INDEXA-SEIKI Multi-Pro Spot Drills & Chamfer Mills

A spotting drill with all the advantages of indexable inserts - reduced tool maintenance time, increased performance, lower inventory cost and no regrinding requirements. The insert clamping method ensures accurate and secure location with quick change-over times. Multi-pro has a unique geometry which allows cutting over the centre line, using carbide, without chipping of the cutting edge. This versatile tool may be used to 'spot' holes prior to drilling, as a means to guide the drill and keep the hole straight, to keep size and accurately position, relative to the datum.
NB. The 118° inclusive tool is recommended for 'spotting' prior to drilling with 118° point drills. Countersinks may be produced prior to drilling to provide a corner break on a drilled hole, a chamfer conforming to drawing specifications, a lead in for a subsequent tapping operation, or a full countersink to accommodate a screw head. Corner chamfers on edges, contours and bores can be machined as light de-burring operations or full depth chamfers. Multi-pro may be used to produce vee grooves for fluid channels, locations for round components and grip pattern or serrations on jaws and clamp pads.

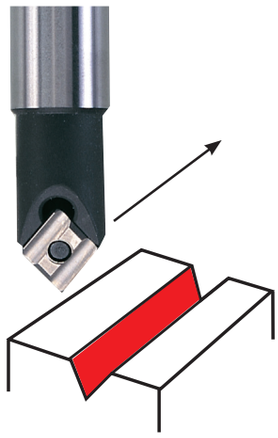


SCM1045C SC1645C SC1630C

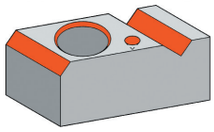
Hole Chamfer



Vee Groove Milling



Application Range



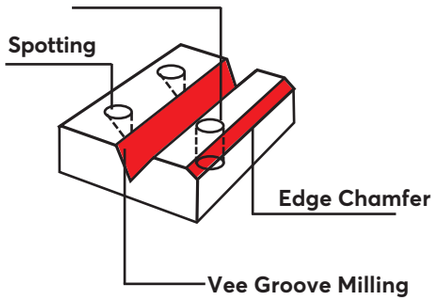
'Multi Pro Mini' - Uses C22 GUX Inserts

Designation	Cutting Diameter	Overall Length	Included Angle	Shank Diameter	Weight each	Order Code IND-139	Price/1 THB
SCM 1045C	8mm	105mm	90°	10mm	78g	**-8050K**	**12191.00**

'Multi Pro Standard' - Uses C32 GUX Inserts

Designation	Cutting Diameter	Overall Length	Included Angle	Shank Diameter	Weight each	Order Code IND-139	Price/1 THB
SC 1645C	13mm	110mm	90°	16mm	174g	**-8545K**	**12401.00**
SC 1630C	16mm	110mm	118°	16mm	184g	**-8530K**	**12422.00**

Hole Chamfer

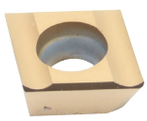


Insert Grade Description

QM10 **(ISO P10/M10/K10)** Tin Coated Multi-purpose grade for general use, can cut the majority of ferrous and non-ferrous materials used in industry.

QS20 **(ISO P20)** Uncoated Grade for steel and stainless steel application.

QC10 **(ISO K10)** Uncoated Grade for cast irons, aluminiums, and non-ferrous materials.



Inserts

Designation	Grade	To Suit	Order Code YML-122	Price/1 THB
C22 GUX	QM10	Multi-Pro Mini	**-0080N**	**3182.00**
C32 GUX	QS20	Multi-Pro	**-0102P**	**2583.00**

Spares

Insert Screw	Order Code IND-107	Price/1 THB
To suit SCM1045C	**-3249K**	**308.00**
To suit SC1645C & SC1630C	**-4800K**	**494.00**

Speed & Feed Recommendations for Multi-Pro

Group	Materials	Rockwell Hardness HRC	Recommended Grade		Cutting Speed M/min	Type of Operation	Feed/Rev Pro Mini 105mm	Feed/Rev Pro Standard 110mm	Feed/Rev Pro Mini 165mm
1.1 to 1.3	Alloy Steels and castings	from 36 up to 45	**QS20**	**QM10**	80~100	Spot Drilling Chamfer Milling	0.020 0.050	0.026 0.070	0.013 0.040
1.4 to 1.6	Tool and die steels	from 45 up to 55	**QS20**	**QM10**	55~65	Spot Drilling Chamfer Milling	0.012 0.030	0.016 0.050	0.008 0.020
2.1 to 2.3	Stainless steels	up to 36	**QS20**	**QM10**	70~90	Spot Drilling Chamfer Milling	0.020 0.040	0.026 0.060	0.013 0.030
3.1 to 3.4	Cast irons	-	**QC10**	**QM10**	100~120	Spot Drilling Chamfer Milling	0.034 0.050	0.045 0.070	0.022 0.040
6.1 to 6.6	Copper alloys brass and bronze	-	**QC10**	**QM10**	120~150	Spot Drilling Chamfer Milling	0.034 0.050	0.045 0.070	0.022 0.040
7.1 to 7.4	Aluminium alloys	-	**QC10**	**QM10**	120~150	Spot Drilling Chamfer Milling	0.034 0.050	0.045 0.070	0.022 0.040

© 2022

OS21_APAC_TH_0049.indd 1 07/12/2021 10:15