

DRILLING

- Drilling Overview
- Drill Holder
- Drilling Inserts (SPMX)
- Drilling Inserts (WCMX)

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	

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

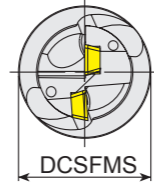
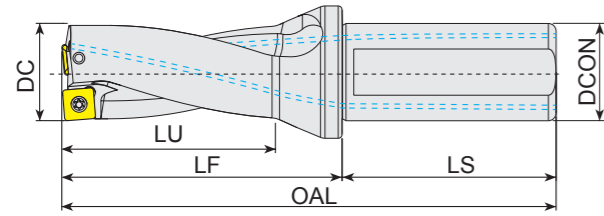
Universal Drilling Inserts

	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

Drilling - Drill Holder
SPMX 050204 Drill (DC 13~15)



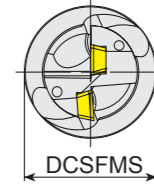
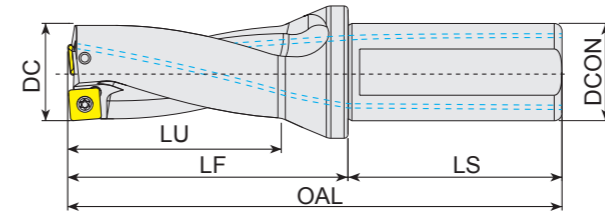
Screw	Wrench
T062043	TWFT06

☐: p.161 Unit:mm

Series	DC	LU	Designation	EDP 3700..	LF	OAL	DCON	DCSFMS	LS
SPMX 050204	13	26	YGSP2-13S20F026-05	0001	44	94	20	25	50
		39	YGSP3-13S20F039-05	0004	57	107			
		65	YGSP5-13S20F065-05	0007	83	133			
	14	28	YGSP2-14S20F028-05	0002	46	96			
		42	YGSP3-14S20F042-05	0005	60	110			
		70	YGSP5-14S20F070-05	0008	88	138			
	15	30	YGSP2-15S20F030-05	0003	48	98			
		45	YGSP3-15S20F045-05	0006	63	113			
		75	YGSP5-15S20F075-05	0009	93	143			

* Call for us DC size increments of 0.5

Drilling - Drill Holder
SPMX 060204 Drill (DC 16~21)



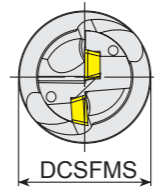
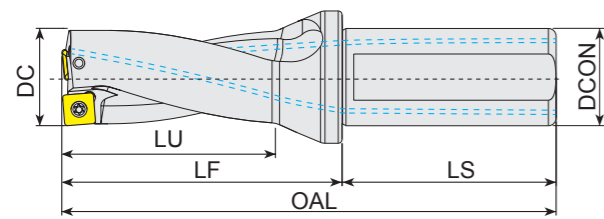
Screw	Wrench
T072252	TWFT07

☐: p.161 Unit:mm

Series	DC	LU	Designation	EDP 3700..	LF	OAL	DCON	DCSFMS	LS
SPMX 060204	16	32	YGSP2-16S25F032-06	0010	53	109	25	32	56
		48	YGSP3-16S25F048-06	0016	69	125			
		80	YGSP5-16S25F080-06	0022	101	157			
	17	34	YGSP2-17S25F034-06	0011	55	111			
		51	YGSP3-17S25F051-06	0017	72	128			
		85	YGSP5-17S25F085-06	0023	106	162			
	18	36	YGSP2-18S25F036-06	0012	57	113			
		54	YGSP3-18S25F054-06	0018	75	131			
		90	YGSP5-18S25F090-06	0024	111	167			
	19	38	YGSP2-19S25F038-06	0013	59	115			
		57	YGSP3-19S25F057-06	0019	78	134			
		95	YGSP5-19S25F095-06	0025	116	172			
	20	40	YGSP2-20S25F040-06	0014	62	118			
		60	YGSP3-20S25F060-06	0020	82	138			
		100	YGSP5-20S25F100-06	0026	122	178			
	21	42	YGSP2-21S25F042-06	0015	64	120			
		63	YGSP3-21S25F063-06	0021	85	141			
		105	YGSP5-21S25F105-06	0027	127	183			

