

**Product group:** twist drill  
**Workpiece:** others  
**Material group:** P 3.1 - Cementation steels, Heat-treatable steels, Cold work steels, etc. ≤ 1000 N/mm<sup>2</sup>  
**Material:** 38MnVs6

**Application conditions**

**before**

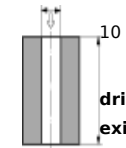
**Machine type** CNC machine  
 - Machining plane vertical  
 - Internal cooling [bar] emulsion  
**Tool adaptation** collet  
 - internal coolant supply E - emulsion  
**Coolant-lubricant** E - emulsion  
 - System internal  
**Tool** Spiralbohrer  
 - Article number  
 - Manufacturer Gühring  
 - cutting material HM  
 - coating  
**Cutting speed [m/min]** 88  
 - feed f [mm/rev] 0,15  
**tool life (no. of drilled holes)** 4.000  
**tool path [m]** 40,00  
**Problem / Advantage** • low tool life

Mexico / Camilo Martinez

**drilled hole diameter:**

Ø8

**drilled hole depth [mm]:**



**drilled hole exit:**

straight

**after**

CNC machine  
 vertical  
 emulsion  
 collet  
 E - emulsion  
 E - emulsion  
 internal

**BASIC-DRILL-5xD-IK**

**TA211344.0800**

**EMUGE**

HM

**TIALN-T63**

88

0,15

7.000

**70,00**

• increased tool life

Julian.Ellis@emuge.de / 2022-12-12 22:26:09