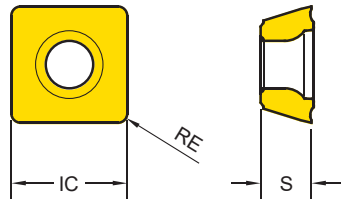


Drilling - Inserts
Drilling Inserts (SPMX)

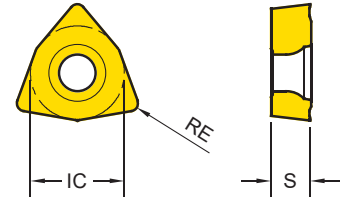


Series	inch	
	IC	S
SPMX 0502	.197	.094
SPMX 0602	.236	.095
SPMX 07T3	.313	.156
SPMX 0904	.386	.169
SPMX 1104	.453	.189
SPMX 1405	.563	.205

SPMX		Designation	Fn (mm/rev.)	EDP 3200..	
				YG602	YG713
SPMX General		SPMX 050204	.003 ~ .006	● 0005	● 0062
		SPMX 060204	.003 ~ .006	● 0006	● 0063
		SPMX 07T308	.003 ~ .006	● 0007	● 0064
		SPMX 090408	.003 ~ .006	● 0008	● 0065
		SPMX 110408	.004 ~ .007	● 0009	● 0066
		SPMX 140512	.004 ~ .008	● 0010	● 0067
-ST Stainless Steel		SPMX 050204 - ST	.001 ~ .004	● 0011	
		SPMX 060204 - ST	.002 ~ .004	● 0012	
		SPMX 07T308 - ST	.002 ~ .004	● 0013	
		SPMX 090408 - ST	.002 ~ .005	● 0014	

Cutting Speed			Vc (ft/min)			
ISO	VDI	Sub Group	YG602		YG713	
			Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	460	1250	490	920
	6~9	Low-Alloyed Steel	390	980	430	770
	10~11	High-Alloyed Steel	230	490	300	430
M	12~13	Ferritic & Martensitic	390	660	-	-
	14	Austenitic Stainless Steel	430	820	-	-
K	15~16	Grey Cast Iron	390	820	-	-
	17~18	Nodular Cast Iron	430	720	-	-
H	38~41	Hard materials	-	-	160	330

Drilling - Inserts
Drilling Inserts (WCMX)



Series	inch	
	IC	S
WCMX 0302	.219	.094
WCMX 0402	.250	.094
WCMX 0503	.313	.125
WCMX 06T3	.375	.156
WCMX 0804	.500	.187

WCMX		Designation	Fn (in/rev.)	EDP 3200..	
				YG602	
WCMX General		WCMX 030208	.002~.005	● 0031	
		WCMX 040208	.002~.005	● 0003	
		WCMX 050308	.002 ~ .006	● 0001	
		WCMX 06T308	.003 ~ .006	● 0002	
		WCMX 080412	.003 ~ .006	● 0004	

Cutting Speed			Vc (ft/min)			
ISO	VDI	Sub Group	YG602			
			Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	460	1250		
	6~9	Low-Alloyed Steel	390	980		
	10~11	High-Alloyed Steel	230	490		
M	12~13	Ferritic & Martensitic	390	660		
	14	Austenitic Stainless Steel	430	820		
K	15~16	Grey Cast Iron	390	820		
	17~18	Nodular Cast Iron	430	720		