* Call for us DC size increments of 0.5

Drilling - Drill Holder
SPMX 07T308 Drill (DC 22~27)



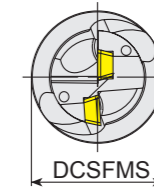
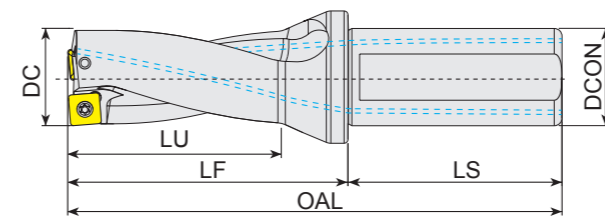
Screw	Wrench
T082564	TWFT08

☐: p.161 Unit:mm

Series	DC	LU	Designation	EDP 3700..	LF	OAL	DCON	DCSFMS	LS
SPMX 07T308	22	44	YGSP2-22S32F044-07	0028	74	134	32	45	60
		66	YGSP3-22S32F066-07	0034	96	156			
		110	YGSP5-22S32F110-07	0040	140	200			
	23	46	YGSP2-23S32F046-07	0029	76	136			
		69	YGSP3-23S32F069-07	0035	99	159			
	24	115	YGSP5-23S32F115-07	0041	145	205			
		48	YGSP2-24S32F048-07	0030	78	138			
	25	72	YGSP3-24S32F072-07	0036	102	162			
		120	YGSP5-24S32F120-07	0042	150	210			
		50	YGSP2-25S32F050-07	0031	80	140			
	26	75	YGSP3-25S32F075-07	0037	105	165			
		125	YGSP5-25S32F125-07	0043	155	215			
		52	YGSP2-26S32F052-07	0032	82	142			
	27	78	YGSP3-26S32F078-07	0038	108	168			
		130	YGSP5-26S32F130-07	0044	160	220			
		54	YGSP2-27S32F054-07	0033	84	144			
		81	YGSP3-27S32F081-07	0039	111	171			
		135	YGSP5-27S32F135-07	0045	165	225			

* Call for us DC size increments of 0.5

Drilling - Drill Holder
SPMX 090408 Drill (DC 28~33)



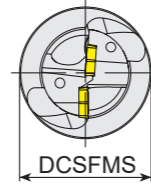
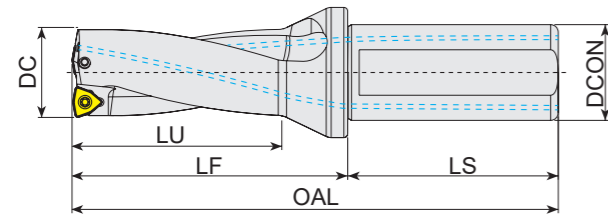
Screw	Wrench
T103588	TWFT10

☐: p.161 Unit:mm

Series	DC	LU	Designation	EDP 3700..	LF	OAL	DCON	DCSFMS	LS
SPMX 090408	28	56	YGSP2-28S32F056-09	0046	86	146	32	45	60
		84	YGSP3-28S32F084-09	0052	114	174			
		140	YGSP5-28S32F140-09	0058	170	230			
	29	58	YGSP2-29S32F058-09	0047	88	148			
		87	YGSP3-29S32F087-09	0053	117	177			
	30	145	YGSP5-29S32F145-09	0059	175	235			
		60	YGSP2-30S32F060-09	0048	91	151			
	31	90	YGSP3-30S32F090-09	0054	121	181			
		150	YGSP5-30S32F150-09	0060	181	241			
		62	YGSP2-31S32F062-09	0049	93	153			
	32	93	YGSP3-31S32F093-09	0055	124	184			
		155	YGSP5-31S32F155-09	0061	186	246			
		64	YGSP2-32S32F064-09	0050	95	155			
	33	96	YGSP3-32S32F096-09	0056	127	187			
		160	YGSP5-32S32F160-09	0062	191	251			
		66	YGSP2-33S32F066-09	0051	97	157			
		99	YGSP3-33S32F099-09	0057	130	190			
		165	YGSP5-33S32F165-09	0063	196	256			

