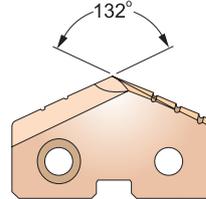


### SPADE DRILL INSERTS - HSS M4 EINWEG BOHREINSATZ - HSS M4

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

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



cutting conditions : p.283

Series Min. to Max. (mm/inch)	Diameter			Thick Metric (mm/inch)	EDP No. HSS (M4)		
	Inch (inch)	Metric (mm)	Decimal (inch)		TiN	TiCN	TiAlN
<b>2</b> 24.41 (.961") to 35.05 (1.380")	1-3/32"	27.78	1.0938"	4.8 (3/16")	S1405106	S1410106	S1415106
		28.00	1.1024"		S1455280	S1460280	S1465280
	1-7/64"	28.18	1.1094"		S1405107	S1410107	S1415107
		28.58	1.1250"		S1405108	S1410108	S1415108
	1-1/8"	29.00	1.1417"		S1455290	S1460290	S1465290
		29.37	1.1563"		S1405110	S1410110	S1415110
	1-5/32"	30.00	1.1811"		S1455300	S1460300	S1465300
		30.16	1.1875"		S1405112	S1410112	S1415112
	1-7/32"	30.96	1.2188"		S1405114	S1410114	S1415114
		31.00	1.2205"		S1455310	S1460310	S1465310
	1-1/4"	31.75	1.2500"		S1405116	S1410116	S1415116
		32.00	1.2598"		S1455320	S1460320	S1465320
	1-9/32"	32.54	1.2813"		S1405118	S1410118	S1415118
		33.00	1.2992"		S1455330	S1460330	S1465330
	1-5/16"	33.34	1.3125"		S1405120	S1410120	S1415120
		34.00	1.3386"		S1455340	S1460340	S1465340
1-11/32"	34.13	1.3438"	S1405122	S1410122	S1415122		
	34.93	1.3750"	S1405124	S1410124	S1415124		
1-3/8"	35.00	1.3780"	S1455350	S1460350	S1465350		
	1-13/32"	35.72	1.4063"	S1405126	S1410126	S1415126	
36.00		1.4173"	S1455360	S1460360	S1465360		
1-7/16"	36.51	1.4375"	S1405128	S1410128	S1415128		
	37.00	1.4567"	S1455370	S1460370	S1465370		
1-15/32"	37.31	1.4688"	S1405130	S1410130	S1415130		
	38.00	1.4961"	S1455380	S1460380	S1465380		
1-1/2"	38.10	1.5000"	S1405132	S1410132	S1415132		
	38.89	1.5313"	S1405134	S1410134	S1415134		
1-17/32"	39.00	1.5354"	S1455390	S1460390	S1465390		
	39.69	1.5625"	S1405136	S1410136	S1415136		
1-9/16"	40.00	1.5748"	S1455400	S1460400	S1465400		
	40.48	1.5938"	S1405138	S1410138	S1415138		
1-19/32"	41.00	1.6142"	S1455410	S1460410	S1465410		
	41.28	1.6250"	S1405140	S1410140	S1415140		
1-5/8"	42.00	1.6535"	S1455420	S1460420	S1465420		

◎ : 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)
○	○	○	○		○		○	○			◎	◎	○	◎	◎

**SPADE DRILL INSERTS - HSS M4**  
**EINWEG BOHREINSATZ - HSS M4**

- ▶ For general use in steels and cast irons.
- ▶ Set up time can be reduced due to changing inserts easily on the machine.
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- ▶ Für allgemeine Anwendung in Stahl und Gusseisen
- ▶ Reduzierte Rüstzeiten, einfacher Einsatzwechsel auf der Maschine
- ▶ Jede Abmessung außerhalb des Kataloges lieferbar



cutting conditions : p.283

Series Min. to Max. (mm/inch)	Diameter			Thick Metric (mm/inch)	EDP No. HSS (M4)		
	Inch (inch)	Metric (mm)	Decimal (inch)		TiN	TiCN	TiAlN
<b>3</b>  34.37 (1.353") to 47.80 (1.882")	1-21/32"	42.07	1.6563"	6.4 (1/4")	S1405142	S1410142	S1415142
	1-11/16"	42.86	1.6875"		S1405144	S1410144	S1415144
		43.00	1.6929"		S1455430	S1460430	S1465430
	1-23/32"	43.66	1.7188"		S1405146	S1410146	S1415146
		44.00	1.7323"		S1455440	S1460440	S1465440
	1-3/4"	44.45	1.7500"		S1405148	S1410148	S1415148
		45.00	1.7717"		S1455450	S1460450	S1465450
	1-25/32"	45.24	1.7813"		S1405150	S1410150	S1415150
		46.00	1.8110"		S1455460	S1460460	S1465460
	1-13/16"	46.04	1.8125"		S1405152	S1410152	S1415152
	1-27/32"	46.83	1.8438"		S1405154	S1410154	S1415154
		47.00	1.8504"		S1455470	S1460470	S1465470
<b>4</b>  46.99 (1.850") to 65.28 (2.570")	1-7/8"	47.63	1.8750"	7.9 (5/16")	S1405156	S1410156	S1415156
		48.00	1.8898"		S1455480	S1460480	S1465480
	1-29/32"	48.42	1.9063"		S1405158	S1410158	S1415158
		49.00	1.9291"		S1455490	S1460490	S1465490
	1-15/16"	49.21	1.9375"		S1405160	S1410160	S1415160
		50.00	1.9685"		S1455500	S1460500	S1465500
	1-31/32"	50.01	1.9688"		S1405162	S1410162	S1415162
	2"	50.80	2.0000"		S1405200	S1410200	S1415200
		51.00	2.0079"		S1455510	S1460510	S1465510
	2-1/32"	51.59	2.0313"		S1405202	S1410202	S1415202
	2-3/64"	52.00	2.0472"		S1405203	S1410203	S1415203
	2-1/16"	52.39	2.0625"		S1405204	S1410204	S1415204
		53.00	2.0866"		S1455530	S1460530	S1465530
	2-3/32"	53.18	2.0938"		S1405206	S1410206	S1415206
	2-1/8"	53.98	2.1250"		S1405208	S1410208	S1415208
		54.00	2.1260"		S1455540	S1460540	S1465540
	2-5/32"	54.79	2.1563"		S1405210	S1410210	S1415210
		55.00	2.1654"		S1455550	S1460550	S1465550
2-3/16"	55.56	2.1875"	S1405212	S1410212	S1415212		
	56.00	2.2047"	S1455560	S1460560	S1465560		
2-7/32"	56.36	2.2188"	S1405214	S1410214	S1415214		
	57.00	2.2441"	S1455570	S1460570	S1465570		

◎ : 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)	-HRc19 (-HB220)	HRc19~ (-HB220~)	-HRc8 (-HB180)
○	○	○	○	○	○	○	○	○	○	○	◎	◎	○	◎	◎