

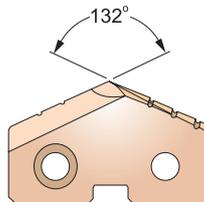
YG SPADE DRILLS

SERIES 2

SPADE DRILL INSERTS FOR CAST IRON - CARBIDE(K10)
EINWEG BOHREINSATZ - VOLLHARTMETALL(K10)

- ▶ High performance on Gray cast iron over 220 Brinell, malleable cast iron with short chips, silicon aluminum and copper alloys.
- ▶ Set up time can be reduced due to changing inserts easily on the machine.
- ▶ Any non-standard size available.

- ▶ Beste Leistung in Grauguss über 220 Brinell, kurzspanendem Kugelgraphitguss, Si-Aluminium und Kupferlegierungen
- ▶ Reduzierte Rüstzeiten, einfacher Einsatzwechsel auf der Maschine
- ▶ Jede Abmessung außerhalb des Kataloges lieferbar



cutting conditions : P.326

Series Min. to Max. (mm/inch)	Diameter			Thick Metric (mm/inch)	EDP No.		
	Inch (inch)	Metric (mm)	Decimal (inch)		CARBIDE (K10)		
					TiN	TiCN	TiAlN
2 24.41 (.961") to 35.05 (1.380")	31/32"	24.61	.9688"	4.8 (3/16")	S1605062	S1610062	S1615062
	63/64"	25.00	.9843"		S1655250	S1660250	S1665250
	1"	25.40	1.0000"		S1605100	S1610100	S1615100
	1-1/64"	25.80	1.0156"		S1605101	S1610101	S1615101
		26.00	1.0236"		S1655260	S1660260	S1665260
	1-1/32"	26.19	1.0313"		S1605102	S1610102	S1615102
	1-3/64"	26.59	1.0469"		S1605103	S1610103	S1615103
	1-1/16"	26.99	1.0625"		S1605104	S1610104	S1615104
		27.00	1.0630"		S1655270	S1660270	S1665270
	1-3/32"	27.78	1.0938"		S1605106	S1610106	S1615106
		28.00	1.1024"		S1655280	S1660280	S1665280
	1-7/64"	28.18	1.1094"		S1605107	S1610107	S1615107
	1-1/8"	28.58	1.1250"		S1605108	S1610108	S1615108
		29.00	1.1417"		S1655290	S1660290	S1665290
	1-5/32"	29.37	1.1563"		S1605110	S1610110	S1615110
		30.00	1.1811"		S1655300	S1660300	S1665300
	1-3/16"	30.16	1.1875"		S1605112	S1610112	S1615112
	1-7/32"	30.96	1.2188"		S1605114	S1610114	S1615114
		31.00	1.2205"		S1655310	S1660310	S1665310
	1-1/4"	31.75	1.2500"		S1605116	S1610116	S1615116
		32.00	1.2598"		S1655320	S1660320	S1665320
	1-9/32"	32.54	1.2813"		S1605118	S1610118	S1615118
		33.00	1.2992"		S1655330	S1660330	S1665330
	1-5/16"	33.34	1.3125"		S1605120	S1610120	S1615120
	34.00	1.3386"	S1655340	S1660340	S1665340		
1-11/32"	34.13	1.3438"	S1605122	S1610122	S1615122		
1-3/8"	34.93	1.3750"	S1605124	S1610124	S1615124		
	35.00	1.3780"	S1655350	S1660350	S1665350		

◎ : Excellent ○ : Good

Non- alloyed Steels, Free Machining Steels	Carbon Steels		Alloy Steels		High Alloyed steels		Structural Steels		Tool Steels		Stainless Steels	Cast Iron		Aluminum	Copper Alloys
	~HRc24 (~HB250)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc37 (~HB350)	HRc37~ (HB350~)	~HRc24 (~HB250)	HRc24~ (HB250~)	~HRc13 (~HB200)		HRc13~ (HB200~)	~HRc28 (~HB275)		
												◎	◎		



RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN

DRILL INSERT (METRIC) - CARBIDE
BOHREINSATZ (METRISCH) - VOLLHARTMETALL

Material	Material Hardness		CARBIDE Grade	Speed (M/min)			Feed (mm/rev)				
	(Bhn)	(HRc)		TiN	TiCN	TiAlN	Ø 9.5 ~12.5	Ø 13 ~17.5	Ø 18 ~24	Ø 25 ~35	Ø 36 ~47
Free machining Steels 9SMn36, 9SMnPb28 10SPb20 etc	100 - 150		P40	101	113	125	0.18	0.28	0.36	0.44	0.50
	150 - 200	- 13	P40	88	99	110	0.16	0.26	0.33	0.39	0.45
	200 - 250	13 - 24	P40	82	88	101	0.14	0.23	0.31	0.41	0.42
Low Carbon Steels C10, C15, C22, C25 etc	85 - 125		P40	94	110	119	0.20	0.24	0.31	0.42	0.46
	125 - 175	- 7	P40	82	88	107	0.18	0.24	0.31	0.39	0.43
	175 - 225	7 - 20	P40	76	82	96	0.15	0.22	0.29	0.36	0.40
Medium Carbon Steels C35, C40, C45 etc	225 - 275	20 - 28	P40	62	73	84	0.13	0.22	0.29	0.36	0.40
	125 - 175	- 7	P40	82	88	102	0.17	0.24	0.31	0.37	0.42
	175 - 225	7 - 20	P40	75	84	93	0.15	0.22	0.28	0.36	0.40
Structural Steels St33, St37-2, St44-2 St52, St60 etc	225 - 275	20 - 28	P40	66	70	84	0.15	0.22	0.28	0.36	0.40
	275 - 325	28 - 34	P40	56	64	67	0.13	0.19	0.26	0.33	0.37
	100 - 150		P40	75	82	91	0.19	0.26	0.34	0.39	0.43
Cast Iron / S,G Iron GG10, 20, 25, 35, 40 GGG50, 70 GTW35, GTS70 etc	150 - 250	- 24	P40	62	70	75	0.15	0.24	0.29	0.33	0.37
	250 - 350	24 - 37	P40	55	64	73	0.13	0.23	0.27	0.29	0.33
	120 - 150		K20,K10	98	125	137	0.18	0.30	0.37	0.46	0.56
	150 - 200	- 13	K20,K10	95	101	125	0.17	0.26	0.32	0.42	0.53
Alloy Steels 45CrNiMo4, 42CrNiMo4 16MnCr5, Ck75 35CrNiMo4, 16MnCr5 etc	200 - 220	13 - 19	K20,K10	75	91	111	0.14	0.23	0.30	0.38	0.45
	220 - 260	19 - 26	K20,K10	66	81	93	0.13	0.15	0.28	0.33	0.37
	260 - 320	26 - 34	K20,K10	56	70	79	0.13	0.18	0.23	0.28	0.33
	125 - 175	- 7	P40	79	85	98	0.18	0.25	0.32	0.40	0.45
Tool Steels T02Cr6, T05WCr6, C75W etc	175 - 225	7 - 20	P40	73	81	88	0.15	0.23	0.29	0.38	0.42
	225 - 275	20 - 28	P40	66	73	81	0.15	0.21	0.28	0.37	0.41
	275 - 325	28 - 34	P40	62	70	78	0.12	0.20	0.27	0.33	0.40
High Temp. Alloy Hastelloy B, Inconel etc	325 - 375	34 - 40	P40	53	58	64	0.10	0.18	0.23	0.30	0.38
	150 - 200	- 13	P40	50	56	67	0.09	0.18	0.22	0.28	0.31
High Strength Alloy 36CrNiMo4, 34CrNiMo8 40NiCrMo73 etc	200 - 250	13 - 24	P40	37	46	50	0.09	0.18	0.22	0.28	0.31
	140 - 220	- 19	K20	26	27	30	0.10	0.17	0.23	0.27	0.33
Aluminum AlCuSiMn, AlMgSi0.5, AlZnMgCu1.5 etc	220 - 310	19 - 33	K20	20	23	24	0.10	0.14	0.20	0.24	0.30
	225 - 300	- 32	P40	49	55	62	0.15	0.23	0.25	0.29	0.38
Stainless Steels X7Cr13, X10CrAl18, X5CrNi189, X5CrNiMo18 10 etc	300 - 350	32 - 37	P40	43	49	55	0.12	0.20	0.23	0.27	0.35
	350 - 400	37 - 43	P40	38	43	47	0.10	0.18	0.20	0.24	0.30
Aluminum AlCuSiMn, AlMgSi0.5, AlZnMgCu1.5 etc	30		K20	366	396	427	0.24	0.38	0.45	0.50	0.53
	180	- 8	K20	244	290	291	0.22	0.33	0.40	0.45	0.48
Stainless Steels X7Cr13, X10CrAl18, X5CrNi189, X5CrNiMo18 10 etc	135 - 185	- 9	K20	50	55	62	0.19	0.19	0.21	0.24	0.30
	185 - 275	9 - 28	K20	38	44	46	0.15	0.17	0.20	0.21	0.25

RPM= revolution per minute (rev/min)
M/min= surface meter per minute(M/min)
DIA= diameter of drill (mm)
mm/rev = feed rate(mm/rev)

*** Formulas :**

$$M/min = \frac{(RPM) \cdot (\pi) \cdot (DIA.)}{1000}$$

$$mm/min= (RPM) \cdot (mm/rev)$$

$$RPM = \frac{(M/min) \cdot (1000)}{(\pi) \cdot (DIA.)}$$

The recommendations for speeds, feeds and other parameters presented in this chart are nominal recommendations and should be considered only as good starting points.

Speed and feed reductions (20% reduction in speed and 10% reduction in feed) are recommended.