

NC Zabušivači



NC-SPOTTING DRILLS

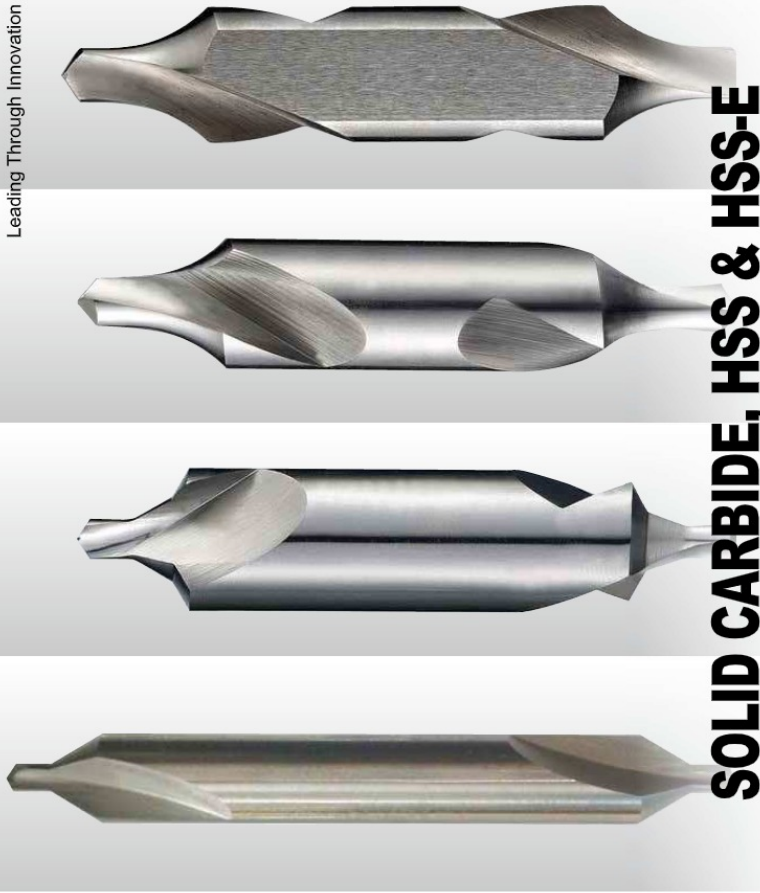
**RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDPARAMETER**

ISO	VDI	Material Description	Wc (in/rev)	Drill Diameter (mm)											RPM = rev./min. FEED = mm/rev.
				7.0	3.0	4.0	6.0	8.0	10.0	12.0	16.0	20.0			
P	1	Non-alloy steel	RPM	3980	2650	1900	1320	900	650	500	400	300	240	400	
	FEED		0.02-0.04	0.04-0.06	0.05-0.08	0.07-0.10	0.08-0.12	0.09-0.14	0.11-0.17	0.13-0.19	0.15-0.21				
	RPM		3980	2650	1900	1330	900	660	500	400	300	240	400		
	FEED		0.02-0.04	0.04-0.06	0.05-0.08	0.07-0.10	0.08-0.12	0.09-0.14	0.11-0.17	0.13-0.19	0.15-0.21				
M	12	Stainless steel	RPM	2390	1590	1190	800	600	480	400	300	240	400		
	FEED		0.02-0.04	0.04-0.06	0.05-0.08	0.07-0.10	0.08-0.12	0.09-0.14	0.11-0.17	0.13-0.19	0.15-0.21				
	RPM		2390	1590	1190	800	600	480	400	300	240	400			
	FEED		0.02-0.04	0.04-0.06	0.05-0.08	0.07-0.10	0.08-0.12	0.09-0.14	0.11-0.17	0.13-0.19	0.15-0.21				
K	15	Grey cast iron	RPM	4770	3180	2390	1590	1190	950	800	600	480	480		
	FEED		0.03-0.05	0.05-0.07	0.06-0.09	0.08-0.11	0.10-0.13	0.12-0.16	0.15-0.20	0.18-0.24	0.22-0.28				
	RPM		4770	3180	2390	1590	1190	950	800	600	480	480			
	FEED		0.03-0.05	0.05-0.07	0.06-0.09	0.08-0.11	0.10-0.13	0.12-0.16	0.15-0.20	0.18-0.24	0.22-0.28				
N	20	Malleable cast iron	RPM	3180	2130	1590	1060	800	640	530	400	320	320		
	FEED		0.03-0.05	0.05-0.07	0.06-0.09	0.08-0.11	0.10-0.13	0.12-0.16	0.15-0.20	0.18-0.24	0.22-0.28				
	RPM		10350	6900	5170	3450	2590	2070	1720	1390	1030	1030			
	FEED		0.04-0.06	0.06-0.09	0.08-0.11	0.10-0.13	0.12-0.16	0.15-0.19	0.18-0.23	0.21-0.27	0.25-0.31				
S	31	Heat Resistant Super Alloys	RPM	9550	6270	4770	3180	2390	1910	1590	1190	950	950		
	FEED		0.04-0.06	0.06-0.09	0.08-0.11	0.10-0.13	0.12-0.16	0.15-0.19	0.18-0.23	0.21-0.27	0.25-0.31				
	RPM		7940	5310	3980	2650	1900	1330	1000	760	590	460	460		
	FEED		0.04-0.06	0.06-0.09	0.08-0.11	0.10-0.13	0.12-0.16	0.15-0.19	0.18-0.23	0.21-0.27	0.25-0.31				
H	38	Titanium Alloys													
	39		Hardened steel												
	40			Chilled Cast Iron											
	41		Hardened Cast Iron												

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