INDEXABLE DRILLS OVERVIEW
VISION GENERAL DE LAS BROCAS INDEXABLES
FORETS A PLAQUETTES INDEXABLES

Working length / Longitud útil Longueur utile	2D	3D	4D	XPET..AP	SCET..-UD	XPET..AP-SD	SCET..-SD
Picture / Foto Photo							
Coolant / Refrigeración Refroidissement				–	–	–	–
	D10 – D11	D12 – D13	D14 – D15	D17	D16	D17	D16
Drill type / Tipo de broca Type de foret	802D	803D	804D	–	–	–	–
Drill tolerance / Tolerancia de la broca Tolérance de foret	± .002	± .002	± .002	–	–	–	–
Hole tolerance * / Tolerancia del agujero * Tolérance de perçage *	0 /+.008	0 /+.012	0 /+.016	–	–	–	–
Surface finish * / Acabado superficial * Finiton de surface *	R_a 78.74 - 236.22µin	R_a 78.74 - 236.22µin	R_a 78.74 - 236.22µin	–	–	–	–
Diameter range / Campo de diámetros Plage de diamètres	15,0 – 40,0 mm .591 – 1.575 in	15,0 – 58,0 mm .591 – 2.283 in	17,0 – 58,0 mm .669 – 2.283 in	–	–	–	–
Application areas Área de aplicación Domaines d'application	P1			■	■	■	■
	P2			■	■	■	■
	P3			■	■	■	■
	P4			■	■	■	■
	M1			□	□	■	■
	M2			□	□	■	■
	M3			□	□	■	■
	M4			□	□	■	■
	K1			◪	■		
	K2			◪	■		
	K3			◪	■		
	K4			◪	■		
	N1					□	□
	N2					□	□
	N3					□	□
	N4					□	□
	S1					◪	◪
	S2					◪	◪
	S3					◪	◪
	S4					◪	◪

* The tolerance of drilled hole and surface finish are heavily dependent on machining conditions
* La tolerancia del agujero y el acabado superficial dependen en gran medida de las condiciones de mecanizado
* La tolérance du perçage et de la finiton de surface dépendent fortement des caractéristiques de la machine

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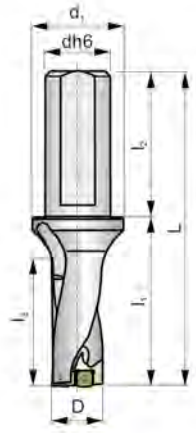

2D | 1 | ISO 9766

ANSI	D	h_{max}	L	l_1	l_2	l_3	dh6	d_1	-D	D+				lbs	
802D-0594-118-S100	.594	1.188	4.417	2.173	2.244	1.346	1.000	1.378	.012	.012	EP253253	IGI300	IGI313	.68	IHM001
802D-0625-125-S100	.625	1.250	4.480	2.236	2.244	1.425	1.000	1.378	.006	.016	EP253253	IGI300	IGI313	.71	IHM001
802D-0656-131-S100	.656	1.312	4.539	2.295	2.244	1.500	1.000	1.378	.006	.016	EP253253	IGI300	IGI313	.71	IHM001
802D-0687-137-S100	.687	1.374	4.602	2.358	2.244	1.559	1.000	1.378	.020	.020	EP253253	IGI301	IGI314	.73	IHM002
802D-0709-141-S100	.709	1.418	4.646	2.402	2.244	1.614	1.000	1.378	.014	.008	EP253253	IGI301	IGI314	.73	IHM002
802D-0750-150-S100	.750	1.500	4.728	2.484	2.244	1.677	1.000	1.378	.012	.014	EP253253	IGI301	IGI314	.73	IHM002
802D-0766-153-S100	.766	1.532	4.760	2.516	2.244	1.717	1.000	1.378	.008	.020	EP253253	IGI302	IGI315	.75	IHM003
802D-0787-157-S100	.787	1.574	4.803	2.559	2.244	1.772	1.000	1.378	.008	.020	EP253253	IGI302	IGI315	.75	IHM003
802D-0812-162-S100	.812	1.624	4.850	2.606	2.244	1.831	1.000	1.378	.004	.019	EP253253	IGI302	IGI315	.77	IHM003
802D-0827-165-S100	.827	1.654	4.882	2.638	2.244	1.870	1.000	1.378	.004	.019	EP253253	IGI302	IGI315	.77	IHM003
802D-0875-175-S100	.875	1.750	4.976	2.732	2.244	1.992	1.000	1.378	.011	.019	EP253253	IGI303	IGI316	.82	IHM004
802D-0906-181-S100	.906	1.812	5.039	2.795	2.244	2.067	1.000	1.378	.008	.019	EP253253	IGI304	IGI317	.79	IHM005
802D-0937-187-S100	.937	1.874	5.102	2.858	2.244	2.146	1.000	1.378	.004	.019	EP253253	IGI304	IGI317	.84	IHM005
802D-0984-196-S125	.984	1.969	5.315	2.953	2.362	2.165	1.250	1.654	.004	.019	EP324058	IGI304	IGI317	1.26	IHM005
802D-1000-200-S125	1.000	2.000	5.346	2.984	2.362	2.205	1.250	1.654	.004	.019	EP324058	IGI304	IGI317	1.28	IHM005
802D-1032-206-S125	1.032	2.064	5.409	3.047	2.362	2.283	1.250	1.654	.004	.019	EP324058	IGI305	IGI318	1.30	IHM006
802D-1062-212-S125	1.062	2.124	5.469	3.106	2.362	2.358	1.250	1.654	.020	.008	EP324058	IGI305	IGI318	1.30	IHM006
802D-1109-221-S125	1.109	2.218	5.563	3.201	2.362	2.476	1.250	1.654	.020	.014	EP324058	IGI306	IGI319	1.34	IHM007
802D-1125-225-S125	1.125	2.250	5.598	3.236	2.362	2.520	1.250	1.654	.020	.014	EP324058	IGI306	IGI319	1.37	IHM007
802D-1187-237-S125	1.187	2.374	5.720	3.358	2.362	2.669	1.250	1.654	.014	.020	EP324058	IGI306	IGI319	1.43	IHM007
802D-1250-250-S150	1.250	2.500	6.122	3.484	2.638	2.669	1.500	1.969	.006	.020	–	IGI307	IGI320	2.07	IHM008
802D-1312-262-S150	1.312	2.624	6.244	3.606	2.638	2.827	1.500	1.969	.020	.020	–	IGI307	IGI320	2.16	IHM008
802D-1375-275-S150	1.375	2.750	6.370	3.732	2.638	2.945	1.500	1.969	.008	.020	–	IGI308	IGI321	2.23	IHM009
802D-1437-287-S150	1.437	2.874	6.496	3.858	2.638	3.098	1.500	1.969	.004	.020	–	IGI308	IGI321	2.29	IHM009
802D-1500-300-S150	1.500	3.000	6.622	3.984	2.638	3.256	1.500	1.969	.006	.020	–	IGI308	IGI321	2.43	IHM009
802D-1750-350-S150	1.750	3.500	7.094	4.457	2.638	3.894	1.500	1.969	.020	.020	–	IGI309	IGI322	2.87	IHM010
802D-2000-400-S150	2.000	4.000	7.626	4.988	2.638	4.394	1.500	2.205	.006	.020	–	IGI310	IGI323	3.70	IHM011

IGI300	XPET 0502AP	SCET 050204-UD
IGI301	XPET 0602AP	SCET 050204-UD
IGI302	XPET 0602AP	SCET 060204-UD
IGI303	XPET 0703AP	SCET 060204-UD
IGI304	XPET 0703AP	SCET 070308-UD
IGI305	XPET 0903AP	SCET 070308-UD
IGI306	XPET 0903AP	SCET 09T308-UD
IGI307	XPET 11T3AP	SCET 09T308-UD
IGI308	XPET 11T3AP	SCET 120408-UD
IGI309	XPET 1504AP	SCET 120408-UD
IGI310	XPET 1504AP	SCET 150512-UD
IGI313	XPET 0502AP-SD	SCET 050204-SD
IGI314	XPET 0602AP-SD	SCET 050204-SD
IGI315	XPET 0602AP-SD	SCET 060204-SD
IGI316	XPET 0703AP-SD	SCET 060204-SD
IGI317	XPET 0703AP-SD	SCET 070308-SD
IGI318	XPET 0903AP-SD	SCET 070308-SD
IGI319	XPET 0903AP-SD	SCET 09T308-SD
IGI320	XPET 11T3AP-SD	SCET 09T308-SD
IGI321	XPET 11T3AP-SD	SCET 120408-SD
IGI322	XPET 1504AP-SD	SCET 120408-SD
IGI323	XPET 1504AP-SD	SCET 150512-SD