* Call for us DC size increments of 0.5

WCMX 030208 Drill (DC 16~19.5)

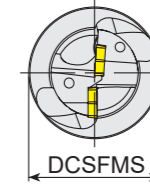
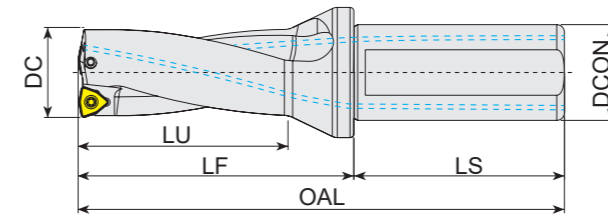


Screw	Wrench
Y3008-M2.5x6	Y80-T08

⚠: p. 162 Unit:mm

Series	DC	LU	Designation	EDP 3700..	LF	OAL	DCON	DCSFMS	LS
WCMX 030208	16	32	YGWC2-16S25F032-03	0253	54	110	25	34	56
		48	YGWC3-16S25F048-03	0296	70	126			
		64	YGWC4-16S25F064-03	0339	86	142			
	16.5	32	YGWC2-16.5S25F032-03	0780	54	110			
		48	YGWC3-16.5S25F048-03	0781	70	126			
		64	YGWC4-16.5S25F064-03	0782	86	142			
	17	34	YGWC2-17S25F034-03	0254	56	112			
		51	YGWC3-17S25F051-03	0297	73	129			
		68	YGWC4-17S25F068-03	0340	90	146			
	17.5	34	YGWC2-17.5S25F034-03	0783	56	112			
		51	YGWC3-17.5S25F051-03	0784	73	129			
		68	YGWC4-17.5S25F068-03	0785	90	146			
	18	36	YGWC2-18S25F036-03	0255	58	114			
		54	YGWC3-18S25F054-03	0298	76	132			
		72	YGWC4-18S25F072-03	0341	94	150			
	18.5	36	YGWC2-18.5S25F036-03	0786	58	114			
		54	YGWC3-18.5S25F054-03	0787	76	132			
		72	YGWC4-18.5S25F072-03	0788	94	150			
	19	38	YGWC2-19S25F038-03	0256	60	116			
		57	YGWC3-19S25F057-03	0299	79	135			
		76	YGWC4-19S25F076-03	0342	98	154			
	19.5	38	YGWC2-19.5S25F038-03	0789	60	116			
		57	YGWC3-19.5S25F057-03	0790	79	135			
			76	YGWC4-19.5S25F076-03	0791	98			

WCMX 040208 Drill (DC 20~23.5)

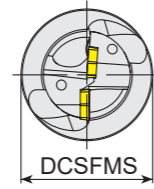
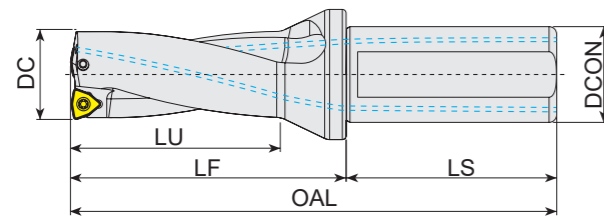


