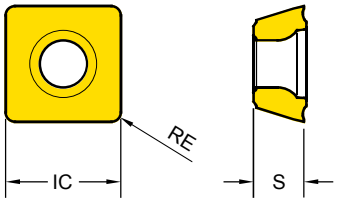
Drilling - Inserts

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	.193
SPMX 1405	.563	.209

EDP 3200..

SPMX		Designation	Fn (in/rev.)	YG602
SPMX General		SPMX 050204	.003 ~ .006	● 0005
		SPMX 060204	.003 ~ .006	● 0006
		SPMX 07T308	.003 ~ .006	● 0007
		SPMX 090408	.003 ~ .006	● 0008
		SPMX 110408	.004 ~ .007	● 0009
		SPMX 140512	.004 ~ .008	● 0010
-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 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