		Nm		Nm	
IHM001	US 2245-T07P	0.9	US 2245-T07P	0.9	FLAG T07P
IHM002	US 2205-T07P	0.9	US 2245-T07P	0.9	FLAG T07P
IHM003	US 2205-T07P	0.9	US 2205-T07P	0.9	FLAG T07P
IHM004	US 2506-T07P	1.2	US 2506-T07P	1.2	FLAG T07P
IHM005	US 2507-T08P	1.2	US 3007-T08P	2.0	FLAG T08P
IHM006	US 3007-T09P	2.0	US 3007-T09P	2.0	FLAG T09P
IHM007	US 3007-T09P	2.0	US 3009-T09P	2.0	FLAG T09P
IHM008	US 3510-T15P	3.0	US 3508-T15P	3.0	FLAG T15P
IHM009	US 3510-T15P	3.0	US 5012-T15P	5.0	FLAG T15P
IHM010	US 4011-T15P	4.0	US 5012-T15P	5.0	FLAG T15P
IHM011	US 4011-T15P	4.0	US 5012-T15P	5.0	FLAG T15P

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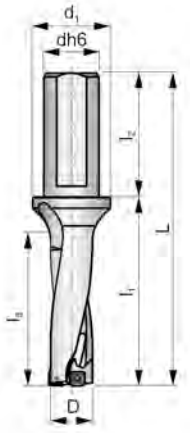

3D | 1 | ISO 9766

ANSI	D	h_{max}	L	l_1	l_2	l_3	dh6	d_1	-D	D+				lbs	
803D-0594-178-S100	.594	1.783	5.012	2.768	2.244	1.941	1.000	1.378	.012	.012	EP253253	IGI300	IGI313	.71	IHM001
803D-0625-187-S100	.625	1.875	5.102	2.858	2.244	2.047	1.000	1.378	.006	.016	EP253253	IGI300	IGI313	.73	IHM001
803D-0656-196-S100	.656	1.969	5.197	2.953	2.244	2.157	1.000	1.378	.006	.016	EP253253	IGI300	IGI313	.73	IHM001
803D-0687-206-S100	.687	2.061	5.287	3.043	2.244	2.244	1.000	1.378	.020	.020	EP253253	IGI301	IGI314	.75	IHM002
803D-0709-212-S100	.709	2.127	5.354	3.110	2.244	2.323	1.000	1.378	.014	.008	EP253253	IGI301	IGI314	.77	IHM002
803D-0750-225-S100	.750	2.250	5.476	3.232	2.244	2.425	1.000	1.378	.012	.014	EP253253	IGI301	IGI314	.79	IHM002
803D-0766-229-S100	.766	2.298	5.528	3.283	2.244	2.484	1.000	1.378	.008	.020	EP253253	IGI302	IGI315	.79	IHM003
803D-0787-236-S100	.787	2.361	5.591	3.346	2.244	2.559	1.000	1.378	.008	.020	EP253253	IGI302	IGI315	.82	IHM003
803D-0812-243-S100	.812	2.436	5.665	3.421	2.244	2.646	1.000	1.378	.004	.019	EP253253	IGI302	IGI315	.82	IHM003
803D-0827-248-S100	.827	2.481	5.709	3.465	2.244	2.697	1.000	1.378	.004	.019	EP253253	IGI302	IGI315	.84	IHM003
803D-0875-262-S100	.875	2.625	5.854	3.610	2.244	2.866	1.000	1.378	.011	.019	EP253253	IGI303	IGI316	.88	IHM004
803D-0906-271-S100	.906	2.718	5.945	3.701	2.244	2.972	1.000	1.378	.008	.019	EP253253	IGI304	IGI317	.90	IHM005
803D-0922-276-S100	.922	2.766	5.996	3.752	2.244	3.031	1.000	1.378	.008	.019	EP253253	IGI304	IGI317	.95	IHM005
803D-0937-281-S100	.937	2.811	6.039	3.795	2.244	3.083	1.000	1.378	.004	.019	EP253253	IGI304	IGI317	.93	IHM005
803D-0984-295-S125	.984	2.952	6.299	3.937	2.362	3.150	1.250	1.654	.004	.019	EP324058	IGI304	IGI317	1.37	IHM005
803D-1000-300-S125	1.000	3.000	6.346	3.984	2.362	3.205	1.250	1.654	.004	.019	EP324058	IGI304	IGI317	1.39	IHM005
803D-1032-310-S125	1.032	3.096	6.441	4.079	2.362	3.315	1.250	1.654	.004	.019	EP324058	IGI305	IGI318	1.41	IHM006
803D-1062-318-S125	1.062	3.186	6.531	4.169	2.362	3.421	1.250	1.654	.020	.008	EP324058	IGI305	IGI318	1.43	IHM006
803D-1109-332-S125	1.109	3.327	6.673	4.311	2.362	3.587	1.250	1.654	.020	.014	EP324058	IGI306	IGI319	1.52	IHM007
803D-1125-337-S125	1.125	3.375	6.720	4.358	2.362	3.642	1.250	1.654	.020	.014	EP324058	IGI306	IGI319	1.52	IHM007
803D-1172-351-S125	1.172	3.516	6.862	4.500	2.362	3.807	1.250	1.654	.014	.020	EP324058	IGI306	IGI319	1.61	IHM007
803D-1187-356-S125	1.187	3.561	6.906	4.543	2.362	3.858	1.250	1.654	.014	.020	EP324058	IGI306	IGI319	1.63	IHM007
803D-1250-375-S150	1.250	3.750	7.370	4.732	2.638	3.921	1.500	1.969	.006	.020	–	IGI307	IGI320	2.31	IHM008
803D-1312-393-S150	1.312	3.936	7.559	4.921	2.638	4.138	1.500	1.969	.020	.020	–	IGI307	IGI320	2.45	IHM008
803D-1375-412-S150	1.375	4.125	7.748	5.110	2.638	4.319	1.500	1.969	.008	.020	–	IGI308	IGI321	2.56	IHM009
803D-1437-431-S150	1.437	4.311	7.933	5.295	2.638	4.535	1.500	1.969	.004	.020	–	IGI308	IGI321	2.62	IHM009
803D-1500-450-S150	1.500	4.500	8.122	5.484	2.638	4.756	1.500	1.969	.006	.020	–	IGI308	IGI321	2.80	IHM009
803D-1750-525-S150	1.750	5.250	8.843	6.205	2.638	5.642	1.500	1.969	.020	.020	–	IGI309	IGI322	3.48	IHM010
803D-2000-600-S150	2.000	6.000	9.626	6.988	2.638	6.394	1.500	2.205	.006	.020	–	IGI310	IGI323	4.70	IHM011

IGI300	XPET 0502AP	SCET 050204-UD
IGI301	XPET 0602AP	SCET 050204-UD
IGI302	XPET 0602AP	SCET 060204-UD
IGI303	XPET 0703AP	SCET 060204-UD
IGI304	XPET 0703AP	SCET 070308-UD
IGI305	XPET 0903AP	SCET 070308-UD
IGI306	XPET 0903AP	SCET 09T308-UD
IGI307	XPET 11T3AP	SCET 09T308-UD
IGI308	XPET 11T3AP	SCET 120408-UD
IGI309	XPET 1504AP	SCET 120408-UD
IGI310	XPET 1504AP	SCET 150512-UD
IGI311	XPET 1504AP	SCET 150512-UD
IGI312	XPET 1904AP	SCET 150512-UD
IGI313	XPET 0502AP-SD	SCET 050204-SD
IGI314	XPET 0602AP-SD	SCET 050204-SD
IGI315	XPET 0602AP-SD	SCET 060204-SD
IGI316	XPET 0703AP-SD	SCET 060204-SD
IGI317	XPET 0703AP-SD	SCET 070308-SD
IGI318	XPET 0903AP-SD	SCET 070308-SD
IGI319	XPET 0903AP-SD	SCET 09T308-SD
IGI320	XPET 11T3AP-SD	SCET 09T308-SD
IGI321	XPET 11T3AP-SD	SCET 120408-SD
IGI322	XPET 1504AP-SD	SCET 120408-SD
IGI323	XPET 1504AP-SD	SCET 150512-SD
IGI324	XPET 1504AP-SD	SCET 150512-SD
IGI325	XPET 1904AP-SD	SCET 150512-SD