Screw	Wrench
Y3008-M2.5x6	Y80-T08

⚠: p. 162 Unit:mm

Series	DC	LU	Designation	EDP 3700..	LF	OAL	DCON	DCSFMS	LS
WCMX 040208	20	40	YGWC2-20S25F040-04	0257	62	118	25	34	56
		60	YGWC3-20S25F060-04	0300	82	138			
		80	YGWC4-20S25F080-04	0343	102	158			
	20.5	40	YGWC2-20.5S25F040-04	0726	62	118			
		60	YGWC3-20.5S25F060-04	0727	82	138			
		80	YGWC4-20.5S25F080-04	0728	102	158			
	21	42	YGWC2-21S25F042-04	0258	64	120			
		63	YGWC3-21S25F063-04	0301	85	141			
		84	YGWC4-21S25F084-04	0344	106	162			
	21.5	42	YGWC2-21.5S25F042-04	0728	64	120			
		63	YGWC3-21.5S25F063-04	0729	85	141			
		84	YGWC4-21.5S25F084-04	0729	106	162			
	22	44	YGWC2-22S25F044-04	0259	66	122			
		66	YGWC3-22S25F066-04	0302	88	144			
		88	YGWC4-22S25F088-04	0345	110	166			
	22.5	44	YGWC2-22.5S25F044-04	0730	66	122			
		66	YGWC3-22.5S25F066-04	0731	88	144			
		88	YGWC4-22.5S25F088-04	0732	110	166			
	23	46	YGWC2-23S25F046-04	0260	68	124			
		69	YGWC3-23S25F069-04	0303	91	147			
		92	YGWC4-23S25F092-04	0346	114	170			
	23.5	46	YGWC2-23.5S25F046-04	0733	68	124			
		69	YGWC3-23.5S25F069-04	0734	91	147			

WCMX 050308 Drill (DC 24~29.5)

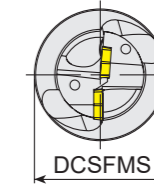
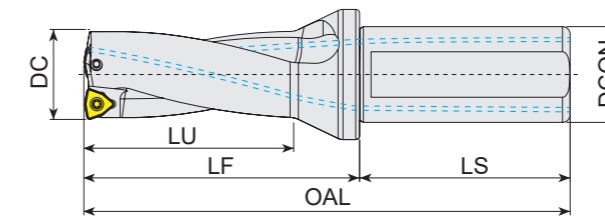


Screw	Wrench
Y3008-M3x8	Y80-T08

⚠: p. 162 Unit:mm

Series	DC	LU	Designation	EDP 3700..	LF	OAL	DCON	DCSFMS	LS
WCMX 050308	24	48	YGWC2 - 24S25F048 - 05	0261	70	126	25	34	56
		72	YGWC3 - 24S25F072 - 05	0304	94	150			
		96	YGWC4 - 24S25F096 - 05	0347	118	174			
	24.5	48	YGWC2 - 24.5S25F048 - 05	0735	70	126			
		72	YGWC3 - 24.5S25F072 - 05	0736	94	150			
	25	50	YGWC2 - 25S25F050 - 05	0262	72	128			
		75	YGWC3 - 25S25F075 - 05	0305	97	153			
		100	YGWC4 - 25S25F100 - 05	0251	122	178			
	25.5	50	YGWC2 - 25.5S25F050 - 05	0737	72	128			
		75	YGWC3 - 25.5S25F075 - 05	0738	97	153			
	26	52	YGWC2 - 26S25F052 - 05	0263	74	130			
		78	YGWC3 - 26S25F078 - 05	0306	100	156			
		104	YGWC4 - 26S25F104 - 05	0349	126	182			
	26.5	52	YGWC2 - 26.5S25F052 - 05	0739	74	130			
		78	YGWC3 - 26.5S25F078 - 05	0741	100	156			
	27	104	YGWC4 - 26.5S25F104 - 05	0742	126	182			
		54	YGWC2 - 27S25F054 - 05	0264	76	132			
		81	YGWC3 - 27S25F081 - 05	0307	103	159			
	27.5	108	YGWC4 - 27S25F108 - 05	0350	130	186			
		54	YGWC2 - 27.5S25F054 - 05	0743	76	132			
	28	81	YGWC3 - 27.5S25F081 - 05	0744	103	159			
		56	YGWC2 - 28S25F056 - 05	0265	78	134			
		84	YGWC3 - 28S25F084 - 05	0308	106	162			
	28.5	112	YGWC4 - 28S25F112 - 05	0351	134	190			
		56	YGWC2 - 28.5S25F056 - 05	0745	78	134			
	29	84	YGWC3 - 28.5S25F084 - 05	0746	106	162			
		112	YGWC4 - 28.5S25F112 - 05	0747	134	190			
		58	YGWC2 - 29S25F058 - 05	0266	80	136			
29.5	87	YGWC3 - 29S25F087 - 05	0309	109	165				
	116	YGWC4 - 29S25F116 - 05	0352	138	194				
	58	YGWC2 - 29.5S25F058 - 05	0748	80	136				
	87	YGWC3 - 29.5S25F087 - 05	0749	109	165				

