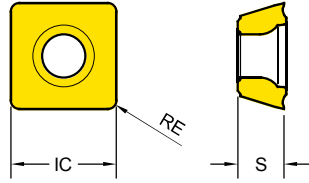


Drilling - Inserts

Drilling Inserts (SPMX)



Series	IC	S
SPMX 0502	5.00	2.38
SPMX 0602	6.00	2.41
SPMX 07T3	7.94	3.97
SPMX 0904	9.80	4.30
SPMX 1104	11.50	4.80
SPMX 1405	14.30	5.20

SPMX		Designation	Fn (mm/rev.)	YG602	YG713	YG613
SPMX General		SPMX 050204	0.07~0.14	● 0005	● 0062	● 0077
		SPMX 060204	0.08~0.14	● 0006	● 0063	● 0078
		SPMX 07T308	0.08~0.16	● 0007	● 0064	● 0061
		SPMX 090408	0.08~0.16	● 0008	● 0065	● 0079
		SPMX 110408	0.10~0.18	● 0009	● 0066	● 0080
		SPMX 140512	0.10~0.20	● 0010	● 0067	
-ST Stainless Steel		SPMX 050204-ST	0.03~0.10	● 0011		● 0070
		SPMX 060204-ST	0.04~0.11	● 0012		● 0071
		SPMX 07T308-ST	0.04~0.11	● 0013		● 0068
		SPMX 090408-ST	0.05~0.12	● 0014		● 0072
		SPMX 110408-ST	0.05~0.12			● 0073
		SPMX 140512-ST	0.05~0.16			● 0074

EDP 3200..

TURNING

PARTING & GROOVING

MILLING

DRILLING

TECHNICAL INFORMATION

Cutting Speed			Vc (m/min.)					
ISO	VDI	Sub Group	YG602		YG713		YG613	
			Min	Max	Min	Max	Min	Max
P	1-5	Non-Alloyed Steel	180	380	200	300	100	210
	6-9	Low-Alloyed Steel	120	300	170	270	70	180
	10-11	High-Alloyed Steel	70	150	85	145	40	90
M	12-13	Ferritic & Martensitic	120	200	-	-	70	180
	14	Austenitic Stainless Steel	130	250	-	-	70	200
K	15-16	Grey Cast Iron	120	250	-	-	-	-
	17-18	Nodular Cast Iron	130	220	-	-	-	-
H	38-41	Hard Materials	-	-	-	-	-	-