

CrazyDrill™ Alu

 **MIKRON**



The cost-effective
high-performance small drill

CRAZYDRILL™
by Mikron Tool
Alu

The range

CRAZYDRILL™
by Mikron Tool

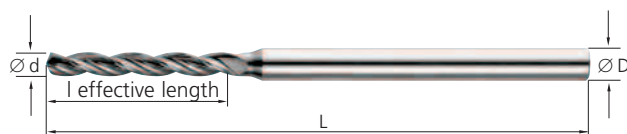
Alu

Usable length 5 x d

Item Number	d (k ₅) mm	l mm	D (h ₆) mm	L mm
CD.050040.A	0.40	2.9	3.0	43.0
CD.050045.A	0.45	3.3	3.0	43.0
CD.050050.A	0.50	3.6	3.0	43.0
CD.050055.A	0.55	4.0	3.0	43.0
CD.050060.A	0.60	4.3	3.0	43.0
CD.050065.A	0.65	4.7	3.0	43.0
CD.050070.A	0.70	5.1	3.0	45.0
CD.050075.A	0.75	5.4	3.0	45.0
CD.050080.A	0.80	5.8	3.0	45.0
CD.050085.A	0.85	6.1	3.0	45.0
CD.050090.A	0.90	6.5	3.0	45.0
CD.050095.A	0.95	6.9	3.0	46.0
CD.050100.A	1.00	7.2	3.0	46.0
CD.050105.A	1.05	7.6	3.0	46.0
CD.050110.A	1.10	8.0	3.0	46.0
CD.050115.A	1.15	8.3	3.0	48.0
CD.050120.A	1.20	8.7	3.0	48.0
CD.050125.A	1.25	9.0	3.0	48.0
CD.050130.A	1.30	9.4	3.0	48.0
CD.050135.A	1.35	9.8	3.0	48.0
CD.050140.A	1.40	10.1	3.0	48.0
CD.050145.A	1.45	10.5	3.0	49.0
CD.050150.A	1.50	10.9	3.0	49.0
CD.050155.A	1.55	11.2	3.0	50.5
CD.050160.A	1.60	11.6	3.0	50.5
CD.050165.A	1.65	11.9	3.0	50.5
CD.050170.A	1.70	12.3	3.0	50.5
CD.050175.A	1.75	12.7	3.0	52.0
CD.050180.A	1.80	13.0	3.0	52.0
CD.050185.A	1.85	13.4	3.0	52.0
CD.050190.A	1.90	13.7	3.0	53.5
CD.050195.A	1.95	14.1	3.0	53.5
CD.050200.A	2.00	14.5	4.0	60.0
CD.050205.A	2.05	14.8	4.0	60.0
CD.050210.A	2.10	15.2	4.0	60.0
CD.050215.A	2.15	15.6	4.0	60.0
CD.050220.A	2.20	15.9	4.0	61.5
CD.050225.A	2.25	16.3	4.0	61.5
CD.050230.A	2.30	16.6	4.0	61.5
CD.050235.A	2.35	17.0	4.0	61.5
CD.050240.A	2.40	17.4	4.0	62.0
CD.050245.A	2.45	17.7	4.0	62.0
CD.050250.A	2.50	18.1	4.0	62.0
CD.050255.A	2.55	18.4	4.0	63.0
CD.050260.A	2.60	18.8	4.0	63.0
CD.050265.A	2.65	19.2	4.0	63.0
CD.050270.A	2.70	19.5	4.0	63.0
CD.050275.A	2.75	19.9	4.0	64.5
CD.050280.A	2.80	20.3	4.0	64.5
CD.050285.A	2.85	20.6	4.0	64.5
CD.050290.A	2.90	21.0	4.0	65.0
CD.050295.A	2.95	21.3	4.0	65.0
CD.050300.A	3.00	21.7	4.0	65.0

