Drilling of cast iron

Tool
Carbide drill, $\phi = 8.5$ mm

Workpiece
Cast Iron GGG60 (AISI 100-70-03, FCD600)

Cutting parameters
$v_c = 90$ m/min
$f = 0.22$ mm/rev
$L_D = 5xD$ (through hole)
Emulsion (internal cooling)

Criteria for end of tool life
$VB = 0.3$ mm

Source
Oerlikon Balzers
Cutting Laboratory