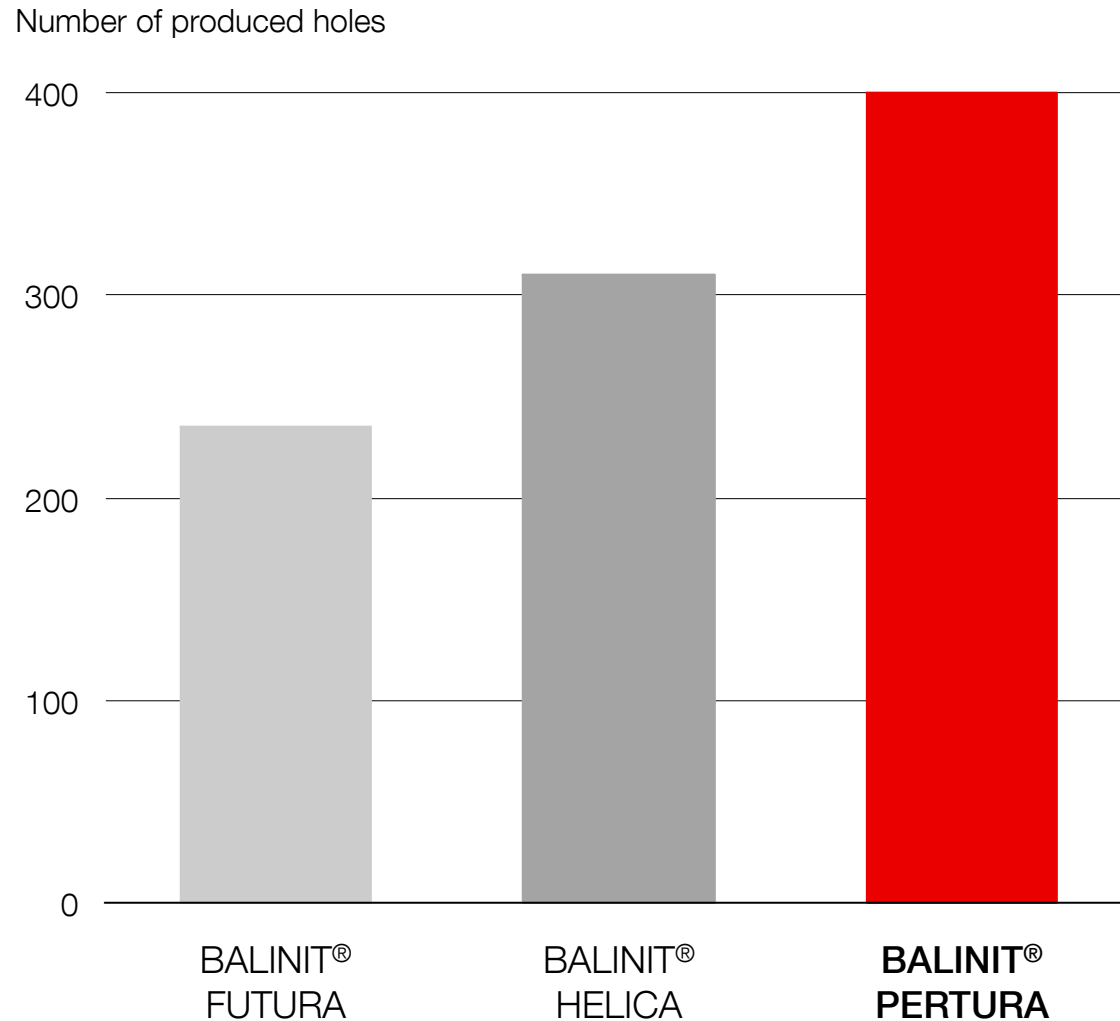


# Drilling of hot work steel



## Tool

Carbide drill,  $\varnothing = 5.5 \text{ mm}$

## Workpiece

Steel 1.2714 (high alloyed steel)  
1200 N/mm<sup>2</sup>

## Cutting parameters

$v_c = 65 \text{ m/min}$   
 $f = 0.10 \text{ mm / rev}$   
 $L_D = 25 \text{ mm}$   
MQL

## Criteria for end of tool life

VB = 0.3 mm

## Source

Oerlikon Balzers  
University of Hamburg