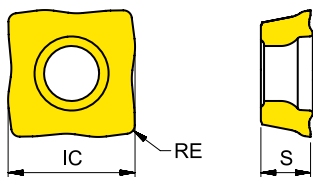


Drilling - Inserts

X-Drill Inserts (SYMX)

Recommended Cutting Conditions : p.223



Series	IC	S
SYMX 0502	4.97	2.35
SYMX 0602	5.99	2.35
SYMX 07T2	7.01	2.80
SYMX 0803	8.30	3.20

EDP 3200..

SYMX	Designation	RE (mm)	Fn (mm/rev.)	P25	P20	P40
				M25	M20	
				K30	K20	M40
				YG602	YG713	YG613
	SYMX 050204	0.4	0.06~0.12		● 0097	● 0098
	SYMX 060204	0.4	0.06~0.12		● 0093	● 0095
	SYMX 07T206	0.6	0.06~0.12		● 0099	● 0100
	SYMX 080306	0.6	0.08~0.20		● 0101	● 0102

NEW
SYMX
General



● : Stock item ○ : Order made item

TURNING

PARTING & GROOVING

MILLING

DRILLING

TECHNICAL INFORMATION

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	YG713			713					713					713		
	YG602			602					602					602		
	YG613				613					613						

<p>YG713</p> <p>P15 - P30 M15 - M30</p> <p>K15 - K30 H20 - H30</p>	<p>PVD - TiAlN</p>	<p>Drilling Grade for General Steel Application</p> <ul style="list-style-type: none"> Multi-layer TiAlN structure realizes stronger crater and flank wear resistance Fine-grained carbide and balanced substrate
<p>YG602</p> <p>P20 - P35 M20 - M40</p> <p>K20 - K40 S15 - S25</p>	<p>PVD - TiAlN</p>	<p>Universal grade for General Drilling Application</p> <ul style="list-style-type: none"> Ultra Dense PVD Coating with optimal thermal resistance & strength Sub-Micron substrate designed for demanding application
<p>YG613</p> <p>P30 - P50</p> <p>M30 - M50</p>	<p>PVD - TiAlN</p>	<p>Drilling Grade for Stainless Steel Application</p> <ul style="list-style-type: none"> New coating layer with lubrication preventing built-up edge on ultra fine grain substrate with high toughness. The toughest substrate provides excellent cutting performance in stainless steel

Universal Drilling Inserts

	4 Corner	SYM ^{NEW} X Series	SYMX	05, 06, 07, 08
	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	<ul style="list-style-type: none"> Sharp Geometry Sticky Material, Stainless Steel
P	M	K	General Inserts (No Description)	<ul style="list-style-type: none"> First Choice for General Application