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KENNAMETAL®



MASTER CATALOGUE 2018

VOLUME TWO | **ROTATING** TOOLS



HOLEMAKING | TAPPING | SOLID END MILLING | INDEXABLE MILLING

KENNAMETAL



The Perfect Fusion of a Solid Carbide and an Indexable Drill

The new modular drill KenTIP™ FS covers more applications and provides better performance than any other modular system, delivering substantial cost savings and process simplifications on your shop floor.

KenTIP™ FS

See pages H6–H23.

Since its inception in 1938, Kennametal has understood precisely how to improve manufacturing performance and profitability — by introducing unparalleled products and services to reduce operating costs and lead times.

These 1900+ pages bring you the latest in milling and holemaking products and superior services — specifically engineered to enhance overall productivity, even in the most challenging metalworking applications.

Rely on Kennametal to significantly boost manufacturing competitiveness. To learn more, contact your Kennametal Representative or Authorised Kennametal Distributor.

Visit us at **kennametal.com**.

POWERED BY NOVO™

Volume II • Rotating Tools

This Catalogue Consists of Two Volumes — Vol. I: Turning Tools / Vol. II: Rotating Tools

Rotating Tools

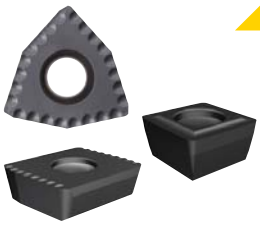
Introduction ..... **ii–xi**
Services and Support ..... **xiv**
Holemaking **F1–K212**
Holemaking Introduction F2–F10
Solid Carbide Drills G1–G153
Modular Drills H1–H106
Combination Tools I1–I27
Indexable Drills J1–J101
Hole Finishing K1–K212
Tapping **L1–M132**
Tapping Introduction L2–L15
Spiral-Point/Left-Hand Spiral-Flute Taps M1–M18
Spiral-Flute Taps M20–M50
Straight-Flute Taps M52–M68
Forming Taps M70–M75
Pipe Taps M76–M79
Solid Carbide Thread Mills M80–M97
Technical Information M98–M132
Solid End Milling **N1–Q43**
Solid End Milling Introduction N2–N3
Duo-Lock Modular Milling O1–O59
High-Performance Solid Carbide End Mills P1–P197
General Purpose Solid Carbide End Mills Q1–Q43
Indexable Milling **R1–X37**
Indexable Milling Introduction R2–R21
Face Milling S1–S150
Shoulder Milling T1–T123
Slot Milling U1–U53
Copy Milling V1–V157
Thread Milling W1–W55
Technical Information • Recommended Starting Speeds X1–X37
Ordering Information **Y2–Y217**
Index by Order Number Y2–Y93
Index by Catalogue Number Y94–Y182
Global Contacts Y184–Y185
Icon Legend Y186–Y190
Material Overview Y191
Workpiece Material Overview Listing Y192–Y217

Turning Tools • See Volume I

Turning **A2–E65**
ISO Turning B1–B387
Grooving and Cut-Off C1–C179
Threading D1–D110
Application Specific E1–E65

Holemaking

PRODUCT HIGHLIGHTS



DRILL FIX™ DFSP™

INDEXABLE DRILLS WITH DS AND LP INSERTS

See section J (Volume II) for more details.

DFSP is the renamed expanded Drill Fix DFS™ indexable drilling platform. The standard diameter range is now 14–55mm in L/D ratios 2 x D, 3 x D, 4 x D, and 5 x D. The DFSP platform combines the economical squared outboard insert with the superior centring capabilities of the trigon inboard insert. These indexable drills offer increased metal removal rates and high surface quality and hole straightness.

Use new DS and LP chipbreaker insert designs with Drill Fix DFSP, DFT™, and HTS indexable drills, and KSEM PLUS™ modular drills. These inserts enable excellent chip formation on low-carbon steels and other long-chipping materials.

KENTIP™ FS

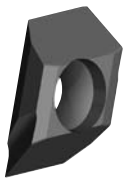
THE PERFECT FUSION OF A SOLID CARBIDE AND AN INDEXABLE DRILL

See section H (Volume II) for more details.

The new modular drill KenTIP FS covers more applications and provides better performance than any other modular system, delivering substantial cost savings and process simplifications on your shop floor.

- 3-point geometries, 3 high-performance grades, 3 different shank styles.
- 6–26mm diameter range.
- Up to 12 x D drilling depths.
- Applicable in steel, stainless steel, and cast iron.





COUNTERFIX MICRO

SMALL INSERTS THAT MAKE A BIG DIFFERENCE!

See section H (Volume II) for more details.

New CounterFix Micro (CFM) tangential inserts offer a new way to enhance drilling, chamfering, and counterboring operations. They enable very small incremental steps on tailor-made step drills, longer tool life per edge, and improved surface finish.

CFM inserts can be used on KenTIP, KSEM™, and Drill Fix products, as well as for made-to-order indexable countersinking tools.

CounterFix Micro will be available for KenTIP FS tailor-made drills in 2018 upon request.

NEW SGL DRILLS WITH THROUGH COOLANT FOR STAINLESS STEEL

See section G (Volume II) for more details.

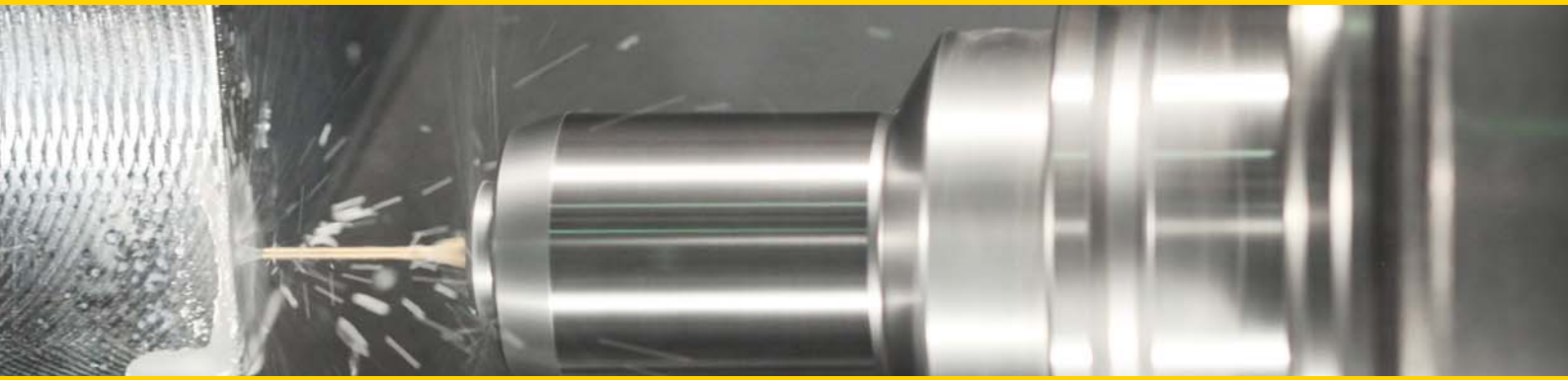
The all-new B21_SGL series solid carbide drills are designed specifically for stainless steel applications, offering high performance and long tool life in high-temperature alloys and regular steel, also.

By combining unique Kennametal features, such as the all-new SGL-point-geometry with patented gashing, a unique flute design, and a best-in-class coating into one tool, the B21*SGL drill is the ultimate high-volume production tool.

The all-new B27_SGL series is designed specifically for deep-hole drilling up to 40 x D applications in stainless steel and high-temperature alloys.









NEW KMH DRILLS FOR HARD MATERIALS

See section G (Volume II) for more details.

The all-new KMH solid carbide drills are engineered for hard material applications up to 65 HRC. The B94_drill series without through coolant is specifically designed to machine hardened and surface-hardened materials using flood coolant. With its 145° point angle, it is also perfectly suited as a pilot drill for the B95_drill series with through coolant and 140° point for deeper applications.

Both series come with an increased core to strengthen the drill, feature a curved cutting edge with corner chamfer to avoid chipping on the margin lands and increased tool life in these challenging materials.



RMR™ AND RHR™ DISC-STYLE REAMERS

See section K (Volume II) for more details.

Performance, quality, and regrindability, like solid carbide reamers for diameters 14–42,5mm.

Common reamers have single tips brazed onto a steel body. The new Kennametal RMR and RHR reamers have a solid carbide disc brazed onto the steel body. This enables more regrinds than a regular tipped reamer, reducing the cost-per-hole significantly. The new KCU05 coating holds the surface finish more than twice as long as conventional reamer coatings, depending on the workpiece material.



GOTAP™

MULTIPURPOSE HSS-E TAPS

See section M (Volume II) for more details.

GOtap is our multipurpose line of taps that include optimised geometries and PVD coatings capable of tapping a wide range of ductile materials, such as stainless steels, carbon and alloy steels, cast aluminium, and ductile iron. GOtap taps versatility extends beyond the part, as it can be used in a wide range of machine tools and application conditions. The new GOtap TC multipurpose taps enable blind-hole tapping with tension/compression holders without sizing problems due to over-feeding. The versatility of GOtap taps mean lower inventory costs with no loss of productivity, consistent tool life, and high-quality thread finish.

Solid End Milling

PRODUCT HIGHLIGHTS

DUO-λOCK®

See section O for more details.

Duo-Lock™ is a revolutionary new coupling for solid carbide end milling applications. This replaceable-head design combines high accuracy in runout and length repeatability with maximum stability, making it a precise and virtually unbreakable interface for challenging milling applications.

- **Up to 1 x D full slotting increases metal removal rates for significantly higher productivity.**
- **1,5 x D standard cutting edge length enables fewer passes.**
- **Cutting data and tool life comparable to high-performance solid carbide tools.**



DUO-λOCK®
by HAIMER® and Kennametal



HARVI™ III FAMILY

See section P for more details.

HARVI III end mills are the first choice for high-temperature alloy machining, profiling, semi-finishing, and finishing. Beyond grade KCSM15™ delivers maximum metal removal rates and exceptional tool life in titanium and stainless steel, as well as excellent surface finishes.

- **Taper ball nose for complex 5-axis machining.**
- **Ball nose for 3D profiling.**
- **Square end for semi-finishing/finishing operations.**

beyond



BEYOND™ EADE SOLID CERAMIC END MILLS

See section P for more details.

Beyond™ EADE solid ceramic end mills offer higher productivity in roughing nickel-based high-temperature alloys. With reduced machining time, EADE ceramic end mills also achieve significantly longer tool life compared to carbide tooling.

— Beyond grade KYS40™ enables cutting speeds up to 1000 m/min.



beyond



GOMILL™ GP PLATFORM

See section Q for more details.

GOmill GP tools enable plunging, slotting, and profiling, plus longer tool life, on a wide range of workpiece materials. They are designed to provide higher metal removal rates (MRR) and good surface finishes at an excellent cost-benefit ratio.

— Roughing and finishing with one tool.

— Excellent cost-benefit ratio.

— Multilayer KC633M™ grades for longer tool life.

Indexable Milling

PRODUCT HIGHLIGHTS

MILL 4-11™ AND MILL 4-15™

See section T for more details.

The Mill 4-11™ and Mill 4-15™ series tools are specially engineered to achieve excellent surface quality and higher metal removal rates in shoulder milling applications. The unique design enables multiple passes (stepping down) with outstanding results.

Use Mill 4-11 in roughing to finishing applications in steel, cast iron, stainless steel, non-ferrous materials, and high-temp alloys. Use Mill 4-15 for roughing to finishing in steel, cast iron, stainless steel, and titanium.





MILL 16™

See section S for more details.

The new Mill 16™ series is a tailor-made platform for rough milling of components like engine heads and blocks, housings and gear boxes in cast iron materials (CGI, DCI, GCI), and all other cast iron face milling jobs.



KCSM40™

NEW MILLING GRADE FOR TITANIUM MACHINING

Breakthrough indexable milling grade for roughing and semi-finishing operations in titanium and stainless steels — S40, M30 application range.

Available in these indexable milling platforms: Mill 1-10™, Mill 1-14™, Mill 1-18™, Mill 4-11™, Mill 4-15™, Dodeka™ Mini, Dodeka, Dodeka MAX™, MEGA™, KSOM™ Mini, KSOM™, KSRM™, NGE™, KSSM™ 90, KSSM8+™, Rodeka™, Stellram® 5230, Stellram 7713, and Stellram 7792.





STELLRAM® 7792VX HIGH-FEED SERIES

See section V for more details.

The 7792VX cutter series is designed for high-feed milling applications with superior surface generation. The 7792VX cutters are designed for a wide range of applications, including facing, pocketing, ramping, helical interpolation, and plunging. They are capable of machining all materials, including steel, stainless steel, cast iron, and high-temperature and aluminium alloys.

Turning

PRODUCT HIGHLIGHTS

BEYOND™ EVOLUTION™

See section C (Volume I) for more details.

Kennametal proudly introduces the Beyond™ Evolution™ platform. This innovative platform is built on simplicity and challenges today's approach to grooving and cut-off. Selecting the right tool is easy with the Beyond™ Evolution™ platform because this high-performance system is versatile and flexible. It is the first portfolio in the market to compete in all grooving and cut-off applications, with up to 35% less tooling than current competitors.

The proprietary coolant delivery system directs coolant precisely to the cutting edges underneath the chip, which is the best method for heat removal in grooving and cut-off applications.



beyond™ EVOLUTION™

BEYOND™ DRIVE™

See section B (Volume I) for more details.

Beyond™ Drive™ ISO turning inserts provide up to 50% improved insert edge utilisation. The advanced surface treatment reduces coating stress and improves coating adhesion. The bronze outer layer simplifies wear detection and increases insert utilisation. PVD grades KCU10™ and KCU25™ with Beyond™ technology resist the high temperatures of machining in tough alloys. Achieve up to 30–40% longer tool life for more profitability in general engineering, transportation, aerospace, energy, and earthworks markets. The PVD coating helps to maintain consistent chip control and minimise insert edge wear in turning, grooving, and cut-off operations in a wide range of materials and applications.



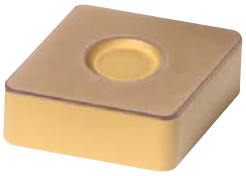
beyond™ DRIVE™



CAST IRON TURNING WITH KBK45™

See section B (Volume I) for more details.

KBK45 is a new high-content PcBN grade designed for high-performance machining of grey cast iron, such as brake discs and fly wheels. It is designed for reducing waste of unused corners, reducing cost-per-part (CPP) by maintaining tool changes between shifts, and enhancing output by using more reliable products. KBK45 grade provides an excellent CPP value.



HARD TURNING WITH KBH20™

See section B (Volume I) for more details.

KBH20 is the ideal PcBN hard turning grade in continuous to lightly interrupted applications with up to medium-severity interruption. The structure and different edge preparations enable tight and repeatable workpiece tolerances, excellent surface finishes, and surface integrity — even at elevated speeds.

KBH20 grade is a new substrate for applications like case-hardened components, including gears, shafts, and other drive-train components.

The nano-composite coating enhances speed capabilities and tool life. The improved edge preparation promotes longer tool life, reliable performance, and better surface finish.



Tooling Systems

PRODUCT HIGHLIGHTS

ERICKSON™

Visit **kennametal.com** or **kennametal.com/novo** for more details.

Kennametal proudly offers premium quality ERICKSON™ toolholder products, so you can be sure that you're buying the best the industry has to offer. The entire portfolio — including steep taper, HSK, straight shank extensions, collets, sleeves, and accompanying products — offers high productivity, increased accuracy, and application flexibility. Designed for both manual and automatic tool changing, ERICKSON interfaces are ideally suited for most machine tools and feature a compact and rigid construction guaranteed to handle high torque and deliver optimal metal removal rates.

Machinists have relied on the ERICKSON name for more than 60 years. With one of the broadest product offerings in the industry, ERICKSON tools can be used on all types of machine tools and in applications ranging from low-speed, heavy-milling jobs to high-speed operations greater than 20,000 RPM.





KM4X™

Visit **kennametal.com** or **kennametal.com/novo** for more details.

The KM4X spindle interface is designed for heavy-duty machining applications. It's especially suited for machining large structural components. These rotating and static tool adaptors handle 3x more bending capacity than similar competitive models.

- Rigid configuration through higher clamping force.
- Design enables front-loaded spindle configurations.
- High spindle speed capability.
- Designed for use in most applications.
- Use in a wide range of high and low speeds and torques.
- Can upgrade to the KM4X system on spindles which use HSK format.
- Maintain taper contact in higher speeds.



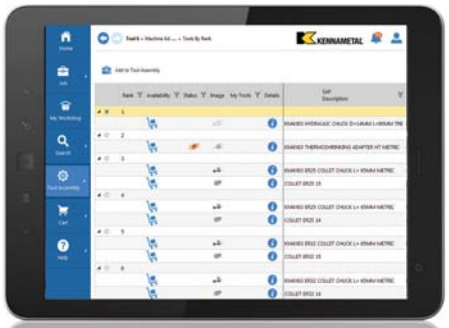
HYDROFORCE™ HYDRAULIC CHUCKS

Visit **kennametal.com** or **kennametal.com/novo** for more details.

Our most advanced and universal hydraulic chuck is your first choice for milling, drilling, and reaming applications. HydroForce hydraulic chucks require only two sizes for all tooling applications. Reducer sleeves are applied for all other diameters. We offer ERICKSON™ Safe-Lock™ Smart Coolant reducer sleeves, specially designed for secure clamping when used with end mills featuring Safe-Lock™ tool shanks. The special drive feature in the reducer sleeve and grooves in the tool shank prevent the end mill from spinning and pulling out of the sleeve during extreme machining conditions.



- High rigidity.
- Enables higher cutting parameters.
- Provides better surface quality.
- Up to 50% longer tool life and improved workpiece surface quality.
- More productivity at higher cutting speed.
- Consistently reliable clamping.
- No overtorque.
- No torque wrench required.
- Reduced toolholder inventory.
- Maximum flexibility.
- Minimum cost.



NOVO™ WITH MACHINE ADAPTOR ADVISOR

Visit **kennametal.com/novo** for more details.

Let the NOVO Machine Adaptor Advisor help you build the right assembly. With NOVO applications, simply select a rotating tool (end mill, drill, reamer, or tap), then use the Machine Adaptor Advisor to build an entire assembly from machine spindle to cutting tool with minimal data input. This new feature reduces a tool configuration build from minutes to seconds, regardless of gage length. Previously, it was a manual process to select a tool then individually filter and pick one adaptor after another. Now, NOVO applications make it easy.

Kennametal on the Web

kennametal.com

FIND THE LATEST PRODUCT INFORMATION

Whether your operation is turning, milling, or holemaking, Kennametal brands are the high-performance tooling you need. We offer standard and custom solutions for a wide range of applications.

Find information about our most current campaigns and catalogues.

Register on Konnect for the full functionality of the Kennametal online ordering website.



CONTACT US

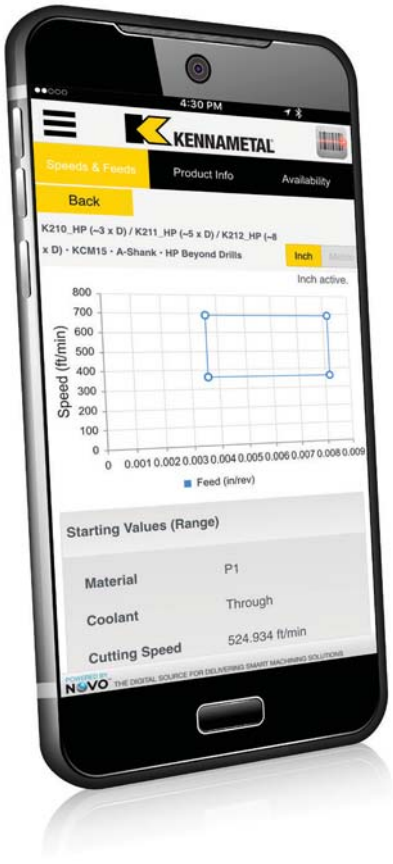
Our customers are important to us. We want to provide you the best customer service in the industry. If you have a comment or question, please send it to us. We strive to respond to all inquiries within 24 hours.

FIND A LOCAL AUTHORISED DISTRIBUTOR IN YOUR AREA

Kennametal offers world-class products and services globally. Our distributors know us, and more importantly, they know you. They know better than anyone in the industry how to put the global power of Kennametal to work for you — in your industry, in your region, and for your business.

Mobile App

The Kennametal mobile app makes it easy to access product information, calculators, and much more from iPhone® and Android™ devices.



FEATURES

Scan a Kennametal tool package barcode or search a product catalogue number to access complete product information.

Product information includes tool image, dimensions, grades, and product highlights.

View product availability at global locations.

Get speed and feed information in inch and metric values for all metalcutting products.

View tech tips for helpful solutions to common machining questions.

Contact Customer Support directly from the app.

MACHINING CALCULATORS

View data for milling and drilling applications.

Inch and metric values calculated.

ORDERING

Login using your Konnect credentials to complete a purchase.

WHERE TO FIND IT

Download the free app today from iTunes® or the Google Play™ store.

ANDROID APP ON Google play

Available on the App Store

Service and Support

Customer Application Support (CAS)

Get Fast and Reliable Answers to Your Toughest Metalcutting Problems

Our Customer Application Support (CAS) Team is the metalworking industry's leading help desk resource for tooling application solutions and problem resolution.

Easy Access to Proven Metalworking Expertise!

Kennametal Customer Application Engineers assist customers and engineering groups throughout the world with expert tool selection and application recommendations for the entire range of Kennametal tooling.

SERVICE LEVEL EXCELLENCE	Fast telephone response. Quick technical solutions. Efficient case management.
SERVICES	Operating parameters. Process optimisation. Hardware support. Tooling selection. Troubleshooting.
BEST-IN-CLASS SUPPORT TOOLS AND TECHNOLOGY	Materials database. Application calculators. Tooling performance experts.



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Numbers shown only serve the originating country listed.

NOVO KNOWS SEARCH

Searching for a tool has been enhanced by Advise and Select functions from NOVO™ applications — saving you time and money.

ADVISE

Uses a rules-based approach to provide cutting tool recommendations:

- Define Machining Feature (face milling, slotting, blind hole, etc.)
- Apply Constraint Requirements (geometric, material, tolerance, etc.)
- Set Machining Sequence (single or multi-step operations, rough then finish, etc.)
- Receive Ranked Results

SELECT

A method of selecting cutting tools from a tree structure via a hierarchy or parametric search:

- If you know which product you are looking for, a quick search can be performed by just the catalogue number or product description.
- Smart filters significantly reduce the amount of potential tooling solutions.
- After the tool is selected, NOVO also provides cutting and adaptive item options that fit with your solution.

NOVO applications can ensure you have the right tools on your machines, in the right sequence. Resulting in flawless execution that accelerates every job, and maximises every shift. **kennametal.com/novo**



Holemaking

Holemaking Introduction F2–F10

Solid Carbide Drills G1–G153

Modular Drills H1–H106

Combination Tools I1–I27

Indexable Drills J1–J101

Hole Finishing K1–K212



Holemaking Products

Our latest Metalcutting Innovations are designed to deliver higher productivity, longer tool life, and increased application versatility.

For more information about the latest products and services from Kennametal, please contact your Kennametal Representative or Authorised Kennametal Distributor, or visit **kennametal.com**.

SOLID CARBIDE DRILLS

See Section G for more details.

GOdrill™
TF Drills
Beyond™ Drills
Deep-Hole Drills
Y-TECH™ Drills
TX Drills
CFRP Drills
Flat-Bottom Drills
NEW! KMH Drills
Kenna Universal™ Drills
NC Spot Drills

MODULAR DRILLS

See Section H for more details.

NEW! KenTIP™ FS
KenTIP™
KSEM™
KSEM PLUS™





COMBINATION TOOLS

See Section I for more details.

BF Combination Drilling System
SEFAS™ Combination Drilling System



INDEXABLE DRILLS

See Section J for more details.

Drill Fix™ DFR™, DFSP™, and DFT™
HTS™ Series Indexable Deep-Hole Drilling System
Indexable Drill Inserts
CTR Counterboring Tools
Counterboring Inserts

HOLE FINISHING

See Section K for more details.

Reaming Tools
SIF™ Steerable Toolholders
Romicron™ Fine-Boring System
ModBORE™ Boring System
PCD Customised Tooling



TAPS

See Section L and M for more details.

Beyond™ High-Performance
Solid Carbide Taps
High-Performance HSS-E-PM Taps
GOtap™ Multipurpose Taps
General-Purpose Taps
High-Performance Solid Carbide
Thread Mills

Select the Correct Holemaking Solution for Your Application

Added Value for Your Performance

Increase of Productivity and Efficiency

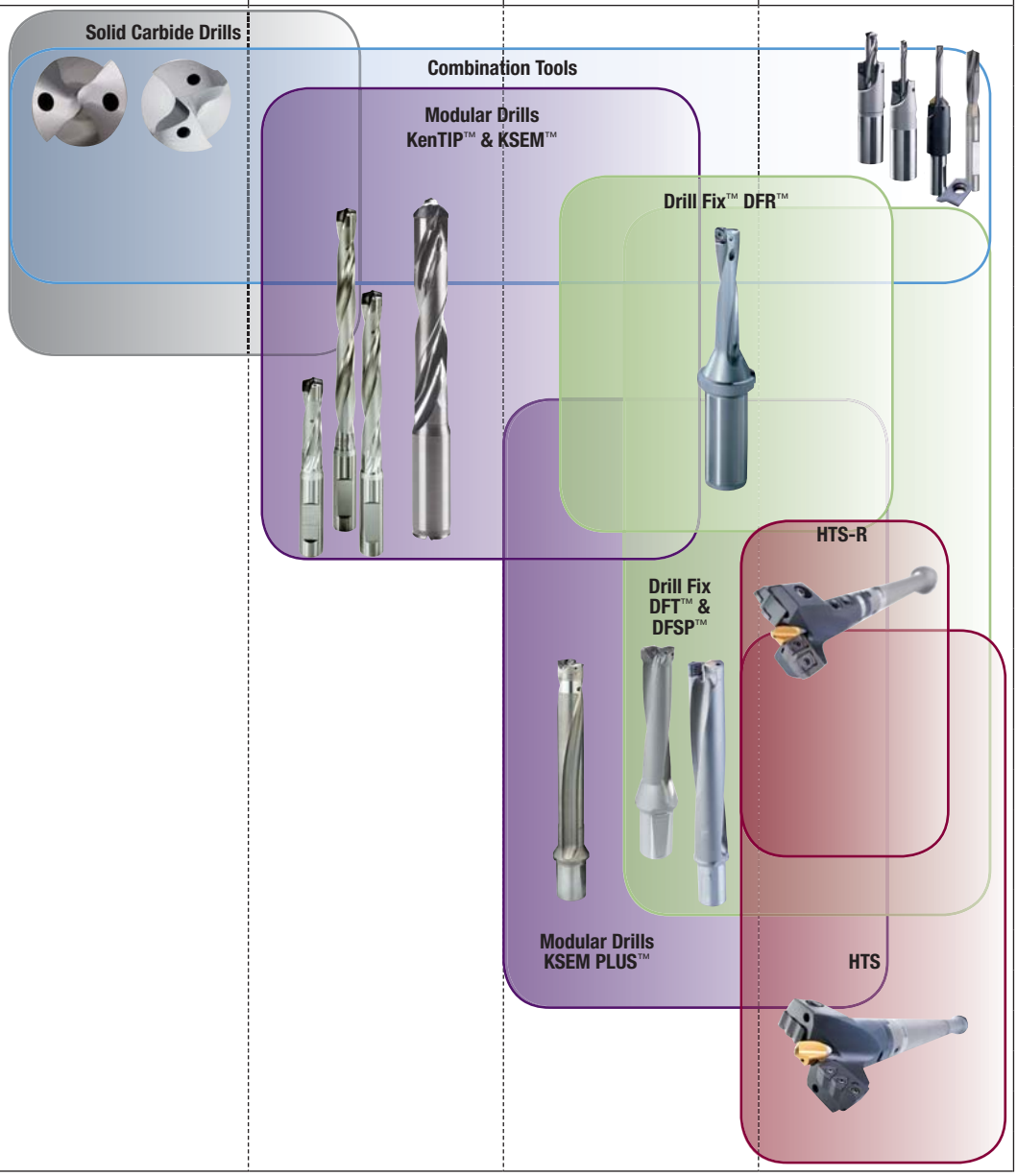
- Material and application-specific solutions.
- Maximum metal removal rates and repeatability.
- Standardised design platforms for special tools based on “proven solutions” for individual optimisations and combination tools.

Control of Total Tooling Costs

- High tool utilisation through material and application-specific solutions.
- Process-safe regrinding service.
- Reduction of stocks through efficient modular concepts.
- Multiple platforms per application to achieve the most cost-efficient solution.

Solid Drilling

diameter		hourly rate			
		high to normal	normal (M/C)	normal to low	low (rough)
		precision			
mm	inch	IT8	IT9	IT10	IT11
1,0	0.0393				
3,0	0.1181				
6,0	0.2362				
9,0	0.3543				
12,0	0.4724				
15,0	0.5906				
18,0	0.7087				
21,0	0.8268				
24,0	0.9449				
27,0	1.0630				
30,0	1.1811				
33,0	1.2992				
36,0	1.4173				
39,0	1.5354				
42,0	1.6535				
45,0	1.7717				
48,0	1.8898				
51,0	2.0079				
54,0	2.1260				
57,0	2.2441				
60,0	2.3622				
70,0	2.7559				
80,0	3.1496				
90,0	3.5433				
100,0	3.9370				
150,0	5.9055				
200,0	7.8740				
250,0	9.8425				
270,0	10				



(continued)

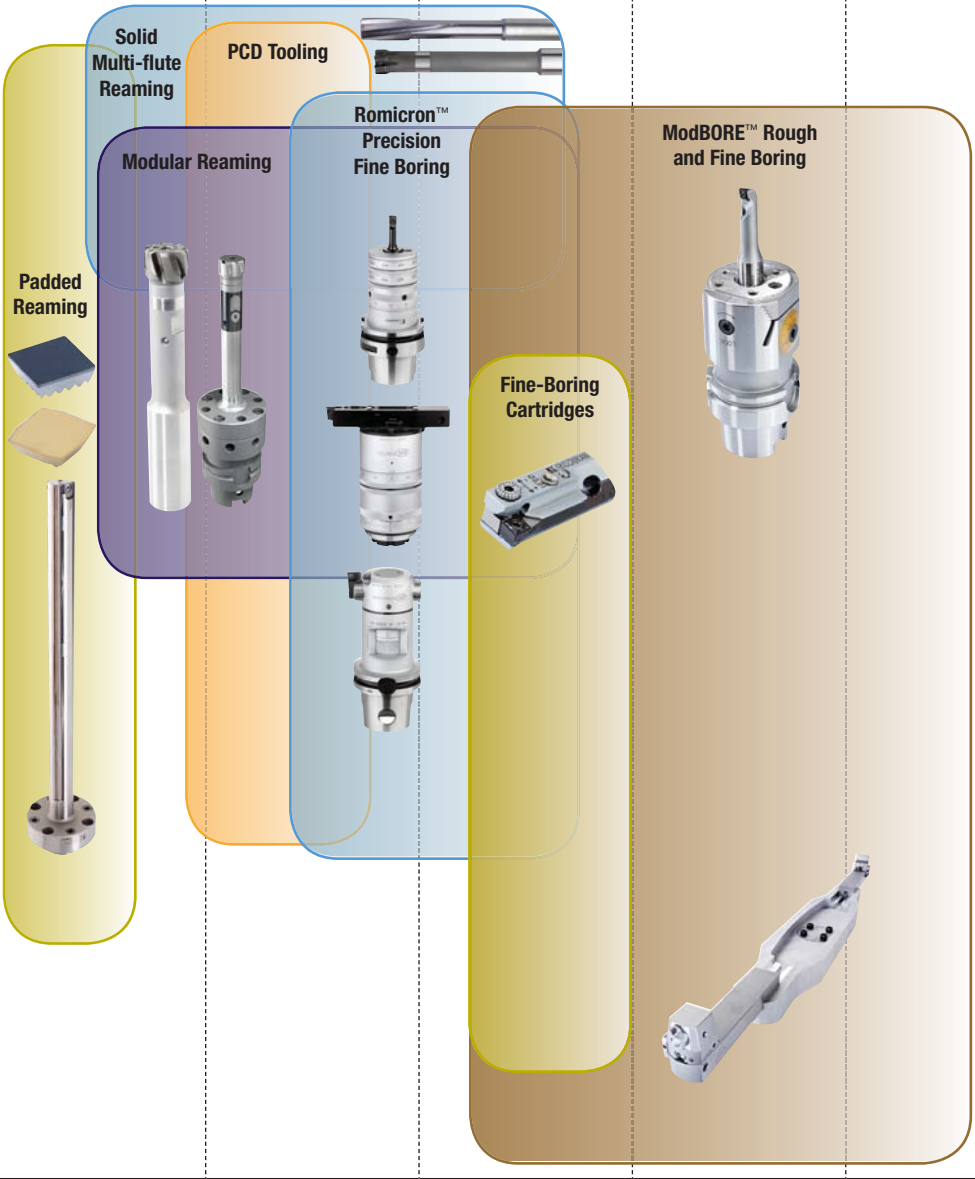
Select the Correct Holemaking Solution for Your Application *(continued)*

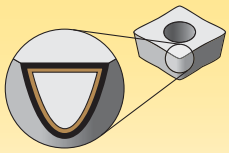
Optimised Purchase

- Broad selection of holemaking tools.
- Integrated into a full range of cutting tools and service offers.
- Onsite service for an efficient development and implementation of machining solutions.

Hole Finishing

diameter		hourly rate				
			very high	high (fine)	high to normal	normal (M/C)
		precision				
mm	inch	IT5	IT6	IT7	IT8	IT9
1,0	0.0393					
3,0	0.1181					
6,0	0.2362					
9,0	0.3543					
12,0	0.4724					
15,0	0.5906					
18,0	0.7087					
21,0	0.8268					
24,0	0.9449					
27,0	1.0630					
30,0	1.1811					
33,0	1.2992					
36,0	1.4173					
39,0	1.5354					
42,0	1.6535					
45,0	1.7717					
48,0	1.8898					
50,0	1.9685					
100,0	3.937					
150,0	5.9055					
200,0	7.878					
250,0	9.8425					
300,0	11.811					
400,0	15.748					
500,0	19.685					
1000,0	39.3701					
1500,0	59.0551					
2000,0	78.7402					
2500,0	98.4252					





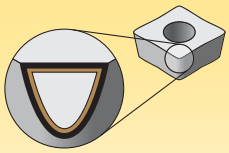
Coatings provide high-speed capability and are engineered for finishing to heavy roughing.

P	Steel
M	Stainless Steel
K	Cast Iron
N	Non-Ferrous
S	High-Temp Alloys
H	Hardened Materials
C	CFRP Materials

wear resistance ⟷ toughness

Solid Carbide Drill Grades

Coating	Grade Description	05	10	15	20	25	30	35	40	45
KN15	**Composition:** Uncoated, highly wear-resistant fine-grain carbide. **Application:** Highly polished chip flute surfaces ensure superior chip evacuation and reduce tendency for built-up edges. First choice for non-ferrous materials.			N	N	N				
					S	S				
KN25	**Composition:** Uncoated, highly wear-resistant ultra-fine-grain carbide. **Application:** Highly polished chip flute surfaces ensure superior chip evacuation and reduce tendency for built-up edges. First choice for deep-hole drilling of non-ferrous materials.									
				N	N	N	N			
K10	**Composition:** Uncoated, highly wear-resistant fine-grain carbide with enhanced hot hardness properties. **Application:** Best suited for dry and external flood coolant applications in aerospace materials like high-temperature resistant materials and wrought aluminium alloys. Due to its high wear-resistance, this grade is also applicable for cast iron machining at low to medium speeds.									
				K	K					
			N	N	N					
				S	S					
KCPK15	**Composition:** Multilayered PVD TiN-TiAlN coated fine-grain carbide with superior surface finish. **Application:** First choice for alloyed and high-alloyed steel and cast iron. A state-of-the-art surface condition enables superior chip evacuation and offers highest level of wear resistance at enhanced material removal rates.									
			P	P	P					
				K	K	K				
KCPK20	**Composition:** Multilayered PVD AlCrN-based coated ultra-fine-grain carbide with superior surface finish. **Application:** First choice for deep-hole drilling applications in steel and cast iron. Due to the uniquely developed coating combined with the state-of-the-art surface condition, this grade offers extraordinary wear resistance and superior chip evacuation.									
			P	P	P					
				K	K	K				
KCK10	**Composition:** Multilayered PVD AlCrN-based coated fine-grain carbide with superior surface finish. **Application:** First choice for cast iron. Due to the uniquely developed coating combined with the state-of-the-art surface condition, this grade offers extraordinary wear resistance in abrasive materials at elevated cutting conditions.									
				K	K					
KCMS15	**Composition:** Monolayer PVD AlTiN-coated fine-grain carbide with superior surface finish. **Application:** First choice for stainless steel and high-temperature-resistant materials. The coating offers high hardness and excellent wear resistance as well as enhanced high-temperature properties increasing its applicability also to MQL machining of steel.									
			P	P	P					
			M	M	M					
				S	S					



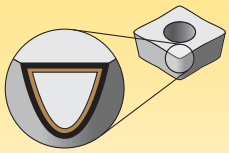
Coatings provide high-speed capability and are engineered for finishing to heavy roughing.

P	Steel
M	Stainless Steel
K	Cast Iron
N	Non-Ferrous
S	High-Temp Alloys
H	Hardened Materials
C	CFRP Materials

wear resistance ← → toughness

Solid Carbide Drill Grades

Coating	Grade Description		05	10	15	20	25	30	35	40	45
KCMS20	**Composition:** Monolayer PVD AlTiN-coated ultra-fine-grain carbide with superior surface finish. **Application:** First choice for deep-hole drilling of stainless steel and high-temperature resistant materials. Due to the coating's enhanced high-temperature properties, this grade can also be applied to MQL applications in steel.	P			■	■	■				
		M			■	■	■				
		S			■	■	■				
KCH10	**Composition:** PVD AlTiN coated, ultra-fine-grain carbide. **Application:** First choice for hardened steels >55 HRC up to 5 x D.										
		H	■	■	■						
KCH15	**Composition:** PVD AlTiN coated, fine-grain carbide. **Application:** First choice for hardened steels between 48 and 55 HRC as well as case-hardened workpieces with hole depths >3 x D.										
		H		■	■	■					
KC7315	**Composition:** Multilayered PVD TiN-TiAlN coated fine-grain carbide **Application:** Applicable for steel, cast iron, and hardened materials. This grade offers excellent wear resistance and reliability at intermediate to elevated cutting speeds.	P			■	■					
		K				■	■				
		H				■	■				
KC7325	**Composition:** Multilayered PVD TiN-TiAlN coated fine-grain carbide with a TiN top layer for better wear identification. **Application:** This multipurpose grade has been combined with a unique general-purpose cutting geometry to offer high versatility and reliability across all material groups at intermediate cutting conditions.	P				■	■	■			
		M					■	■			
		K				■	■	■			
		N		■	■	■					
		S				■	■				
		H				■	■				
KDF400	**Composition:** CVD diamond-coated fine-grain carbide. **Application:** First choice for machining carbon-fiber reinforced polymers (CFRPs). The crystalline diamond-coated grade offers a high degree of abrasive wear resistance. Paired with sharp cutting geometries and low-axial thrust point geometries, this grade is perfectly suited to machine most CFRPs.										
		C	■	■							



Coatings provide high-speed capability and are engineered for finishing to heavy roughing.

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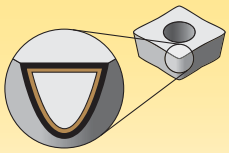
C	CFRP Materials

wear resistance ⟷ toughness

Modular Drill Grades

Coating	Grade Description		05	10	15	20	25	30	35	40	45
KCP15	**Composition:** Monolayer PVD AlTiN-coated fine-grain carbide. **Application:** First choice for steel and second choice for cast iron. This AlTiN coating offers the perfect combination of enhanced high-temperature properties and optimised toughness for high-performance modular drilling applications.	P		■	■	■					
		K			■	■	■				
KCP15A	**Composition:** Monolayer PVD AlTiN coated fine-grain carbide **Application:** First choice for steel and second choice for cast iron. This grade consists of an updated AlTiN coating offering improved high-temperature properties on top of the proven fine-grain carbide substrate offering required toughness for modular drilling applications.	P		■	■	■					
		K			■	■	■				
KC7135	**Composition:** PVD TiCN/TiN-coated medium-grain carbide with high toughness. **Application:** Used for KSEM™ PC pre-centring inserts in most materials. The highly wear-resistant TiCN coating combined with a tough carbide substrate are perfectly suited to help with pre-centring operations in metastable machining conditions.	P								■	■
		M							■	■	
		K							■	■	
		S					■	■			
KC7315	**Composition:** Multilayered PVD TiN-TiAlN-coated fine-grain carbide. **Application:** Applicable for steel and cast iron. This grade offers excellent wear resistance and reliability at intermediate to elevated cutting speeds.	P			■	■	■				
		K				■	■	■			
KC7320	**Composition:** Monolayer PVD AlTiN-coated fine-grain carbide. **Application:** First choice for stainless steel and high-temperature-resistant materials. The coating offers high hardness and excellent wear resistance as well as enhanced high-temperature properties.	M		■	■	■					
		S		■	■	■					
KC7410	**Composition:** Multilayered PVD AlCrN-based-coated fine-grain carbide. **Application:** First choice for cast iron. Due to the uniquely developed coating, this grade exhibits extraordinary wear resistance in abrasive materials offering the highest material removal rates.	K	■	■	■	■					
KCPM45	**Composition:** Multilayered PVD TiN-TiAlN-coated medium-grain carbide. **Application:** Applicable for steel and cast iron. This grade offers excellent wear resistance and reliability at intermediate cutting speeds. Due to the medium-grain carbide, it offers superior chipping resistance in metastable machining conditions.	P						■	■	■	■
		M						■	■	■	



Coatings provide high-speed capability and are engineered for finishing to heavy roughing.

P	Steel
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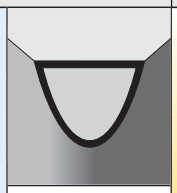
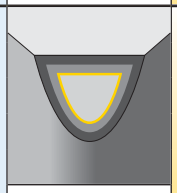
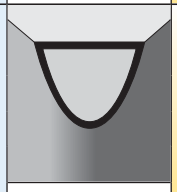
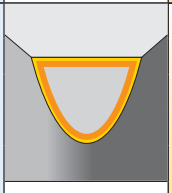
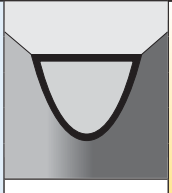
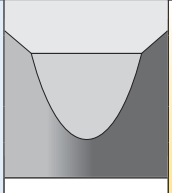
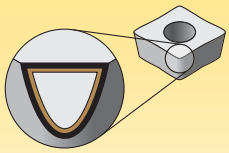
C	CFRP Materials

Modular Drill Grades

Coating		Grade Description		05	10	15	20	25	30	35	40	45
KCMS35		**Composition:** Monolayer PVD AlTiN-coated medium-grain carbide. **Application:** Applicable for stainless steel and high-temperature resistant materials. The coating offers high hardness and excellent wear resistance as well as enhanced high-temperature properties. In combination with its tough substrate, this grade offers superior chipping resistance and is best suited for metastable machining conditions.	M S									
KCU25		**Composition:** Advanced CVD TiCN-Al_2O_3 coating combined with a tough carbide substrate. **Application:** First choice for steel, stainless steel, and cast iron. This grade offers adequate deformation resistance, excellent edge strength, and superior wear resistance over a wide range of machining conditions for high productivity with very good reliability.	P M K									
KCU40		**Composition:** Multilayered PVD TiN-TiAlN-coated fine-grain carbide. **Application:** First choice for high reliability in most materials. This grade should be used at medium speeds and high feeds due to sharper cutting edges. As a grade developed for high toughness applications, it withstands interruptions and provides high wear resistance for long tool life. It covers steel, stainless steel, cast iron, and high-temp alloys under certain conditions.	P M K S									
KC7140		**Composition:** PVD TiCN/TiN-coated medium-grain carbide with high toughness. **Application:** Best suited for machining of steel and stainless steel. This exceptionally tough grade is perfectly suited for metastable machining conditions offering excellent tool life.	P M S									
KC7225		**Composition:** PVD TiAlN-coated fine-grain carbide with enhanced toughness. **Application:** Best suited for machining of most materials. This grade offers excellent process reliability in metastable conditions due to enhanced carbide toughness. The TiAlN coating improves wear resistance for use at intermediate cutting conditions.	M K N S									
K715		**Composition:** Uncoated, highly wear-resistant fine-grain carbide. **Application:** For use on KenTIP™ and KSEM™ made-to-order inserts when a sharp cutting edge is needed. Non-coated, polished carbide for drilling aluminium, titanium, and non-ferrous materials.	N S									

wear resistance ← → toughness



Coatings provide high-speed capability and are engineered for finishing to heavy roughing.

P	Steel
M	Stainless Steel
K	Cast Iron
N	Non-Ferrous
S	High-Temp Alloys
H	Hardened Materials
C	CFRP Materials

Indexable Drill Grades

Coating	Grade Description		05	10	15	20	25	30	35	40	45
KCPK10	**Composition:** Advanced CVD TiCN-Al_2O_3 coating combined with a cobalt-enriched carbide substrate. **Application:** The KCPK10™ grade offers a balanced combination of deformation resistance and edge toughness leading to outstanding abrasion and crater wear resistance for high-speed machining of steel and cast iron. Use for very high cutting speeds with low to medium feed rates.	P									
		K									
KCU25	**Composition:** Advanced CVD TiCN-Al_2O_3 coating combined with a tough carbide substrate. **Application:** First choice for steel, stainless steel, and cast iron. This grade offers adequate deformation resistance, excellent edge strength, and superior wear resistance over a wide range of machining conditions for high productivity with very good reliability.	P									
		M									
		K									
KCU40	**Composition:** Multilayered PVD TiN-TiAlN-coated fine-grain carbide. **Application:** First choice for high reliability in most materials. This grade should be used at medium speeds and high feeds due to sharper cutting edges. As a grade developed for high toughness applications, it withstands interruptions and provides high wear resistance for long tool life. It covers steel, stainless steel, cast iron, and high-temp alloys under certain conditions.	P									
		M									
		K									
KC7140	**Composition:** PVD TiCN/TiN-coated medium-grain carbide with high toughness. **Application:** Best suited for machining of steel and stainless steel. This exceptionally tough grade is perfectly suited for metastable machining conditions offering excellent tool life.	P									
		M									
KD1425	**Composition:** A multimodal PCD grade with a range of grain sizes brazed on carbide substrate. **Application:** Engineered for excellent abrasion resistance combined with good edge strength for demanding applications. An ideal choice for high-silicon aluminium alloys, MMCs, carbon fibre reinforced plastics, and other abrasive non-ferrous materials.	N									
		C									

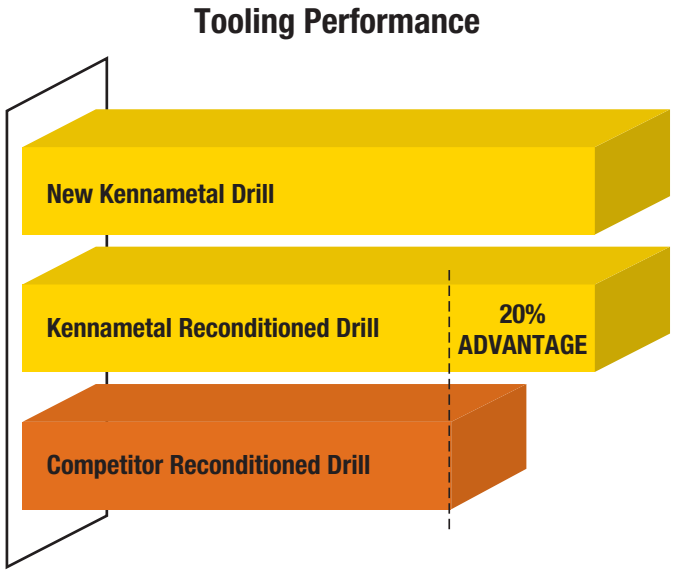
wear resistance ← → toughness

Why Reconditioning?

Reconditioning Services

Our Reconditioning Services optimise the value of your metalcutting tools by providing like-new performance to tools on-hand. Reconditioning tools is smart for business and the environment. You save money, reduce inventory, and avoid material waste.

Customers purchase Kennametal tooling for its high performance. Why not continue receiving that same high performance after each reconditioning cycle? Kennametal can help you reduce tooling costs by more than 50% versus purchasing new tools. Taking advantage of our innovative tooling designs provides even greater savings because the reconditioned tool continues to achieve the same like-new performance as the original purchase.



NOTE: Estimated value. Values vary based on machining conditions.

Kennametal keeps you performing at the highest productivity rates.

KENNAMETAL®

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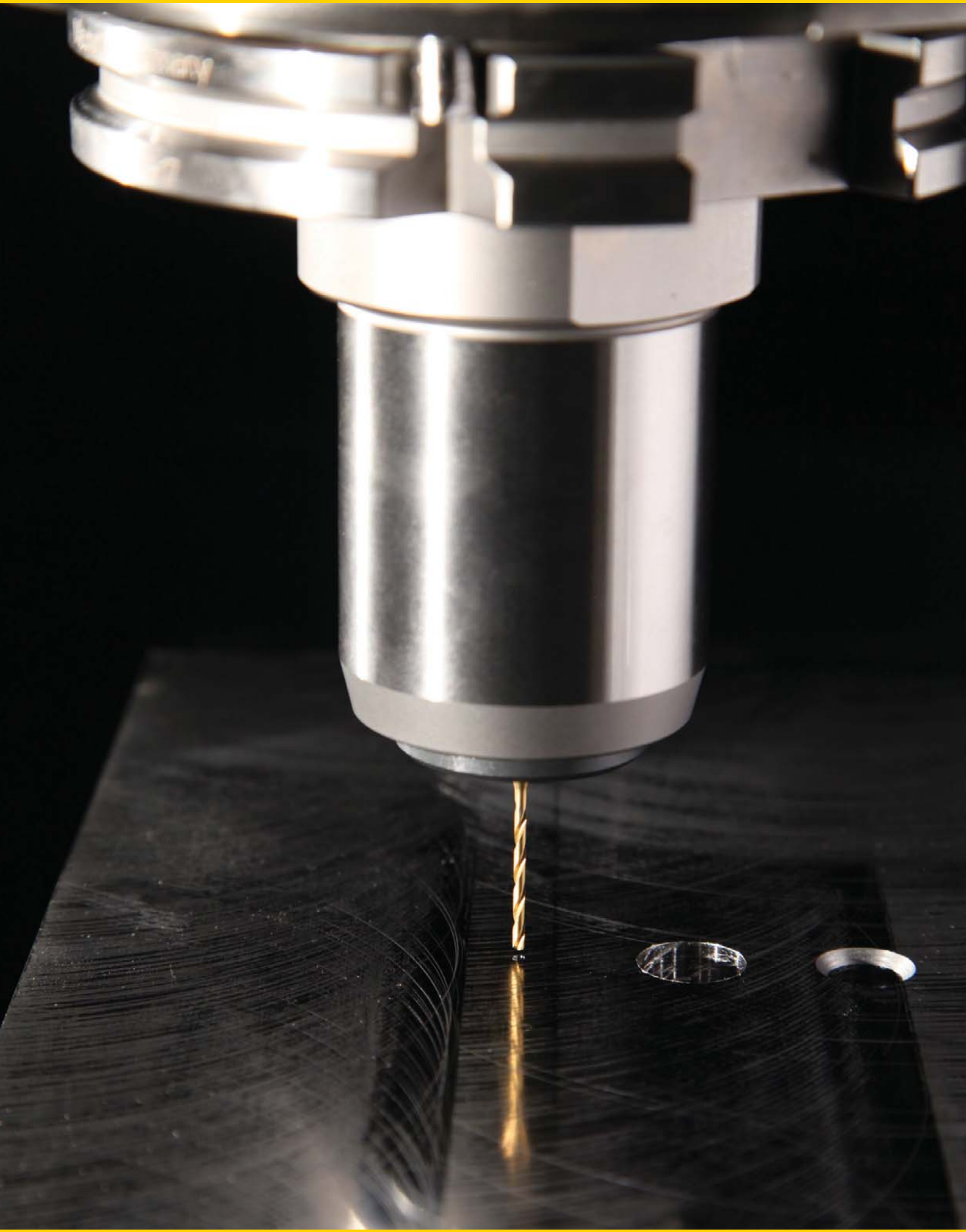


Solid Carbide Drills

Tool Selection Guide G2–G3

Solid Carbide Drills Dimension Tables and Recommendation Chart Foldout

GOdrill • Multiple Materials G6–G29

TF Drills • High Metal Removal Rates G30–G34

SGL Beyond Drills • Stainless Steel G36–G42

HP Beyond Drills • Steel G44–G55

YPC Beyond Drills • Iron Materials G56–G61

SE 4-Margin Drills • Steel G62–G64

HP Beyond 4-Margin, Long-Length Drills G66–G71

Deep-Hole Drills • Steel, Cast Iron, Stainless Steel, High-Temperature Alloys, and Non-Ferrous G72–G85

HPS Beyond Drills • Aluminium Machining G86–G91

Y-TECH Drills • Difficult-to-Machine Materials G92–G97

TX Drills • Close Tolerance Holes G98–G102

SPF Drills • CFRP G104–G105

DAL Drills • CFRP-Stacks G106–G111

Flat-Bottom Drills G112–G117

HP Beyond Step Drills G118–G122

KMH Drills • Hard Materials G124–G129

Kenna Universal Drills G130–G150

NC Spot Drills G152–G153

solid carbide drills for external coolant or dry machining		series	grade	standard* (● first choice ○ alternate choice) P	M	K	N	C	S	H	hole tolerance	standard range: diameter range D1 mm min–max	D1 inch min–max	drilling depth L/D1
	GOdrill™ for Multiple Materials	**B04_CPG**	**KC7325**	●	●	●	●		●	○	IT9–IT10	1,0–20,0	.0394–.7874	3–5 x
	**TF Drill** for High Metal Removal Rates	**B105**	**K10**			●	●		○		IT9–IT10	3,0–21,0	.1130–.8101	5 x D
	**HP Drill** for Dry Applications or Flood Coolant	**B221/B222_HP**	**KCPK15**	●		●					IT9–IT10	3,0–21,0	.1181–.8268	3–5 x
	**SPF Drill** for Composite (CFRP) Materials	**B53_SPF**	**KDF400**					●			IT9–IT10	3,2–12,7	.1260–.5010	3–5 x
	**DAL Drill** for CFRP — Metal Stack Materials	**B551_DAL**	**KN15**					●			IT9–IT10	4,763–15,875	.1875–.6250	3 x
	**NEW KMH Drill** for Hard Materials	**B941**	**KCH10**	○		○				●	IT9–IT10	2,5–14,0	.0984–.5512	3 x
	**KU Drill** for Universal Applications	**B966/B967**	**KC7315**	●		●	○				IT9–IT10	3,0–20,0	.1181–.7874	3–5 x
	**NC Spot Drill 120°** **NC Spot Drill 90°**	**B501** **B505**	**K10** **K10**	● ●	○ ○	● ●	○ ○		○ ○		– –	6,0–12,0 6,0–20,0	.2352–.4724 .2362–.7874	1 x D 1 x D

solid carbide drills with internal coolant channel		series	grade	standard* (● first choice ○ alternate choice) P	M	K	N	C	S	H	hole tolerance	standard range: diameter range D1 mm min–max	D1 inch min–max	drilling depth L/D1
	GOdrill™ for Multiple Materials	**B05_CPG**	**KC7325**	●	●	●	●		●	○	IT9–IT10	1,0–20,0	.0394–.7874	3–8 x
	**NEW SGL Drill** for Stainless Steel	**B21_SGL**	**KCMS15**	○	●				●		IT9–IT10	3,0–20,5	.1181–.8071	3–8 x
	**HP Drill** for Steel	**B224/B225_HP**	**KCPK15**	●		○					IT9–IT10	3,0–21,0	.1181–.8268	3–5 x
	**YPC Drill** for Cast Iron Materials	**B25_YPC**	**KCK10**			●					IT9–IT10	3,0–25,0	.1181–.9844	3–8 x
	**SE Drill** for Steel	**B256**	**KC7315**	●		○					IT9–IT10	5,0–16,0	.1969–.6299	8 x D
	Long-Length Drill for Steel, Iron, and Stainless Steel	**B269_HP**	**KCPK15**	●	○	○					IT9–IT10	3,0–20,0	.1181–.7874	12 x D
	**NEW Deep-Hole Drill** for Steel, Iron, and Non-Ferrous Materials for Stainless Steel and High-Temperature Alloys	**B27_HPG** **B27_HPS** **B27_SGL**	**KCPK20** **KN25** **KCMS20**	● ○	○ ●	●	 ●		 ●		IT9–IT10 IT9–IT10 IT9–IT10	2,4–16,0 2,4–16,0 2,4–16,0	.0938–.6299 .0938–.6299 .0938–.6299	15–40 x 15–40 x 15–40 x
	**HPS Drill** for Non-Ferrous Materials	**B28_HPS**	**KN15**				●				IT9–IT10	3,0–20,0	.1181–.7874	3–8 x
	**Y-TECH™ Drill** for High-Temperature Alloys	**B29_YPL**	**KC7315**	○	●				●		IT9–IT10	3,0–21,0	.1181–.8268	3–5 x
	**TX Drill** for Close Tolerance Holes	**B411**	**KF1**			●	●				IT8–IT9	3,2–25,0	.1250–.9843	5 x D
	**DAL Drill** for CFRP — Metal Stack Materials	**B556_DAL**	**KN15**					●			IT9–IT10	4,763–15,875	.1875–.6250	3 x
	**Flat-Bottom Drill** for Flat-Bottom Applications	**B707_FBG** **B707_FBL** **B707_FBS**	**KC7315** **KCMS15** **KN15**	●	 ●	●	 ●		 ●		IT9–IT10 IT9–IT10 IT9–IT10	3,0–21,0 3,0–21,0 3,0–21,0	.1181–.8268 .1181–.8268 .1181–.8268	3 x D 3 x D 3 x D
	**HP Step Drill** for Steel and Iron	**B73_HP**	**KCPK15**	●		●					IT9–IT10	3,7–19,45	.1470–.7656	short, long
	**NEW KMH Drill** for Hard Materials	**B951**	**KCH15**	○		○				●	IT9–IT10	3,0–16,0	.1181–.6299	3 x
	**KU Drill** for Universal Applications	**B97_**	**KC7315**	●	○	●	○		○		IT9–IT10	2,4–20,0	.0938–.7874	3–8 x

*In regard to coatings, anything is possible. If a specific drill is not suitable for your workpiece material, please contact our Engineered Solutions Department for an offer about special coatings and edge preparations.

