Drilling of stainless steel

**Tool**
Carbide drill
Ø = 8.5 mm

**Workpiece**
Steel 1.4571 (AISI 316Ti, SUS316Ti)

**Cutting parameters**
- $v_c = 80$ m/min
- $f = 0.1$ mm/rev
- $L_0 = 40$ mm
- Emulsion (internal cooling)

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

**Source**
Oerlikon Balzers
Cutting Laboratory