

Product group: twist drill
Workpiece: others
Material group: S 2.3 - Nickel-base alloys ≤ 1600 N/mm²
Material: Astroloy

Application conditions

before

Machine type CNC machine
 - Manufacturer MoriSeiki
 - Machining plane vertical
 - Internal cooling [bar] none
Tool adaptation collet
Coolant-lubricant O - oil
 - System external
Tool Spiralbohrer
 - Article number DR-CA14JL 220-1820
 - Manufacturer OSG
 - cutting material HM
 - coating
Cutting speed [m/min] 12
 - feed f [mm/rev] 0,024
tool life (no. of drilled holes) 12
tool path [m] 0,29

Problem / Advantage

Comment

- Werkzeuge wurden Aufgrund des Einsatzes mit Außenkühlung mit Entspanzyklus eingesetzt.

Mexico / Michael Maul

drilled hole diameter:

Ø4,6

drilled hole depth [mm]:



drilled hole exit:

straight

after

CNC machine
 MoriSeiki
 vertical
 none
 collet
 O - oil
 external
 Spiralbohrer
TA211344.0460
EMUGE
 HM
TIALN-T63

15

0,09

36

0,86

- increased tool life

bernhard.borschert@emuge.de / 2022-09-28 10:12:16