*1 Drills be can optimised for performance in specific applications. Ask your local Kennametal representative about Kennametal Custom Solutions service for special coatings, grades, or geometries to increase productivity.

*2 Step Drill Capability Guidelines: 5 steps maximum; 10 different shapes; at least 0,4mm difference in diameters; the largest diameter may not exceed the smallest diameter by more than 2x.

custom solution range			■ standard □ custom solution capabilities																				
diameter range																							
D1 mm	D1 in	drilling depth																					page(s)
min-max	min-max																						
1,0–20,0	.0394–.7874	1.5–12 x	■				■			■			□	□				□	■	■	□		G6
3,0–25,0	.1130–1.00	1.5–8 x	■	■			■			■			□	□		■		□	■	□			G30
3,0–25,0	.1181–1.00	1.5–8 x	■	■			■			■			□	□	■		□	□	■	□			G44
3,0–25,0	.1181–1.00	1.5–5 x	■	■			■			■			□	□				□	■	□			G104
3,0–25,0	.1181–1.00	1.5–5 x	■	■			■	□		■			□	□	■		□	□	■	□			G106
2,5–20,0	.0984–.7874	1.5–8 x	■				■			■			□		■		□	□	■	□			G124
3,0–25,0	.1181–1.00	1.5–8 x	■	■			■	■		■			□	□	□		■	■	■	■			G130
6,0–20,0 6,0–20,0	.2362–.7874 .2362–.7874	1 x D 1 x D	■ ■																				G152

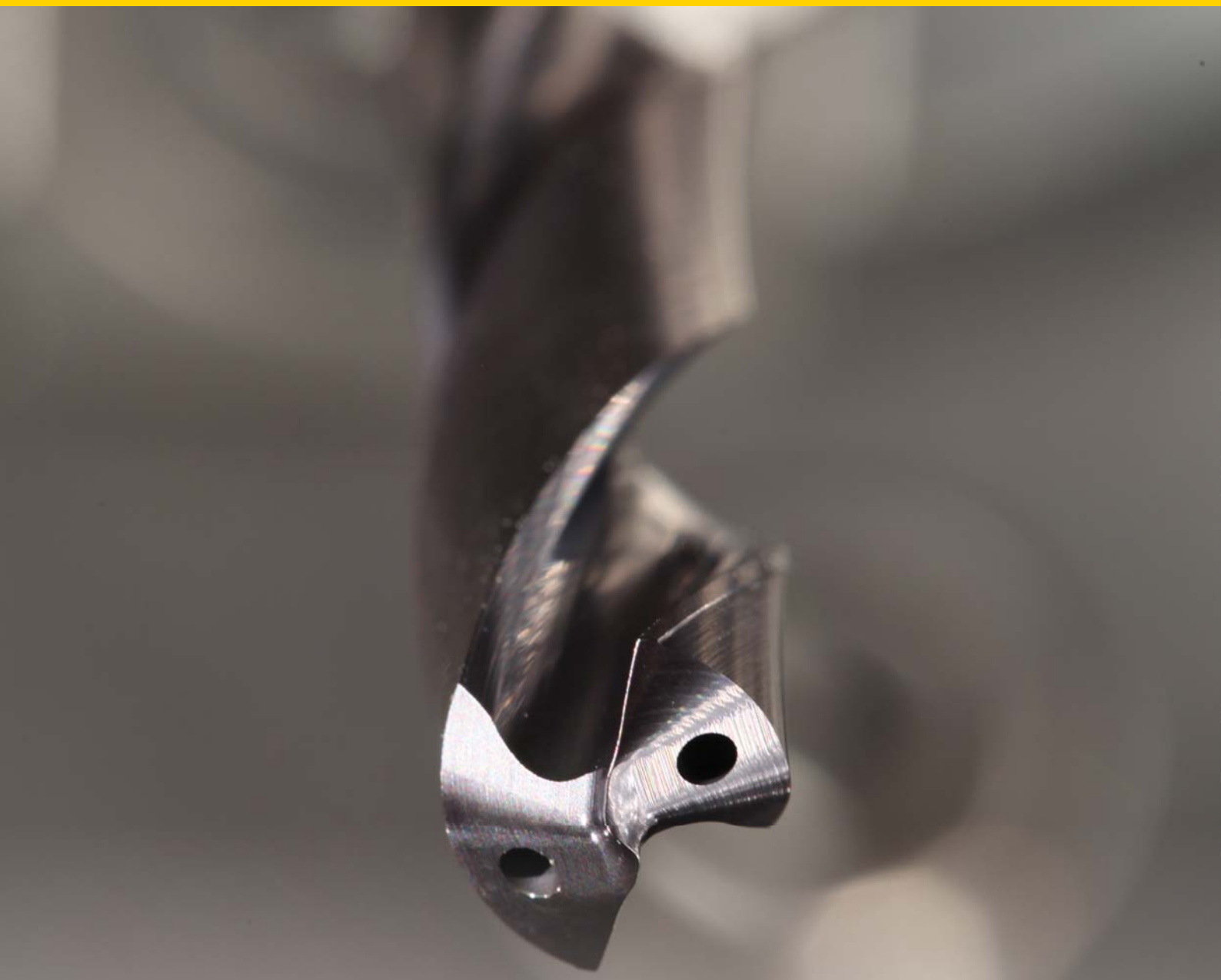
custom solution range			■ standard □ custom solution capabilities																				
diameter range																							
D1 mm	D1 in	drilling depth																					page(s)
min-max	min-max																						
1,0–20,0	.0394–.7874	1.5–12 x			■	■	■			■			□	□				□	■	■	□		G18
3,0–25,0	.1181–1.00	1.5–8 x			■		■			■			□	□	■		□	□	■	□			G36
3,0–25,0	.1181–1.00	1.5–5 x			■	■	■			■			□	□	■		□	□	■	□			G44
3,0–25,0	.1181–1.00	1.5–8 x			■	■	■	■		■			□	□		■		■	■	□			G56
3,0–25,0	.1181–1.00	1.5–12 x			■	■	■	■		■			□	□	□		■	□	■	□			G62
3,0–25,0	.1181–.7874	1.5–12 x			■	■	■	■		■			□	□	□		■	□	■	□			G66
2,4–16,0 2,4–16,0 2,4–16,0	.0938–.6299 .0938–.6299 .0938–.6299	500mm 500mm 500mm			■ ■ ■	■ ■ ■	■ ■ ■	■ ■ ■		■ ■ ■					□ □ □		■ ■ ■	□ □ □	■ ■ ■	□ □ □			G72
3,0–25,0	.1181–.7874	3–8 x			■	■	■						□	□	■		□	□	■	□			G86
3,0–25,0	.1181–1.00	1.5–8 x			■	■	■	■		■			□	□		■		□	■	□			G92
3,0–25,0	.1181–1.00	1.5–12 x			■	■	■	■	■	■	■		□	□	□		■	□	■	□			G98
3,0–25,0	.1181–1.00	1.5–5 x			■	■	■	□		■			□	□	■		□	□	■	□			G106
3,0–25,0 3,0–25,0 3,0–25,0	.1181–1.00 .1181–1.00 .1181–1.00	1.5–8 x 1.5–8 x 1.5–8 x			■ ■ ■	■ ■ ■	■ ■ ■	■ ■ ■	■ ■ ■		■ ■ ■	■ ■ ■	□ □ □	□ □ □	□ □ □		■ ■ ■	■ ■ ■	■ ■ ■	□ □ □			G112
3,0–25,0	.1181–1.00	1.5–8 x			■	■	■						■	■	■		□	□	■	□			G118
3,0–20,0	.1181–.7874	1.5–12 x			■		■	□		■			□	□	■		□	□	■	□			G127
2,4–25,0	.1181–1.00	1.5–12 x			■	■	■	■		■			□	□	□		■	□	■	■			G130

*3 Drill Shank Configuration Guidelines: shank diameter may be 2 “steps” larger than the standard shank in relation to the drill diameter or 1 step smaller than the standard shank. i.e. If the standard drill has 6mm shank, shank could be changed to 4mm, 8mm, or 10mm.

4 On symmetrical 2-fluted drills the following point geometries are possible: Split point (SP), Cone point (KM*), HP* point, SE* point, FB* point & FE* point; except for GOdrill™ which is limited to CP* point.

5 On asymmetrical 2-fluted drills (Y-TECH™) the Cone point and HP point are possible.

KENNAMETAL®



High-Performance Solid Carbide Drills

NOVO KNOWS SEARCH

Searching for a tool has been enhanced by Advise and Select functions from NOVO™ applications — saving you time and money.

ADVISE

Uses a rules-based approach to provide cutting tool recommendations:

- Define Machining Feature (face milling, slotting, blind hole, etc.)
- Apply Constraint Requirements (geometric, material, tolerance, etc.)
- Set Machining Sequence (single or multi-step operations, rough then finish, etc.)
- Receive Ranked Results

SELECT

A method of selecting cutting tools from a tree structure via a hierarchy or parametric search:

- If you know which product you are looking for, a quick search can be performed by just the catalogue number or product description.
- Smart filters significantly reduce the amount of potential tooling solutions.
- After the tool is selected, NOVO also provides cutting and adaptive item options that fit with your solution.

NOVO applications can ensure you have the right tools on your machines, in the right sequence. Resulting in flawless execution that accelerates every job, and maximises every shift. **kennametal.com/novo**

Solid Carbide Drills • Recommendation Chart

Material Specific

standard first choice = **bold** alternate choice = regular simple special = grey	through coolant	flood coolant	MQL
P — Steels	**B224*HP** **B225*HP** B226*HP **B256**	**B221*HP** **B222*HP**	**B224*HP** **B225*HP** B226*HP **B256**
M — Stainless Steels	**B210*SGL** **B211*SGL** **B212*SGL**		
K — Cast Iron	**B254*YPC** **B255*YPC** **B256*YPC**	B105	**B254*YPC** **B255*YPC** **B256*YPC**
N — Non-Ferrous	**B284*HPS** **B285*HPS** **B286*HPS** **B411**	B105	**B284*HPS** **B285*HPS** **B286*HPS**
C1 — CFRP, CFRP/CFRP		**B531A** **B532A** B533AA	
C2 — CFRP/Non-Ferrous **C3 — CFRP/High-Temp** **C4 — CFRP/Stainless Steel**	B546A/**B556A** B547A/B557A B548A/B558A	B541A/**B551A** B542A/B552A B543A/B553A	B546A/**B556A** B547A/B557A B548A/B558A
S — Heat-Resistant Alloys, Titanium Alloys	**B291*YPL** **B292*YPL**		
H — Hardened Materials	B951/**B952**/B953 B955/B956/B957 B958/B959	B941/**B942**/B943 B945/B946/B947	

Application-Specific Solid Carbide Drills

Kennametal material-specific drills are targeted to end users with mass production and the need for very long tool life in a specific material, high cutting feeds and speeds, and reduced cost per part through time optimisation with high metal removal rates.

Application-specific drills are designed to solve certain machining operations, such as deep-hole drilling or flat-bottom drilling, to save cycle times and costs.

HP Beyond™ Drill Series is available for different materials offering highest cutting parameters and long tool life. These ultimate high-volume production tools, such as the all-new drill for aluminium, are often platform for make-to-order or Custom Solutions.

Application Specific				Versatile
dry	**deep hole**	**flat bottom**	**drill and chamfer**	**universal**
B221*HP **B222*HP**	**B269*HP** **B271*HPG** **B272*HPG** **B273*HPG** **B274*HPG** **B275*HPG**	B706*FBG **B707*FBG** B708*FBG B709*FBG	**B731*HP** **B732*HP**	**B966, B967** **B976, B977, B978** **B041*CPG, B042*CPG** **B051*CPG, B052*CPG,** **B053*CPG**
	B269*HP **B271*SGL** **B272*SGL** **B273*SGL** **B274*SGL** **B275*SGL**	B706*FBL **B707*FBL** B708*FBL B709*FBL		B966, B967 B976, B977, B978 **B041*CPG, B042*CPG** **B051*CPG, B052*CPG,** **B053*CPG**
B105	**B269*HP** **B271*HPG** **B272*HPG** **B273*HPG** **B274*HPG** **B275*HPG**	B706*FBG **B707*FBG** B708*FBG B709*FBG	**B731*HP** **B732*HP**	**B966, B967** **B976, B977, B978** **B041*CPG, B042*CPG** **B051*CPG, B052*CPG,** **B053*CPG**
	B271*HPS **B272*HPS** **B273*HPS** **B274*HPS** **B275*HPS**	B706*FBS **B707*FBS** B708*FBS B709*FBS		B966, B967 B976, B977, B978 B041*CPG, B042*CPG B051*CPG, B052*CPG, B053*CPG
B531A **B532A** B533AA				
B541A/**B551A** B542A/B552A B543A/B553A				
		B706*FBL **B707*FBL** B708*FBL B709*FBL		B966, B967 B976, B977, B978 **B041*CPG, B042*CPG** **B051*CPG, B052*CPG,** **B053*CPG**

Versatile Solid Carbide Drills

Kennametal versatile drills are targeted to end users with the need for long tool life in many materials, versatility and saving time for tool changes, and reducing the capital spent on a variety of SC Drill styles on the shelf.

The GOdrill™ is a multi-material drill. It addresses drilling operations in a diameter range of 1–20mm in a broad variety of materials and applications, such as fuel systems or medical components. Due to its very unique design, the GOdrill expands the advantages of modular drills into the small diameter range, enabling the full utilisation of the drill's tool life capacity.

The Kenna Universal™ Drill is a multi-purpose drill. It is engineered to deliver superior performance in steel, cast iron, and stainless steel applications, making it ideal for small- and medium-sized shops. The universal application profile reduces tool change times and the number of drills in inventory. Covering a large spectrum of off-the-shelf diameters and a broad range of applications makes Kenna Universal Drills an excellent alternative to other high-performance products.

Solid Carbide Drills • Dimension Tables

Dimensions for Kennametal Solid Carbide Drills (B_Series) • Metric

mm Ø		DIN 6535		SHORT* ~3 x D			LONG* ~5 x D			EXTRA LONG** ~8 x D			EXTRA LONG** NEW 8 x D (SGL)		
D1 min	D1 max	D	LS	L	L3	L4 max	L	L3	L4 max	L	L3	L4 max	L	L3	L4 max
1,000	1,400	4	28	58	7	5	58	9	6	58	12	10	–	–	–
1,401	1,900	4	28	58	9	6	58	12	9	58	18	15	–	–	–
1,901	2,300	4	28	58	13	9	58	18	14	66	26	22	–	–	–
2,301	2,999	4	28	58	17	12	58	22	17	66	30	25	–	–	–
3,000	3,750	6	36	62	20	14	66	28	23	78	40	33	78	40	33
3,751	4,750	6	36	66	24	17	74	36	29	87	49	41	87	49	41
4,751	6,000	6	36	66	28	20	82	44	35	94	56	48	94	56	48
6,001	7,000	8	36	79	34	24	91	53	43	105	67	57	105	67	57
7,001	8,000	8	36	79	41	29	91	53	43	110	72	61	121	82	64
8,001	10,000	10	40	89	47	35	103	61	49	122	80	68	145	102	80
10,001	12,000	12	45	102	55	40	118	71	56	141	94	79	170	122	96
12,001	14,000	14	45	107	60	43	124	77	60	155	108	91	190	142	112
14,001	16,000	16	48	115	65	45	133	83	63	171	121	101	213	162	128
16,001	18,000	18	48	123	73	51	143	93	71	185	135	113	232	181	144
18,001	20,000	20	50	131	79	55	153	101	77	200	148	124	254	201	160
20,001	22,000	20	50	141	86	60	167	112	85	217	162	136	274	221	176
22,001	25,000	25	56	153	95	65	184	126	98	238	180	150	310	251	200

* D1<20mm to DIN 6537K
D1>20mm to factory standard
** To factory standard

NOTE: Solid Carbide Drills from Kennametal in short and regular lengths conform to DIN 6537.
Drills with long lengths conform to Kennametal factory standard.
Solid Carbide Drills with diameter D1>20mm (not DIN 6537) are also standardised to factory standard.

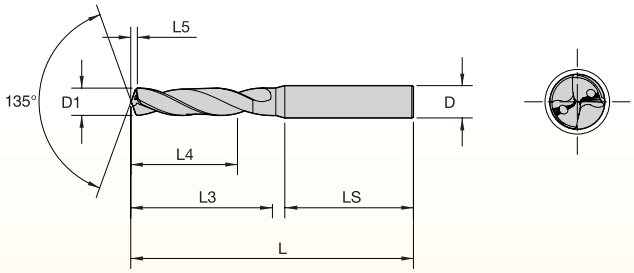
Shank designs to DIN 6535



Form HE,
2° angle
Design F



Form HA,
straight round
Design A

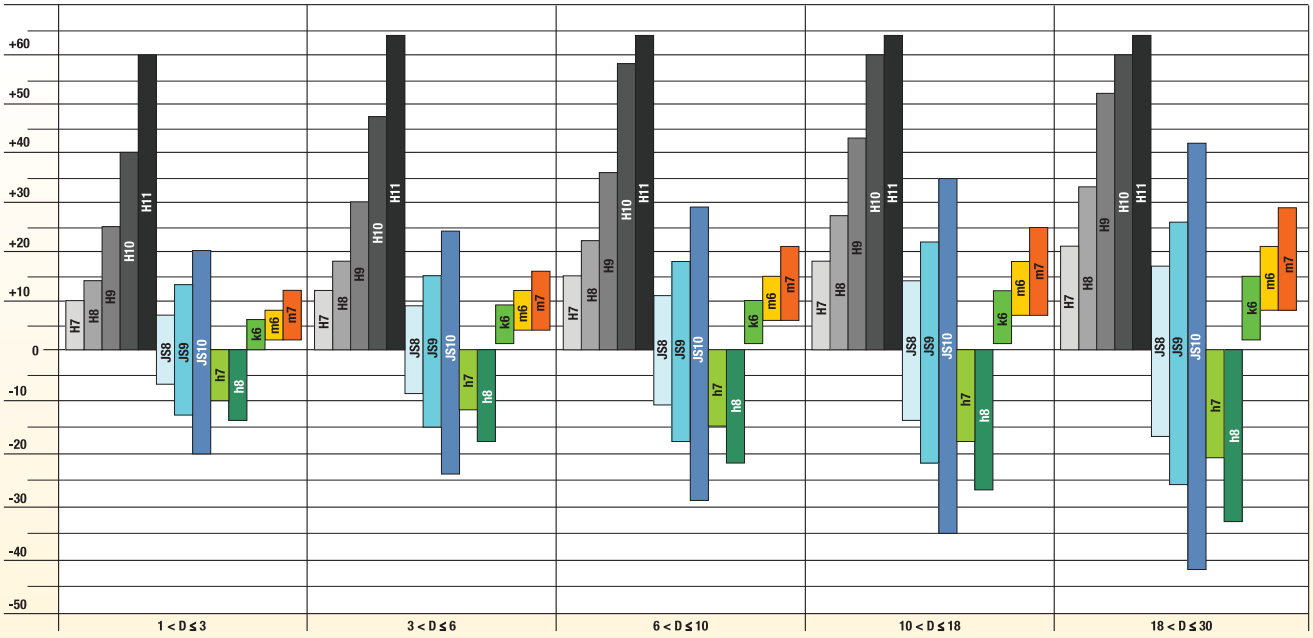


Holemaking Drilling Portfolio • Diameter Tolerances

Hole tolerances which can be achieved with solid carbide drills are listed in the table below.
Achievable tolerances depend on the application (machining conditions, material etc.) and may deviate from the list below.
Hole accuracy might decline with increasing drill length.
Other drilling tolerances require special solid carbide drill solutions.

drill type	drill tolerance	hole tolerance	hole tolerance (best*)	drill series
GO	h8	JS10	JS9	B04*CPG, B05*CPG ≤3mm
	h7	JS9	JS8	B04*CPG, B05*CPG ≥3mm
TF	m7	H9	H8	B105
HP/SGL	m7	H9	H8	B21*SGL, B22*HP, B269*HP
YPC	m7	H9	H8	B25*YPC
SE	m7	H9	H8	B256
HPG/SGL	h7	JS9	JS8	B27*HPG, B27*KMG, B27*SGL
HPS	h7	JS9	JS8	B27*HPS, B27*KMS
HPS	m7	H9	H8	B28*HPS
Y-TECH	m7	H9	H8	B29*YPL
BF	h7	JS9	JS8	B343
SPF	m7	H10	H9	B53*SPF
TX	k6	H8	H7	B41* ≤5 x D
	k6	H9	H8	B41* ≥5 x D
DAL	k6	H8	H7	B54*, B55* ≤5 x D
	k6	H9	H8	B54*, B55* ≥5 x D
FB*	m7	H11	H9	B70*FBG, B70*FBL
	m7	H10	H8	B70*FBS
KMH	m7	H9	H8	B94*, B95*
KU	m7	H9	H8	B96*, B97*

* Can be achieved in very good conditions.



Achievable hole tolerance in µm per diameter range (mm).
Tolerance table according to DIN EN ISO 286-1.

GOdrill™

For Multiple Materials

Primary Application

The GOdrill platform addresses drilling operations in a diameter range of 1–20mm in a broad variety of materials and applications such as fuel systems or medical components. Due to its very unique design, the GOdrill platform expands the advantages of modular drills into the small diameter range: high-end grades, wear-indicator coating, and new, proprietary geometries enable full utilisation of the drill's tool life capacity. The GOdrill platform qualifies as a very cost-effective, throwaway-type tool in the given diameter range.

Features and Benefits

GOdrill Design

- Marginless design for reduced friction and heat — thus longer tool life.
- Very versatile tool works in a wide range of materials.
- Cost-effective, no regrind logistics.
- No setup.
- Throw away or recycle.
- Through-coolant option down to diameter 1mm.

CPG Point

- Optimised gashing design for microdrilling ensures free flow of chips in the centre of the drill.
- Excellent centring capabilities.
- Reduced axial forces.
- Good hole quality, roundness, and cylindricity for all materials.

The high-performance solid carbide drill tailored for very small- to medium-diameter drilling applications.

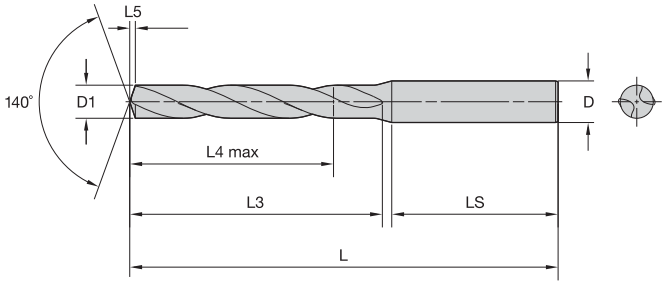


KC7325™ Grade

The grade contains a double coating:

- The multilayer, TiAlN-based coating with high hot hardness enables the drill to run at high cutting speeds as well as in MQL applications.
- A TiN top layer serves as wear indicator for easier monitoring on small drills, which can be difficult to see.
- Improved visibility of wear helps to utilise the tool's full tool life capacity.

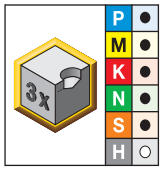


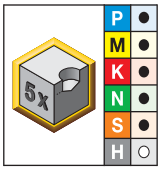




For information on L, L3, and L4 max, see the Solid Carbide Drills foldout table.

B041A/B042A • ~3 x D/~5 x D



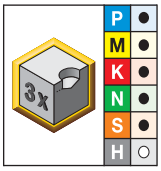


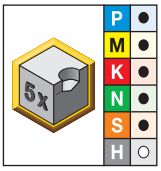
● first choice
○ alternate choice

short • KC7325	long • KC7325	D1 diameter mm	D1 diameter in	L5	LS	D
B041A01000CPG	B042A01000CPG	1,000	.0394	0,1	28	4
B041A01016CPG	B042A01016CPG	1,016	.0400	0,1	28	4
B041A01041CPG	B042A01041CPG	1,041	.0410	0,2	28	4
B041A01067CPG	B042A01067CPG	1,067	.0420	0,2	28	4
B041A01092CPG	B042A01092CPG *	1,092	.0430	0,2	28	4
B041A01100CPG	B042A01100CPG	1,100	.0433	0,2	28	4
B041A01181CPG	B042A01181CPG	1,181	.0465	0,2	28	4
B041A01191CPG	B042A01191CPG	1,191	.0469	0,2	28	4
B041A01200CPG	B042A01200CPG	1,200	.0472	0,2	28	4
B041A01300CPG	B042A01300CPG	1,300	.0512	0,2	28	4
B041A01321CPG	B042A01321CPG	1,321	.0520	0,2	28	4
B041A01397CPG	B042A01397CPG	1,397	.0550	0,2	28	4
B041A01400CPG	B042A01400CPG	1,400	.0551	0,2	28	4
B041A01500CPG	B042A01500CPG	1,500	.0591	0,2	28	4
B041A01600CPG	B042A01600CPG	1,600	.0630	0,2	28	4
B041A01700CPG	B042A01700CPG	1,700	.0669	0,3	28	4
B041A01800CPG	B042A01800CPG	1,800	.0709	0,3	28	4
B041A01900CPG	B042A01900CPG	1,900	.0748	0,3	28	4
B041A01984CPG	B042A01984CPG	1,984	.0781	0,3	28	4
B041A02000CPG	B042A02000CPG	2,000	.0787	0,3	28	4
B041A02100CPG	B042A02100CPG	2,100	.0827	0,3	28	4
B041A02200CPG	B042A02200CPG	2,200	.0866	0,3	28	4
B041A02300CPG	B042A02300CPG	2,300	.0906	0,4	28	4
B041A02383CPG	B042A02383CPG	2,383	.0938	0,4	28	4
B041A02400CPG	B042A02400CPG	2,400	.0945	0,4	28	4
B041A02439CPG	B042A02439CPG	2,439	.0960	0,4	28	4
B041A02489CPG	B042A02489CPG	2,489	.0980	0,4	28	4
B041A02500CPG	B042A02500CPG	2,500	.0984	0,4	28	4
B041A02578CPG	B042A02578CPG	2,578	.1015	0,4	28	4
B041A02600CPG	B042A02600CPG	2,600	.1024	0,4	28	4
B041A02642CPG	B042A02642CPG	2,642	.1040	0,4	28	4
B041A02700CPG	B042A02700CPG	2,700	.1063	0,4	28	4

(continued)

(B041A/B042A • ~3 x D/~5 x D — continued)



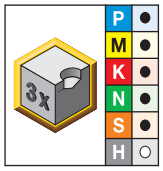


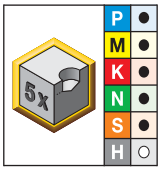
● first choice
○ alternate choice

short • KC7325	long • KC7325	D1 diameter mm	D1 diameter in	L5	LS	D
B041A02705CPG	B042A02705CPG	2,705	.1065	0,4	28	4
B041A02779CPG	B042A02779CPG	2,779	.1094	0,4	28	4
B041A02800CPG	B042A02800CPG	2,800	.1102	0,5	28	4
B041A02820CPG	B042A02820CPG	2,820	.1110	0,5	28	4
B041A02870CPG	B042A02870CPG	2,870	.1130	0,5	28	4
B041A02900CPG	B042A02900CPG	2,900	.1142	0,5	28	4
B041A02947CPG	B042A02947CPG	2,947	.1160	0,5	28	4
B041A03000CPG	B042A03000CPG	3,000	.1181	0,5	36	6
B041A03048CPG	B042A03048CPG	3,048	.1200	0,5	36	6
B041A03100CPG	B042A03100CPG	3,100	.1220	0,5	36	6
B041A03175CPG	B042A03175CPG	3,175	.1250	0,5	36	6
B041A03200CPG	B042A03200CPG	3,200	.1260	0,5	36	6
B041A03264CPG	B042A03264CPG	3,264	.1285	0,5	36	6
B041A03300CPG	B042A03300CPG	3,300	.1299	0,5	36	6
B041A03400CPG	B042A03400CPG	3,400	.1339	0,6	36	6
B041A03455CPG	B042A03455CPG	3,455	.1360	0,6	36	6
B041A03500CPG	B042A03500CPG	3,500	.1378	0,6	36	6
B041A03571CPG	B042A03571CPG	3,571	.1406	0,6	36	6
B041A03600CPG	B042A03600CPG	3,600	.1417	0,6	36	6
B041A03658CPG	B042A03658CPG	3,658	.1440	0,6	36	6
B041A03700CPG	B042A03700CPG	3,700	.1457	0,6	36	6
B041A03734CPG	B042A03734CPG	3,734	.1470	0,6	36	6
B041A03800CPG	B042A03800CPG	3,800	.1496	0,6	36	6
B041A03900CPG	B042A03900CPG	3,900	.1535	0,6	36	6
B041A03970CPG	B042A03970CPG	3,970	.1563	0,7	36	6
B041A04000CPG	B042A04000CPG	4,000	.1575	0,7	36	6
B041A04039CPG	B042A04039CPG	4,039	.1590	0,7	36	6
B041A04090CPG	B042A04090CPG	4,090	.1610	0,7	36	6
B041A04100CPG	B042A04100CPG	4,100	.1614	0,7	36	6
B041A04200CPG	B042A04200CPG	4,200	.1654	0,7	36	6
B041A04217CPG	B042A04217CPG	4,217	.1660	0,7	36	6
B041A04300CPG	B042A04300CPG	4,300	.1693	0,7	36	6
B041A04366CPG	B042A04366CPG	4,366	.1719	0,7	36	6
B041A04400CPG	B042A04400CPG	4,400	.1732	0,7	36	6
B041A04500CPG	B042A04500CPG	4,500	.1772	0,7	36	6
B041A04600CPG	B042A04600CPG	4,600	.1811	0,8	36	6
B041A04623CPG	B042A04623CPG	4,623	.1820	0,8	36	6
B041A04700CPG	B042A04700CPG	4,700	.1850	0,8	36	6
B041A04763CPG	B042A04763CPG	4,763	.1875	0,8	36	6
B041A04800CPG	B042A04800CPG	4,800	.1890	0,8	36	6
B041A04852CPG	B042A04852CPG	4,852	.1910	0,8	36	6
B041A04900CPG	B042A04900CPG	4,900	.1929	0,8	36	6
B041A05000CPG	B042A05000CPG	5,000	.1969	0,8	36	6
B041A05100CPG	B042A05100CPG	5,100	.2008	0,8	36	6
B041A05106CPG	B042A05106CPG	5,106	.2010	0,8	36	6
B041A05159CPG	B042A05159CPG	5,159	.2031	0,9	36	6
B041A05200CPG	B042A05200CPG	5,200	.2047	0,9	36	6
B041A05300CPG	B042A05300CPG	5,300	.2087	0,9	36	6
B041A05400CPG	B042A05400CPG	5,400	.2126	0,9	36	6
B041A05410CPG	B042A05410CPG	5,410	.2130	0,9	36	6
B041A05500CPG	B042A05500CPG	5,500	.2165	0,9	36	6
B041A05558CPG	B042A05558CPG	5,558	.2188	0,9	36	6

(continued)

(B041A/B042A • ~3 x D/~5 x D — continued)



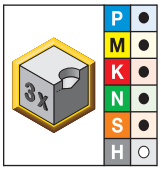


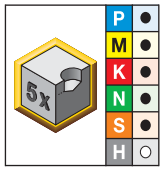
● first choice
○ alternate choice

short • KC7325	long • KC7325	D1 diameter mm	D1 diameter in	L5	LS	D
B041A05600CPG	B042A05600CPG	5,600	.2205	0,9	36	6
B041A05616CPG	B042A05616CPG	5,616	.2211	0,9	36	6
B041A05700CPG	B042A05700CPG	5,700	.2244	1,0	36	6
B041A05800CPG	B042A05800CPG	5,800	.2283	1,0	36	6
B041A05900CPG	B042A05900CPG	5,900	.2323	1,0	36	6
B041A05954CPG	B042A05954CPG	5,954	.2344	1,0	36	6
B041A06000CPG	B042A06000CPG	6,000	.2362	1,0	36	6
B041A06100CPG	B042A06100CPG	6,100	.2402	1,0	36	8
B041A06200CPG	B042A06200CPG	6,200	.2441	1,0	36	8
B041A06300CPG	B042A06300CPG	6,300	.2480	1,1	36	8
B041A06350CPG	B042A06350CPG	6,350	.2500	1,1	36	8
B041A06400CPG	B042A06400CPG	6,400	.2520	1,1	36	8
B041A06500CPG	B042A06500CPG	6,500	.2559	1,1	36	8
B041A06528CPG	B042A06528CPG	6,528	.2570	1,1	36	8
B041A06600CPG	B042A06600CPG	6,600	.2598	1,1	36	8
B041A06630CPG	B042A06630CPG	6,630	.2610	1,1	36	8
B041A06700CPG	B042A06700CPG	6,700	.2638	1,1	36	8
B041A06746CPG	B042A06746CPG	6,746	.2656	1,1	36	8
B041A06800CPG	B042A06800CPG	6,800	.2677	1,1	36	8
B041A06900CPG	B042A06900CPG	6,900	.2717	1,2	36	8
B041A07000CPG	B042A07000CPG	7,000	.2756	1,2	36	8
B041A07100CPG	B042A07100CPG	7,100	.2795	1,2	36	8
B041A07145CPG	B042A07145CPG	7,145	.2813	1,2	36	8
B041A07200CPG	B042A07200CPG	7,200	.2835	1,2	36	8
B041A07300CPG	B042A07300CPG	7,300	.2874	1,2	36	8
B041A07400CPG	B042A07400CPG	7,400	.2913	1,3	36	8
B041A07500CPG	B042A07500CPG	7,500	.2953	1,3	36	8
B041A07541CPG	B042A07541CPG	7,541	.2969	1,3	36	8
B041A07600CPG	B042A07600CPG	7,600	.2992	1,3	36	8
B041A07700CPG	B042A07700CPG	7,700	.3031	1,3	36	8
B041A07800CPG	B042A07800CPG	7,800	.3071	1,3	36	8
B041A07900CPG	B042A07900CPG	7,900	.3110	1,3	36	8
B041A07938CPG	B042A07938CPG	7,938	.3125	1,3	36	8
B041A08000CPG	B042A08000CPG	8,000	.3150	1,4	36	8
B041A08100CPG	B042A08100CPG	8,100	.3189	1,4	40	10
B041A08200CPG	B042A08200CPG	8,200	.3228	1,4	40	10
B041A08300CPG	B042A08300CPG	8,300	.3268	1,4	40	10
B041A08334CPG	B042A08334CPG	8,334	.3281	1,4	40	10
B041A08400CPG	B042A08400CPG	8,400	.3307	1,4	40	10
B041A08433CPG	B042A08433CPG	8,433	.3320	1,4	40	10
B041A08500CPG	B042A08500CPG	8,500	.3346	1,4	40	10
B041A08600CPG	B042A08600CPG	8,600	.3386	1,5	40	10
B041A08700CPG	B042A08700CPG	8,700	.3425	1,5	40	10
B041A08733CPG	B042A08733CPG	8,733	.3438	1,5	40	10
B041A08800CPG	B042A08800CPG	8,800	.3465	1,5	40	10
B041A08900CPG	B042A08900CPG	8,900	.3504	1,5	40	10
B041A09000CPG	B042A09000CPG	9,000	.3543	1,5	40	10
B041A09100CPG	B042A09100CPG	9,100	.3583	1,5	40	10
B041A09129CPG	B042A09129CPG	9,129	.3594	1,6	40	10
B041A09200CPG	B042A09200CPG	9,200	.3622	1,6	40	10
B041A09300CPG	B042A09300CPG	9,300	.3661	1,6	40	10
B041A09347CPG	B042A09347CPG	9,347	.3680	1,6	40	10

(continued)

(B041A/B042A • ~3 x D/~5 x D — continued)



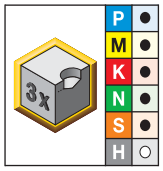


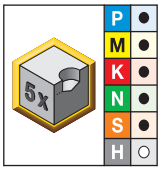
● first choice
○ alternate choice

short • KC7325	long • KC7325	D1 diameter mm	D1 diameter in	L5	LS	D
B041A09400CPG	B042A09400CPG	9,400	.3701	1,6	40	10
B041A09500CPG	B042A09500CPG	9,500	.3740	1,6	40	10
B041A09525CPG	B042A09525CPG	9,525	.3750	1,6	40	10
B041A09600CPG	B042A09600CPG	9,600	.3780	1,6	40	10
B041A09700CPG	B042A09700CPG	9,700	.3819	1,7	40	10
B041A09800CPG	B042A09800CPG	9,800	.3858	1,7	40	10
B041A09900CPG	B042A09900CPG	9,900	.3898	1,7	40	10
B041A09921CPG	B042A09921CPG	9,921	.3906	1,7	40	10
B041A10000CPG	B042A10000CPG	10,000	.3937	1,7	40	10
B041A10100CPG	B042A10100CPG	10,100	.3976	1,7	45	12
B041A10200CPG	B042A10200CPG	10,200	.4016	1,7	45	12
B041A10300CPG	B042A10300CPG	10,300	.4055	1,8	45	12
B041A10320CPG	B042A10320CPG	10,320	.4063	1,8	45	12
B041A10400CPG	B042A10400CPG	10,400	.4094	1,8	45	12
B041A10500CPG	B042A10500CPG	10,500	.4134	1,8	45	12
B041A10600CPG	B042A10600CPG	10,600	.4173	1,8	45	12
B041A10700CPG	B042A10700CPG	10,700	.4213	1,8	45	12
B041A10716CPG	B042A10716CPG	10,716	.4219	1,8	45	12
B041A10800CPG	B042A10800CPG	10,800	.4252	1,8	45	12
B041A10900CPG	B042A10900CPG	10,900	.4291	1,9	45	12
B041A11000CPG	B042A11000CPG	11,000	.4331	1,9	45	12
B041A11100CPG	B042A11100CPG	11,100	.4370	1,9	45	12
B041A11113CPG	B042A11113CPG	11,113	.4375	1,9	45	12
B041A11200CPG	B042A11200CPG	11,200	.4409	1,9	45	12
B041A11300CPG	B042A11300CPG	11,300	.4449	1,9	45	12
B041A11400CPG	B042A11400CPG *	11,400	.4488	2,0	45	12
B041A11500CPG	B042A11500CPG	11,500	.4528	2,0	45	12
B041A11509CPG	B042A11509CPG	11,509	.4531	2,0	45	12
B041A11600CPG	B042A11600CPG	11,600	.4567	2,0	45	12
B041A11700CPG	B042A11700CPG	11,700	.4606	2,0	45	12
B041A11800CPG	B042A11800CPG	11,800	.4646	2,0	45	12
B041A11900CPG	B042A11900CPG	11,900	.4685	2,0	45	12
B041A11908CPG	B042A11908CPG	11,908	.4688	2,0	45	12
B041A12000CPG	B042A12000CPG	12,000	.4724	2,1	45	12
B041A12100CPG	B042A12100CPG	12,100	.4764	2,1	45	14
B041A12200CPG	B042A12200CPG	12,200	.4803	2,1	45	14
B041A12300CPG	B042A12300CPG	12,300	.4843	2,1	45	14
B041A12304CPG	B042A12304CPG	12,304	.4844	2,1	45	14
B041A12400CPG	B042A12400CPG *	12,400	.4882	2,1	45	14
B041A12500CPG	B042A12500CPG	12,500	.4921	2,1	45	14
B041A12600CPG	B042A12600CPG	12,600	.4961	2,2	45	14
B041A12700CPG	B042A12700CPG	12,700	.5000	2,2	45	14
B041A12800CPG	B042A12800CPG	12,800	.5039	2,2	45	14
B041A12900CPG	B042A12900CPG	12,900	.5079	2,2	45	14
B041A13000CPG	B042A13000CPG	13,000	.5118	2,2	45	14
B041A13096CPG	B042A13096CPG	13,096	.5156	2,3	45	14
B041A13100CPG	B042A13100CPG	13,100	.5157	2,3	45	14
B041A13200CPG	B042A13200CPG	13,200	.5197	2,3	45	14
B041A13300CPG	B042A13300CPG	13,300	.5236	2,3	45	14
B041A13400CPG	B042A13400CPG	13,400	.5276	2,3	45	14
B041A13500CPG	B042A13500CPG	13,500	.5315	2,3	45	14
B041A13600CPG	B042A13600CPG	13,600	.5354	2,3	45	14

(continued)

(B041A/B042A • ~3 x D/~5 x D — continued)



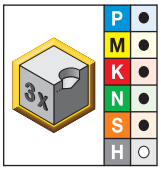


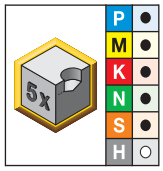
● first choice
○ alternate choice

short • KC7325	long • KC7325	D1 diameter mm	D1 diameter in	L5	LS	D
B041A13700CPG	B042A13700CPG	13,700	.5394	2,4	45	14
B041A13800CPG	B042A13800CPG	13,800	.5433	2,4	45	14
B041A13891CPG	B042A13891CPG	13,891	.5469	2,4	45	14
B041A13900CPG	B042A13900CPG	13,900	.5472	2,4	45	14
B041A14000CPG	B042A14000CPG	14,000	.5512	2,4	45	14
B041A14100CPG	B042A14100CPG	14,100	.5551	2,4	48	16
B041A14200CPG	B042A14200CPG	14,200	.5591	2,5	48	16
B041A14288CPG	B042A14288CPG	14,288	.5625	2,5	48	16
B041A14300CPG	B042A14300CPG	14,300	.5630	2,5	48	16
B041A14400CPG	B042A14400CPG	14,400	.5669	2,5	48	16
B041A14500CPG	B042A14500CPG	14,500	.5709	2,5	48	16
B041A14600CPG	B042A14600CPG	14,600	.5748	2,5	48	16
B041A14684CPG	B042A14684CPG	14,684	.5781	2,5	48	16
B041A14700CPG	B042A14700CPG	14,700	.5787	2,5	48	16
B041A14800CPG	B042A14800CPG	14,800	.5827	2,6	48	16
B041A14900CPG	B042A14900CPG	14,900	.5866	2,6	48	16
B041A15000CPG	B042A15000CPG	15,000	.5906	2,6	48	16
B041A15083CPG	B042A15083CPG	15,083	.5938	2,6	48	16
B041A15100CPG	B042A15100CPG	15,100	.5945	2,6	48	16
B041A15200CPG	B042A15200CPG	15,200	.5984	2,6	48	16
B041A15300CPG	B042A15300CPG	15,300	.6024	2,6	48	16
B041A15400CPG	B042A15400CPG	15,400	.6063	2,7	48	16
B041A15479CPG	B042A15479CPG	15,479	.6094	2,7	48	16
B041A15500CPG	B042A15500CPG	15,500	.6102	2,7	48	16
B041A15600CPG	B042A15600CPG	15,600	.6142	2,7	48	16
B041A15700CPG	B042A15700CPG	15,700	.6181	2,7	48	16
B041A15800CPG	B042A15800CPG	15,800	.6220	2,7	48	16
B041A15875CPG	B042A15875CPG	15,875	.6250	2,7	48	16
B041A15900CPG	B042A15900CPG	15,900	.6260	2,8	48	16
B041A16000CPG	B042A16000CPG	16,000	.6299	2,8	48	16
B041A16100CPG	B042A16100CPG	16,100	.6339	2,8	48	18
B041A16200CPG	B042A16200CPG	16,200	.6378	2,8	48	18
B041A16271CPG	B042A16271CPG	16,271	.6406	2,8	48	18
B041A16300CPG	B042A16300CPG	16,300	.6417	2,8	48	18
B041A16400CPG	B042A16400CPG	16,400	.6457	2,8	48	18
B041A16500CPG	B042A16500CPG	16,500	.6496	2,9	48	18
B041A16600CPG	B042A16600CPG	16,600	.6535	2,9	48	18
B041A16670CPG	B042A16670CPG	16,670	.6563	2,9	48	18
B041A16700CPG	B042A16700CPG	16,700	.6575	2,9	48	18
B041A16800CPG	B042A16800CPG	16,800	.6614	2,9	48	18
B041A16900CPG	B042A16900CPG	16,900	.6654	2,9	48	18
B041A17000CPG	B042A17000CPG	17,000	.6693	2,9	48	18
B041A17100CPG	B042A17100CPG	17,100	.6732	3,0	48	18
B041A17200CPG	B042A17200CPG	17,200	.6772	3,0	48	18
B041A17300CPG	B042A17300CPG	17,300	.6811	3,0	48	18
B041A17400CPG	B042A17400CPG	17,400	.6850	3,0	48	18
B041A17463CPG	B042A17463CPG	17,463	.6875	3,0	48	18
B041A17500CPG	B042A17500CPG	17,500	.6890	3,0	48	18
B041A17600CPG	B042A17600CPG	17,600	.6929	3,1	48	18
B041A17700CPG	B042A17700CPG	17,700	.6969	3,1	48	18
B041A17800CPG	B042A17800CPG	17,800	.7008	3,1	48	18
B041A17859CPG	B042A17859CPG	17,859	.7031	3,1	48	18

(continued)

(B041A/B042A • ~3 x D/~5 x D — continued)



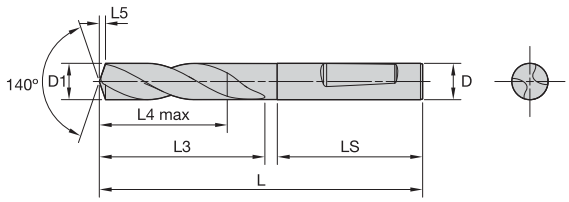


● first choice
○ alternate choice

short • KC7325	long • KC7325	D1 diameter mm	D1 diameter in	L5	LS	D
B041A17900CPG	B042A17900CPG	17,900	.7047	3,1	48	18
B041A18000CPG	B042A18000CPG	18,000	.7087	3,1	48	18
B041A18100CPG	B042A18100CPG	18,100	.7126	3,1	50	20
B041A18200CPG	B042A18200CPG	18,200	.7165	3,2	50	20
B041A18258CPG	B042A18258CPG	18,258	.7188	3,2	50	20
B041A18300CPG	B042A18300CPG	18,300	.7205	3,2	50	20
B041A18400CPG	B042A18400CPG	18,400	.7244	3,2	50	20
B041A18500CPG	B042A18500CPG	18,500	.7283	3,2	50	20
B041A18600CPG	B042A18600CPG	18,600	.7323	3,2	50	20
B041A18654CPG	B042A18654CPG	18,654	.7344	3,2	50	20
B041A18700CPG	B042A18700CPG	18,700	.7362	3,2	50	20
B041A18800CPG	B042A18800CPG	18,800	.7402	3,3	50	20
B041A18900CPG	B042A18900CPG	18,900	.7441	3,3	50	20
B041A19000CPG	B042A19000CPG	19,000	.7480	3,3	50	20
B041A19050CPG	B042A19050CPG	19,050	.7500	3,3	50	20
B041A19100CPG	B042A19100CPG	19,100	.7520	3,3	50	20
B041A19200CPG	B042A19200CPG	19,200	.7559	3,3	50	20
B041A19300CPG	B042A19300CPG	19,300	.7598	3,4	50	20
B041A19400CPG	B042A19400CPG	19,400	.7638	3,4	50	20
B041A19500CPG	B042A19500CPG	19,500	.7677	3,4	50	20
B041A19600CPG	B042A19600CPG	19,600	.7717	3,4	50	20
B041A19700CPG	B042A19700CPG	19,700	.7756	3,4	50	20
B041A19800CPG	B042A19800CPG	19,800	.7795	3,4	50	20
B041A19900CPG	B042A19900CPG	19,900	.7835	3,5	50	20
B041A20000CPG	B042A20000CPG	20,000	.7874	3,5	50	20

NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

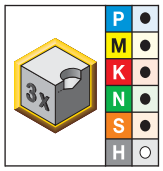


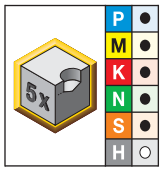




For information on L, L3, and L4 max, see the Solid Carbide Drills foldout table.

