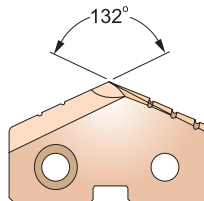


SPADE DRILL INSERTS - HSS M4
EINWEG BOHREINSATZ - HSS M4

- ▶ 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
1 17.53 (.690") to 24.38 (.960")	45/64"	17.86	.7031"	4.0 (5/32")	S1405045	S1410045	S1415045
		18.00	.7087"		S1455180	S1460180	S1465180
	23/32"	18.26	.7188"		S1405046	S1410046	S1415046
		18.50	.7283"		S1455185	S1460185	S1465185
	47/64"	18.65	.7344"		S1405047	S1410047	S1415047
		19.00	.7480"		S1455190	S1460190	S1465190
	3/4"	19.05	.7500"		S1405048	S1410048	S1415048
	49/64"	19.45	.7656"		S1405049	S1410049	S1415049
		19.50	.7677"		S1455195	S1460195	S1465195
	25/32"	19.84	.7813"		S1405050	S1410050	S1415050
		20.00	.7874"		S1455200	S1460200	S1465200
	51/64"	20.24	.7969"		S1405051	S1410051	S1415051
		20.50	.8071"		S1455205	S1460205	S1465205
	13/16"	20.64	.8125"		S1405052	S1410052	S1415052
		21.00	.8268"		S1455210	S1460210	S1465210
	27/32"	21.43	.8438"		S1405054	S1410054	S1415054
	55/64"	21.83	.8594"		S1405055	S1410055	S1415055
	22.00	.8661"	S1455220	S1460220	S1465220		
7/8"	22.23	.8750"	S1405056	S1410056	S1415056		
57/64"	22.62	.8906"	S1405057	S1410057	S1415057		
	23.00	.9055"	S1455230	S1460230	S1465230		
29/32"	23.02	.9063"	S1405058	S1410058	S1415058		
59/64"	23.42	.9219"	S1405059	S1410059	S1415059		
15/16"	23.81	.9375"	S1405060	S1410060	S1415060		
	24.00	.9449"	S1455240	S1460240	S1465240		
2 24.41 (.961") to 35.05 (1.380")	31/32"	24.61	.9688"	4.8 (3/16")	S1405062	S1410062	S1415062
	63/64"	25.00	.9843"		S1405063	S1410063	S1415063
	1"	25.40	1.0000"		S1405100	S1410100	S1415100
	1-1/64"	25.80	1.0156"		S1405101	S1410101	S1415101
		26.00	1.0236"		S1455260	S1460260	S1465260
	1-1/32"	26.19	1.0313"		S1405102	S1410102	S1415102
	1-3/64"	26.59	1.0469"		S1405103	S1410103	S1415103
	1-1/16"	26.99	1.0625"		S1405104	S1410104	S1415104
		27.00	1.0630"		S1455270	S1460270	S1465270

◎ : 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)
	○	○	○	○		○		○	○		◎	◎	○	◎	◎