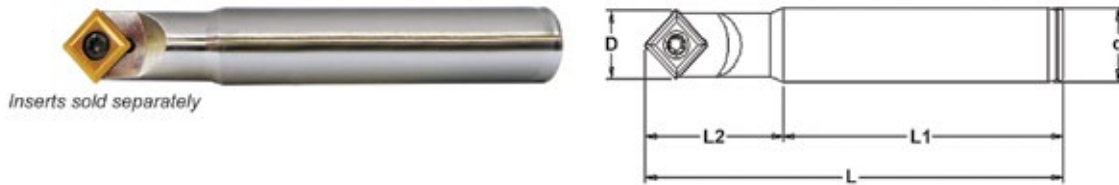


Indexable Spotting Drills

Carbide Inserts

- One combination tool that does four applications, giving extra efficiency and reduced cycle times
- For spotting, engraving, chamfering and grooving on CNC and conventional milling machines
- For spotting on CNC lathes
- Indexable carbide insert with 4 cutting edges provides great cost per edge and long tool life
- Insert fits both 1/2" and 5/8" diameter tools
- Extended reach tools: 5/8" x 6" and 5/8" x 9"

Individual Holders



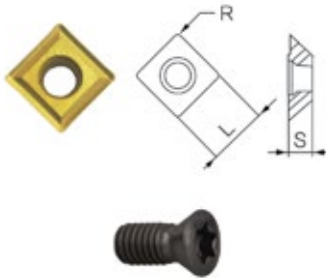
Dimensions (Inch)	Insert Reference	Screw Reference	Key Reference	D (Inch)	d (Inch)	L (Inch)	L1 (Inch)	L2 (Inch)	Code
1/2 x 4	XDBPIIT308	TSB-3508	Torx® 15	0.551	0.500	4.00	2.75	1.25	530650
5/8 x 4	XDBPIIT308	TSB-3508	Torx® 15	0.551	0.625	4.00	2.75	1.25	530651
5/8 x 6	XDBPIIT308	TSB-3508	Torx® 15	0.551	0.625	6.00	4.75	1.25	530652
5/8 x 9	XDBPIIT308	TSB-3508	Torx® 15	0.551	0.625	9.00	7.75	1.25	530653



Indexable Spotting Drill Sets

Description	Grade	Code
1/2" x 4" holder, 1 carbide insert and a Torx® 15 key	Steel	530676
5/8" x 4" holder, 1 carbide insert and a Torx® 15 key	Steel	530675
1/2" x 4" holder, 6 carbide inserts and a Torx® 15 key	Steel	530659
5/8" x 4" holder, 6 carbide inserts and a Torx® 15 key	Steel	530656
5/8" x 4" holder, 6 carbide inserts and a Torx® 15 key	Stainless Steel	530657

Replacement Inserts



Description	Material/Grade	L (Inch)	S (Inch)	R (Inch)	Code
XDBPIIT308-P	Carbide for Steel	0.433	0.156	0.031	530654
XDBPIIT308-S	Carbide for Stainless Steel	0.433	0.156	0.031	530655

Spare Screw

Description	Code
TSB-3508 (Torx® 15)	530658

Recommended Cutting Data

- = Point angle 90°
- H = Centering depth
- D = Effective diameter
- Vc = Cutting speed: ft./min. or m/min.
- S = Spindle speed
- F = Feed rate
- f = Feed/Rev.: inch/rev. or mm/rev.
- Ff = Feed rate factor

Maximum H

- Centering0.28" (7mm)
- Grooving0.20" (5mm)
- Chamfering....0.28" (7mm)

Inch

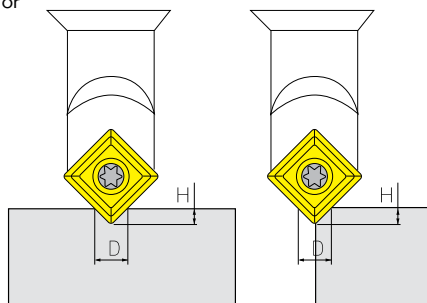
$$RPM = \frac{SFM \times 3.82}{D}$$

$$F = RPM \times \text{Inch/Rev} \times \# \text{ of Flutes}$$

Metric

$$RPM = \frac{1000 \times SFM}{\pi \times D}$$

$$F = RPM \times \text{mm/Rev} \times \# \text{ of Flutes}$$



Material	Cutting Speed		Feed/Revolution	
	ft./min.	m/min.	inch/rev.	mm/rev.
Carbon Steel	400-500	120-150	0.002	0.05
Alloy Steel	330-400	100-120	0.0015	0.04
High Alloy Steel	200-260	60-80	0.001	0.03
Hard Steel < HRC40	200-260	60-80	0.001	0.03
Hard Steel, 40	165-200	50-60	0.001	0.03
Stainless Steel	165-200	50-60	0.001	0.03
Gray Cast Iron	260-332	80-102	0.002	0.05