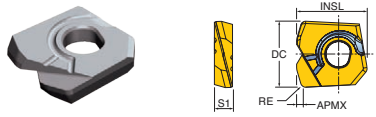




NANOFEED METRIC INSERTS

LNXF09



Part Number	Application	RE Corner Radius	INSL Insert Length	DC Cutting Dia.	S1 Thickness Overall	APMX Depth of Cut Max.	NOI Number of Indexes	IH Insert Hand	Grade	IN2006
WEEM060105R	Hi-Feed	0.5	5.9	6	1.6	0.3	1	Right		•
WEEM080106R	Hi-Feed	0.6	8.4	8	1.8	0.5	1	Right		•

NANOFEED HARDWARE

	Screw	Driver	Torque Driver Handle	Preset Torque Bit	Torque Driver Bit	
12G1D006013T7R00	SM20-050-10	DS-T06F	DS-A00-.25-S	DT-05-.25	DS-T06B	
12G1D006013T1R00	SM20-050-10	DS-T06F	DS-A00-.25-S	DT-05-.25	DS-T06B	
12G1E008018T0R00	SM25-080-B1	DS-T08W	DS-A00-.25-S	DT-08-.25	DS-T08B	
12G1E008018T2R00	SM25-080-B1	DS-T08W	DS-A00-.25-S	DT-08-.25	DS-T08B	
12G1D006020T7RC1	SM20-050-10	DS-T06F	DS-A00-.25-S	DT-05-.25	DS-T06B	
12G1D006025T7RC1	SM20-050-10	DS-T06F	DS-A00-.25-S	DT-05-.25	DS-T06B	
12G1E008020T0RC1	SM25-080-B1	DS-T08W	DS-A00-.25-S	DT-08-.25	DS-T08B	
12G1E008030T0RC1	SM25-080-B1	DS-T08W	DS-A00-.25-S	DT-08-.25	DS-T08B	

NANOFEED OPERATING GUIDELINES

Materials				V _c Cutting Speed m/min	f _z Feed/Tooth (mm)	Grade	Coolant
ISO	Mat'l Group #VDI 3323	Type	Examples			IN2006	
P	1 thru 5	Non-alloy Steel	1018, A36, 1045, A572, 1070	100 - 305	.3mm - .5mm	1	No
	6 thru 9	Low-alloy Steel	4140, 4340, P20, 8620, 300M				
	10, 11	High-alloy Steel	H13, A2, D2, M2, T1	90 - 200			
H	38 thru 39	Hardened Steel >48	A2, 01, D2	45 - 75	.3mm - .5mm	1	No

Note: Feed and speed recommendations are starting operating parameters. They are only guidelines from which further optimization should take place. Operating parameters are influenced by many machining variables. These variables may cause for reductions in feeds and speed or dramatic increases. Additionally, DOC and WOC may need to be revised to optimize the tools performance.