

CrazyDrill™ Steel

MIKRON



The cost-effective
high-performance small drill

CRAZYDRILL™
by Mikron Tool
Steel

The high-performance range

CRAZYDRILL™
by Mikron Tool

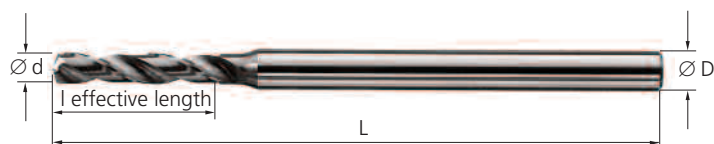
Steel

Usable length 4 x d

Item number	d (k5) mm	l mm	D (h6) mm	L mm	Item number	d (k5) mm	l mm	D (h6) mm	L mm
CD.040040.S	0.40	2.00	3.0	42.0	CD.040270.S	2.70	13.50	4.0	58.0
CD.040045.S	0.45	2.30	3.0	42.0	CD.040275.S	2.75	13.70	4.0	58.0
CD.040050.S	0.50	2.50	3.0	42.0	CD.040280.S	2.80	14.20	4.0	59.0
CD.040055.S	0.55	2.80	3.0	42.0	CD.040285.S	2.85	14.40	4.0	59.0
CD.040060.S	0.60	3.00	3.0	43.5	CD.040290.S	2.90	14.50	4.0	59.0
CD.040065.S	0.65	3.30	3.0	43.5	CD.040295.S	2.95	14.70	4.0	59.0
CD.040070.S	0.70	3.50	3.0	43.5	CD.040300.S	3.00	14.80	4.0	59.0
CD.040075.S	0.75	3.80	3.0	43.5	CD.040305.S	3.05	15.30	4.0	60.0
CD.040080.S	0.80	4.00	3.0	43.5	CD.040310.S	3.10	15.50	4.0	60.0
CD.040085.S	0.85	4.20	3.0	43.5	CD.040315.S	3.15	15.80	4.0	60.0
CD.040090.S	0.90	4.50	3.0	43.5	CD.040320.S	3.20	16.00	4.0	60.0
CD.040095.S	0.95	4.70	3.0	43.5	CD.040325.S	3.25	16.30	4.0	60.0
CD.040100.S	1.00	5.00	3.0	44.0	CD.040330.S	3.30	16.50	4.0	60.0
CD.040105.S	1.05	5.30	3.0	44.0	CD.040335.S	3.35	16.80	4.0	60.0
CD.040110.S	1.10	5.40	3.0	44.0	CD.040340.S	3.40	17.00	4.0	60.0
CD.040115.S	1.15	5.70	3.0	44.0	CD.040345.S	3.45	17.30	4.0	60.0
CD.040120.S	1.20	6.00	3.0	45.0	CD.040350.S	3.50	17.50	4.0	60.0
CD.040125.S	1.25	6.20	3.0	45.0	CD.040355.S	3.55	17.80	4.0	60.0
CD.040130.S	1.30	6.50	3.0	45.0	CD.040360.S	3.60	18.00	4.0	64.5
CD.040135.S	1.35	6.70	3.0	45.0	CD.040365.S	3.65	18.30	4.0	64.5
CD.040140.S	1.40	7.00	3.0	46.0	CD.040370.S	3.70	18.50	4.0	64.5
CD.040145.S	1.45	7.30	3.0	46.0	CD.040375.S	3.75	18.80	4.0	64.5
CD.040150.S	1.50	7.40	3.0	46.0	CD.040380.S	3.80	19.00	4.0	64.5
CD.040155.S	1.55	7.70	3.0	46.0	CD.040385.S	3.85	19.30	4.0	64.5
CD.040160.S	1.60	8.10	3.0	47.0	CD.040390.S	3.90	19.50	4.0	64.5
CD.040165.S	1.65	8.30	3.0	47.0	CD.040395.S	3.95	19.80	4.0	64.5
CD.040170.S	1.70	8.50	3.0	47.0	CD.040400.S	4.00	20.00	6.0	70.0
CD.040175.S	1.75	8.70	3.0	47.0	CD.040410.S	4.10	20.50	6.0	70.0
CD.040180.S	1.80	9.20	3.0	48.0	CD.040420.S	4.20	21.00	6.0	70.0
CD.040185.S	1.85	9.40	3.0	48.0	CD.040430.S	4.30	21.50	6.0	70.0
CD.040190.S	1.90	9.50	3.0	48.0	CD.040440.S	4.40	22.00	6.0	70.0
CD.040195.S	1.95	9.70	3.0	48.0	CD.040450.S	4.50	22.50	6.0	70.0
CD.040200.S	2.00	10.10	4.0	55.0	CD.040460.S	4.60	23.00	6.0	70.0
CD.040205.S	2.05	10.30	4.0	55.0	CD.040470.S	4.70	23.50	6.0	70.0
CD.040210.S	2.10	10.40	4.0	55.0	CD.040480.S	4.80	24.00	6.0	70.0
CD.040215.S	2.15	10.70	4.0	55.0	CD.040490.S	4.90	24.50	6.0	70.0
CD.040220.S	2.20	11.00	4.0	56.0	CD.040500.S	5.00	25.00	6.0	70.0
CD.040225.S	2.25	11.20	4.0	56.0	CD.040510.S	5.10	25.50	6.0	70.0
CD.040230.S	2.30	11.50	4.0	56.0	CD.040520.S	5.20	26.00	6.0	75.0
CD.040235.S	2.35	11.70	4.0	56.0	CD.040530.S	5.30	26.50	6.0	75.0
CD.040240.S	2.40	12.00	4.0	57.0	CD.040540.S	5.40	27.00	6.0	75.0
CD.040245.S	2.45	12.30	4.0	57.0	CD.040550.S	5.50	27.50	6.0	75.0
CD.040250.S	2.50	12.40	4.0	57.0	CD.040560.S	5.60	28.00	6.0	75.0
CD.040255.S	2.55	12.70	4.0	57.0	CD.040570.S	5.70	28.50	6.0	75.0
CD.040260.S	2.60	13.10	4.0	58.0	CD.040580.S	5.80	29.00	6.0	75.0
CD.040265.S	2.65	13.30	4.0	58.0	CD.040590.S	5.90	29.50	6.0	75.0
					CD.040600.S	6.00	30.00	6.0	75.0