B041F/B042F • ~3 x D/~5 x D



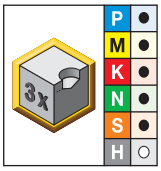


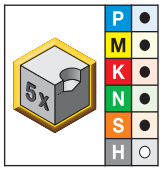
● first choice
○ alternate choice

short • KC7325	long • KC7325	D1 diameter mm	D1 diameter in	L5	LS	D
B041F03000CPG	B042F03000CPG	3,000	.1181	0,5	36	6
B041F03100CPG	B042F03100CPG	3,100	.1220	0,5	36	6
B041F03200CPG	B042F03200CPG	3,200	.1260	0,5	36	6
B041F03300CPG	B042F03300CPG	3,300	.1299	0,5	36	6
B041F03400CPG	B042F03400CPG	3,400	.1339	0,6	36	6
B041F03500CPG	B042F03500CPG	3,500	.1378	0,6	36	6
B041F03600CPG	B042F03600CPG	3,600	.1417	0,6	36	6
B041F03700CPG	B042F03700CPG	3,700	.1457	0,6	36	6
B041F03800CPG	B042F03800CPG	3,800	.1496	0,6	36	6
B041F03900CPG	B042F03900CPG	3,900	.1535	0,6	36	6
B041F04000CPG	B042F04000CPG	4,000	.1575	0,7	36	6
B041F04100CPG	B042F04100CPG	4,100	.1614	0,7	36	6
B041F04200CPG	B042F04200CPG	4,200	.1654	0,7	36	6
B041F04300CPG	B042F04300CPG	4,300	.1693	0,7	36	6
B041F04400CPG	B042F04400CPG	4,400	.1732	0,7	36	6
B041F04500CPG	B042F04500CPG	4,500	.1772	0,7	36	6
B041F04600CPG	B042F04600CPG	4,600	.1811	0,8	36	6
B041F04700CPG	B042F04700CPG	4,700	.1850	0,8	36	6
B041F04800CPG	B042F04800CPG	4,800	.1890	0,8	36	6
B041F04900CPG	B042F04900CPG	4,900	.1929	0,8	36	6
B041F05000CPG	B042F05000CPG	5,000	.1969	0,8	36	6
B041F05100CPG	B042F05100CPG	5,100	.2008	0,8	36	6
B041F05200CPG	B042F05200CPG	5,200	.2047	0,9	36	6
B041F05300CPG	B042F05300CPG	5,300	.2087	0,9	36	6
B041F05400CPG	B042F05400CPG	5,400	.2126	0,9	36	6
B041F05500CPG	B042F05500CPG	5,500	.2165	0,9	36	6
B041F05600CPG	B042F05600CPG	5,600	.2205	0,9	36	6
B041F05700CPG	B042F05700CPG	5,700	.2244	1,0	36	6
B041F05800CPG	B042F05800CPG	5,800	.2283	1,0	36	6
B041F05900CPG	B042F05900CPG	5,900	.2323	1,0	36	6
B041F06000CPG	B042F06000CPG	6,000	.2362	1,0	36	6
B041F06100CPG	B042F06100CPG	6,100	.2402	1,0	36	8
B041F06200CPG	B042F06200CPG	6,200	.2441	1,0	36	8
B041F06300CPG	B042F06300CPG	6,300	.2480	1,1	36	8
B041F06400CPG	B042F06400CPG	6,400	.2520	1,1	36	8
B041F06500CPG	B042F06500CPG	6,500	.2559	1,1	36	8

(continued)

(B041F/B042F • ~3 x D/~5 x D — continued)



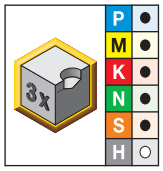


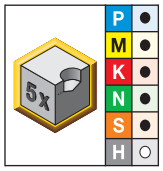
● first choice
○ alternate choice

short • KC7325	long • KC7325	D1 diameter mm	D1 diameter in	L5	LS	D
B041F06600CPG	B042F06600CPG	6,600	.2598	1,1	36	8
B041F06700CPG	B042F06700CPG	6,700	.2638	1,1	36	8
B041F06800CPG	B042F06800CPG	6,800	.2677	1,1	36	8
B041F06900CPG	B042F06900CPG	6,900	.2717	1,2	36	8
B041F07000CPG	B042F07000CPG	7,000	.2756	1,2	36	8
B041F07100CPG	B042F07100CPG	7,100	.2795	1,2	36	8
B041F07200CPG	B042F07200CPG	7,200	.2835	1,2	36	8
B041F07300CPG	B042F07300CPG	7,300	.2874	1,2	36	8
B041F07400CPG	B042F07400CPG	7,400	.2913	1,3	36	8
B041F07500CPG	B042F07500CPG	7,500	.2953	1,3	36	8
B041F07600CPG	B042F07600CPG	7,600	.2992	1,3	36	8
B041F07700CPG	B042F07700CPG	7,700	.3031	1,3	36	8
B041F07800CPG	B042F07800CPG	7,800	.3071	1,3	36	8
B041F07900CPG	B042F07900CPG	7,900	.3110	1,3	36	8
B041F08000CPG	B042F08000CPG	8,000	.3150	1,4	36	8
B041F08100CPG	B042F08100CPG	8,100	.3189	1,4	40	10
B041F08200CPG	B042F08200CPG	8,200	.3228	1,4	40	10
B041F08300CPG	B042F08300CPG	8,300	.3268	1,4	40	10
B041F08400CPG	B042F08400CPG	8,400	.3307	1,4	40	10
B041F08500CPG	B042F08500CPG	8,500	.3346	1,4	40	10
B041F08600CPG	B042F08600CPG	8,600	.3386	1,5	40	10
B041F08700CPG	B042F08700CPG	8,700	.3425	1,5	40	10
B041F08800CPG	B042F08800CPG	8,800	.3465	1,5	40	10
B041F08900CPG	B042F08900CPG	8,900	.3504	1,5	40	10
B041F09000CPG	B042F09000CPG	9,000	.3543	1,5	40	10
B041F09100CPG	B042F09100CPG	9,100	.3583	1,5	40	10
B041F09200CPG	B042F09200CPG	9,200	.3622	1,6	40	10
B041F09300CPG	B042F09300CPG	9,300	.3661	1,6	40	10
B041F09400CPG	B042F09400CPG	9,400	.3701	1,6	40	10
B041F09500CPG	B042F09500CPG	9,500	.3740	1,6	40	10
B041F09600CPG	B042F09600CPG	9,600	.3780	1,6	40	10
B041F09700CPG	B042F09700CPG	9,700	.3819	1,7	40	10
B041F09800CPG	B042F09800CPG	9,800	.3858	1,7	40	10
B041F09900CPG	B042F09900CPG	9,900	.3898	1,7	40	10
B041F10000CPG	B042F10000CPG	10,000	.3937	1,7	40	10
B041F10100CPG	B042F10100CPG	10,100	.3976	1,7	45	12
B041F10200CPG	B042F10200CPG	10,200	.4016	1,7	45	12
B041F10300CPG	B042F10300CPG	10,300	.4055	1,8	45	12
B041F10400CPG	B042F10400CPG	10,400	.4094	1,8	45	12
B041F10500CPG	B042F10500CPG	10,500	.4134	1,8	45	12
B041F10600CPG	B042F10600CPG	10,600	.4173	1,8	45	12
B041F10700CPG	B042F10700CPG	10,700	.4213	1,8	45	12
B041F10800CPG	B042F10800CPG	10,800	.4252	1,8	45	12
B041F10900CPG	B042F10900CPG	10,900	.4291	1,9	45	12
B041F11000CPG	B042F11000CPG	11,000	.4331	1,9	45	12
B041F11100CPG	B042F11100CPG	11,100	.4370	1,9	45	12
B041F11200CPG	B042F11200CPG	11,200	.4409	1,9	45	12
B041F11300CPG	B042F11300CPG	11,300	.4449	1,9	45	12
B041F11400CPG	B042F11400CPG	11,400	.4488	2,0	45	12
B041F11500CPG	B042F11500CPG	11,500	.4528	2,0	45	12
B041F11600CPG	B042F11600CPG	11,600	.4567	2,0	45	12
B041F11700CPG	B042F11700CPG	11,700	.4606	2,0	45	12

(continued)

(B041F/B042F • ~3 x D/~5 x D — continued)



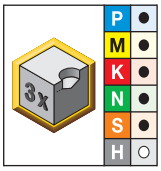


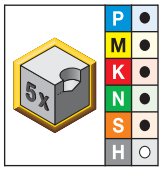
● first choice
○ alternate choice

short • KC7325	long • KC7325	D1 diameter mm	D1 diameter in	L5	LS	D
B041F11800CPG	B042F11800CPG	11,800	.4646	2,0	45	12
B041F11900CPG	B042F11900CPG	11,900	.4685	2,0	45	12
B041F12000CPG	B042F12000CPG	12,000	.4724	2,1	45	12
B041F12100CPG	B042F12100CPG	12,100	.4764	2,1	45	14
B041F12200CPG	B042F12200CPG	12,200	.4803	2,1	45	14
B041F12300CPG	B042F12300CPG	12,300	.4843	2,1	45	14
B041F12400CPG	B042F12400CPG	12,400	.4882	2,1	45	14
B041F12500CPG	B042F12500CPG	12,500	.4921	2,1	45	14
B041F12600CPG	B042F12600CPG	12,600	.4961	2,2	45	14
B041F12700CPG	B042F12700CPG	12,700	.5000	2,2	45	14
B041F12800CPG	B042F12800CPG	12,800	.5039	2,2	45	14
B041F12900CPG	B042F12900CPG	12,900	.5079	2,2	45	14
B041F13000CPG	B042F13000CPG	13,000	.5118	2,2	45	14
B041F13100CPG	B042F13100CPG	13,100	.5157	2,3	45	14
B041F13200CPG	B042F13200CPG	13,200	.5197	2,3	45	14
B041F13300CPG	B042F13300CPG	13,300	.5236	2,3	45	14
B041F13400CPG	B042F13400CPG	13,400	.5276	2,3	45	14
B041F13500CPG	B042F13500CPG	13,500	.5315	2,3	45	14
B041F13600CPG	B042F13600CPG	13,600	.5354	2,3	45	14
B041F13700CPG	B042F13700CPG	13,700	.5394	2,4	45	14
B041F13800CPG	B042F13800CPG	13,800	.5433	2,4	45	14
B041F13900CPG	B042F13900CPG	13,900	.5472	2,4	45	14
B041F14000CPG	B042F14000CPG	14,000	.5512	2,4	45	14
B041F14100CPG	B042F14100CPG	14,100	.5551	2,4	48	16
B041F14200CPG	B042F14200CPG	14,200	.5591	2,5	48	16
B041F14300CPG	B042F14300CPG	14,300	.5630	2,5	48	16
B041F14400CPG	B042F14400CPG	14,400	.5669	2,5	48	16
B041F14500CPG	B042F14500CPG	14,500	.5709	2,5	48	16
B041F14600CPG	B042F14600CPG	14,600	.5748	2,5	48	16
B041F14700CPG	B042F14700CPG	14,700	.5787	2,5	48	16
B041F14800CPG	B042F14800CPG	14,800	.5827	2,6	48	16
B041F14900CPG	B042F14900CPG	14,900	.5866	2,6	48	16
B041F15000CPG	B042F15000CPG	15,000	.5906	2,6	48	16
B041F15100CPG	B042F15100CPG	15,100	.5945	2,6	48	16
B041F15200CPG	B042F15200CPG	15,200	.5984	2,6	48	16
B041F15300CPG	B042F15300CPG	15,300	.6024	2,6	48	16
B041F15400CPG	B042F15400CPG	15,400	.6063	2,7	48	16
B041F15500CPG	B042F15500CPG	15,500	.6102	2,7	48	16
B041F15600CPG	B042F15600CPG	15,600	.6142	2,7	48	16
B041F15700CPG	B042F15700CPG	15,700	.6181	2,7	48	16
B041F15800CPG	B042F15800CPG	15,800	.6220	2,7	48	16
B041F15900CPG	B042F15900CPG	15,900	.6260	2,8	48	16
B041F16000CPG	B042F16000CPG	16,000	.6299	2,8	48	16
B041F16100CPG	B042F16100CPG	16,100	.6339	2,8	48	18
B041F16200CPG	B042F16200CPG	16,200	.6378	2,8	48	18
B041F16300CPG	B042F16300CPG	16,300	.6417	2,8	48	18
B041F16400CPG	B042F16400CPG	16,400	.6457	2,8	48	18
B041F16500CPG	B042F16500CPG	16,500	.6496	2,9	48	18
B041F16600CPG	B042F16600CPG	16,600	.6535	2,9	48	18
B041F16700CPG	B042F16700CPG	16,700	.6575	2,9	48	18
B041F16800CPG	B042F16800CPG	16,800	.6614	2,9	48	18
B041F16900CPG	B042F16900CPG	16,900	.6654	2,9	48	18

(continued)

(B041F/B042F • ~3 x D/~5 x D — continued)





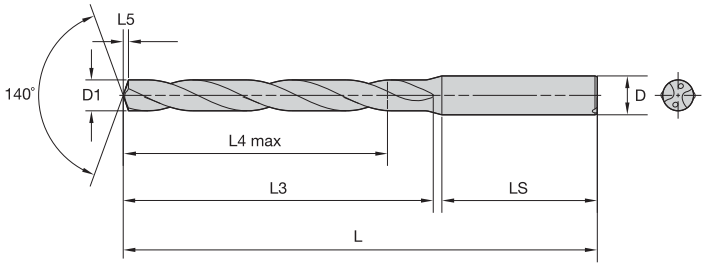
● first choice
○ alternate choice

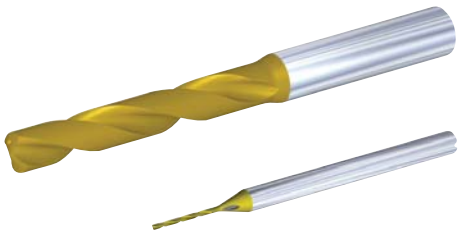
short • KC7325	long • KC7325	D1 diameter mm	D1 diameter in	L5	LS	D
B041F17000CPG	B042F17000CPG	17,000	.6693	2,9	48	18
B041F17100CPG	B042F17100CPG	17,100	.6732	3,0	48	18
B041F17200CPG	B042F17200CPG	17,200	.6772	3,0	48	18
B041F17300CPG	B042F17300CPG	17,300	.6811	3,0	48	18
B041F17400CPG	B042F17400CPG	17,400	.6850	3,0	48	18
B041F17500CPG	B042F17500CPG	17,500	.6890	3,0	48	18
B041F17600CPG	B042F17600CPG	17,600	.6929	3,1	48	18
B041F17700CPG	B042F17700CPG	17,700	.6969	3,1	48	18
B041F17800CPG	B042F17800CPG	17,800	.7008	3,1	48	18
B041F17900CPG	B042F17900CPG	17,900	.7047	3,1	48	18
B041F18000CPG	B042F18000CPG	18,000	.7087	3,1	48	18
B041F18100CPG	B042F18100CPG	18,100	.7126	3,1	50	20
B041F18200CPG	B042F18200CPG	18,200	.7165	3,2	50	20
B041F18300CPG	B042F18300CPG	18,300	.7205	3,2	50	20
B041F18400CPG	B042F18400CPG	18,400	.7244	3,2	50	20
B041F18500CPG	B042F18500CPG	18,500	.7283	3,2	50	20
B041F18600CPG	B042F18600CPG	18,600	.7323	3,2	50	20
B041F18700CPG	B042F18700CPG	18,700	.7362	3,2	50	20
B041F18800CPG	B042F18800CPG	18,800	.7402	3,3	50	20
B041F18900CPG	B042F18900CPG	18,900	.7441	3,3	50	20
B041F19000CPG	B042F19000CPG	19,000	.7480	3,3	50	20
B041F19100CPG	B042F19100CPG	19,100	.7520	3,3	50	20
B041F19200CPG	B042F19200CPG	19,200	.7559	3,3	50	20
B041F19300CPG	B042F19300CPG	19,300	.7598	3,4	50	20
B041F19400CPG	B042F19400CPG	19,400	.7638	3,4	50	20
B041F19500CPG	B042F19500CPG	19,500	.7677	3,4	50	20
B041F19600CPG	B042F19600CPG	19,600	.7717	3,4	50	20
B041F19700CPG	B042F19700CPG	19,700	.7756	3,4	50	20
B041F19800CPG	B042F19800CPG	19,800	.7795	3,4	50	20
B041F19900CPG	B042F19900CPG	19,900	.7835	3,5	50	20
B041F20000CPG	B042F20000CPG	20,000	.7874	3,5	50	20

Tolerance • Metric

nominal size range	D1 tolerance	D tolerance h6
1–3	0,000/-0,014 (h8)	0,000/-0,006
>3–6	0,000/-0,012 (h7)	0,000/-0,008
>6–10	0,000/-0,015 (h7)	0,000/-0,009
>10–18	0,000/-0,018 (h7)	0,000/-0,011
>18–20	0,000/-0,021 (h7)	0,000/-0,013

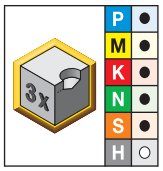


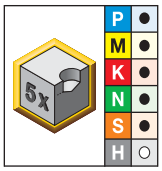


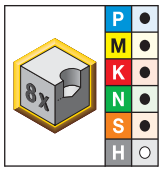


For information on L, L3, and L4 max, see the Solid Carbide Drills foldout table.

B051A/B052A/B053A • ~3 x D/~5 x D/~8 x D





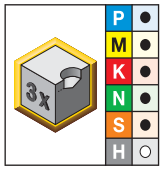


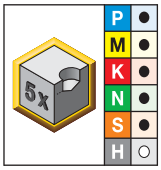
● first choice
○ alternate choice

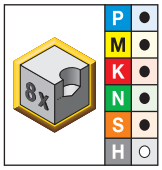
short • KC7325	long • KC7325	extra long • KC7325	D1 diameter mm	D1 diameter in	L5	LS	D
–	–	B053A01000CPG	1,000	.0394	0,1	28	4
–	–	B053A01016CPG	1,016	.0400	0,1	28	4
–	–	B053A01067CPG	1,067	.0420	0,2	28	4
–	–	B053A01100CPG	1,100	.0433	0,2	28	4
–	–	B053A01181CPG	1,181	.0465	0,2	28	4
–	–	B053A01191CPG	1,191	.0469	0,2	28	4
–	–	B053A01200CPG	1,200	.0472	0,2	28	4
–	–	B053A01300CPG	1,300	.0512	0,2	28	4
–	–	B053A01321CPG	1,321	.0520	0,2	28	4
–	–	B053A01397CPG	1,397	.0550	0,2	28	4
–	–	B053A01400CPG	1,400	.0551	0,2	28	4
B051A01500CPG	B052A01500CPG	B053A01500CPG	1,500	.0591	0,2	28	4
B051A01600CPG	B052A01600CPG	B053A01600CPG	1,600	.0630	0,2	28	4
B051A01700CPG	B052A01700CPG	B053A01700CPG	1,700	.0669	0,3	28	4
B051A01800CPG	B052A01800CPG	B053A01800CPG	1,800	.0709	0,3	28	4
B051A01900CPG	B052A01900CPG	B053A01900CPG	1,900	.0748	0,3	28	4
B051A01984CPG	B052A01984CPG	B053A01984CPG	1,984	.0781	0,3	28	4
B051A02000CPG	B052A02000CPG	B053A02000CPG	2,000	.0787	0,3	28	4
B051A02100CPG	B052A02100CPG	B053A02100CPG	2,100	.0827	0,3	28	4
B051A02200CPG	B052A02200CPG	B053A02200CPG	2,200	.0866	0,3	28	4
B051A02300CPG	B052A02300CPG	B053A02300CPG	2,300	.0906	0,4	28	4
B051A02383CPG	B052A02383CPG	B053A02383CPG	2,383	.0938	0,4	28	4
B051A02400CPG	B052A02400CPG	B053A02400CPG	2,400	.0945	0,4	28	4
B051A02439CPG	B052A02439CPG	B053A02439CPG	2,439	.0960	0,4	28	4
B051A02489CPG	B052A02489CPG	B053A02489CPG	2,489	.0980	0,4	28	4
B051A02500CPG	B052A02500CPG	B053A02500CPG	2,500	.0984	0,4	28	4
B051A02578CPG	B052A02578CPG	B053A02578CPG	2,578	.1015	0,4	28	4
B051A02600CPG	B052A02600CPG	B053A02600CPG	2,600	.1024	0,4	28	4
B051A02642CPG	B052A02642CPG	B053A02642CPG	2,642	.1040	0,4	28	4
B051A02700CPG	B052A02700CPG	B053A02700CPG	2,700	.1063	0,4	28	4
B051A02705CPG	B052A02705CPG	B053A02705CPG	2,705	.1065	0,4	28	4
B051A02779CPG	B052A02779CPG	B053A02779CPG	2,779	.1094	0,4	28	4
B051A02800CPG	B052A02800CPG	B053A02800CPG	2,800	.1102	0,5	28	4
B051A02820CPG	B052A02820CPG	B053A02820CPG	2,820	.1110	0,5	28	4
B051A02870CPG	B052A02870CPG	B053A02870CPG	2,870	.1130	0,5	28	4
B051A02900CPG	B052A02900CPG	B053A02900CPG	2,900	.1142	0,5	28	4

(continued)

(B051A/B052A/B053A • ~3 x D/~5 x D/~8 x D — continued)





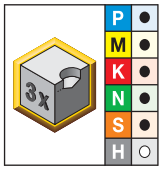


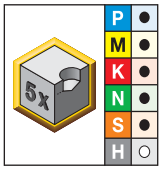
● first choice
○ alternate choice

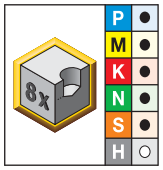
short • KC7325	long • KC7325	extra long • KC7325	D1 diameter mm	D1 diameter in	L5	LS	D
B051A02947CPG	B052A02947CPG	B053A02947CPG	2,947	.1160	0,5	28	4
B051A03000CPG	B052A03000CPG	B053A03000CPG	3,000	.1181	0,5	36	6
B051A03048CPG	B052A03048CPG	B053A03048CPG	3,048	.1200	0,5	36	6
B051A03100CPG	B052A03100CPG	B053A03100CPG	3,100	.1220	0,5	36	6
B051A03175CPG	B052A03175CPG	B053A03175CPG	3,175	.1250	0,5	36	6
B051A03200CPG	B052A03200CPG	B053A03200CPG	3,200	.1260	0,5	36	6
B051A03264CPG	B052A03264CPG	B053A03264CPG	3,264	.1285	0,5	36	6
B051A03300CPG	B052A03300CPG	B053A03300CPG	3,300	.1299	0,5	36	6
B051A03400CPG	B052A03400CPG	B053A03400CPG	3,400	.1339	0,6	36	6
B051A03455CPG	B052A03455CPG	B053A03455CPG	3,455	.1360	0,6	36	6
B051A03500CPG	B052A03500CPG	B053A03500CPG	3,500	.1378	0,6	36	6
B051A03571CPG	B052A03571CPG	B053A03571CPG	3,571	.1406	0,6	36	6
B051A03600CPG	B052A03600CPG	B053A03600CPG	3,600	.1417	0,6	36	6
B051A03658CPG	B052A03658CPG	B053A03658CPG	3,658	.1440	0,6	36	6
B051A03700CPG	B052A03700CPG	B053A03700CPG	3,700	.1457	0,6	36	6
B051A03734CPG	B052A03734CPG	B053A03734CPG	3,734	.1470	0,6	36	6
B051A03800CPG	B052A03800CPG	B053A03800CPG	3,800	.1496	0,6	36	6
B051A03900CPG	B052A03900CPG	B053A03900CPG	3,900	.1535	0,6	36	6
B051A03970CPG	B052A03970CPG	B053A03970CPG	3,970	.1563	0,7	36	6
B051A04000CPG	B052A04000CPG	B053A04000CPG	4,000	.1575	0,7	36	6
B051A04039CPG	B052A04039CPG	B053A04039CPG	4,039	.1590	0,7	36	6
B051A04090CPG	B052A04090CPG	B053A04090CPG	4,090	.1610	0,7	36	6
B051A04100CPG	B052A04100CPG	B053A04100CPG	4,100	.1614	0,7	36	6
B051A04200CPG	B052A04200CPG	B053A04200CPG	4,200	.1654	0,7	36	6
B051A04217CPG	B052A04217CPG	B053A04217CPG	4,217	.1660	0,7	36	6
B051A04300CPG	B052A04300CPG	B053A04300CPG	4,300	.1693	0,7	36	6
B051A04366CPG	B052A04366CPG	B053A04366CPG	4,366	.1719	0,7	36	6
B051A04400CPG	B052A04400CPG	B053A04400CPG	4,400	.1732	0,7	36	6
B051A04500CPG	B052A04500CPG	B053A04500CPG	4,500	.1772	0,7	36	6
B051A04600CPG	B052A04600CPG	B053A04600CPG	4,600	.1811	0,8	36	6
B051A04623CPG	B052A04623CPG	B053A04623CPG	4,623	.1820	0,8	36	6
B051A04700CPG	B052A04700CPG	B053A04700CPG	4,700	.1850	0,8	36	6
B051A04763CPG	B052A04763CPG	B053A04763CPG	4,763	.1875	0,8	36	6
B051A04800CPG	B052A04800CPG	B053A04800CPG	4,800	.1890	0,8	36	6
B051A04852CPG	B052A04852CPG	B053A04852CPG	4,852	.1910	0,8	36	6
B051A04900CPG	B052A04900CPG	B053A04900CPG	4,900	.1929	0,8	36	6
B051A05000CPG	B052A05000CPG	B053A05000CPG	5,000	.1969	0,8	36	6
B051A05100CPG	B052A05100CPG	B053A05100CPG	5,100	.2008	0,8	36	6
B051A05106CPG	B052A05106CPG	B053A05106CPG	5,106	.2010	0,8	36	6
B051A05159CPG	B052A05159CPG	B053A05159CPG	5,159	.2031	0,9	36	6
B051A05200CPG	B052A05200CPG	B053A05200CPG	5,200	.2047	0,9	36	6
B051A05300CPG	B052A05300CPG	B053A05300CPG	5,300	.2087	0,9	36	6
B051A05400CPG	B052A05400CPG	B053A05400CPG	5,400	.2126	0,9	36	6
B051A05410CPG	B052A05410CPG	B053A05410CPG	5,410	.2130	0,9	36	6
B051A05500CPG	B052A05500CPG	B053A05500CPG	5,500	.2165	0,9	36	6
B051A05558CPG	B052A05558CPG	B053A05558CPG	5,558	.2188	0,9	36	6
B051A05600CPG	B052A05600CPG	B053A05600CPG	5,600	.2205	0,9	36	6
B051A05616CPG	B052A05616CPG	B053A05616CPG	5,616	.2211	0,9	36	6
B051A05700CPG	B052A05700CPG	B053A05700CPG	5,700	.2244	1,0	36	6
B051A05800CPG	B052A05800CPG	B053A05800CPG	5,800	.2283	1,0	36	6
B051A05900CPG	B052A05900CPG	B053A05900CPG	5,900	.2323	1,0	36	6
B051A05954CPG	B052A05954CPG	B053A05954CPG	5,954	.2344	1,0	36	6

(continued)

(B051A/B052A/B053A • ~3 x D/~5 x D/~8 x D — continued)





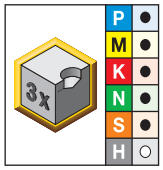


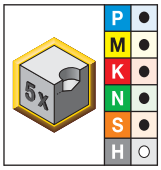
● first choice
○ alternate choice

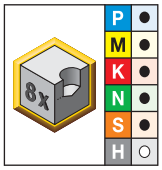
short • KC7325	long • KC7325	extra long • KC7325	D1 diameter mm	D1 diameter in	L5	LS	D
B051A06000CPG	B052A06000CPG	B053A06000CPG	6,000	.2362	1,0	36	6
B051A06100CPG	B052A06100CPG	B053A06100CPG	6,100	.2402	1,0	36	8
B051A06200CPG	B052A06200CPG	B053A06200CPG	6,200	.2441	1,0	36	8
B051A06300CPG	B052A06300CPG	B053A06300CPG	6,300	.2480	1,1	36	8
B051A06350CPG	B052A06350CPG	B053A06350CPG	6,350	.2500	1,1	36	8
B051A06400CPG	B052A06400CPG	B053A06400CPG	6,400	.2520	1,1	36	8
B051A06500CPG	B052A06500CPG	B053A06500CPG	6,500	.2559	1,1	36	8
B051A06528CPG	B052A06528CPG	B053A06528CPG	6,528	.2570	1,1	36	8
B051A06600CPG	B052A06600CPG	B053A06600CPG	6,600	.2598	1,1	36	8
B051A06630CPG	B052A06630CPG	B053A06630CPG	6,630	.2610	1,1	36	8
B051A06700CPG	B052A06700CPG	B053A06700CPG	6,700	.2638	1,1	36	8
B051A06746CPG	B052A06746CPG	B053A06746CPG	6,746	.2656	1,1	36	8
B051A06800CPG	B052A06800CPG	B053A06800CPG	6,800	.2677	1,1	36	8
B051A06900CPG	B052A06900CPG	B053A06900CPG	6,900	.2717	1,2	36	8
B051A07000CPG	B052A07000CPG	B053A07000CPG	7,000	.2756	1,2	36	8
B051A07100CPG	B052A07100CPG	B053A07100CPG	7,100	.2795	1,2	36	8
B051A07145CPG	B052A07145CPG	B053A07145CPG	7,145	.2813	1,2	36	8
B051A07200CPG	B052A07200CPG	B053A07200CPG	7,200	.2835	1,2	36	8
B051A07300CPG	B052A07300CPG	B053A07300CPG	7,300	.2874	1,2	36	8
B051A07400CPG	B052A07400CPG	B053A07400CPG	7,400	.2913	1,3	36	8
B051A07500CPG	B052A07500CPG	B053A07500CPG	7,500	.2953	1,3	36	8
B051A07541CPG	B052A07541CPG	B053A07541CPG	7,541	.2969	1,3	36	8
B051A07600CPG	B052A07600CPG	B053A07600CPG	7,600	.2992	1,3	36	8
B051A07700CPG	B052A07700CPG	B053A07700CPG	7,700	.3031	1,3	36	8
B051A07800CPG	B052A07800CPG	B053A07800CPG	7,800	.3071	1,3	36	8
B051A07900CPG	B052A07900CPG	B053A07900CPG	7,900	.3110	1,3	36	8
B051A07938CPG	B052A07938CPG	B053A07938CPG	7,938	.3125	1,3	36	8
B051A08000CPG	B052A08000CPG	B053A08000CPG	8,000	.3150	1,4	36	8
B051A08100CPG	B052A08100CPG	B053A08100CPG	8,100	.3189	1,4	40	10
B051A08200CPG	B052A08200CPG	B053A08200CPG	8,200	.3228	1,4	40	10
B051A08300CPG	B052A08300CPG	B053A08300CPG	8,300	.3268	1,4	40	10
B051A08334CPG	B052A08334CPG	B053A08334CPG	8,334	.3281	1,4	40	10
B051A08400CPG	B052A08400CPG	B053A08400CPG	8,400	.3307	1,4	40	10
B051A08433CPG	B052A08433CPG	B053A08433CPG	8,433	.3320	1,4	40	10
B051A08500CPG	B052A08500CPG	B053A08500CPG	8,500	.3346	1,4	40	10
B051A08600CPG	B052A08600CPG	B053A08600CPG	8,600	.3386	1,5	40	10
B051A08700CPG	B052A08700CPG	B053A08700CPG	8,700	.3425	1,5	40	10
B051A08733CPG	B052A08733CPG	B053A08733CPG	8,733	.3438	1,5	40	10
B051A08800CPG	B052A08800CPG	B053A08800CPG	8,800	.3465	1,5	40	10
B051A08900CPG	B052A08900CPG	B053A08900CPG	8,900	.3504	1,5	40	10
B051A09000CPG	B052A09000CPG	B053A09000CPG	9,000	.3543	1,5	40	10
B051A09100CPG	B052A09100CPG	B053A09100CPG	9,100	.3583	1,5	40	10
B051A09129CPG	B052A09129CPG	B053A09129CPG	9,129	.3594	1,6	40	10
B051A09200CPG	B052A09200CPG	B053A09200CPG	9,200	.3622	1,6	40	10
B051A09300CPG	B052A09300CPG	B053A09300CPG	9,300	.3661	1,6	40	10
B051A09347CPG	B052A09347CPG	B053A09347CPG	9,347	.3680	1,6	40	10
B051A09400CPG	B052A09400CPG	B053A09400CPG	9,400	.3701	1,6	40	10
B051A09500CPG	B052A09500CPG	B053A09500CPG	9,500	.3740	1,6	40	10
B051A09525CPG	B052A09525CPG	B053A09525CPG	9,525	.3750	1,6	40	10
B051A09600CPG	B052A09600CPG	B053A09600CPG	9,600	.3780	1,6	40	10
B051A09700CPG	B052A09700CPG	B053A09700CPG	9,700	.3819	1,7	40	10
B051A09800CPG	B052A09800CPG	B053A09800CPG	9,800	.3858	1,7	40	10

(continued)

(B051A/B052A/B053A • ~3 x D/~5 x D/~8 x D — continued)





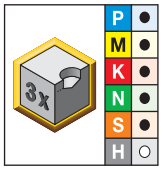


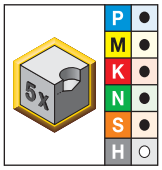
● first choice
○ alternate choice

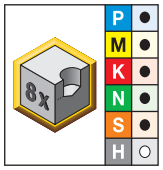
short • KC7325	long • KC7325	extra long • KC7325	D1 diameter mm	D1 diameter in	L5	LS	D
B051A09900CPG	B052A09900CPG	B053A09900CPG	9,900	.3898	1,7	40	10
B051A09921CPG	B052A09921CPG	B053A09921CPG	9,921	.3906	1,7	40	10
B051A10000CPG	B052A10000CPG	B053A10000CPG	10,000	.3937	1,7	40	10
B051A10100CPG	B052A10100CPG	B053A10100CPG	10,100	.3976	1,7	45	12
B051A10200CPG	B052A10200CPG	B053A10200CPG	10,200	.4016	1,7	45	12
B051A10300CPG	B052A10300CPG	B053A10300CPG	10,300	.4055	1,8	45	12
B051A10320CPG	B052A10320CPG	B053A10320CPG	10,320	.4063	1,8	45	12
B051A10400CPG	B052A10400CPG	B053A10400CPG	10,400	.4094	1,8	45	12
B051A10500CPG	B052A10500CPG	B053A10500CPG	10,500	.4134	1,8	45	12
B051A10600CPG	B052A10600CPG	B053A10600CPG	10,600	.4173	1,8	45	12
B051A10700CPG	B052A10700CPG	B053A10700CPG	10,700	.4213	1,8	45	12
B051A10716CPG	B052A10716CPG	B053A10716CPG	10,716	.4219	1,8	45	12
B051A10800CPG	B052A10800CPG	B053A10800CPG	10,800	.4252	1,8	45	12
B051A10900CPG	B052A10900CPG	B053A10900CPG	10,900	.4291	1,9	45	12
B051A11000CPG	B052A11000CPG	B053A11000CPG	11,000	.4331	1,9	45	12
B051A11100CPG	B052A11100CPG	B053A11100CPG	11,100	.4370	1,9	45	12
B051A11113CPG	B052A11113CPG	B053A11113CPG	11,113	.4375	1,9	45	12
B051A11200CPG	B052A11200CPG	B053A11200CPG	11,200	.4409	1,9	45	12
B051A11300CPG	B052A11300CPG	B053A11300CPG	11,300	.4449	1,9	45	12
B051A11400CPG	B052A11400CPG	B053A11400CPG	11,400	.4488	2,0	45	12
B051A11500CPG	B052A11500CPG	B053A11500CPG	11,500	.4528	2,0	45	12
B051A11509CPG	B052A11509CPG	B053A11509CPG	11,509	.4531	2,0	45	12
B051A11600CPG	B052A11600CPG	B053A11600CPG	11,600	.4567	2,0	45	12
B051A11700CPG	B052A11700CPG	B053A11700CPG	11,700	.4606	2,0	45	12
B051A11800CPG	B052A11800CPG	B053A11800CPG	11,800	.4646	2,0	45	12
B051A11900CPG	B052A11900CPG	B053A11900CPG	11,900	.4685	2,0	45	12
B051A11908CPG	B052A11908CPG	B053A11908CPG	11,908	.4688	2,0	45	12
B051A12000CPG	B052A12000CPG	B053A12000CPG	12,000	.4724	2,1	45	12
B051A12100CPG	B052A12100CPG	B053A12100CPG	12,100	.4764	2,1	45	14
B051A12200CPG	B052A12200CPG	B053A12200CPG	12,200	.4803	2,1	45	14
B051A12300CPG	B052A12300CPG	B053A12300CPG	12,300	.4843	2,1	45	14
B051A12304CPG	B052A12304CPG	B053A12304CPG	12,304	.4844	2,1	45	14
B051A12400CPG	B052A12400CPG	B053A12400CPG	12,400	.4882	2,1	45	14
B051A12500CPG	B052A12500CPG	B053A12500CPG	12,500	.4921	2,1	45	14
B051A12600CPG	B052A12600CPG	B053A12600CPG	12,600	.4961	2,2	45	14
B051A12700CPG	B052A12700CPG	B053A12700CPG	12,700	.5000	2,2	45	14
B051A12800CPG	B052A12800CPG	B053A12800CPG	12,800	.5039	2,2	45	14
B051A12900CPG	B052A12900CPG	B053A12900CPG	12,900	.5079	2,2	45	14
B051A13000CPG	B052A13000CPG	B053A13000CPG	13,000	.5118	2,2	45	14
B051A13096CPG	B052A13096CPG	B053A13096CPG	13,096	.5156	2,3	45	14
B051A13100CPG	B052A13100CPG	B053A13100CPG	13,100	.5157	2,3	45	14
B051A13200CPG	B052A13200CPG	B053A13200CPG	13,200	.5197	2,3	45	14
B051A13300CPG	B052A13300CPG	B053A13300CPG	13,300	.5236	2,3	45	14
B051A13400CPG	B052A13400CPG	B053A13400CPG	13,400	.5276	2,3	45	14
B051A13500CPG	B052A13500CPG	B053A13500CPG	13,500	.5315	2,3	45	14
B051A13600CPG	B052A13600CPG	B053A13600CPG	13,600	.5354	2,3	45	14
B051A13700CPG	B052A13700CPG	B053A13700CPG	13,700	.5394	2,4	45	14
B051A13800CPG	B052A13800CPG	B053A13800CPG	13,800	.5433	2,4	45	14
B051A13891CPG	B052A13891CPG	B053A13891CPG	13,891	.5469	2,4	45	14
B051A13900CPG	B052A13900CPG	B053A13900CPG	13,900	.5472	2,4	45	14
B051A14000CPG	B052A14000CPG	B053A14000CPG	14,000	.5512	2,4	45	14
B051A14100CPG	B052A14100CPG	B053A14100CPG	14,100	.5551	2,4	48	16

(continued)

(B051A/B052A/B053A • ~3 x D/~5 x D/~8 x D — continued)





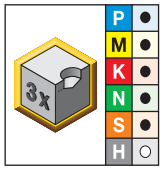


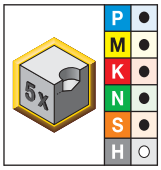
● first choice
○ alternate choice

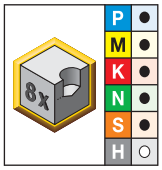
short • KC7325	long • KC7325	extra long • KC7325	D1 diameter mm	D1 diameter in	L5	LS	D
B051A14200CPG	B052A14200CPG	B053A14200CPG	14,200	.5591	2,5	48	16
B051A14288CPG	B052A14288CPG	B053A14288CPG	14,288	.5625	2,5	48	16
B051A14300CPG	B052A14300CPG	B053A14300CPG	14,300	.5630	2,5	48	16
B051A14400CPG	B052A14400CPG	B053A14400CPG	14,400	.5669	2,5	48	16
B051A14500CPG	B052A14500CPG	B053A14500CPG	14,500	.5709	2,5	48	16
B051A14600CPG	B052A14600CPG	B053A14600CPG	14,600	.5748	2,5	48	16
B051A14684CPG	B052A14684CPG	B053A14684CPG	14,684	.5781	2,5	48	16
B051A14700CPG	B052A14700CPG	B053A14700CPG	14,700	.5787	2,5	48	16
B051A14800CPG	B052A14800CPG	B053A14800CPG	14,800	.5827	2,6	48	16
B051A14900CPG	B052A14900CPG	B053A14900CPG	14,900	.5866	2,6	48	16
B051A15000CPG	B052A15000CPG	B053A15000CPG	15,000	.5906	2,6	48	16
B051A15083CPG	B052A15083CPG	B053A15083CPG	15,083	.5938	2,6	48	16
B051A15100CPG	B052A15100CPG	B053A15100CPG	15,100	.5945	2,6	48	16
B051A15200CPG	B052A15200CPG	B053A15200CPG	15,200	.5984	2,6	48	16
B051A15300CPG	B052A15300CPG	B053A15300CPG	15,300	.6024	2,6	48	16
B051A15400CPG	B052A15400CPG	B053A15400CPG	15,400	.6063	2,7	48	16
B051A15479CPG	B052A15479CPG	B053A15479CPG	15,479	.6094	2,7	48	16
B051A15500CPG	B052A15500CPG	B053A15500CPG	15,500	.6102	2,7	48	16
B051A15600CPG	B052A15600CPG	B053A15600CPG	15,600	.6142	2,7	48	16
B051A15700CPG	B052A15700CPG	B053A15700CPG	15,700	.6181	2,7	48	16
B051A15800CPG	B052A15800CPG	B053A15800CPG	15,800	.6220	2,7	48	16
B051A15875CPG	B052A15875CPG	B053A15875CPG	15,875	.6250	2,7	48	16
B051A15900CPG	B052A15900CPG	B053A15900CPG	15,900	.6260	2,8	48	16
B051A16000CPG	B052A16000CPG	B053A16000CPG	16,000	.6299	2,8	48	16
B051A16100CPG	B052A16100CPG	B053A16100CPG	16,100	.6339	2,8	48	18
B051A16200CPG	B052A16200CPG	B053A16200CPG	16,200	.6378	2,8	48	18
B051A16271CPG	B052A16271CPG	B053A16271CPG	16,271	.6406	2,8	48	18
B051A16300CPG	B052A16300CPG	B053A16300CPG	16,300	.6417	2,8	48	18
B051A16400CPG	B052A16400CPG	B053A16400CPG	16,400	.6457	2,8	48	18
B051A16500CPG	B052A16500CPG	B053A16500CPG	16,500	.6496	2,9	48	18
B051A16600CPG	B052A16600CPG	B053A16600CPG	16,600	.6535	2,9	48	18
B051A16670CPG	B052A16670CPG	B053A16670CPG	16,670	.6563	2,9	48	18
B051A16700CPG	B052A16700CPG	B053A16700CPG	16,700	.6575	2,9	48	18
B051A16800CPG	B052A16800CPG	B053A16800CPG	16,800	.6614	2,9	48	18
B051A16900CPG	B052A16900CPG	B053A16900CPG	16,900	.6654	2,9	48	18
B051A17000CPG	B052A17000CPG	B053A17000CPG	17,000	.6693	2,9	48	18
B051A17100CPG	B052A17100CPG	B053A17100CPG	17,100	.6732	3,0	48	18
B051A17200CPG	B052A17200CPG	B053A17200CPG	17,200	.6772	3,0	48	18
B051A17300CPG	B052A17300CPG	B053A17300CPG	17,300	.6811	3,0	48	18
B051A17400CPG	B052A17400CPG	B053A17400CPG	17,400	.6850	3,0	48	18
B051A17463CPG	B052A17463CPG	B053A17463CPG	17,463	.6875	3,0	48	18
B051A17500CPG	B052A17500CPG	B053A17500CPG	17,500	.6890	3,0	48	18
B051A17600CPG	B052A17600CPG	B053A17600CPG	17,600	.6929	3,1	48	18
B051A17700CPG	B052A17700CPG	B053A17700CPG	17,700	.6969	3,1	48	18
B051A17800CPG	B052A17800CPG	B053A17800CPG	17,800	.7008	3,1	48	18
B051A17859CPG	B052A17859CPG	B053A17859CPG	17,859	.7031	3,1	48	18
B051A17900CPG	B052A17900CPG	B053A17900CPG	17,900	.7047	3,1	48	18
B051A18000CPG	B052A18000CPG	B053A18000CPG	18,000	.7087	3,1	48	18
B051A18100CPG	B052A18100CPG	B053A18100CPG	18,100	.7126	3,1	50	20
B051A18200CPG	B052A18200CPG	B053A18200CPG	18,200	.7165	3,2	50	20
B051A18258CPG	B052A18258CPG	B053A18258CPG	18,258	.7188	3,2	50	20
B051A18300CPG	B052A18300CPG	B053A18300CPG	18,300	.7205	3,2	50	20

(continued)

(B051A/B052A/B053A • ~3 x D/~5 x D/~8 x D — continued)





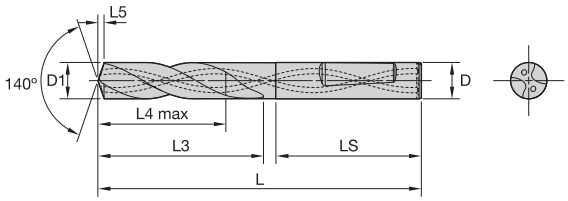


● first choice
○ alternate choice

short • KC7325	long • KC7325	extra long • KC7325	D1 diameter mm	D1 diameter in	L5	LS	D
B051A18400CPG	B052A18400CPG	B053A18400CPG	18,400	.7244	3,2	50	20
B051A18500CPG	B052A18500CPG	B053A18500CPG	18,500	.7283	3,2	50	20
B051A18600CPG	B052A18600CPG	B053A18600CPG	18,600	.7323	3,2	50	20
B051A18654CPG	B052A18654CPG	B053A18654CPG	18,654	.7344	3,2	50	20
B051A18700CPG	B052A18700CPG	B053A18700CPG	18,700	.7362	3,2	50	20
B051A18800CPG	B052A18800CPG	B053A18800CPG	18,800	.7402	3,3	50	20
B051A18900CPG	B052A18900CPG	B053A18900CPG	18,900	.7441	3,3	50	20
B051A19000CPG	B052A19000CPG	B053A19000CPG	19,000	.7480	3,3	50	20
B051A19050CPG	B052A19050CPG	B053A19050CPG	19,050	.7500	3,3	50	20
B051A19100CPG	B052A19100CPG	B053A19100CPG	19,100	.7520	3,3	50	20
B051A19200CPG	B052A19200CPG	B053A19200CPG	19,200	.7559	3,3	50	20
B051A19300CPG	B052A19300CPG	B053A19300CPG	19,300	.7598	3,4	50	20
B051A19400CPG	B052A19400CPG	B053A19400CPG	19,400	.7638	3,4	50	20
B051A19500CPG	B052A19500CPG	B053A19500CPG	19,500	.7677	3,4	50	20
B051A19600CPG	B052A19600CPG	B053A19600CPG	19,600	.7717	3,4	50	20
B051A19700CPG	B052A19700CPG	B053A19700CPG	19,700	.7756	3,4	50	20
B051A19800CPG	B052A19800CPG	B053A19800CPG	19,800	.7795	3,4	50	20
B051A19900CPG	B052A19900CPG	B053A19900CPG	19,900	.7835	3,5	50	20
B051A20000CPG	B052A20000CPG	B053A20000CPG	20,000	.7874	3,5	50	20

NOTE: GOdrills with a D1 < 1,5mm (.0591") have coolant exiting the shank.

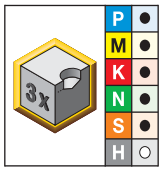


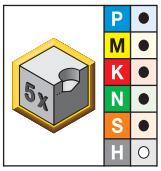




For information on L, L3, and L4 max, see the Solid Carbide Drills foldout table.

B051F/B052F/B053F • ~3 x D/~5 x D/~8 x D



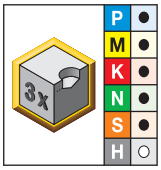


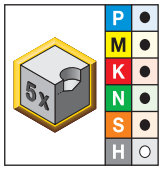
● first choice
○ alternate choice

short • KC7325	long • KC7325	D1 diameter mm	D1 diameter in	L5	LS	D
B051F03000CPG	B052F03000CPG	3,000	.1181	0,5	36	6
B051F03100CPG	B052F03100CPG	3,100	.1220	0,5	36	6
B051F03200CPG	B052F03200CPG	3,200	.1260	0,5	36	6
B051F03300CPG	B052F03300CPG	3,300	.1299	0,5	36	6
B051F03400CPG	B052F03400CPG	3,400	.1339	0,6	36	6
B051F03500CPG	B052F03500CPG	3,500	.1378	0,6	36	6
B051F03600CPG	B052F03600CPG	3,600	.1417	0,6	36	6
B051F03700CPG	B052F03700CPG	3,700	.1457	0,6	36	6
B051F03800CPG	B052F03800CPG	3,800	.1496	0,6	36	6
B051F03900CPG	B052F03900CPG	3,900	.1535	0,6	36	6
B051F04000CPG	B052F04000CPG	4,000	.1575	0,7	36	6
B051F04100CPG	B052F04100CPG	4,100	.1614	0,7	36	6
B051F04200CPG	B052F04200CPG	4,200	.1654	0,7	36	6
B051F04300CPG	B052F04300CPG	4,300	.1693	0,7	36	6
B051F04400CPG	B052F04400CPG	4,400	.1732	0,7	36	6
B051F04500CPG	B052F04500CPG	4,500	.1772	0,7	36	6
B051F04600CPG	B052F04600CPG	4,600	.1811	0,8	36	6
B051F04700CPG	B052F04700CPG	4,700	.1850	0,8	36	6
B051F04800CPG	B052F04800CPG	4,800	.1890	0,8	36	6
B051F04900CPG	B052F04900CPG	4,900	.1929	0,8	36	6
B051F05000CPG	B052F05000CPG	5,000	.1969	0,8	36	6
B051F05100CPG	B052F05100CPG	5,100	.2008	0,8	36	6
B051F05200CPG	B052F05200CPG	5,200	.2047	0,9	36	6
B051F05300CPG	B052F05300CPG	5,300	.2087	0,9	36	6
B051F05400CPG	B052F05400CPG	5,400	.2126	0,9	36	6
B051F05500CPG	B052F05500CPG	5,500	.2165	0,9	36	6
B051F05600CPG	B052F05600CPG	5,600	.2205	0,9	36	6
B051F05700CPG	B052F05700CPG	5,700	.2244	1,0	36	6
B051F05800CPG	B052F05800CPG	5,800	.2283	1,0	36	6
B051F05900CPG	B052F05900CPG	5,900	.2323	1,0	36	6
B051F06000CPG	B052F06000CPG	6,000	.2362	1,0	36	6
B051F06100CPG	B052F06100CPG	6,100	.2402	1,0	36	8

(continued)

(B051F/B052F/B053F • ~3 x D/~5 x D/~8 x D — continued)



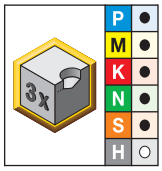


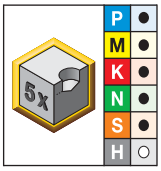
● first choice
○ alternate choice

short • KC7325	long • KC7325	D1 diameter mm	D1 diameter in	L5	LS	D
B051F06200CPG	B052F06200CPG	6,200	.2441	1,0	36	8
B051F06300CPG	B052F06300CPG	6,300	.2480	1,1	36	8
B051F06400CPG	B052F06400CPG	6,400	.2520	1,1	36	8
B051F06500CPG	B052F06500CPG	6,500	.2559	1,1	36	8
B051F06600CPG	B052F06600CPG	6,600	.2598	1,1	36	8
B051F06700CPG	B052F06700CPG	6,700	.2638	1,1	36	8
B051F06800CPG	B052F06800CPG	6,800	.2677	1,1	36	8
B051F06900CPG	B052F06900CPG	6,900	.2717	1,2	36	8
B051F07000CPG	B052F07000CPG	7,000	.2756	1,2	36	8
B051F07100CPG	B052F07100CPG	7,100	.2795	1,2	36	8
B051F07200CPG	B052F07200CPG	7,200	.2835	1,2	36	8
B051F07300CPG	B052F07300CPG	7,300	.2874	1,2	36	8
B051F07400CPG	B052F07400CPG	7,400	.2913	1,3	36	8
B051F07500CPG	B052F07500CPG	7,500	.2953	1,3	36	8
B051F07600CPG	B052F07600CPG	7,600	.2992	1,3	36	8
B051F07700CPG	B052F07700CPG	7,700	.3031	1,3	36	8
B051F07800CPG	B052F07800CPG	7,800	.3071	1,3	36	8
B051F07900CPG	B052F07900CPG	7,900	.3110	1,3	36	8
B051F08000CPG	B052F08000CPG	8,000	.3150	1,4	36	8
B051F08100CPG	B052F08100CPG	8,100	.3189	1,4	40	10
B051F08200CPG	B052F08200CPG	8,200	.3228	1,4	40	10
B051F08300CPG	B052F08300CPG	8,300	.3268	1,4	40	10
B051F08400CPG	B052F08400CPG	8,400	.3307	1,4	40	10
B051F08500CPG	B052F08500CPG	8,500	.3346	1,4	40	10
B051F08600CPG	B052F08600CPG	8,600	.3386	1,5	40	10
B051F08700CPG	B052F08700CPG	8,700	.3425	1,5	40	10
B051F08800CPG	B052F08800CPG	8,800	.3465	1,5	40	10
B051F08900CPG	B052F08900CPG	8,900	.3504	1,5	40	10
B051F09000CPG	B052F09000CPG	9,000	.3543	1,5	40	10
B051F09100CPG	B052F09100CPG	9,100	.3583	1,5	40	10
B051F09200CPG	B052F09200CPG	9,200	.3622	1,6	40	10
B051F09300CPG	B052F09300CPG	9,300	.3661	1,6	40	10
B051F09400CPG	B052F09400CPG	9,400	.3701	1,6	40	10
B051F09500CPG	B052F09500CPG	9,500	.3740	1,6	40	10
B051F09600CPG	B052F09600CPG	9,600	.3780	1,6	40	10
B051F09700CPG	B052F09700CPG	9,700	.3819	1,7	40	10
B051F09800CPG	B052F09800CPG	9,800	.3858	1,7	40	10
B051F09900CPG	B052F09900CPG	9,900	.3898	1,7	40	10
B051F10000CPG	B052F10000CPG	10,000	.3937	1,7	40	10
B051F10100CPG	B052F10100CPG	10,100	.3976	1,7	45	12
B051F10200CPG	B052F10200CPG	10,200	.4016	1,7	45	12
B051F10300CPG	B052F10300CPG	10,300	.4055	1,8	45	12
B051F10400CPG	B052F10400CPG	10,400	.4094	1,8	45	12
B051F10500CPG	B052F10500CPG	10,500	.4134	1,8	45	12
B051F10600CPG	B052F10600CPG	10,600	.4173	1,8	45	12
B051F10700CPG	B052F10700CPG	10,700	.4213	1,8	45	12
B051F10800CPG	B052F10800CPG	10,800	.4252	1,8	45	12
B051F10900CPG	B052F10900CPG	10,900	.4291	1,9	45	12
B051F11000CPG	B052F11000CPG	11,000	.4331	1,9	45	12
B051F11100CPG	B052F11100CPG	11,100	.4370	1,9	45	12
B051F11200CPG	B052F11200CPG	11,200	.4409	1,9	45	12
B051F11300CPG	B052F11300CPG	11,300	.4449	1,9	45	12

(continued)

(B051F/B052F/B053F • ~3 x D/~5 x D/~8 x D — continued)



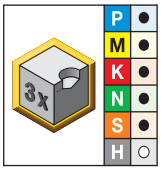


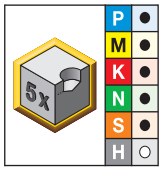
● first choice
○ alternate choice

short • KC7325	long • KC7325	D1 diameter mm	D1 diameter in	L5	LS	D
B051F11400CPG	B052F11400CPG	11,400	.4488	2,0	45	12
B051F11500CPG	B052F11500CPG	11,500	.4528	2,0	45	12
B051F11600CPG	B052F11600CPG	11,600	.4567	2,0	45	12
B051F11700CPG	B052F11700CPG	11,700	.4606	2,0	45	12
B051F11800CPG	B052F11800CPG	11,800	.4646	2,0	45	12
B051F11900CPG	B052F11900CPG	11,900	.4685	2,0	45	12
B051F12000CPG	B052F12000CPG	12,000	.4724	2,1	45	12
B051F12100CPG	B052F12100CPG	12,100	.4764	2,1	45	14
B051F12200CPG	B052F12200CPG	12,200	.4803	2,1	45	14
B051F12300CPG	B052F12300CPG	12,300	.4843	2,1	45	14
B051F12400CPG	B052F12400CPG	12,400	.4882	2,1	45	14
B051F12500CPG	B052F12500CPG	12,500	.4921	2,1	45	14
B051F12600CPG	B052F12600CPG	12,600	.4961	2,2	45	14
B051F12700CPG	B052F12700CPG	12,700	.5000	2,2	45	14
B051F12800CPG	B052F12800CPG	12,800	.5039	2,2	45	14
B051F12900CPG	B052F12900CPG	12,900	.5079	2,2	45	14
B051F13000CPG	B052F13000CPG	13,000	.5118	2,2	45	14
B051F13100CPG	B052F13100CPG	13,100	.5157	2,3	45	14
B051F13200CPG	B052F13200CPG	13,200	.5197	2,3	45	14
B051F13300CPG	B052F13300CPG	13,300	.5236	2,3	45	14
B051F13400CPG	B052F13400CPG	13,400	.5276	2,3	45	14
B051F13500CPG	B052F13500CPG	13,500	.5315	2,3	45	14
B051F13600CPG	B052F13600CPG	13,600	.5354	2,3	45	14
B051F13700CPG	B052F13700CPG	13,700	.5394	2,4	45	14
B051F13800CPG	B052F13800CPG	13,800	.5433	2,4	45	14
B051F13900CPG	B052F13900CPG	13,900	.5472	2,4	45	14
B051F14000CPG	B052F14000CPG	14,000	.5512	2,4	45	14
B051F14100CPG	B052F14100CPG	14,100	.5551	2,4	48	16
B051F14200CPG	B052F14200CPG	14,200	.5591	2,5	48	16
B051F14300CPG	B052F14300CPG	14,300	.5630	2,5	48	16
B051F14400CPG	B052F14400CPG	14,400	.5669	2,5	48	16
B051F14500CPG	B052F14500CPG	14,500	.5709	2,5	48	16
B051F14600CPG	B052F14600CPG	14,600	.5748	2,5	48	16
B051F14700CPG	B052F14700CPG	14,700	.5787	2,5	48	16
B051F14800CPG	B052F14800CPG	14,800	.5827	2,6	48	16
B051F14900CPG	B052F14900CPG	14,900	.5866	2,6	48	16
B051F15000CPG	B052F15000CPG	15,000	.5906	2,6	48	16
B051F15100CPG	B052F15100CPG	15,100	.5945	2,6	48	16
B051F15200CPG	B052F15200CPG	15,200	.5984	2,6	48	16
B051F15300CPG	B052F15300CPG	15,300	.6024	2,6	48	16
B051F15400CPG	B052F15400CPG	15,400	.6063	2,7	48	16
B051F15500CPG	B052F15500CPG	15,500	.6102	2,7	48	16
B051F15600CPG	B052F15600CPG	15,600	.6142	2,7	48	16
B051F15700CPG	B052F15700CPG	15,700	.6181	2,7	48	16
B051F15800CPG	B052F15800CPG	15,800	.6220	2,7	48	16
B051F15900CPG	B052F15900CPG	15,900	.6260	2,8	48	16
B051F16000CPG	B052F16000CPG	16,000	.6299	2,8	48	16
B051F16100CPG	B052F16100CPG	16,100	.6339	2,8	48	18
B051F16200CPG	B052F16200CPG	16,200	.6378	2,8	48	18
B051F16300CPG	B052F16300CPG	16,300	.6417	2,8	48	18
B051F16400CPG	B052F16400CPG	16,400	.6457	2,8	48	18
B051F16500CPG	B052F16500CPG	16,500	.6496	2,9	48	18

(continued)

(B051F/B052F/B053F • ~3 x D/~5 x D/~8 x D — continued)





● first choice
○ alternate choice

short • KC7325	long • KC7325	D1 diameter mm	D1 diameter in	L5	LS	D
B051F16600CPG	B052F16600CPG	16,600	.6535	2,9	48	18
B051F16700CPG	B052F16700CPG	16,700	.6575	2,9	48	18
B051F16800CPG	B052F16800CPG	16,800	.6614	2,9	48	18
B051F16900CPG	B052F16900CPG	16,900	.6654	2,9	48	18
B051F17000CPG	B052F17000CPG	17,000	.6693	2,9	48	18
B051F17100CPG	B052F17100CPG	17,100	.6732	3,0	48	18
B051F17200CPG	B052F17200CPG	17,200	.6772	3,0	48	18
B051F17300CPG	B052F17300CPG	17,300	.6811	3,0	48	18
B051F17400CPG	B052F17400CPG	17,400	.6850	3,0	48	18
B051F17500CPG	B052F17500CPG	17,500	.6890	3,0	48	18
B051F17600CPG	B052F17600CPG	17,600	.6929	3,1	48	18
B051F17700CPG	B052F17700CPG	17,700	.6969	3,1	48	18
B051F17800CPG	B052F17800CPG	17,800	.7008	3,1	48	18
B051F17900CPG	B052F17900CPG	17,900	.7047	3,1	48	18
B051F18000CPG	B052F18000CPG	18,000	.7087	3,1	48	18
B051F18100CPG	B052F18100CPG	18,100	.7126	3,1	50	20
B051F18200CPG	B052F18200CPG	18,200	.7165	3,2	50	20
B051F18300CPG	B052F18300CPG	18,300	.7205	3,2	50	20
B051F18400CPG	B052F18400CPG	18,400	.7244	3,2	50	20
B051F18500CPG	B052F18500CPG	18,500	.7283	3,2	50	20
B051F18600CPG	B052F18600CPG	18,600	.7323	3,2	50	20
B051F18700CPG	B052F18700CPG	18,700	.7362	3,2	50	20
B051F18800CPG	B052F18800CPG	18,800	.7402	3,3	50	20
B051F18900CPG	B052F18900CPG	18,900	.7441	3,3	50	20
B051F19000CPG	B052F19000CPG	19,000	.7480	3,3	50	20
B051F19100CPG	B052F19100CPG	19,100	.7520	3,3	50	20
B051F19200CPG	B052F19200CPG	19,200	.7559	3,3	50	20
B051F19300CPG	B052F19300CPG	19,300	.7598	3,4	50	20
B051F19400CPG	B052F19400CPG	19,400	.7638	3,4	50	20
B051F19500CPG	B052F19500CPG	19,500	.7677	3,4	50	20
B051F19600CPG	B052F19600CPG	19,600	.7717	3,4	50	20
B051F19700CPG	B052F19700CPG	19,700	.7756	3,4	50	20
B051F19800CPG	B052F19800CPG	19,800	.7795	3,4	50	20
B051F19900CPG	B052F19900CPG	19,900	.7835	3,5	50	20
B051F20000CPG	B052F20000CPG	20,000	.7874	3,5	50	20

Tolerance • Metric

nominal size range	D1 tolerance	D tolerance h6
1–3	0,000/-0,014 (h8)	0,000/-0,006
>3–6	0,000/-0,012 (h7)	0,000/-0,008
>6–10	0,000/-0,015 (h7)	0,000/-0,009
>10–18	0,000/-0,018 (h7)	0,000/-0,011
>18–20	0,000/-0,021 (h7)	0,000/-0,013

GOdrill™ • B04_CPG Series • Grade KC7325™ • Flood Coolant • Drill Diameters 1–20mm • Metric