		Nm		Nm	
IHM001	US 2245-T07P	0.9	US 2245-T07P	0.9	FLAG T07P
IHM002	US 2205-T07P	0.9	US 2245-T07P	0.9	FLAG T07P
IHM003	US 2205-T07P	0.9	US 2205-T07P	0.9	FLAG T07P
IHM004	US 2506-T07P	1.2	US 2506-T07P	1.2	FLAG T07P
IHM005	US 2507-T08P	1.2	US 3007-T08P	2.0	FLAG T08P
IHM006	US 3007-T09P	2.0	US 3007-T09P	2.0	FLAG T09P
IHM007	US 3007-T09P	2.0	US 3009-T09P	2.0	FLAG T09P
IHM008	US 3510-T15P	3.0	US 3508-T15P	3.0	FLAG T15P
IHM009	US 3510-T15P	3.0	US 5012-T15P	5.0	FLAG T15P
IHM010	US 4011-T15P	3.5	US 5012-T15P	5.0	FLAG T15P
IHM011	US 4011-T15P	4.0	US 5012-T15P	5.0	FLAG T15P

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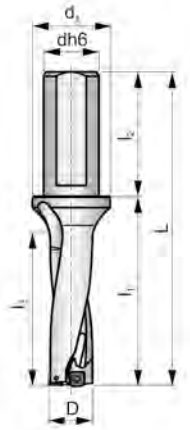


4D | 1 | ISO 9766

ANSI	D	h_{max}	L	l_1	l_2	l_3	dh6	d_1	-D	D+					
804D-0594-237-S100	.594	2.376	5.606	3.362	2.244	2.535	1.000	1.378	.012	.012	EP253253	IGI300	IGI313	.73	IHM001
804D-0625-250-S100	.625	2.500	5.728	3.484	2.244	2.673	1.000	1.378	.006	.016	EP253253	IGI300	IGI313	.75	IHM001
804D-0656-262-S100	.656	2.624	5.850	3.587	2.244	2.811	1.000	1.378	.006	.016	EP253253	IGI300	IGI313	.77	IHM001
804D-0687-274-S100	.687	2.748	5.976	3.732	2.244	2.933	1.000	1.378	.020	.020	EP253253	IGI301	IGI314	.79	IHM002
804D-0709-283-S100	.709	2.836	6.063	3.819	2.244	3.031	1.000	1.378	.014	.008	EP253253	IGI301	IGI314	.79	IHM002
804D-0750-300-S100	.750	3.000	6.228	3.984	2.244	3.217	1.000	1.378	.012	.014	EP253253	IGI301	IGI314	.82	IHM002
804D-0766-306-S100	.766	3.064	6.291	4.047	2.244	3.248	1.000	1.378	.008	.020	EP253253	IGI302	IGI315	.84	IHM003
804D-0787-314-S100	.787	3.148	6.378	4.134	2.244	3.346	1.000	1.378	.008	.020	EP253253	IGI302	IGI315	.86	IHM003
804D-0812-324-S100	.812	3.248	6.476	4.232	2.244	3.457	1.000	1.378	.004	.019	EP253253	IGI302	IGI315	.88	IHM003
804D-0827-330-S100	.827	3.308	6.535	4.291	2.244	3.524	1.000	1.378	.004	.019	EP253253	IGI302	IGI315	.90	IHM003
804D-0875-350-S100	.875	3.500	6.728	4.484	2.244	3.740	1.000	1.378	.011	.019	EP253253	IGI303	IGI316	.97	IHM004
804D-0922-368-S100	.922	3.688	6.917	4.673	2.244	3.953	1.000	1.378	.008	.019	EP253253	IGI304	IGI317	1.01	IHM005
804D-0937-374-S100	.937	3.748	6.976	4.732	2.244	4.020	1.000	1.378	.004	.019	EP253253	IGI304	IGI317	1.01	IHM005
804D-0984-393-S125	.984	3.936	7.283	4.921	2.362	4.134	1.250	1.654	.004	.019	EP324058	IGI304	IGI317	1.48	IHM005
804D-1000-400-S125	1.000	4.000	7.346	4.984	2.362	4.205	1.250	1.654	.004	.019	EP324058	IGI304	IGI317	1.52	IHM005
804D-1032-412-S125	1.032	4.128	7.476	5.114	2.362	4.350	1.250	1.654	.004	.019	EP324058	IGI305	IGI318	1.54	IHM006
804D-1062-424-S125	1.062	4.248	7.594	5.232	2.362	4.248	1.250	1.654	.020	.008	EP324058	IGI305	IGI318	1.59	IHM006
804D-1109-443-S125	1.109	4.437	7.783	5.421	2.362	4.697	1.250	1.654	.020	.014	EP324058	IGI306	IGI319	1.68	IHM007
804D-1125-450-S125	1.125	4.500	7.846	5.484	2.362	4.768	1.250	1.654	.020	.014	EP324058	IGI306	IGI319	1.70	IHM007
804D-1172-468-S125	1.172	4.688	8.035	5.673	2.362	4.980	1.250	1.654	.014	.020	EP324058	IGI306	IGI319	1.79	IHM007
804D-1187-474-S125	1.187	4.748	8.094	5.732	2.362	5.043	1.250	1.654	.014	.020	EP324058	IGI306	IGI319	1.83	IHM007
804D-1250-500-S150	1.250	5.000	8.622	5.984	2.638	5.169	1.500	1.969	.006	.020	–	IGI307	IGI320	2.54	IHM008
804D-1312-524-S150	1.312	5.248	8.870	6.232	2.638	5.449	1.500	1.969	.020	.020	–	IGI307	IGI320	2.73	IHM008
804D-1375-550-S150	1.375	5.500	9.122	6.484	2.638	5.693	1.500	1.969	.008	.020	–	IGI308	IGI321	2.87	IHM009
804D-1437-574-S150	1.437	5.748	9.370	6.732	2.638	5.748	1.500	1.969	.004	.020	–	IGI308	IGI321	2.98	IHM009
804D-1500-600-S150	1.500	6.000	9.622	6.984	2.638	6.256	1.500	1.969	.006	.020	–	IGI308	IGI321	3.20	IHM009
804D-1750-700-S150	1.750	7.000	10.622	7.984	2.638	7.421	1.500	1.969	.020	.020	–	IGI309	IGI322	4.12	IHM010
804D-2000-800-S150	2.000	8.000	11.622	8.984	2.638	8.390	1.500	2.205	.006	.020	–	IGI310	IGI323	5.67	IHM011

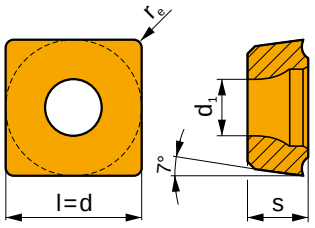
IGI300	XPET 0502AP	SCET 050204-UD
IGI301	XPET 0602AP	SCET 050204-UD
IGI302	XPET 0602AP	SCET 060204-UD
IGI303	XPET 0703AP	SCET 060204-UD
IGI304	XPET 0703AP	SCET 070308-UD
IGI305	XPET 0903AP	SCET 070308-UD
IGI306	XPET 0903AP	SCET 09T308-UD
IGI307	XPET 11T3AP	SCET 09T308-UD
IGI308	XPET 11T3AP	SCET 120408-UD
IGI309	XPET 1504AP	SCET 120408-UD
IGI310	XPET 1504AP	SCET 150512-UD
IGI311	XPET 1504AP	SCET 150512-UD
IGI312	XPET 1904AP	SCET 150512-UD
IGI313	XPET 0502AP-SD	SCET 050204-SD
IGI314	XPET 0602AP-SD	SCET 050204-SD
IGI315	XPET 0602AP-SD	SCET 060204-SD
IGI316	XPET 0703AP-SD	SCET 060204-SD
IGI317	XPET 0703AP-SD	SCET 070308-SD
IGI318	XPET 0903AP-SD	SCET 070308-SD
IGI319	XPET 0903AP-SD	SCET 09T308-SD
IGI320	XPET 11T3AP-SD	SCET 09T308-SD
IGI321	XPET 11T3AP-SD	SCET 120408-SD
IGI322	XPET 1504AP-SD	SCET 120408-SD
IGI323	XPET 1504AP-SD	SCET 150512-SD
IGI324	XPET 1504AP-SD	SCET 150512-SD
IGI325	XPET 1904AP-SD	SCET 150512-SD

