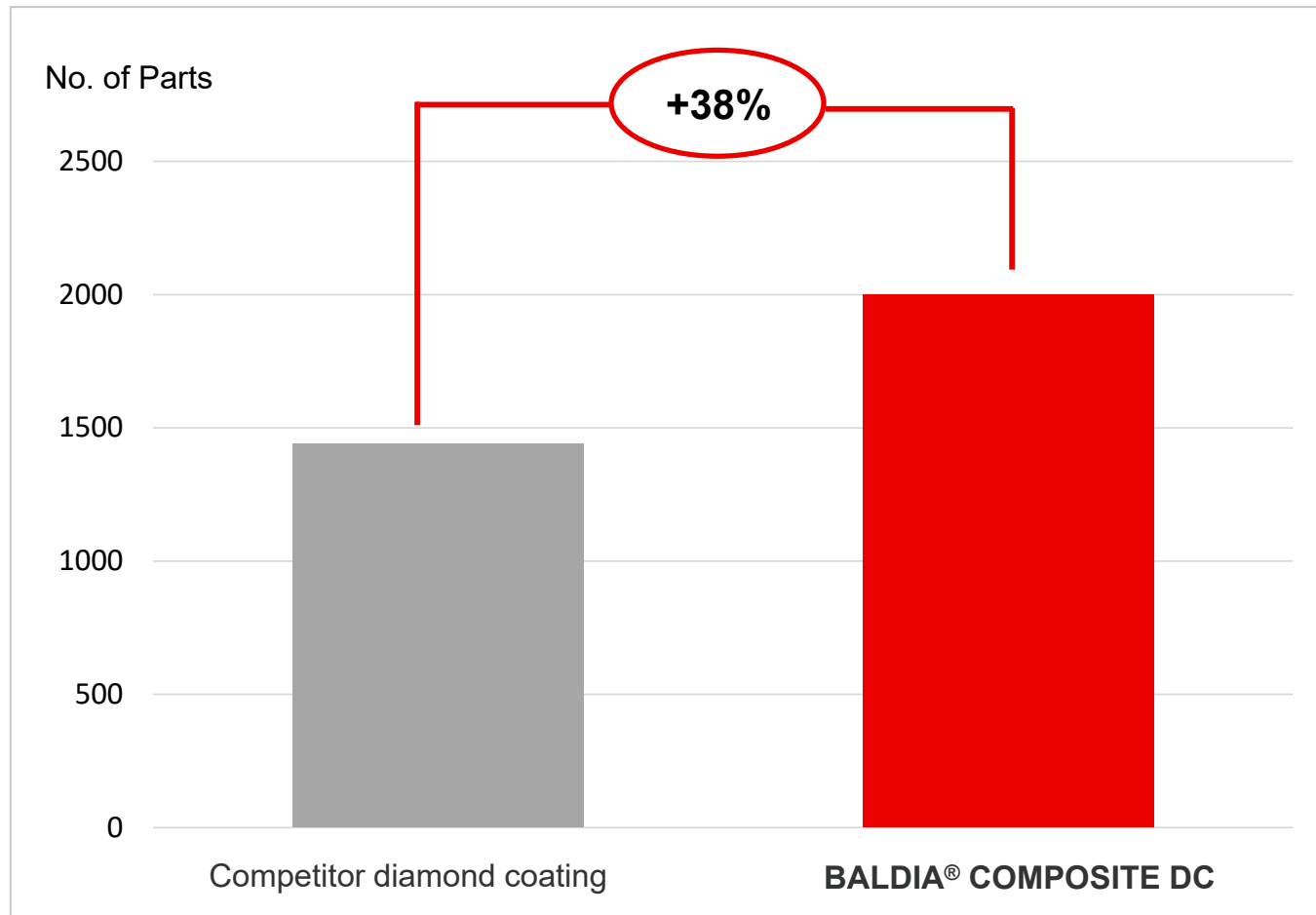


Excellent process reliability and perfect hole quality for drilling CFRP with BALDIA COMPOSITE DC

oerlikon
balzers



Tool:

Cemented carbide step drill
Ø 5.560 mm

Workpiece:

CFK
Carbonwerke / Predo®

Cutting data:

$v_c = 105$ m/min
RPM = 6.000 rpm
 $f = 0.06$ mm/rev

Benefit:

- Low wear of the tool, high process stability, high accuracy and excellent enter and exit hole quality
- Less tool change necessary

Source:

Internal benchmarktest