WCMX 06T308 Drill (DC 30~44.5)



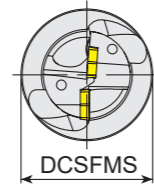
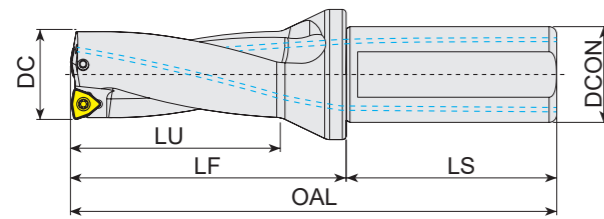
Screw	Wrench
Y3010-M3.5x9	Y80-T10

⚠: p. 162 Unit:mm

Series	DC	LU	Designation	EDP 3700..	LF	OAL	DCON	DCSFMS	LS
WCMX 06T308	30	60	YGWC2 - 30S32F060 - 06	0267	87	147	32	44	60
		90	YGWC3 - 30S32F090 - 06	0310	117	177			
		120	YGWC4 - 30S32F120 - 06	0353	147	207			
	30.5	90	YGWC3 - 30.5S32F090 - 06	0750	117	177			
		62	YGWC2 - 31S32F062 - 06	0268	89	149			
	31	93	YGWC3 - 31S32F093 - 06	0311	120	180			
		124	YGWC4 - 31S32F124 - 06	0354	151	211			
	31.5	93	YGWC3 - 31.5S32F093 - 06	0751	120	180			
		64	YGWC2 - 32S32F064 - 06	0269	91	151			
	32	96	YGWC3 - 32S32F096 - 06	0312	123	183			
		128	YGWC4 - 32S32F128 - 06	0252	155	215			
	32.5	96	YGWC3 - 32.5S32F096 - 06	0752	123	183			
		66	YGWC2 - 33S32F066 - 06	0753	93	153			
	33	99	YGWC3 - 33S32F099 - 06	0754	126	186			
		132	YGWC4 - 33S32F132 - 06	0755	159	219			
		99	YGWC3 - 33.5S32F099 - 06	0756	126	186			
	33.5	132	YGWC4 - 33.5S32F132 - 06	0757	159	219			
		68	YGWC2 - 34S32F068 - 06	0271	95	155			
	34	102	YGWC3 - 34S32F102 - 06	0314	129	189			
		136	YGWC4 - 34S32F136 - 06	0357	163	223			
	34.5	102	YGWC3 - 34.5S32F102 - 06	0758	129	189			
		70	YGWC2 - 35S32F070 - 06	0272	97	157			
	35	105	YGWC3 - 35S32F105 - 06	0315	132	192			
		140	YGWC4 - 35S32F140 - 06	0358	167	227			
	35.5	105	YGWC3 - 35.5S32F105 - 06	0759	132	192			
		72	YGWC2 - 36S32F072 - 06	0273	99	159			
	36	108	YGWC3 - 36S32F108 - 06	0316	135	195			
		144	YGWC4 - 36S32F144 - 06	0359	171	231			
	36.5	108	YGWC3 - 36.5S32F108 - 06	0760	135	195			
		74	YGWC2 - 37S32F074 - 06	0274	101	161			
37	111	YGWC3 - 37S32F111 - 06	0317	138	198				
	148	YGWC4 - 37S32F148 - 06	0360	175	235				