		Nm		Nm	
IHM001	US 2245-T07P	0.9	US 2245-T07P	0.9	FLAG T07P
IHM002	US 2205-T07P	0.9	US 2245-T07P	0.9	FLAG T07P
IHM003	US 2205-T07P	0.9	US 2205-T07P	0.9	FLAG T07P
IHM004	US 2506-T07P	1.2	US 2506-T07P	1.2	FLAG T07P
IHM005	US 2507-T08P	1.2	US 3007-T08P	2.0	FLAG T08P
IHM006	US 3007-T09P	2.0	US 3007-T09P	2.0	FLAG T09P
IHM007	US 3007-T09P	2.0	US 3009-T09P	2.0	FLAG T09P
IHM008	US 3510-T15P	3.0	US 3508-T15P	3.0	FLAG T15P
IHM009	US 3510-T15P	3.0	US 5012-T15P	5.0	FLAG T15P
IHM010	US 4011-T15P	3.5	US 5012-T15P	5.0	FLAG T15P
IHM011	US 4011-T15P	4.0	US 5012-T15P	5.0	FLAG T15P

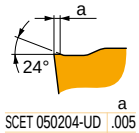
PRAMET

SCET

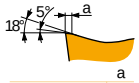
	d	d_1	l	s
0502	.219	.094	.219	.094
0602	.250	.114	.250	.094
0703	.312	.138	.312	.125
09T3	.375	.177	.375	.156
1204	.500	.220	.500	.187
1505	.625	.220	.625	.219



ANSI		P	M	K	N	S	H			r_e	f_{min}	f_{max}	$a_{p\,min}$	$a_{p\,max}$
SCET 050204-UD	**D8330**	■	□	■				●	+++	.016	.002	.004	–	–
	D9335	■	□	■				●	+++	.016	.002	.004	–	–
SCET 060204-UD	**D8330**	■	□	■				●	+++	.016	.002	.006	–	–
	D9335	■	□	■				●	+++	.016	.002	.006	–	–
SCET 070308-UD	**D8330**	■	□	■				●●	+++	.031	.003	.007	–	–
	D9335	■	□	■				●●	+++	.031	.003	.007	–	–
SCET 09T308-UD	**D8330**	■	□	■				●●	+++	.031	.003	.008	–	–
	D9335	■	□	■				●●	+++	.031	.003	.008	–	–
SCET 120408-UD	**D8330**	■	□	■				●●	+++	.031	.004	.009	–	–
	D9335	■	□	■				●●	+++	.031	.004	.009	–	–
SCET 150512-UD	**D8330**	■	□	■				●●	+++	.047	.004	.010	–	–
	D9335	■	□	■				●●	+++	.047	.004	.010	–	–
SCET 050204-SD	**D8330**	■	■		□	◪		●	+++	.016	.002	.004	–	–
	D9335	■	■			◪		●	+++	.016	.002	.004	–	–
SCET 060204-SD	**D8330**	■	■		□	◪		●	+++	.016	.002	.006	–	–
	D9335	■	■			◪		●	+++	.016	.002	.006	–	–
SCET 070308-SD	**D8330**	■	■		□	◪		●●	+++	.031	.003	.007	–	–
	D9335	■	■			◪		●●	+++	.031	.003	.007	–	–
SCET 09T308-SD	**D8330**	■	■		□	◪		●●	+++	.031	.003	.008	–	–
	D9335	■	■			◪		●●	+++	.031	.003	.008	–	–
SCET 120408-SD	**D8330**	■	■		□	◪		●●	+++	.031	.004	.009	–	–
	D9335	■	■			◪		●●	+++	.031	.004	.009	–	–
SCET 150512-SD	**D8330**	■	■		□	◪		●●	+++	.047	.004	.010	–	–
	D9335	■	■			◪		●●	+++	.047	.004	.010	–	–



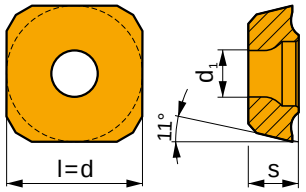
	a
SCET 050204-UD	.005
SCET 060204-UD	.006
SCET 070308-UD	.006
SCET 09T308-UD	.006
SCET 120408-UD	.008
SCET 150512-UD	.008



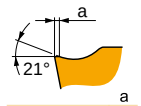
	a
SCET 050204-SD	.002
SCET 060204-SD	.002
SCET 070308-SD	.003
SCET 09T308-SD	.004
SCET 120408-SD	.004
SCET 150512-SD	.004

XPET

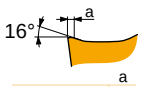
	d	d_1	l	s
0502	.219	.094	.219	.094
0602	.250	.102	.250	.094
0703	.312	.114	.313	.125
0903	.375	.138	.375	.125
11T3	.453	.154	.453	.156
12T3	.500	.154	.500	.156
1504	.625	.177	.625	.187
1904	.750	.177	.750	.187



		ANSI		P	M	K	N	S	H			r_e	f_{min}	f_{max}	$a_{p\,min}$	$a_{p\,max}$
		XPET 0502AP	**D8345**	■	□	◪					+++	–	.002	.004	–	–
		XPET 0602AP	**D8345**	■	□	◪					+++	–	.002	.006	–	–
		XPET 0703AP	**D8345**	■	□	◪					+++	–	.003	.007	–	–
		XPET 0903AP	**D8345**	■	□	◪					+++	–	.003	.008	–	–
		XPET 11T3AP	**D8345**	■	□	◪					+++	–	.004	.009	–	–
		XPET 12T3AP	**D8345**	■	□	◪					+++	–	.004	.009	–	–
		XPET 1504AP	**D8345**	■	□	◪					+++	–	.004	.010	–	–
		XPET 1904AP	**D8345**	■	□	◪					+++	–	.004	.010	–	–
		XPET 0502AP-SD	**D8345**	■	■			◪			+++	–	.002	.004	–	–
		XPET 0602AP-SD	**D8345**	■	■			◪			+++	–	.002	.006	–	–
		XPET 0703AP-SD	**D8345**	■	■			◪			+++	–	.003	.007	–	–
		XPET 0903AP-SD	**D8345**	■	■			◪			+++	–	.003	.008	–	–
		XPET 11T3AP-SD	**D8345**	■	■			◪			+++	–	.004	.009	–	–
		XPET 12T3AP-SD	**D8345**	■	■			◪			+++	–	.004	.009	–	–
		XPET 1504AP-SD	**D8345**	■	■			◪			+++	–	.004	.010	–	–
		XPET 1904AP-SD	**D8345**	■	■			◪			+++	–	.004	.010	–	–



	a
XPET 0502AP	.004
XPET 0602AP	.004
XPET 0703AP	.006
XPET 0903AP	.010
XPET 11T3AP	.010
XPET 12T3AP	.010
XPET 1504AP	.010
XPET 1904AP	.010



	a
XPET 0502AP-SD	.002
XPET 0602AP-SD	.002
XPET 0703AP-SD	.003
XPET 0903AP-SD	.004
XPET 11T3AP-SD	.004
XPET 12T3AP-SD	.004
XPET 1504AP-SD	.004
XPET 1904AP-SD	.005

DRILLING
- TECHNICAL INFORMATION

TALADRADO
- APARTADO TÉCNICO

PERÇAGE
- INFORMATIONS TECHNIQUES

WORKPIECE MATERIALS – CLASSIFICATION
CLASIFICACIÓN DE MATERIALES MECANIZADOS

Correctly identifying the machined material is one of the most important factors when choosing the tool and the initial machining conditions. To facilitate this, the machined materials are divided into six basic groups, or into twenty–four subgroups, combining materials that qualitatively cause the same type of loading (pressure) on the cutting edge and therefore a similar type of wear.

