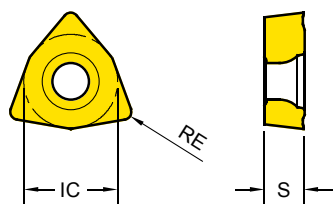


Drilling - Inserts

Drilling Inserts (WCMX)



Series	IC	S
WCMX 0302	5.56	2.38
WCMX 0402	6.35	2.38
WCMX 0503	7.94	3.18
WCMX 06T3	9.53	3.97
WCMX 0804	12.70	4.76


TURNING

PARTING & GROOVING

MILLING

DRILLING

TECHNICAL INFORMATION

WCMX	Designation	Fn (mm/rev.)	EDP 3200..	
			YG602	YG713
WCMX General 	WCMX 030208	0.05 ~ 0.12	● 0031	● 0086
	WCMX 040208	0.05 ~ 0.12	● 0003	● 0087
	WCMX 050308	0.06 ~ 0.14	● 0001	● 0088
	WCMX 06T308	0.08 ~ 0.14	● 0002	● 0089
	WCMX 080412	0.08 ~ 0.14	● 0004	● 0090

Cutting Speed			Vc (m/min.)			
ISO	VDI	Sub Group	YG602		YG713	
			Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	180	380	200	300
	6~9	Low-Alloyed Steel	120	300	170	270
	10~11	High-Alloyed Steel	70	150	85	145
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	-	-

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