

Cutting data recommendations for solid carbide drills

Feed and cutting speed

MEGA-180°-Drill-Alu | SCD241

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		
N	N1.1	Aluminium, unalloyed and alloyed < 3 % Si												
	N1.2	Aluminium, alloyed ≤ 7 % Si												
	N1.3	Aluminium, alloyed > 7 - 12 % Si												
	N1.4	Aluminium, alloyed > 12 % Si												
N2	N2.1	Copper, non-alloy and low-alloy	< 300											
	N2.2	Copper, alloy	> 300											
	N2.3	Brass, bronze, gunmetal	< 1,200											

* MAPAL machining groups

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