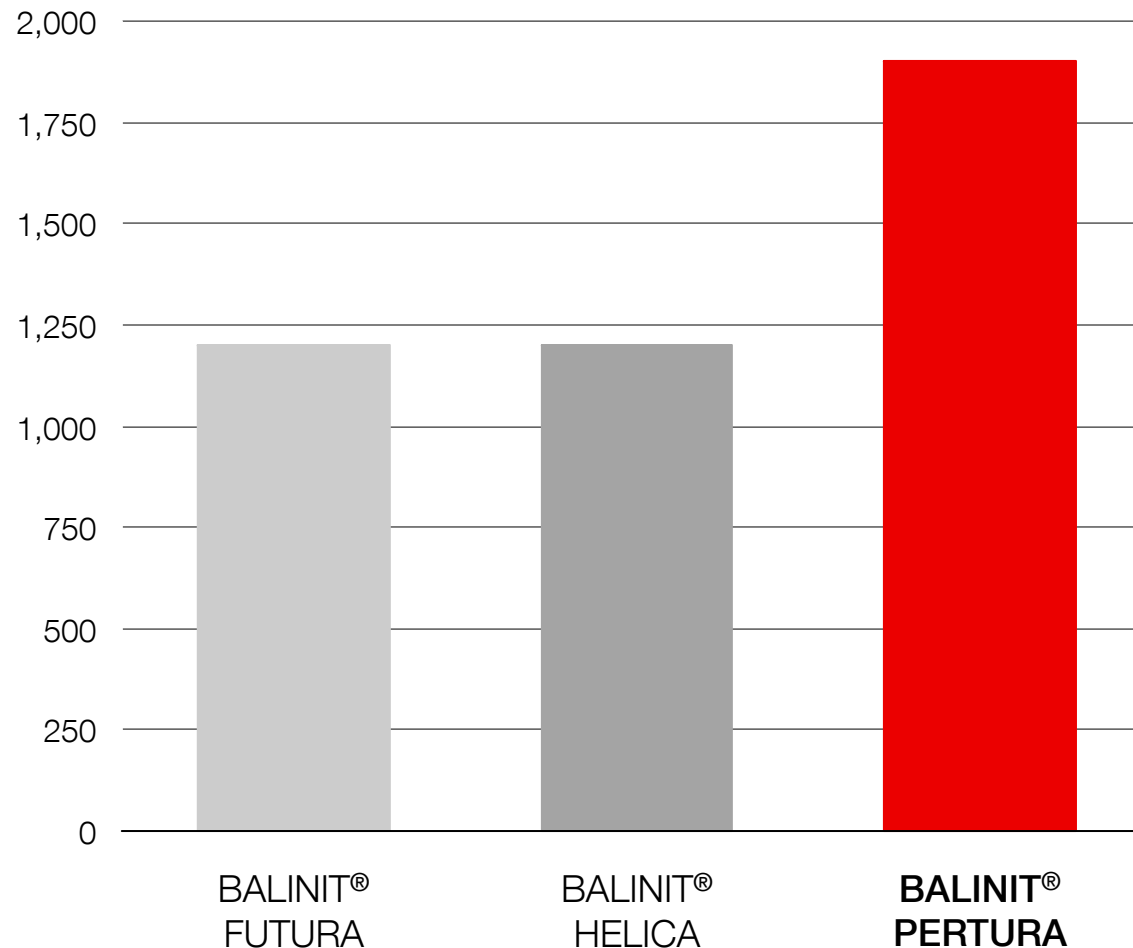


Drilling of stainless steel

Number of produced holes



Tool

Carbide drill

$\varnothing = 8,5 \text{ mm}$

Workpiece

Steel 1.4571 (AISI 316Ti,
SUS316Ti)

Cutting parameters

$v_c = 80 \text{ m/min}$

$f = 0.1 \text{ mm / rev}$

$L_D = 40 \text{ mm}$

Emulsion (internal cooling)

Criteria for end of tool life

$VB = 0.3 \text{ mm}$

Source

Oerlikon Balzers

Cutting Laboratory