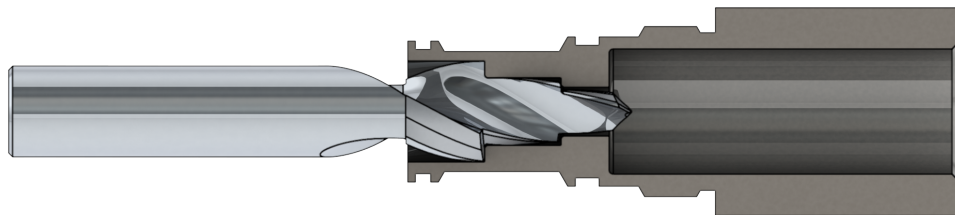


## APPLICATION EXAMPLE

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### MACHINING OF A STEPPED DRILLING

APPLICATION FIELD:  
HYDRAULIC WORKPIECE



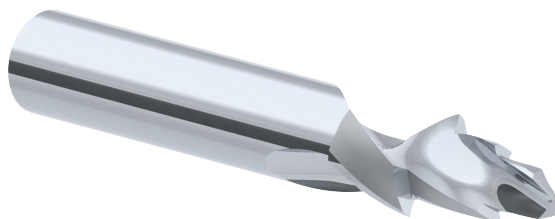
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#### MACHINING

**Tool**

STEPPED TWIST DRILL

**DIXI 1504 SP** Ø 11.7 x Ø 16.2 x Ø 24.2 x Ø 22 x 150 TiAlN



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#### CUTTING CONDITIONS

**Material**

Alloyed steel 1.7227

**Machine**

Dewoo Puma 2600 LSY

**Lubricant**

Emulsion

**Cutting data**

$n = 800 \text{ rev/min}$

$V_f = 152 \text{ mm/min}$

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#### RESULTS

The use of a step drill allowed to cancel the roughing operation and to reduce the number of tools. Cycle time has been reduced by 3 minutes.