▶ NEXT PAGE

Drilling - Drill Holder
WCMX 06T308 Drill (DC 30~44.5)

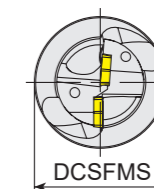
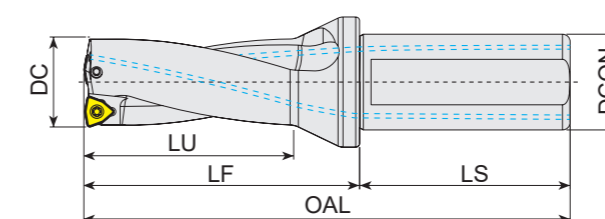


Screw	Wrench
Y3010-M3.5x9	Y80-T10

⚠: p. 162 Unit:mm

Series	DC	LU	Designation	EDP 3700..	LF	OAL	DCON	DCSFMS	LS
WCMX 06T308	37.5	111	YGWC3 - 37.5S32F111 - 06	0761	138	198	32	44	60
		76	YGWC2 - 38S32F076 - 06	0275	103	163			
	38	114	YGWC3 - 38S32F114 - 06	0318	141	201			
		152	YGWC4 - 38S32F152 - 06	0361	179	239			
	38.5	114	YGWC3 - 38.5S32F114 - 06	0762	141	201			
		152	YGWC4 - 38.5S32F152 - 06	0763	179	239			
	39	78	YGWC2 - 39S32F078 - 06	0276	105	165			
		117	YGWC3 - 39S32F117 - 06	0319	144	204			
	39.5	156	YGWC4 - 39S32F156 - 06	0362	183	243			
		117	YGWC3 - 39.5S32F117 - 06	0764	144	204			
	40	80	YGWC2 - 40S32F080 - 06	0277	107	167			
		120	YGWC3 - 40S32F120 - 06	0320	147	207			
	40.5	160	YGWC4 - 40S32F160 - 06	0363	187	247			
		120	YGWC3 - 40.5S32F120 - 06	0765	147	207			
	41	82	YGWC2 - 41S32F082 - 06	0278	109	169			
		123	YGWC3 - 41S32F123 - 06	0321	150	210			
	41.5	164	YGWC4 - 41S32F164 - 06	0364	191	251			
		123	YGWC3 - 41.5S32F123 - 06	0766	150	210			
	42	84	YGWC2 - 42S32F084 - 06	0279	111	171			
		126	YGWC3 - 42S32F126 - 06	0322	153	213			
	42.5	168	YGWC4 - 42S32F168 - 06	0365	195	255			
		126	YGWC3 - 42.5S32F126 - 06	0767	153	213			
	43	86	YGWC2 - 43S32F086 - 06	0280	113	173			
		129	YGWC3 - 43S32F129 - 06	0323	156	216			
	43.5	172	YGWC4 - 43S32F172 - 06	0366	199	259			
		129	YGWC3 - 43.5S32F129 - 06	0768	156	216			
	44	88	YGWC2 - 44S32F088 - 06	0281	115	175			
		132	YGWC3 - 44S32F132 - 06	0324	159	219			
44.5	176	YGWC4 - 44S32F176 - 06	0367	203	263				
	132	YGWC3 - 44.5S32F132 - 06	0769	159	219				