Material Group		Cutting Speed – vc			Metric										
		Range – m/min			Recommended Feed Rate (f) by Diameter										
		min	Starting Value	max		1,0	2,0	3,0	4,0	6,0	8,0	10,0	12,0	16,0	20,0
P	0	70	**80**	115	mm/r	0,03–0,08	0,04–0,09	0,05–0,11	0,08–0,14	0,09–0,19	0,11–0,22	0,13–0,26	0,15–0,30	0,19–0,36	0,24–0,46
	1	60	**70**	100	mm/r	0,04–0,09	0,05–0,11	0,06–0,13	0,09–0,16	0,11–0,22	0,13–0,26	0,15–0,31	0,18–0,35	0,22–0,42	0,28–0,54
	2	80	**90**	100	mm/r	0,04–0,09	0,05–0,11	0,06–0,13	0,08–0,16	0,12–0,22	0,14–0,26	0,17–0,31	0,20–0,35	0,24–0,42	0,31–0,53
	3	50	**70**	90	mm/r	0,05–0,11	0,06–0,13	0,07–0,15	0,09–0,17	0,13–0,23	0,15–0,28	0,19–0,33	0,22–0,38	0,26–0,47	0,34–0,59
	4	50	**70**	100	mm/r	0,04–0,12	0,05–0,13	0,06–0,15	0,08–0,17	0,12–0,23	0,14–0,28	0,17–0,33	0,19–0,38	0,23–0,47	0,29–0,59
	5	30	**40**	60	mm/r	0,03–0,05	0,04–0,06	0,05–0,07	0,06–0,10	0,08–0,14	0,10–0,18	0,12–0,22	0,14–0,24	0,18–0,32	0,23–0,41
	6	30	**40**	60	mm/r	0,03–0,05	0,04–0,06	0,05–0,07	0,06–0,10	0,08–0,14	0,10–0,18	0,12–0,22	0,14–0,24	0,18–0,32	0,23–0,41
M	1	20	**30**	40	mm/r	0,02–0,05	0,03–0,06	0,04–0,07	0,05–0,09	0,08–0,11	0,09–0,12	0,10–0,14	0,12–0,16	0,14–0,18	0,16–0,20
	2	30	**40**	50	mm/r	0,02–0,06	0,03–0,07	0,04–0,08	0,06–0,10	0,08–0,12	0,09–0,14	0,10–0,16	0,12–0,18	0,14–0,20	0,16–0,22
	3	20	**30**	40	mm/r	0,02–0,05	0,03–0,06	0,04–0,07	0,06–0,09	0,08–0,11	0,09–0,12	0,10–0,14	0,12–0,16	0,14–0,18	0,16–0,20
K	1	80	**130**	170	mm/r	0,09–0,18	0,10–0,20	0,11–0,22	0,12–0,24	0,16–0,31	0,20–0,38	0,23–0,44	0,25–0,49	0,31–0,60	0,38–0,74
	2	90	**110**	120	mm/r	0,06–0,13	0,08–0,15	0,10–0,17	0,12–0,19	0,16–0,25	0,20–0,31	0,23–0,36	0,25–0,40	0,31–0,48	0,38–0,60
	3	80	**110**	130	mm/r	0,05–0,11	0,06–0,13	0,07–0,15	0,09–0,19	0,12–0,25	0,14–0,30	0,17–0,35	0,19–0,40	0,25–0,48	0,30–0,60
N	1	90	**230**	270	mm/r	0,05–0,12	0,06–0,13	0,08–0,14	0,10–0,16	0,12–0,20	0,16–0,24	0,20–0,28	0,24–0,32	0,28–0,40	0,32–0,48
	2	90	**220**	270	mm/r	0,04–0,08	0,06–0,12	0,08–0,16	0,10–0,20	0,12–0,24	0,16–0,28	0,20–0,32	0,24–0,36	0,28–0,44	0,32–0,52
	3	90	**180**	225	mm/r	0,10–0,13	0,11–0,14	0,12–0,14	0,13–0,16	0,14–0,20	0,16–0,24	0,20–0,28	0,24–0,32	0,28–0,40	0,32–0,44
	4	90	**130**	270	mm/r	0,04–0,08	0,06–0,12	0,08–0,16	0,10–0,20	0,12–0,24	0,16–0,28	0,20–0,32	0,24–0,36	0,28–0,40	0,32–0,48
S	1	20	**25**	30	mm/r	0,01–0,04	0,02–0,05	0,03–0,06	0,04–0,08	0,06–0,10	0,08–0,12	0,09–0,13	0,10–0,14	0,12–0,16	0,14–0,18
	2	10	**20**	30	mm/r	0,01–0,03	0,02–0,03	0,02–0,04	0,03–0,06	0,05–0,08	0,07–0,10	0,08–0,11	0,09–0,12	0,10–0,14	0,11–0,16
	3	20	**25**	40	mm/r	0,01–0,03	0,02–0,03	0,02–0,04	0,02–0,05	0,04–0,07	0,06–0,09	0,07–0,10	0,08–0,11	0,09–0,13	0,10–0,15
	4	20	**25**	50	mm/r	0,01–0,03	0,02–0,03	0,02–0,04	0,03–0,06	0,05–0,08	0,07–0,10	0,08–0,11	0,09–0,12	0,10–0,14	0,11–0,16
H	1	10	**15**	30	mm/r	0,01–0,03	0,02–0,03	0,02–0,04	0,03–0,06	0,05–0,08	0,07–0,10	0,08–0,11	0,09–0,12	0,10–0,14	0,11–0,16
	2	10	**10**	30	mm/r	0,01–0,03	0,02–0,03	0,02–0,04	0,02–0,05	0,04–0,07	0,06–0,09	0,07–0,10	0,08–0,11	0,09–0,13	0,10–0,15

GOdrill™ • B05_CPG Series • Grade KC7325™ • Through Coolant • Drill Diameters 1–20mm • Metric



Material Group		Cutting Speed — vc			Metric										
		Range — m/min			Recommended Feed Rate (f) by Diameter										
		min	Starting Value	max		1,0	2,0	3,0	4,0	6,0	8,0	10,0	12,0	16,0	20,0
P	0	70	**80**	115	mm/r	0,03–0,08	0,04–0,09	0,05–0,11	0,08–0,14	0,09–0,19	0,11–0,22	0,13–0,26	0,15–0,30	0,19–0,36	0,24–0,46
	1	70	**100**	140	mm/r	0,04–0,09	0,05–0,12	0,07–0,14	0,08–0,16	0,11–0,22	0,13–0,26	0,15–0,31	0,18–0,35	0,22–0,42	0,28–0,54
	2	90	**120**	140	mm/r	0,04–0,09	0,05–0,12	0,07–0,14	0,08–0,16	0,12–0,22	0,14–0,26	0,17–0,31	0,20–0,35	0,24–0,42	0,31–0,53
	3	60	**80**	100	mm/r	0,05–0,10	0,06–0,13	0,08–0,15	0,09–0,17	0,13–0,23	0,15–0,28	0,19–0,33	0,22–0,38	0,26–0,47	0,34–0,59
	4	50	**80**	100	mm/r	0,05–0,10	0,06–0,13	0,07–0,15	0,08–0,17	0,12–0,23	0,14–0,28	0,17–0,33	0,19–0,38	0,23–0,47	0,29–0,59
	5	40	**50**	70	mm/r	0,03–0,05	0,04–0,06	0,05–0,07	0,06–0,10	0,08–0,14	0,10–0,18	0,12–0,22	0,14–0,24	0,18–0,32	0,23–0,41
	6	40	**50**	70	mm/r	0,03–0,05	0,04–0,06	0,05–0,08	0,06–0,10	0,08–0,14	0,10–0,18	0,13–0,22	0,14–0,24	0,18–0,32	0,23–0,41
M	1	20	**30**	40	mm/r	0,02–0,05	0,03–0,06	0,04–0,07	0,05–0,09	0,08–0,11	0,09–0,12	0,10–0,14	0,12–0,16	0,14–0,18	0,16–0,20
	2	30	**40**	50	mm/r	0,02–0,06	0,03–0,07	0,04–0,08	0,06–0,10	0,08–0,12	0,09–0,14	0,10–0,16	0,12–0,18	0,14–0,20	0,16–0,22
	3	20	**30**	40	mm/r	0,02–0,05	0,03–0,06	0,04–0,07	0,05–0,09	0,08–0,11	0,09–0,12	0,10–0,14	0,12–0,16	0,14–0,18	0,16–0,20
K	1	80	**120**	170	mm/r	0,08–0,16	0,09–0,17	0,11–0,22	0,12–0,24	0,16–0,31	0,20–0,38	0,23–0,44	0,25–0,49	0,31–0,60	0,38–0,74
	2	80	**110**	140	mm/r	0,10–0,14	0,11–0,15	0,12–0,16	0,13–0,19	0,16–0,25	0,20–0,31	0,23–0,36	0,25–0,40	0,31–0,48	0,38–0,60
	3	80	**100**	130	mm/r	0,05–0,13	0,07–0,15	0,08–0,17	0,09–0,19	0,12–0,25	0,14–0,30	0,17–0,35	0,19–0,40	0,24–0,48	0,30–0,60
N	1	90	**230**	315	mm/r	0,05–0,12	0,06–0,13	0,08–0,14	0,10–0,16	0,12–0,20	0,16–0,24	0,20–0,28	0,24–0,32	0,28–0,40	0,32–0,48
	2	90	**225**	270	mm/r	0,04–0,08	0,06–0,12	0,08–0,16	0,10–0,20	0,12–0,24	0,16–0,28	0,20–0,32	0,24–0,36	0,28–0,44	0,32–0,52
	3	90	**180**	270	mm/r	0,10–0,13	0,11–0,14	0,12–0,14	0,13–0,16	0,14–0,20	0,16–0,24	0,20–0,28	0,24–0,32	0,28–0,40	0,32–0,44
	4	90	**135**	180	mm/r	0,04–0,08	0,06–0,12	0,08–0,16	0,10–0,20	0,12–0,24	0,16–0,28	0,20–0,32	0,24–0,36	0,28–0,40	0,32–0,48
S	1	10	**25**	30	mm/r	0,01–0,04	0,02–0,05	0,03–0,06	0,04–0,08	0,06–0,10	0,08–0,12	0,09–0,13	0,10–0,14	0,12–0,16	0,14–0,18
	2	10	**20**	25	mm/r	0,01–0,03	0,02–0,03	0,02–0,04	0,03–0,06	0,05–0,08	0,07–0,10	0,08–0,11	0,09–0,12	0,10–0,14	0,11–0,16
	3	10	**25**	30	mm/r	0,01–0,03	0,02–0,03	0,02–0,04	0,02–0,05	0,04–0,07	0,06–0,09	0,07–0,10	0,08–0,11	0,09–0,13	0,10–0,15
	4	10	**25**	40	mm/r	0,01–0,03	0,02–0,03	0,02–0,04	0,03–0,06	0,05–0,08	0,07–0,10	0,08–0,11	0,09–0,12	0,10–0,14	0,11–0,16
H	1	10	**15**	30	mm/r	0,01–0,03	0,02–0,03	0,02–0,04	0,03–0,06	0,05–0,08	0,07–0,10	0,08–0,11	0,09–0,12	0,10–0,14	0,11–0,16
	2	10	**10**	30	mm/r	0,01–0,03	0,02–0,03	0,02–0,04	0,02–0,05	0,04–0,07	0,06–0,09	0,07–0,10	0,08–0,11	0,09–0,13	0,10–0,15

TF Drill for High Metal Removal Rates

Primary Application

B105 Solid Carbide Drills are ideal for high metal removal rates and excellent hole quality in short chipping materials such as grey cast iron, ductile iron, and aluminium as well as in short-hole titanium applications.

Features and Benefits

Three Cutting Edges

- Higher feed rates than with two-edged drills.

Three Spacious Flutes

- Rapid chip evacuation.
- Three-margin lands deliver better hole quality and straightness than two-flute drills.

Wear-Resistant Carbide Grade

- High tool life in abrasive materials such as cast iron and aluminium die cast alloys.



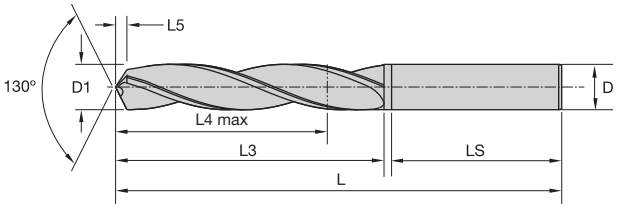
Uncoated K10™ Grade

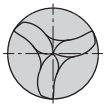
- The uncoated grade helps to prevent built-up edge in drilling aluminium and high-temp alloys.

Customisation

- Intermediate diameters available as engineered solutions.
- Length variations and step drills available as custom solutions.

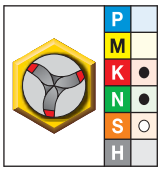








B105 • ~5 x D

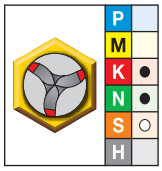


● first choice
○ alternate choice

K10	D1 diameter mm	in	L	L3	L4 max	L5	LS	D
B105A03000	3,000	.1181	66	28	23	0,7	36	6
B105A03100	3,100	.1220	66	28	23	0,8	36	6
B105A03200	3,200	.1260	66	28	23	0,8	36	6
B105A03300	3,300	.1299	66	28	23	0,8	36	6
B105A03400	3,400	.1339	66	28	23	0,8	36	6
B105A03500	3,500	.1378	66	28	23	0,9	36	6
B105A03600	3,600	.1417	66	28	23	0,9	36	6
B105A03700	3,700	.1457	66	28	23	0,9	36	6
B105A03800	3,800	.1496	74	36	29	0,9	36	6
B105A03900	3,900	.1535	74	36	29	1,0	36	6
B105A04000	4,000	.1575	74	36	29	1,0	36	6
B105A04100	4,100	.1614	74	36	29	1,0	36	6
B105A04200	4,200	.1654	74	36	29	1,0	36	6
B105A04300	4,300	.1693	74	36	29	1,1	36	6
B105A04500	4,500	.1772	74	36	29	1,1	36	6
B105A04600	4,600	.1811	74	36	29	1,1	36	6
B105A04650	4,650	.1831	74	36	29	1,2	36	6
B105A04700	4,700	.1850	74	36	29	1,2	36	6
B105A04800	4,800	.1890	82	44	35	1,2	36	6
B105A04900	4,900	.1929	82	44	35	1,2	36	6
B105A05000	5,000	.1969	82	44	35	1,2	36	6
B105A05100	5,100	.2008	82	44	35	1,3	36	6
B105A05200	5,200	.2047	82	44	35	1,3	36	6
B105A05400	5,400	.2126	82	44	35	1,3	36	6
B105A05500	5,500	.2165	82	44	35	1,4	36	6
B105A05550	5,550	.2185	82	44	35	1,4	36	6
B105A05600	5,600	.2205	82	44	35	1,4	36	6
B105A05700	5,700	.2244	82	44	35	1,4	36	6
B105A05800	5,800	.2283	82	44	35	1,4	36	6
B105A06000	6,000	.2362	82	44	35	1,5	36	6
B105A06100	6,100	.2402	91	53	43	1,5	36	8
B105A06200	6,200	.2441	91	53	43	1,5	36	8
B105A06300	6,300	.2480	91	53	43	1,6	36	8
B105A06350	6,350	.2500	91	53	43	1,6	36	8
B105A06400	6,400	.2520	91	53	43	1,6	36	8
B105A06500	6,500	.2559	91	53	43	1,6	36	8

(continued)

(B105 • ~5 x D — continued)

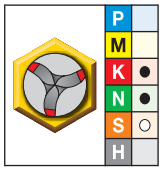


● first choice
○ alternate choice

K10	D1 diameter mm	D1 diameter in	L	L3	L4 max	L5	LS	D
B105A06600	6,600	.2598	91	53	43	1,6	36	8
B105A06700	6,700	.2638	91	53	43	1,7	36	8
B105A06800	6,800	.2677	91	53	43	1,7	36	8
B105A07000	7,000	.2756	91	53	43	1,7	36	8
B105A07100	7,100	.2795	91	53	43	1,8	36	8
B105A07400	7,400	.2913	91	53	43	1,8	36	8
B105A07500	7,500	.2953	91	53	43	1,9	36	8
B105A07600	7,600	.2992	91	53	43	1,9	36	8
B105A07800	7,800	.3071	91	53	43	1,9	36	8
B105A08000	8,000	.3150	91	53	43	2,0	36	8
B105A08100	8,100	.3189	103	61	49	2,0	40	10
B105A08200	8,200	.3228	103	61	49	2,0	40	10
B105A08300	8,300	.3268	103	61	49	2,1	40	10
B105A08400	8,400	.3307	103	61	49	2,1	40	10
B105A08500	8,500	.3346	103	61	49	2,1	40	10
B105A08600	8,600	.3386	103	61	49	2,1	40	10
B105A08700	8,700	.3425	103	61	49	2,2	40	10
B105A08800	8,800	.3465	103	61	49	2,2	40	10
B105A09000	9,000	.3543	103	61	49	2,2	40	10
B105A09100	9,100	.3583	103	61	49	2,3	40	10
B105A09300	9,300	.3661	103	61	49	2,3	40	10
B105A09500	9,500	.3740	103	61	49	2,4	40	10
B105A09700	9,700	.3819	103	61	49	2,4	40	10
B105A09800	9,800	.3858	103	61	49	2,4	40	10
B105A10000	10,000	.3937	103	61	49	2,5	40	10
B105A10100	10,100	.3976	118	71	56	2,5	45	12
B105A10200	10,200	.4016	118	71	56	2,5	45	12
B105A10300	10,300	.4055	118	71	56	2,6	45	12
B105A10400	10,400	.4094	118	71	56	2,6	45	12
B105A10500	10,500	.4134	118	71	56	2,6	45	12
B105A10700	10,700	.4213	118	71	56	2,7	45	12
B105A10800	10,800	.4252	118	71	56	2,7	45	12
B105A11000	11,000	.4331	118	71	56	2,7	45	12
B105A11100	11,100	.4370	118	71	56	2,8	45	12
B105A11200	11,200	.4409	118	71	56	2,8	45	12
B105A11500	11,500	.4528	118	71	56	2,9	45	12
B105A11700	11,700	.4606	118	71	56	2,9	45	12
B105A11800	11,800	.4646	118	71	56	2,9	45	12
B105A12000	12,000	.4724	118	71	56	3,0	45	12
B105A12100	12,100	.4764	124	77	60	3,0	45	14
B105A12500	12,500	.4921	124	77	60	3,1	45	14
B105A12700	12,700	.5000	124	77	60	3,2	45	14
B105A12800	12,800	.5039	124	77	60	3,2	45	14
B105A13000	13,000	.5118	124	77	60	3,2	45	14
B105A13100	13,100	.5157	124	77	60	3,3	45	14
B105A13500	13,500	.5315	124	77	60	3,4	45	14
B105A13800	13,800	.5433	124	77	60	3,4	45	14
B105A14000	14,000	.5512	124	77	60	3,5	45	14
B105A14200	14,200	.5591	133	83	63	3,5	48	16
B105A14500	14,500	.5709	133	83	63	3,6	48	16
B105A15000	15,000	.5906	133	83	63	3,7	48	16
B105A15100	15,100	.5945	133	83	63	3,8	48	16

(continued)

(B105 • ~5 x D — continued)



● first choice
○ alternate choice

K10	D1 diameter mm	D1 diameter in	L	L3	L4 max	L5	LS	D
B105A15500	15,500	.6102	133	83	63	3,9	48	16
B105A15800	15,800	.6220	133	83	63	3,9	48	16
B105A16000	16,000	.6299	133	83	63	4,0	48	16
B105A16500	16,500	.6496	143	93	71	4,1	48	18
B105A17000	17,000	.6693	143	93	71	4,2	48	18
B105A17500	17,500	.6890	143	93	71	4,4	48	18
B105A18000	18,000	.7087	143	93	71	4,5	48	18
B105A18500	18,500	.7283	153	101	77	4,6	50	20
B105A19000	19,000	.7480	153	101	77	4,7	50	20
B105A19500	19,500	.7677	153	101	77	4,9	50	20
B105A20000	20,000	.7874	153	101	77	5,0	50	20
B105A20500	20,500	.8071	167	112	85	5,1	50	20
B105A21000	21,000	.8268	167	112	85	5,2	50	20

Tolerance • Metric

nominal size range	D1 tolerance m7	D tolerance h6
>3–6	0,004/0,016	0,000/-0,008
>6–10	0,006/0,021	0,000/-0,009
>10–18	0,007/0,025	0,000/-0,011
>18–25,4	0,008/0,029	0,000/-0,013

Application Data

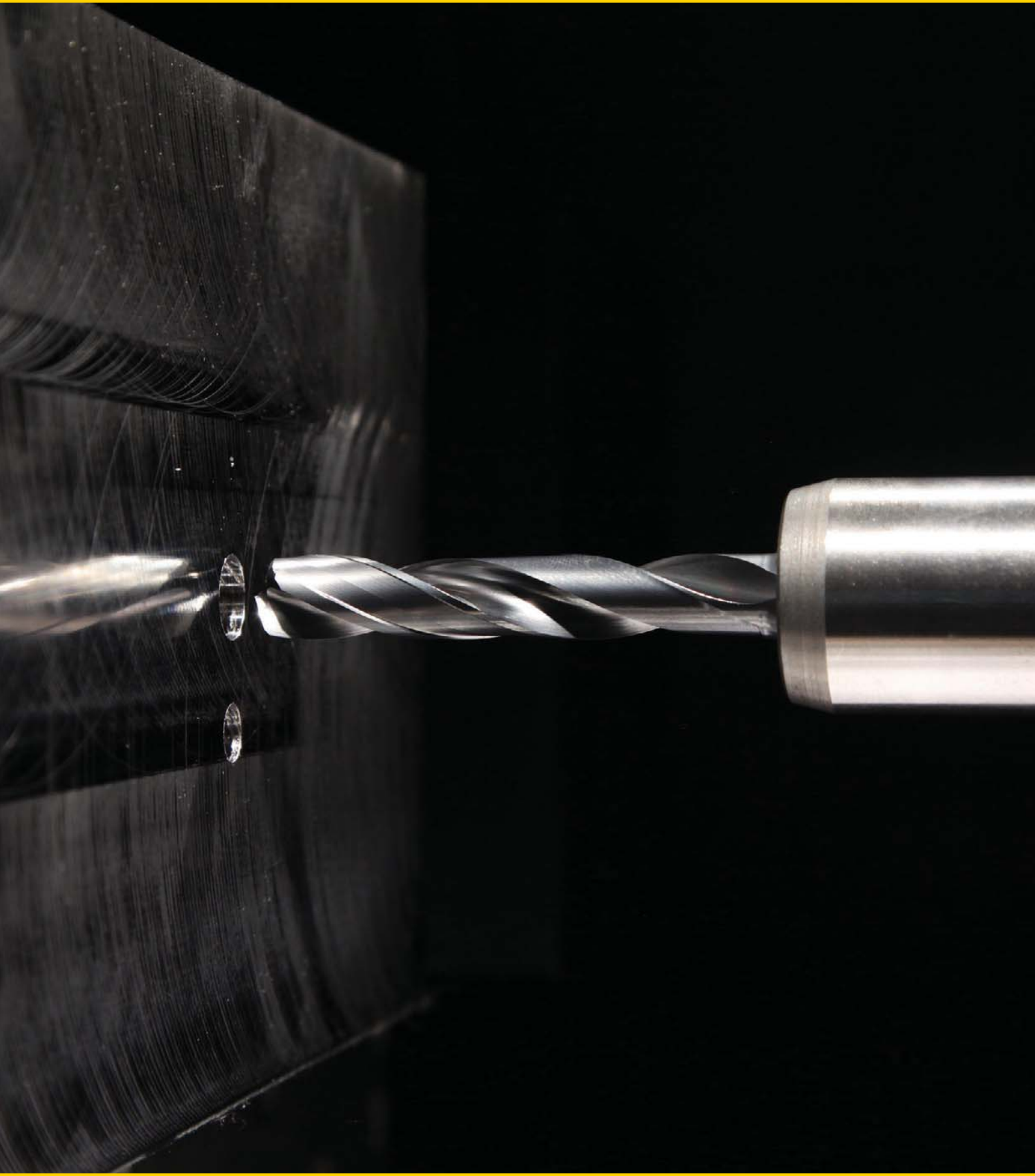
TF Drills • B105 Series • Grade K10™ • Flood Coolant • Drill Diameters 3–20mm • Metric





Material Group		Cutting Speed — vc Range — m/min min	Starting Value	max	Metric Recommended Feed Rate (f) by Diameter		3,0	4,0	6,0	8,0	10,0	12,0	16,0	20,0
K	1	60	**85**	110	mm/r	0,11–0,20	0,12–0,20	0,16–0,28	0,20–0,35	0,22–0,42	0,24–0,50	0,28–0,61	0,30–0,68	
	2	70	**70**	90	mm/r	0,11–0,20	0,12–0,20	0,16–0,28	0,20–0,35	0,22–0,42	0,24–0,50	0,28–0,61	0,30–0,68	
	3	50	**50**	70	mm/r	0,09–0,18	0,10–0,18	0,14–0,26	0,18–0,33	0,02–0,40	0,22–0,48	0,26–0,59	0,28–0,66	
N	1	100	**210**	410	mm/r	0,09–0,15	0,10–0,20	0,18–0,33	0,20–0,38	0,25–0,43	0,03–0,51	0,43–0,58	0,64–0,79	
	2	100	**250**	250	mm/r	0,10–0,19	0,12–0,21	0,18–0,33	0,25–0,42	0,30–0,50	0,35–0,58	0,44–0,74	0,52–0,88	
	3	100	**180**	400	mm/r	0,09–0,16	0,10–0,20	0,12–0,26	0,16–0,36	0,20–0,40	0,24–0,45	0,30–0,50	0,34–0,60	
	4	60	**170**	250	mm/r	0,08–0,15	0,13–0,18	0,18–0,33	0,20–0,36	0,23–0,38	0,33–0,46	0,38–0,48	0,58–0,76	
S	4	20	**20**	50	mm/r	0,03–0,05	0,04–0,07	0,07–0,09	0,09–0,12	0,11–0,15	0,13–0,18	0,17–0,24	0,22–0,30	

KENNAMETAL®



New SGL Drills with Through Coolant for Stainless Steel

Primary Application

The all-new B21_SGL series solid carbide drills are designed specifically for stainless steel applications, offering high performance and long tool life in high-temperature alloys and regular steel, also.

By combining unique Kennametal features, such as the all-new SGL-point-geometry with patented gashing, a unique flute design, and a best-in-class coating into one tool, the B21*SGL drill is the ultimate high-volume production tool.

Features and Benefits

New SGL Point Design

- Improved web thinning and patented gashing, which migrates in a straight cutting edge, enables high cutting parameters (feeds).
- Creates controlled chips, which lead to a reliable performance.
- Improved centring capabilities for better positioning accuracy and improved hole quality.

Unique Flute Design

- Large chip-flute cross-section and small web diameter improve the chip evacuation and the capability to drill deeper holes in difficult-to-machine materials.
- The highly-polished surface ensures superior chip evacuation, even when low-pressure coolant is applied.

New KCMS15™ Beyond Grade

- A monolayer PVD AlTiN-coated fine-grain carbide with superior surface finish.
- First choice for stainless steel and high-temperature resistant materials for longer tool life.
- The coating offers high hardness and excellent abrasive and adhesive wear resistance, as well as enhanced high-temperature properties, increasing its applicability, also, to MQL machining of steel.

Specifically for stainless steel applications.

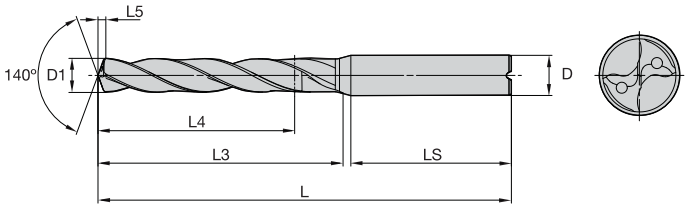


Customisation

- Intermediate diameters available as semi-standards.
- Length variations and step drills available as custom solutions.
- High step diameter ratios and very complex step drill geometries are not recommended for austenitic stainless steel.
- Using Kennametal slim line hydraulic chucks is recommended if workpiece contours need to be bypassed.





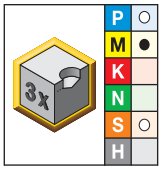


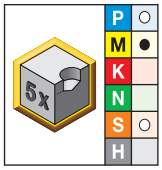


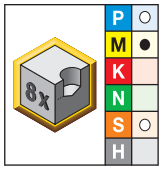
For information on L, L3, and L4 max, see the Solid Carbide Drills foldout table.

beyond

B210/B211/B212_SGL • ~3 x D/~5 x D/~8 x D





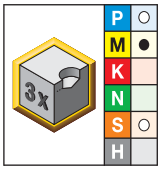


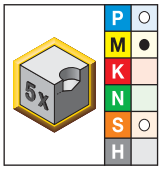
● first choice
○ alternate choice

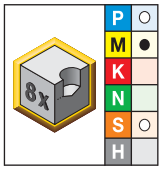
short • KCMS15	long • KCMS15	extra long • KCMS15	D1 diameter mm	D1 diameter in	L5	LS	D
B210Z02500SGL	–	–	2,500	.0984	0,4	28	3
B210A03000SGL	B211A03000SGL	B212A03000SGL	3,000	.1181	0,4	36	6
B210A03048SGL	B211A03048SGL	–	3,048	.1200	0,5	36	6
–	B211A03100SGL	–	3,100	.1220	0,5	36	6
B210A03175SGL	B211A03175SGL	B212A03175SGL	3,175	.1250	0,5	36	6
B210A03200SGL	B211A03200SGL	B212A03200SGL	3,200	.1260	0,5	36	6
B210A03264SGL	–	B212A03264SGL	3,264	.1285	0,5	36	6
B210A03300SGL	B211A03300SGL	B212A03300SGL	3,300	.1299	0,5	36	6
B210A03400SGL	B211A03400SGL	–	3,400	.1339	0,5	36	6
B210A03455SGL	B211A03455SGL	B212A03455SGL	3,455	.1360	0,5	36	6
B210A03500SGL	B211A03500SGL	B212A03500SGL	3,500	.1378	0,5	36	6
–	B211A03571SGL	B212A03571SGL	3,571	.1406	0,5	36	6
–	B211A03600SGL	–	3,600	.1417	0,5	36	6
–	B211A03658SGL	B212A03658SGL	3,658	.1440	0,5	36	6
–	B211A03700SGL	B212A03700SGL	3,700	.1457	0,5	36	6
B210A03700SGL	–	–	3,700	.1457	0,6	36	6
–	B211A03734SGL	–	3,734	.1470	0,6	36	6
B210A03800SGL	B211A03800SGL	B212A03800SGL	3,800	.1496	0,6	36	6
–	B211A03861SGL	–	3,861	.1520	0,6	36	6
–	B211A03900SGL	–	3,900	.1535	0,6	36	6
B210A04000SGL	B211A04000SGL	B212A04000SGL	4,000	.1575	0,6	36	6
–	B211A04039SGL	B212A04039SGL	4,039	.1590	0,6	36	6
B210A04100SGL	B211A04100SGL	B212A04100SGL	4,100	.1614	0,6	36	6
B210A04200SGL	B211A04200SGL	B212A04200SGL	4,200	.1654	0,6	36	6
–	B211A04217SGL	–	4,217	.1660	0,6	36	6
B210A04300SGL	B211A04300SGL	B212A04300SGL	4,300	.1693	0,6	36	6
–	B211A04366SGL	B212A04366SGL	4,366	.1719	0,6	36	6
B210A04366SGL	–	–	4,366	.1719	0,7	36	6
–	B211A04400SGL	–	4,400	.1732	0,7	36	6
B210A04500SGL	B211A04500SGL	B212A04500SGL	4,500	.1772	0,7	36	6
–	B211A04600SGL	–	4,600	.1811	0,7	36	6
B210A04700SGL	B211A04700SGL	B212A04700SGL	4,700	.1850	0,7	36	6

(continued)

(B210/B211/B212_SGL • ~3 x D/~5 x D/~8 x D — continued)





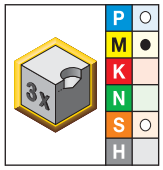


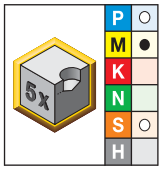
● first choice
○ alternate choice

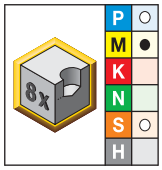
short • KCMS15	long • KCMS15	extra long • KCMS15	D1 diameter mm	D1 diameter in	L5	LS	D
–	B211A04763SGL	–	4,763	.1875	0,7	36	6
B210A04800SGL	B211A04800SGL	B212A04800SGL	4,800	.1890	0,7	36	6
–	B211A04852SGL	B212A04852SGL	4,852	.1910	0,7	36	6
B210A04900SGL	B211A04900SGL	–	4,900	.1929	0,7	36	6
B210A05000SGL	B211A05000SGL	B212A05000SGL	5,000	.1969	0,7	36	6
B210A05100SGL	B211A05100SGL	B212A05100SGL	5,100	.2008	0,8	36	6
B210A05106SGL	B211A05106SGL	–	5,106	.2010	0,8	36	6
B210A05159SGL	B211A05159SGL	–	5,159	.2031	0,8	36	6
B210A05200SGL	B211A05200SGL	B212A05200SGL	5,200	.2047	0,8	36	6
B210A05300SGL	B211A05300SGL	–	5,300	.2087	0,8	36	6
B210A05400SGL	B211A05400SGL	–	5,400	.2126	0,8	36	6
B210A05500SGL	B211A05500SGL	B212A05500SGL	5,500	.2165	0,8	36	6
–	B211A05558SGL	–	5,558	.2188	0,8	36	6
–	B211A05600SGL	–	5,600	.2205	0,8	36	6
B210A05616SGL	–	–	5,616	.2211	0,8	36	6
–	B211A05700SGL	–	5,700	.2244	0,8	36	6
B210A05800SGL	B211A05800SGL	B212A05800SGL	5,800	.2283	0,9	36	6
–	B211A05900SGL	–	5,900	.2323	0,9	36	6
B210A05954SGL	B211A05954SGL	–	5,954	.2344	0,9	36	6
B210A06000SGL	B211A06000SGL	B212A06000SGL	6,000	.2362	0,9	36	6
B210A06100SGL	B211A06100SGL	–	6,100	.2402	0,9	36	8
B210A06200SGL	B211A06200SGL	–	6,200	.2441	0,9	36	8
B210A06300SGL	B211A06300SGL	–	6,300	.2480	0,9	36	8
B210A06350SGL	B211A06350SGL	B212A06350SGL	6,350	.2500	0,9	36	8
–	B211A06400SGL	–	6,400	.2520	0,9	36	8
B210A06400SGL	–	–	6,400	.2520	1,0	36	8
B210A06500SGL	B211A06500SGL	B212A06500SGL	6,500	.2559	1,0	36	8
–	B211A06600SGL	–	6,600	.2598	1,0	36	8
–	B211A06630SGL	B212A06630SGL	6,630	.2610	1,0	36	8
B210A06700SGL	B211A06700SGL	–	6,700	.2638	1,0	36	8
B210A06800SGL	B211A06800SGL	B212A06800SGL	6,800	.2677	1,0	36	8
B210A06900SGL	B211A06900SGL	–	6,900	.2717	1,0	36	8
B210A07000SGL	B211A07000SGL	B212A07000SGL	7,000	.2756	1,0	36	8
B210A07100SGL	B211A07100SGL	–	7,100	.2795	1,1	36	8
B210A07145SGL	–	–	7,145	.2813	1,1	36	8
–	B211A07200SGL	–	7,200	.2835	1,1	36	8
–	B211A07300SGL	–	7,300	.2874	1,1	36	8
B210A07400SGL	B211A07400SGL	–	7,400	.2913	1,1	36	8
B210A07500SGL	B211A07500SGL	–	7,500	.2953	1,1	36	8
–	–	B212A07500SGL	7,500	.2953	1,1	74	8
–	B211A07600SGL	–	7,600	.2992	1,1	36	8
–	B211A07700SGL	–	7,700	.3031	1,1	36	8
B210A07800SGL	B211A07800SGL	B212A07800SGL	7,800	.3071	1,2	36	8
–	B211A07900SGL	–	7,900	.3110	1,2	36	8
B210A07938SGL	B211A07938SGL	–	7,938	.3125	1,2	36	8
B210A08000SGL	B211A08000SGL	B212A08000SGL	8,000	.3150	1,2	36	8
B210A08100SGL	B211A08100SGL	–	8,100	.3189	1,2	40	10
B210A08200SGL	B211A08200SGL	–	8,200	.3228	1,2	40	10
B210A08400SGL	B211A08400SGL	B212A08400SGL	8,400	.3307	1,2	40	10
B210A08433SGL	–	–	8,433	.3320	1,3	40	10
B210A08500SGL	B211A08500SGL	B212A08500SGL	8,500	.3346	1,3	40	10
B210A08600SGL	B211A08600SGL	–	8,600	.3386	1,3	40	10

(continued)

(B210/B211/B212_SGL • ~3 x D/~5 x D/~8 x D — continued)





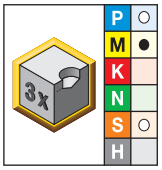


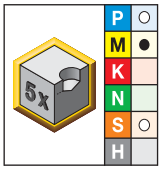
● first choice
○ alternate choice

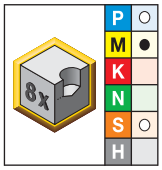
short • KCMS15	long • KCMS15	extra long • KCMS15	D1 diameter mm	D1 diameter in	L5	LS	D
B210A08700SGL	–	–	8,700	.3425	1,3	40	10
B210A08800SGL	B211A08800SGL	B212A08800SGL	8,800	.3465	1,3	40	10
–	B211A08900SGL	–	8,900	.3504	1,3	40	10
B210A09000SGL	B211A09000SGL	B212A09000SGL	9,000	.3543	1,3	40	10
B210A09093SGL	–	–	9,093	.3580	1,4	40	10
–	B211A09100SGL	–	9,100	.3583	1,3	40	10
–	B211A09200SGL	–	9,200	.3622	1,4	40	10
–	B211A09300SGL	–	9,300	.3661	1,4	40	10
–	B211A09400SGL	–	9,400	.3701	1,4	40	10
B210A09500SGL	B211A09500SGL	B212A09500SGL	9,500	.3740	1,4	40	10
–	B211A09525SGL	–	9,525	.3750	1,4	40	10
–	B211A09600SGL	–	9,600	.3780	1,4	40	10
B210A09700SGL	B211A09700SGL	–	9,700	.3819	1,4	40	10
B210A09800SGL	B211A09800SGL	–	9,800	.3858	1,5	40	10
–	B211A09900SGL	–	9,900	.3898	1,5	40	10
B210A09921SGL	–	–	9,921	.3906	1,5	40	10
B210A10000SGL	B211A10000SGL	B212A10000SGL	10,000	.3937	1,5	40	10
–	B211A10100SGL	–	10,100	.3976	1,5	45	12
B210A10200SGL	B211A10200SGL	B212A10200SGL	10,200	.4016	1,5	45	12
–	B211A10300SGL	–	10,300	.4055	1,5	45	12
B210A10400SGL	B211A10400SGL	–	10,400	.4094	1,5	45	12
B210A10500SGL	B211A10500SGL	B212A10500SGL	10,500	.4134	1,6	45	12
–	B211A10700SGL	–	10,700	.4213	1,6	45	12
B210A10716SGL	–	–	10,716	.4219	1,6	45	12
B210A10800SGL	B211A10800SGL	–	10,800	.4252	1,6	45	12
B210A11000SGL	B211A11000SGL	B212A11000SGL	11,000	.4331	1,6	45	12
–	B211A11100SGL	–	11,100	.4370	1,6	45	12
–	B211A11113SGL	–	11,113	.4375	1,6	45	12
B210A11200SGL	B211A11200SGL	–	11,200	.4409	1,7	45	12
–	B211A11400SGL	–	11,400	.4488	1,7	45	12
B210A11500SGL	B211A11500SGL	–	11,500	.4528	1,7	45	12
B210A11509SGL	–	–	11,509	.4531	1,7	45	12
–	B211A11700SGL	–	11,700	.4606	1,7	45	12
–	B211A11800SGL	B212A11800SGL	11,800	.4646	1,7	45	12
B210A12000SGL	B211A12000SGL	B212A12000SGL	12,000	.4724	1,8	45	12
–	B211A12100SGL	–	12,100	.4764	1,8	45	14
B210A12200SGL	B211A12200SGL	–	12,200	.4803	1,8	45	14
–	B211A12300SGL	–	12,300	.4843	1,8	45	14
B210A12304SGL	–	–	12,304	.4844	1,8	45	14
B210A12500SGL	B211A12500SGL	B212A12500SGL	12,500	.4921	1,9	45	14
B210A12700SGL	B211A12700SGL	–	12,700	.5000	1,9	45	14
B210A12800SGL	B211A12800SGL	–	12,800	.5039	1,9	45	14
–	B211A12900SGL	–	12,900	.5079	1,9	45	14
B210A13000SGL	B211A13000SGL	B212A13000SGL	13,000	.5118	1,9	45	14
–	B211A13100SGL	–	13,100	.5157	1,9	45	14
–	B211A13200SGL	–	13,200	.5197	2,0	45	14
–	B211A13300SGL	–	13,300	.5236	2,0	45	14
B210A13495SGL	–	–	13,495	.5313	2,0	45	14
B210A13500SGL	B211A13500SGL	B212A13500SGL	13,500	.5315	2,0	45	14
–	B211A13800SGL	–	13,800	.5433	2,0	45	14
B210A14000SGL	B211A14000SGL	B212A14000SGL	14,000	.5512	2,1	45	14
B210A14100SGL	B211A14100SGL	–	14,100	.5551	2,1	48	16

(continued)

(B210/B211/B212_SGL • ~3 x D/~5 x D/~8 x D — continued)







● first choice
○ alternate choice

short • KCMS15	long • KCMS15	extra long • KCMS15	D1 diameter mm	D1 diameter in	L5	LS	D
B210A14200SGL	–	–	14,200	.5591	2,1	48	16
–	B211A14300SGL	–	14,300	.5630	2,1	48	16
–	B211A14400SGL	–	14,400	.5669	2,1	48	16
–	B211A14500SGL	–	14,500	.5709	2,1	48	16
B210A14500SGL	–	–	14,500	.5709	2,2	48	16
–	B211A14600SGL	–	14,600	.5748	2,2	48	16
–	B211A14800SGL	–	14,800	.5827	2,2	48	16
B210A15000SGL	B211A15000SGL	–	15,000	.5906	2,2	48	16
–	B211A15100SGL	–	15,100	.5945	2,2	48	16
–	B211A15300SGL	–	15,300	.6024	2,3	48	16
B210A15500SGL	B211A15500SGL	–	15,500	.6102	2,3	48	16
–	B211A15700SGL	–	15,700	.6181	2,3	48	16
B210A15875SGL	B211A15875SGL	–	15,875	.6250	2,4	48	16
B210A16000SGL	B211A16000SGL	–	16,000	.6299	2,4	48	16
–	B211A16100SGL	–	16,100	.6339	2,4	48	18
B210A16129SGL	–	–	16,129	.6350	2,4	48	18
B210A16500SGL	B211A16500SGL	–	16,500	.6496	2,4	48	18
B210A16670SGL	–	–	16,670	.6563	2,5	48	18
B210A17000SGL	B211A17000SGL	–	17,000	.6693	2,5	48	18
B210A17500SGL	B211A17500SGL	–	17,500	.6890	2,6	48	18
–	B211A17700SGL	–	17,700	.6969	2,6	48	18
B210A18000SGL	B211A18000SGL	–	18,000	.7087	2,7	48	18
B210A18500SGL	B211A18500SGL	–	18,500	.7283	2,7	50	20
–	B211A19000SGL	–	19,000	.7480	2,8	50	20
B210A19050SGL	–	–	19,050	.7500	2,8	50	20
–	B211A19159SGL	–	19,159	.7543	2,8	50	20
–	B211A19300SGL	–	19,300	.7598	2,9	50	20
B210A19500SGL	–	–	19,500	.7677	2,9	50	20
B210A20000SGL	–	–	20,000	.7874	3,0	50	20
–	B211A20500SGL	–	20,500	.8071	3,0	50	20

Tolerance • Metric

nominal size range	D1 tolerance m7	D tolerance h6
>3–6	0,004/0,016	0,000/-0,008
>6–10	0,006/0,021	0,000/-0,009
>10–18	0,007/0,025	0,000/-0,011
>18–25,4	0,008/0,029	0,000/-0,013

HP Drills • B21_SGL Series • Grade KCMS15 • Through Coolant • Metric



Material Group		Cutting Speed — vc			Metric								
		Range — m/min			Recommended Feed Rate per Rev								
		min	Starting Value	max		3,0	4,0	6,0	8,0	10,0	12,0	16,0	20,0
P	1	110	**160**	210	mm/r	0,05–0,13	0,08–0,19	0,11–0,24	0,14–0,30	0,16–0,35	0,18–0,39	0,20–0,46	0,23–0,51
	2	130	**170**	210	mm/r	0,05–0,13	0,08–0,17	0,11–0,20	0,14–0,24	0,16–0,28	0,18–0,32	0,20–0,37	0,23–0,41
	3	110	**150**	190	mm/r	0,08–0,13	0,12–0,19	0,14–0,24	0,17–0,30	0,20–0,35	0,22–0,39	0,26–0,46	0,29–0,51
	4	80	**120**	150	mm/r	0,08–0,12	0,11–0,18	0,12–0,23	0,15–0,28	0,17–0,33	0,19–0,37	0,22–0,43	0,25–0,48
	5	60	**80**	90	mm/r	0,03–0,11	0,04–0,11	0,05–0,11	0,05–0,14	0,08–0,18	0,11–0,21	0,14–0,24	0,16–0,26
	6	70	**120**	170	mm/r	0,05–0,11	0,08–0,14	0,11–0,17	0,13–0,21	0,15–0,24	0,17–0,27	0,19–0,33	0,22–0,36
M	1	60	**80**	90	mm/r	0,05–0,14	0,06–0,15	0,08–0,17	0,10–0,19	0,12–0,21	0,13–0,22	0,16–0,25	0,18–0,27
	2	50	**70**	90	mm/r	0,05–0,14	0,06–0,15	0,08–0,17	0,10–0,19	0,12–0,21	0,13–0,22	0,16–0,25	0,18–0,27
	3	50	**60**	80	mm/r	0,05–0,14	0,06–0,15	0,08–0,17	0,10–0,19	0,12–0,21	0,13–0,22	0,16–0,25	0,18–0,27
S	1	10	**20**	30	mm/r	0,03–0,08	0,04–0,09	0,05–0,11	0,05–0,11	0,08–0,14	0,11–0,16	0,14–0,19	0,16–0,21
	2	10	**20**	30	mm/r	0,03–0,11	0,04–0,11	0,05–0,11	0,05–0,11	0,08–0,14	0,11–0,16	0,14–0,19	0,16–0,21
	3	20	**30**	40	mm/r	0,03–0,11	0,04–0,11	0,05–0,11	0,05–0,11	0,08–0,14	0,11–0,16	0,14–0,19	0,16–0,21
	4	30	**40**	50	mm/r	0,03–0,04	0,04–0,05	0,06–0,08	0,08–0,10	0,11–0,13	0,13–0,15	0,14–0,18	0,16–0,20

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Kennametal offers world-class products and services globally. Our distributors know us, and more importantly, they know you. They know better than anyone in the industry how to put the global power of Kennametal to work for you — in your industry, in your region, and for your business.

HP Beyond™ Drills for Steel

Primary Application

B221_HP series solid carbide drills offer the highest metal removal rates and longest tool life in steel and iron materials when dry cutting or using external flood coolant. Dry drilling up to 5 x D possible.

B224_HP series solid carbide drills are ideal for super high-speed drilling of unalloyed and alloyed steel. Achieve 100% higher cutting speed without compromising tool life. Operate these drills with standard through coolant or MQL.

By combining unique Kennametal technologies, such as the HP-point, flute geometry, and a new Beyond grade technology into one tool, the B22_HP Beyond is the ultimate high-volume production tool.

Features and Benefits

HP Drill-Point Design

- Low thrust prevents workpiece flexing.
- Excellent centring capabilities.

Unique Flute Design

- Improved chip evacuation in dry and mid L/D drilling operations.
- Better hole surface quality.

KCPK15™ Beyond Grade

- The grade is a multilayer, TiAlN-based coating with high hot hardness. High cutting speeds enable use in MQL applications.
- The highly polished surface ensures superior chip evacuation even when low-pressure coolant is applied.
- The average metal removal rate and tool life performance improved dramatically (10–30%).

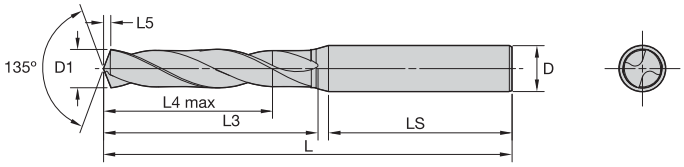
B22_HP Beyond™ drills are the ultimate high-volume production tool.



Customisation

- Intermediate diameters available as semi-standards.
- Length variations and step drills available as engineered solutions.
- For holes deeper than 5 x D, internal coolant is recommended.
- Using Kennametal slim line hydraulic chucks together with standard B22_HP is recommended if workpiece contours need to be bypassed.



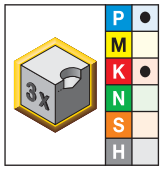


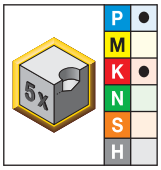


For information on L, L3, and L4 max, see the Solid Carbide Drills foldout table.

beyond

B221/B222_HP • ~3 x D/~5 x D



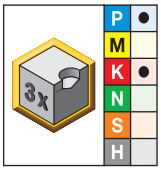


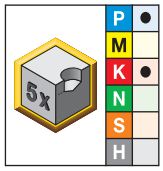
● first choice
○ alternate choice

short • KCPK15	long • KCPK15	D1 diameter mm	D1 diameter in	L5	LS	D
B221A03000HP	B222A03000HP	3,000	.1181	0,6	36	6
B221A03048HP	B222A03048HP	3,048	.1200	0,6	36	6
B221A03100HP	–	3,100	.1220	0,6	36	6
B221A03175HP	B222A03175HP	3,175	.1250	0,6	36	6
B221A03200HP	–	3,200	.1260	0,6	36	6
B221A03264HP	B222A03264HP	3,264	.1285	0,6	36	6
B221A03300HP	B222A03300HP	3,300	.1299	0,6	36	6
B221A03400HP	–	3,400	.1339	0,6	36	6
B221A03455HP	B222A03455HP	3,455	.1360	0,7	36	6
B221A03500HP	B222A03500HP	3,500	.1378	0,7	36	6
B221A03571HP	B222A03571HP	3,571	.1406	0,7	36	6
B221A03600HP	–	3,600	.1417	0,7	36	6
B221A03700HP	B222A03700HP	3,700	.1457	0,7	36	6
B221A03734HP *	–	3,734	.1470	0,7	36	6
B221A03800HP	B222A03800HP	3,800	.1496	0,7	36	6
B221A03900HP	–	3,900	.1535	0,7	36	6
B221A03970HP	B222A03970HP	3,970	.1563	0,7	36	6
B221A04000HP	B222A04000HP	4,000	.1575	0,8	36	6
B221A04039HP	–	4,039	.1590	0,8	36	6
B221A04090HP	–	4,090	.1610	0,8	36	6
B221A04100HP	–	4,100	.1614	0,8	36	6
B221A04200HP	B222A04200HP	4,200	.1654	0,8	36	6
B221A04217HP *	–	4,217	.1660	0,8	36	6
B221A04300HP	–	4,300	.1693	0,8	36	6
B221A04366HP	B222A04366HP	4,366	.1719	0,8	36	6
B221A04400HP	–	4,400	.1732	0,8	36	6
B221A04500HP	B222A04500HP	4,500	.1772	0,8	36	6
B221A04600HP	B222A04600HP	4,600	.1811	0,9	36	6
B221A04623HP *	–	4,623	.1820	0,9	36	6
B221A04700HP	–	4,700	.1850	0,9	36	6
B221A04763HP	B222A04763HP	4,763	.1875	0,9	36	6
B221A04800HP	B222A04800HP	4,800	.1890	0,9	36	6
B221A04852HP	–	4,852	.1910	0,9	36	6
B221A04900HP	–	4,900	.1929	0,9	36	6
B221A05000HP	B222A05000HP	5,000	.1969	0,9	36	6
B221A05100HP	B222A05100HP	5,100	.2008	1,0	36	6

(continued)

(B221/B222_HP • ~3 x D/~5 x D — continued)



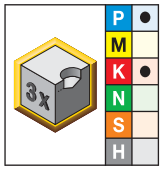


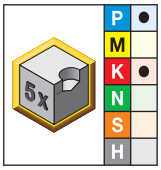
● first choice
○ alternate choice

short • KCPK15	long • KCPK15	D1 diameter mm	D1 diameter in	L5	LS	D
B221A05106HP	B222A05106HP	5,106	.2010	1,0	36	6
B221A05159HP	B222A05159HP	5,159	.2031	1,0	36	6
B221A05200HP	–	5,200	.2047	1,0	36	6
B221A05300HP	–	5,300	.2087	1,0	36	6
B221A05400HP	–	5,400	.2126	1,0	36	6
B221A05410HP *	B222A05410HP *	5,410	.2130	1,0	36	6
B221A05500HP	B222A05500HP	5,500	.2165	1,0	36	6
B221A05558HP	B222A05558HP *	5,558	.2188	1,0	36	6
B221A05600HP	–	5,600	.2205	1,1	36	6
B221A05616HP *	–	5,616	.2211	1,1	36	6
B221A05700HP	–	5,700	.2244	1,1	36	6
B221A05800HP	B222A05800HP	5,800	.2283	1,1	36	6
B221A05900HP	–	5,900	.2323	1,1	36	6
–	B222A05954HP	5,954	.2344	1,1	36	6
B221A06000HP	B222A06000HP	6,000	.2362	1,1	36	6
B221A06100HP	–	6,100	.2402	1,1	36	8
B221A06200HP	–	6,200	.2441	1,2	36	8
B221A06300HP	–	6,300	.2480	1,2	36	8
B221A06350HP	B222A06350HP	6,350	.2500	1,2	36	8
B221A06400HP	–	6,400	.2520	1,2	36	8
B221A06500HP	B222A06500HP	6,500	.2559	1,2	36	8
B221A06528HP	B222A06528HP	6,528	.2570	1,2	36	8
B221A06600HP	–	6,600	.2598	1,2	36	8
B221A06630HP *	–	6,630	.2610	1,2	36	8
B221A06700HP	B222A06700HP	6,700	.2638	1,3	36	8
B221A06746HP	B222A06746HP	6,746	.2656	1,3	36	8
B221A06800HP	B222A06800HP	6,800	.2677	1,3	36	8
B221A06900HP	–	6,900	.2717	1,3	36	8
B221A07000HP	B222A07000HP	7,000	.2756	1,3	36	8
B221A07100HP	–	7,100	.2795	1,3	36	8
B221A07145HP *	B222A07145HP	7,145	.2813	1,3	36	8
B221A07200HP	–	7,200	.2835	1,3	36	8
B221A07300HP	–	7,300	.2874	1,4	36	8
B221A07400HP	–	7,400	.2913	1,4	36	8
B221A07500HP	B222A07500HP	7,500	.2953	1,4	36	8
B221A07541HP *	B222A07541HP	7,541	.2969	1,4	36	8
B221A07600HP *	–	7,600	.2992	1,4	36	8
B221A07700HP	–	7,700	.3031	1,4	36	8
B221A07800HP	B222A07800HP	7,800	.3071	1,5	36	8
B221A07900HP	–	7,900	.3110	1,5	36	8
B221A07938HP	B222A07938HP	7,938	.3125	1,5	36	8
B221A08000HP	B222A08000HP	8,000	.3150	1,5	36	8
B221A08100HP	–	8,100	.3189	1,5	40	10
B221A08200HP	B222A08200HP	8,200	.3228	1,5	40	10
B221A08300HP	–	8,300	.3268	1,6	40	10
B221A08334HP	B222A08334HP	8,334	.3281	1,6	40	10
B221A08400HP	–	8,400	.3307	1,6	40	10
B221A08433HP *	B222A08433HP	8,433	.3320	1,6	40	10
B221A08500HP	B222A08500HP	8,500	.3346	1,6	40	10
B221A08600HP	–	8,600	.3386	1,6	40	10
B221A08700HP	–	8,700	.3425	1,6	40	10
B221A08733HP *	B222A08733HP	8,733	.3438	1,6	40	10

(continued)

(B221/B222_HP • ~3 x D/~5 x D — continued)





● first choice
○ alternate choice

short • KCPK15	long • KCPK15	D1 diameter mm	D1 diameter in	L5	LS	D
B221A08800HP	B222A08800HP	8,800	.3465	1,6	40	10
B221A08900HP	–	8,900	.3504	1,7	40	10
B221A09000HP	B222A09000HP	9,000	.3543	1,7	40	10
B221A09100HP	–	9,100	.3583	1,7	40	10
B221A09129HP	B222A09129HP	9,129	.3594	1,7	40	10
B221A09200HP	–	9,200	.3622	1,7	40	10
B221A09300HP	B222A09300HP	9,300	.3661	1,7	40	10
B221A09347HP	–	9,347	.3680	1,7	40	10
B221A09400HP	–	9,400	.3701	1,8	40	10
B221A09500HP	B222A09500HP	9,500	.3740	1,8	40	10
B221A09525HP	B222A09525HP	9,525	.3750	1,8	40	10
B221A09600HP	–	9,600	.3780	1,8	40	10
B221A09700HP	–	9,700	.3819	1,8	40	10
B221A09800HP	B222A09800HP	9,800	.3858	1,8	40	10
B221A09900HP	–	9,900	.3898	1,8	40	10
B221A09921HP	B222A09921HP	9,921	.3906	1,9	40	10
B221A10000HP	B222A10000HP	10,000	.3937	1,9	40	10
B221A10100HP	–	10,100	.3976	1,9	45	12
B221A10200HP	B222A10200HP	10,200	.4016	1,9	45	12
B221A10300HP	–	10,300	.4055	1,9	45	12
B221A10320HP	B222A10320HP	10,320	.4063	1,9	45	12
B221A10400HP	–	10,400	.4094	1,9	45	12
B221A10500HP	B222A10500HP	10,500	.4134	2,0	45	12
B221A10600HP	–	10,600	.4173	2,0	45	12
B221A10700HP	–	10,700	.4213	2,0	45	12
B221A10716HP	B222A10716HP	10,716	.4219	2,0	45	12
B221A10800HP	B222A10800HP	10,800	.4252	2,0	45	12
B221A10900HP *	–	10,900	.4291	2,0	45	12
B221A11000HP	B222A11000HP	11,000	.4331	2,1	45	12
B221A11100HP	–	11,100	.4370	2,1	45	12
B221A11113HP	B222A11113HP	11,113	.4375	2,1	45	12
B221A11200HP	–	11,200	.4409	2,1	45	12
B221A11300HP	–	11,300	.4449	2,1	45	12
B221A11400HP	–	11,400	.4488	2,1	45	12
B221A11500HP	B222A11500HP	11,500	.4528	2,1	45	12
B221A11509HP *	B222A11509HP	11,509	.4531	2,1	45	12
B221A11600HP *	–	11,600	.4567	2,2	45	12
B221A11700HP	–	11,700	.4606	2,2	45	12
B221A11800HP	–	11,800	.4646	2,2	45	12
B221A11900HP	–	11,900	.4685	2,2	45	12
B221A11908HP	B222A11908HP	11,908	.4688	2,2	45	12
B221A12000HP	B222A12000HP	12,000	.4724	2,2	45	12
B221A12100HP	–	12,100	.4764	2,3	45	14
B221A12200HP	–	12,200	.4803	2,3	45	14
B221A12300HP	–	12,300	.4843	2,3	45	14
–	B222A12304HP	12,304	.4844	2,3	45	14
B221A12400HP	–	12,400	.4882	2,3	45	14
B221A12500HP	B222A12500HP *	12,500	.4921	2,3	45	14
B221A12600HP	–	12,600	.4961	2,3	45	14
B221A12700HP	B222A12700HP	12,700	.5000	2,4	45	14
B221A12800HP	–	12,800	.5039	2,4	45	14
B221A12900HP	–	12,900	.5079	2,4	45	14