Usable length 7 x d

Item number	d (k5) mm	l mm	D (h6) mm	L mm	Item number	d (k5) mm	l mm	D (h6) mm	L mm
CD.070040.S	0.40	2.80	3.0	42.0	CD.070270.S	2.70	21.50	4.0	66.0
CD.070045.S	0.45	3.20	3.0	42.0	CD.070275.S	2.75	21.70	4.0	66.0
CD.070050.S	0.50	3.50	3.0	42.0	CD.070280.S	2.80	22.70	4.0	67.5
CD.070055.S	0.55	3.90	3.0	42.0	CD.070285.S	2.85	22.90	4.0	67.5
CD.070060.S	0.60	4.20	3.0	43.5	CD.070290.S	2.90	23.00	4.0	67.5
CD.070065.S	0.65	4.60	3.0	43.5	CD.070295.S	2.95	23.20	4.0	67.5
CD.070070.S	0.70	4.90	3.0	43.5	CD.070300.S	3.00	23.40	4.0	67.5
CD.070075.S	0.75	5.30	3.0	43.5	CD.070305.S	3.05	24.40	4.0	70.0
CD.070080.S	0.80	5.60	3.0	45.0	CD.070310.S	3.10	24.80	4.0	70.0
CD.070085.S	0.85	5.90	3.0	45.0	CD.070315.S	3.15	25.20	4.0	70.0
CD.070090.S	0.90	6.30	3.0	45.0	CD.070320.S	3.20	25.60	4.0	70.0
CD.070095.S	0.95	6.60	3.0	45.0	CD.070325.S	3.25	26.00	4.0	70.0
CD.070100.S	1.00	7.00	3.0	46.0	CD.070330.S	3.30	26.40	4.0	70.0
CD.070105.S	1.05	7.30	3.0	46.0	CD.070335.S	3.35	26.80	4.0	70.0
CD.070110.S	1.10	7.70	3.0	46.0	CD.070340.S	3.40	27.20	4.0	70.0
CD.070115.S	1.15	7.80	3.0	46.0	CD.070345.S	3.45	27.60	4.0	75.0
CD.070120.S	1.20	9.90	3.0	49.0	CD.070350.S	3.50	28.00	4.0	75.0
CD.070125.S	1.25	10.10	3.0	49.0	CD.070355.S	3.55	28.40	4.0	75.0
CD.070130.S	1.30	10.40	3.0	49.0	CD.070360.S	3.60	28.80	4.0	75.0
CD.070135.S	1.35	10.70	3.0	49.0	CD.070365.S	3.65	29.20	4.0	75.0
CD.070140.S	1.40	11.50	3.0	50.5	CD.070370.S	3.70	29.60	4.0	75.0
CD.070145.S	1.45	11.70	3.0	50.5	CD.070375.S	3.75	30.00	4.0	75.0
CD.070150.S	1.50	12.00	3.0	50.5	CD.070380.S	3.80	30.40	4.0	75.0
CD.070155.S	1.55	12.30	3.0	50.5	CD.070385.S	3.85	30.80	4.0	75.0
CD.070160.S	1.60	13.10	3.0	52.0	CD.070390.S	3.90	31.20	4.0	75.0
CD.070165.S	1.65	13.30	3.0	52.0	CD.070395.S	3.95	31.60	4.0	75.0
CD.070170.S	1.70	13.50	3.0	52.0	CD.070400.S	4.00	32.00	6.0	80.0
CD.070175.S	1.75	13.80	3.0	52.0	CD.070410.S	4.10	32.80	6.0	80.0
CD.070180.S	1.80	14.70	3.0	53.5	CD.070420.S	4.20	33.60	6.0	80.0
CD.070185.S	1.85	14.90	3.0	53.5	CD.070430.S	4.30	34.40	6.0	80.0
CD.070190.S	1.90	15.20	3.0	53.5	CD.070440.S	4.40	35.20	6.0	80.0
CD.070195.S	1.95	15.30	3.0	53.5	CD.070450.S	4.50	36.00	6.0	85.0
CD.070200.S	2.00	16.20	4.0	61.5	CD.070460.S	4.60	36.80	6.0	85.0
CD.070205.S	2.05	16.40	4.0	61.5	CD.070470.S	4.70	37.60	6.0	85.0
CD.070210.S	2.10	16.80	4.0	61.5	CD.070480.S	4.80	38.40	6.0	85.0
CD.070215.S	2.15	17.20	4.0	61.5	CD.070490.S	4.90	39.20	6.0	85.0
CD.070220.S	2.20	18.00	4.0	63.0	CD.070500.S	5.00	40.00	6.0	85.0
CD.070225.S	2.25	18.20	4.0	63.0	CD.070510.S	5.10	40.80	6.0	90.0
CD.070230.S	2.30	18.50	4.0	63.0	CD.070520.S	5.20	41.60	6.0	90.0
CD.070235.S	2.35	18.70	4.0	63.0	CD.070530.S	5.30	42.40	6.0	90.0
CD.070240.S	2.40	19.50	4.0	64.5	CD.070540.S	5.40	43.20	6.0	90.0
CD.070245.S	2.45	19.80	4.0	64.5	CD.070550.S	5.50	44.00	6.0	90.0
CD.070250.S	2.50	19.90	4.0	64.5	CD.070560.S	5.60	44.80	6.0	90.0
CD.070255.S	2.55	20.20	4.0	64.5	CD.070570.S	5.70	45.60	6.0	95.0
CD.070260.S	2.60	21.10	4.0	66.0	CD.070580.S	5.80	46.40	6.0	95.0
CD.070265.S	2.65	21.30	4.0	66.0	CD.070590.S	5.90	47.20	6.0	95.0
					CD.070600.S	6.00	48.00	6.0	95.0



