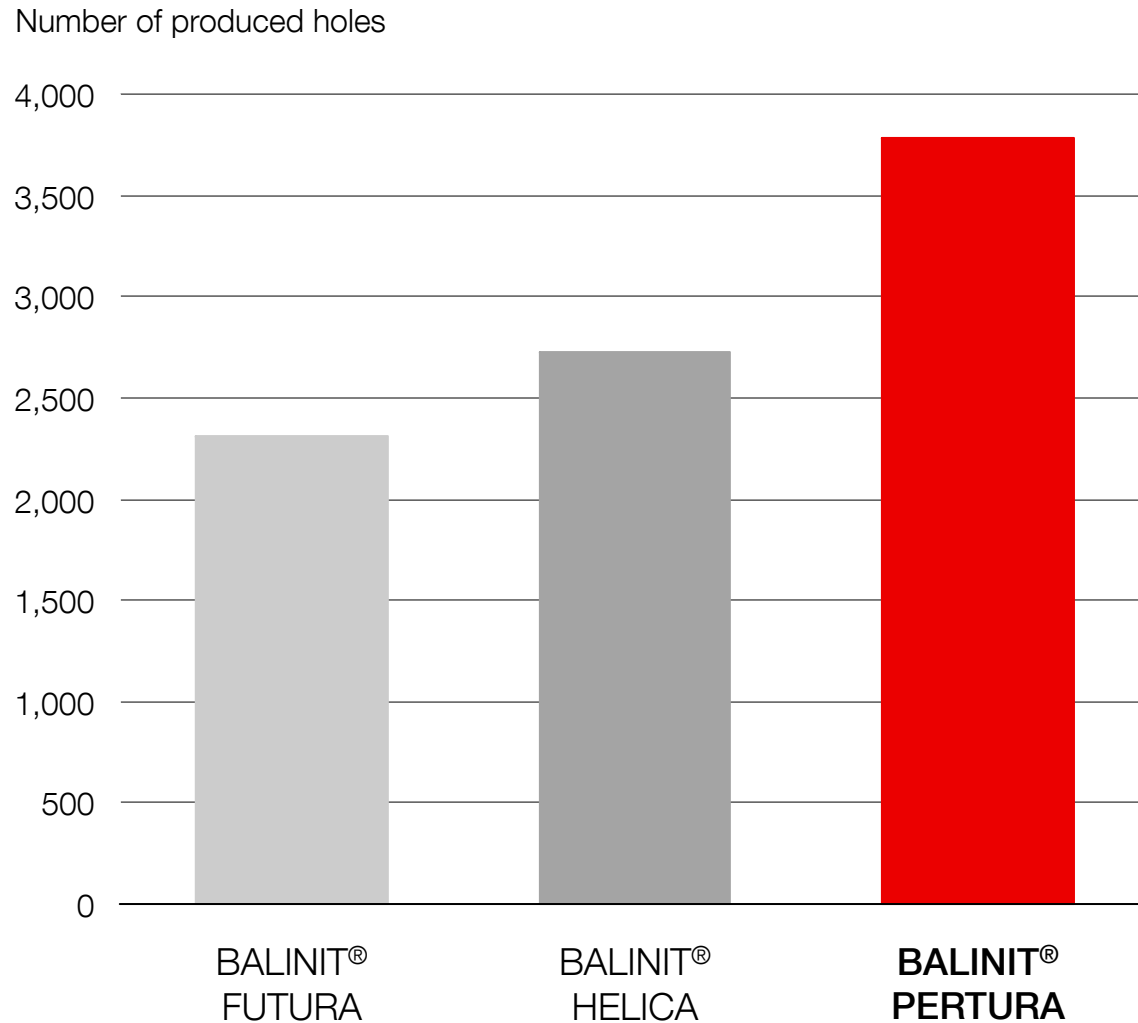


Drilling of cast iron



Tool

Carbide drill, $\varnothing = 8.5$ 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