

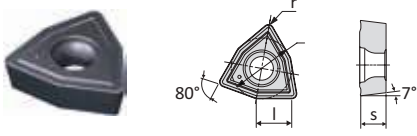
WCMX-U DRILL

Economy Replaceable Insert Indexable Drilling System

CUTTING DATA

DRILLING

Workpiece			Feed (mm/rev.)			Vc (m/min.)		
ISO	Material	Hardness (HB)	Min.	Max.	Recommended	Min.	Max.	Recommended
WCMX 03								
P STEEL	Non Alloy Steel	120	0.05	0.1	0.08	180	270	225
	Low Alloy Steel	200	0.05	0.1	0.08	120	230	175
	High Alloy Steel	220	0.07	0.1	0.09	70	170	120
M STAINLESS STEEL	Austenitic	190	0.05	0.1	0.08	170	230	200
K CAST IRON	Grey Cast Iron	140	0.1	0.11	0.11	150	230	190
WCMX 04								
P STEEL	Non Alloy Steel	120	0.05	0.1	0.08	180	270	225
	Low Alloy Steel	200	0.05	0.1	0.08	120	230	175
	High Alloy Steel	220	0.07	0.1	0.09	70	170	120
M STAINLESS STEEL	Austenitic	190	0.05	0.1	0.08	170	230	200
K CAST IRON	Grey Cast Iron	140	0.1	0.11	0.11	150	230	190
WCMX 05								
P STEEL	Non Alloy Steel	120	0.06	0.11	0.09	180	270	225
	Low Alloy Steel	200	0.06	0.11	0.09	120	230	175
	High Alloy Steel	220	0.09	0.11	0.1	70	170	120
M STAINLESS STEEL	Austenitic	190	0.06	0.11	0.09	170	230	200
K CAST IRON	Grey Cast Iron	140	0.13	0.12	0.13	150	230	190
WCMX 06								
P STEEL	Non Alloy Steel	120	0.06	0.12	0.07	180	270	230
	Low Alloy Steel	200	0.06	0.12	0.06	120	230	180
	High Alloy Steel	220	0.08	0.12	0.1	70	170	120
M STAINLESS STEEL	Austenitic	190	0.06	0.12	0.09	170	230	200
K CAST IRON	Grey Cast Iron	140	0.12	0.13	0.13	150	230	190
WCMX 08								
P STEEL	Non Alloy Steel	120	0.06	0.16	0.11	180	270	225
	Low Alloy Steel	200	0.06	0.16	0.11	120	230	175
	High Alloy Steel	220	0.09	0.16	0.13	70	170	120
M STAINLESS STEEL	Austenitic	190	0.06	0.15	0.11	170	230	200
K CAST IRON	Grey Cast Iron	140	0.1	0.18	0.14	150	230	190

INSERT	Dimensions				For Drill Diameter	ORDER CODE	PRICE
	l	d	s	r			
	3.00	5.56	2.38	0.5	16-19.5	WCMX030208	
	3.33	6.35	2.38	0.8	20-23.5	WCMX040208	
	3.39	7.94	3.18	0.8	24-29.5	WCMX050308	
	4.48	9.53	3.97	1.8	30-44	WCMX06T308	
	7.26	12.7	4.76	1.2	45-60	WCMX080412	