Usable length 10 x d

Item Number	d (k ₅) mm	l mm	D (h ₆) mm	L mm
CD.100040.A	0.40	4.9	3.0	45.0
CD.100045.A	0.45	5.5	3.0	45.0
CD.100050.A	0.50	6.1	3.0	45.0
CD.100055.A	0.55	6.7	3.0	45.0
CD.100060.A	0.60	7.3	3.0	47.0
CD.100065.A	0.65	8.0	3.0	47.0
CD.100070.A	0.70	8.6	3.0	47.0
CD.100075.A	0.75	9.2	3.0	49.0
CD.100080.A	0.80	9.8	3.0	49.0
CD.100085.A	0.85	10.4	3.0	49.0
CD.100090.A	0.90	11.0	3.0	49.0
CD.100095.A	0.95	11.6	3.0	50.5
CD.100100.A	1.00	12.2	3.0	50.5
CD.100105.A	1.05	12.8	3.0	52.0
CD.100110.A	1.10	13.5	3.0	52.0
CD.100115.A	1.15	14.1	3.0	53.5
CD.100120.A	1.20	14.7	3.0	53.5
CD.100125.A	1.25	15.3	3.0	53.5
CD.100130.A	1.30	15.9	3.0	55.5
CD.100135.A	1.35	16.5	3.0	55.5
CD.100140.A	1.40	17.1	3.0	55.5
CD.100145.A	1.45	17.7	3.0	55.5
CD.100150.A	1.50	18.4	4.0	64.5
CD.100155.A	1.55	19.0	4.0	64.5
CD.100160.A	1.60	19.6	4.0	64.5
CD.100165.A	1.65	20.2	4.0	64.5
CD.100170.A	1.70	20.8	4.0	67.0
CD.100175.A	1.75	21.4	4.0	67.0
CD.100180.A	1.80	22.0	4.0	67.0
CD.100185.A	1.85	22.6	4.0	68.5
CD.100190.A	1.90	23.2	4.0	68.5
CD.100195.A	1.95	23.9	4.0	68.5
CD.100200.A	2.00	24.5	4.0	70.0
CD.100205.A	2.05	25.1	4.0	70.0
CD.100210.A	2.10	25.7	4.0	70.0
CD.100215.A	2.15	26.3	4.0	72.0
CD.100220.A	2.20	26.9	4.0	72.0
CD.100225.A	2.25	27.5	4.0	72.0
CD.100230.A	2.30	28.1	4.0	73.5
CD.100235.A	2.35	28.7	4.0	73.5
CD.100240.A	2.40	29.4	4.0	73.5
CD.100245.A	2.45	30.0	4.0	75.0
CD.100250.A	2.50	30.6	4.0	75.0
CD.100255.A	2.55	31.2	4.0	75.0
CD.100260.A	2.60	31.8	4.0	76.5
CD.100265.A	2.65	32.4	4.0	76.5
CD.100270.A	2.70	33.0	4.0	76.5
CD.100275.A	2.75	33.6	4.0	78.0
CD.100280.A	2.80	34.3	4.0	78.0
CD.100285.A	2.85	34.9	4.0	78.0
CD.100290.A	2.90	35.5	4.0	80.0
CD.100295.A	2.95	36.1	4.0	80.0
CD.100300.A	3.00	36.7	4.0	80.0



Execution: Coated carbide alloy with cylindrical shank and cutting angle of 140°.

Recommended cutting data

Aluminium Alloys, Wrought (for ex. AlSi1 – AlSi1Mn – AlSi1MgMn)

Drill-length	Drill-depth	Cutting speed Vc m/min	Feed f in mm/revolution in relation to diameter					
			0.5 mm	1.0 mm	1.5 mm	2.0 mm	2.5 mm	3.0 mm
Short-size Swarf evacuation	5 x d	up to 300	up to 0,03 none	up to 0,05 none	up to 0,10 none	up to 0,20 none	up to 0,25 none	up to 0,30 none
Long-size Swarf evacuation	10 x d	up to 300	up to 0,03 after 5 x d	up to 0,04 after 5 x d	up to 0,10 after 5 x d	up to 0,20 after 5 x d	up to 0,25 after 5 x d	up to 0,30 after 5 x d

Aluminium Alloys, Cast (for ex. GD-AlSi9Cu3 – GD-AlSi12 – GD-AlSi12(Cu) – GD-AlSi10Mg)

Drill-length	Drill-depth	Cutting speed Vc m/min	Feed f in mm/revolution in relation to diameter					
			0.5 mm	1.0 mm	1.5 mm	2.0 mm	2.5 mm	3.0 mm
Short-size Swarf evacuation	5 x d	up to 200	up to 0,10 none	up to 0,20 none	up to 0,25 none	up to 0,30 none	up to 0,40 none	up to 0,50 none
Long-size Swarf evacuation	10 x d	up to 200	up to 0,07 after 5 x d	up to 0,10 after 5 x d	up to 0,15 after 5 x d	up to 0,25 after 5 x d	up to 0,30 after 5 x d	up to 0,40 after 5 x d

Important criteria for using CrazyDrill Alu

For best results, Mikron Tool recommends the use of cutting oil as lubricant. The use of water based coolant with high pressure additives, or minimum quantity lubrication is also possible as an alternative. In this case, the cutting parameters have to be adjusted accordingly.

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by Mikron Tool
Alu

Five benefits:

1. fastest drill speeds
2. highest drill-precision
3. self-centering
4. fewer drill returns for swarf evacuation
5. excellent service life



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