Drilling - Drill Holder
WCMX 080412 Drill (DC 45~60)



Screw	Wrench
Y4015-M4x11	Y80-T15

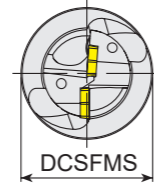
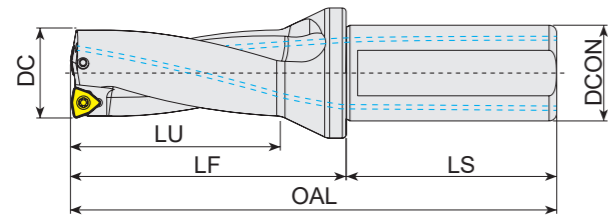
⚠: p. 162 Unit:mm

Series	DC	LU	Designation	EDP 3700..	LF	OAL	DCON	DCSFMS	LS
WCMX 080412	45	90	YGWC2 - 45S40F090 - 08	0282	122	192	40	54	70
		135	YGWC3 - 45S40F135 - 08	0325	167	237			
	45.5	180	YGWC4 - 45S40F180 - 08	0368	212	282			
		135	YGWC3 - 45.5S40F135 - 08	0770	167	237			
	46	92	YGWC2 - 46S40F092 - 08	0283	124	194			
		138	YGWC3 - 46S40F138 - 08	0326	170	240			
	47	184	YGWC4 - 46S40F184 - 08	0369	216	286			
		94	YGWC2 - 47S40F094 - 08	0284	126	196			
	48	141	YGWC3 - 47S40F141 - 08	0327	173	243			
		188	YGWC4 - 47S40F188 - 08	0370	220	290			
	49	96	YGWC2 - 48S40F096 - 08	0285	128	198			
		144	YGWC3 - 48S40F144 - 08	0328	176	246			
	50	192	YGWC4 - 48S40F192 - 08	0371	224	294			
		98	YGWC2 - 49S40F098 - 08	0286	130	200			
	51	147	YGWC3 - 49S40F147 - 08	0329	179	249			
		196	YGWC4 - 49S40F196 - 08	0372	228	298			
	50	100	YGWC2 - 50S40F100 - 08	0287	132	202			
		150	YGWC3 - 50S40F150 - 08	0330	182	252			
	51	200	YGWC4 - 50S40F200 - 08	0373	232	302			
		102	YGWC2 - 51S40F102 - 08	0288	134	204			

▶ NEXT PAGE

Drilling - Drill Holder

WCMX 080412 Drill (DC 45~60)



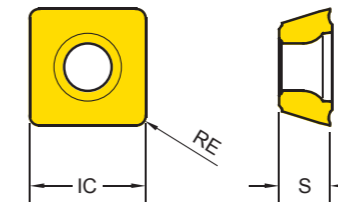
Screw	Wrench
Y4015-M4x11	Y80-T15

⚠: p. 162 Unit: mm

Series	DC	LU	Designation	EDP 3700..	LF	OAL	DCON	DCSFMS	LS
WCMX 080412	51	153	YGWC3 - 51S40F153 - 08	0331	185	255	40	54	70
	52	104	YGWC2 - 52S40F104 - 08	0289	136	206			
		156	YGWC3 - 52S40F156 - 08	0332	188	258			
	53	106	YGWC2 - 53S40F106 - 08	0290	138	208			
		159	YGWC3 - 53S40F159 - 08	0333	191	261			
	54	108	YGWC2 - 54S40F108 - 08	0291	140	210			
		162	YGWC3 - 54S40F162 - 08	0334	194	264			
	55	110	YGWC2 - 55S40F110 - 08	0292	142	212			
		165	YGWC3 - 55S40F165 - 08	0335	197	267			
	56	112	YGWC2 - 56S40F112 - 08	0293	144	214			
		168	YGWC3 - 56S40F168 - 08	0336	200	270			
	57	114	YGWC2 - 57S40F114 - 08	0294	146	216			
		171	YGWC3 - 57S40F171 - 08	0337	203	273			
	58	116	YGWC2 - 58S40F116 - 08	0295	148	218			
		174	YGWC3 - 58S40F174 - 08	0338	206	276			
	59	118	YGWC2 - 59S40F118 - 08	0771	150	220			
		177	YGWC3 - 59S40F177 - 08	0772	209	279			
	60	120	YGWC2 - 60S40F120 - 08	0773	152	222			
		180	YGWC3 - 60S40F180 - 08	0774	212	282			

