

## PCD Vein Drill - Case study

### Test parameters

Vein Drill/countersink .191" (4.88mm)

Cutting speed: 8000 RPM

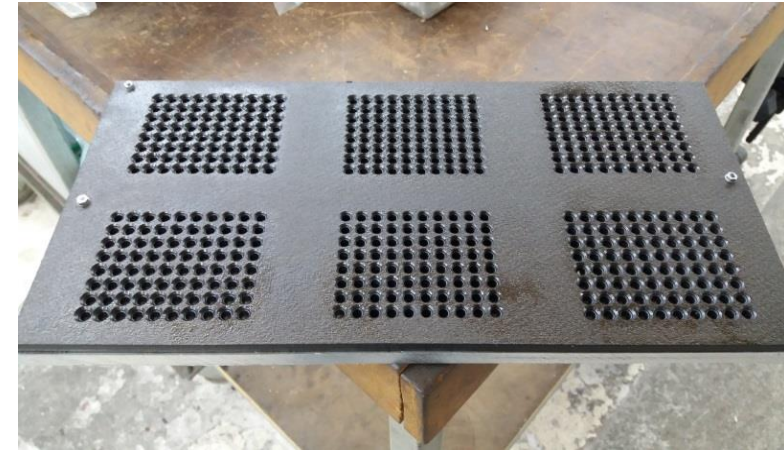
Feed:                600 mm/min @ the CFRP  
                          400 mm/min @ the Aluminum  
                          300 mm/min @ the Countersink section

Coolant:            Mist (air + oil) - External.

Part:                Stack, US customer, Military

CFRP:              6 mm thickness

Alum:               4 mm thickness



### Summary:

**Drill successfully performed 1000 holes in material with excellent quality to the customer satisfactory.**

