Cutting data recommendations for solid carbide drills

Feed and cutting speed

MEGA–Drill–Hardened | SCD141

MMG*		Workpiece material	Strength/hardness [N/mm²] [HRC]		Cutting speed v_c [m/min]				Feed f [mm] for drill diameter					
					Internal cooling	External cooling	MQL	Air	2.50	3.62	5.25	7.61	11.04	16.00
H	H1	H1.1	Hardened steel/cast steel	< 44		80	80	80		0.07	0.09	0.11	0.02	0.19	0.20
		H1.2	Hardened steel/cast steel	< 55		30	30	30		0.05	0.06	0.08	0.10	0.13	0.16
	H2	H2.1	Hardened steel/cast steel	< 60			30	30		0.04	0.05	0.07	0.09	0.11	0.13
		H2.2	Hardened steel/cast steel	< 65			20	20		0.03	0.04	0.05	0.06	0.08	0.09
		H2.3	Hardened steel/cast steel	< 68			15	15		0.03	0.04	0.05	0.06	0.08	0.09

* MAPAL machining groups
** If the alloy parts Cr, Mo, Ni, V, W in total > 8% then select the next highest MAPAL machining group.

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