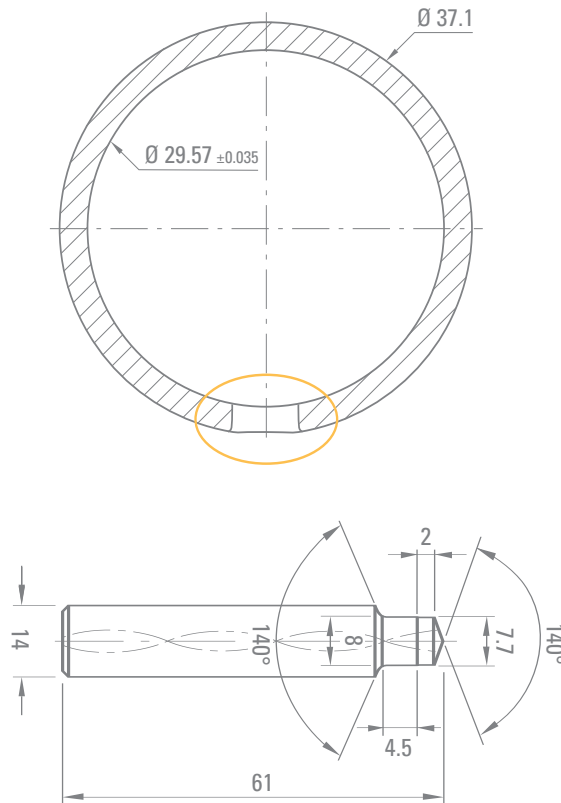


May 2008 - Application of the month

Drilling in SAE 1040 steel Application field: automotive



Tool:
Stepped drill, geometry according to DIXI 1146 with internal cooling

Cutting conditions

Material	SAE 1040 - DIN 1.1186 - CK40
Machine	Emissa transfer machine
Workpiece	Crankschaft axis / automotive
Machining	Drill Ø 7.7 x 2 x Ø 8 x 4.5 x Ø 14/140° x 61 mm

Requests Feed 1'000 mm/min to guarantee the daily productivity and a minimum of 1'500-1'800 holes per drill.

Lubricant Emulsion - 80 bars pressure

Cutting data Vc = 90 m/min
Vf = 1'200 mm/min

Remark With the drills of the competition, the customer could not guarantee his productivity. With the DIXI tool, the requests were respected as well for cycle time as for tool life.