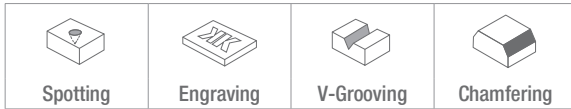


SPOT DRILL

High quality multipurpose system

APPLICATION



ISO APPLICATION FIELDS

P M K N

ADVANTAGES AND CHARACTERISTICS

- Highly universal system for chamfering, engraving, spot drilling or milling grooves
- Convenient to use with great flexibility
- Inserts available with different radii and for diverse workpiece materials



• Drilling bodies

- Cylindrical type and screw-in type
- Max. drilling dia. 14mm, min. drilling dia. 2.4mm
- Smart kit of 1 holder plus 4 inserts available
- Extension sleeves (steel/carbon 10xD)



• Inserts

- Available R03/08 for PMK, R04/08 for aluminium
- Cemented carbide grades with PVD coatings or uncoated for N materials
- Geometries: GP, AL



A - TURNING

B - THREADING

C - GROOVING

D - MILLING

E - DRILLING

F - ACCESSORIES

G - SPARE PARTS

<h1>NT-SPOT</h1> <h2>SPOT drill</h2> <ul style="list-style-type: none"> • Spot drill system with SPOT inserts • External coolant • Multifunctional system for maximum versatility • Inserts cannot be mounted on DRS drills or ChamferSquare milling holders 	<p>Screw-in</p>	
	<p>Cylindrical</p>	

Designation	Stock	DC	DCX	CICT	DCON	LF	LU	CRKS			MIID
SCREW-IN											
NT-SPOT D14-M08-L052	●	15.4	14	1	8.5	35	-	M8			SPOT11
CYLINDRICAL											
NT-SPOT D14-S16-L100	●	15.4	14	1	16	100	30	-			SPOT11

● stock standard, ○ non-standard stock, ▲ upcoming introduction, ▽ stock exhaustion

Spare parts	Insert screws	Flag wrenches
NT-SPOT D14-∞∞-L∞∞	NT-ST35080T15	NT-FTB15

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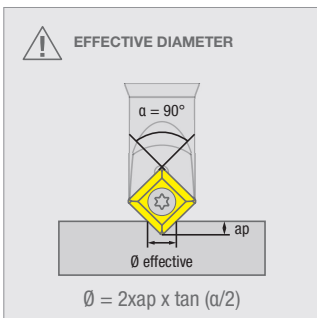
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<h1>SPOT11</h1>	HF: Micrograin carbide PVD: Physical vapour deposition				HF PVD	HF PVD	HF PVD	HF	
	SPOT drill				JP7525	JP8725	JP9535	JU6520	
<ul style="list-style-type: none"> General purpose type or fine polished sharp geometries for aluminum or non-ferrous materials available Diverse PVD coated or uncoated carbide grades available Multiple radii available for each geometry Inserts cannot be mounted on DRS drills or ChamferSquare milling holders 	Stable machining, light cut	● 1 st choice ○ suitable			○			●	
	General machining, medium cut	● 1 st choice ○ suitable	●	●	●	●			
	Unstable machining, heavy cut	▲ 1 st choice ▼ suitable	▲	▲					
Dimensions		ISO		Vc(m/min) - suggested cutting speed range (bold: 1st choice)					
		P		120 240					
		M			80 160				
		K	100 160						
		N				240 400			
		S							
		H							

Designation		RE	IC	S	D1	LE	Stock				
GENERAL 	SPOT11 R03-GP	0.3	11	3.97	4.3	10.4	●	●	●		
	SPOT11 R08-GP	0.8	11	3.97	4.3	9.4	●	●	●		
ALUMINIUM polished surface	SPOT11 R04-AL	0.4	11	3.97	4.3	10.2				●	
	SPOT11 R08-AL	0.8	11	3.97	4.3	9.4				●	

● stock standard, ○ non-standard stock, ▲ upcoming introduction, ▼ stock exhaustion



ISO 513	MATERIAL	HARDNESS HB	JP8725				
			min	start	max		
P1 - P2	Free cutting steel and low carbon (ex. 1.0715/9 smn 28/avp, 1.0503/c45)	≤ 200	120	180	240		
P3 - P4	Medium and high alloy steel (ex. 1.7225/42 CrMo 4, 1.3505/100 Cr 6)	200 ÷ 300	100	150	200		
P5 - P6	High tensile strength and tool steel (ex. 1.2344/X 40 CrMoV 5 1/ORVAR, Hardox400®)	300 ÷ 400	80	120	160		
ISO 513	MATERIAL	HARDNESS HB	JP9535				
			min	start	max		
P7	Ferritic and martensitic stainless steel (ex. 1.4021/X 20 Cr 13/AISI420)	≤ 200	80	120	160		
P8	Precipitation hardening stainless steel (ex. 1.4548/X 5 CrNiCuNb 17 4/17-4-PH)	≤ 450	60	90	120		
M1	Austenitic stainless steel (ex. 1.4305/X 10 CrNiS 18 9/AISI303)	> 200	80	120	160		
M2 - M3	Austenitic and Duplex stainless steel (ex. 1.4401/X 5 CrNiMo 17 12 2/AISI316)		60	100	140		
ISO 513	MATERIAL	HARDNESS HB	JP7525				
			min	start	max		
K1	Grey cast iron (ex. 0.6025/GG 25/EN-GJL-250)	150 ÷ 250	100	130	160		
K2	Nodular cast iron (ex. 0.7050/GGG 50/EN-GJS-500-7)	150 ÷ 350	100	110	120		
ISO 513	MATERIAL	HARDNESS HB	JU6520				
			min	start	max		
N1	Aluminium alloys ≤ Si 12% (ex. 3.4365/AlZn5.5MgCu/ERGA)		240	320	400		
N2	Aluminium alloys Si > 12% (ex. 3.2382/G-AISI12)		160	230	300		

Complete workpiece materials p. H1.

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