

Cutting data recommendations for solid carbide drills

Feed and cutting speed

MEGA-Speed-Drill-Titan | SCD961

MMG*	Workpiece material	Strength/hardness [N/mm ²] [HRC]	Cutting speed v _c [m/min]				Feed f [mm] for drill diameter						
			Internal cooling	External cooling	MQL	Air	3.00	4.50	6.50	9.50	14.00	20.00	
S	S1 S1.1	Titanium, titanium alloys	< 400	40	25			0.077	0.103	0.134	0.173	0.219	0.259
	S2 S2.1	Titanium, titanium alloys	< 1,200	30	20			0.066	0.088	0.115	0.149	0.188	0.222
	S2 S2.2	Titanium, titanium alloys	> 1,200	25	15			0.055	0.073	0.095	0.124	0.157	0.185

* MAPAL machining groups

The specified cutting data are guide values.
The optimum data for the respective machining task should be determined during the test or machining.