

Cutting data recommendations for solid carbide drills

Feed and cutting speed

MEGA-Speed-Drill-Iron | SCD421

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		
K	K1.1	Cast iron with lamellar graphite (grey cast iron), GJL	< 300	170	120	120	120	0.15	0.21	0.29	0.40	0.51	0.61	
	K2.1	Cast iron with spheroidal graphite, GJS	< 500	225	140	170	170	0.15	0.21	0.28	0.37	0.48	0.57	
	K2	K2.2	Cast iron with spheroidal graphite, GJS	≤ 800	140	105	105		0.14	0.19	0.25	0.32	0.41	0.49
		K2.3	Cast iron with spheroidal graphite, GJS	> 800	85	55	70		0.10	0.13	0.17	0.22	0.27	0.32
	K3	K3.1	Cast iron with spheroidal graphite, GJV; malleable cast iron, GJM	< 500	125	110	110		0.15	0.20	0.26	0.35	0.44	0.52
		K3.2	Cast iron with spheroidal graphite, GJV; malleable cast iron, GJM	> 500	110	100	100		0.13	0.17	0.22	0.28	0.35	0.41

* 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.