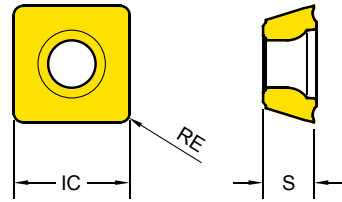




Drilling - Inserts

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.)	EDP 3200..		
			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

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	-	-	-	-	-	-

Drilling Overview

Drilling Grades

Drilling Grades		P Steel					M Stainless steel					K Cast iron				
		P05	P15	P25	P35	P45	M05	M15	M25	M35	M45	K05	K15	K25	K35	K45
PVD	YG602			602					602					602		
	YG713		713													
	YG613				613					613						

YG602 P20 - P35 M20 - M40 K20 - K40 S15 - S25	PVD - TiAlN 	Universal grade for General Drilling Application <ul style="list-style-type: none"> • Ultra Dense PVD Coating with optimal thermal resistance & strength • Sub-Micron substrate designed for demanding application
YG713 P15 - P25	PVD - TiAlN 	Drilling Grade for General Steel Application <ul style="list-style-type: none"> • Multi-layer TiAlN structure realizes stronger crater and flank wear resistance • Fine-grained carbide and balanced substrate
YG613 P30 - P50 M30 - M50	PVD - TiAlN 	Drilling Grade for Stainless Steel Application <ul style="list-style-type: none"> • New coating layer with high toughness and lubrication on ultra fine grain substrate with high toughness. • The toughest substrates provides excellent cutting performance in stainless steel

Universal Drilling Inserts

	4 Corner	SPMX Series	SPMX	05, 06, 07, 09, 11, 14
	ISO 3 Corner	WCMX Series	WCMX	03, 04, 05, 06, 08

Drilling Chipbreakers

P	M	K		
	M		-ST	 • Sharp Geometry • Sticky Material, Stainless Steel
P	M	K	General Inserts (No Description)	 • First Choice for General Application