

# Cutting data recommendations for solid carbide drills

Feed and cutting speed

## MEGA-180°-Drill-Alu | SCD241

MMG*		Workpiece material	Strength/hardness [N/mm <sup>2</sup> ] [HRC]
N	N1	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

## Ecu-G-Drill | SCD211

MMG*		Workpiece material	Strength/hardness [N/mm <sup>2</sup> ] [HRC]
K	K1	K1.1 Cast iron with lamellar graphite (grey cast iron), GJL	< 300
		K2.1 Cast iron with spheroidal graphite, GJS	< 500
		K2.2 Cast iron with spheroidal graphite, GJS	≤ 800
		K2.3 Cast iron with spheroidal graphite, GJS	> 800
N	N1	N1.1 Aluminium, non-alloy and alloy < 3 % Si	
		N1.2 Aluminium, alloy ≤ 7 % Si	
		N1.3 Aluminium, alloy > 7-12 % Si	
		N1.4 Aluminium, alloy > 12 % Si	
	N2	N2.1 Copper, non-alloy and low-alloy	< 300
		N2.2 Copper, alloy	> 300
		N2.3 Brass, bronze, gunmetal	< 1,200