Thus the first step is to assign the workpiece material to one of the (sub)groups – see table 5. below.

Identificar correctamente el material mecanizado es uno de los factores más importantes al momento de elegir la herramienta y la condiciones iniciales de mecanizado. Para facilitar esto, los materiales mecanizados se dividen en seis grupos básicos, o en veinticuatro subgrupos, combinando materiales que cualitativamente pueden causar el mismo tipo de carga (esfuerzo) en la arista de de corte y por lo tanto un tipo similar de desgaste. Así, el primer paso es asignar el material de la pieza a uno de los (sub) grupos - véase la tabla 5. a continuación.

Table 5 / Tabla 5

Subgroup Sub-grupo		DORMER AMG	Subgroup definition	Definición de sub-grupo	Example Ejemplo	Correction factor / Factor de corrección
P	P1	1.1, 1.2	Steel and cast steel with very good (enhanced) machinability; automatic steel and low–carbon steel	Acero y fundición de acero con muy buena (mejorado) mecanización, acero automático y de acero bajo en carbono	9SMn28	1.33
	P2	1.3	Non–alloy and low–alloy cast steel and steel with a medium carbon content (0.25 < C < 0.55); rigidity of up to 900 MPa and hardness of 160 – 255 HB	Sin alear y de baja aleación de acero fundido y acero con un contenido de carbono medio (0,25 < C < 0,55); rigidez de hasta 900 MPa y una dureza de 160 – 255 HB	C45	1.00
	P3	1.4	Less machinable non–alloy and low–alloy cast steel and steel with a medium carbon content; rigidity of up to 1000 MPa and hardness of up to 300 HB	Menos mecanizable sin alear y de acero fundido de baja aleación y acero con un contenido de carbono medio; rigidez de hasta 1000 MPa y una dureza de hasta 300 HB	41CrAlMo7	0.80
	P4	1.5	Medium – to high-alloy cast steel and steel (usually with a carbon content of 0.55 < C); rigidity of up to 1270 MPa and hardness of up to 375 HB (resp. 40 HRC)	Medio – alto-aleación de acero fundido y acero (normalmente con un contenido de carbono de 0,55 < C); rigidez de hasta 1270 MPa y una dureza de hasta 375HB (resp. 40 HRC)	X210Cr12	0.60
M	M1	2.1	Ferritic corrosion–resistant steel	Acero resistente a la corrosión ferrítico	X6Cr17	1.09
	M2	(2.1, 2.4)	Martensitic corrosion–resistant steel	Acero resistente a la corrosión martensítico	X 45CrSi 9.3	1.06
	M3	2.2	Austenitic corrosion–resistant steel	Acero resistente a la corrosión austenítico	X 6CrNiTi 18 10	1.00
	M4	2.3, 2.4	Ferritic–austenitic (duplex) and super–austenitic corrosion–resistant steel	Ferrítico-austenítico (dúplex) y super-austenítico acero resistente a la corrosión	X 53 CrMnNiN21 9	0.93
K	K1	3.1, 3.2	Grey cast iron	Gris hierro fundido	GG–25	1.00
	K2	3.1, 3.2	Tempered cast iron	Hierro fundido templado	GTS 45–06	0.95
	K3	3.3	Ductile cast iron ferritic and ferrite–pearlite	Fundición ferrítico hierro y ferrita-perlita	GGG40	0.90
	K4	3.4	Ductile cast iron pearlite–ferritic, pearlite–sorbitic and pearlite	Fundición dúctil de perlita y ferrita, perlita-sorbitic y perlita	GGG–70	0.85
N	N1	7.1	Aluminium and its soft alloys (with a low Si content), particularly formed and cast (non–hardened); hardness of up to 100 HB	Aluminio y sus aleaciones blandas (con bajo contenido de Si), especialmente formado y yeso (no resistente); dureza de hasta 100 HB	AlMgSi1	1.00
	N2	7.2, 7.3, 7.4	Hard Al alloys, particularly cast and hardened (with a high Si content)	Duro aleaciones de Al, en particular emitidos y endurecidos (con un alto contenido de Si)	G–AlSi11	0.65
	N3	6.1, 6.2, 6.3	Soft Cu alloys, automatic brass and other types of soft brass and bronze	Aleaciones Cu suaves, latón automática y otros tipos de latón blando y bronce	G–CuSn5Zn5Pb	0.60
	N4	6.4	Less machinable and hard Cu alloys	Aleaciones Cu menos mecanizables y duros	G–CuAl10Fe	0.40
S	S1	4.1, 4.2, 4.3	Technically pure Ti, alloys a , a+b and b, refined and aged alloys	Técnicamente ti puro, aleaciones a , a+b y b, refinado y aleaciones viejas	TiAl6V4	1.75
	S2	(9.1)	Fe–based alloys	Aleaciones a base de hierro	X10NiCrAlTi3221	1.20
	S3	5.1, 5.2, 5.3	Ni–based alloys	Aleaciones a base de niquel	INCONEL 718	1.20
	S4	(9.1)	Co–based alloys	Aleaciones a base de cobalto	Haynes 25	0.75
H	H1	1.6	Highly rigid and hard tool steel and hardened and refined steel with a hardness of 40 – 50 HRC	Muy rígido y duro y acero para herramientas endurecido y acero refinado, con una dureza de 40 – 50 HRC	X30WCrV9.3	1.15
	H2	–	Hardened and white cast iron 350 – 600 HV	Hierro fundido templado y blanco 350 – 600 HV	G–X 260 NiCr 4 2	1.10
	H3	1.7	Hardened and refined steel with hardness in the 50 – 55 HRC range	Acero templado y refinada con dureza en el 50 – 55 gama HRC	X38CrMoV5.1	1.00
	H4	1.8	Hardened and refined (mostly tool) steel with hardness of more than 55 HRC	Endurecido y refinado (en su mayoría de la herramienta) de acero con dureza de más de 55 HRC	X210Cr12	0.95

CLASSIFICATION DES GROUPES DE MATÉRIAUX À USINER

L'identification du matériau à usiner est l'un des facteurs les plus importants pour choisir l'outil et les conditions de coupe de départ. Pour simplifier ce choix, les matériaux usinés sont divisés en six groupes de base, ou vingt quatre sous-groupes. Dans chacun sont associés des matériaux qui causent le même type de charge sur l'arête de coupe et également un type d'usure similaire. C'est pourquoi la première étape consiste à identifier le matériau à usiner parmi les (sous-)groupes référencés - voir tableau N°5 ci-dessous.