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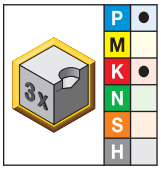
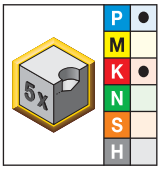
(B221/B222_HP • ~3 x D/~5 x D — continued)





● first choice
○ alternate choice

short • KCPK15	long • KCPK15	D1 diameter mm	D1 diameter in	L5	LS	D
B221A13000HP	B222A13000HP	13,000	.5118	2,4	45	14
B221A13100HP	–	13,100	.5157	2,4	45	14
B221A13200HP	–	13,200	.5197	2,5	45	14
B221A13300HP	–	13,300	.5236	2,5	45	14
B221A13500HP	B222A13500HP	13,500	.5315	2,5	45	14
B221A13600HP	–	13,600	.5354	2,5	45	14
B221A13700HP	–	13,700	.5394	2,6	45	14
B221A13800HP	–	13,800	.5433	2,6	45	14
B221A13891HP	–	13,891	.5469	2,6	45	14
B221A14000HP	B222A14000HP	14,000	.5512	2,6	45	14
B221A14100HP	–	14,100	.5551	2,6	48	16
B221A14200HP	–	14,200	.5591	2,6	48	16
B221A14288HP	B222A14288HP	14,288	.5625	2,7	48	16
B221A14300HP	–	14,300	.5630	2,7	48	16
B221A14400HP	–	14,400	.5669	2,7	48	16
B221A14500HP	B222A14500HP	14,500	.5709	2,7	48	16
B221A14600HP	–	14,600	.5748	2,7	48	16
B221A14684HP *	–	14,684	.5781	2,7	48	16
B221A14700HP	–	14,700	.5787	2,7	48	16
B221A14800HP	–	14,800	.5827	2,8	48	16
B221A14900HP	–	14,900	.5866	2,8	48	16
B221A15000HP	B222A15000HP	15,000	.5906	2,8	48	16
B221A15083HP	–	15,083	.5938	2,8	48	16
B221A15100HP	–	15,100	.5945	2,8	48	16
B221A15200HP	–	15,200	.5984	2,8	48	16
B221A15300HP	–	15,300	.6024	2,8	48	16
B221A15400HP *	–	15,400	.6063	2,9	48	16
B221A15479HP	–	15,479	.6094	2,9	48	16
B221A15500HP	B222A15500HP	15,500	.6102	2,9	48	16
B221A15600HP	–	15,600	.6142	2,9	48	16
B221A15700HP	–	15,700	.6181	2,9	48	16
B221A15800HP	–	15,800	.6220	2,9	48	16
B221A15875HP	B222A15875HP	15,875	.6250	3,0	48	16
B221A15900HP *	–	15,900	.6260	3,0	48	16
B221A16000HP	B222A16000HP	16,000	.6299	3,0	48	16
B221A16500HP	B222A16500HP	16,500	.6496	3,1	48	18
B221A17000HP	B222A17000HP	17,000	.6693	3,2	48	18
B221A17463HP	B222A17463HP	17,463	.6875	3,2	48	18
B221A17500HP	B222A17500HP	17,500	.6890	3,3	48	18
B221A17700HP	–	17,700	.6969	3,3	48	18
B221A18000HP	B222A18000HP	18,000	.7087	3,3	48	18
B221A18500HP	B222A18500HP *	18,500	.7283	3,4	50	20
B221A19000HP	B222A19000HP	19,000	.7480	3,5	50	20
B221A19050HP	B222A19050HP	19,050	.7500	3,5	50	20
B221A19500HP	–	19,500	.7677	3,6	50	20
B221A20000HP	B222A20000HP	20,000	.7874	3,7	50	20
B221A20500HP	–	20,500	.8071	3,8	50	20
B221A21000HP	–	21,000	.8268	3,9	50	20

NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Tolerance • Metric

nominal size range	D1 tolerance m7	D tolerance h6
>3–6	0,004/0,016	0,000/-0,008
>6–10	0,006/0,021	0,000/-0,009
>10–18	0,007/0,025	0,000/-0,011
>18–25,4	0,008/0,029	0,000/-0,013

HP Drills • B221_HP, B222_HP Series • Grade KCPK15™ • Flood Coolant • Drill Diameters 3–20mm • Metric



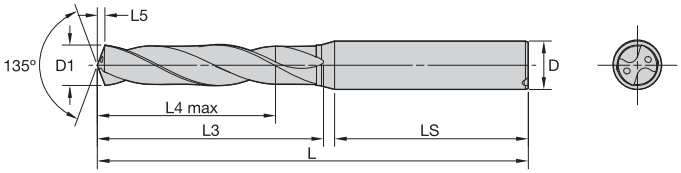
Material Group		Cutting Speed — vc Range — m/min				Metric Recommended Feed Rate (fz) by Diameter							
		min	Starting Value	max		3,0	4,0	6,0	8,0	10,0	12,0	16,0	20,0
P	0	80	**110**	170	mm/r	0,06–0,14	0,06–0,14	0,07–0,20	0,08–0,25	0,09–0,30	0,12–0,36	0,18–0,42	0,21–0,49
	1	70	**110**	150	mm/r	0,07–0,16	0,07–0,17	0,08–0,24	0,09–0,29	0,09–0,35	0,12–0,42	0,25–0,50	0,33–0,58
	2	90	**120**	160	mm/r	0,07–0,15	0,07–0,17	0,12–0,23	0,14–0,31	0,16–0,33	0,20–0,40	0,25–0,50	0,31–0,58
	3	60	**90**	120	mm/r	0,09–0,16	0,09–0,17	0,14–0,24	0,15–0,33	0,19–0,35	0,24–0,44	0,27–0,50	0,34–0,60
	4	50	**80**	120	mm/r	0,08–0,16	0,08–0,17	0,13–0,25	0,16–0,33	0,17–0,33	0,21–0,44	0,24–0,50	0,30–0,60
	6	50	**80**	120	mm/r	0,06–0,11	0,07–0,13	0,09–0,17	0,13–0,24	0,15–0,24	0,18–0,30	0,23–0,40	0,28–0,49
K	1	70	**100**	120	mm/r	0,11–0,21	0,09–0,18	0,14–0,28	0,16–0,37	0,20–0,40	0,22–0,45	0,28–0,58	0,36–0,71
	2	70	**120**	120	mm/r	0,11–0,19	0,09–0,16	0,14–0,23	0,16–0,32	0,19–0,32	0,22–0,37	0,28–0,47	0,36–0,60
	3	50	**90**	130	mm/r	0,08–0,17	0,07–0,14	0,12–0,25	0,13–0,27	0,16–0,29	0,18–0,39	0,25–0,48	0,29–0,58

HP Drills • B221HP, B222HP Series • Grade KCPK15™ • Dry Applications • Drill Diameters 3–20mm • Metric



Material Group		Cutting Speed — vc Range — m/min				Metric Recommended Feed Rate (fz) by Diameter							
		min	Starting Value	max		3,0	4,0	6,0	8,0	10,0	12,0	16,0	20,0
P	0	70	**90**	140	mm/r	0,06–0,10	0,06–0,12	0,11–0,18	0,14–0,24	0,17–0,30	0,21–0,36	0,29–0,43	0,36–0,59
	1	60	**90**	120	mm/r	0,07–0,12	0,07–0,14	0,13–0,21	0,17–0,28	0,20–0,35	0,25–0,42	0,34–0,50	0,42–0,69
	2	60	**90**	120	mm/r	0,07–0,13	0,07–0,14	0,13–0,21	0,17–0,28	0,20–0,35	0,25–0,42	0,34–0,50	0,42–0,69
	3	60	**80**	90	mm/r	0,05–0,07	0,07–0,13	0,11–0,19	0,14–0,21	0,18–0,28	0,21–0,33	0,28–0,42	0,36–0,53
	4	60	**80**	90	mm/r	0,08–0,12	0,11–0,18	0,12–0,23	0,15–0,28	0,17–0,33	0,19–0,37	0,22–0,43	0,25–0,48
	6	60	**80**	90	mm/r	0,05–0,07	0,07–0,13	0,11–0,19	0,14–0,21	0,18–0,28	0,21–0,33	0,28–0,42	0,36–0,53



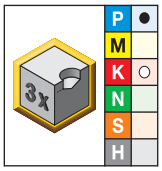


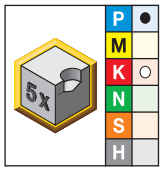


For information on L, L3, and L4 max, see the Solid Carbide Drills foldout table.

beyond

B224/B225_HP • ~3 x D/~5 x D



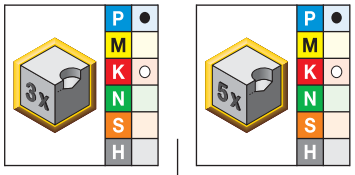


● first choice
○ alternate choice

short • KCPK15	long • KCPK15	D1 diameter mm	D1 diameter in	L5	LS	D
B224A03000HP	B225A03000HP	3,000	.1181	0,6	36	6
B224A03048HP	B225A03048HP	3,048	.1200	0,6	36	6
B224A03100HP	B225A03100HP	3,100	.1220	0,6	36	6
B224A03175HP	B225A03175HP	3,175	.1250	0,6	36	6
B224A03200HP	B225A03200HP	3,200	.1260	0,6	36	6
B224A03264HP *	B225A03264HP	3,264	.1285	0,6	36	6
B224A03300HP	B225A03300HP	3,300	.1299	0,6	36	6
B224A03400HP	B225A03400HP	3,400	.1339	0,6	36	6
B224A03455HP	B225A03455HP	3,455	.1360	0,7	36	6
B224A03500HP	B225A03500HP	3,500	.1378	0,7	36	6
–	B225A03571HP	3,571	.1406	0,7	36	6
B224A03600HP	B225A03600HP	3,600	.1417	0,7	36	6
B224A03658HP	–	3,658	.1440	0,7	36	6
B224A03700HP *	B225A03700HP	3,700	.1457	0,7	36	6
B224A03734HP *	–	3,734	.1470	0,7	36	6
–	B225A03797HP	3,797	.1495	0,7	36	6
B224A03800HP	B225A03800HP	3,800	.1496	0,7	36	6
B224A03900HP	B225A03900HP	3,900	.1535	0,7	36	6
B224A03970HP	B225A03970HP	3,970	.1563	0,7	36	6
B224A04000HP	B225A04000HP	4,000	.1575	0,8	36	6
B224A04039HP *	–	4,039	.1590	0,8	36	6
B224A04090HP	–	4,090	.1610	0,8	36	6
B224A04100HP	B225A04100HP	4,100	.1614	0,8	36	6
B224A04200HP	B225A04200HP	4,200	.1654	0,8	36	6
B224A04217HP *	–	4,217	.1660	0,8	36	6
–	B225A04300HP	4,300	.1693	0,8	36	6
B224A04366HP	B225A04366HP	4,366	.1719	0,8	36	6
–	B225A04400HP	4,400	.1732	0,8	36	6
B224A04496HP	B225A04496HP	4,496	.1770	0,8	36	6
–	B225A04500HP	4,500	.1772	0,8	36	6
–	B225A04600HP	4,600	.1811	0,9	36	6
B224A04623HP	–	4,623	.1820	0,9	36	6
B224A04700HP *	B225A04700HP	4,700	.1850	0,9	36	6
B224A04763HP	B225A04763HP	4,763	.1875	0,9	36	6
–	B225A04800HP	4,800	.1890	0,9	36	6
B224A04852HP	–	4,852	.1910	0,9	36	6

(continued)

(B224/B225_HP • ~3 x D/~5 x D — continued)

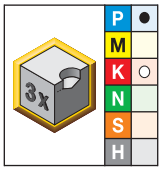


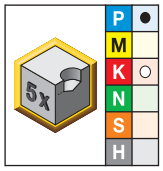
● first choice
○ alternate choice

short • KCPK15	long • KCPK15	D1 diameter mm	in	L5	LS	D
–	B225A04900HP	4,900	.1929	0,9	36	6
B224A05000HP	B225A05000HP	5,000	.1969	0,9	36	6
B224A05050HP	–	5,050	.1988	0,9	36	6
B224A05100HP	B225A05100HP	5,100	.2008	1,0	36	6
B224A05106HP	B225A05106HP	5,106	.2010	1,0	36	6
B224A05159HP	B225A05159HP	5,159	.2031	1,0	36	6
–	B225A05200HP	5,200	.2047	1,0	36	6
–	B225A05300HP	5,300	.2087	1,0	36	6
–	B225A05400HP	5,400	.2126	1,0	36	6
B224A05410HP	B225A05410HP	5,410	.2130	1,0	36	6
B224A05500HP	B225A05500HP	5,500	.2165	1,0	36	6
B224A05558HP	B225A05558HP	5,558	.2188	1,0	36	6
B224A05600HP	B225A05600HP	5,600	.2205	1,1	36	6
B224A05616HP *	–	5,616	.2211	1,1	36	6
–	B225A05700HP	5,700	.2244	1,1	36	6
B224A05791HP	B225A05791HP	5,791	.2280	1,1	36	6
–	B225A05800HP	5,800	.2283	1,1	36	6
–	B225A05900HP	5,900	.2323	1,1	36	6
B224A05944HP *	B225A05944HP	5,944	.2340	1,1	36	6
B224A05954HP *	B225A05954HP	5,954	.2344	1,1	36	6
B224A06000HP	B225A06000HP	6,000	.2362	1,1	36	6
–	B225A06100HP	6,100	.2402	1,1	36	8
–	B225A06200HP	6,200	.2441	1,2	36	8
–	B225A06300HP	6,300	.2480	1,2	36	8
B224A06350HP	B225A06350HP	6,350	.2500	1,2	36	8
–	B225A06400HP	6,400	.2520	1,2	36	8
B224A06500HP	B225A06500HP	6,500	.2559	1,2	36	8
B224A06528HP *	B225A06528HP	6,528	.2570	1,2	36	8
–	B225A06600HP	6,600	.2598	1,2	36	8
B224A06630HP	–	6,630	.2610	1,2	36	8
B224A06700HP *	B225A06700HP	6,700	.2638	1,3	36	8
B224A06746HP *	B225A06746HP	6,746	.2656	1,3	36	8
B224A06800HP	B225A06800HP	6,800	.2677	1,3	36	8
–	B225A06900HP	6,900	.2717	1,3	36	8
B224A06909HP	B225A06909HP	6,909	.2720	1,3	36	8
B224A07000HP	B225A07000HP	7,000	.2756	1,3	36	8
–	B225A07100HP	7,100	.2795	1,3	36	8
B224A07145HP	B225A07145HP	7,145	.2813	1,3	36	8
–	B225A07200HP	7,200	.2835	1,3	36	8
–	B225A07300HP	7,300	.2874	1,4	36	8
B224A07366HP *	B225A07366HP	7,366	.2900	1,4	36	8
B224A07400HP	B225A07400HP	7,400	.2913	1,4	36	8
B224A07500HP	B225A07500HP	7,500	.2953	1,4	36	8
B224A07541HP	B225A07541HP	7,541	.2969	1,4	36	8
–	B225A07600HP	7,600	.2992	1,4	36	8
–	B225A07700HP	7,700	.3031	1,4	36	8
–	B225A07800HP	7,800	.3071	1,5	36	8
–	B225A07900HP	7,900	.3110	1,5	36	8
B224A07938HP	B225A07938HP	7,938	.3125	1,5	36	8
B224A08000HP	B225A08000HP	8,000	.3150	1,5	36	8
–	B225A08100HP	8,100	.3189	1,5	40	10
B224A08200HP	B225A08200HP	8,200	.3228	1,5	40	10

(continued)

(B224/B225_HP • ~3 x D/~5 x D — continued)



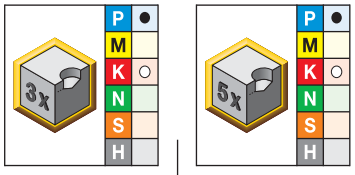


● first choice
○ alternate choice

short • KCPK15	long • KCPK15	D1 diameter mm	D1 diameter in	L5	LS	D
–	B225A08300HP	8,300	.3268	1,6	40	10
B224A08334HP	B225A08334HP	8,334	.3281	1,6	40	10
–	B225A08400HP	8,400	.3307	1,6	40	10
B224A08433HP	B225A08433HP	8,433	.3320	1,6	40	10
B224A08500HP	B225A08500HP	8,500	.3346	1,6	40	10
–	B225A08600HP	8,600	.3386	1,6	40	10
B224A08700HP	B225A08700HP	8,700	.3425	1,6	40	10
B224A08733HP	B225A08733HP	8,733	.3438	1,6	40	10
B224A08800HP	B225A08800HP	8,800	.3465	1,6	40	10
B224A08839HP *	B225A08839HP	8,839	.3480	1,7	40	10
–	B225A08900HP	8,900	.3504	1,7	40	10
B224A09000HP	B225A09000HP	9,000	.3543	1,7	40	10
B224A09093HP *	B225A09093HP	9,093	.3580	1,7	40	10
–	B225A09100HP	9,100	.3583	1,7	40	10
B224A09129HP	B225A09129HP	9,129	.3594	1,7	40	10
–	B225A09200HP	9,200	.3622	1,7	40	10
–	B225A09300HP	9,300	.3661	1,7	40	10
–	B225A09347HP	9,347	.3680	1,7	40	10
B224A09400HP	B225A09400HP	9,400	.3701	1,8	40	10
B224A09500HP	B225A09500HP	9,500	.3740	1,8	40	10
B224A09525HP	B225A09525HP	9,525	.3750	1,8	40	10
–	B225A09600HP	9,600	.3780	1,8	40	10
–	B225A09700HP	9,700	.3819	1,8	40	10
–	B225A09800HP	9,800	.3858	1,8	40	10
–	B225A09900HP	9,900	.3898	1,8	40	10
B224A09921HP *	B225A09921HP	9,921	.3906	1,9	40	10
B224A10000HP	B225A10000HP	10,000	.3937	1,9	40	10
–	B225A10100HP	10,100	.3976	1,9	45	12
B224A10200HP	B225A10200HP	10,200	.4016	1,9	45	12
B224A10300HP	B225A10300HP	10,300	.4055	1,9	45	12
B224A10320HP	B225A10320HP	10,320	.4063	1,9	45	12
B224A10400HP	B225A10400HP	10,400	.4094	1,9	45	12
B224A10500HP	B225A10500HP	10,500	.4134	2,0	45	12
–	B225A10600HP	10,600	.4173	2,0	45	12
–	B225A10700HP	10,700	.4213	2,0	45	12
B224A10716HP	B225A10716HP	10,716	.4219	2,0	45	12
B224A10800HP	B225A10800HP	10,800	.4252	2,0	45	12
–	B225A10900HP	10,900	.4291	2,0	45	12
B224A11000HP	B225A11000HP	11,000	.4331	2,1	45	12
–	B225A11100HP	11,100	.4370	2,1	45	12
B224A11113HP	B225A11113HP	11,113	.4375	2,1	45	12
–	B225A11200HP	11,200	.4409	2,1	45	12
–	B225A11300HP	11,300	.4449	2,1	45	12
–	B225A11400HP	11,400	.4488	2,1	45	12
B224A11500HP	B225A11500HP	11,500	.4528	2,1	45	12
B224A11509HP	B225A11509HP	11,509	.4531	2,1	45	12
–	B225A11600HP	11,600	.4567	2,2	45	12
–	B225A11700HP	11,700	.4606	2,2	45	12
–	B225A11800HP	11,800	.4646	2,2	45	12
–	B225A11900HP	11,900	.4685	2,2	45	12
B224A11908HP	B225A11908HP	11,908	.4688	2,2	45	12
B224A12000HP	B225A12000HP	12,000	.4724	2,2	45	12

(continued)

(B224/B225_HP • ~3 x D/~5 x D — continued)

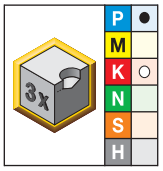


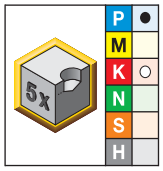
● first choice
○ alternate choice

short • KCPK15	long • KCPK15	D1 diameter mm	in	L5	LS	D
–	B225A12100HP	12,100	.4764	2,3	45	14
–	B225A12200HP	12,200	.4803	2,3	45	14
B224A12300HP	B225A12300HP	12,300	.4843	2,3	45	14
B224A12304HP *	B225A12304HP	12,304	.4844	2,3	45	14
–	B225A12400HP	12,400	.4882	2,3	45	14
B224A12500HP	B225A12500HP	12,500	.4921	2,3	45	14
–	B225A12600HP	12,600	.4961	2,3	45	14
B224A12700HP	B225A12700HP	12,700	.5000	2,4	45	14
B224A12800HP *	B225A12800HP	12,800	.5039	2,4	45	14
–	B225A12900HP	12,900	.5079	2,4	45	14
B224A13000HP	B225A13000HP	13,000	.5118	2,4	45	14
B224A13096HP *	–	13,096	.5156	2,4	45	14
B224A13100HP	B225A13100HP	13,100	.5157	2,4	45	14
–	B225A13200HP	13,200	.5197	2,5	45	14
–	B225A13300HP	13,300	.5236	2,5	45	14
–	B225A13400HP	13,400	.5276	2,5	45	14
B224A13495HP	B225A13495HP	13,495	.5313	2,5	45	14
B224A13500HP	B225A13500HP	13,500	.5315	2,5	45	14
–	B225A13600HP	13,600	.5354	2,5	45	14
–	B225A13700HP	13,700	.5394	2,6	45	14
–	B225A13800HP	13,800	.5433	2,6	45	14
B224A13891HP	B225A13891HP *	13,891	.5469	2,6	45	14
–	B225A13900HP	13,900	.5472	2,6	45	14
B224A14000HP	B225A14000HP	14,000	.5512	2,6	45	14
–	B225A14100HP	14,100	.5551	2,6	48	16
B224A14200HP *	B225A14200HP	14,200	.5591	2,6	48	16
B224A14288HP	B225A14288HP	14,288	.5625	2,7	48	16
–	B225A14300HP	14,300	.5630	2,7	48	16
–	B225A14400HP	14,400	.5669	2,7	48	16
B224A14500HP	B225A14500HP	14,500	.5709	2,7	48	16
–	B225A14600HP	14,600	.5748	2,7	48	16
B224A14684HP	B225A14684HP *	14,684	.5781	2,7	48	16
–	B225A14700HP	14,700	.5787	2,7	48	16
–	B225A14800HP	14,800	.5827	2,8	48	16
–	B225A14900HP *	14,900	.5866	2,8	48	16
–	B225A15000HP	15,000	.5906	2,8	48	16
B224A15083HP *	B225A15083HP *	15,083	.5938	2,8	48	16
–	B225A15100HP	15,100	.5945	2,8	48	16
–	B225A15200HP	15,200	.5984	2,8	48	16
–	B225A15300HP	15,300	.6024	2,8	48	16
–	B225A15400HP	15,400	.6063	2,9	48	16
–	B225A15479HP *	15,479	.6094	2,9	48	16
B224A15500HP	B225A15500HP	15,500	.6102	2,9	48	16
B224A15600HP	B225A15600HP	15,600	.6142	2,9	48	16
–	B225A15700HP	15,700	.6181	2,9	48	16
–	B225A15800HP	15,800	.6220	2,9	48	16
B224A15875HP	B225A15875HP	15,875	.6250	3,0	48	16
–	B225A15900HP *	15,900	.6260	3,0	48	16
B224A16000HP	B225A16000HP	16,000	.6299	3,0	48	16
–	B225A16100HP	16,100	.6339	3,0	48	18
B224A16500HP	B225A16500HP	16,500	.6496	3,1	48	18
–	B225A16670HP	16,670	.6563	3,1	48	18

(continued)

(B224/B225_HP • ~3 x D/~5 x D — continued)





● first choice
○ alternate choice

short • KCPK15	long • KCPK15	D1 diameter mm	D1 diameter in	L5	LS	D
B224A17000HP	B225A17000HP	17,000	.6693	3,2	48	18
B224A17463HP	B225A17463HP	17,463	.6875	3,2	48	18
B224A17500HP	B225A17500HP	17,500	.6890	3,3	48	18
–	B225A17700HP	17,700	.6969	3,3	48	18
B224A18000HP	B225A18000HP	18,000	.7087	3,3	48	18
–	B225A18500HP	18,500	.7283	3,4	50	20
B224A19000HP	B225A19000HP	19,000	.7480	3,5	50	20
B224A19050HP *	B225A19050HP	19,050	.7500	3,5	50	20
–	B225A19200HP	19,200	.7559	3,6	50	20
–	B225A19250HP	19,250	.7579	3,6	50	20
–	B225A19300HP	19,300	.7598	3,6	50	20
–	B225A19500HP	19,500	.7677	3,6	50	20
B224A20000HP	B225A20000HP	20,000	.7874	3,7	50	20
–	B225A20500HP	20,500	.8071	3,8	50	20
–	B225A21000HP	21,000	.8268	3,9	50	20

NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Tolerance • Metric

nominal size range	D1 tolerance m7	D tolerance h6
>3–6	0,004/0,016	0,000/-0,008
>6–10	0,006/0,021	0,000/-0,009
>10–18	0,007/0,025	0,000/-0,011
>18–25,4	0,008/0,029	0,000/-0,013

Application Data

HP Drills • B224_HP, B225_HP Series • Grade KCPK15™ • Through Coolant or MQL (Minimum Quantity Lubricant) • Drill Diameters 3–20mm • Metric





Material Group		Cutting Speed — vc Range — m/min min	Starting Value	max	Metric Recommended Feed Rate (f) by Diameter	3,0	4,0	6,0	8,0	10,0	12,0	16,0	20,0
P	0	140	**240**	290	mm/r	0,08–0,15	0,09–0,18	0,12–0,21	0,14–0,29	0,15–0,33	0,17–0,37	0,19–0,43	0,22–0,49
	1	130	**240**	290	mm/r	0,09–0,18	0,11–0,21	0,14–0,25	0,16–0,34	0,18–0,39	0,20–0,43	0,22–0,51	0,26–0,58
	2	190	**230**	270	mm/r	0,09–0,18	0,11–0,21	0,14–0,25	0,16–0,34	0,18–0,39	0,20–0,43	0,26–0,51	0,32–0,58
	3	130	**160**	190	mm/r	0,10–0,18	0,12–0,21	0,14–0,26	0,16–0,34	0,19–0,39	0,24–0,46	0,27–0,51	0,34–0,60
	4	110	**150**	170	mm/r	0,07–0,16	0,09–0,18	0,14–0,26	0,16–0,34	0,17–0,36	0,22–0,45	0,25–0,52	0,30–0,60
	5	60	**80**	90	mm/r	0,06–0,14	0,08–0,16	0,10–0,20	0,14–0,25	0,16–0,28	0,18–0,32	0,22–0,40	0,26–0,48
	6	110	**150**	190	mm/r	0,07–0,13	0,11–0,16	0,12–0,20	0,15–0,28	0,17–0,33	0,19–0,37	0,22–0,43	0,25–0,48
K	1	120	**150**	200	mm/r	0,08–0,11	0,14–0,20	0,20–0,28	0,25–0,35	0,29–0,40	0,32–0,43	0,36–0,50	0,40–0,55
	2	80	**120**	160	mm/r	0,08–0,11	0,13–0,17	0,19–0,26	0,23–0,30	0,25–0,36	0,30–0,40	0,34–0,46	0,37–0,50
	3	60	**80**	120	mm/r	0,07–0,10	0,10–0,14	0,15–0,21	0,19–0,26	0,22–0,30	0,24–0,33	0,28–0,38	0,30–0,41

YPC Beyond™ Solid Carbide Drills with Through Coolant for Iron Materials

beyond

Primary Application

The B25_YPC series solid carbide drills are specifically engineered to deliver best-in-class hole quality and longest tool life in cast iron, ductile iron, CGI, and ADI. Operate these drills with standard through coolant or MQL.

The B25_YPC Beyond solid carbide drill combines unique Kennametal technologies, such as the Y-TECH™ flute spacing, the HP-point geometry, the KCK10™ Beyond grade, and the latest, proprietary post-coat treatment technology into one tool.

Features and Benefits

Y-TECH Technology with Uneven Flute-to-Flute Angle

- Unbalanced forces by design avoid chipping on margin lands.

Three-Margin Lands

- Reduce pendulum motion by directing forces towards third margin for superior hole accuracy (cylindricity, constant diameter, hole straightness).

New HP Drill-Point Design

- Low thrust prevents workpiece flexing.
- Excellent centring capabilities.
- Highest possible feed rates.

Corner Chamfer

- Avoids breakout when drilling through holes in grey iron.
- Significantly increases tool life at elevated speeds and feeds.

KCK10 Beyond Grade

- The grade contains multiple layers of PVD coating offering outstanding wear resistance for the drilling of cast irons.
- The highly polished surface ensures superior chip evacuation even when low-pressure coolant or MQL is applied.

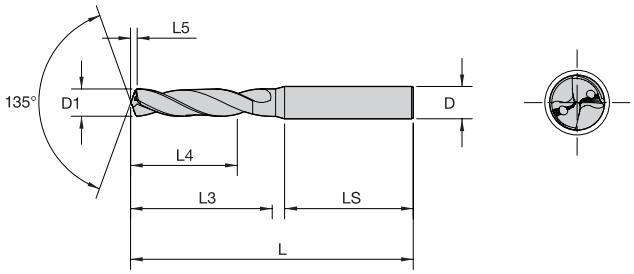
Y-TECH™ technology for superior hole quality.



Customisation

- Intermediate diameters available as semi-standards.
- Length variations and step drills available as engineered solutions.
- Using Kennametal slim line hydraulic chucks together with standard B25_YPC is recommended if workpiece contours need to be bypassed.



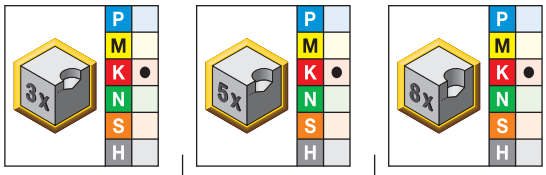




beyond

For information on L, L3, and L4 max, see the Solid Carbide Drills foldout table.

B254/B255/B256_YPC • ~3 x D/~5 x D/~8 x D



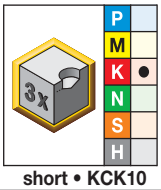
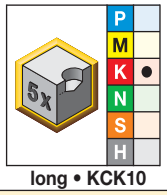
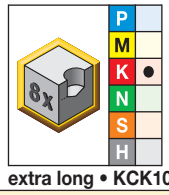
● first choice
○ alternate choice

short • KCK10	long • KCK10	extra long • KCK10	D1 diameter mm	D1 diameter in	L5	LS	D
B254A03000YPC	B255A03000YPC	B256A03000YPC	3,000	.1181	0,9	36	6
B254A03048YPC *	B255A03048YPC	–	3,048	.1200	0,9	36	6
–	B255A03175YPC *	B256A03175YPC	3,175	.1250	0,9	36	6
B254A03200YPC	B255A03200YPC	–	3,200	.1260	0,9	36	6
–	B255A03250YPC	–	3,250	.1280	0,9	36	6
–	–	B256A03264YPC	3,264	.1285	0,9	36	6
B254A03300YPC *	B255A03300YPC	–	3,300	.1299	0,9	36	6
–	B255A03400YPC *	–	3,400	.1339	1,0	36	6
B254A03454YPC *	–	–	3,454	.1360	1,0	36	6
B254A03500YPC	B255A03500YPC *	B256A03500YPC	3,500	.1378	1,0	36	6
B254A03600YPC *	B255A03600YPC *	–	3,600	.1417	1,0	36	6
–	B255A03700YPC	B256A03700YPC *	3,700	.1457	1,0	36	6
–	B255A03797YPC	–	3,797	.1495	1,1	36	6
B254A03800YPC *	B255A03800YPC	B256A03800YPC *	3,800	.1496	1,1	36	6
B254A03861YPC *	B255A03861YPC *	–	3,861	.1520	1,1	36	6
–	B255A03970YPC *	–	3,970	.1563	1,1	36	6
B254A04000YPC	B255A04000YPC	B256A04000YPC	4,000	.1575	1,1	36	6
B254A04039YPC	B255A04039YPC	–	4,039	.1590	1,1	36	6
B254A04100YPC	B255A04100YPC	B256A04100YPC	4,100	.1614	1,1	36	6
B254A04200YPC	B255A04200YPC	B256A04200YPC	4,200	.1654	1,2	36	6
–	B255A04217YPC	–	4,217	.1660	1,2	36	6
–	B255A04300YPC	B256A04300YPC *	4,300	.1693	1,2	36	6
–	B255A04366YPC *	B256A04366YPC *	4,366	.1719	1,2	36	6
B254A04500YPC	B255A04500YPC	B256A04500YPC	4,500	.1772	1,2	36	6
B254A04572YPC	B255A04572YPC	–	4,572	.1800	1,3	36	6
–	B255A04600YPC *	–	4,600	.1811	1,3	36	6
–	–	B256A04623YPC	4,623	.1820	1,3	36	6
–	B255A04700YPC *	B256A04700YPC	4,700	.1850	1,3	36	6
B254A04763YPC *	–	–	4,763	.1875	1,3	36	6
B254A04800YPC	B255A04800YPC	B256A04800YPC	4,800	.1890	1,3	36	6
–	–	B256A04852YPC *	4,852	.1910	1,3	36	6
–	B255A04900YPC *	–	4,900	.1929	1,3	36	6
B254A05000YPC	B255A05000YPC	B256A05000YPC	5,000	.1969	1,4	36	6
B254A05055YPC	B255A05055YPC	–	5,055	.1990	1,4	36	6
B254A05100YPC	B255A05100YPC	B256A05100YPC	5,100	.2008	1,4	36	6
B254A05106YPC *	–	–	5,106	.2010	1,4	36	6
–	B255A05159YPC *	–	5,159	.2031	1,4	36	6
–	B255A05200YPC	B256A05200YPC *	5,200	.2047	1,4	36	6
–	B255A05250YPC	–	5,250	.2067	1,4	36	6
B254A05300YPC *	B255A05300YPC *	–	5,300	.2087	1,4	36	6

(continued)

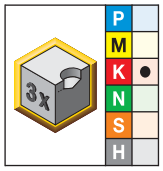
(B254/B255/B256_YPC • ~3 x D/~5 x D/~8 x D — continued)

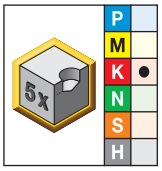
● first choice
○ alternate choice

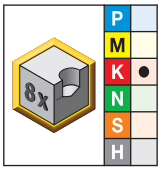
 short • KCK10	 long • KCK10	 extra long • KCK10	D1 diameter mm	D1 diameter in	L5	LS	D
–	B255A05400YPC *	–	5,400	.2126	1,5	36	6
–	B255A05410YPC *	–	5,410	.2130	1,5	36	6
B254A05500YPC *	B255A05500YPC	B256A05500YPC	5,500	.2165	1,5	36	6
B254A05558YPC *	B255A05558YPC *	–	5,558	.2188	1,5	36	6
–	B255A05600YPC	B256A05600YPC	5,600	.2205	1,5	36	6
–	B255A05700YPC *	–	5,700	.2244	1,5	36	6
B254A05791YPC	B255A05791YPC *	–	5,791	.2280	1,6	36	6
B254A05800YPC	B255A05800YPC	B256A05800YPC	5,800	.2283	1,6	36	6
–	–	B256A05900YPC	5,900	.2323	1,6	36	6
B254A06000YPC	B255A06000YPC	B256A06000YPC	6,000	.2362	1,6	36	6
B254A06100YPC *	B255A06100YPC *	–	6,100	.2402	1,6	36	8
B254A06200YPC *	B255A06200YPC	B256A06200YPC	6,200	.2441	1,7	36	8
–	B255A06300YPC	–	6,300	.2480	1,7	36	8
–	B255A06350YPC *	B256A06350YPC	6,350	.2500	1,7	36	8
–	B255A06400YPC	B256A06400YPC	6,400	.2520	1,7	36	8
B254A06500YPC *	B255A06500YPC	B256A06500YPC	6,500	.2559	1,7	36	8
B254A06528YPC	–	–	6,528	.2570	1,7	36	8
B254A06600YPC *	B255A06600YPC	B256A06600YPC *	6,600	.2598	1,8	36	8
–	B255A06630YPC	–	6,630	.2610	1,8	36	8
B254A06700YPC *	B255A06700YPC *	B256A06700YPC *	6,700	.2638	1,8	36	8
B254A06746YPC *	B255A06746YPC	–	6,746	.2656	1,8	36	8
B254A06800YPC	B255A06800YPC	B256A06800YPC	6,800	.2677	1,8	36	8
B254A06900YPC *	B255A06900YPC	–	6,900	.2717	1,8	36	8
–	B255A06909YPC *	–	6,909	.2720	1,8	36	8
B254A07000YPC	B255A07000YPC	B256A07000YPC	7,000	.2756	1,9	36	8
B254A07100YPC *	–	–	7,100	.2795	1,9	36	8
–	B255A07145YPC *	–	7,145	.2813	1,9	36	8
–	B255A07200YPC	–	7,200	.2835	1,9	36	8
–	–	B256A07300YPC *	7,300	.2874	1,9	36	8
B254A07366YPC *	–	–	7,366	.2900	1,9	36	8
–	B255A07400YPC	–	7,400	.2913	2,0	36	8
B254A07493YPC *	B255A07493YPC *	–	7,493	.2950	2,0	36	8
B254A07500YPC	B255A07500YPC *	B256A07500YPC	7,500	.2953	2,0	36	8
–	B255A07541YPC	–	7,541	.2969	2,0	36	8
B254A07600YPC *	B255A07600YPC *	B256A07600YPC	7,600	.2992	2,0	36	8
–	B255A07700YPC	–	7,700	.3031	2,0	36	8
B254A07800YPC	B255A07800YPC	B256A07800YPC	7,800	.3071	2,1	36	8
–	B255A07900YPC	–	7,900	.3110	2,1	36	8
B254A07938YPC	B255A07938YPC	–	7,938	.3125	2,1	36	8
B254A08000YPC	B255A08000YPC	B256A08000YPC	8,000	.3150	2,1	36	8
B254A08100YPC	B255A08100YPC *	–	8,100	.3189	2,1	40	10
B254A08200YPC	B255A08200YPC	B256A08200YPC	8,200	.3228	2,1	40	10
–	B255A08300YPC	B256A08300YPC	8,300	.3268	2,2	40	10
B254A08334YPC *	–	–	8,334	.3281	2,2	40	10
B254A08400YPC	–	–	8,400	.3307	2,2	40	10
B254A08433YPC *	B255A08433YPC	–	8,433	.3320	2,2	40	10
B254A08500YPC	B255A08500YPC	B256A08500YPC	8,500	.3346	2,2	40	10
B254A08600YPC	B255A08600YPC	B256A08600YPC	8,600	.3386	2,2	40	10
B254A08700YPC	B255A08700YPC	B256A08700YPC *	8,700	.3425	2,3	40	10
B254A08800YPC	B255A08800YPC	B256A08800YPC	8,800	.3465	2,3	40	10
B254A08839YPC *	B255A08839YPC *	–	8,839	.3480	2,3	40	10
–	B255A08900YPC *	–	8,900	.3504	2,3	40	10
B254A09000YPC	B255A09000YPC	B256A09000YPC	9,000	.3543	2,3	40	10
–	B255A09093YPC *	–	9,093	.3580	2,4	40	10
B254A09100YPC *	B255A09100YPC	B256A09100YPC	9,100	.3583	2,4	40	10
–	B255A09129YPC *	–	9,129	.3594	2,4	40	10
B254A09200YPC	B255A09200YPC *	–	9,200	.3622	2,4	40	10
–	B255A09300YPC	B256A09300YPC	9,300	.3661	2,4	40	10
–	–	B256A09347YPC	9,347	.3680	2,4	40	10
B254A09400YPC *	B255A09400YPC	–	9,400	.3701	2,4	40	10

(continued)

(B254/B255/B256_YPC • ~3 x D/~5 x D/~8 x D — continued)





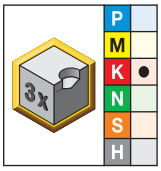


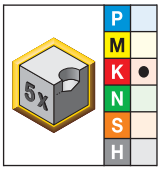
● first choice
○ alternate choice

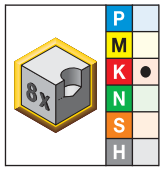
short • KCK10	long • KCK10	extra long • KCK10	D1 diameter mm	D1 diameter in	L5	LS	D
B254A09500YPC	B255A09500YPC	B256A09500YPC	9,500	.3740	2,5	40	10
B254A09525YPC *	B255A09525YPC *	–	9,525	.3750	2,5	40	10
–	B255A09600YPC	B256A09600YPC	9,600	.3780	2,5	40	10
–	B255A09700YPC	B256A09700YPC *	9,700	.3819	2,5	40	10
B254A09800YPC	B255A09800YPC *	B256A09800YPC	9,800	.3858	2,5	40	10
B254A09921YPC *	B255A09921YPC	–	9,921	.3906	2,6	40	10
B254A10000YPC	B255A10000YPC	B256A10000YPC	10,000	.3937	2,6	40	10
B254A10200YPC	B255A10200YPC	B256A10200YPC	10,200	.4016	2,6	45	12
B254A10262YPC	B255A10262YPC *	–	10,262	.4040	2,6	45	12
B254A10300YPC	B255A10300YPC	B256A10300YPC	10,300	.4055	2,6	45	12
B254A10320YPC	B255A10320YPC *	–	10,320	.4063	2,7	45	12
–	B255A10400YPC *	B256A10400YPC	10,400	.4094	2,7	45	12
B254A10490YPC *	–	–	10,490	.4130	2,7	45	12
B254A10500YPC	B255A10500YPC	B256A10500YPC	10,500	.4134	2,7	45	12
–	B255A10600YPC	–	10,600	.4173	2,7	45	12
B254A10700YPC	–	B256A10700YPC	10,700	.4213	2,7	45	12
–	B255A10716YPC	–	10,716	.4219	2,7	45	12
B254A10800YPC	B255A10800YPC	B256A10800YPC	10,800	.4252	2,8	45	12
–	B255A10900YPC *	–	10,900	.4291	2,8	45	12
B254A11000YPC	B255A11000YPC	B256A11000YPC	11,000	.4331	2,8	45	12
B254A11100YPC *	B255A11100YPC	–	11,100	.4370	2,8	45	12
B254A11113YPC *	B255A11113YPC	–	11,113	.4375	2,8	45	12
B254A11200YPC	B255A11200YPC	B256A11200YPC	11,200	.4409	2,9	45	12
–	–	B256A11300YPC *	11,300	.4449	2,9	45	12
B254A11500YPC	B255A11500YPC	B256A11500YPC	11,500	.4528	2,9	45	12
–	–	B256A11600YPC	11,600	.4567	3,0	45	12
–	B255A11700YPC	–	11,700	.4606	3,0	45	12
B254A11800YPC	B255A11800YPC	B256A11800YPC	11,800	.4646	3,0	45	12
–	B255A11900YPC	B256A11900YPC	11,900	.4685	3,0	45	12
B254A11908YPC *	B255A11908YPC *	–	11,908	.4688	3,0	45	12
B254A12000YPC	B255A12000YPC	B256A12000YPC	12,000	.4724	3,1	45	12
–	B255A12100YPC	–	12,100	.4764	3,1	45	14
B254A12200YPC	B255A12200YPC	B256A12200YPC	12,200	.4803	3,1	45	14
–	B255A12251YPC	–	12,251	.4823	3,1	45	14
–	B255A12300YPC *	B256A12300YPC	12,300	.4843	3,1	45	14
B254A12304YPC *	B255A12304YPC *	–	12,304	.4844	3,1	45	14
–	–	B256A12400YPC *	12,400	.4882	3,1	45	14
B254A12500YPC	B255A12500YPC	B256A12500YPC	12,500	.4921	3,2	45	14
–	B255A12700YPC	B256A12700YPC	12,700	.5000	3,2	45	14
B254A12800YPC	–	B256A12800YPC	12,800	.5039	3,2	45	14
B254A13000YPC	B255A13000YPC	B256A13000YPC	13,000	.5118	3,3	45	14
–	B255A13096YPC *	B256A13096YPC	13,096	.5156	3,3	45	14
B254A13100YPC	–	–	13,100	.5157	3,3	45	14
B254A13200YPC	–	B256A13200YPC	13,200	.5197	3,3	45	14
–	B255A13495YPC	B256A13495YPC	13,495	.5313	3,4	45	14
B254A13500YPC	B255A13500YPC	B256A13500YPC	13,500	.5315	3,4	45	14
–	–	B256A13700YPC	13,700	.5394	3,5	45	14
B254A13800YPC	–	B256A13800YPC	13,800	.5433	3,5	45	14
B254A13891YPC *	–	B256A13891YPC *	13,891	.5469	3,5	45	14
B254A14000YPC	B255A14000YPC	B256A14000YPC	14,000	.5512	3,5	45	14
B254A14100YPC *	B255A14100YPC *	–	14,100	.5551	3,6	48	16
B254A14288YPC	B255A14288YPC	–	14,288	.5625	3,6	48	16
B254A14500YPC	B255A14500YPC	B256A14500YPC	14,500	.5709	3,6	48	16
–	B255A14600YPC *	–	14,600	.5748	3,7	48	16
–	B255A14684YPC	B256A14684YPC *	14,684	.5781	3,7	48	16
B254A14800YPC	–	B256A14800YPC	14,800	.5827	3,7	48	16
B254A15000YPC	B255A15000YPC	B256A15000YPC	15,000	.5906	3,8	48	16
–	B255A15083YPC	B256A15083YPC *	15,083	.5938	3,8	48	16
B254A15200YPC	–	B256A15200YPC	15,200	.5984	3,8	48	16
B254A15250YPC *	B255A15250YPC	–	15,250	.6004	3,8	48	16

(continued)

(B254/B255/B256_YPC • ~3 x D/~5 x D/~8 x D — continued)







● first choice
○ alternate choice

short • KCK10	long • KCK10	extra long • KCK10	D1 diameter mm	D1 diameter in	L5	LS	D
–	–	B256A15300YPC	15,300	.6024	3,8	48	16
B254A15400YPC	B255A15400YPC *	–	15,400	.6063	3,9	48	16
B254A15500YPC	B255A15500YPC *	B256A15500YPC	15,500	.6102	3,9	48	16
B254A15800YPC	B255A15800YPC	B256A15800YPC *	15,800	.6220	4,0	48	16
–	B255A15875YPC *	–	15,875	.6250	4,0	48	16
B254A16000YPC	B255A16000YPC	B256A16000YPC	16,000	.6299	4,0	48	16
–	B255A16300YPC	B256A16300YPC	16,300	.6417	4,1	48	18
B254A16500YPC	B255A16500YPC	B256A16500YPC	16,500	.6496	4,1	48	18
B254A16670YPC *	B255A16670YPC	–	16,670	.6563	4,2	48	18
B254A16800YPC	B255A16800YPC	B256A16800YPC	16,800	.6614	4,2	48	18
B254A17000YPC	B255A17000YPC	B256A17000YPC	17,000	.6693	4,2	48	18
–	B255A17200YPC *	–	17,200	.6772	4,3	48	18
B254A17463YPC *	B255A17463YPC	–	17,463	.6875	4,3	48	18
B254A17500YPC	B255A17500YPC	B256A17500YPC	17,500	.6890	4,3	48	18
B254A17800YPC	B255A17800YPC	B256A17800YPC	17,800	.7008	4,4	48	18
B254A17859YPC *	B255A17859YPC	–	17,859	.7031	4,4	48	18
B254A18000YPC	B255A18000YPC	B256A18000YPC	18,000	.7087	4,5	48	18
B254A18200YPC *	–	–	18,200	.7165	4,5	50	20
B254A18258YPC *	B255A18258YPC	B256A18258YPC *	18,258	.7188	4,5	50	20
B254A18500YPC *	B255A18500YPC	B256A18500YPC	18,500	.7283	4,6	50	20
B254A18800YPC	B255A18800YPC	B256A18800YPC	18,800	.7402	4,7	50	20
B254A19000YPC	B255A19000YPC	B256A19000YPC	19,000	.7480	4,7	50	20
B254A19050YPC *	–	–	19,050	.7500	4,7	50	20
–	B255A19500YPC	B256A19500YPC	19,500	.7677	4,8	50	20
–	B255A19700YPC	–	19,700	.7756	4,9	50	20
B254A19800YPC	B255A19800YPC	B256A19800YPC	19,800	.7795	4,9	50	20
B254A20000YPC	B255A20000YPC	B256A20000YPC	20,000	.7874	4,9	50	20
–	B255A20500YPC	–	20,500	.8071	5,1	50	20
B254A20638YPC *	B255A20638YPC	B256A20638YPC	20,638	.8125	5,1	50	20
B254A21000YPC *	B255A21000YPC *	–	21,000	.8268	5,2	50	20
B254A22000YPC	B255A22000YPC	B256A22000YPC	22,000	.8661	5,4	50	20
B254A22225YPC *	B255A22225YPC *	B256A22225YPC *	22,225	.8750	5,5	56	25
B254A23416YPC	B255A23416YPC *	–	23,416	.9219	5,7	56	25
–	B255A24000YPC *	–	24,000	.9449	5,9	56	25
B254A25000YPC *	B255A25000YPC *	–	25,000	.9843	6,1	56	25
–	–	B256A25004YPC *	25,004	.9844	6,1	56	25

NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Application Data

YPC Drills • B25_YPC • Grade KCK10™ • Through Coolant • Drill Diameters 3–20mm • Metric





Material Group		Cutting Speed — vc Range — m/min min	Starting Value	max	Metric Recommended Feed Rate (f) by Diameter	3,0	4,0	6,0	8,0	10,0	12,0	16,0	20,0
K	1	130	**160**	210	mm/r	0,12–0,22	0,14–0,25	0,16–0,32	0,22–0,44	0,30–0,46	0,34–0,50	0,38–0,62	0,42–0,74
	2	90	**130**	180	mm/r	0,12–0,22	0,14–0,25	0,16–0,32	0,22–0,44	0,30–0,46	0,34–0,50	0,38–0,62	0,42–0,74
	3	70	**90**	130	mm/r	0,11–0,17	0,12–0,22	0,22–0,34	0,24–0,46	0,26–0,48	0,28–0,50	0,30–0,62	0,34–0,74

SE 4-Margin Drills with Through Coolant for Steel

High-performance platform for mid-L/D applications in steel.



Primary Application

B256 series solid carbide drills are the high-performance platform for mid-L/D applications in steel that require high accuracy and consistent hole straightness combined with excellent metal removal rates and long tool life.

Features and Benefits

SE Drill-Point Design

- Sculptured edge enables high feed rates.



Four-Margin Lands

- Improves hole straightness.
- Improves hole alignment when drilling through cross holes.

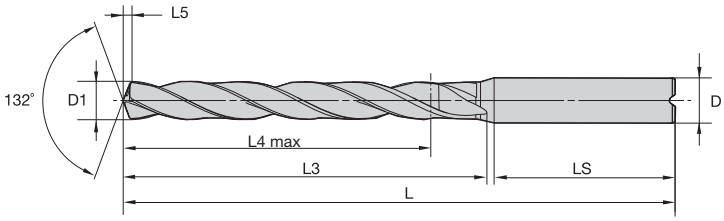
KC7315™ Grade

- Multilayer, TiAlN-based coating with high hot hardness allows 30% higher cutting speeds and constant tool life.
- Optimised tool surface finish ensures chip evacuation when drilling deeper holes.

Customisation

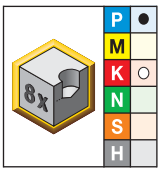
- Intermediate diameters available as semi-standards.
- Length variations and step drills available as engineered solutions.
- For follow-up operations, such as machining screw holes in connecting rods, the point angle of the step drill for the screw head should be adjusted.







B256 • ~8 x D



● first choice
○ alternate choice

extra long • KC7315	D1 diameter mm	D1 diameter in	L	L3	L4 max	L5	LS	D
B256A05000	5,000	.1969	94	56	48	1,0	36	6
B256A05100	5,100	.2008	94	56	48	1,0	36	6
B256A05500	5,500	.2165	94	56	48	1,1	36	6
B256A05800	5,800	.2283	94	56	48	1,2	36	6
B256A06000	6,000	.2362	94	56	48	1,2	36	6
B256A06500	6,500	.2559	105	67	57	1,3	36	8
B256A06800	6,800	.2677	105	67	57	1,4	36	8
B256A07000	7,000	.2756	105	67	57	1,4	36	8
B256A07800	7,800	.3071	110	72	61	1,6	36	8
B256A08000	8,000	.3150	110	72	61	1,6	36	8
B256A08400	8,400	.3307	122	80	68	1,7	40	10
B256A08500	8,500	.3346	122	80	68	1,7	40	10
B256A08800	8,800	.3465	122	80	68	1,8	40	10
B256A09000	9,000	.3543	122	80	68	1,8	40	10
B256A09500	9,500	.3740	122	80	68	1,9	40	10
B256A10000	10,000	.3937	122	80	68	2,0	40	10
B256A10200	10,200	.4016	141	94	79	2,0	45	12
B256A10500	10,500	.4134	141	94	79	2,1	45	12
B256A11000	11,000	.4331	141	94	79	2,2	45	12
B256A11800	11,800	.4646	141	94	79	2,3	45	12
B256A12000	12,000	.4724	141	94	79	2,4	45	12
B256A12500	12,500	.4921	155	108	91	2,5	45	14
B256A13000	13,000	.5118	155	108	91	2,6	45	14
B256A13500	13,500	.5315	155	108	91	2,7	45	14
B256A14000	14,000	.5512	155	108	91	2,8	45	14
B256A15000	15,000	.5906	171	121	101	3,0	48	16
B256A16000	16,000	.6299	171	121	101	3,2	48	16

Tolerance • Metric

nominal size range	D1 tolerance m7	D tolerance h6
>3–6	0,004/0,016	0,000/-0,008
>6–10	0,006/0,021	0,000/-0,009
>10–18	0,007/0,025	0,000/-0,011
>18–25,4	0,008/0,029	0,000/-0,013

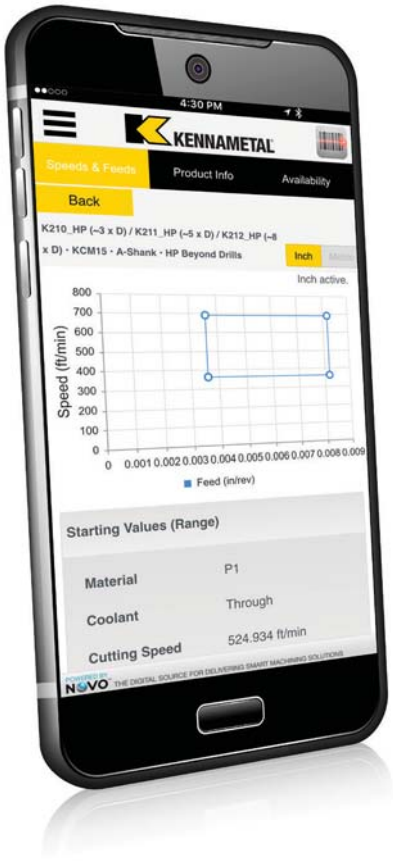
SE Drills • B256 Series • Grade KC7315™ • Through Coolant • Drill Diameters 3–20mm • Metric



Material Group		Cutting Speed — vc			Metric								
		Range — m/min			Recommended Feed Rate (f) by Diameter								
		min	Starting Value	max		3,0	4,0	6,0	8,0	10,0	12,0	16,0	20,0
P	0	130	**145**	200	mm/r	0,07–0,09	0,08–0,13	0,09–0,13	0,11–0,16	0,11–0,19	0,13–0,23	0,15–0,28	0,19–0,31
	1	120	**145**	175	mm/r	0,08–0,11	0,09–0,15	0,11–0,15	0,13–0,19	0,13–0,22	0,15–0,27	0,18–0,33	0,22–0,37
	2	80	**100**	120	mm/r	0,08–0,11	0,08–0,13	0,09–0,17	0,15–0,21	0,16–0,25	0,18–0,33	0,22–0,42	0,26–0,50
	3	80	**90**	120	mm/r	0,08–0,11	0,09–0,15	0,11–0,15	0,13–0,19	0,13–0,22	0,15–0,27	0,18–0,33	0,22–0,37
	4	60	**70**	80	mm/r	0,06–0,09	0,07–0,13	0,09–0,13	0,11–0,15	0,11–0,17	0,13–0,22	0,15–0,27	0,17–0,30
K	1	120	**150**	200	mm/r	0,08–0,11	0,14–0,20	0,20–0,28	0,25–0,35	0,29–0,40	0,32–0,43	0,36–0,50	0,40–0,55
	2	80	**120**	160	mm/r	0,08–0,11	0,13–0,17	0,19–0,26	0,23–0,30	0,25–0,36	0,30–0,40	0,34–0,46	0,37–0,50
	3	60	**80**	120	mm/r	0,07–0,10	0,10–0,14	0,15–0,21	0,19–0,26	0,22–0,30	0,24–0,33	0,28–0,38	0,30–0,41

Mobile App

The Kennametal mobile app makes it easy to access product information, calculators, and much more from iPhone® and Android™ devices.



