

Ref **370** :

EXPERT DRILL

stainless steel

7'000 holes

INOX 316L/904L
Thickness 8 mm - Through holes

Ø 0.50 to 3.00 mm



Comparative trial

- Ø tested drill : 1.85 mm
- Machined material : Inox 904L et 316L
- Dimensions of the steel plate : 150 x 100 x 8 mm
- Through holes (8 mm)

Cutting conditions :

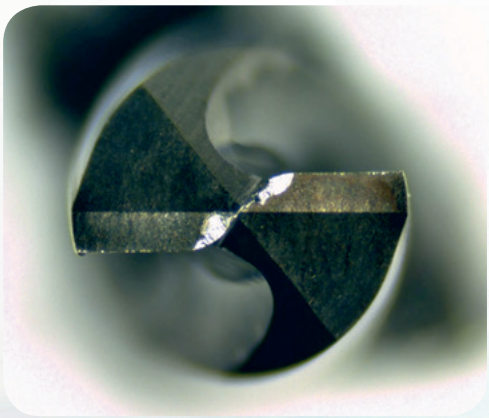
V_c = 30 m/min
 f = 0.04 mm/tour
 n = 5164 tr/min
 V_f = 200 mm/min
Peck drilling = 0.37 mm

End of life criteria

- Broken tool
- Ø out of tolerances : ± 0.01 mm
- Conical hole
- Excessive burr
- Hole location

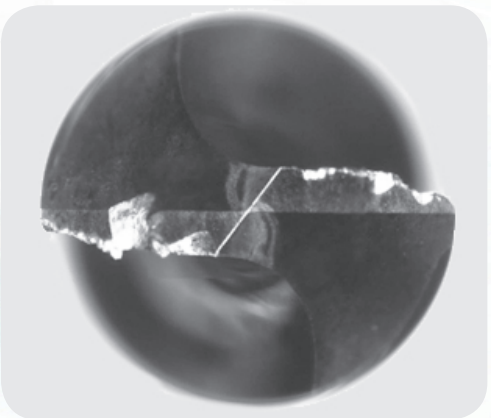


Drill 370



7'000 holes

Standard drill



1'800 holes

Results :

Drilling with
ref. 370

- Less burrs
- Short chips
- Holes more accurate
- Cleaner holes

Examination of the chips



- Fragmentation of the chips
- No chip coiled around the tool shank

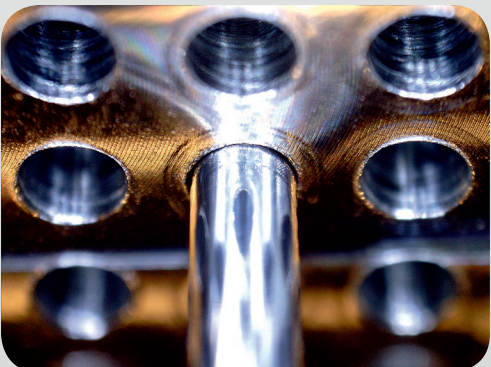


- Long chips
- building of a cluster of chips around the tool shank

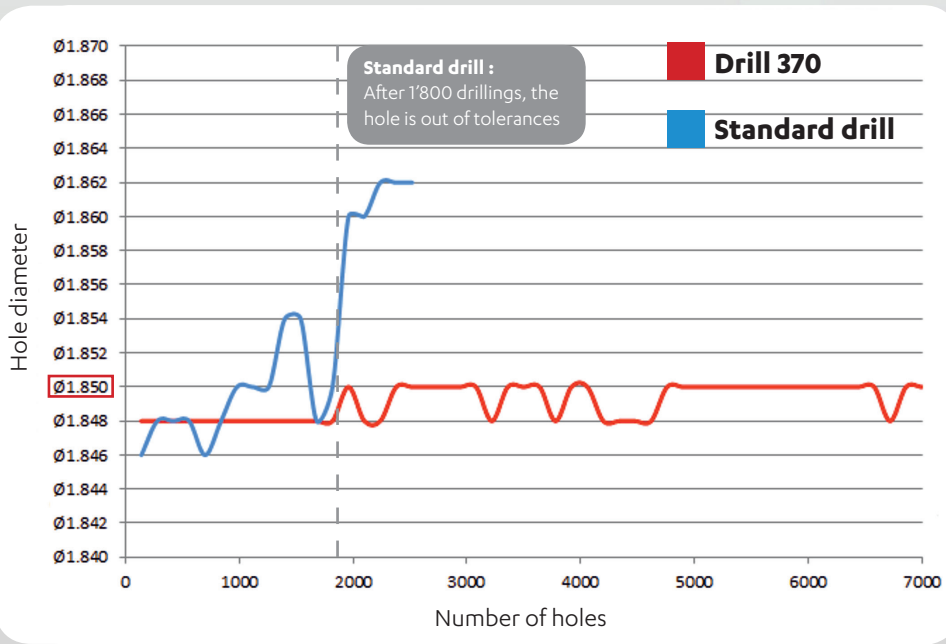
Holes geometries comparison



- Less conicity
- Less marks on holes
- Small burrs



- More conicity
- More burrs





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