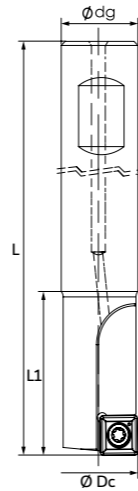


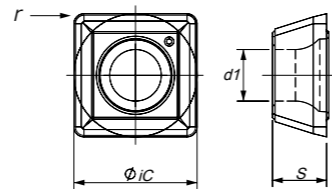
# SPOT FACE



Order code Código	Reference Referência Referencia	⌀	Dimensions   Dimensões   Dimensiones (mm)				Kg	Insert Pastilha Inserto	Stock
			ØDc	Ødg	L	L1			
181150100	SP91 D10-W10/100-01-05	1	10	10	100	30	0,048	SPKX 05T104	⊗
181150200	SP91 D11-W12/100-01-05	1	11	12	100	30	0,070	SPKX 05T104	⊗
181150300	SP91 D13-W16/100-01-06	1	13	16	100	30	0,116	SPKX 060204	⊗
181150400	SP91 D14-W16/120-01-06	1	14	16	120	30	0,123	SPKX 060204	⊗
181150500	SP91 D17-W20/120-01-07	1	17	20	120	35	0,224	SPKX 070308	⊗
181150600	SP91 D18-W20/140-01-07	1	18	20	140	35	0,272	SPKX 070308	⊗
181150700	SP91 D20-W20/140-01-09	1	20	20	140	40	0,303	SPKX 090308	⊗
181150800	SP91 D21-W25/150-01-09	1	21	25	150	40	0,449	SPKX 090308	⊗
181150900	SP91 D25-W25/150-01-11	1	25	25	150	40	0,473	SPKX 110408	⊗

⊗ Stock item | Produto de stock | Itens de stock      ○ Available under request (see page A-6) | Disponível sobre consulta (consulte a página A-6) | Disponible bajo consulta (mire página A-6)

## SPKX | Inserts | Pastilhas | Plaquitas



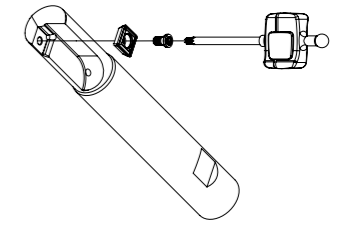
(1) Geometry code	(2) Grade code	P		M				K				N		S				H		Dimensions Dimensões Dimensiones (mm)									
		PVD								PVD				CVD		UNC		DP		PVD				PVD		IC	S	d1	r
		64	54	68	66	J3	I5	78	68	66	J3	78	54	68	66	J3	10	D6	54	68	66	64	D4						
1111635	SPKX 05T104			⊗				⊗					⊗											5,00	1,98	2,20	0,40		
1111282	SPKX 060204			⊗	⊗	⊗		⊗	⊗	⊗			⊗	⊗	⊗									6,00	2,38	2,55	0,80		
1111636	SPKX 070308			⊗				⊗					⊗											7,94	3,18	2,85	0,80		
1111637	SPKX 090308			⊗				⊗					⊗											9,80	3,18	4,10	0,80		
111285	SPKX 110408			⊗	⊗	⊗		⊗	⊗	⊗			⊗	⊗	⊗									11,50	4,80	4,40	0,80		

⊗ First choice | Primeira opção | 1ª opción      ⊗ Stock item | Produto de stock | Itens de stock      ○ Available under request (see page A-7) | Disponível sobre consulta (consulte a página A-7) | Disponible bajo consulta (mire página A-7)      Insert order code = (1) Geometry Code + (2) Grade Code

## Spot face SPKX

### SPARE PARTS | Complementos | Repuestos

Cutter ØDc	Insert Screw	Key (Torx)	Order separately	
			Key (Torx - Nm)	Torque Value
10-11	P0200400	XT06	DT0606	0,6
13-14	P0220500	XT07	DT0709	0,9
17-18	P0250704	XT08	DT0812	1,2
20-21	P0350702	XT15	DT1530	3,0
25	P0400900	XT15	DT1530	3,0



Note: The toolholder is supplied with the XT/PT key. To order the DT key please check the page A-243. Check the procedures for the clamping screws on the page A-243.

### RECOMMENDED CUTTING CONDITIONS | Condições de corte recomendadas | Condiciones de corte recomendables

ISO	PSM	Material	HB (Brinell)	Vc (m/min)		
				← Wear Resistance		Toughness →
				PH6920	PH6930	PHC930
P	1	Unalloyed Steel	125-220	180-250	160-240	160-240
	2	Low-Alloyed Steel	220-280	160-220	140-200	140-200
	3	High-Alloyed Steel	280-380	130-180	110-160	110-160
M	4	SS - Ferritic / Martensitic	200-330	170-230	140-210	140-210
	5	SS - Austenitic	200-330	160-200	130-200	130-200
	6	SS - Austenitic-ferritic (Duplex)	230-260	140-180	120-190	120-190
K	8	Grey Cast Iron	180-245	180-250	150-220	150-220
	9	Nodular Cast iron	160-250	130-200	110-180	110-180

ISO	PSM	Material	HB (Brinell)	Feed fz (mm/t)				
				SPKX 05...	SPKX 06...	SPKX 07...	SPKX 09...	SPKX 11...
P	1	Unalloyed Steel	125-220	0,05-0,08	0,06-0,10	0,06-0,12	0,07-0,13	0,08-0,15
	2	Low-Alloyed Steel	220-280	0,06-0,12	0,08-0,15	0,10-0,18	0,12-0,22	0,12-0,25
	3	High-Alloyed Steel	280-380	0,06-0,10	0,08-0,15	0,10-0,20	0,12-0,23	0,12-0,26
M	4	SS - Ferritic / Martensitic	200-330	0,05-0,10	0,06-0,12	0,08-0,15	0,09-0,16	0,10-0,20
	5	SS - Austenitic	200-330	0,04-0,08	0,05-0,10	0,06-0,12	0,07-0,13	0,08-0,18
	6	SS - Austenitic-ferritic (Duplex)	230-260	0,04-0,08	0,05-0,11	0,06-0,13	0,07-0,14	0,08-0,19
K	8	Grey Cast Iron	180-245	0,06-0,12	0,08-0,16	0,12-0,20	0,15-0,25	0,15-0,30
	9	Nodular Cast iron	160-250	0,06-0,10	0,08-0,15	0,10-0,18	0,12-0,20	0,15-0,25

### GRADES SELECTION GUIDE | Guia para selecção de graus | Tabla para selección de calidades

ISO	PSM	Material	HB (Brinell)	Grades		
				← Wear Resistance		Toughness →
				PH6920	PH6930	PHC930
P	1	Unalloyed Steel	125-220	⊗	⊗	⊗
	2	Low-Alloyed Steel	220-280	✓	✓	✓
	3	High-Alloyed Steel	280-380	✓	✓	✓
M	4	SS - Ferritic / Martensitic	200-330	✓	✓	✓
	5	SS - Austenitic	200-330	✓	✓	✓
	6	SS - Austenitic-ferritic (Duplex)	230-260	✓	✓	✓
K	8	Grey Cast Iron	180-245	✓	✓	✓
	9	Nodular Cast iron	160-250	✓	✓	✓

⊗ Good Conditions  
 ⊗ Average Conditions  
 ⊗ Difficult Conditions