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HP Beyond™ 4-Margin Long-Length Drills with Through Coolant

beyond

Primary Application

B269_HP series solid carbide drills are 12 x D, long-length drills, closing the gap between 8 x D drill (B256_SE) and 15 x D (B271_HP). They are designed for deep-hole applications without pilot drill in steel, cast iron, and stainless steel materials. Operate these drills with standard through coolant or MQL. The drills have a standard A-shank according to DIN 6535 HA (round cylindrical with 2mm steps).

Features and Benefits

Four-Margin Lands

- Improves hole straightness.
- Improves hole alignment when drilling through cross holes or inclined exits.

HP Drill-Point Design

- Low thrust prevents workpiece flexing.
- Excellent centring capabilities.
- Eliminates the need for pilot drilling.

Unique Flute Design

- Drastically improved chip evacuation.
- Better hole surface quality.

KCPK15™ Beyond Grade

- The grade is a multilayer, TiAlN-based coating with high hot hardness. It enables highest cutting speeds and enables the use in MQL applications.
- The highly polished surface ensures superior chip evacuation even when low-pressure coolant is applied.

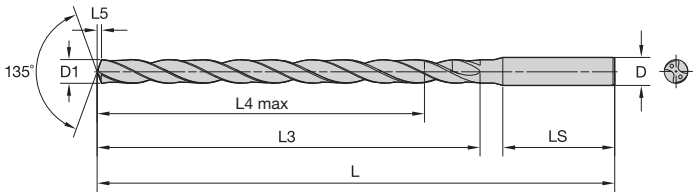
Designed for deep-hole applications without pilot drill.



Customisation

- Intermediate diameters available as engineered solutions.
- Length variations and step drills available as engineered solutions.

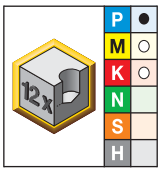






beyond

B269_HP • ~12 x D

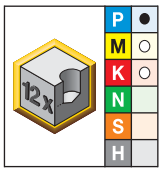


● first choice
○ alternate choice

extra long • KCPK15	D1 diameter mm	in	L	L3	L4 max	L5	LS	D
B269A02400KMG	2,400	.0945	75	42	35	0,5	28	4
B269A02500KMG	2,500	.0984	75	42	35	0,5	28	4
B269A02600KMG	2,600	.1024	75	42	35	0,5	28	4
B269A02800KMG	2,800	.1102	75	43	36	0,6	28	4
B269A02900KMG	2,900	.1142	75	43	36	0,6	28	4
B269A03000HP	3,000	.1181	93	52	44	0,6	36	6
B269A03175HP	3,175	.1250	93	52	44	0,6	36	6
B269A03264HP	3,264	.1285	93	53	44	0,6	36	6
B269A03300HP	3,300	.1299	93	53	44	0,6	36	6
B269A03400HP *	3,400	.1339	93	53	44	0,6	36	6
B269A03500HP	3,500	.1378	93	53	44	0,7	36	6
B269A03600HP	3,600	.1417	93	54	45	0,7	36	6
B269A03700HP	3,700	.1457	93	54	45	0,7	36	6
B269A03800HP	3,800	.1496	107	65	55	0,7	36	6
B269A03970HP	3,970	.1563	107	66	56	0,7	36	6
B269A04000HP	4,000	.1575	107	66	56	0,8	36	6
B269A04100HP	4,100	.1614	107	66	55	0,8	36	6
B269A04200HP	4,200	.1654	107	67	56	0,8	36	6
B269A04300HP	4,300	.1693	107	67	56	0,8	36	6
B269A04500HP	4,500	.1772	107	67	56	0,8	36	6
B269A04550HP	4,550	.1791	107	68	57	0,9	36	6
B269A04600HP	4,600	.1811	107	68	57	0,9	36	6
B269A04700HP	4,700	.1850	107	68	57	0,9	36	6
B269A04763HP	4,763	.1875	125	82	69	0,9	36	6
B269A04800HP	4,800	.1890	125	82	69	0,9	36	6
B269A05000HP	5,000	.1969	125	83	70	0,9	36	6
B269A05100HP	5,100	.2008	125	83	70	1,0	36	6
B269A05200HP	5,200	.2047	125	83	70	1,0	36	6
B269A05300HP	5,300	.2087	125	84	71	1,0	36	6
B269A05410HP	5,410	.2130	125	84	71	1,0	36	6
B269A05500HP	5,500	.2165	125	84	71	1,0	36	6
B269A05558HP	5,558	.2188	125	84	71	1,0	36	6

(continued)

(B269_HP • ~12 x D — continued)

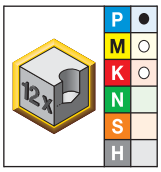


● first choice
○ alternate choice

extra long • KCPK15	D1 diameter mm	in	L	L3	L4 max	L5	LS	D
B269A05600HP	5,600	.2205	125	85	72	1,1	36	6
B269A05700HP	5,700	.2244	125	85	72	1,1	36	6
B269A05800HP	5,800	.2283	125	85	71	1,1	36	6
B269A06000HP	6,000	.2362	125	86	72	1,1	36	6
B269A06100HP	6,100	.2402	139	97	82	1,1	36	8
B269A06200HP	6,200	.2441	139	97	82	1,2	36	8
B269A06350HP	6,350	.2500	139	98	83	1,2	36	8
B269A06400HP	6,400	.2520	139	98	83	1,2	36	8
B269A06500HP	6,500	.2559	139	98	83	1,2	36	8
B269A06528HP	6,528	.2570	139	98	83	1,2	36	8
B269A06600HP	6,600	.2598	139	99	84	1,2	36	8
B269A06746HP	6,746	.2656	139	99	83	1,3	36	8
B269A06800HP	6,800	.2677	139	99	83	1,3	36	8
B269A06909HP	6,909	.2720	139	100	84	1,3	36	8
B269A07000HP	7,000	.2756	139	100	84	1,3	36	8
B269A07145HP	7,145	.2813	153	111	94	1,3	36	8
B269A07500HP	7,500	.2953	153	112	95	1,4	36	8
B269A07541HP	7,541	.2969	153	112	95	1,4	36	8
B269A07700HP	7,700	.3031	153	113	96	1,4	36	8
B269A07800HP	7,800	.3071	153	113	95	1,5	36	8
B269A07938HP	7,938	.3125	153	114	96	1,5	36	8
B269A08000HP	8,000	.3150	153	114	96	1,5	36	8
B269A08100HP	8,100	.3189	185	136	116	1,5	40	10
B269A08200HP	8,200	.3228	185	136	116	1,5	40	10
B269A08334HP	8,334	.3281	185	137	117	1,6	40	10
B269A08433HP	8,433	.3320	185	137	117	1,6	40	10
B269A08500HP	8,500	.3346	185	137	117	1,6	40	10
B269A08600HP	8,600	.3386	185	138	118	1,6	40	10
B269A08700HP	8,700	.3425	185	138	118	1,6	40	10
B269A08733HP	8,733	.3438	185	138	117	1,6	40	10
B269A09000HP	9,000	.3543	185	139	118	1,7	40	10
B269A09100HP	9,100	.3583	185	139	118	1,7	40	10
B269A09129HP *	9,129	.3594	185	139	118	1,7	40	10
B269A09500HP	9,500	.3740	185	140	119	1,8	40	10
B269A09525HP	9,525	.3750	185	140	119	1,8	40	10
B269A09800HP	9,800	.3858	185	141	119	1,8	40	10
B269A09921HP	9,921	.3906	185	142	120	1,9	40	10
B269A10000HP	10,000	.3937	185	142	120	1,9	40	10
B269A10200HP	10,200	.4016	218	164	140	1,9	45	12
B269A10300HP	10,300	.4055	218	165	141	1,9	45	12
B269A10320HP	10,320	.4063	218	165	141	1,9	45	12
B269A10400HP	10,400	.4094	218	165	141	1,9	45	12
B269A10500HP	10,500	.4134	218	165	141	2,0	45	12
B269A10716HP	10,716	.4219	218	166	142	2,0	45	12
B269A10800HP	10,800	.4252	218	166	141	2,0	45	12
B269A11000HP	11,000	.4331	218	167	142	2,1	45	12
B269A11113HP	11,113	.4375	218	167	142	2,1	45	12
B269A11200HP	11,200	.4409	218	167	142	2,1	45	12

(continued)

(B269_HP • ~12 x D — continued)



● first choice
○ alternate choice

extra long • KCPK15	D1 diameter mm	D1 diameter in	L	L3	L4 max	L5	LS	D
B269A11500HP	11,500	.4528	218	168	143	2,1	45	12
B269A11800HP	11,800	.4646	218	169	143	2,2	45	12
B269A12000HP	12,000	.4724	218	170	144	2,2	45	12
B269A12100HP	12,100	.4764	246	192	164	2,3	45	14
B269A12200HP	12,200	.4803	246	192	164	2,3	45	14
B269A12304HP	12,304	.4844	246	193	165	2,3	45	14
B269A12500HP	12,500	.4921	246	193	165	2,3	45	14
B269A12700HP	12,700	.5000	246	194	166	2,4	45	14
B269A13000HP	13,000	.5118	246	195	166	2,4	45	14
B269A13100HP	13,100	.5157	246	195	166	2,4	45	14
B269A13500HP	13,500	.5315	246	196	167	2,5	45	14
B269A13800HP *	13,800	.5433	246	197	168	2,6	45	14
B269A14000HP	14,000	.5512	246	198	168	2,6	45	14
B269A14100HP *	14,100	.5551	277	220	188	2,6	48	16
B269A14288HP	14,288	.5625	277	220	188	2,7	48	16
B269A14500HP	14,500	.5709	277	221	189	2,7	48	16
B269A14600HP *	14,600	.5748	277	221	189	2,7	48	16
B269A14684HP	14,684	.5781	277	222	190	2,7	48	16
B269A15000HP	15,000	.5906	277	223	190	2,8	48	16
B269A15200HP *	15,200	.5984	277	223	190	2,8	48	16
B269A15500HP	15,500	.6102	277	224	191	2,9	48	16
B269A15875HP	15,875	.6250	277	225	192	3,0	48	16
B269A16000HP	16,000	.6299	277	226	192	3,0	48	16
B269A16500HP	16,500	.6496	305	249	213	3,1	48	18
B269A17000HP	17,000	.6693	305	250	214	3,2	48	18
B269A17100HP	17,100	.6732	305	251	214	3,2	48	18
B269A17463HP	17,463	.6875	305	252	215	3,2	48	18
B269A17500HP	17,500	.6890	305	252	215	3,3	48	18
B269A17600HP *	17,600	.6929	305	252	215	3,3	48	18
B269A18000HP	18,000	.7087	305	253	216	3,3	48	18
B269A18500HP	18,500	.7283	334	277	237	3,4	50	20
B269A18600HP *	18,600	.7323	334	277	237	3,5	50	20
B269A19000HP	19,000	.7480	334	278	238	3,5	50	20
B269A19050HP	19,050	.7500	334	279	239	3,5	50	20
B269A19500HP	19,500	.7677	334	280	239	3,6	50	20
B269A20000HP	20,000	.7874	334	281	240	3,7	50	20

NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Tolerance • Metric

nominal size range	D1 tolerance m7	D tolerance h6
>3–6	0,004/0,016	0,000/-0,008
>6–10	0,006/0,021	0,000/-0,009
>10–18	0,007/0,025	0,000/-0,011
>18–25,4	0,008/0,029	0,000/-0,013

HP Drills • B269_HP Series • Grade KCPK15™ • Through Coolant • Drill Diameters 3–20mm • Metric





Material Group		Cutting Speed — vc			Metric								
		Range — m/min			Recommended Feed Rate (f) by Diameter								
		min	Starting Value	max		3,0	4,0	6,0	8,0	10,0	12,0	16,0	20,0
P	0	110	**140**	170	mm/r	0,10–0,14	0,12–0,20	0,14–0,20	0,17–0,25	0,25–0,28	0,20–0,35	0,23–0,43	0,28–0,48
	1	100	**140**	150	mm/r	0,12–0,17	0,14–0,23	0,17–0,23	0,20–0,29	0,29–0,33	0,23–0,41	0,27–0,50	0,33–0,56
	2	70	**100**	110	mm/r	0,12–0,17	0,12–0,20	0,14–0,26	0,23–0,32	0,24–0,38	0,27–0,50	0,33–0,63	0,39–0,75
	3	70	**90**	110	mm/r	0,12–0,17	0,14–0,23	0,17–0,23	0,20–0,29	0,29–0,33	0,23–0,41	0,27–0,50	0,33–0,56
	4	60	**70**	90	mm/r	0,09–0,14	0,11–0,20	0,14–0,20	0,17–0,23	0,17–0,26	0,20–0,33	0,23–0,41	0,26–0,45
	5	60	**80**	90	mm/r	0,03–0,11	0,04–0,11	0,05–0,11	0,05–0,14	0,08–0,18	0,11–0,21	0,14–0,24	0,16–0,26
	6	80	**150**	160	mm/r	0,07–0,13	0,11–0,11	0,12–0,20	0,15–0,28	0,17–0,33	0,19–0,37	0,22–0,43	0,25–0,48
M	1	50	**60**	80	mm/r	0,04–0,08	0,06–0,13	0,08–0,16	0,10–0,18	0,12–0,20	0,13–0,22	0,15–0,24	0,18–0,28
	2	40	**50**	80	mm/r	0,04–0,08	0,06–0,13	0,08–0,16	0,10–0,18	0,12–0,20	0,13–0,22	0,15–0,24	0,18–0,28
	3	40	**50**	70	mm/r	0,03–0,07	0,05–0,10	0,06–0,14	0,08–0,16	0,10–0,18	0,12–0,20	0,14–0,22	0,16–0,26
K	1	90	**150**	150	mm/r	0,10–0,15	0,14–0,20	0,20–0,30	0,22–0,36	0,26–0,42	0,30–0,45	0,36–0,59	0,40–0,72
	2	80	**120**	120	mm/r	0,10–0,15	0,14–0,20	0,20–0,30	0,22–0,36	0,26–0,42	0,30–0,45	0,36–0,59	0,40–0,72
	3	80	**80**	140	mm/r	0,11–0,15	0,15–0,21	0,22–0,32	0,22–0,39	0,26–0,45	0,28–0,50	0,30–0,60	0,34–0,72

Beyond™ HP Solid Carbide Deep-Hole Drills

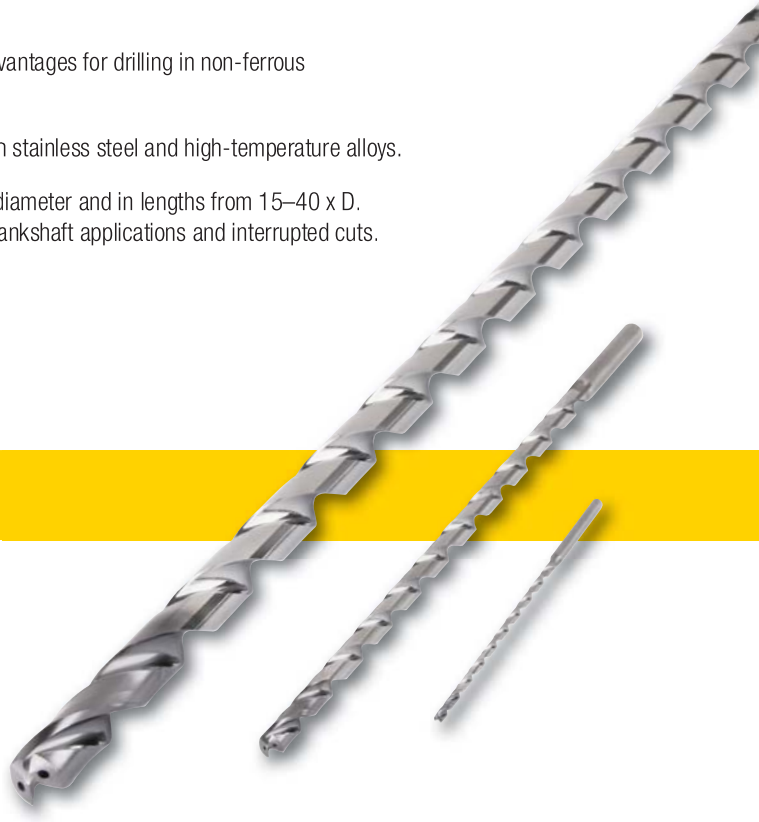
Primary Application

B27_HPG Series Solid Carbide Drills, made of the KCPK20™ grade, are the optimum platform for drilling holes up to 40 x D deep in steel and cast iron. The B27_HPG series drills deep holes up to 4x faster than conventional HSS and gun drills. The application of MQL is possible.

The B27_HPS in the new uncoated KN25™ grade offers the same advantages for drilling in non-ferrous materials, such as aluminium, copper, and brass.

The all new B27_SGL series is designed specifically for applications in stainless steel and high-temperature alloys.

The standard series is available from 2,383–16mm (.0938–.6299") diameter and in lengths from 15–40 x D. KMH-point geometry is available as a semi-standard, especially for crankshaft applications and interrupted cuts. Longer drills up to 550mm (21.65") are available as custom solution.



Features and Benefits

HP Drill-Point Design

- Low thrust.
- Excellent centring capabilities.
- Highest possible feed rates.

Four-Margin Lands

- Improves hole straightness.
- Improves hole alignment when drilling through cross holes.

Unique Flute Design

- The highly polished surface ensures superior chip evacuation even when low-pressure coolant or MQL is applied.
- Drastically improved chip evacuation.
- Better hole surface quality.

KCPK20 Grade (B27_HPG)

- An AlCrN-TiAlN based coating on the head of the drill provides outstanding wear resistance.
- New ultra-fine-grain carbide ensures process reliability at high feed rates.



Solid carbide deep-hole drills run up to 4x faster than conventional HSS and gun drills.

KN25™ Grade (B27_HPS)

- Sharp cutting edge enables higher tool life in aluminium and other non-ferrous materials.
- The uncoated grade helps to prevent built-up edge in drilling aluminium and high-temp alloys.

New KCMS20 Grade (B27_SGL)

- Monolayer PVD AlTiN coated ultra-fine grain carbide with superior surface finish.
- First choice for deep hole drilling of stainless steel and high-temperature resistant materials. Due to the coatings enhanced high temperature properties, this grade can also be applied for MQL applications in steel.

Customisation

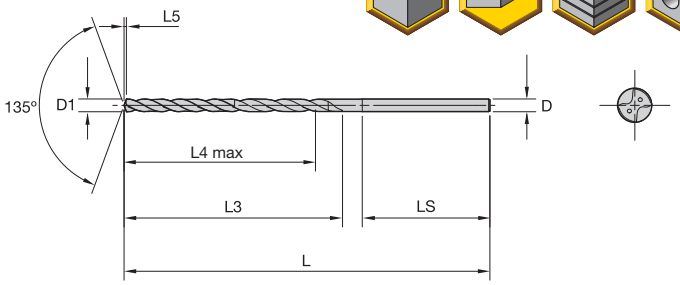
- Intermediate diameters available as semi-standards.
- Length variations, including even longer versions up to 550mm (21.65"), available as custom solutions.
- One-shot drilling of deep holes with a small step is possible.
- Maximum 2mm (.08") step range. Consult the custom solutions department for specific applications.
- Excellent surface finish and concentricity.







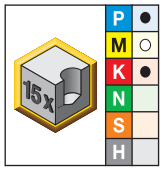


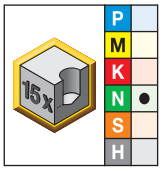


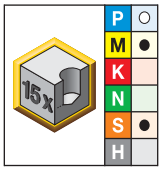
For information on L5, see B224_HP drills or B210_SGL drills.



B271Z_HPG/HPS/SGL • 15 x D





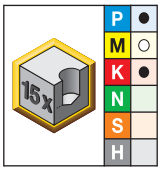


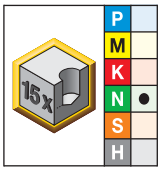
● first choice
○ alternate choice

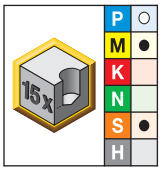
KCPK20	KN25	KCMS20	D1 diameter mm	D1 diameter in	L	L3	L4 max	LS	D
B271Z02383KMG	B271Z02383KMS	–	2,383	.0938	86	51	44	30	3
–	B271Z02400KMS	–	2,400	.0945	86	51	44	30	3
–	B271Z02439KMS	–	2,439	.0960	86	51	44	30	3
–	B271Z02489KMS	–	2,489	.0980	86	51	44	30	3
B271Z02500KMG	B271Z02500KMS	B271Z02500SGL	2,500	.0984	86	51	44	30	3
–	B271Z02578KMS	–	2,578	.1015	86	51	44	30	3
–	B271Z02600KMS	–	2,600	.1024	86	51	44	30	3
B271Z02642KMG	–	–	2,642	.1040	86	51	44	30	3
B271Z02705KMG	–	–	2,705	.1065	86	52	45	30	3
B271Z02779KMG	B271Z02779KMS *	–	2,779	.1094	86	52	45	30	3
–	B271Z02800KMS	–	2,800	.1102	86	52	45	30	3
B271Z02820KMG *	B271Z02820KMS *	–	2,820	.1110	86	52	45	30	3
–	B271Z02870KMS *	–	2,870	.1130	86	52	45	30	3
–	B271Z02900KMS	–	2,900	.1142	86	52	45	30	3
–	B271Z02947KMS *	–	2,947	.1160	86	52	45	30	3
B271Z03000HPG	B271Z03000HPS	B271Z03000SGL	3,000	.1181	86	52	45	30	3
B271Z03175HPG	B271Z03175HPS	B271Z03175SGL	3,175	.1250	105	67	58	32	4
B271Z03200HPG	B271Z03200HPS	–	3,200	.1260	105	67	58	32	4
B271Z03500HPG	B271Z03500HPS	B271Z03500SGL	3,500	.1378	105	68	59	32	4
B271Z03600HPG	–	–	3,600	.1417	105	68	59	32	4
B271Z03700HPG	–	–	3,700	.1457	105	69	60	32	4
B271Z03970HPG	B271Z03970HPS *	B271Z03970SGL	3,970	.1563	105	70	60	32	4
B271Z04000HPG	B271Z04000HPS	B271Z04000SGL	4,000	.1575	105	70	60	32	4
B271Z04500HPG	B271Z04500HPS	B271Z04500SGL	4,500	.1772	124	85	74	34	5
B271Z04623HPG	–	–	4,623	.1820	124	86	75	34	5
B271Z04763HPG	B271Z04763HPS	B271Z04763SGL	4,763	.1875	124	86	75	34	5
B271Z04800HPG	–	–	4,800	.1890	124	86	75	34	5
–	–	B271Z04800SGL	4,800	.1890	124	86	75	34	5
B271Z05000HPG	B271Z05000HPS	B271Z05000SGL	5,000	.1969	124	87	75	34	5
B271Z05060HPG	–	–	5,060	.1992	143	101	88	36	6
B271Z05260HPG	–	–	5,260	.2071	143	102	89	36	6
B271Z05410HPG	–	–	5,410	.2130	143	102	89	36	6
B271Z05500HPG	B271Z05500HPS	B271Z05500SGL	5,500	.2165	143	102	89	36	6
B271Z05558HPG	–	–	5,558	.2188	143	102	89	36	6
–	–	B271Z05558SGL	5,558	.2188	143	102	89	36	6
B271Z05800HPG	–	–	5,800	.2283	143	103	89	36	6
B271Z05900HPG	–	–	5,900	.2323	143	103	89	36	6
B271Z06000HPG	B271Z06000HPS	B271Z06000SGL	6,000	.2362	143	104	90	36	6
B271Z06200HPG	B271Z06200HPS	–	6,200	.2441	162	118	103	38	7
B271Z06350HPG	B271Z06350HPS	B271Z06350SGL	6,350	.2500	162	119	104	38	7

(continued)

(B271Z_HPG/HPS/SGL • 15 x D — continued)





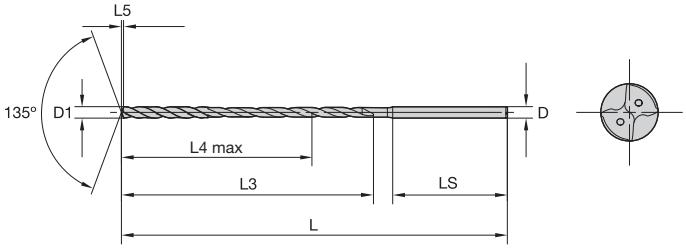


● first choice
○ alternate choice

KCPK20	KN25	KCMS20	D1 diameter mm	D1 diameter in	L	L3	L4 max	LS	D
B271Z06500HPG	B271Z06500HPS	B271Z06500SGL	6,500	.2559	162	119	104	38	7
B271Z06528HPG	—	—	6,528	.2570	162	119	104	38	7
B271Z06746HPG	B271Z06746HPS	B271Z06746SGL	6,746	.2656	162	120	104	38	7
B271Z06909HPG	—	—	6,909	.2720	162	121	105	38	7
B271Z07000HPG	B271Z07000HPS	B271Z07000SGL	7,000	.2756	162	121	105	38	7
B271Z07145HPG	B271Z07145HPS	B271Z07145SGL	7,145	.2813	181	135	118	40	8
B271Z07500HPG	B271Z07500HPS	B271Z07500SGL	7,500	.2953	181	136	119	40	8
B271Z07541HPG *	—	—	7,541	.2969	181	136	119	40	8
B271Z07938HPG	—	B271Z07938SGL	7,938	.3125	181	138	120	40	8
B271Z08000HPG	B271Z08000HPS	B271Z08000SGL	8,000	.3150	181	138	120	40	8
B271Z08200HPG	—	—	8,200	.3228	200	152	133	42	9
B271Z08334HPG	—	—	8,334	.3281	200	153	134	42	9
B271Z08500HPG	B271Z08500HPS	B271Z08500SGL	8,500	.3346	200	153	134	42	9
B271Z08733HPG	B271Z08733HPS	—	8,733	.3438	200	154	134	42	9
—	—	B271Z08733SGL	8,733	.3438	200	154	134	42	9
B271Z09000HPG	B271Z09000HPS	B271Z09000SGL	9,000	.3543	200	155	135	42	9
B271Z09100HPG	—	—	9,100	.3583	219	169	148	44	10
B271Z09200HPG *	—	—	9,200	.3622	219	169	148	44	10
B271Z09500HPG	B271Z09500HPS	—	9,500	.3740	219	170	149	44	10
B271Z09525HPG	B271Z09525HPS	B271Z09525SGL	9,525	.3750	219	170	149	44	10
B271Z09750HPG	—	—	9,750	.3839	219	171	149	44	10
B271Z10000HPG	B271Z10000HPS	B271Z10000SGL	10,000	.3937	219	172	150	44	10
B271Z10200HPG	B271Z10200HPS	—	10,200	.4016	238	186	163	46	11
—	—	B271Z10320SGL	10,320	.4063	238	187	164	46	11
B271Z10500HPG	B271Z10500HPS	B271Z10500SGL	10,500	.4134	238	187	164	46	11
B271Z10716HPG	—	—	10,716	.4219	238	188	165	46	11
—	B271Z10720HPS	—	10,720	.4220	238	188	165	46	11
B271Z10800HPG	—	—	10,800	.4252	238	188	164	46	11
B271Z11000HPG	B271Z11000HPS	B271Z11000SGL	11,000	.4331	238	189	165	46	11
—	—	B271Z11113SGL	11,113	.4375	257	203	178	48	12
B271Z11500HPG	B271Z11500HPS	B271Z11500SGL	11,500	.4528	257	204	179	48	12
B271Z12000HPG	B271Z12000HPS	B271Z12000SGL	12,000	.4724	257	206	180	48	12
B271Z12500HPG	B271Z12500HPS	—	12,500	.4921	276	221	194	50	13
B271Z12700HPG	B271Z12700HPS	B271Z12700SGL	12,700	.5000	276	222	195	50	13
B271Z13000HPG	B271Z13000HPS	—	13,000	.5118	276	223	195	50	13
B271Z13500HPG	B271Z13500HPS	—	13,500	.5315	295	238	209	52	14
B271Z14000HPG	B271Z14000HPS	B271Z14000SGL	14,000	.5512	295	240	210	52	14
B271Z14288HPG	—	—	14,288	.5625	314	255	224	54	15
—	B271Z14290HPS	—	14,290	.5626	314	255	224	54	15
B271Z14500HPG	—	B271Z14500SGL	14,500	.5709	314	255	224	54	15
B271Z15000HPG	—	B271Z15000SGL	15,000	.5906	314	257	225	54	15
B271Z15300HPG	—	—	15,300	.6024	333	272	239	56	16
—	B271Z15500HPS	—	15,500	.6102	333	272	239	56	16
—	B271Z15870HPS	—	15,870	.6248	333	273	240	56	16
B271Z15875HPG	—	—	15,875	.6250	333	273	240	56	16
B271Z16000HPG	B271Z16000HPS	B271Z16000SGL	16,000	.6299	333	274	240	56	16

NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

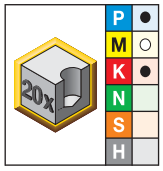


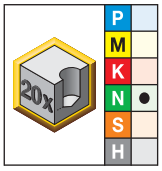


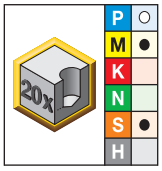
For information on L5, see B224_HP drills or B210_SGL drills.



B272Z_HPG/HPS/SGL • 20 x D







● first choice
○ alternate choice

KCPK20	KN25	KCMS20	D1 diameter mm	D1 diameter in	L	L3	L4 max	LS	D
B272Z02383KMG	B272Z02383KMS	–	2,383	.0938	101	63	56	30	3
B272Z02400KMG	B272Z02400KMS *	–	2,400	.0945	101	63	56	30	3
–	B272Z02439KMS	–	2,439	.0960	101	63	56	30	3
B272Z02489KMG	B272Z02489KMS *	–	2,489	.0980	101	63	56	30	3
B272Z02500KMG	B272Z02500KMS	B272Z02500SGL	2,500	.0984	101	63	56	30	3
B272Z02779KMG	–	–	2,779	.1094	101	66	59	30	3
–	B272Z02800KMS	–	2,800	.1102	101	66	59	30	3
–	B272Z02947KMS *	–	2,947	.1160	101	67	60	30	3
B272Z03000HPG	B272Z03000HPS	B272Z03000SGL	3,000	.1181	101	67	60	30	3
B272Z03175HPG	B272Z03175HPS	B272Z03175SGL	3,175	.1250	125	83	74	32	4
B272Z03300HPG	B272Z03300HPS	–	3,300	.1299	125	84	75	32	4
B272Z03500HPG	B272Z03500HPS	B272Z03500SGL	3,500	.1378	125	86	77	32	4
B272Z03850HPG	–	–	3,850	.1516	125	88	79	32	4
B272Z03970HPG	B272Z03970HPS	B272Z03970SGL	3,970	.1563	125	89	79	32	4
B272Z04000HPG	B272Z04000HPS	B272Z04000SGL	4,000	.1575	125	90	80	32	4
B272Z04500HPG	B272Z04500HPS	B272Z04500SGL	4,500	.1772	149	108	97	34	5
B272Z04623HPG	–	–	4,623	.1820	149	109	98	34	5
B272Z04763HPG	B272Z04763HPS	B272Z04763SGL	4,763	.1875	149	110	99	34	5
–	–	B272Z04800SGL	4,800	.1890	149	110	99	34	5
B272Z05000HPG	B272Z05000HPS	B272Z05000SGL	5,000	.1969	149	112	100	34	5
B272Z05200HPG	–	–	5,200	.2047	173	127	114	36	6
B272Z05260HPG	–	–	5,260	.2071	173	128	115	36	6
B272Z05410HPG	–	–	5,410	.2130	173	129	116	36	6
B272Z05500HPG	B272Z05500HPS	B272Z05500SGL	5,500	.2165	173	130	117	36	6
B272Z05558HPG	–	–	5,558	.2188	173	130	117	36	6
–	–	B272Z05558SGL	5,558	.2188	173	130	117	36	6
B272Z05800HPG	–	B272Z05800SGL	5,800	.2283	173	132	118	36	6
B272Z06000HPG	B272Z06000HPS	B272Z06000SGL	6,000	.2362	173	134	120	36	6
B272Z06200HPG	B272Z06200HPS	–	6,200	.2441	197	149	134	38	7
B272Z06350HPG	B272Z06350HPS	B272Z06350SGL	6,350	.2500	197	151	136	38	7
–	B272Z06400HPS *	–	6,400	.2520	197	151	136	38	7
B272Z06500HPG	B272Z06500HPS	B272Z06500SGL	6,500	.2559	197	152	137	38	7
B272Z06528HPG	–	–	6,528	.2570	197	152	137	38	7
B272Z06746HPG	B272Z06746HPS	B272Z06746SGL	6,746	.2656	197	154	138	38	7
B272Z06800HPG	–	–	6,800	.2677	197	154	138	38	7
B272Z06909HPG	–	–	6,909	.2720	197	155	139	38	7

(continued)

(B272Z_HPG/HPS/SGL • 20 x D — continued)





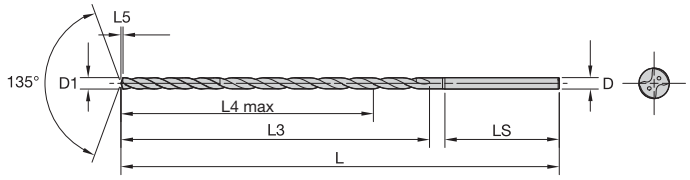


● first choice
○ alternate choice

KCPK20	KN25	KCMS20	D1 diameter mm	D1 diameter in	L	L3	L4 max	LS	D
B272Z07000HPG	B272Z07000HPS	B272Z07000SGL	7,000	.2756	197	156	140	38	7
B272Z07145HPG	B272Z07145HPS	B272Z07145SGL	7,145	.2813	221	171	154	40	8
B272Z07200HPG *	–	–	7,200	.2835	221	171	154	40	8
B272Z07500HPG	B272Z07500HPS	B272Z07500SGL	7,500	.2953	221	174	157	40	8
B272Z07541HPG *	–	–	7,541	.2969	221	174	157	40	8
B272Z07938HPG	–	B272Z07938SGL	7,938	.3125	221	177	159	40	8
B272Z08000HPG	B272Z08000HPS	B272Z08000SGL	8,000	.3150	221	178	160	40	8
B272Z08334HPG *	–	–	8,334	.3281	245	194	175	42	9
B272Z08433HPG	–	–	8,433	.3320	245	195	176	42	9
B272Z08500HPG	B272Z08500HPS	B272Z08500SGL	8,500	.3346	245	196	177	42	9
B272Z08733HPG	B272Z08733HPS	–	8,733	.3438	245	198	178	42	9
–	–	B272Z08733SGL	8,733	.3438	245	198	178	42	9
B272Z09000HPG	B272Z09000HPS	B272Z09000SGL	9,000	.3543	245	200	180	42	9
B272Z09100HPG *	–	–	9,100	.3583	269	215	194	44	10
B272Z09500HPG	–	–	9,500	.3740	269	218	197	44	10
B272Z09525HPG	B272Z09525HPS	B272Z09525SGL	9,525	.3750	269	218	197	44	10
B272Z09750HPG	B272Z09750HPS	–	9,750	.3839	269	220	198	44	10
B272Z10000HPG	B272Z10000HPS	B272Z10000SGL	10,000	.3937	269	222	200	44	10
B272Z10200HPG	B272Z10200HPS	–	10,200	.4016	293	237	214	46	11
–	–	B272Z10320SGL	10,320	.4063	293	238	215	46	11
B272Z10500HPG	B272Z10500HPS	B272Z10500SGL	10,500	.4134	293	240	217	46	11
B272Z10716HPG	–	–	10,716	.4219	293	242	219	46	11
–	–	B272Z10716SGL	10,716	.4219	293	242	219	46	11
–	B272Z10720HPS	–	10,720	.4220	293	242	219	46	11
B272Z11000HPG	B272Z11000HPS	B272Z11000SGL	11,000	.4331	293	244	220	46	11
–	–	B272Z11113SGL	11,113	.4375	317	259	234	48	12
B272Z11500HPG	B272Z11500HPS	B272Z11500SGL	11,500	.4528	317	262	237	48	12
B272Z11800HPG	–	–	11,800	.4646	317	264	238	48	12
B272Z12000HPG	B272Z12000HPS	B272Z12000SGL	12,000	.4724	317	266	240	48	12
B272Z12500HPG	B272Z12500HPS	B272Z12500SGL	12,500	.4921	341	284	257	50	13
B272Z12700HPG	B272Z12700HPS	B272Z12700SGL	12,700	.5000	341	285	258	50	13
B272Z13000HPG	B272Z13000HPS	B272Z13000SGL	13,000	.5118	341	288	260	50	13
B272Z13100HPG	–	–	13,100	.5157	365	302	273	52	14
B272Z13500HPG	B272Z13500HPS	–	13,500	.5315	365	306	277	52	14
B272Z14000HPG	B272Z14000HPS	B272Z14000SGL	14,000	.5512	365	310	280	52	14
B272Z14500HPG	B272Z14500HPS	B272Z14500SGL	14,500	.5709	389	328	297	54	15
B272Z15000HPG	B272Z15000HPS	B272Z15000SGL	15,000	.5906	389	332	300	54	15
B272Z15500HPG	B272Z15500HPS	B272Z15500SGL	15,500	.6102	413	350	317	56	16
–	B272Z15870HPS	–	15,870	.6248	413	353	320	56	16
B272Z15875HPG	–	–	15,875	.6250	413	353	320	56	16
B272Z16000HPG	B272Z16000HPS	B272Z16000SGL	16,000	.6299	413	354	320	56	16

NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

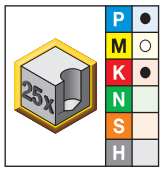


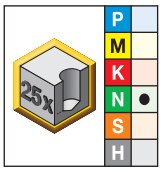


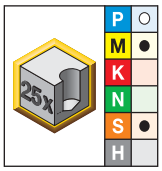
For information on L5, see B224_HP drills or B210_SGL drills.



B273Z_HPG/HPS/SGL • 25 x D





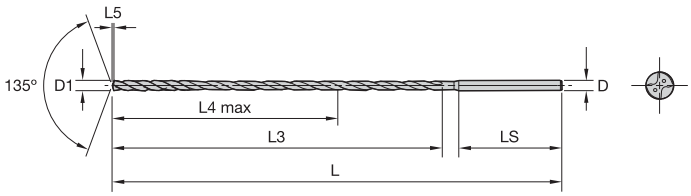


● first choice
○ alternate choice

KCPK20	KN25	KCMS20	D1 diameter mm	D1 diameter in	L	L3	L4 max	LS	D
B273Z02383KMG	B273Z02383KMS	–	2,383	.0938	116	74	67	30	3
–	B273Z02439KMS *	–	2,439	.0960	116	75	68	30	3
B273Z02500KMG	–	B273Z02500SGL	2,500	.0984	116	76	69	30	3
B273Z02600KMG *	–	–	2,600	.1024	116	77	70	30	3
–	B273Z02779KMS *	–	2,779	.1094	116	80	73	30	3
–	B273Z02800KMS *	–	2,800	.1102	116	80	73	30	3
–	B273Z02820KMS *	–	2,820	.1110	116	80	73	30	3
–	B273Z02870KMS *	–	2,870	.1130	116	81	74	30	3
–	B273Z02947KMS *	–	2,947	.1160	116	82	75	30	3
B273Z03000HPG	B273Z03000HPS	B273Z03000SGL	3,000	.1181	116	82	75	30	3
B273Z03175HPG	B273Z03175HPS	B273Z03175SGL	3,175	.1250	145	99	90	32	4
B273Z03500HPG *	B273Z03500HPS	B273Z03500SGL	3,500	.1378	145	103	94	32	4
B273Z04000HPG	B273Z04000HPS	B273Z04000SGL	4,000	.1575	145	110	100	32	4
B273Z04500HPG *	B273Z04500HPS *	B273Z04500SGL	4,500	.1772	174	130	119	34	5
B273Z05000HPG	B273Z05000HPS	B273Z05000SGL	5,000	.1969	174	137	125	34	5
B273Z05100HPG *	–	–	5,100	.2008	203	152	139	36	6
B273Z05500HPG	B273Z05500HPS	B273Z05500SGL	5,500	.2165	203	157	144	36	6
B273Z05800HPG *	–	–	5,800	.2283	203	161	147	36	6
B273Z06000HPG	B273Z06000HPS	B273Z06000SGL	6,000	.2362	203	164	150	36	6
B273Z06350HPG	B273Z06350HPS	–	6,350	.2500	232	182	167	38	7
B273Z06500HPG *	B273Z06500HPS	B273Z06500SGL	6,500	.2559	232	184	169	38	7
B273Z06746HPG	B273Z06746HPS *	–	6,746	.2656	232	187	171	38	7
B273Z07000HPG	B273Z07000HPS *	B273Z07000SGL	7,000	.2756	232	191	175	38	7
B273Z07500HPG	–	–	7,500	.2953	261	211	194	40	8
B273Z08000HPG	B273Z08000HPS	B273Z08000SGL	8,000	.3150	261	218	200	40	8
B273Z08500HPG	B273Z08500HPS *	B273Z08500SGL	8,500	.3346	290	238	219	42	9
B273Z08733HPG	B273Z08733HPS *	–	8,733	.3438	290	241	221	42	9
B273Z09000HPG	–	B273Z09000SGL	9,000	.3543	290	245	225	42	9
–	B273Z09525HPS *	–	9,525	.3750	319	266	245	44	10
B273Z10000HPG	B273Z10000HPS	B273Z10000SGL	10,000	.3937	319	272	250	44	10
B273Z10200HPG	–	–	10,200	.4016	348	288	265	46	11
B273Z10500HPG	B273Z10500HPS	–	10,500	.4134	348	292	269	46	11
B273Z11000HPG	B273Z11000HPS	B273Z11000SGL	11,000	.4331	348	299	275	46	11
B273Z11500HPG	B273Z11500HPS	–	11,500	.4528	377	319	294	48	12
B273Z12000HPG	B273Z12000HPS	B273Z12000SGL	12,000	.4724	377	326	300	48	12
B273Z12500HPG	B273Z12500HPS	–	12,500	.4921	406	346	319	50	13
B273Z12700HPG	–	–	12,700	.5000	406	349	322	50	13
B273Z13000HPG	B273Z13000HPS	B273Z13000SGL	13,000	.5118	406	353	325	50	13
–	B273Z13100HPS	–	13,100	.5157	435	368	339	52	14
B273Z13500HPG	–	B273Z13500SGL	13,500	.5315	435	373	344	52	14
B273Z14000HPG	B273Z14000HPS	B273Z14000SGL	14,000	.5512	435	380	350	52	14
B273Z14288HPG	–	–	14,288	.5625	464	397	366	54	15
–	B273Z14290HPS	–	14,290	.5626	464	397	366	54	15
B273Z14500HPG	B273Z14500HPS	–	14,500	.5709	464	400	369	54	15
B273Z15000HPG	–	B273Z15000SGL	15,000	.5906	464	407	375	54	15
B273Z16000HPG	B273Z16000HPS	B273Z16000SGL	16,000	.6299	493	434	400	56	16

NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

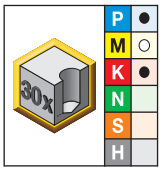


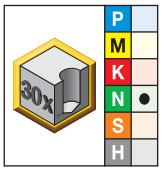


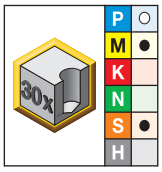
For information on L5, see B224_HP drills or B210_SGL drills.



B274Z_HPG/HPS/SGL • 30 x D





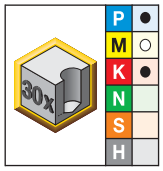


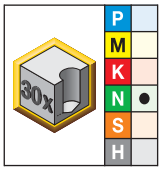
● first choice
○ alternate choice

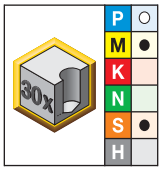
KCPK20	KN25	KCMS20	D1 diameter mm	D1 diameter in	L	L3	L4 max	LS	D
B274Z02383KMG	B274Z02383KMS	–	2,383	.0938	131	86	79	30	3
–	B274Z02400KMS	–	2,400	.0945	131	87	80	30	3
–	B274Z02439KMS *	–	2,439	.0960	131	87	80	30	3
B274Z02500KMG	B274Z02500KMS	B274Z02500SGL	2,500	.0984	131	88	81	30	3
B274Z02600KMG	B274Z02600KMS	–	2,600	.1024	131	90	83	30	3
–	B274Z02642KMS *	–	2,642	.1040	131	91	84	30	3
–	B274Z02779KMS *	–	2,779	.1094	131	94	87	30	3
B274Z02800KMG	B274Z02800KMS *	–	2,800	.1102	131	94	87	30	3
–	B274Z02870KMS *	–	2,870	.1130	131	95	88	30	3
–	B274Z02900KMS *	–	2,900	.1142	131	96	89	30	3
–	B274Z02947KMS *	–	2,947	.1160	131	97	90	30	3
B274Z03000HPG	B274Z03000HPS	B274Z03000SGL	3,000	.1181	131	97	90	30	3
B274Z03175HPG	B274Z03175HPS	B274Z03175SGL	3,175	.1250	165	115	106	32	4
B274Z03500HPG	B274Z03500HPS	B274Z03500SGL	3,500	.1378	165	121	112	32	4
B274Z03970HPG	–	B274Z03970SGL	3,970	.1563	165	129	119	32	4
B274Z04000HPG	B274Z04000HPS	B274Z04000SGL	4,000	.1575	165	130	120	32	4
B274Z04300HPG	–	–	4,300	.1693	199	149	138	34	5
B274Z04500HPG	B274Z04500HPS	B274Z04500SGL	4,500	.1772	199	153	142	34	5
B274Z04763HPG	–	B274Z04763SGL	4,763	.1875	199	157	146	34	5
B274Z05000HPG	B274Z05000HPS	B274Z05000SGL	5,000	.1969	199	162	150	34	5
B274Z05100HPG *	–	B274Z05100SGL	5,100	.2008	233	178	165	36	6
B274Z05500HPG	B274Z05500HPS *	B274Z05500SGL	5,500	.2165	233	185	172	36	6
–	–	B274Z05558SGL	5,558	.2188	233	186	173	36	6
B274Z05700HPG *	–	–	5,700	.2244	233	188	175	36	6
B274Z06000HPG	B274Z06000HPS	B274Z06000SGL	6,000	.2362	233	194	180	36	6
B274Z06350HPG	B274Z06350HPS	B274Z06350SGL	6,350	.2500	267	214	199	38	7
B274Z06500HPG	B274Z06500HPS	B274Z06500SGL	6,500	.2559	267	217	202	38	7
–	B274Z06746HPS *	B274Z06746SGL	6,746	.2656	267	221	205	38	7
B274Z06800HPG	–	–	6,800	.2677	267	222	206	38	7
B274Z07000HPG	B274Z07000HPS	B274Z07000SGL	7,000	.2756	267	226	210	38	7
–	–	B274Z07145SGL	7,145	.2813	301	242	225	40	8
–	–	B274Z07500SGL	7,500	.2953	301	249	232	40	8

(continued)

(B274Z_HPG/HPS/SGL • 30 x D — continued)





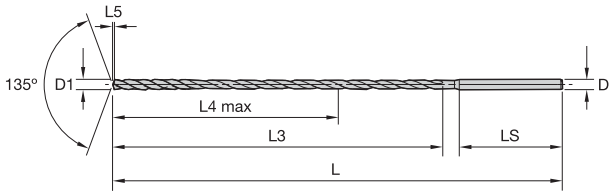


● first choice
○ alternate choice

KCPK20	KN25	KCMS20	D1 diameter mm	D1 diameter in	L	L3	L4 max	LS	D
B274Z07700HPG *	—	—	7,700	.3031	301	252	235	40	8
B274Z07938HPG	—	B274Z07938SGL	7,938	.3125	301	257	239	40	8
B274Z08000HPG	B274Z08000HPS	B274Z08000SGL	8,000	.3150	301	258	240	40	8
B274Z08334HPG	—	—	8,334	.3281	335	278	259	42	9
B274Z08500HPG	B274Z08500HPS	B274Z08500SGL	8,500	.3346	335	281	262	42	9
B274Z08700HPG	—	—	8,700	.3425	335	284	264	42	9
—	B274Z08733HPS *	—	8,733	.3438	335	285	265	42	9
—	—	B274Z08733SGL	8,733	.3438	335	285	265	42	9
B274Z09000HPG	B274Z09000HPS *	B274Z09000SGL	9,000	.3543	335	290	270	42	9
—	—	B274Z09129SGL	9,129	.3594	369	306	285	44	10
B274Z09525HPG	B274Z09525HPS *	B274Z09525SGL	9,525	.3750	369	313	292	44	10
B274Z10000HPG	B274Z10000HPS	B274Z10000SGL	10,000	.3937	369	322	300	44	10
B274Z10200HPG	B274Z10200HPS	—	10,200	.4016	403	339	316	46	11
B274Z10500HPG *	—	B274Z10500SGL	10,500	.4134	403	345	322	46	11
B274Z10716HPG	—	—	10,716	.4219	403	349	326	46	11
B274Z11000HPG	B274Z11000HPS	B274Z11000SGL	11,000	.4331	403	354	330	46	11
B274Z11500HPG	B274Z11500HPS	B274Z11500SGL	11,500	.4528	437	377	352	48	12
B274Z11800HPG	—	—	11,800	.4646	437	382	356	48	12
B274Z12000HPG	B274Z12000HPS	B274Z12000SGL	12,000	.4724	437	386	360	48	12
B274Z12500HPG	B274Z12500HPS	—	12,500	.4921	471	409	382	50	13
B274Z12700HPG	—	B274Z12700SGL	12,700	.5000	471	412	385	50	13
B274Z13000HPG	B274Z13000HPS	B274Z13000SGL	13,000	.5118	471	418	390	50	13
B274Z13500HPG	B274Z13500HPS	B274Z13500SGL	13,500	.5315	505	441	412	52	14
B274Z14000HPG	B274Z14000HPS	B274Z14000SGL	14,000	.5512	505	450	420	52	14
B274Z15000HPG	B274Z15000HPS	B274Z15000SGL	15,000	.5906	539	482	450	54	15

NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.



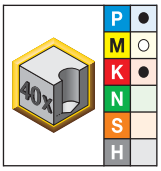


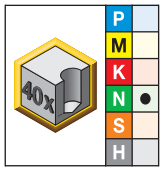
For information on L5, see B224_HP drills or B210_SGL drills.

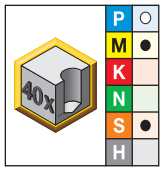


beyond

B275Z_HPG/HPS/SGL • 40 x D







● first choice
○ alternate choice

KCPK20	KN25	KCMS20	D1 diameter mm	D1 diameter in	L	L3	L4 max	LS	D
B275Z02500KMG	B275Z02500KMS	B275Z02500SGL	2,500	.0984	161	113	106	30	3
B275Z03000KMG	B275Z03000HPS	B275Z03000SGL	3,000	.1181	161	127	120	30	3
B275Z03175HPG	B275Z03175HPS	B275Z03175SGL	3,175	.1250	205	146	137	32	4
B275Z03500HPG	B275Z03500HPS	B275Z03500SGL	3,500	.1378	205	156	147	32	4
B275Z03571HPG	B275Z03571HPS	B275Z03571SGL	3,571	.1406	205	158	149	32	4
B275Z03970HPG	B275Z03970HPS	B275Z03970SGL	3,970	.1563	205	169	159	32	4
B275Z04000HPG	B275Z04000HPS	B275Z04000SGL	4,000	.1575	205	170	160	32	4
B275Z04200HPG	B275Z04200HPS	B275Z04200SGL	4,200	.1654	249	189	178	34	5
–	B275Z04500HPS	B275Z04500SGL	4,500	.1772	249	198	187	34	5
B275Z04763HPG	B275Z04763HPS	B275Z04763SGL	4,763	.1875	249	205	194	34	5
B275Z05000HPG	B275Z05000HPS	B275Z05000SGL	5,000	.1969	249	212	200	34	5
B275Z05500HPG	B275Z05500HPS	B275Z05500SGL	5,500	.2165	293	240	227	36	6
B275Z05558HPG	B275Z05558HPS	B275Z05558SGL	5,558	.2188	293	241	228	36	6
B275Z06000HPG	B275Z06000HPS	B275Z06000SGL	6,000	.2362	293	254	240	36	6
B275Z06350HPG	B275Z06350HPS	B275Z06350SGL	6,350	.2500	337	278	263	38	7
B275Z06500HPG	B275Z06500HPS	B275Z06500SGL	6,500	.2559	337	282	267	38	7
B275Z06800HPG	B275Z06800HPS	B275Z06800SGL	6,800	.2677	337	290	274	38	7
B275Z07000HPG	B275Z07000HPS	B275Z07000SGL	7,000	.2756	337	296	280	38	7
B275Z07145HPG	B275Z07145HPS	B275Z07145SGL	7,145	.2813	381	314	297	40	8
B275Z07500HPG	B275Z07500HPS	B275Z07500SGL	7,500	.2953	381	324	307	40	8
B275Z07938HPG	B275Z07938HPS	B275Z07938SGL	7,938	.3125	381	336	318	40	8
B275Z08000HPG	B275Z08000HPS	B275Z08000SGL	8,000	.3150	381	338	320	40	8
–	B275Z08500HPS	B275Z08500SGL	8,500	.3346	425	366	347	42	9
B275Z08733HPG	B275Z08733HPS	B275Z08733SGL	8,733	.3438	425	372	352	42	9
B275Z09000HPG	B275Z09000HPS	B275Z09000SGL	9,000	.3543	425	380	360	42	9
B275Z09525HPG	B275Z09525HPS	B275Z09525SGL	9,525	.3750	469	408	387	44	10
B275Z10000HPG	B275Z10000HPS	B275Z10000SGL	10,000	.3937	469	422	400	44	10
B275Z10200HPG	B275Z10200HPS	B275Z10200SGL	10,200	.4016	513	441	418	46	11
B275Z10320HPG	B275Z10320HPS	B275Z10320SGL	10,320	.4063	513	445	422	46	11
B275Z11000HPG	B275Z11000HPS	B275Z11000SGL	11,000	.4331	513	464	440	46	11

Tolerance • Metric

nominal size range	D1 HPG/SGL tolerance h7	D1 HPS tolerance h8	D tolerance h6
1–3	0,000/-0,010	0,000/-0,014	0,000/-0,006
>3–6	0,000/-0,012	0,000/-0,018	0,000/-0,008
>6–10	0,000/-0,015	0,000/-0,022	0,000/-0,009
>10–18	0,000/-0,018	0,000/-0,027	0,000/-0,011

Deep-Hole Drills • B27_HPG Series • Grade KCPK20™ • Through Coolant • Drill Diameters 3–16mm • Metric





Material Group		Cutting Speed – vc Range – m/min			Metric Recommended Feed Rate (f) by Diameter								
		min	Starting Value	max		3,0	4,0	6,0	8,0	10,0	12,0	14,0	16,0
P	0	100	**100**	125	mm/r	0,13–0,15	0,14–0,16	0,15–0,21	0,19–0,26	0,21–0,31	0,26–0,36	0,30–0,41	0,34–0,46
	1	90	**100**	110	mm/r	0,15–0,18	0,16–0,19	0,18–0,25	0,22–0,30	0,25–0,37	0,30–0,42	0,35–0,48	0,40–0,54
	2	90	**100**	110	mm/r	0,15–0,18	0,16–0,19	0,18–0,25	0,22–0,30	0,25–0,37	0,30–0,42	0,35–0,48	0,40–0,54
	3	80	**95**	110	mm/r	0,15–0,18	0,16–0,19	0,18–0,25	0,22–0,30	0,25–0,37	0,30–0,42	0,35–0,48	0,40–0,54
	4	80	**90**	110	mm/r	0,15–0,18	0,16–0,19	0,18–0,25	0,22–0,30	0,25–0,37	0,30–0,42	0,35–0,48	0,40–0,54
	5	60	**80**	90	mm/r	0,03–0,11	0,04–0,11	0,05–0,11	0,05–0,14	0,08–0,18	0,11–0,21	0,12–0,22	0,14–0,24
	6	110	**150**	190	mm/r	0,07–0,13	0,09–0,15	0,12–0,20	0,15–0,28	0,17–0,33	0,19–0,37	0,20–0,40	0,22–0,43
M	1	40	**50**	60	mm/r	0,04–0,08	0,06–0,12	0,08–0,14	0,10–0,15	0,11–0,16	0,12–0,17	0,13–0,18	0,14–0,19
	2	30	**40**	50	mm/r	0,04–0,08	0,06–0,10	0,08–0,13	0,09–0,14	0,10–0,15	0,11–0,16	0,12–0,17	0,13–0,18
	3	30	**40**	50	mm/r	0,04–0,07	0,06–0,10	0,08–0,13	0,09–0,14	0,10–0,15	0,11–0,16	0,12–0,17	0,13–0,18
K	1	80	**100**	120	mm/r	0,15–0,19	0,17–0,20	0,19–0,26	0,24–0,32	0,27–0,40	0,32–0,45	0,38–0,52	0,45–0,59
	2	80	**90**	100	mm/r	0,15–0,18	0,16–0,19	0,18–0,25	0,22–0,30	0,25–0,37	0,30–0,42	0,35–0,48	0,40–0,54
	3	60	**90**	120	mm/r	0,15–0,18	0,16–0,19	0,18–0,25	0,22–0,30	0,25–0,37	0,30–0,42	0,35–0,48	0,40–0,54

Deep-Hole Drills • B27_HPS Series • Grade KN25™ • Through Coolant • Drill Diameters 3–16mm • Metric



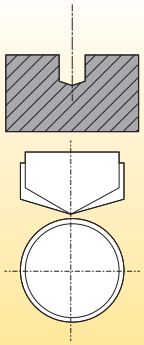


Material Group		Cutting Speed – vc Range – m/min			Metric Recommended Feed Rate (f) by Diameter								
		min	Starting Value	max		3,0	4,0	6,0	8,0	10,0	12,0	14,0	16,0
N	1	120	**200**	300	mm/r	0,12–0,17	0,13–0,18	0,15–0,24	0,19–0,29	0,26–0,35	0,31–0,40	0,35–0,45	0,41–0,51
	2	120	**170**	300	mm/r	0,13–0,18	0,14–0,19	0,16–0,25	0,20–0,30	0,28–0,37	0,33–0,42	0,38–0,48	0,44–0,54
	3	100	**150**	300	mm/r	0,13–0,18	0,14–0,19	0,16–0,25	0,20–0,30	0,28–0,37	0,33–0,42	0,38–0,48	0,44–0,54
	4	80	**200**	300	mm/r	0,03–0,05	0,03–0,06	0,03–0,06	0,04–0,06	0,05–0,07	0,05–0,08	0,05–0,08	0,06–0,09

Deep Hole Drills • B27_SGL Series • Grade KCMS20 • Through Coolant • Metric



Material Group		Cutting Speed — vc			Metric								
		Range — m/min			Recommended Feed Rate per Rev								
		min	Starting Value	max		3,0	4,0	6,0	8,0	10,0	12,0	14,0	16,0
P	5	60	**80**	90	mm/r	0,03–0,06	0,04–0,06	0,05–0,06	0,05–0,09	0,08–0,13	0,11–0,16	0,12–0,17	0,14–0,18
	6	70	**120**	170	mm/r	0,06–0,10	0,08–0,12	0,10–0,14	0,12–0,16	0,14–0,18	0,16–0,20	0,18–0,22	0,20–0,24
M	1	40	**50**	60	mm/r	0,05–0,08	0,06–0,09	0,07–0,10	0,08–0,11	0,09–0,12	0,10–0,13	0,11–0,14	0,12–0,15
	2	30	**40**	50	mm/r	0,05–0,08	0,06–0,09	0,07–0,10	0,08–0,11	0,09–0,12	0,10–0,13	0,11–0,14	0,12–0,15
	3	30	**40**	50	mm/r	0,05–0,08	0,06–0,09	0,07–0,10	0,08–0,11	0,09–0,12	0,10–0,13	0,11–0,14	0,12–0,15
S	1	20	**30**	40	mm/r	0,09–0,12	0,10–0,13	0,11–0,14	0,12–0,15	0,13–0,16	0,14–0,17	0,15–0,18	0,16–0,19
	2	20	**30**	40	mm/r	0,09–0,12	0,10–0,13	0,11–0,14	0,12–0,15	0,13–0,16	0,14–0,17	0,15–0,18	0,16–0,19
	3	20	**30**	40	mm/r	0,09–0,12	0,10–0,13	0,11–0,14	0,12–0,15	0,13–0,16	0,14–0,17	0,15–0,18	0,16–0,19
	4	20	**30**	40	mm/r	0,09–0,14	0,10–0,15	0,11–0,16	0,12–0,17	0,13–0,18	0,14–0,19	0,15–0,20	0,16–0,21

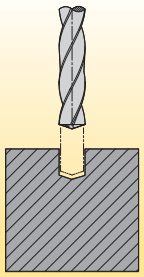


1) Pilot Drill Hole — IMPORTANT!

