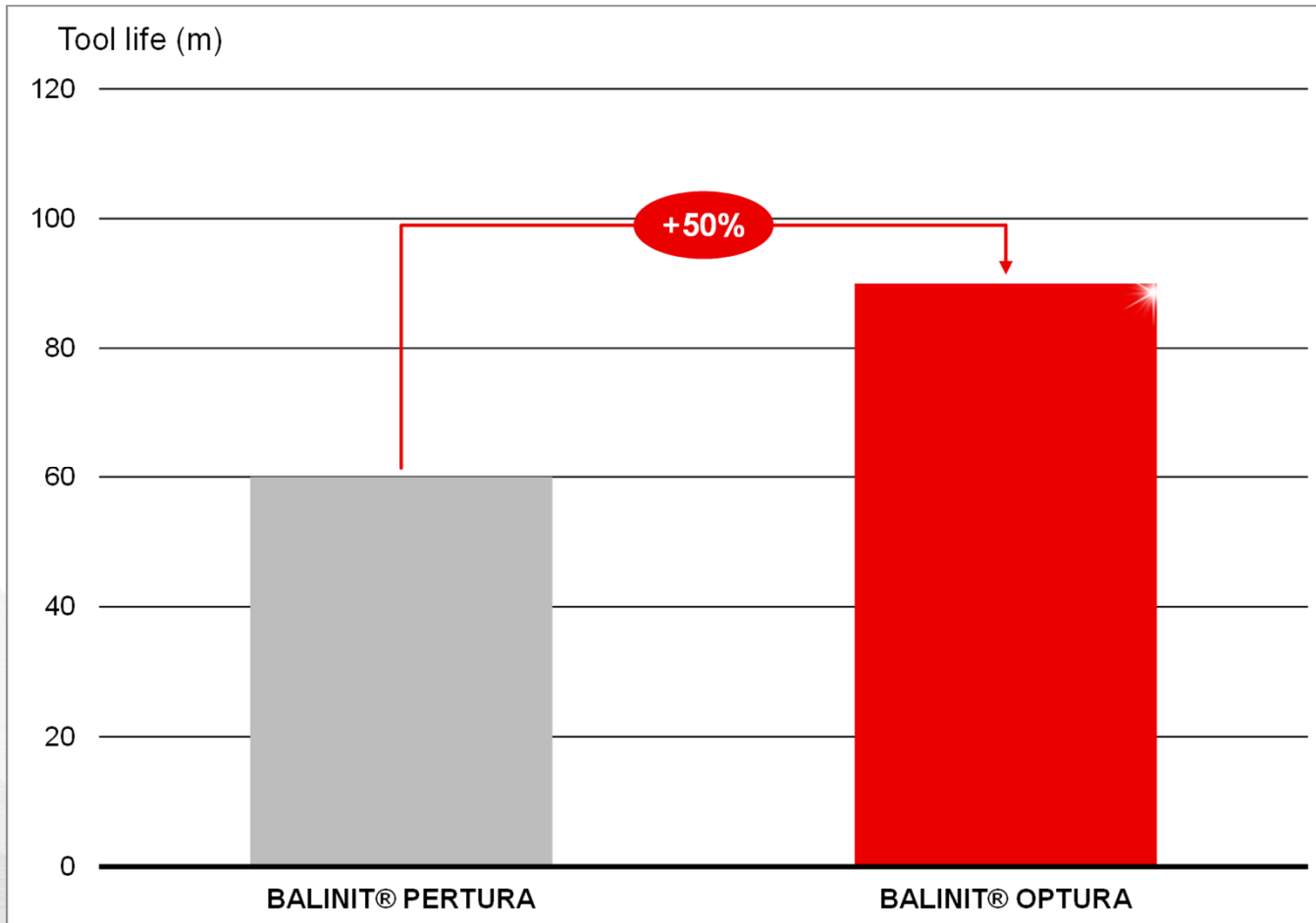


# BALINIT OPTURA

## Drilling of 42CrMo4+QT / AISI 4140 / 1.7225

**oerlikon**



### Tool:

HP solid carbide drill  
D = 8.5 mm, 5xD

### Workpiece:

Low alloy steel AISI 4140 / 42CrMo4+QT / 1.7225, Rm > 1'000 MPa  
Drilling depth = 40 mm / through

### Cutting data:

$v_c = 140$  m/min  
 $f = 0.21$  mm  
Coolant: Emulsion,  $p = 60$  bar

### Benefit:

Increase of tool life

### Source/Customer:

Balzers Cutting Lab

**oerlikon**  
balzers