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

The high-performance data

CRAZYDRILL™
by Mikron Tool
Steel

High-speed data for steel: Carbon Steels - Tool Steels - Cast Iron / Short lengths up to 4 x d (CD.040xxx.S)

Materials to be machined	Strength / Hardness (N/mm ²)	Examples	Cutting speed V _C (m/min)	Feed f in mm / revolution in relation to diameter											
				0,4 mm	0,8 mm	1,0 mm	1,25 mm	1,5 mm	2,0 mm	2,5 mm	3,0 mm	4,0 mm	5,0 mm	6,0 mm	
Non-alloy steels	up to 800	Cq15, C15, St.37, St.60, CK45 9SMnPb28, C35, 45Mn6, GS58	50 to 120	up to 0,04	up to 0,10	up to 0,12	up to 0,15	up to 0,20	up to 0,25	up to 0,27	up to 0,35	up to 0,37	up to 0,39	up to 0,40	
Low-alloy steels	800 to 1000	16MnCr5, CK60, 53MnSi4, 90MnCrV8, 31NiCr14, 41CrAlMo7	50 to 100	up to 0,015	up to 0,04	up to 0,10	up to 0,15	up to 0,25	up to 0,28	up to 0,30	up to 0,35	up to 0,37	up to 0,39	up to 0,40	
Alloy steels	1000 to 1400	14CrNi14, 100Cr6, 100MnCrW4, 31CrMo12, 20MnCr5, 42CrMo4	40 to 80	up to 0,015	up to 0,03	up to 0,08	up to 0,12	up to 0,16	up to 0,20	up to 0,23	up to 0,25	up to 0,27	up to 0,30	up to 0,32	
Tool steels	up to 1200	X210CrW12, 75CrMoNi6-7, X165CrMoV12, 56NiCrMoV7	30 to 60	up to 0,02	up to 0,07	up to 0,12	up to 0,15	up to 0,20	up to 0,25	up to 0,28	up to 0,30	up to 0,32	up to 0,34	up to 0,35	
Cast iron	up to 300 HB	GG20-GG50 GGG40-GGG70 GTW / GTS	up to 150	up to 0,04	up to 0,15	up to 0,20	up to 0,25	up to 0,30	up to 0,35	up to 0,40	up to 0,45	up to 0,47	up to 0,49	up to 0,50	

Important operating criteria

For optimum results Mikron Tool recommends the use of cutting oil as a coolant. Alternatively emulsion can also be used (with EP additives).

Drills up to 7 x d (long length)

In the case of drill depths over 4 x d, Mikron Tool SA recommends centering or a pilot hole. It can be drilled using the CrazyDrill Pilot. Standard feed rates should be reduced by about 30%. In the case of drill depths greater than 4 x d, we recommend pecking cycles.

CRAZYDRILL™
by Mikron Tool

Five benefits:

1. Maximum drilling speeds
2. Enhanced tool life
3. Self-centering
4. Highly accurate hole dimensions (H7 / H8)
5. Excellent surface quality



Your contacts

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