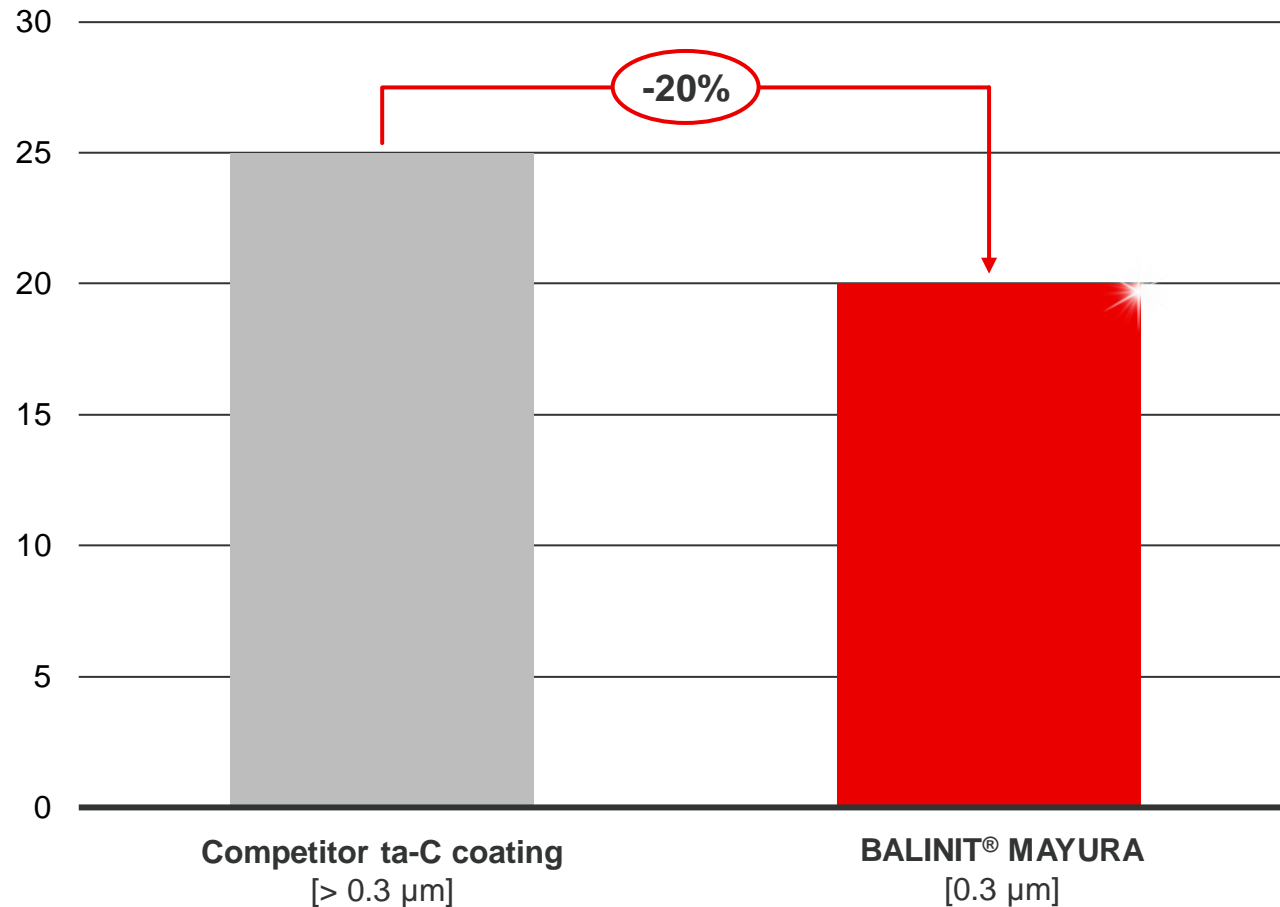


BALINIT MAYURA – Drilling ADC 12

Flank wear after 400 holes [μm]



Tool:

Drill (diameter: 6 mm)

Workpiece:

ADC 12 (Aluminium alloy with 12% Si)

Cutting data:

Cutting speed: 180m/min
Feed: 0.13 mm/rev
Hole depth: 18 mm
No. of holes: 400

Benefit:

Machining aluminium with a high silicon content:

- Significantly less wear
- Less adhesion for sharp cutting edges

Source:

Japanese tool manufacturer