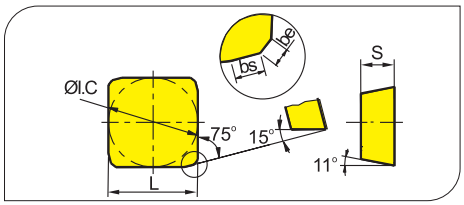
SP*R

Ideal Machining Condition
Gute Bearbeitungsbedingungen

Normal Machining Condition
Normale Bearbeitungsbedingungen

Unfavorable Machining Condition
Ungünstige Bearbeitungsbedingungen



Workpiece Material / Werkstoffe		YBC301	YBC401	YBM251	YBM351	YBD152	YBD252	YBG102	YBG202	YBG205	YBG302	YBG152	YBG252	YNG151	YNG151C	YC30S	YD051	YD101	YD201
P	Steel / *Stahl*	✱	✱	✱	✱		✱		✱	✱	✱		●	●	●	✱			
M	Steinless Steel / *Rostfreier Stahl*	✱	✱	✱	✱				✱	✱	✱		●	●	●	✱			
K	Cast iron / *Gusseisen*					✱	✱	●				✱	●				●		✱
N	Non-ferrite material / *Ne Metalle*																	✱	✱
S	Heat-resistant steel / *Warmfester Stahl*				✱			●	✱	✱									

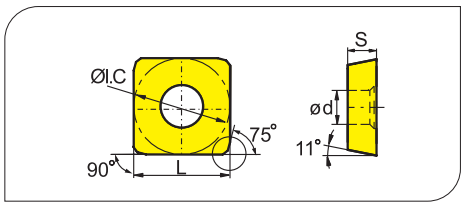
Insert WSP	Type · Typ	Dimensions (mm) · Abmessungen					CVD Coating CVD Beschicht.						PVD Coating PVD Beschicht.						Cermet		Carbide uncoat. unbe. Hartmetall			
		L	I.C	S	be	bs	YBC301	YBC401	YBM251	YBM351	YBD152	YBD252	YBG102	YBG202	YBG205	YBG302	YBG152	YBG252	YNG151	YNG151C	YC30S	YD051	YD101	YD201
	SPKR1203EDR-GM	12.7	12.7	3.18	1	1.4			●					○										
	SPKR1203EDL-GM	12.7	12.7	3.18	1	1.4			●					○										
	SPKR1504EDR-GM	15.875	15.875	4.76	1	1.4			○					○										
	SPKR1504EDL-GM	15.875	15.875	4.76	1	1.4			○					○										

SP*W

Ideal Machining Condition
Gute Bearbeitungsbedingungen

Normal Machining Condition
Normale Bearbeitungsbedingungen

Unfavorable Machining Condition
Ungünstige Bearbeitungsbedingungen



Workpiece Material / Werkstoffe		YBC301	YBC401	YBM251	YBM351	YBD152	YBD252	YBG102	YBG202	YBG205	YBG302	YBG152	YBG252	YNG151	YNG151C	YC30S	YD051	YD101	YD201
P	Steel / *Stahl*	✱	✱	✱	✱		✱		✱	✱	✱		●	●	●	✱			
M	Steinless Steel / *Rostfreier Stahl*	✱	✱	✱	✱				✱	✱	✱		●	●	●	✱			
K	Cast iron / *Gusseisen*					✱	✱	●				✱	●				●		✱
N	Non-ferrite material / *Ne Metalle*																	✱	✱
S	Heat-resistant steel / *Warmfester Stahl*				✱			●	✱	✱									

Insert WSP	Type · Typ	Dimensions (mm) · Abmessungen						CVD Coating CVD Beschicht.						PVD Coating PVD Beschicht.						Cermet		Carbide uncoat. unbe. Hartmetall			
		r	L	I.C	S	d	α	YBC301	YBC401	YBM251	YBM351	YBD152	YBD252	YBG102	YBG202	YBG205	YBG302	YBG152	YBG252	YNG151	YNG151C	YC30S	YD051	YD101	YD201
	SPKW1204EDFR	---	12.7	12.7	4.76	5.56	11°								○										
	SPKW1204EDSR	---	12.7	12.7	4.76	5.56	11°								○										

Applicable tool B9-B15
Werkzeug

Tools code key B152-B153
WSP ISO

Grade selection guide B16-B20
Sortenauswahl

Technical data B183-B188
Technische Daten