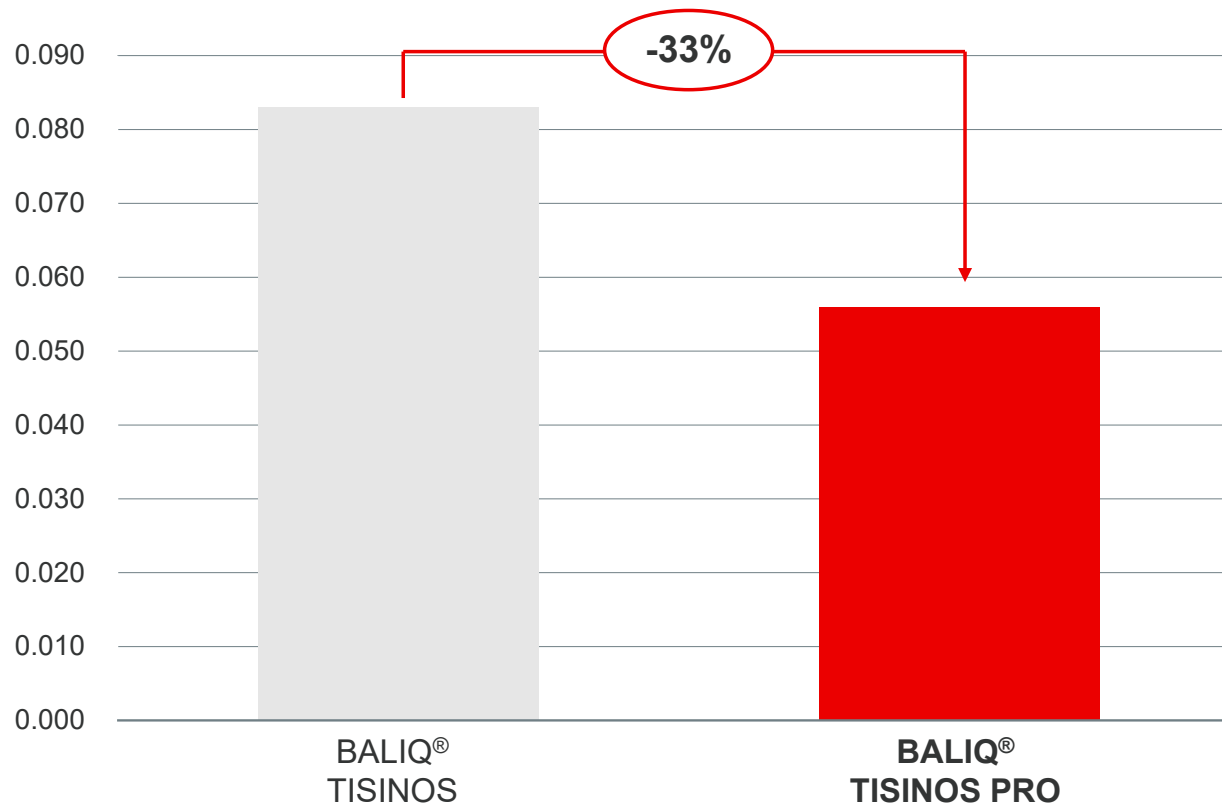


# BALIQ TISINOS PRO

## Drilling austenitic stainless steel (1.4301)

**oerlikon**

Flank Wear [mm]



### Tool

Carbide Drill Ø 5.0 mm

### Workpiece

Austenitic Stainless 1.4301,  
X5CrNi18-10 (SAE 304, UNS  
S30400)

### Cutting parameters

$v_c = 50$  m/min  
 $f_z = 0.1$  mm/rev

### Benefit

Reduced wear

### Source

Tool manufacturer