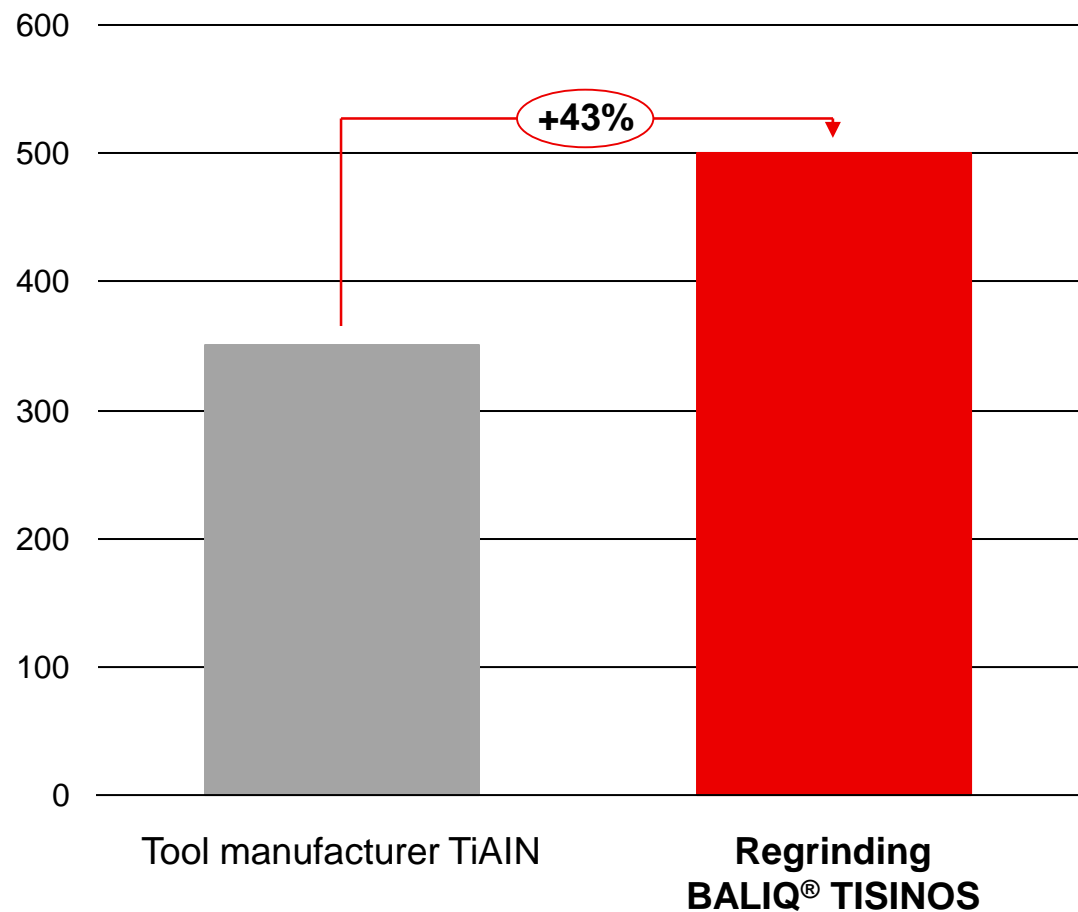


BALIQ TISINOS

Drilling of nickel alloy (72% nickel)

Tool life [holes]



Tool:

Solid carbide drill Ø5mm

Work piece:

Nickle Alloy (72% nickel)
32 HRC

Cutting data:

$v_c = 35$ m/min
 $f = 0.05$ mm/rev
 $a_p = 12$ mm

Benefit:

+43% higher tool life

Source:

Enduser / Automotive industry