Tableau 5

Subgrupo Sous-groupe		DORMER AMG	Définiton du sous-groupe	Exemplo Exemple	Correção Standard Correction à la norme
P	P1	1.1, 1.2	Acier et acier coulé avec une usinabilité améliorée ; acier de construction et acier à faible teneur en carbone	9SMn28	1.33
	P2	1.3	Acier et acier coulé non allié et faiblement allié à moyenne teneur en carbone (0,25 < C < 0,55); résistance jusqu'à 900 MPa et dureté de 160 – 255 HB	C45	1.00
	P3	1.4	Acier et acier coulé non allié et faiblement allié à moyenne teneur en carbone plus di□ciles à usiner; résistance jusqu'à 1000 MPa et dureté jusqu'à 300 HB	41CrAlMo7	0.80
	P4	1.5	Acier et acier coulé moyennement et fortement allié (généralement avec une teneur en carbonne 0,55 < C); résistance jusqu'à 1270 MPa et dureté jusqu'à 375 HB HRC)	X210Cr12	0.60
M	M1	2.1	Aciers inoxydables ferritiques résistants à la corrosion	X6Cr17	1.09
	M2	(2.1, 2.4)	Aciers inoxydables martensitiques résistants à la corrosion	X 45CrSi 9.3	1.06
	M3	2.2	Aciers inoxydables austénitiques résistants à la corrosion	X 6CrNiTi 18 10	1.00
	M4	2. , 2.4	Aciers inoxydables ferritiques-austénitiques (duplex) et super austénitiques résistants à la corrosion	X 53 CrMnNiN21 9	0.93
K	K1	3.1, 3.2	Fontes grises	GG–25	1.00
	K2	3.1, 3.2	Fontes trempées	GTS 45–06	0.95
	K3	3.3	Fontes ductiles ferritiques et ferritiques-perlitiques	GGG40	0.90
	K4	3.4	Fontes ductiles perlites-ferrites, perlites et de perlites sorbitiques	GGG–70	0.85
N	N1	7.1	L'aluminium et ses alliages doux (à faible teneur en Si), en particulier formés et coulés (non trempé); dureté jusqu'à 100 HB	AlMgSi1	1.00
	N2	7.2, 7.3, 7.4	Alliages Al durs, en particulier coulés et traités (à haute teneur en Si)	G–AlSi11	0.65
	N3	6.1, 6.2, 6.3	Alliages Cu doux, laiton automatique et autres types de laiton et de bronze tendre	G–CuSn5Zn5Pb	0.60
	N4	6.4	Alliages moins faciles à usiner et alliages durs Cu	G–CuAl10Fe	0.40
S	S1	4.1, 4.2, 4.3	Ti techniquement pur, alliages a, a+b et b, alliages a□nés et vieillis	TiAl6V4	1.75
	S2	(9.1)	Alliages base Fe	X10NiCrAlTi3221	1.20
	S3	5.1, 5.2, 5.3	Alliages base Ni	INCONEL 718	1.00
	S4	(9.1)	Alliages base Co	Haynes 25	0.75
H	H1	1.6	Aciers à outils très résistants durs, trempés, a□nés avec une dureté de 40 – 50 HRC	X30WCrV9.3	1.15
	H2	–	Fontes trempées et blanches 350 – 600 HV	G–X 260 NiCr 4 2	1.10
	H3	1.7	Aciers trempés et a□nés avec une dureté dans la plage 50 – 55 HRC	X38CrMoV5.1	1.00
	H4	1.8	Aciers trempés et a□nés (principalement acier à outil) avec une dureté de plus de 55 HRC	X210Cr12	0.95

DRILLING GRADES
CALIDADES DE TALADRADO
CODIFICATION DES NUANCES

D	8	3	3	0
Application Aplicación Application	Coating / Substrate Recubrimiento / Sustrato Revêtement / Substrat	Sequence number Número de secuencia Numéro de séquence	ISO range Gama ISO Plage ISO	

D	Drilling Taladrado Perçage
M	Milling Fresado Fraisage
T	Turning Torneado Tournage

0 PVD **1 CVD**	Special application Aplicación especial Application spéciale
2 PVD **3 CVD**	Free Libre Libre
4 PVD **5 CVD**	Cast iron Fundición Fonte
6 PVD **7 CVD**	Group M, S Grupos M, S Groupes M, S
8 PVD **9 CVD**	Universal Universal Universel
B	CBN
C	Ceramic Cerámica Céramique
D	PCD
T	Cermet Cermet Cermet

1 – 9

	01 – 50
	**01 – 05**
	**05 – 10**
	**10 – 20**
	**20 – 30**
	**30 – 40**
	**40 – 50**

Table 2
Tabla 2
Tableau 2

DRILLING GRADES
DESCRIPCIÓN DE CALIDADES
CODIFICATION DES NUANCES

Grade Identification Calidad Désignation de la nuance	Area of Application Área de aplicación Domaine d'application	Application / Aplicación/ Application	Feed Avance Avance	Cutting speed Velocidad de corte Vitesse de coupe	Resistance to adverse Working Conditions Resistencia a condiciones de trabajo adversas Résistance aux chocs et aux conditions défavorables	Substrate Sustrato Substrat	Coating Recubrimiento Revêtement	Colour / Color Couleur	Coolant benefit / Refrigerante Bénéfice de l'arrosage	Drilling Taladrado Perçage	Boring Mandrinado Alésage
D9335	P20 - P35 M15 - M30 K15 - K35 S10 - S20 H10 - H20	■ ■ ■ ◪ □	▲	▲	▲	FGM	MT-CVD		+ + +		
D8330	P20 - P35 M15 - M30 K15 - K35 N10 - N25 S10 - S20 H10 - H20	■ ■ ■ □ ◪ □	▲	▲	▲	submicron H	PVD		+ + +		
D8345	P25 - P45 M15 - M35 K15 - K35 S15 - S25 H15 - H25	◪ ■ ■ ■ □	▲	▲	▲+	submicron H	PVD		+ + +		

Substrate / Sustrato Substrat			
submicron H	WC-Co based substrate fine grained (< 1 mm)	Sustrato de grano fino de base WC-Co (<1 µm)	Substrat base WC-Co à grains fins (< 1 µm)
FGM	Functionally graded substrate	Sustrato de grado funcional	Substrat gradient fonctionnel
Coating / Recubrimiento Revêtement			
MT-CVD	Medium-temperature chemical method of coating	Método de recubrimiento químico a media temperatura	Revêtement par dépôt chimique en phase vapeur à température moyenne
PVD	Low-temperature physical method of coating	Método de recubrimiento físico a baja temperatura	Revêtement par dépôt physique en phase vapeur à basse température

Table 3
Tabla 3
Tableau 3

RECOMMENDED CUTTING CONDITIONS FOR INDEXABLE DRILLS
CONDICIONES DE CORTE RECOMENDADAS PARA BROCAS CON PLAQUITAS INTERCAMBIABLES
CONDITIONS DE COUPE RECOMMANDÉES POUR LES FORETS À PLAQUETTES INDEXABLES

802D, 803D (XPET..AP, SCET..-UD)

	Dormer AMG *	D9335		D8330		D8345	f ⇨					
			V_c		V_c		Ø .591	Ø .787	Ø .984	Ø 1.181	Ø 1.575	Ø 2.283
P1	1.1, 1.2	■	1099	■	886	■	.003	.003	.004	.004	.005	.006
P2	1.3	■	820	■	656	■	.004	.005	.006	.007	.008	.011
P3	1.4	■	656	■	525	■	.005	.006	.007	.008	.009	.013
P4	1.5	■	492	■	394	■	.005	.006	.006	.007	.009	.012
M1	2.1	□	459	□	426	□	.005	.006	.006	.007	.009	.012
M2	(2.1, 2.4)	□	443	□	410	□	.004	.005	.006	.007	.008	.011
M3	2.2	□	410	□	377	□	.003	.003	.004	.004	.005	.006
M4	2.3, 2.4	□	394	□	361	□	.003	.003	.004	.004	.005	.006
K1	3.1, 3.2	■	623	■	492	◪	.006	.006	.007	.008	.010	.013
K2	3.1, 3.2	■	607	■	476	◪	.006	.006	.007	.008	.010	.013
K3	3.3	■	574	■	443	◪	.006	.006	.007	.008	.010	.013
K4	3.4	■	541	■	426	◪	.006	.006	.007	.008	.010	.013

802D, 803D (XPET..AP-SD, SCET..-SD)

	Dormer AMG *	D9335		D8330		D8345	f ⇨					
			V_c		V_c		Ø .591	Ø .787	Ø .984	Ø 1.181	Ø 1.575	Ø 2.283
P1	1.1, 1.2	■	1099	■	886	■	.003	.004	.004	.004	.006	.007
P2	1.3	■	820	■	656	■	.004	.005	.006	.007	.008	.011
P3	1.4	■	656	■	525	■	.005	.006	.007	.008	.009	.013
P4	1.5	■	–	■	–	■	–	–	–	–	–	–
M1	2.1	■	459	■	426	■	.005	.006	.006	.007	.009	.012
M2	(2.1, 2.4)	■	443	■	410	■	.004	.005	.006	.007	.008	.011
M3	2.2	■	410	■	377	■	.003	.003	.004	.004	.005	.006
M4	2.3, 2.4	■	394	■	361	■	.003	.003	.004	.004	.005	.006
N1	7.1	□	1476	□	1312	□	.005	.006	.007	.008	.009	.013
N2	7.2, 7.3, 7.4	□	968	□	853	□	.005	.006	.007	.008	.009	.013
N3	6.1, 6.2, 6.3	□	886	□	787	□	.005	.006	.007	.008	.009	.013
N4	6.4	□	590	□	525	□	.005	.006	.006	.007	.009	.012
S1	4.1, 4.2, 4.3	◪	213	◪	180	◪	.003	.004	.004	.004	.006	.007
S2	5.1, 5.2, 5.3	◪	148	◪	131	◪	.003	.004	.004	.004	.006	.007
S3	5.1, 5.2, 5.3	◪	115	◪	98	◪	.003	.003	.004	.004	.005	.006
S4	5.1, 5.2, 5.3	◪	98	◪	82	◪	.003	.003	.004	.004	.005	.006

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* Le code de classification des matériaux utilisé par Dormer est ajouté pour permettre une correspondance et peut être utilisé comme un guide.

