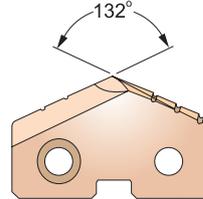


SPADE DRILL INSERTS - CARBIDE(P40)

EINWEG BOHREINSATZ - VOLLHARTMETALL(P40)

- ▶ For general use in carbon steels and alloy steels.
- ▶ Set up time can be reduced due to changing inserts easily on the machine.
- ▶ Any non-standard size available.

- ▶ Für allgemeine Anwendung in Kohlenstoffstählen und legierten Stählen
- ▶ Reduzierte Rüstzeiten, einfacher Einsatzwechsel auf der Maschine
- ▶ Jede Abmessung außerhalb des Kataloges lieferbar



cutting conditions : p.284

Series Min. to Max. (mm/inch)	Diameter			Thick Metric (mm/inch)	EDP No.		
	Inch (inch)	Metric (mm)	Decimal (inch)		CARBIDE (P40)		
					TiN	TiCN	TiAlN
Y 9.50 (.374") to 11.07 (.436")		9.50	.3740"	2.4 (3/32")	S1855095	S1860095	S1865095
	3/8"	9.53	.3750"		S1805024	S1810024	S1815024
		9.80	.3860"		S1855098	S1860098	S1865098
	25/64"	9.92	.3906"		S1805025	S1810025	S1815025
		10.00	.3937"		S1855100	S1860100	S1865100
		10.20	.4016"		S1855102	S1860102	S1865102
	13/32"	10.32	.4063"		S1805026	S1810026	S1815026
		10.50	.4134"		S1855105	S1860105	S1865105
	27/64"	10.72	.4219"		S1805027	S1810027	S1815027
		10.80	.4252"		S1855108	S1860108	S1865108
Z 11.11(.437") to 12.95(.510")		11.00	.4331"	2.4 (3/32")	S1855110	S1860110	S1865110
	7/16"	11.11	.4375"		S1805028	S1810028	S1815028
		11.50	.4528"		S1855115	S1860115	S1865115
	29/64"	11.51	.4531"		S1805029	S1810029	S1815029
	15/32"	11.91	.4688"		S1805030	S1810030	S1815030
		12.00	.4724"		S1855120	S1860120	S1865120
	31/64"	12.30	.4844"		S1805031	S1810031	S1815031
		12.50	.4921"		S1855125	S1860125	S1865125
	1/2"	12.70	.5000"		S1805032	S1810032	S1815032
		13.00	.5118"		S1855130	S1860130	S1865130
0 12.98 (.511") to 17.65 (.695")		13.10	.5156"	3.2 (1/8")	S1805033	S1810033	S1815033
	33/64"	13.10	.5156"		S1805034	S1810034	S1815034
	17/32"	13.49	.5313"		S1855135	S1860135	S1865135
		13.50	.5315"		S1805035	S1810035	S1815035
	35/64"	13.89	.5469"		S1855140	S1860140	S1865140
		14.00	.5512"		S1805036	S1810036	S1815036
	9/16"	14.29	.5625"		S1855145	S1860145	S1865145
		14.50	.5709"		S1805037	S1810037	S1815037
	37/64"	14.68	.5781"		S1855150	S1860150	S1865150
		15.00	.5906"		S1805038	S1810038	S1815038
	19/32"	15.08	.5938"		S1805039	S1810039	S1815039
	39/64"	15.48	.6094"		S1855155	S1860155	S1865155
		15.50	.6102"		S1805040	S1810040	S1815040
	5/8"	15.88	.6250"		S1855160	S1860160	S1865160
	16.00	.6299"					

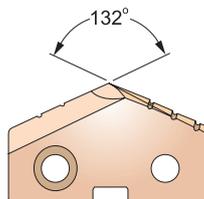
◎ : Excellent ○ : Good

Non-alloy 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)	-HRc19 (-HB220)	HRc19~ (HB220~)	-HRc8 (-HB180)	-HB110
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○	○

SPADE DRILL INSERTS - CARBIDE(P40)
EINWEG BOHREINSATZ - VOLLHARTMETALL(P40)

- ▶ For general use in carbon steels and alloy steels.
- ▶ Set up time can be reduced due to changing inserts easily on the machine.
- ▶ Any non-standard size available.

- ▶ Für allgemeine Anwendung in Kohlenstoffstählen und legierten Stählen
- ▶ Reduzierte Rüstzeiten, einfacher Einsatzwechsel auf der Maschine
- ▶ Jede Abmessung außerhalb des Kataloges lieferbar



cutting conditions : p.284

Series Min. to Max. (mm/inch)	Diameter			Thick Metric (mm/inch)	EDP No. CARBIDE (P40)		
	Inch (inch)	Metric (mm)	Decimal (inch)		TiN	TiCN	TiAlN
0 12.98(.511") to 17.65(.695")	41/64"	16.27	.6406"	3.2 (1/8")	S1805041	S1810041	S1815041
		16.50	.6496"		S1855165	S1860165	S1865165
	21/32"	16.67	.6563"		S1805042	S1810042	S1815042
		17.00	.6693"		S1855170	S1860170	S1865170
	43/64"	17.07	.6719"		S1805043	S1810043	S1815043
	11/16"	17.46	.6875"		S1805044	S1810044	S1815044
		17.50	.6890"		S1855175	S1860175	S1865175
	45/64"	17.86	.7031"		S1805045	S1810045	S1815045
		18.00	.7087"		S1855180	S1860180	S1865180
	23/32"	18.26	.7188"		S1805046	S1810046	S1815046
	18.50	.7283"	S1855185	S1860185	S1865185		
47/64"	18.65	.7344"	S1805047	S1810047	S1815047		
	19.00	.7480"	S1855190	S1860190	S1865190		
3/4"	19.05	.7500"	S1805048	S1810048	S1815048		
49/64"	19.45	.7656"	S1805049	S1810049	S1815049		
	19.50	.7677"	S1855195	S1860195	S1865195		
1 17.53 (.690") to 24.38 (.960")	25/32"	19.84	.7813"	4.0 (5/32")	S1805050	S1810050	S1815050
		20.00	.7874"		S1855200	S1860200	S1865200
	51/64"	20.24	.7969"		S1805051	S1810051	S1815051
		20.50	.8071"		S1855205	S1860205	S1865205
	13/16"	20.64	.8125"		S1805052	S1810052	S1815052
		21.00	.8268"		S1855210	S1860210	S1865210
	27/32"	21.43	.8438"		S1805054	S1810054	S1815054
	55/64"	21.83	.8594"		S1805055	S1810055	S1815055
		22.00	.8661"		S1855220	S1860220	S1865220
	7/8"	22.23	.8750"		S1805056	S1810056	S1815056
	57/64"	22.62	.8906"		S1805057	S1810057	S1815057
		23.00	.9055"		S1855230	S1860230	S1865230
	29/32"	23.02	.9063"		S1805058	S1810058	S1815058
59/64"	23.42	.9219"	S1805059	S1810059	S1815059		
15/16"	23.81	.9375"	S1805060	S1810060	S1815060		
	24.00	.9449"	S1855240	S1860240	S1865240		

◎ : 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)		
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○