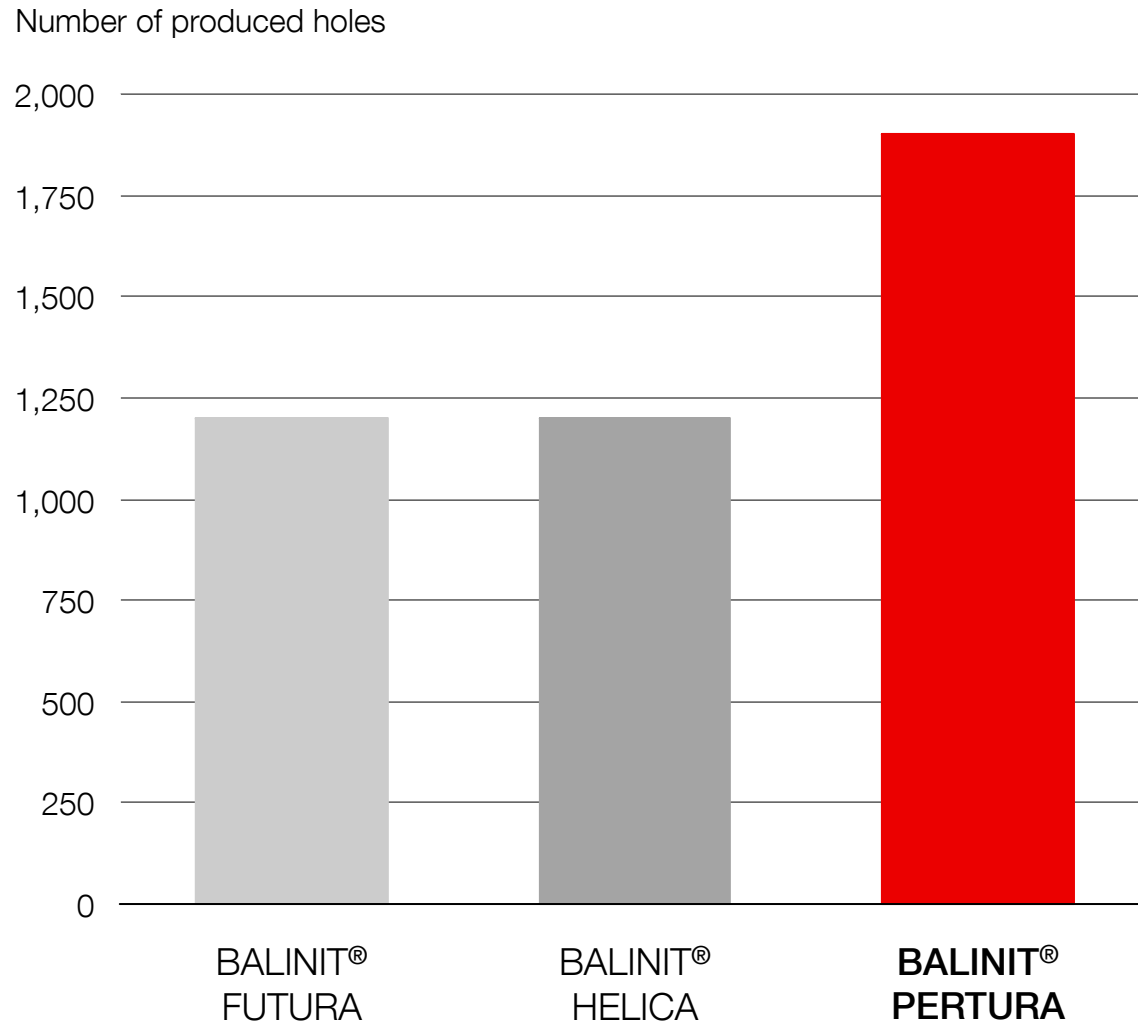


Drilling of stainless steel



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
 $L_D = 40$ mm
Emulsion (internal cooling)

Criteria for end of tool life

VB = 0.3 mm

Source

Oerlikon Balzers
Cutting Laboratory