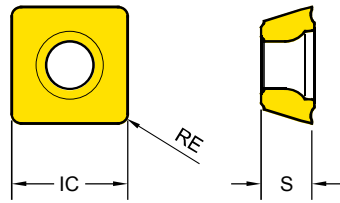


Drilling - Inserts

Drilling Inserts (SPMX)



| Series | Metric | |
|-----------|--------|------|
| | 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.) | EDP 3200.. | |
|------------------------|--|------------------|-----------------|------------|-----------|
| | | | | YG602 | YG713 |
| SPMX General | | SPMX 050204 | 0.07~0.14 | ● 0005 | ● 0062 |
| | | SPMX 060204 | 0.08~0.14 | ● 0006 | ● 0063 |
| | | SPMX 07T308 | 0.08~0.16 | ● 0007 | ● 0064 |
| | | SPMX 090408 | 0.08~0.16 | ● 0008 | ● 0065 |
| | | SPMX 110408 | 0.10~0.18 | ● 0009 | ● 0066 |
| | | SPMX 140512 | 0.10~0.20 | ● 0010 | ● 0067 |
| -ST Stainless Steel | | SPMX 050204 - ST | 0.03~0.10 | ● 0011 | |
| | | SPMX 060204 - ST | 0.04~0.11 | ● 0012 | |
| | | SPMX 07T308 - ST | 0.04~0.11 | ● 0013 | |
| | | SPMX 090408 - ST | 0.05~0.12 | ● 0014 | |

| Cutting Speed | | | Vc (m/min.) | | | |
|---------------|-------|----------------------------|-------------|-----|-------|-----|
| ISO | VDI | Sub Group | YG602 | | YG713 | |
| | | | Min | Max | Min | Max |
| P | 1~5 | Non-Alloyed Steel | 140 | 380 | 150 | 280 |
| | 6~9 | Low-Alloyed Steel | 120 | 300 | 130 | 235 |
| | 10~11 | High-Alloyed Steel | 70 | 150 | 90 | 130 |
| M | 12~13 | Ferritic & Martensitic | 120 | 200 | - | - |
| | 14 | Austenitic Stainless Steel | 130 | 250 | - | - |
| K | 15~16 | Grey Cast Iron | 120 | 250 | - | - |
| | 17~18 | Nodular Cast Iron | 130 | 220 | - | - |
| H | 38~41 | Hard materials | | | 50 | 100 |