- The point angle of the pilot drill must be greater than the one of following deep-hole drill to protect its cutting corners.
- The diameter size of the pilot drill must be greater than the one of the deep-hole drill to enable easy fit and protect margin lands. The required difference in diameter is covered by design with the different position of tolerance.
- Drill Ø = nominal Ø up to nominal +0,010mm (+.0004").
- Depth of pilot hole: minimum 2 x D.
- Deeper pilot holes are preferable.

Recommendations:

- Use a conical (B976_) or split-point drill to pilot (do not use a HP, TX, GOdrill™ or any competitive drill).
- Check the pilot drill for wear, which can lead to premature wear on the B27_ cutting edge and possibly catastrophic failure.
- B976_ and B977_KC7315 drills with a 140° point angle are recommended. B978_ is not recommended as the point angle is 135°.
- B70_ Flat Bottom Drill with a point angle of 180° is the alternate choice, especially on inclined entries, such as on crankshafts.

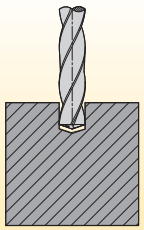


2) Feed B27_ into Pilot Hole

- Max 500 RPM and recommended feed rate; no rapid traverse.
- Run anti-clockwise, especially in horizontal applications to protect the cutting edge, when entering the pilot hole.
- Depth: 1mm (.039") above the bottom of pilot hole.

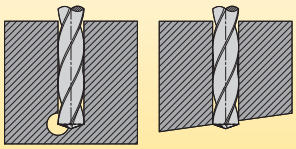
Recommendations:

- Reduce cutting speed to minimise imbalances in machine spindle/adaptor!



3) Drill Hole

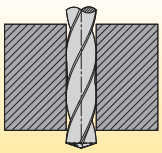
Cutting Parameters: Start recommended speed and feed rate at 1mm (.039") from the bottom of the pilot hole, clockwise.



Recommendations:

- DO NOT PECK OR DWELL up to 30 x D!
- With long-chipping steel materials, it may be necessary to increase feed rate by 10–20% to provide optimal chip control.
- For long-chipping aluminium materials, it may be necessary to decrease feed rate and increase speed.
- Reduce feed rate on angled exits and crossholes by 50–60%.

HP feed recommendations are usually higher than with competitive SC drills!



4) Drill Retraction

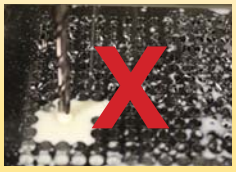
Cutting Parameters: 50–500 RPM and feed rate 2–6 m/min.

Recommendations:

To achieve the best tool performance, we recommend using the deep-hole drill with a hydraulic chuck.

Reduce cutting speed to minimise imbalances in machine spindle/adaptor!





5) Vertical Applications

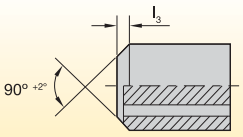
- If the pilot holes are close to each other, chips can fall into the neighboring hole.
- Do not enter a pilot hole that might contain chips with a deep hole drill to avoid chip jamming, wear, or breakage.
- If required holes are close to each other, use smart drilling strategies, make sure the pilot holes are getting properly cleaned, or switch to horizontal drilling.

Horizontal drilling process preferred for optimum chip evacuation



6) Coolant

- For increased stability, the coolant channels of the B27_ are smaller than on typical Kennametal drills.
- Steady supply of coolant delivered to the cutting edges necessary. If coolant supply is not steady or is unequal through both channels, check:
  - — Coolant filtering system.
  - — Sealing of adaptor/spindle.
  - — Chips blocking the coolant hole on the drill shank.
- Make sure that the coolant supply reaches the cutting edge before drilling begins.
- Pressure by diameter: <5mm 40–50 bar maximum; >5mm 25 bar minimum.



MQL back end according to DIN 69090-3

7) Minimal Quantity Lubrication

- On MQL applications, make sure that the coolant is directly supplied from the chuck into the back end of the drill shank (without gap) to avoid leakage.
- Pressure should be between 1–10 bar depending on coolant hole size.
- Spray contains an amount of oil less than 50 ml/h.
- If required, the shank can be even optimised for MQL applications with enlarged 90° chamfer instead of 40°.



8) Shanks

- Other than normal SC drills, B27_ series have a “Z” shank, increasing with 1mm steps.
- For drills with uneven shank size, use reduction sleeves to adapt the shank to the customer's toolholder.
- The clamping force is better with increasing diameter.
- If required, DIN-shanks (even, 2mm steps) are available as custom solutions.

Achieve the best tool performance with hydraulic chucks.

	12mm hydraulic reducer sleeve		20mm hydraulic reducer sleeve		25mm hydraulic reducer sleeve		32mm hydraulic reducer sleeve		.500" hydraulic reducer sleeve		.750" hydraulic reducer sleeve	
D1	order number	catalogue number	order number	catalogue number	order number	catalogue number	order number	catalogue number	order number	catalogue number	order number	catalogue number
3	3026450	12MHC030M	3026648	20MHC030M	3026662	25MHC030M	–	–	2248993	50HC030M	2248995	75HC030M
4	3026451	12MHC040M	3026649	20MHC040M	3026663	25MHC040M	–	–	1606050	50HC040M	2248996	75HC040M
5	3026452	12MHC050M	3026650	20MHC050M	3026664	25MHC050M	–	–	2248994	50HC050M	2248997	75HC050M
6	3026643	12MHC060M	3026651	20MHC060M	3026665	25MHC060M	3026675	32MHC060M	1606061	50HC060M	1093271	75HC060M
7	3026644	12MHC070M	3026652	20MHC070M	3026666	25MHC070M	3026676	32MHC070M	–	–	–	–
8	3026645	12MHC080M	3026653	20MHC080M	3026667	25MHC080M	3026677	32MHC080M	1606062	50HC080M	1093272	75HC080M
9	3026646	12MHC090M	3026654	20MHC090M	3026668	25MHC090M	3026678	32MHC090M	–	–	–	–
10	3026647	12MHC100M	3026655	20MHC100M	3026669	25MHC100M	3026679	32MHC100M	1606064	50HC100M	1093273	75HC100M
11	–	–	3026656	20MHC110M	–	–	3026680	32MHC110M	–	–	–	–
12	–	–	3026657	20MHC120M	3026669	25MHC120M	3026681	32MHC120M	–	–	1093524	75HC120M
13	–	–	3026658	20MHC130M	–	–	3026682	32MHC130M	–	–	–	–
14	–	–	3026659	20MHC140M	3026671	25MHC140M	3026683	32MHC140M	–	–	1093525	75HC140M
15	–	–	3026660	20MHC150M	–	–	3026684	32MHC150M	–	–	–	–
16	–	–	3026661	20MHC160M	3026672	25MHC160M	3026685	32MHC160M	–	–	1093526	75HC160M

HPS Beyond™ Drills for Aluminium Machining with MQL

Primary Application

B28_HPS series solid carbide drills offer the highest metal removal rates and longest tool life in aluminium and other non-ferrous materials when MQL is applied. These drills can also be used with standard through coolant.

By combining the HP-Point geometry and the new KN15™ Beyond grade with the new Kennametal polishing technology and unique flute design into one tool, the B28_HPS is the ultimate production tool for aluminium workpiece applications — even when compared to PCD solutions. This drill family is a differentiated high-end and high-performance alternative to commoditized conventional carbide or PCD straight-fluted drills.

Features and Benefits

HPS Drill-Point Design

- Sharp cutting edge enables higher tool life in aluminium and other non-ferrous materials.
- Low cutting forces and less built-up edge.
- HP-point enables high feed rates by progressive rake angle and excellent centring capabilities.

Enlarged Flute Design

- Enables fast chip evacuation and high metal removal rates.

KN15 Beyond Grade

- The highly polished surface ensures superior chip evacuation, even when MQL coolant is applied.
- Specified, uncoated 9% Co fine-grain carbide.

“D” Shank Optimised for MQL Applications

- Enlarged chamfer on back end according to DIN 69090-3 (round cylindrical for MQL) to ensure optimum coolant flow without leakage.

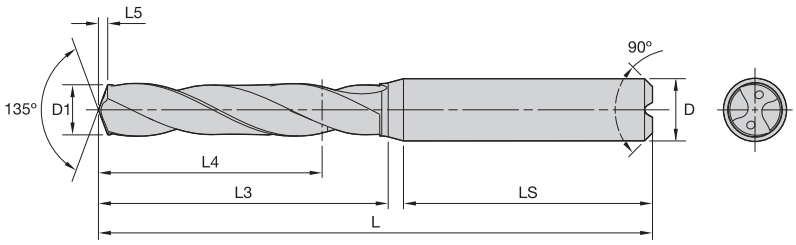
Much more cost-effective compared to PCD-tipped drills.



Customisation

- Intermediate diameters available as semi-standards.
- Length variations and step drills available as custom solutions.
- Using Kennametal MQL chucks together with standard B28_HPS is recommended.
- Optional coatings available for applications in aluminium with Si>9%, based on TiB_2 and DLC.

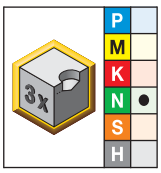


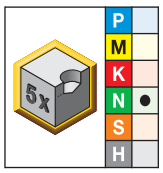


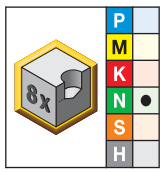


For information on L, L3, and L4 max, see the Solid Carbide Drills foldout table.

B284/B285/B286_HPS • ~3 x D/~5 x D/~8 x D





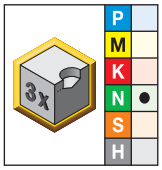


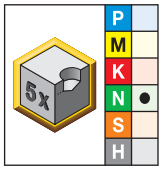
● first choice
○ alternate choice

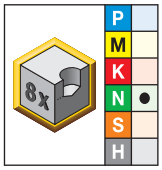
short • KN15	long • KN15	extra long • KN15	D1 diameter mm	D1 diameter in	L5	LS	D
B284D03000HPS	B285D03000HPS	B286D03000HPS	3,000	.1181	0,6	36	6
B284D03100HPS	B285D03100HPS	B286D03100HPS	3,100	.1220	0,6	36	6
B284D03175HPS	B285D03175HPS	B286D03175HPS	3,175	.1250	0,6	36	6
B284D03200HPS	B285D03200HPS	B286D03200HPS	3,200	.1260	0,6	36	6
B284D03264HPS	B285D03264HPS	B286D03264HPS	3,264	.1285	0,6	36	6
B284D03300HPS	B285D03300HPS	B286D03300HPS	3,300	.1299	0,6	36	6
B284D03455HPS	B285D03455HPS	B286D03455HPS	3,455	.1360	0,6	36	6
B284D03500HPS	B285D03500HPS	B286D03500HPS	3,500	.1378	0,6	36	6
B284D03571HPS	B285D03571HPS	B286D03571HPS	3,571	.1406	0,7	36	6
B284D03700HPS	B285D03700HPS	B286D03700HPS	3,700	.1457	0,7	36	6
B284D03734HPS	B285D03734HPS	B286D03734HPS	3,734	.1470	0,7	36	6
B284D03900HPS	B285D03900HPS	B286D03900HPS	3,900	.1535	0,7	36	6
B284D03970HPS	B285D03970HPS	B286D03970HPS	3,970	.1563	0,7	36	6
B284D04000HPS	B285D04000HPS	B286D04000HPS	4,000	.1575	0,7	36	6
B284D04039HPS	B285D04039HPS	B286D04039HPS	4,039	.1590	0,7	36	6
B284D04100HPS	B285D04100HPS	B286D04100HPS	4,100	.1614	0,8	36	6
B284D04200HPS	B285D04200HPS	B286D04200HPS	4,200	.1654	0,8	36	6
B284D04305HPS	B285D04305HPS	B286D04305HPS	4,305	.1695	0,8	36	6
B284D04366HPS	–	–	4,366	.1719	0,8	36	6
B284D04400HPS	B285D04400HPS	B286D04400HPS	4,400	.1732	0,8	36	6
B284D04500HPS	B285D04500HPS	B286D04500HPS	4,500	.1772	0,8	36	6
B284D04600HPS	B285D04600HPS	B286D04600HPS	4,600	.1811	0,8	36	6
B284D04700HPS	B285D04700HPS	B286D04700HPS	4,700	.1850	0,9	36	6
B284D04763HPS	B285D04763HPS	B286D04763HPS	4,763	.1875	0,9	36	6
B284D04800HPS	B285D04800HPS	B286D04800HPS	4,800	.1890	0,9	36	6
B284D04900HPS	B285D04900HPS	B286D04900HPS	4,900	.1929	0,9	36	6
B284D05000HPS	B285D05000HPS	B286D05000HPS	5,000	.1969	0,9	36	6
B284D05100HPS	B285D05100HPS	B286D05100HPS	5,100	.2008	0,9	36	6
B284D05106HPS	B285D05106HPS	B286D05106HPS	5,106	.2010	0,9	36	6
B284D05159HPS	B285D05159HPS	B286D05159HPS	5,159	.2031	1,0	36	6
B284D05200HPS	B285D05200HPS	B286D05200HPS	5,200	.2047	1,0	36	6
B284D05300HPS	B285D05300HPS	B286D05300HPS	5,300	.2087	1,0	36	6
B284D05400HPS	B285D05400HPS	B286D05400HPS	5,400	.2126	1,0	36	6
B284D05410HPS	B285D05410HPS	B286D05410HPS	5,410	.2130	1,0	36	6
B284D05500HPS	B285D05500HPS	B286D05500HPS	5,500	.2165	1,0	36	6
B284D05558HPS	B285D05558HPS	B286D05558HPS	5,558	.2188	1,0	36	6

(continued)

(B284/B285/B286_HPS • ~3 x D/~5 x D/~8 x D — continued)





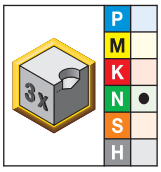


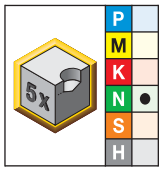
● first choice
○ alternate choice

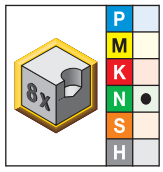
short • KN15	long • KN15	extra long • KN15	D1 diameter mm	D1 diameter in	L5	LS	D
B284D05600HPS	B285D05600HPS	B286D05600HPS	5,600	.2205	1,0	36	6
B284D05791HPS	B285D05791HPS	B286D05791HPS	5,791	.2280	1,1	36	6
B284D05800HPS	–	–	5,800	.2283	1,1	36	6
B284D05954HPS	–	–	5,954	.2344	1,1	36	6
B284D06000HPS	B285D06000HPS	B286D06000HPS	6,000	.2362	1,1	36	6
B284D06200HPS	B285D06200HPS	B286D06200HPS	6,200	.2441	1,1	36	8
B284D06300HPS	B285D06300HPS	B286D06300HPS	6,300	.2480	1,2	36	8
B284D06350HPS	B285D06350HPS	B286D06350HPS	6,350	.2500	1,2	36	8
B284D06400HPS	B285D06400HPS	B286D06400HPS	6,400	.2520	1,2	36	8
B284D06500HPS	B285D06500HPS	B286D06500HPS	6,500	.2559	1,2	36	8
B284D06528HPS	B285D06528HPS	B286D06528HPS	6,528	.2570	1,2	36	8
B284D06600HPS	B285D06600HPS	B286D06600HPS	6,600	.2598	1,2	36	8
B284D06630HPS	B285D06630HPS	B286D06630HPS	6,630	.2610	1,2	36	8
B284D06700HPS	B285D06700HPS	B286D06700HPS	6,700	.2638	1,2	36	8
B284D06746HPS	B285D06746HPS	B286D06746HPS	6,746	.2656	1,2	36	8
B284D06800HPS	B285D06800HPS	B286D06800HPS	6,800	.2677	1,3	36	8
B284D06900HPS	B285D06900HPS	B286D06900HPS	6,900	.2717	1,3	36	8
B284D07000HPS	B285D07000HPS	B286D07000HPS	7,000	.2756	1,3	36	8
B284D07145HPS	B285D07145HPS	B286D07145HPS	7,145	.2813	1,3	36	8
B284D07300HPS	B285D07300HPS	B286D07300HPS	7,300	.2874	1,3	36	8
B284D07400HPS	B285D07400HPS	B286D07400HPS	7,400	.2913	1,4	36	8
B284D07500HPS	–	–	7,500	.2953	1,4	36	8
B284D07541HPS	B285D07541HPS	B286D07541HPS	7,541	.2969	1,4	36	8
B284D07600HPS	B285D07600HPS	B286D07600HPS	7,600	.2992	1,4	36	8
B284D07700HPS	B285D07700HPS	B286D07700HPS	7,700	.3031	1,4	36	8
–	B285D07800HPS	–	7,800	.3071	1,4	36	8
B284D07938HPS	B285D07938HPS	B286D07938HPS	7,938	.3125	1,5	36	8
B284D08000HPS	B285D08000HPS	B286D08000HPS	8,000	.3150	1,5	36	8
B284D08334HPS	B285D08334HPS	B286D08334HPS	8,334	.3281	1,5	40	10
B284D08400HPS	B285D08400HPS	B286D08400HPS	8,400	.3307	1,6	40	10
B284D08433HPS	B285D08433HPS	B286D08433HPS	8,433	.3320	1,6	40	10
B284D08500HPS	B285D08500HPS	B286D08500HPS	8,500	.3346	1,6	40	10
B284D08700HPS	B285D08700HPS	B286D08700HPS	8,700	.3425	1,6	40	10
B284D08733HPS	B285D08733HPS	B286D08733HPS	8,733	.3438	1,6	40	10
B284D08800HPS	B285D08800HPS	B286D08800HPS	8,800	.3465	1,6	40	10
B284D08900HPS	B285D08900HPS	B286D08900HPS	8,900	.3504	1,6	40	10
B284D09000HPS	B285D09000HPS	B286D09000HPS	9,000	.3543	1,7	40	10
B284D09100HPS	B285D09100HPS	B286D09100HPS	9,100	.3583	1,7	40	10
B284D09129HPS	B285D09129HPS	B286D09129HPS	9,129	.3594	1,7	40	10
B284D09300HPS	B285D09300HPS	B286D09300HPS	9,300	.3661	1,7	40	10
B284D09400HPS	B285D09400HPS	B286D09400HPS	9,400	.3701	1,7	40	10
B284D09500HPS	B285D09500HPS	B286D09500HPS	9,500	.3740	1,8	40	10
B284D09525HPS	B285D09525HPS	B286D09525HPS	9,525	.3750	1,8	40	10
B284D09900HPS	B285D09900HPS	B286D09900HPS	9,900	.3898	1,8	40	10
B284D09921HPS	B285D09921HPS	B286D09921HPS	9,921	.3906	1,8	40	10
B284D10000HPS	B285D10000HPS	B286D10000HPS	10,000	.3937	1,8	40	10
B284D10100HPS	B285D10100HPS	B286D10100HPS	10,100	.3976	1,9	45	12
B284D10200HPS	B285D10200HPS	B286D10200HPS	10,200	.4016	1,9	45	12
B284D10300HPS	B285D10300HPS	B286D10300HPS	10,300	.4055	1,9	45	12
B284D10320HPS	B285D10320HPS	B286D10320HPS	10,320	.4063	1,9	45	12
B284D10500HPS	B285D10500HPS	B286D10500HPS	10,500	.4134	1,9	45	12
B284D10600HPS	B285D10600HPS	B286D10600HPS	10,600	.4173	2,0	45	12

(continued)

(B284/B285/B286_HPS • ~3 x D/~5 x D/~8 x D — continued)







● first choice
○ alternate choice

short • KN15	long • KN15	extra long • KN15	D1 diameter mm	D1 diameter in	L5	LS	D
B284D10716HPS	B285D10716HPS	B286D10716HPS	10,716	.4219	2,0	45	12
B284D10800HPS	B285D10800HPS	B286D10800HPS	10,800	.4252	2,0	45	12
B284D11000HPS	B285D11000HPS	B286D11000HPS	11,000	.4331	2,0	45	12
B284D11100HPS	B285D11100HPS	B286D11100HPS	11,100	.4370	2,0	45	12
B284D11113HPS	B285D11113HPS	B286D11113HPS	11,113	.4375	2,1	45	12
B284D11200HPS	B285D11200HPS	B286D11200HPS	11,200	.4409	2,1	45	12
B284D11300HPS	B285D11300HPS	B286D11300HPS	11,300	.4449	2,1	45	12
B284D11400HPS	B285D11400HPS	B286D11400HPS	11,400	.4488	2,1	45	12
B284D11500HPS	B285D11500HPS	B286D11500HPS	11,500	.4528	2,1	45	12
B284D11509HPS	B285D11509HPS	B286D11509HPS	11,509	.4531	2,1	45	12
B284D11800HPS	B285D11800HPS	B286D11800HPS	11,800	.4646	2,2	45	12
B284D11908HPS	B285D11908HPS	B286D11908HPS	11,908	.4688	2,2	45	12
B284D12000HPS	B285D12000HPS	B286D12000HPS	12,000	.4724	2,2	45	12
B284D12304HPS	B285D12304HPS	B286D12304HPS	12,304	.4844	2,3	45	14
B284D12500HPS	B285D12500HPS	B286D12500HPS	12,500	.4921	2,3	45	14
B284D12600HPS	B285D12600HPS	B286D12600HPS	12,600	.4961	2,3	45	14
B284D12700HPS	B285D12700HPS	B286D12700HPS	12,700	.5000	2,3	45	14
B284D13000HPS	B285D13000HPS	B286D13000HPS	13,000	.5118	2,4	45	14
B284D13096HPS	B285D13096HPS	B286D13096HPS	13,096	.5156	2,4	45	14
B284D13100HPS	B285D13100HPS	B286D13100HPS	13,100	.5157	2,4	45	14
B284D13300HPS	B285D13300HPS	B286D13300HPS	13,300	.5236	2,5	45	14
B284D13400HPS	B285D13400HPS	B286D13400HPS	13,400	.5276	2,5	45	14
B284D13500HPS	B285D13500HPS	B286D13500HPS	13,500	.5315	2,5	45	14
B284D14000HPS	B285D14000HPS	B286D14000HPS	14,000	.5512	2,6	45	14
B284D14200HPS	B285D14200HPS	B286D14200HPS	14,200	.5591	2,6	48	16
B284D14288HPS	B285D14288HPS	B286D14288HPS	14,288	.5625	2,6	48	16
B284D14500HPS	B285D14500HPS	B286D14500HPS	14,500	.5709	2,7	48	16
B284D14684HPS	B285D14684HPS	B286D14684HPS	14,684	.5781	2,7	48	16
B284D15000HPS	B285D15000HPS	B286D15000HPS	15,000	.5906	2,8	48	16
B284D15083HPS	B285D15083HPS	B286D15083HPS	15,083	.5938	2,8	48	16
B284D15100HPS	B285D15100HPS	B286D15100HPS	15,100	.5945	2,8	48	16
B284D15300HPS	B285D15300HPS	B286D15300HPS	15,300	.6024	2,8	48	16
B284D15400HPS	B285D15400HPS	B286D15400HPS	15,400	.6063	2,8	48	16
B284D15875HPS	B285D15875HPS	B286D15875HPS	15,875	.6250	2,9	48	16
B284D16000HPS	B285D16000HPS	B286D16000HPS	16,000	.6299	3,0	48	16
B284D16500HPS	B285D16500HPS	B286D16500HPS	16,500	.6496	3,0	48	18
B284D16670HPS	B285D16670HPS	B286D16670HPS	16,670	.6563	3,1	48	18
B284D16800HPS	B285D16800HPS	B286D16800HPS	16,800	.6614	3,1	48	18
B284D16900HPS	B285D16900HPS	B286D16900HPS	16,900	.6654	3,1	48	18
B284D17000HPS	B285D17000HPS	B286D17000HPS	17,000	.6693	3,1	48	18
B284D17300HPS	B285D17300HPS	B286D17300HPS	17,300	.6811	3,2	48	18
B284D17463HPS	B285D17463HPS	B286D17463HPS	17,463	.6875	3,2	48	18
B284D17500HPS	B285D17500HPS	B286D17500HPS	17,500	.6890	3,2	48	18
B284D17859HPS	B285D17859HPS	B286D17859HPS	17,859	.7031	3,3	48	18
B284D18000HPS	B285D18000HPS	B286D18000HPS	18,000	.7087	3,3	48	18
B284D19000HPS	B285D19000HPS	B286D19000HPS	19,000	.7480	3,5	50	20
B284D19050HPS	B285D19050HPS	B286D19050HPS	19,050	.7500	3,5	50	20
B284D20000HPS	B285D20000HPS	B286D20000HPS	20,000	.7874	3,7	50	20

Tolerance • Metric

nominal size range	D1 tolerance m7	D tolerance h6
>3–6	0,004/0,016	0,000/-0,008
>6–10	0,006/0,021	0,000/-0,009
>10–18	0,007/0,025	0,000/-0,011
>18–25,4	0,008/0,029	0,000/-0,013

HP Drills • B28_HPS Series • Grade KN15™ • MQL and Through Coolant • Drill Diameters 3–20mm • Metric



Material Group		Cutting Speed — vc			Metric								
		Range — m/min			Recommended Feed Rate (f) by Diameter								
		min	Starting Value	max		3,0	4,0	6,0	8,0	10,0	12,0	16,0	20,0
N	1	120	**230**	450	mm/r	0,13–0,25	0,14–0,29	0,17–0,35	0,21–0,42	0,27–0,50	0,33–0,57	0,37–0,69	0,43–0,82
	2	120	**220**	350	mm/r	0,14–0,23	0,15–0,28	0,17–0,34	0,22–0,39	0,29–0,46	0,34–0,54	0,39–0,67	0,45–0,80
	3	100	**180**	400	mm/r	0,13–0,20	0,14–0,21	0,16–0,27	0,20–0,33	0,28–0,40	0,33–0,45	0,38–0,60	0,44–0,68
	4	100	**130**	300	mm/r	0,10–0,18	0,12–0,20	0,14–0,26	0,16–0,30	0,18–0,34	0,20–0,38	0,24–0,42	0,28–0,46

Y-TECH™ Drills with Through Coolant for Difficult-to-Machine Materials

Primary Application

The B29_YPL series solid carbide drills are specifically engineered to drill stainless steel, high-temp alloys, and difficult-to-machine materials.

Y-TECH drills deliver best-in-class hole quality and longest tool life in these difficult-to-machine workpiece materials. Operate these drills with standard through coolant.

Features and Benefits

YPL Drill-Point Design

- Ensures good centring and chip formation.
- No jamming of chips and enables easy reconditioning.

Uneven Flute-to-Flute Angle

- Unbalanced forces by design eliminate chipping on margin lands.

Three-Margin Lands

- Reduce pendulum motion by directing forces towards third margin, which results in superior hole accuracy (cylindricity, constant diameter, and hole straightness).

KC7315™ Grade

- A multilayer, TiAlN-based coating with high hot hardness enables higher cutting speeds and outstanding wear resistance.
- Optimised surface finish of the tool ensures chip evacuation in high-speed drilling applications.

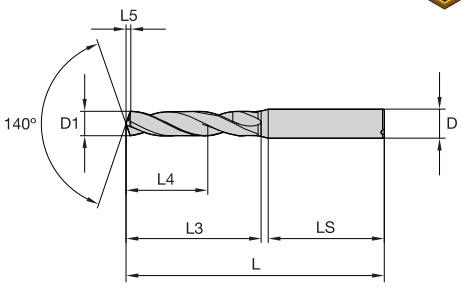
Y-TECH™ drills deliver best-in-class hole quality.

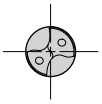


Customisation

- Intermediate diameters available as semi-standards.
- Length variations and step drills available as engineered solutions.
- Using Kennametal slim line hydraulic chucks together with standard B29_YPL is recommended if workpiece contours need to be bypassed.



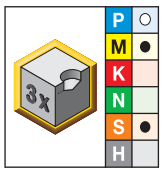


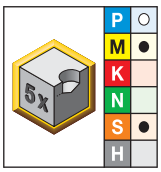




For information on L, L3, and L4 max, see the Solid Carbide Drills foldout table.

B291/B292_YPL • ~3 x D/~5 x D



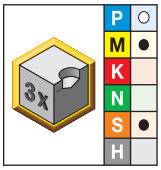


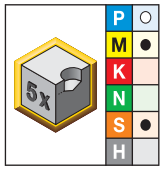
● first choice
○ alternate choice

short • KC7315	long • KC7315	D1 diameter mm	D1 diameter in	L5	LS	D
B291A03000YPL	B292A03000YPL	3,000	.1181	0,6	36	6
B291A03100YPL	B292A03100YPL	3,100	.1220	0,6	36	6
B291A03175YPL	B292A03175YPL	3,175	.1250	0,6	36	6
B291A03200YPL	B292A03200YPL	3,200	.1260	0,6	36	6
B291A03300YPL	B292A03300YPL	3,300	.1299	0,7	36	6
B291A03400YPL	B292A03400YPL	3,400	.1339	0,7	36	6
B291A03454YPL	–	3,454	.1360	0,7	36	6
B291A03500YPL	B292A03500YPL	3,500	.1378	0,7	36	6
B291A03600YPL	B292A03600YPL	3,600	.1417	0,7	36	6
B291A03700YPL	B292A03700YPL	3,700	.1457	0,7	36	6
B291A03800YPL	B292A03800YPL	3,800	.1496	0,8	36	6
B291A03900YPL	B292A03900YPL *	3,900	.1535	0,8	36	6
B291A03970YPL	B292A03970YPL	3,970	.1563	0,8	36	6
B291A04000YPL	B292A04000YPL	4,000	.1575	0,8	36	6
B291A04100YPL	B292A04100YPL	4,100	.1614	0,8	36	6
–	B292A04200YPL	4,200	.1654	0,8	36	6
B291A04300YPL	B292A04300YPL	4,300	.1693	0,8	36	6
B291A04400YPL	–	4,400	.1732	0,9	36	6
B291A04500YPL	B292A04500YPL	4,500	.1772	0,9	36	6
–	B292A04700YPL	4,700	.1850	0,9	36	6
B291A04763YPL	B292A04763YPL	4,763	.1875	0,9	36	6
B291A04800YPL	B292A04800YPL	4,800	.1890	0,9	36	6
B291A04851YPL	B292A04851YPL	4,851	.1910	0,9	36	6
B291A04900YPL	–	4,900	.1929	0,9	36	6
B291A04915YPL	B292A04915YPL	4,915	.1935	1,0	36	6
B291A05000YPL	B292A05000YPL	5,000	.1969	1,0	36	6
B291A05100YPL	B292A05100YPL	5,100	.2008	1,0	36	6
B291A05200YPL	B292A05200YPL	5,200	.2047	1,0	36	6
B291A05410YPL	B292A05410YPL	5,410	.2130	1,1	36	6
B291A05500YPL	B292A05500YPL	5,500	.2165	1,1	36	6
–	B292A05558YPL	5,558	.2188	1,1	36	6
B291A05600YPL	B292A05600YPL	5,600	.2205	1,1	36	6
–	B292A05800YPL	5,800	.2283	1,1	36	6
B291A05900YPL	–	5,900	.2323	1,1	36	6
B291A06000YPL	B292A06000YPL	6,000	.2362	1,2	36	6
B291A06200YPL	B292A06200YPL	6,200	.2441	1,2	36	8

(continued)

(B291/B292_YPL • ~3 x D/~5 x D — continued)



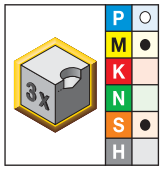


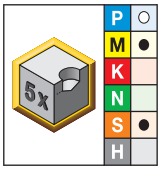
● first choice
○ alternate choice

short • KC7315	long • KC7315	D1 diameter mm	D1 diameter in	L5	LS	D
B291A06350YPL	B292A06350YPL	6,350	.2500	1,2	36	8
B291A06500YPL	B292A06500YPL	6,500	.2559	1,3	36	8
–	B292A06528YPL	6,528	.2570	1,3	36	8
–	B292A06600YPL	6,600	.2598	1,3	36	8
–	B292A06746YPL	6,746	.2656	1,3	36	8
B291A06747YPL	–	6,747	.2656	1,3	36	8
B291A06800YPL	B292A06800YPL	6,800	.2677	1,3	36	8
–	B292A06900YPL	6,900	.2717	1,3	36	8
B291A07000YPL	B292A07000YPL	7,000	.2756	1,4	36	8
–	B292A07100YPL	7,100	.2795	1,4	36	8
B291A07144YPL	–	7,144	.2813	1,4	36	8
–	B292A07145YPL	7,145	.2813	1,4	36	8
B291A07200YPL	B292A07200YPL	7,200	.2835	1,4	36	8
–	B292A07400YPL	7,400	.2913	1,4	36	8
B291A07500YPL	B292A07500YPL *	7,500	.2953	1,4	36	8
–	B292A07600YPL	7,600	.2992	1,5	36	8
–	B292A07900YPL	7,900	.3110	1,5	36	8
B291A07938YPL	B292A07938YPL	7,938	.3125	1,5	36	8
B291A08000YPL	B292A08000YPL	8,000	.3150	1,5	36	8
–	B292A08100YPL	8,100	.3189	1,6	40	10
–	B292A08200YPL	8,200	.3228	1,6	40	10
B291A08334YPL	B292A08334YPL *	8,334	.3281	1,6	40	10
–	B292A08433YPL	8,433	.3320	1,6	40	10
B291A08500YPL	B292A08500YPL	8,500	.3346	1,6	40	10
B291A08600YPL	B292A08600YPL	8,600	.3386	1,7	40	10
B291A08733YPL	B292A08733YPL	8,733	.3438	1,7	40	10
B291A08800YPL	B292A08800YPL	8,800	.3465	1,7	40	10
B291A08900YPL *	B292A08900YPL	8,900	.3504	1,7	40	10
B291A09000YPL	B292A09000YPL	9,000	.3543	1,7	40	10
B291A09129YPL	–	9,129	.3594	1,8	40	10
–	B292A09130YPL	9,130	.3594	1,8	40	10
–	B292A09200YPL	9,200	.3622	1,8	40	10
B291A09300YPL	–	9,300	.3661	1,8	40	10
–	B292A09347YPL	9,347	.3680	1,8	40	10
B291A09500YPL	B292A09500YPL	9,500	.3740	1,8	40	10
B291A09525YPL	B292A09525YPL	9,525	.3750	1,8	40	10
–	B292A09600YPL	9,600	.3780	1,8	40	10
B291A09700YPL	B292A09700YPL	9,700	.3819	1,9	40	10
B291A09800YPL	B292A09800YPL	9,800	.3858	1,9	40	10
B291A10000YPL	B292A10000YPL	10,000	.3937	1,9	40	10
–	B292A10100YPL	10,100	.3976	1,9	45	12
B291A10200YPL	B292A10200YPL	10,200	.4016	2,0	45	12
B291A10320YPL	B292A10320YPL	10,320	.4063	2,0	45	12
B291A10500YPL	B292A10500YPL	10,500	.4134	2,0	45	12
B291A10716YPL	B292A10716YPL	10,716	.4219	2,0	45	12
B291A11000YPL	B292A11000YPL	11,000	.4331	2,1	45	12
–	B292A11112YPL	11,112	.4375	2,1	45	12
B291A11113YPL	–	11,113	.4375	2,1	45	12
B291A11500YPL	B292A11500YPL *	11,500	.4528	2,2	45	12
B291A11509YPL	B292A11509YPL	11,509	.4531	2,2	45	12
B291A11800YPL	–	11,800	.4646	2,2	45	12
B291A11908YPL	B292A11908YPL	11,908	.4688	2,3	45	12

(continued)

(B291/B292_YPL • ~3 x D/~5 x D — continued)





● first choice
○ alternate choice

short • KC7315	long • KC7315	D1 diameter mm	D1 diameter in	L5	LS	D
B291A12000YPL	B292A12000YPL	12,000	.4724	2,3	45	12
B291A12300YPL	–	12,300	.4843	2,3	45	14
–	B292A12304YPL	12,304	.4844	2,3	45	14
B291A12500YPL	B292A12500YPL	12,500	.4921	2,4	45	14
B291A12700YPL	B292A12700YPL	12,700	.5000	2,4	45	14
B291A12900YPL	–	12,900	.5079	2,5	45	14
B291A13000YPL	B292A13000YPL	13,000	.5118	2,5	45	14
–	B292A13500YPL	13,500	.5315	2,6	45	14
B291A13800YPL	–	13,800	.5433	2,6	45	14
–	B292A13900YPL *	13,900	.5472	2,6	45	14
B291A14000YPL	B292A14000YPL	14,000	.5512	2,7	45	14
–	B292A14200YPL *	14,200	.5591	2,7	48	16
B291A14288YPL	B292A14288YPL	14,288	.5625	2,7	48	16
B291A14500YPL	B292A14500YPL	14,500	.5709	2,8	48	16
B291A15000YPL	B292A15000YPL	15,000	.5906	2,8	48	16
–	B292A15500YPL	15,500	.6102	2,9	48	16
–	B292A15600YPL	15,600	.6142	3,0	48	16
B291A15800YPL	–	15,800	.6220	3,0	48	16
B291A15875YPL	B292A15875YPL	15,875	.6250	3,0	48	16
B291A16000YPL	B292A16000YPL *	16,000	.6299	3,0	48	16
B291A16100YPL *	–	16,100	.6339	3,1	48	18
–	B292A16500YPL *	16,500	.6496	3,1	48	18
B291A17000YPL	B292A17000YPL *	17,000	.6693	3,2	48	18
B291A17463YPL	B292A17463YPL	17,463	.6875	3,3	48	18
B291A17500YPL *	B292A17500YPL *	17,500	.6890	3,3	48	18
B291A17900YPL *	–	17,900	.7047	3,4	48	18
B291A18000YPL	B292A18000YPL *	18,000	.7087	3,4	48	18
–	B292A18500YPL *	18,500	.7283	3,5	50	20
–	B292A19000YPL *	19,000	.7480	3,6	50	20
B291A19050YPL *	B292A19050YPL	19,050	.7500	3,6	50	20
B291A19800YPL	–	19,800	.7795	3,7	50	20
–	B292A20000YPL	20,000	.7874	3,8	50	20
–	B292A20500YPL *	20,500	.8071	3,9	50	20
–	B292A21000YPL *	21,000	.8268	4,0	50	20

NOTE: YPL drills are designed specifically for high-temp alloys, duplex stainless steels, and other difficult-to-machine materials.
*Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Tolerance • Metric

nominal size range	D1 tolerance m7	D tolerance h6
>3–6	0,004/0,016	0,000/-0,008
>6–10	0,006/0,021	0,000/-0,009
>10–18	0,007/0,025	0,000/-0,011
>18–25,4	0,008/0,029	0,000/-0,013

Y-TECH™ Drill • B29_YPL Series • Grade KC7315™ • Through Coolant • Drill Diameters 3–20mm • Metric



Material Group		Cutting Speed — vc			Metric								
		Range — m/min			Recommended Feed Rate (f) by Diameter								
		min	Starting Value	max		3,0	4,0	6,0	8,0	10,0	12,0	16,0	20,0
P	5	45	65	80	mm/r	0,04–0,08	0,06–0,09	0,07–0,12	0,09–0,16	0,11–0,19	0,13–0,21	0,15–0,26	0,18–0,30
	6	50	60	90	mm/r	0,04–0,06	0,04–0,07	0,06–0,10	0,10–0,15	0,09–0,16	0,11–0,20	0,13–0,24	0,16–0,28
M	1	40	50	60	mm/r	0,07–0,11	0,08–0,12	0,13–0,17	0,14–0,21	0,14–0,21	0,17–0,23	0,19–0,25	0,22–0,27
	2	40	50	80	mm/r	0,07–0,11	0,07–0,12	0,08–0,17	0,13–0,21	0,14–0,22	0,17–0,23	0,19–0,25	0,22–0,27
	3	40	50	70	mm/r	0,04–0,06	0,04–0,07	0,04–0,07	0,05–0,08	0,06–0,09	0,06–0,10	0,06–0,10	0,07–0,11
S	1	15	20	30	mm/r	0,06–0,08	0,06–0,08	0,07–0,10	0,10–0,13	0,11–0,14	0,12–0,16	0,14–0,19	0,17–0,22
	2	20	20	30	mm/r	0,05–0,07	0,05–0,07	0,06–0,08	0,08–0,11	0,09–0,12	0,10–0,13	0,12–0,16	0,14–0,18
	3	25	30	50	mm/r	0,03–0,05	0,03–0,05	0,04–0,08	0,05–0,10	0,05–0,10	0,05–0,10	0,07–0,11	0,08–0,12
	4	30	30	50	mm/r	0,03–0,05	0,03–0,05	0,04–0,08	0,05–0,10	0,05–0,10	0,05–0,10	0,07–0,11	0,08–0,12
H	1	10	20	30	mm/r	0,01–0,03	0,02–0,03	0,02–0,04	0,02–0,05	0,04–0,07	0,06–0,09	0,07–0,10	0,08–0,11

TX Drills with Through Coolant for Close Tolerance Holes

Primary Application

B411 solid carbide drills have an X-shaped, free-cutting 130° point design and are designed for grey cast iron, nodular iron, and non-ferrous and aluminium alloy materials. Best suited for high-quality, close tolerance holes that require a very good surface finish.

Features and Benefits

Two Cutting Edges with Straight Flutes

- Precise shape of the hole even if used as platform for complex step drills.
- Can run into cored holes.

X-Shaped Drill Point

- Excellent centring capabilities.

Four-Margin Land Design

- Second set of cutting margin lands improves the surface quality.
- Achieve tight diameter tolerances.
- Can run through cross holes and exit on inclined surfaces.

Wear-Resistant Carbide KF1 Grade

- Long tool life in abrasive materials, such as cast iron and aluminium die-cast alloys.
- The uncoated grade KF1 helps to prevent built-up edge in drilling aluminium.

Best suited for high-quality, close tolerance holes that require a very good surface finish.

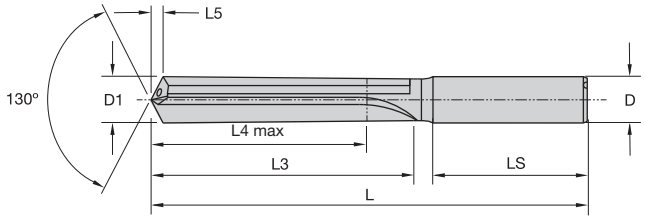


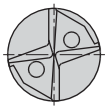
Customisation

- Intermediate diameters available as semi-standards.
- Length variations and step drills available as engineered solutions.
- Coated grades available for other material applications, such as cast iron.



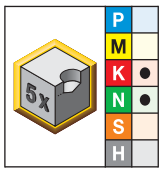








B411 • ~5 x D

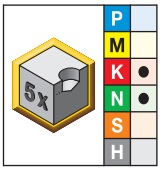


● first choice
○ alternate choice

KF1	D1 diameter mm	in	L	L3	L4 max	L5	LS	D
B411A03200	3,200	.1260	66	28	23	0,7	36	6
B411A03300	3,300	.1299	66	28	23	0,8	36	6
B411A03800	3,800	.1496	74	36	29	0,9	36	6
B411A04000	4,000	.1575	74	36	29	0,9	36	6
B411A04200	4,200	.1654	74	36	29	1,0	36	6
B411A04500	4,500	.1772	74	36	29	1,0	36	6
B411A04600	4,600	.1811	74	36	29	1,1	36	6
B411A04650	4,650	.1831	74	36	29	1,1	36	6
B411A04800	4,800	.1890	82	44	35	1,1	36	6
B411A04900	4,900	.1929	82	44	35	1,1	36	6
B411A05000	5,000	.1969	82	44	35	1,2	36	6
B411A05100	5,100	.2008	82	44	35	1,2	36	6
B411A05200	5,200	.2047	82	44	35	1,2	36	6
B411A05500	5,500	.2165	82	44	35	1,3	36	6
B411A05550	5,550	.2185	82	44	35	1,3	36	6
B411A05600	5,600	.2205	82	44	35	1,2	36	6
B411A05800	5,800	.2283	82	44	35	1,4	36	6
B411A06000	6,000	.2362	82	44	35	1,4	36	6
B411A06100	6,100	.2402	91	53	43	1,3	36	8
B411A06300	6,300	.2480	91	53	43	1,5	36	8
B411A06400	6,400	.2520	91	53	43	1,5	36	8
B411A06500	6,500	.2559	91	53	43	1,5	36	8
B411A06600	6,600	.2598	91	53	43	1,5	36	8
B411A06800	6,800	.2677	91	53	43	1,6	36	8
B411A07000	7,000	.2756	91	53	43	1,6	36	8
B411A07400	7,400	.2913	91	53	43	1,7	36	8
B411A07500	7,500	.2953	91	53	43	1,7	36	8
B411A07700 *	7,700	.3031	91	53	43	1,7	36	8
B411A07800	7,800	.3071	91	53	43	1,8	36	8
B411A08000	8,000	.3150	91	53	43	1,9	36	8
B411A08400	8,400	.3307	103	61	49	2,0	40	10
B411A08500	8,500	.3346	103	61	49	2,0	40	10
B411A08700	8,700	.3425	103	61	49	1,9	40	10
B411A08800	8,800	.3465	103	61	49	1,9	40	10
B411A09000	9,000	.3543	103	61	49	2,1	40	10
B411A09300	9,300	.3661	103	61	49	2,2	40	10

(continued)

(B411 • ~5 x D — continued)



● first choice
○ alternate choice

KF1	D1 diameter mm	D1 diameter in	L	L3	L4 max	L5	LS	D
B411A09500	9,500	.3740	103	61	49	2,2	40	10
B411A09800	9,800	.3858	103	61	49	2,3	40	10
B411A10000	10,000	.3937	103	61	49	2,3	40	10
B411A10200	10,200	.4016	118	71	56	2,4	45	12
B411A10500	10,500	.4134	118	71	56	2,4	45	12
B411A11000	11,000	.4331	118	71	56	2,6	45	12
B411A11200	11,200	.4409	118	71	56	2,6	45	12
B411A11500	11,500	.4528	118	71	56	2,7	45	12
B411A11800	11,800	.4646	118	71	56	2,8	45	12
B411A12000	12,000	.4724	118	71	56	2,8	45	12
B411A12500	12,500	.4921	124	77	60	2,9	45	14
B411A13000	13,000	.5118	124	77	60	3,0	45	14
B411A13500	13,500	.5315	124	77	60	3,1	45	14
B411A13800	13,800	.5433	124	77	60	3,2	45	14
B411A14000	14,000	.5512	124	77	60	3,3	45	14
B411A14500	14,500	.5709	133	83	63	3,4	48	16
B411A15000	15,000	.5906	133	83	63	3,5	48	16
B411A15500	15,500	.6102	133	83	63	3,6	48	16
B411A16000	16,000	.6299	133	83	63	3,7	48	16
B411A16500	16,500	.6496	143	93	71	3,8	48	18
B411A17000	17,000	.6693	143	93	71	4,0	48	18
B411A17500	17,500	.6890	143	93	71	4,1	48	18
B411A18000	18,000	.7087	143	93	71	4,2	48	18
B411A19000	19,000	.7480	153	101	77	4,4	50	20
B411A19500	19,500	.7677	153	101	77	4,5	50	20
B411A20000	20,000	.7874	153	101	77	4,7	50	20
B411A21000	21,000	.8268	167	114	85	4,9	50	20
B411A22000	22,000	.8661	167	114	85	5,1	50	20
B411A23000	23,000	.9055	184	126	98	5,4	56	25
B411A24000	24,000	.9449	184	126	98	5,6	56	25
B411A25000	25,000	.9843	184	126	98	5,8	56	25

NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Tolerance • Metric

nominal size range	D1 tolerance k6	D tolerance h6
>3–6	0,001/0,009	0,000/-0,008
>6–10	0,001/0,010	0,000/-0,009
>10–18	0,001/0,012	0,000/-0,011
>18–25,4	0,002/0,015	0,000/-0,013

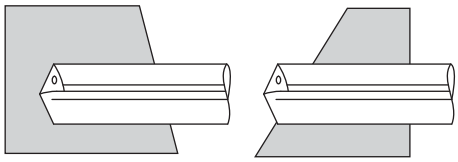
TX Drills • B411 Series • Grade KF1 • Through Coolant • Drill Diameters 3–25mm • Metric



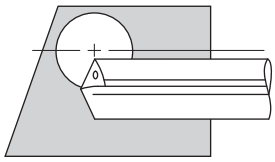
Material Group		Cutting Speed — vc Range — m/min			Metric Recommended Feed Rate (f) by Diameter									
		min	Starting Value	max		3,0	4,0	6,0	8,0	10,0	12,0	16,0	20,0	25,4
K	1	115	**120**	140	mm/r	0,11–0,20	0,12–0,24	0,15–0,28	0,18–0,33	0,20–0,38	0,23–0,44	0,30–0,53	0,34–0,65	0,40–0,76
N	1	100	**250**	450	mm/r	0,12–0,25	0,13–0,29	0,16–0,35	0,20–0,42	0,26–0,50	0,32–0,57	0,36–0,69	0,42–0,82	0,59–0,96
N	2	200	**250**	300	mm/r	0,13–0,21	0,14–0,26	0,16–0,32	0,20–0,37	0,27–0,44	0,32–0,52	0,38–0,64	0,44–0,78	0,60–0,96
N	3	100	**150**	300	mm/r	0,11–0,18	0,12–0,20	0,15–0,24	0,18–0,30	0,20–0,38	0,23–0,44	0,30–0,53	0,34–0,65	0,40–0,76
N	4	100	**170**	250	mm/r	0,10–0,16	0,12–0,20	0,14–0,26	0,16–0,28	0,18–0,32	0,20–0,36	0,22–0,40	0,24–0,44	0,28–0,50

TX Drill Applications

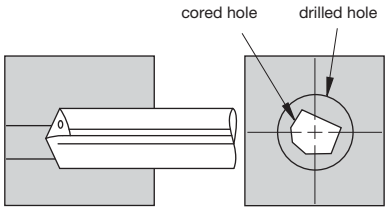
The excellent stability of the TX drill enables it to be used for drilling through inclined planes, intersecting holes, and cored holes:



inclined planes



intersecting holes



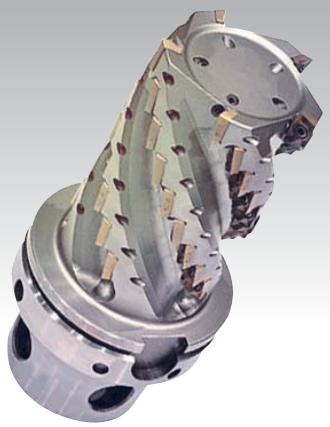
cored holes

Engineered Solutions

You Won't Find These Solutions in a Catalogue

Kennametal engineered solutions pinpoint and address specific needs of customers, workpiece materials, or workpiece configurations. Solutions include standard products, custom designs, and old-fashioned process know-how that can only come from many decades of tooling expertise.

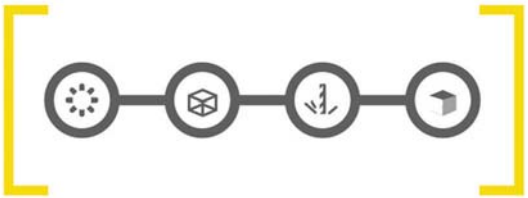
They are the result of coordinated global resources and are available anywhere in the world, no matter how small or large the project.



MANUFACTURING PROCESS

We Look at the Entire Production Process, Not Just Portions of It

From the machine tool to the last stop in production, we can optimise the manufacturing process throughout every step. The result is low implementation time and costs, and rapid return on investment.



SPF Drills for CFRP Composite Materials

Designed to machine carbon fibre-reinforced polymers.



Primary Application

B53_ SPF series solid carbide drills offer a material-specific design and grade to machine carbon fibre-reinforced polymer (CFRP) composite materials by minimising delamination and increasing tool life.

Features and Benefits

SPF Drill-Point Design

- Special 90° point angle increases centring capability.
- Low thrust and improved hole quality.



Unique Geometry

- Combination of point design, substrate, and coating provides longer tool life and requires substantially less cutting force.

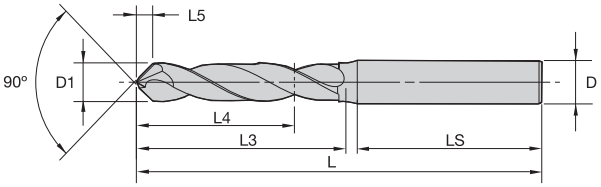
KDF400™ Grade

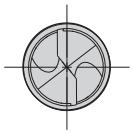
- CVD multilayer diamond coating provides more wear resistance and reduced friction, increasing tool life and improving chip flow.

Customisation

- Intermediate diameters available as semi-standards.
- Length variations and step drills available as engineered solutions.