Drilling - Inserts

Drilling Inserts (SPMX)



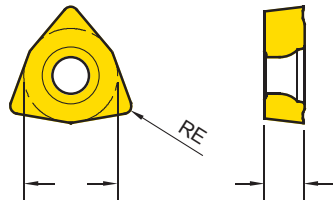
Series	Metric	
	IC	S
SPMX 0502	5.00	2.38
SPMX 0602	6.00	2.41
SPMX 07T3	7.94	3.97
SPMX 0904	9.80	4.30
SPMX 1104	11.50	4.80
SPMX 1405	14.30	5.20

SPMX		Designation	Fn (mm/rev.)	EDP 3200..	
				YG602	YG713
SPMX General		SPMX 050204	0.07~0.14	● 0005	● 0062
		SPMX 060204	0.08~0.14	● 0006	● 0063
		SPMX 07T308	0.08~0.16	● 0007	● 0064
		SPMX 090408	0.08~0.16	● 0008	● 0065
		SPMX 110408	0.10~0.18	● 0009	● 0066
		SPMX 140512	0.10~0.20	● 0010	● 0067
-ST Stainless Steel		SPMX 050204 - ST	0.03~0.10	● 0011	
		SPMX 060204 - ST	0.04~0.11	● 0012	
		SPMX 07T308 - ST	0.04~0.11	● 0013	
		SPMX 090408 - ST	0.05~0.12	● 0014	

Cutting Speed			Vc (m/min.)			
ISO	VDI	Sub Group	YG602		YG713	
			Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	140	380	150	280
	6~9	Low-Alloyed Steel	120	300	130	235
	10~11	High-Alloyed Steel	70	150	90	130
M	12~13	Ferritic & Martensitic	120	200	-	-
	14	Austenitic Stainless Steel	130	250	-	-
K	15~16	Grey Cast Iron	120	250	-	-
	17~18	Nodular Cast Iron	130	220	-	-
H	38~41	Hard materials			50	100

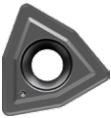
Drilling - Inserts

Drilling Inserts (WCMX)



Series	Metric	
	IC	S
WCMX 0302	5.56	2.38
WCMX 0402	6.35	2.38
WCMX 0503	7.94	3.18
WCMX 06T3	9.53	3.97
WCMX 0804	12.70	4.76

EDP 3200..

WCMX	Designation	Fn (mm/rev.)	YG602
WCMX General 	WCMX 030208	0.05 ~ 0.12	● 0031
	WCMX 040208	0.05 ~ 0.12	● 0003
	WCMX 050308	0.06 ~ 0.14	● 0001
	WCMX 06T308	0.08 ~ 0.14	● 0002
	WCMX 080412	0.08 ~ 0.14	● 0004

Cutting Speed			Vc (m/min.)	
ISO	VDI	Sub Group	YG602	
			Min	Max
P	1~5	Non-Alloyed Steel	140	380
	6~9	Low-Alloyed Steel	120	300
	10~11	High-Alloyed Steel	70	150
M	12~13	Ferritic & Martensitic	120	200
	14	Austenitic Stainless Steel	130	250
K	15~16	Grey Cast Iron	120	250
	17~18	Nodular Cast Iron	130	220