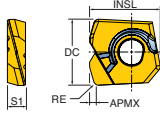
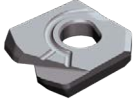





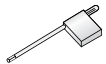



## NANOFEED METRIC INSERTS

### WEEM



| 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 <sub>c</sub><br>Cutting Speed<br>m/min | f <sub>z</sub><br>Feed/Tooth<br>(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.