

Drilling Overview

Drilling Grades

Drilling Grades		P Steel				M Stainless steel				K Cast iron				H Hardened steel			
		P05	P15	P25	P35	M05	M15	M25	M35	K05	K15	K25	K35	H05	H15	H25	H35
PVD	YG602			602				602				602					
	YG713			713													713

<p>YG602</p> <p>P20 - P35 M20 - M40 K20 - K40 S15 - S25</p>	<p>PVD - TiAlN</p>	<p>Universal grade for General Drilling Application</p> <ul style="list-style-type: none"> Ultra Dense PVD Coating with optimal thermal resistance & strength Sub-Micron substrate designed for demanding application
<p>YG713</p> <p>P15 - P25 H20 - K30</p>	<p>PVD - TiAlN</p>	<p>Drilling Grade for General Steel Application</p> <ul style="list-style-type: none"> Multi-layer TiAlN structure realizes stronger crater and flank wear resistance Fine-grained carbide and balanced substrate

Universal Drilling Inserts

	4 Corner	SPMX Series	SPMX	05, 06, 07, 09, 11, 14
	ISO 3 Corner	WCMX Series	WCMX	03, 04, 05, 06, 08

Drilling Chipbreakers

P	M	K			
	M		-ST		<ul style="list-style-type: none"> Sharp Geometry Sticky Material, Stainless Steel
P	M	K	General Inserts (No Description)		<ul style="list-style-type: none"> First Choice for General Application

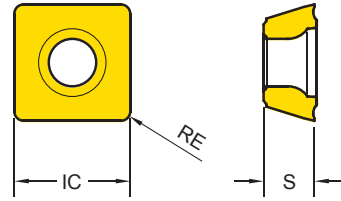
AHB DRILLING

Drilling Overview
Drilling Inserts (SPMX)
Drilling Inserts (WCMX)

TOOLING & MACHINERY

COMPLETE METALWORKING SOLUTIONS
(800) 991-4225 www.ahbinc.com
ISO Certified customerservice@ahbinc.com

Drilling - Inserts Drilling Inserts (SPMX)

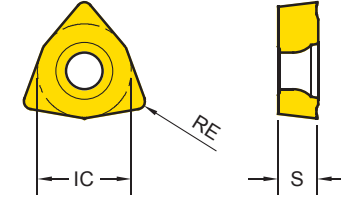


Series	inch	
	IC	S
SPMX 0502	.197	.094
SPMX 0602	.236	.095
SPMX 07T3	.313	.156
SPMX 0904	.386	.169
SPMX 1104	.453	.189
SPMX 1405	.563	.205

SPMX	Designation	Fn (mm/rev.)	EDP 3200..	
			YG602	YG713
SPMX General	SPMX 050204	.003 ~ .006	● 0005	● 0062
	SPMX 060204	.003 ~ .006	● 0006	● 0063
	SPMX 07T308	.003 ~ .006	● 0007	● 0064
	SPMX 090408	.003 ~ .006	● 0008	● 0065
	SPMX 110408	.004 ~ .007	● 0009	● 0066
	SPMX 140512	.004 ~ .008	● 0010	● 0067
-ST Stainless Steel	SPMX 050204 - ST	.001 ~ .004	● 0011	
	SPMX 060204 - ST	.002 ~ .004	● 0012	
	SPMX 07T308 - ST	.002 ~ .004	● 0013	
	SPMX 090408 - ST	.002 ~ .005	● 0014	

Cutting Speed			Vc (ft/min)			
ISO	VDI	Sub Group	YG602		YG713	
			Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	460	1250	490	920
	6~9	Low-Alloyed Steel	390	980	430	770
	10~11	High-Alloyed Steel	230	490	300	430
M	12~13	Ferritic & Martensitic	390	660	-	-
	14	Austenitic Stainless Steel	430	820	-	-
K	15~16	Grey Cast Iron	390	820	-	-
	17~18	Nodular Cast Iron	430	720	-	-
H	38~41	Hard materials	-	-	160	330

Drilling - Inserts Drilling Inserts (WCMX)



Series	inch	
	IC	S
WCMX 0302	.219	.094
WCMX 0402	.250	.094
WCMX 0503	.313	.125
WCMX 06T3	.375	.156
WCMX 0804	.500	.187

WCMX	Designation	Fn (in/rev.)	EDP 3200..	
			YG602	YG713
WCMX General	WCMX 030208	.002~.005	● 0031	
	WCMX 040208	.002~.005	● 0003	
	WCMX 050308	.002 ~ .006	● 0001	
	WCMX 06T308	.003 ~ .006	● 0002	
	WCMX 080412	.003 ~ .006	● 0004	

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