Table 3
Tabla 3
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RECOMMENDED CUTTING CONDITIONS FOR INDEXABLE DRILLS
CONDICIONES DE CORTE RECOMENDADAS PARA BROCAS CON PLAQUITAS INTERCAMBIABLES
CONDITIONS DE COUPE RECOMMANDÉES POUR LES FORETS À PLAQUETTES INDEXABLES

804D (XPET..AP, SCET..-UD)

	Dormer AMG *	D9335		D8330		D8345	f					
			v_c		v_c		Ø .591	Ø .787	Ø .984	Ø 1.181	Ø 1.575	Ø 2.283
P1	1.1, 1.2	■	1099	■	886	■	.002	.003	.003	.004	.004	.006
P2	1.3	■	820	■	656	■	.004	.005	.006	.006	.007	.010
P3	1.4	■	656	■	525	■	.005	.006	.006	.007	.009	.012
P4	1.5	■	492	■	394	■	.004	.005	.006	.007	.008	.011
M1	2.1	□	459	□	426	□	.004	.005	.006	.007	.008	.011
M2	(2.1, 2.4)	□	443	□	410	□	.004	.005	.006	.006	.007	.010
M3	2.2	□	410	□	377	□	.002	.003	.003	.004	.004	.006
M4	2.3, 2.4	□	394	□	361	□	.002	.003	.003	.004	.004	.006
K1	3.1, 3.2	■	623	■	492	◪	.005	.006	.007	.008	.009	.013
K2	3.1, 3.2	■	607	■	476	◪	.005	.006	.007	.008	.009	.013
K3	3.3	■	574	■	443	◪	.005	.006	.007	.008	.009	.013
K4	3.4	■	541	■	426	◪	.005	.006	.007	.008	.009	.013

804D (XPET..AP-SD, SCET..-SD)

	Dormer AMG *	D9335		D8330		D8345	f					
			v_c		v_c		Ø .591	Ø .787	Ø .984	Ø 1.181	Ø 1.575	Ø 2.283
P1	1.1, 1.2	■	1099	■	886	■	.003	.003	.004	.004	.005	.006
P2	1.3	■	820	■	656	■	.004	.005	.006	.006	.007	.010
P3	1.4	■	656	■	525	■	.005	.006	.006	.007	.009	.012
P4	1.5	■	–	■	–	■	–	–	–	–	–	–
M1	2.1	■	459	■	426	■	.004	.005	.006	.007	.008	.011
M2	(2.1, 2.4)	■	443	■	410	■	.004	.005	.006	.006	.007	.010
M3	2.2	■	410	■	377	■	.002	.003	.003	.004	.004	.006
M4	2.3, 2.4	■	394	■	361	■	.002	.003	.003	.004	.004	.006
N1	7.1	□	1476	□	1312	□	.005	.006	.006	.007	.009	.012
N2	7.2, 7.3, 7.4	□	968	□	853	□	.005	.006	.006	.007	.009	.012
N3	6.1, 6.2, 6.3	□	886	□	787	□	.005	.006	.006	.007	.009	.012
N4	6.4	□	590	□	525	□	.004	.005	.006	.007	.008	.011
S1	4.1, 4.2, 4.3	◪	213	◪	180	◪	.003	.003	.004	.004	.005	.006
S2	5.1, 5.2, 5.3	◪	148	◪	131	◪	.003	.003	.004	.004	.005	.006
S3	5.1, 5.2, 5.3	◪	115	◪	98	◪	.002	.003	.003	.004	.004	.006
S4	5.1, 5.2, 5.3	◪	98	◪	82	◪	.002	.003	.003	.004	.004	.006

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CONDICIONES DE CORTE RECOMENDADAS PARA BROCAS CON PLAQUITAS INTERCAMBIABLES
CONDITIONS DE COUPE RECOMMANDÉES POUR LES FORETS À PLAQUETTES INDEXABLES

805D (XPET..AP, SCET..-UD)

	Dormer AMG *	D9335		D8330		D8345	f					
			V_c		V_c		Ø .591	Ø .787	Ø .984	Ø 1.181	Ø 1.575	Ø 2.283
P1	1.1, 1.2	■	886	■	705	■	.002	.003	.003	.004	.004	.006
P2	1.3	■	656	■	525	■	.004	.005	.006	.006	.007	.010
P3	1.4	■	525	■	426	■	.005	.006	.006	.007	.009	.012
P4	1.5	■	394	■	328	■	.004	.005	.006	.007	.008	.011
M1	2.1	□	361	□	344	□	.004	.005	.006	.007	.008	.011
M2	(2.1, 2.4)	□	361	□	328	□	.004	.005	.006	.006	.007	.010
M3	2.2	□	328	□	312	□	.002	.003	.003	.004	.004	.006
M4	2.3, 2.4	□	312	□	295	□	.002	.003	.003	.004	.004	.006
K1	3.1, 3.2	■	508	■	394	◪	.005	.006	.007	.008	.009	.013
K2	3.1, 3.2	■	476	■	377	◪	.005	.006	.007	.008	.009	.013
K3	3.3	■	459	■	361	◪	.005	.006	.007	.008	.009	.013
K4	3.4	■	426	■	344	◪	.005	.006	.007	.008	.009	.013

805D (XPET..AP-SD, SCET..-SD)

	Dormer AMG *	D9335		D8330		D8345	f					
			V_c		V_c		Ø .591	Ø .787	Ø .984	Ø 1.181	Ø 1.575	Ø 2.283
P1	1.1, 1.2	■	886	■	705	■	.003	.003	.004	.004	.005	.006
P2	1.3	■	656	■	525	■	.004	.005	.006	.006	.007	.010
P3	1.4	■	525	■	426	■	.005	.006	.006	.007	.009	.012
P4	1.5	■	–	■	–	■	–	–	–	–	–	–
M1	2.1	■	361	■	344	■	.004	.005	.006	.007	.008	.011
M2	(2.1, 2.4)	■	361	■	328	■	.004	.005	.006	.006	.007	.010
M3	2.2	■	328	■	312	■	.002	.003	.003	.004	.004	.006
M4	2.3, 2.4	■	312	■	295	■	.002	.003	.003	.004	.004	.006
N1	7.1	□	1181	□	1050	□	.005	.006	.006	.007	.009	.012
N2	7.2, 7.3, 7.4	□	771	□	689	□	.005	.006	.006	.007	.009	.012
N3	6.1, 6.2, 6.3	□	722	□	640	□	.005	.006	.006	.007	.009	.012
N4	6.4	□	476	□	426	□	.004	.005	.006	.007	.008	.011
S1	4.1, 4.2, 4.3	◪	164	◪	148	◪	.003	.003	.004	.004	.005	.006
S2	5.1, 5.2, 5.3	◪	115	◪	98	◪	.003	.003	.004	.004	.005	.006
S3	5.1, 5.2, 5.3	◪	98	◪	82	◪	.002	.003	.003	.004	.004	.006
S4	5.1, 5.2, 5.3	◪	82	◪	66	◪	.002	.003	.003	.004	.004	.006

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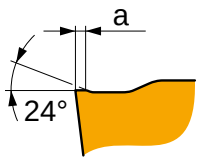
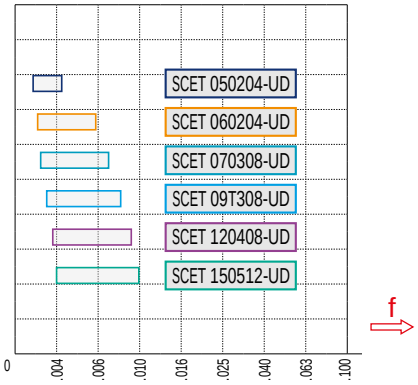
Table 4
Tabla 4
Tableau 4

