

CrazyDrill™ Alu

Mikron Tool 



The cost-effective
high-performance small drill

CRAZYDRILL™
by Mikron Tool
Alu

The range

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Short execution up to 5x 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	52.0
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

Long execution up to 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	55.0
CD.100135.A	1.35	16.5	3.0	55.0
CD.100140.A	1.40	17.1	3.0	55.0
CD.100145.A	1.45	17.7	3.0	55.0
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 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 0,20 none	up to 0,20 none
Long-size Swarf evacuation	10 x d	up to 300	up to 0,03 all 5 x d	up to 0,04 all 5 x d	up to 0,10 all 5 x d	up to 0,20 all 5 x d	up to 0,20 all 5 x d	up to 0,20 all 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 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 all 5 x d	up to 0,10 all 5 x d	up to 0,10 all 5 x d	up to 0,20 all 5 x d	up to 0,30 all 5 x d	up to 0,40 all 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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Alu

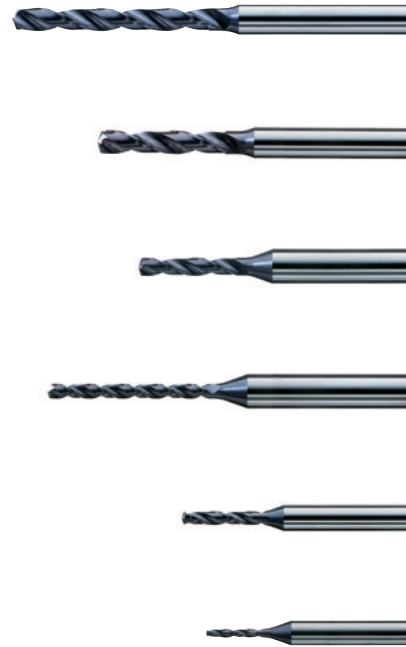
Five benefits:

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



CRAZYDRILL™ by Mikron Tool Alu

High-performance tools from Mikron Tool bring increased speed, service life and cost effectiveness.



Product range

CRAZYDRILL™ by Mikron Tool Steel



CRAZYDRILL™ by Mikron Tool Pilot



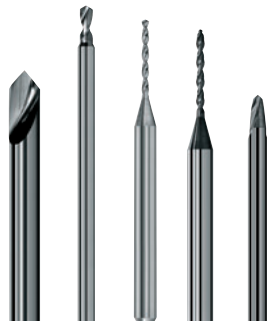
CRAZYDRILL™ by Mikron Tool Cool



Special cutting tools



MIQUADRILL™ by Mikron Tool



Profile milling cutters





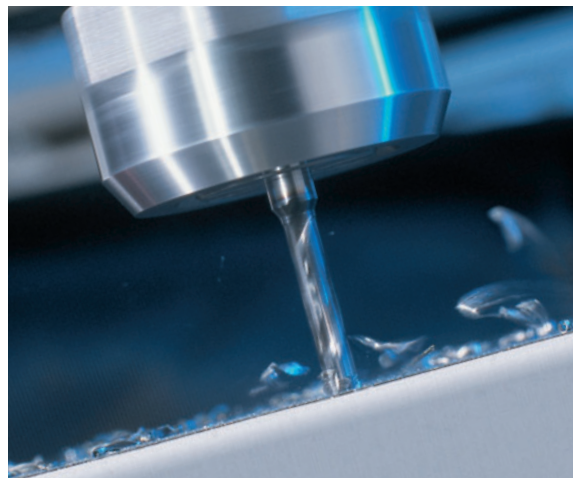
The service

Star Service

With its Star Service (Standard Tool Adjustment & Record Service) Mikron Tool offers high-performance drills in non-standard sizes. Within 48 hours of your request you will receive a quote, including both a drawing and a firm delivery date.

Regrinding Recoating

Mikron Tool offers a regrinding and recoating service for its CrazyDrill range (drill diameters in excess of 1.5 mm), making Mikron Tool products even better value for money.



Factory packaging



Just pull to open. The drill's cutting element remains protected at the top of the packaging.



Insert drill with packaging into chuck, clamp,...



... and then pull packaging from drill.

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