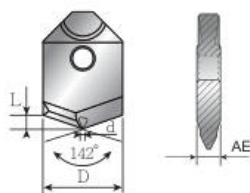
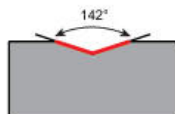


B23 Inserts



Tolerances (mm)

AE : + 0.01
- 0.02



Dimensions (mm)				
D	d	L	AE	angle
8	0.7	1.28	2.0	142°
10	0.8	1.55	2.5	
12	0.9	1.86	3.0	
16	1.0	2.56		

Inserts	Order Code	Grades										
		Carbide					Cermet		Uncoated			
		C125	B350	C350	F20	F30	CE25	CE100	CE60	K10		CE
	B23-0802-142-ME		⊙									 Inserts 10 PCS / Box
	B23-1002-142-ME		⊙									
	B23-1203-142-ME		⊙									
	B23-1603-142-ME		⊙									

- Steel
 ■ Stainless Steel
 ■ Steel/Stainless Steel /Super alloy
 ■ Cast Iron
 ■ Aluminum
 ■ Steel/Cast Iron
- Steel/Stainless Steel/Cast Iron
- Prices and stocks are based on present conditions
- Please specify model numbers and the grade of inserts, ie.: B23-0802-142-ME,B350

Spot Drill



Recommended Cutting Data And Insert Grades

- Recommended spot cutting speed in Vc (m/min), fn (mm/rev).
- For spotting  the effective no. of teeth is calculated with 1 flute.

Material group	 Cutting Speed Vc(m/min)	fn (mm/rev)		Grades	
		D: 8~10mm	D: 12~16mm	ME	E
1-2	50-70	0.10 0.13	0.11 0.14	B350/C350	-
3	50-70	0.10 0.13	0.11 0.14	B350/C350	-
4-5-6	45-60	0.08 0.10	0.10 0.12	B350/C350	-
7	25-30	0.06 0.08	0.06 0.08	B350	-
8-9	35-45	0.08 0.10	0.10 0.12	B350	-
10-11	35-40	0.07 0.09	0.09 0.12	B350	-
12-13	70-90	0.12 0.15	0.13 0.16	C350	-
14-15	60-80	0.10 0.14	0.10 0.15	C350	-
16-18	200-300	0.12 0.15	0.13 0.16	-	F20

How to Fit Inserts - Screw A.B.C.

Screwing the Insert

Step 1: • Put the insert into the slot of shank and press it with the finger

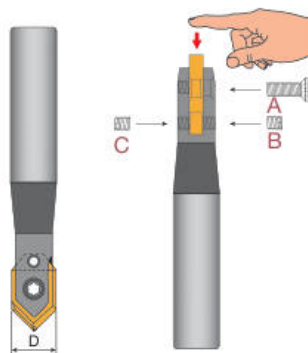
- Fully tighten the screw A first

Step 2: Half tighten the screw B on one side

Step 3: Half tighten the screw C on another side

Step 4: Fully tighten the screw B again (Important)

Step 5: Fully tighten the screw C again (Important)



Standard spare parts

Insert dimension D (mm)	Screw A	Screw B/C	Key	Key
				
8	C02506	S025025	T08P	L013
10	C03008	S02503	T09P	L013
12	C03010	S0304	T09P	L015
16	C03512	S0405	T10P	L02