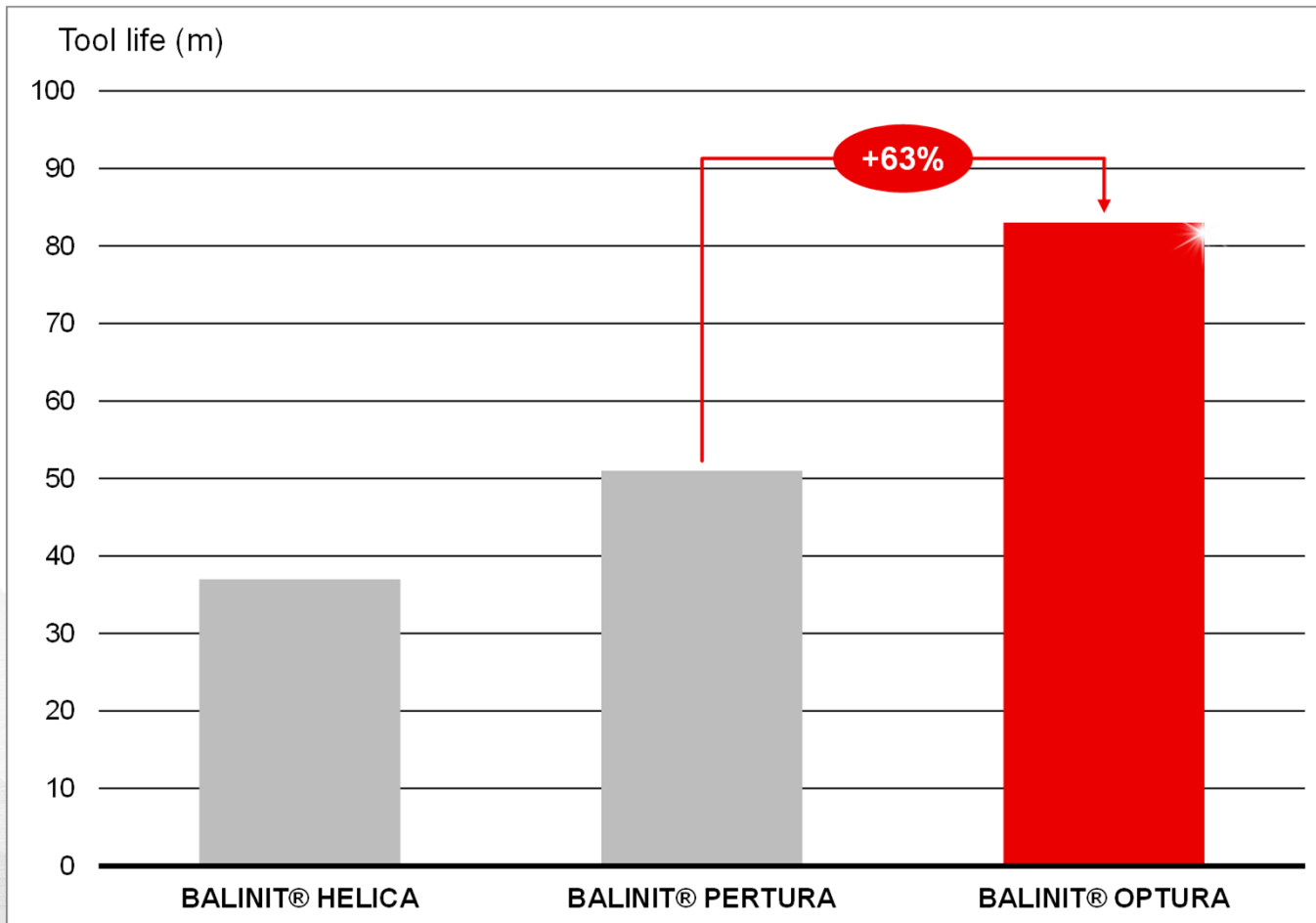


BALINIT OPTURA

Drilling of C45E / AISI 1045 / 1.1191 (1.0503)

oerlikon



Tool:

HP solid carbide drill
D = 8.5 mm, 5xD

Workpiece:

Carbon steel AISI 1045 / C45E / 1.1191 (1.0503), Drilling depth = 40 mm / through

Cutting data:

$v_c = 170$ m/min
 $f = 0.32$ mm
Coolant: Emulsion, $p = 60$ bar

Benefit:

Increase of tool life

Source/Customer:

Balzers Cutting Lab

oerlikon
balzers