GEOMETRY OF CUTTING INSERTS
GEOMETRÍA DE PLAQUITAS DE CORTE
GÉOMÉTRIE DES PLAQUETTES

SCET . . . . . – UD



	a (in)
SCET 050204-UD	.005
SCET 060204-UD	.006
SCET 070308-UD	.006
SCET 09T308-UD	.006
SCET 120408-UD	.008
SCET 150512-UD	.008

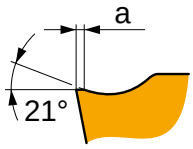


P	M	K	N	S	H
■	□	■			

f ⇨ See diagram / Consultar diagrama / Voir diagramme

? SCET . . . . . – UD

XPET . . . . AP



	a (in)
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XPET 0602AP	.004
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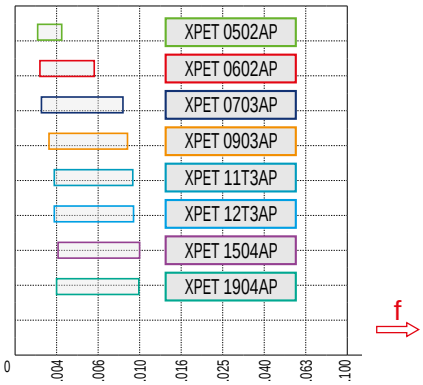
XPET 12T3AP	.010
XPET 1504AP	.010
XPET 1904AP	.010



P	M	K	N	S	H
■	□	◪			

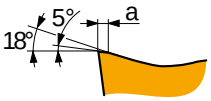
f ⇨ See diagram / Consultar diagrama / Voir diagramme

? XPET . . . . AP

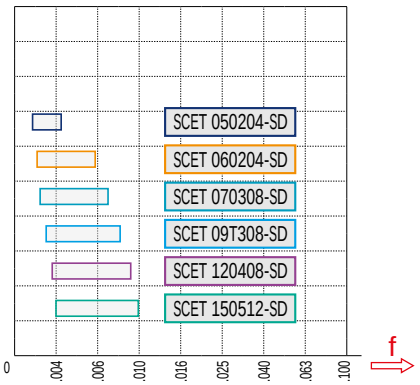
Table 4
Tabla 4
Tableau 4

GEOMETRY OF CUTTING INSERTS
GEOMETRÍA DE PLAQUITAS DE CORTE
GÉOMÉTRIE DES PLAQUETTES

SCET . . . . . – SD

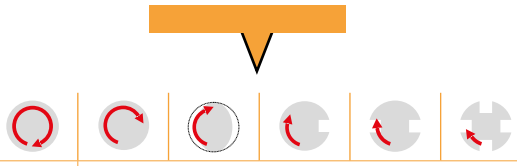


	a(in)
SCET 050204-SD	.002
SCET 060204-SD	.002
SCET 070308-SD	.003
SCET 09T308-SD	.004
SCET 120408-SD	.004
SCET 150512-SD	.004



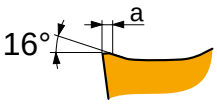
P	M	K	N	S	H
■	■		□	◪	

f ⇨ See diagram / Consultar diagrama / Voir diagramme

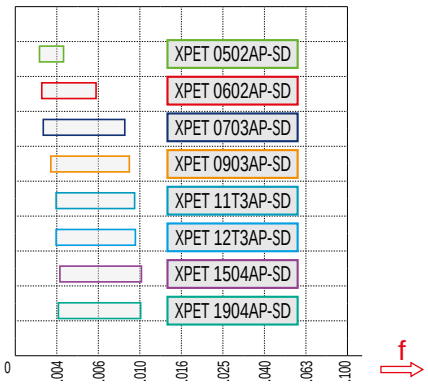


? SCET . . . . . – SD

XPET . . . .AP- SD

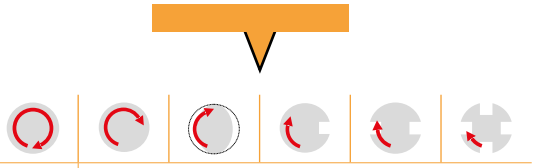


	a(in)
XPET 0502AP-SD	.002
XPET 0602AP-SD	.002
XPET 0703AP-SD	.003
XPET 0903AP-SD	.004
XPET 11T3AP-SD	.004
XPET 12T3AP-SD	.004
XPET 1504AP-SD	.004
XPET 1904AP-SD	.005



P	M	K	N	S	H
■	■		□	◪	

f ⇨ See diagram / Consultar diagrama / Voir diagramme



? XPET . . . . AP – SD

Table 5
Tabla 5
Tableau 5

FORMULAE FOR CALCULATION OF CUTTING PARAMETERS
FÓRMULAS DE CÁLCULO DE LOS PARÁMETROS DE CORTE
FORMULES DE CALCUL DES PARAMÈTRES DE COUPE

NOMENCLATURE AND FORMULA / NOMENCLATURA Y FÓRMULAS
NOMENCLATURES ET FORMULES

Parameter / Parámetro Paramètre	Formula / Fórmula Formule	Unit / Unidad Unité
RPM Velocidad del husillo Vitesse de rotaton	$n = \frac{v_c \cdot 12}{D \cdot \pi}$	[1.min^{-1}]
Cu t ng speed Velocidad de corte Vitesse de coupe	$v_c = \frac{\pi \cdot D \cdot n}{12}$	[ft.min^{-1}]
Feed per minute (speed of feed) Velocida de avance Avance de table	$v_f = n \cdot f$	[in.min^{-1}]
Cross sect on area of the hole Área de sección transversal del orif cio Sect on transversale du trou	$A = \frac{\pi \cdot D^2}{4}$	[in^2]
Metal removal rate Volumen de viruta Taux d'enlèvement de métal	$Q = f_{min} \cdot A$	[in^3.min^{-1}]
Machining t me Tiempo de mecanizado Durée d'usinage	$T_c = \frac{L + h}{f_{min}}$	[min/pcs] [min/pieza] [min/pièce]

D	Diameter of drill	[in]	D	Diámetro de la broca	[in]
f	Feed per revolution	[in/rev]	f	Avance por revolución	[in/rev]
h	Distance from drill point to workpiece before feeding	[in]	h	Distancia desde el punto de taladrado hasta la pieza que se trabaja antes de avanzar	[in]
L	Depth of hole	[in]	L	Profundidad del orificio	[in]

D	Diamètre du foret	[in]
f	Avance par rotation	[tr/min]
h	Distance entre la pointe du foret et la pièce à usiner avant l'avance	[in]
L	Profondeur du trou	[in]

Table 6
Tabla 6
Tableau 6

RECOMMENDED TIGHTENING TORQUES FOR SCREWS
PARES DE APRIETE RECOMENDADOS PARA LOS TORNILLOS
COUPLES DE SERRAGE RECOMMANDÉS POUR LES VIS

						
US 2245-T07P	0.9	FLAG T07P	M 2.2	5.3	D-T7P	MR-0.8-2.0 vario
US 2205-T07P	0.9	FLAG T07P	M2.2	5.4	D-T7P	MR-0.8-2.0 vario
US 2506-T07P	1.2	FLAG T07P	M 2.5	6	D-T7P	MR-0.8-2.0 vario
US 2507-T08P	1.2	FLAG T08P	M 2.5	7	D-T8P	MR-0.8-2.0 vario
US 3007-T08P	2.0	FLAG T08P	M 3	7	D-T8P	MR-1.0-5.0 vario
US 3007-T09P	2.0	FLAG T09P	M 3	7.4	D-T9P	MR-1.0-5.0 vario
US 3009-T09P	2.0	FLAG T09P	M 3	8.7	D-T9P	MR-1.0-5.0 vario
US 3508-T15P	3.0	FLAG T15P	M 3.5	8.3	D-T15P	MR-1.0-5.0 vario
US 3510-T15P	3.0	FLAG T15P	M 3.5	10.6	D-T15P	MR-1.0-5.0 vario
US 4011-T15P	3.5	FLAG T15P	M 4	10.7	D-T15P	MR-1.0-5.0 vario
US 5012-T15P	5.0	FLAG T15P	M 5	12.2	D-T15P	MR-1.0-5.0 vario