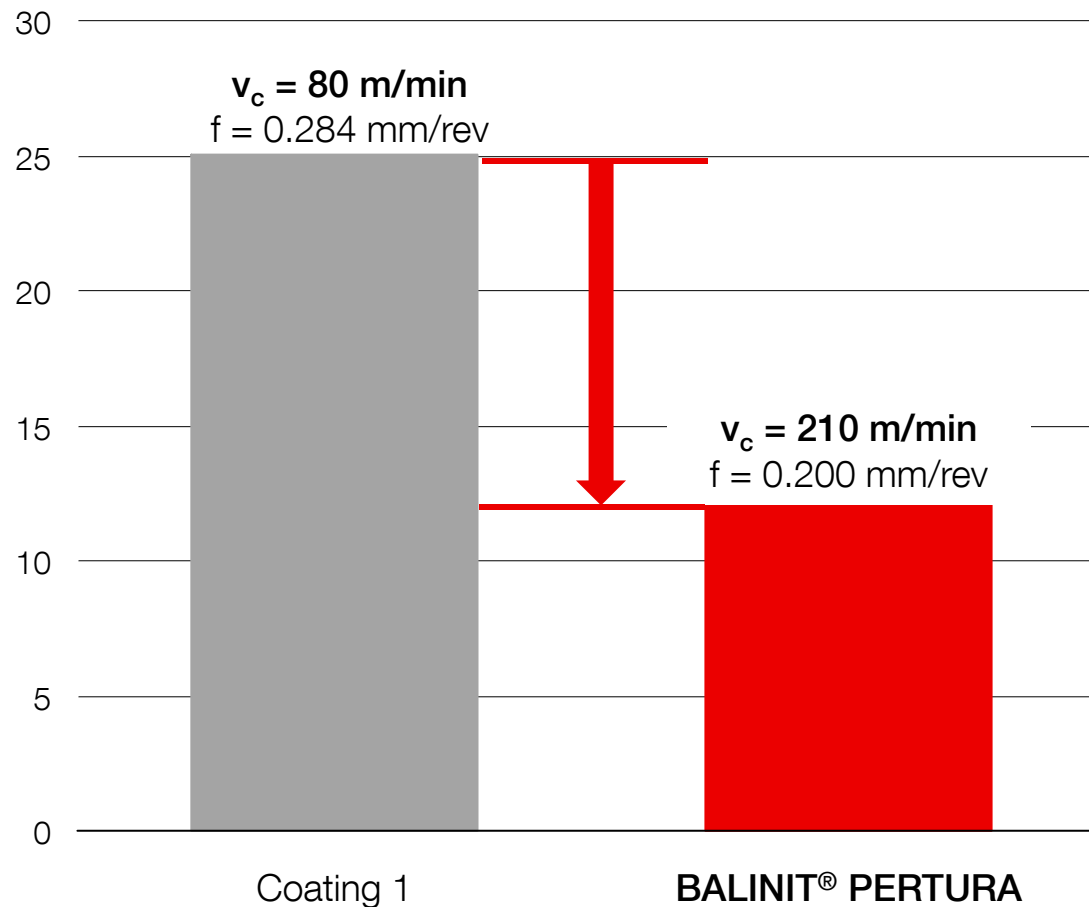


BALINIT® PERTURA increases productivity by +85% at drilling of steel



Machining time to produce 500 holes [min]



Tool

Carbide drill, $\varnothing = 8.5$ mm

Workpiece

Steel 1.7225 (AISI4140, SCM440)
900 N/mm²

Cutting parameters

$L_D = 5 \times D$ (through hole)
Emulsion (internal cooling)

Criteria for end of tool life

VB = 0.3 mm

Source

Oerlikon Balzers
Cutting Laboratory