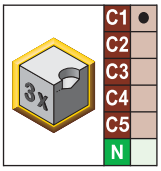


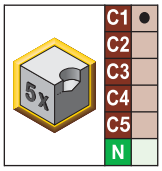




For information on L, L3, and L4 max, see the Solid Carbide Drills foldout table.

B531/B532_SPF • ~3 x D/~5 x D





● first choice
○ alternate choice

short • KDF400	long • KDF400	D1 diameter mm	D1 diameter in	L5	LS	D
B531A03200SPF	B532A03200SPF *	3,200	.1260	1,5	36	6
B531A03300SPF	B532A03300SPF *	3,300	.1299	1,5	36	6
B531A03600SPF	B532A03600SPF *	3,600	.1417	1,6	36	6
B531A04000SPF	–	4,000	.1575	1,8	36	6
B531A04366SPF *	B532A04366SPF *	4,366	.1719	2,0	36	6
B531A04851SPF	B532A04851SPF *	4,851	.1910	2,2	36	6
B531A04864SPF	–	4,864	.1915	2,2	36	6
B531A05100SPF *	B532A05100SPF	5,100	.2008	2,3	36	6
B531A05200SPF *	B532A05200SPF *	5,200	.2047	2,4	36	6
B531A06000SPF	B532A06000SPF	6,000	.2362	2,7	36	6
B531A06375SPF	B532A06375SPF *	6,375	.2510	2,9	36	8
B531A06400SPF	B532A06400SPF *	6,400	.2520	2,9	36	8
B531A06500SPF	B532A06500SPF *	6,500	.2559	3,0	36	8
–	B532A06700SPF *	6,700	.2638	3,0	36	8
–	B532A07200SPF	7,200	.2835	3,3	36	8
B531A07938SPF	B532A07938SPF *	7,938	.3125	3,6	36	8
B531A09550SPF	–	9,550	.3760	4,3	40	10
B531A09563SPF	B532A09563SPF *	9,563	.3765	4,3	40	10
B531A11125SPF *	–	11,125	.4380	5,1	45	12
B531A12725SPF	B532A12725SPF *	12,725	.5010	5,8	45	14

NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Tolerance • Metric

nominal size range	D1 tolerance m7	D tolerance h6
>3–6	0,004/0,016	0,000/-0,008
>6–10	0,006/0,021	0,000/-0,009
>10–18	0,007/0,025	0,000/-0,011
>18–25,4	0,008/0,029	0,000/-0,013

C1	CFRP, CFRP/CFRP
C2	CFRP/Aluminium
C3	CFRP/Titanium
C4	CFRP/Stainless Steel
C5	CFRP/Aluminium/Titanium

Application Data

SPF Drills • B53_ Series • Grade KDF400™ • Dry Applications • Drill Diameters 3–12mm • Metric





Material Group		Cutting Speed — vc Range — m/min min	Starting Value	max	Metric Recommended Feed Rate (f) by Diameter	3,0	4,0	6,0	8,0	10,0	12,0
C	1	90	120	150	mm/r	0,03–0,20	0,03–0,20	0,03–0,20	0,03–0,20	0,03–0,20	0,03–0,20

Drills for Machining of CFRP-Metal Stack Materials

Primary Application

The all new stack drill tackles CFRP-metal stack material drilling operations in diameter ranges of 4,763–15,875mm (3/16–5/8"). The drill can be applied in all combinations of stacks: CFRP-Ti-Al as well as CFRP-Ti, CFRP-Al, and also straight Ti or Al. Operate these drills with standard through coolant, MQL, or even dry.

The new Kennametal B55_DAL solid carbide drill provides excellent hole quality in combination with extended tool life, especially for customers in the aerospace industry who require the best hole quality and cost savings in an increasing number of applications with CFRP-Ti-stack materials.

The new Kennametal PDC251_ drill provides outstanding wear resistance and tool life. Thanks to the PCD tip, the PDC251_ drill withstands the most abrasive CFRP materials with high-fibre content. It is available in diameter ranges of 4,763–12,7mm (3/16–1/2"). Best performance is achieved with automated rigid machining devices. Additionally, multiple regrinds are possible.

Features and Benefits

Double-Angle Point Design

- Sharp cutting edge to cleanly cut CFRPs as top layer in CFRP-metal stacks.
- Bur-free when exiting metal side of stack.
- Excellent centring capabilities.

KN15™ Beyond™ Grade

- The highly polished surface ensures superior chip evacuation, even when MQL coolant is applied.
- The grade is a specified, uncoated 9% Co fine-grain carbide.

KD1415™ Grade

- Polycrystalline diamond grade for high wear resistance.
- Sufficient toughness for Ti- or Al-metal layers.



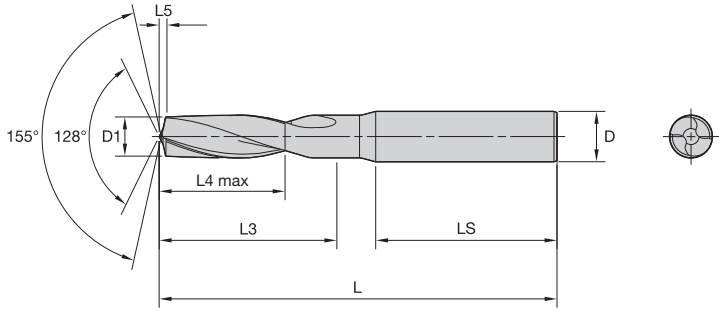
k6 Tolerance

- The drill diameter is ground to a k6 tolerance and can achieve hole tolerances of H8.

Customisation

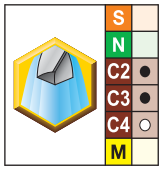
- Intermediate diameters available as semi-standards.
- Length variations and step drills, as well as shank variations, available as custom solutions for carbide and PCD versions.
- A four-margin land design for increased stability is available as semi-standard B54_DAL.







B551A_DAL • ~3 x D



● first choice
○ alternate choice

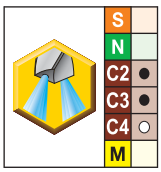
short • KN15	D1 diameter mm	D1 diameter in	L	L3	L4 max	L5	LS	D
B551A04763DAL *	4,763	.1875	66	28	20	0,8	36	6
B551A06350DAL	6,350	.2500	79	34	24	1,1	36	8
B551A07938DAL	7,938	.3125	79	41	29	1,4	36	8
B551A09525DAL	9,525	.3750	89	47	35	1,7	40	10
B551A11113DAL *	11,113	.4375	102	55	40	2,0	45	12
B551A12700DAL *	12,700	.5000	107	60	43	2,3	45	14
B551A14288DAL *	14,288	.5625	115	65	45	2,5	48	16
B551A15875DAL *	15,875	.6250	115	65	45	2,8	48	16

NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

DAL Drills • CFRP-Ti-Stacks • Through Coolant



B556A_DAL • ~3 x D



● first choice
○ alternate choice

short • KN15	D1 diameter mm	D1 diameter in	L	L3	L4 max	L5	LS	D
B556A04763DAL *	4,763	.1875	66	28	20	0,8	36	6
B556A04826DAL	4,826	.1900	66	28	20	0,9	36	6
B556A06350DAL	6,350	.2500	79	34	24	1,1	36	8
B556A06375DAL *	6,375	.2510	79	34	24	1,1	36	8
B556A07938DAL	7,938	.3125	79	41	29	1,4	36	8
B556A09525DAL *	9,525	.3750	89	47	35	1,7	40	10
B556A11113DAL *	11,113	.4375	102	55	40	2,0	45	12
B556A12700DAL *	12,700	.5000	107	60	43	2,3	45	14
B556A14288DAL *	14,288	.5625	115	65	45	2,5	48	16
B556A15875DAL *	15,875	.6250	115	65	45	2,8	48	16

NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Stack Drill • B551/B541 Series • Grade KN15™ • Dry • Drill Diameters 3–20mm • Metric



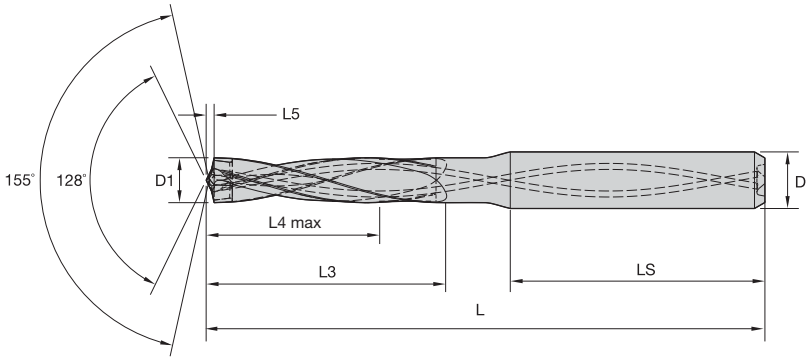
Material Group		Cutting Speed — vc Range — m/min			Metric Recommended Feed Rate (f) by Diameter								
		min	Starting Value	max		3,0	4,0	6,0	8,0	10,0	12,0	16,0	20,0
C	2	15	80	120	mm/r	0,01–0,05	0,02–0,07	0,03–0,10	0,04–0,12	0,05–0,15	0,05–0,18	0,06–0,21	0,07–0,23
	3	10	10	15	mm/r	0,01–0,05	0,02–0,07	0,03–0,10	0,04–0,12	0,05–0,15	0,05–0,18	0,06–0,21	0,07–0,23
	4	10	15	25	mm/r	0,01–0,05	0,02–0,07	0,03–0,10	0,04–0,12	0,05–0,15	0,05–0,18	0,06–0,21	0,07–0,23

Stack Drill • B556/B546 Series • Grade KN15 • Through Coolant • Drill Diameters 3–20mm • Metric



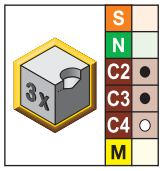
Material Group		Cutting Speed — vc Range — m/min			Metric Recommended Feed Rate (f) by Diameter								
		min	Starting Value	max		3,0	4,0	6,0	8,0	10,0	12,0	16,0	20,0
C	2	15	120	150	mm/r	0,01–0,05	0,02–0,07	0,03–0,10	0,04–0,12	0,05–0,15	0,05–0,18	0,06–0,21	0,07–0,23
	3	10	15	25	mm/r	0,01–0,05	0,02–0,07	0,03–0,10	0,04–0,12	0,05–0,15	0,05–0,18	0,06–0,21	0,07–0,23
	4	10	25	50	mm/r	0,01–0,05	0,02–0,07	0,03–0,10	0,04–0,12	0,05–0,15	0,05–0,18	0,06–0,21	0,07–0,23







PCD Twist Drill • PDC251 Series • ~3 x D



● first choice
○ alternate choice

KD1415	D1 diameter mm	in	L	L3	L4 max	L5	LS	D
PDC251A04763DA	4,7630	0.188	66	28	20	0,8	36	6
PDC251A06350DA	6,3500	0.250	79	34	24	1,1	36	8
PDC251A07938DA *	7,9380	0.313	79	41	29	1,4	36	8
PDC251A09525DA *	9,5250	0.375	89	47	35	1,7	40	10
PDC251A11113DA *	11,1130	0.438	102	55	40	2,0	45	12
PDC251A12700DA *	12,7000	0.500	107	60	43	2,3	45	14

NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Tolerance • Metric

nominal size range	D1 tolerance k6	D tolerance h6
>3–6	0,001/0,009	0,000/-0,008
>6–10	0,001/0,010	0,000/-0,009
>10–18	0,001/0,012	0,000/-0,011
>18–25,4	0,002/0,015	0,000/-0,013

C2	CFRP/Aluminium
C3	CFRP/Titanium
C4	CFRP/Stainless Steel

Stack Drill • PDC25 Series • Grade KD1415™ • Dry • Drill Diameters 3–20mm • Metric



Material Group		Cutting Speed — vc Range — m/min			Metric Recommended Feed Rate (f) by Diameter								
		min	Starting Value	max		3,0	4,0	6,0	8,0	10,0	12,0	16,0	20,0
C	2	15	80	120	mm/r	0,01–0,05	0,02–0,07	0,03–0,10	0,04–0,12	0,05–0,15	0,05–0,18	0,06–0,21	0,07–0,23
	3	10	10	15	mm/r	0,01–0,05	0,02–0,07	0,03–0,10	0,04–0,12	0,05–0,15	0,05–0,18	0,06–0,21	0,07–0,23
	4	10	15	25	mm/r	0,01–0,05	0,02–0,07	0,03–0,10	0,04–0,12	0,05–0,15	0,05–0,18	0,06–0,21	0,07–0,23

Stack Drill • PDC251 Series • Grade KD1415 • Through Coolant • Drill Diameters 3–20mm • Metric



Material Group		Cutting Speed — vc Range — m/min			Metric Recommended Feed Rate (f) by Diameter								
		min	Starting Value	max		3,0	4,0	6,0	8,0	10,0	12,0	16,0	20,0
C	2	15	120	150	mm/r	0,01–0,05	0,02–0,07	0,03–0,10	0,04–0,12	0,05–0,15	0,05–0,18	0,06–0,21	0,07–0,23
	3	10	15	25	mm/r	0,01–0,05	0,02–0,07	0,03–0,10	0,04–0,12	0,05–0,15	0,05–0,18	0,06–0,21	0,07–0,23
	4	10	25	50	mm/r	0,01–0,05	0,02–0,07	0,03–0,10	0,04–0,12	0,05–0,15	0,05–0,18	0,06–0,21	0,07–0,23

FB Drills with Through Coolant for Flat-Bottom Applications

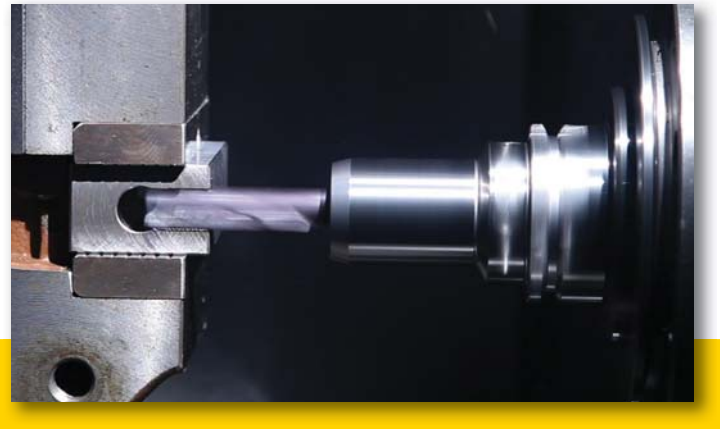
Primary Application

B707_FB series solid carbide drills are productivity tools that combine two operations in one:

1) Eliminate the 180° end mill in flat-bottom drilling or when preparing an inclined or curved surface for drilling.

2) After full cylindrical engagement, the drill runs at normal solid carbide drilling parameters.

The B707_FBS Series with the new uncoated KN15™ grade now offers the same advantages for drilling in non-ferrous materials, such as aluminium, copper, and brass. The 707_FBL Series is designed for applications in stainless steel and high-temperature alloys.



Features and Benefits

Unique FB Drill-Point Design

- Two effective cutting edges over centre enable high feed rates.
- Creates a true flat-bottom hole from O.D. to centre.
- Four-margin land design improves hole straightness and roundness and provides good alignment, even when drilling cross holes.

Straight Cutting Edge

- Guarantees a true 180° hole ground.
- Rake angle correction improves chip control.

KC7315™ Grade on B707_FBG

- Enables high drill-like penetration rates and superior tool life in steel and iron materials.

KN15 Grade on B707_FBS

- The uncoated grade prevents built-up edge reducing the risk of fracture.
- The highly polished surfaces ensure superior chip evacuation even when low-pressure coolant or MQL is applied.

KCMS15™ Grade on B707_FBL

- AlTiN-based PVD coating for the demands of stainless steels.
- Edge preparation with a light hone.

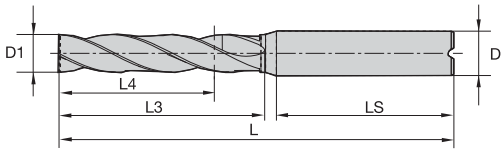
Productivity tools that combine two operations in one.

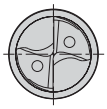


Customisation

- Intermediate diameters available as semi-standards.
- Length variations available as semi-standard:
  - B706_ 1.5 x D
  - B708_ 5 x D
  - B709_ 8 x D
- Other length variations and step drills are available as engineered solutions.

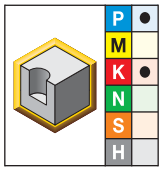


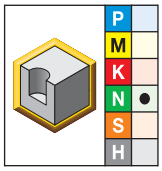


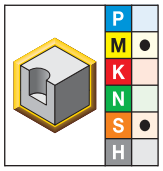




B707_FBG/FBS/FBL • ~3 x D





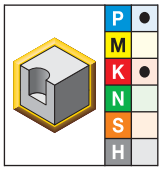


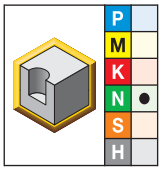
● first choice
○ alternate choice

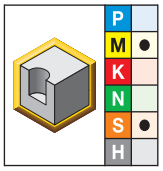
B707A-FBG • KC7315	B707A-FBS • KN15	B707A-FBL • KCMS15	D1 diameter mm	D1 diameter in	L	L3	L4 max	LS	D
B707A03000FBG	B707A03000FBS	B707A03000FBL	3,000	.1181	62	20	14	36	6
B707A03175FBG	B707A03175FBS	B707A03175FBL	3,175	.1250	62	20	14	36	6
B707A03500FBG	B707A03500FBS	B707A03500FBL	3,500	.1378	62	20	14	36	6
B707A03700FBG	–	–	3,700	.1457	62	20	14	36	6
–	–	B707A03800FBL	3,800	.1496	66	24	17	36	6
B707A03970FBG	–	–	3,970	.1563	66	24	17	36	6
B707A04000FBG	B707A04000FBS	B707A04000FBL	4,000	.1575	66	24	17	36	6
B707A04200FBG	B707A04200FBS	–	4,200	.1654	66	24	17	36	6
B707A04400FBG	B707A04400FBS	B707A04400FBL	4,400	.1732	66	24	17	36	6
B707A04500FBG	B707A04500FBS	B707A04500FBL	4,500	.1772	66	24	17	36	6
B707A04763FBG	–	–	4,763	.1875	66	28	20	36	6
B707A04800FBG	B707A04800FBS	B707A04800FBL	4,800	.1890	66	28	20	36	6
B707A04900FBG	B707A04900FBS *	–	4,900	.1929	66	28	20	36	6
B707A05000FBG	B707A05000FBS	B707A05000FBL	5,000	.1969	66	28	20	36	6
B707A05200FBG	–	–	5,200	.2047	66	28	20	36	6
B707A05560FBG	B707A05560FBS	B707A05560FBL	5,560	.2189	66	28	20	36	6
B707A05800FBG	–	–	5,800	.2283	66	28	20	36	6
B707A05900FBG	B707A05900FBS	B707A05900FBL	5,900	.2323	66	28	20	36	6
B707A06000FBG	B707A06000FBS	B707A06000FBL	6,000	.2362	66	28	20	36	6
B707A06100FBG	–	–	6,100	.2402	79	34	24	36	8
B707A06350FBG	B707A06350FBS	B707A06350FBL	6,350	.2500	79	34	24	36	8
B707A06500FBG	B707A06500FBS	B707A06500FBL	6,500	.2559	79	34	24	36	8
B707A06800FBG	B707A06800FBS	B707A06800FBL	6,800	.2677	79	34	24	36	8
B707A07000FBG	B707A07000FBS	B707A07000FBL	7,000	.2756	79	34	24	36	8
B707A07145FBG	–	–	7,145	.2813	79	41	29	36	8
–	B707A07400FBS	–	7,400	.2913	79	41	29	36	8
B707A07500FBG	B707A07500FBS	B707A07500FBL	7,500	.2953	79	41	29	36	8
B707A07800FBG	–	–	7,800	.3071	79	41	29	36	8
B707A07938FBG	B707A07938FBS	B707A07938FBL	7,938	.3125	79	41	29	36	8
B707A08000FBG	B707A08000FBS	B707A08000FBL	8,000	.3150	79	41	29	36	8
B707A08334FBG	–	–	8,334	.3281	89	47	35	40	10
B707A08500FBG	B707A08500FBS	B707A08500FBL	8,500	.3346	89	47	35	40	10

(continued)

(B707_FBG/FBS/FBL • ~3 x D — continued)







● first choice
○ alternate choice

B707A-FBG • KC7315	B707A-FBS • KN15	B707A-FBL • KCMS15	D1 diameter mm	D1 diameter in	L	L3	L4 max	LS	D
B707A08800FBG	B707A08800FBS	B707A08800FBL	8,800	.3465	89	47	35	40	10
B707A09000FBG	B707A09000FBS	B707A09000FBL	9,000	.3543	89	47	35	40	10
B707A09129FBG	–	–	9,129	.3594	89	47	35	40	10
B707A09500FBG	B707A09500FBS	B707A09500FBL	9,500	.3740	89	47	35	40	10
B707A09525FBG	B707A09525FBS	B707A09525FBL	9,525	.3750	89	47	35	40	10
B707A09800FBG	–	–	9,800	.3858	89	47	35	40	10
B707A10000FBG	B707A10000FBS	B707A10000FBL	10,000	.3937	89	47	35	40	10
B707A10200FBG	–	–	10,200	.4016	102	55	40	45	12
B707A10320FBG	B707A10320FBS	B707A10320FBL	10,320	.4063	102	55	40	45	12
B707A10500FBG	B707A10500FBS	B707A10500FBL	10,500	.4134	102	55	40	45	12
B707A10600FBG	–	–	10,600	.4173	102	55	40	45	12
B707A10800FBG	–	–	10,800	.4252	102	55	40	45	12
B707A11000FBG	B707A11000FBS	B707A11000FBL	11,000	.4331	102	55	40	45	12
B707A11111FBG	B707A11111FBS	B707A11111FBL	11,111	.4374	102	55	40	45	12
B707A11350FBG	–	–	11,350	.4469	102	55	40	45	12
B707A11509FBG	B707A11509FBS	B707A11509FBL	11,509	.4531	102	55	40	45	12
B707A11570FBG	B707A11570FBS *	B707A11570FBL	11,570	.4555	102	55	40	45	12
B707A11700FBG	B707A11700FBS	B707A11700FBL	11,700	.4606	102	55	40	45	12
B707A11800FBG	B707A11800FBS	B707A11800FBL	11,800	.4646	102	55	40	45	12
B707A11908FBG	–	–	11,908	.4688	102	55	40	45	12
B707A12000FBG	B707A12000FBS	B707A12000FBL	12,000	.4724	102	55	40	45	12
B707A12100FBG	B707A12100FBS	B707A12100FBL	12,100	.4764	107	60	43	45	14
B707A12500FBG	B707A12500FBS	B707A12500FBL *	12,500	.4921	107	60	43	45	14
B707A12600FBG *	–	–	12,600	.4961	107	60	43	45	14
B707A12700FBG	B707A12700FBS	B707A12700FBL	12,700	.5000	107	60	43	45	14
B707A12800FBG	B707A12800FBS	B707A12800FBL	12,800	.5039	107	60	43	45	14
B707A13000FBG	B707A13000FBS	B707A13000FBL	13,000	.5118	107	60	43	45	14
B707A13500FBG	B707A13500FBS	B707A13500FBL	13,500	.5315	107	60	43	45	14
B707A14000FBG	B707A14000FBS	B707A14000FBL	14,000	.5512	107	60	43	45	14
B707A14288FBG	B707A14288FBS	B707A14288FBL	14,288	.5625	115	65	45	48	16
B707A14500FBG	B707A14500FBS	B707A14500FBL	14,500	.5709	115	65	45	48	16
B707A15000FBG	B707A15000FBS	B707A15000FBL	15,000	.5906	115	65	45	48	16
B707A15250FBG	B707A15250FBS	B707A15250FBL *	15,250	.6004	115	65	45	48	16
B707A15500FBG	B707A15500FBS	B707A15500FBL	15,500	.6102	115	65	45	48	16
B707A15875FBG	B707A15875FBS	B707A15875FBL	15,875	.6250	115	65	45	48	16
B707A16000FBG	B707A16000FBS	B707A16000FBL	16,000	.6299	115	65	45	48	16
B707A16500FBG	B707A16500FBS	B707A16500FBL	16,500	.6496	123	73	51	48	18
B707A17000FBG	B707A17000FBS	B707A17000FBL	17,000	.6693	123	73	51	48	18
B707A17463FBG	–	–	17,463	.6875	123	73	51	48	18
B707A17500FBG	B707A17500FBS	B707A17500FBL	17,500	.6890	123	73	51	48	18
–	–	B707A17900FBL	17,900	.7047	123	73	51	48	18
B707A18000FBG	B707A18000FBS	B707A18000FBL	18,000	.7087	123	73	51	48	18
B707A18500FBG	–	–	18,500	.7283	131	79	55	50	20
B707A19000FBG	B707A19000FBS	B707A19000FBL *	19,000	.7480	131	79	55	50	20
B707A19050FBG	B707A19050FBS	B707A19050FBL *	19,050	.7500	131	79	55	50	20
B707A20000FBG	B707A20000FBS	B707A20000FBL	20,000	.7874	131	79	55	50	20
B707A21000FBG	B707A21000FBS	B707A21000FBL	21,000	.8268	141	86	60	50	20

NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Tolerance • Metric

nominal size range	D1 tolerance m7	D tolerance h6
>3–6	0,004/0,016	0,000/-0,008
>6–10	0,006/0,021	0,000/-0,009
>10–18	0,007/0,025	0,000/-0,011
>18–25,4	0,008/0,029	0,000/-0,013

Flat-Bottom Drills • B707_FBG Series • Grade KC7315™ • Through Coolant • Drill Diameters 3–20mm • Metric



Material Group		Cutting Speed — vc Range — m/min min	Starting Value	max	Metric Recommended Feed Rate (f) by Diameter	3,0	4,0	6,0	8,0	10,0	12,0	16,0	20,0
P	0	100	**133**	170	mm/r	0,06–0,14	0,10–0,17	0,09–0,20	0,11–0,25	0,18–0,28	0,14–0,31	0,16–0,37	0,19–0,42
	1	100	**133**	170	mm/r	0,07–0,16	0,12–0,20	0,10–0,23	0,13–0,29	0,21–0,33	0,17–0,37	0,19–0,44	0,22–0,49
	2	130	**150**	180	mm/r	0,07–0,13	0,10–0,16	0,16–0,19	0,13–0,23	0,18–0,27	0,17–0,30	0,19–0,35	0,22–0,39
	3	80	**106**	130	mm/r	0,09–0,16	0,13–0,20	0,13–0,23	0,16–0,24	0,20–0,31	0,21–0,37	0,25–0,44	0,28–0,46
	4	70	**98**	130	mm/r	0,08–0,16	0,12–0,19	0,11–0,22	0,14–0,27	0,21–0,31	0,18–0,35	0,21–0,41	0,24–0,46
	6	70	**98**	130	mm/r	0,07–0,12	0,10–0,14	0,10–0,16	0,12–0,20	0,16–0,23	0,16–0,26	0,18–0,31	0,21–0,34
K	1	70	**85**	100	mm/r	0,09–0,17	0,13–0,21	0,12–0,25	0,15–0,31	0,23–0,35	0,20–0,39	0,23–0,46	0,26–0,52
	2	100	**113**	130	mm/r	0,09–0,15	0,12–0,18	0,12–0,21	0,15–0,26	0,21–0,30	0,20–0,33	0,23–0,39	0,26–0,44
	3	70	**105**	140	mm/r	0,07–0,13	0,10–0,16	0,11–0,19	0,13–0,23	0,18–0,27	0,17–0,30	0,20–0,35	0,22–0,37

Flat-Bottom Drills • B707_FBS Series • Grade KN15™ • Through Coolant • Drill Diameters 3–20mm • Metric



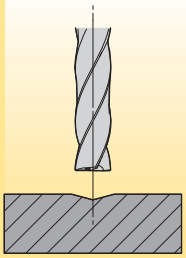
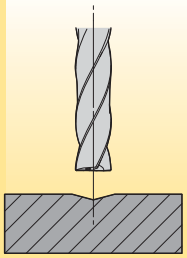
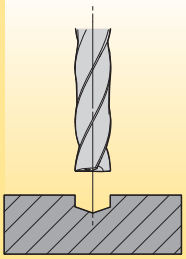
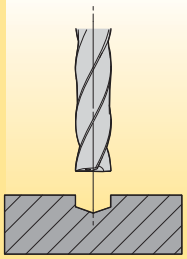
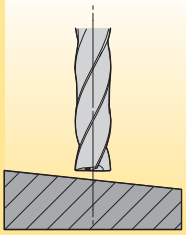
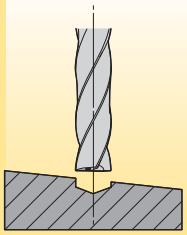
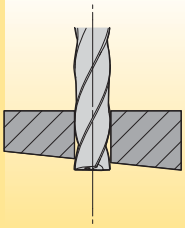
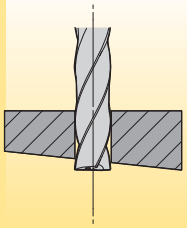
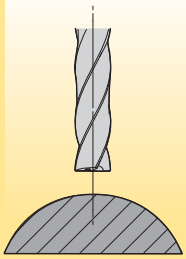
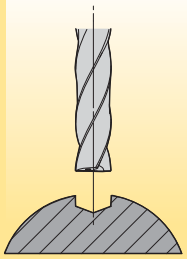
Material Group		Cutting Speed — vc Range — m/min min	Starting Value	max	Metric Recommended Feed Rate (f) by Diameter	3,0	4,0	6,0	8,0	10,0	12,0	16,0	20,0
N	1	120	**260**	400	mm/r	0,07–0,20	0,08–0,22	0,13–0,34	0,14–0,40	0,15–0,44	0,17–0,46	0,19–0,50	0,22–0,58
	2	120	**250**	280	mm/r	0,08–0,20	0,08–0,22	0,09–0,34	0,14–0,40	0,15–0,44	0,19–0,46	0,21–0,50	0,24–0,58
	3	100	**200**	260	mm/r	0,08–0,15	0,08–0,16	0,09–0,22	0,15–0,26	0,16–0,30	0,20–0,37	0,22–0,42	0,26–0,46
	4	60	**150**	200	mm/r	0,03–0,05	0,03–0,06	0,03–0,06	0,04–0,06	0,05–0,07	0,05–0,08	0,05–0,08	0,06–0,09

Flat-Bottom Drills • B707_FBL Series • Grade KCMS15™ • Through Coolant • Drill Diameters 3–20mm • Metric



Material Group		Cutting Speed — vc Range — m/min min	Starting Value	max	Metric Recommended Feed Rate (f) by Diameter	3,0	4,0	6,0	8,0	10,0	12,0	16,0	20,0
P	5	45	**50**	60	mm/r	0,04–0,08	0,05–0,09	0,06–0,12	0,09–0,15	0,10–0,16	0,12–0,20	0,14–0,23	0,16–0,24
	6	40	**50**	60	mm/r	0,03–0,06	0,04–0,07	0,04–0,10	0,08–0,12	0,09–0,14	0,10–0,16	0,12–0,18	0,14–0,20
M	1	40	**50**	60	mm/r	0,04–0,08	0,05–0,09	0,06–0,12	0,09–0,15	0,10–0,16	0,12–0,20	0,14–0,23	0,16–0,24
	2	40	**50**	80	mm/r	0,06–0,11	0,07–0,11	0,08–0,16	0,12–0,20	0,13–0,21	0,16–0,22	0,18–0,24	0,21–0,26
	3	40	**55**	70	mm/r	0,03–0,04	0,03–0,05	0,04–0,06	0,04–0,07	0,05–0,08	0,06–0,10	0,07–0,11	0,08–0,12
S	1	20	**25**	30	mm/r	0,06–0,08	0,06–0,08	0,07–0,10	0,10–0,13	0,10–0,14	0,12–0,16	0,14–0,19	0,17–0,22
	2	10	**20**	30	mm/r	0,05–0,07	0,05–0,07	0,06–0,08	0,08–0,11	0,09–0,12	0,10–0,13	0,12–0,16	0,14–0,18
	3	30	**35**	50	mm/r	0,03–0,05	0,03–0,05	0,04–0,08	0,05–0,10	0,05–0,10	0,05–0,10	0,07–0,11	0,08–0,12
	4	30	**35**	50	mm/r	0,03–0,05	0,03–0,05	0,04–0,08	0,05–0,10	0,05–0,10	0,05–0,10	0,07–0,11	0,08–0,12

The B707_FBG drill eliminates the traditional two-step process to create a flat-bottom hole using a drill and an end mill and can perform the operation 25–40% faster. It also eliminates the two-step process of using an end mill to pre-machine a flat on the workpiece material for inclined surfaces.

Workpiece Application	B707A..FBG Standard Length	B708/B709A..FBG Custom Long Length
• Tapped hole with lead chamfer larger than FBG diameter.	 No feed reduction.	 50% feed reduction.
• Nominal diameter pilot required.	 Rough or hardened surfaces. No feed reduction.	 Pilot on all surfaces. No feed reduction.
• >6° angled entrances.	 Reduce feed by 30% until full diameter, or use pilot.	 Pilot with short FBG on all surfaces. No feed reduction.
• Angled exits.	 30% feed reduction.	 30% feed reduction.
• Round surfaces.	 Reduce feed by 30% until full diameter, or use pilot.	 Pilot with short FBG on all surfaces. No feed reduction.

HP Beyond™ Step Drills with Through Coolant for Steel and Iron

Primary Application

Most tapped holes require a chamfer. The B731_HP and B732_HP step drills offer a one-pass solution in steels and irons in traditional tap sizes to reduce cycle time and increase productivity. An extensive range of step drills are available to cover taps products by Kennametal.

Features and Benefits

HP Drill-Point Design

- Low thrust prevents workpiece flexing.
- Excellent centring capabilities.

Unique Flute Design

- Drastically improved chip evacuation.
- Better hole surface quality.

KCPK15™ Beyond Grade

- The grade is a multilayer, TiAlN-based coating with high hot hardness. High cutting speeds enable usage in MQL applications.
- The highly polished surface ensures superior chip evacuation even when low-pressure coolant is applied.
- Improves average metal removal rate and tool life by 10–20%.

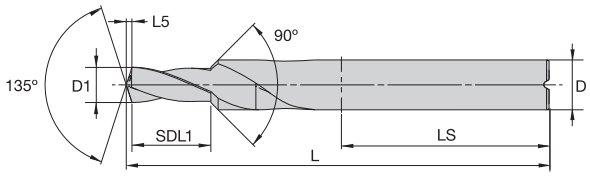
Drill and chamfer in one shot before tapping.

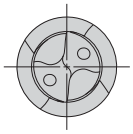


Customisation

- Intermediate diameters available as semi-standards.
- Using Kennametal Slim Line Hydraulic Chucks together is recommended if workpiece contours need to be bypassed.

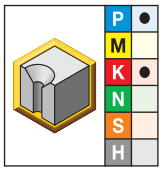








B731_HP • Short



● first choice
○ alternate choice

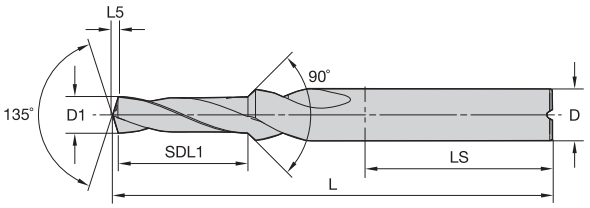
short • KCPK15	D1 diameter mm	D1 diameter in	L	SDL1	L5	LS	D
B731A03734HP	3,734	.1470	66	10	0,7	36	6
B731A04200HP	4,200	.1654	66	12	0,8	36	6
B731A04496HP	4,496	.1770	79	13	0,9	36	8
B731A05000HP	5,000	.1969	79	13	0,9	36	8
B731A05106HP	5,106	.2010	79	15	1,0	36	8
B731A05410HP	5,410	.2130	79	16	1,0	36	8
B731A06528HP	6,528	.2570	89	17	1,2	40	10
B731A06800HP	6,800	.2677	89	16	1,3	40	10
B731A06909HP	6,909	.2720	89	18	1,3	40	10
B731A07938HP	7,938	.3125	89	19	1,5	45	12
B731A08433HP	8,433	.3320	102	21	1,6	45	12
B731A08500HP	8,500	.3346	102	19	1,6	45	12
B731A09921HP	9,921	.3906	107	23	1,9	45	14
B731A10200HP	10,200	.4016	107	22	1,9	45	14
B731A10500HP	10,500	.4134	107	22	2,0	45	14
B731A10716HP	10,716	.4219	107	27	2,0	45	14
B731A12000HP	12,000	.4724	115	27	2,2	48	16
B731A12304HP *	12,304	.4844	115	28	2,3	48	16
B731A12500HP	12,500	.4921	115	27	2,3	48	16
B731A13096HP	13,096	.5156	115	31	2,4	48	16
B731A13495HP	13,495	.5313	123	32	2,5	48	18
B731A14000HP	14,000	.5512	123	29	2,6	48	18
B731A16670HP *	16,670	.6563	131	38	3,1	50	20
B731A17463HP	17,463	.6875	131	40	3,2	50	20
B731A19446HP *	19,446	.7656	153	43	3,6	56	25

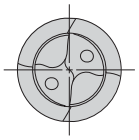
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Tolerance • Metric

nominal size range	D1 tolerance m7	D tolerance h6
>3–6	0,004/0,016	0,000/-0,008
>6–10	0,006/0,021	0,000/-0,009
>10–18	0,007/0,025	0,000/-0,011
>18–25,4	0,008/0,029	0,000/-0,013

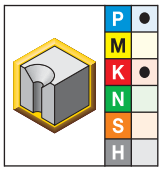








B732_HP • Long



● first choice
○ alternate choice

long • KCPK15	D1 diameter mm	D1 diameter in	L	SDL1	L5	LS	D
B732A03734HP	3,734	.1470	66	16	0,7	36	6
B732A04200HP	4,200	.1654	66	17	0,8	36	6
B732A04496HP	4,496	.1770	79	17	0,9	36	8
B732A05000HP	5,000	.1969	79	20	0,9	36	8
B732A05106HP	5,106	.2010	79	20	1,0	36	8
B732A05410HP *	5,410	.2130	79	21	1,0	36	8
B732A06528HP	6,528	.2570	89	24	1,2	40	10
B732A06800HP	6,800	.2677	89	25	1,3	40	10
B732A06909HP	6,909	.2720	89	25	1,3	40	10
B732A07938HP	7,938	.3125	102	27	1,5	45	12
B732A08433HP	8,433	.3320	102	29	1,6	45	12
B732A08500HP	8,500	.3346	102	30	1,6	45	12
B732A09921HP *	9,921	.3906	107	33	1,9	45	14
B732A10200HP	10,200	.4016	107	35	1,9	45	14
B732A10500HP	10,500	.4134	107	35	2,0	45	14
B732A10716HP	10,716	.4219	107	37	2,0	45	14
B732A12000HP	12,000	.4724	115	40	2,2	48	16
B732A12500HP *	12,500	.4921	115	40	2,3	48	16
B732A13096HP *	13,096	.5156	123	44	2,4	48	16
B732A13495HP *	13,495	.5313	123	45	2,5	48	18
B732A14000HP	14,000	.5512	123	43	2,6	48	18
B732A16670HP	16,670	.6563	141	55	3,1	50	20
B732A17463HP	17,463	.6875	141	58	3,2	50	20

NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Tolerance • Metric

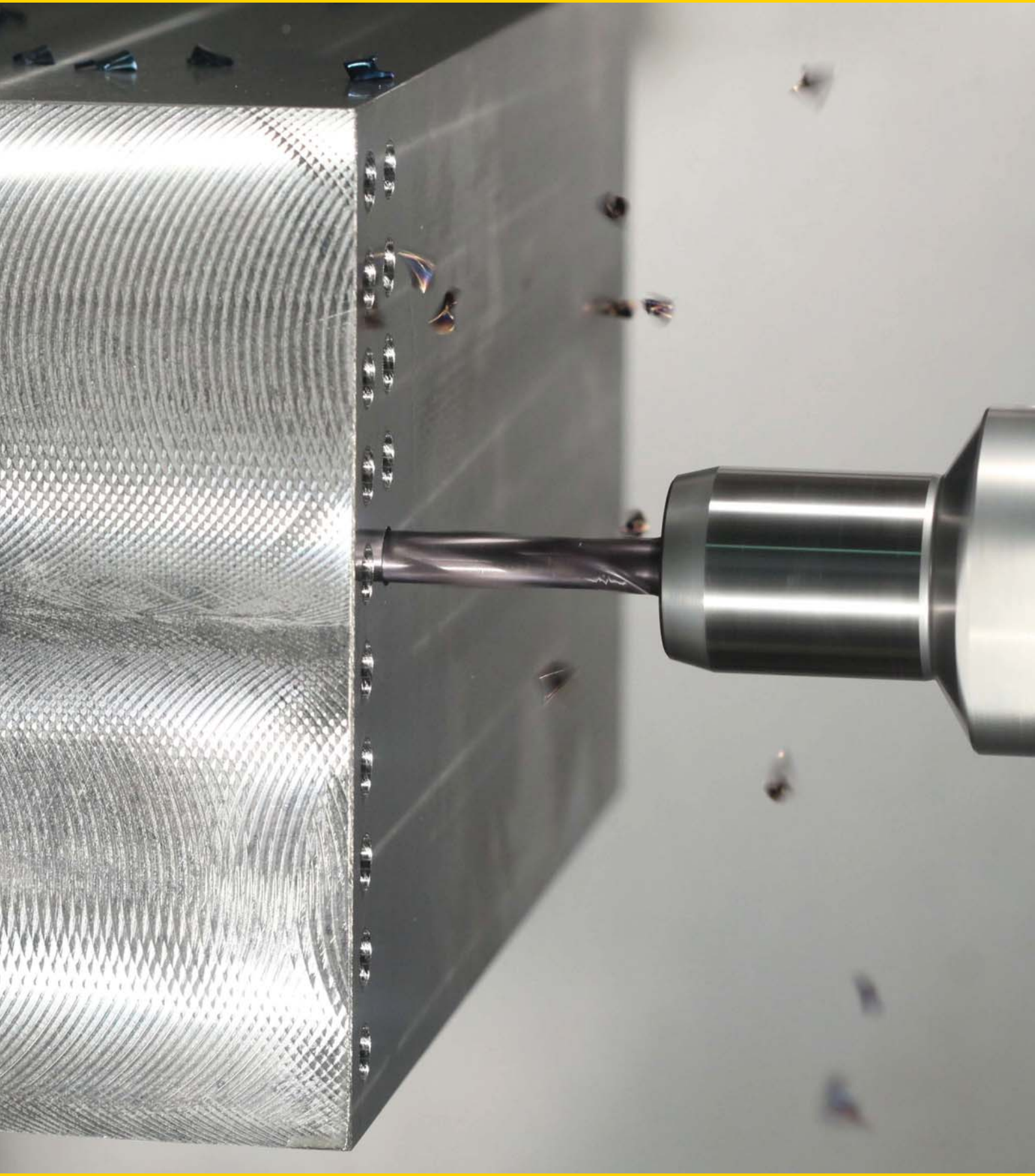
nominal size range	D1 tolerance m7	D tolerance h6
>3–6	0,004/0,016	0,000/-0,008
>6–10	0,006/0,021	0,000/-0,009
>10–18	0,007/0,025	0,000/-0,011
>18–25,4	0,008/0,029	0,000/-0,013

HP Step Drills • B73_HP Series • Grade KCPK15™ • Through Coolant • Drill Diameters 3–20mm • Metric



Material Group		Cutting Speed — vc			Metric								
		Range — m/min			Recommended Feed Rate (f) by Diameter								
		min	Starting Value	max		3,0	4,0	6,0	8,0	10,0	12,0	16,0	20,0
P	0	150	**240**	270	mm/r	0,06–0,14	0,08–0,18	0,09–0,20	0,12–0,26	0,14–0,30	0,15–0,33	0,17–0,39	0,20–0,43
	1	140	**220**	240	mm/r	0,07–0,17	0,09–0,21	0,11–0,24	0,14–0,30	0,16–0,35	0,18–0,39	0,20–0,46	0,24–0,50
	2	180	**210**	240	mm/r	0,07–0,14	0,09–0,17	0,11–0,20	0,14–0,24	0,16–0,28	0,18–0,32	0,20–0,37	0,24–0,43
	3	120	**150**	180	mm/r	0,09–0,17	0,12–0,21	0,14–0,24	0,17–0,30	0,20–0,35	0,22–0,39	0,26–0,46	0,29–0,50
	4	100	**140**	180	mm/r	0,08–0,17	0,11–0,20	0,12–0,23	0,15–0,28	0,17–0,33	0,19–0,37	0,22–0,43	0,25–0,45
	6	140	**150**	180	mm/r	0,07–0,13	0,09–0,15	0,11–0,17	0,13–0,21	0,15–0,24	0,17–0,27	0,19–0,33	0,21–0,36
K	1	140	**160**	180	mm/r	0,09–0,18	0,12–0,22	0,13–0,26	0,16–0,33	0,19–0,37	0,21–0,41	0,24–0,48	0,27–0,51
	2	100	**150**	200	mm/r	0,09–0,16	0,12–0,19	0,13–0,22	0,16–0,27	0,19–0,32	0,21–0,35	0,24–0,41	0,27–0,45
	3	100	**140**	180	mm/r	0,07–0,14	0,09–0,17	0,12–0,20	0,14–0,24	0,16–0,28	0,18–0,32	0,21–0,37	0,24–0,39

KENNAMETAL®



New KMH Drills for Hard Materials

Primary Application

The all-new KMH solid carbide drills are engineered for hard material applications up to 65 HRC. The B94_drill series without through coolant is specifically designed to machine hardened and surface-hardened materials using flood coolant. With its 145° point angle, it is also perfectly suited as a pilot drill for the B95_drill series with through coolant and 140° point for deeper applications.

Both series come with an increased core to strengthen the drill, feature a curved cutting edge with corner chamfer to avoid chipping on the margin lands and increased tool life in these challenging materials.

Features and Benefits

New KMH Point Design

- Curved cutting edge with corner chamfer for maximum corner stability in hard materials.
- Avoids chipping on cutting edge and pre-mature wear.
- Also works well in applications with heavily-interrupted cuts using the make-to-order four-margin version.

Special Flute Design

- Strong web to increase the strength of the drill in tough applications with short chips.
- B94_ series with 15° helix angle to maximise stability in applications above 54 HRC.
- B95_ series with 30° helix angle to improve chip evacuation in higher length-to-diameter ratios.

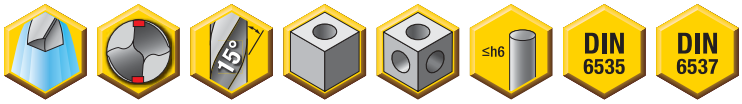
New KCH10 and KCH15 Grades

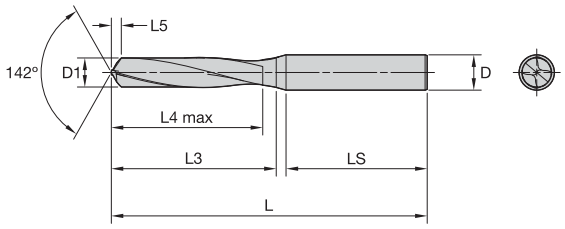
- KCH10 on B94_ series consists of a special fine-grain carbide substrate with higher hardness.
- KCH15 on B95_ series, with its higher toughness, supports edge strength at increased rake angles, which are applied to improve chip evacuation in higher L/D ratios.
- Both series carry a high temperature and shock resistance AlTiN coating for machining hardened materials to increase tool life.



Customisation

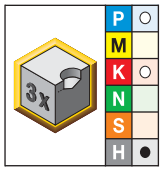
- Intermediate diameters available as semi-standards.
- Four margin land designs also available as semi-standards.
- Length variations and step drills available as custom solutions.
- High step diameter ratios and very complex step drill geometries are not recommended for hard materials.







B941A • ~3 x D

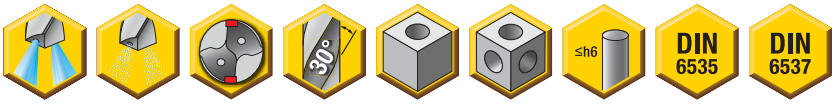


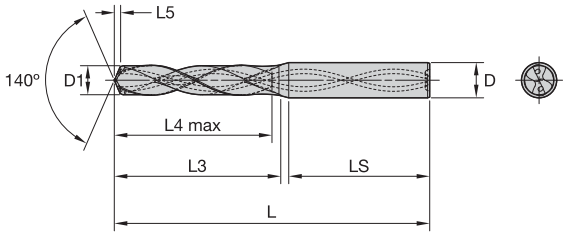
● first choice
○ alternate choice

short • KCH10	D1 diameter mm	D1 diameter in	L	L3	L4 max	L5	LS	D
B941Z02500	2,500	.0984	50	16	11	0,5	28	3
B941A03000	3,000	.1181	62	20	14	0,6	36	6
B941A03300	3,300	.1299	62	20	14	0,6	36	6
B941A03400	3,400	.1339	62	20	14	0,6	36	6
B941A03500	3,500	.1378	62	20	14	0,6	36	6
B941A04000	4,000	.1575	66	24	17	0,7	36	6
B941A04200	4,200	.1654	66	24	17	0,8	36	6
B941A04300	4,300	.1693	66	24	17	0,8	36	6
B941A04500	4,500	.1772	66	24	17	0,8	36	6
B941A05000	5,000	.1969	66	28	20	0,9	36	6
B941A05100	5,100	.2008	66	28	20	0,9	36	6
B941A05200	5,200	.2047	66	28	20	0,9	36	6
B941A05500	5,500	.2165	66	28	20	1,0	36	6
B941A05600	5,600	.2205	66	28	20	1,0	36	6
B941A06000	6,000	.2362	66	28	20	1,1	36	6
B941A06900	6,900	.2717	79	34	24	1,3	36	8
B941A07000	7,000	.2756	79	34	24	1,3	36	8
B941A07100	7,100	.2795	79	41	29	1,3	36	8
B941A08000	8,000	.3150	79	41	29	1,4	36	8
B941A08500	8,500	.3346	89	47	35	1,5	40	10
B941A08600	8,600	.3386	89	47	35	1,6	40	10
B941A09000	9,000	.3543	89	47	35	1,6	40	10
B941A10000	10,000	.3937	89	47	35	1,8	40	10
B941A10200	10,200	.4016	102	55	40	1,8	45	12
B941A10400	10,400	.4094	102	55	40	1,9	45	12
B941A10500	10,500	.4134	102	55	40	1,9	45	12
B941A11100	11,100	.4370	102	55	40	2,0	45	12
B941A12000	12,000	.4724	102	55	40	2,1	45	12
B941A14000	14,000	.5512	107	60	43	2,5	45	14

Tolerance • Metric

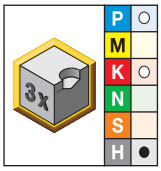
nominal size range	D1 tolerance m7	D tolerance h6
>3–6	0,004/0,016	0,000/-0,008
>6–10	0,006/0,021	0,000/-0,009
>10–18	0,007/0,025	0,000/-0,011
>18–25,4	0,008/0,029	0,000/-0,013







B951A • ~3 x D

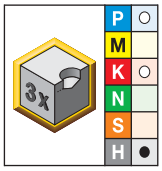


● first choice
○ alternate choice

short • KCH15	D1 diameter mm	in	fraction	L	L3	L4 max	L5	LS	D
B951A03000	3,000	.1181	–	62	20	14	0,6	36	6
B951A03175	3,175	.1250	1/8	62	20	14	0,6	36	6
B951A03454	3,454	.1360	–	62	20	14	0,7	36	6
B951A03500	3,500	.1378	–	62	20	14	0,7	36	6
B951A03800	3,800	.1496	–	66	24	17	0,8	36	6
B951A04000	4,000	.1575	–	66	24	17	0,8	36	6
B951A04100	4,100	.1614	–	66	24	17	0,8	36	6
B951A04200	4,200	.1654	–	66	24	17	0,9	36	6
B951A04300	4,300	.1693	–	66	24	17	0,9	36	6
B951A04500	4,500	.1772	–	66	24	17	0,9	36	6
B951A04800	4,800	.1890	–	66	28	20	1,0	36	6
B951A04900	4,900	.1929	–	66	28	20	1,0	36	6
B951A05000	5,000	.1969	–	66	28	20	1,0	36	6
B951A05500	5,500	.2165	–	66	28	20	1,1	36	6
B951A05800	5,800	.2283	–	66	28	20	1,2	36	6
B951A06000	6,000	.2362	–	66	28	20	1,2	36	6
B951A06350	6,350	.2500	1/4	79	34	24	1,3	36	8
B951A06500	6,500	.2559	–	79	34	24	1,3	36	8
B951A06800	6,800	.2677	–	79	34	24	1,4	36	8
B951A07000	7,000	.2756	–	79	34	24	1,4	36	8
B951A08000	8,000	.3150	–	79	41	29	1,6	36	8
B951A08500	8,500	.3346	–	89	47	35	1,7	40	10
B951A09000	9,000	.3543	–	89	47	35	1,8	40	10
B951A09500	9,500	.3740	–	89	47	35	1,9	40	10
B951A09800	9,800	.3858	–	89	47	35	1,9	40	10
B951A10000	10,000	.3937	–	89	47	35	2,0	40	10
B951A10200	10,200	.4016	–	102	55	40	2,0	45	12
B951A10500	10,500	.4134	–	102	55	40	2,1	45	12

(continued)

(B951A • ~3 x D — continued)



● first choice
○ alternate choice

short • KCH15	D1 diameter mm	in	fraction	L	L3	L4 max	L5	LS	D
B951A10800	10,800	.4252	—	118	71	56	2,1	45	12
B951A11000	11,000	.4331	—	118	71	56	2,2	45	12
B951A11500	11,500	.4528	—	118	71	56	2,3	45	12
B951A11800	11,800	.4646	—	102	55	40	2,3	45	12
B951A12000	12,000	.4724	—	102	55	40	2,4	45	12
B951A12500	12,500	.4921	—	107	60	43	2,5	45	14
B951A12700	12,700	.5000	1/2	107	60	43	2,5	45	14
B951A12800	12,800	.5039	—	107	60	43	2,5	45	14
B951A13000	13,000	.5118	—	107	60	43	2,6	45	14
B951A13500	13,500	.5315	—	107	60	43	2,7	45	14
B951A14000	14,000	.5512	—	107	60	43	2,8	45	14
B951A14500	14,500	.5709	—	115	65	45	2,9	48	16
B951A15500	15,500	.6102	—	115	65	45	3,1	48	16
B951A16000	16,000	.6299	—	133	83	63	3,2	48	16

Application Data

KMH Drill • B94_Series • Grade KCH10 • Flood Coolant • Metric





Material Group		Cutting Speed — vc Range — m/min min	Starting Value	max		Metric Recommended Feed Rate (f) by Diameter 3,0	4,0	6,0	8,0	10,0	12,0	16,0	20,0
P	4	50	**70**	100	mm/r	0,06–0,15	0,08–0,17	0,12–0,23	0,14–0,28	0,17–0,33	0,19–0,38	0,23–0,47	0,29–0,59
	5	40	**50**	70	mm/r	0,08–0,16	0,10–0,20	0,12–0,24	0,16–0,28	0,20–0,32	0,24–0,36	0,28–0,44	0,32–0,52
	6	30	**40**	60	mm/r	0,05–0,07	0,06–0,10	0,08–0,14	0,10–0,18	0,12–0,22	0,14–0,24	0,18–0,32	0,23–0,41
K	1	80	**130**	150	mm/r	0,11–0,22	0,12–0,24	0,16–0,31	0,20–0,38	0,23–0,44	0,25–0,49	0,31–0,06	0,38–0,47
	2	70	**110**	100	mm/r	0,10–0,17	0,12–0,19	0,16–0,25	0,20–0,31	0,23–0,36	0,25–0,40	0,31–0,48	0,38–0,60
	3	80	**110**	120	mm/r	0,07–0,15	0,09–0,19	0,12–0,25	0,14–0,30	0,17–0,35	0,19–0,40	0,25–0,48	0,30–0,60
H	1	20	**30**	40	mm/r	0,03–0,06	0,04–0,08	0,06–0,10	0,08–0,12	0,09–0,13	0,10–0,14	0,12–0,16	0,14–0,18
	2	15	**30**	40	mm/r	0,02–0,04	0,03–0,06	0,05–0,08	0,07–0,10	0,08–0,11	0,09–0,12	0,10–0,14	0,11–0,16
	3	15	**25**	35	mm/r	0,02–0,04	0,02–0,05	0,04–0,07	0,06–0,09	0,07–0,10	0,08–0,11	0,09–0,13	0,10–0,15
	4	15	**20**	30	mm/r	0,02–0,04	0,03–0,06	0,05–0,08	0,07–0,10	0,08–0,11	0,09–0,12	0,10–0,14	0,11–0,16

KMH Drill • B95_Series • Grade KCH15 • Through Coolant • Metric



Material Group		Cutting Speed – vc Range – m/min			Metric Recommended Feed Rate per Rev								
		min	Starting Value	max		3,0	4,0	6,0	8,0	10,0	12,0	16,0	20,0
P	4	50	**70**	100	mm/r	0,06–0,15	0,08–0,17	0,12–0,23	0,14–0,28	0,17–0,33	0,19–0,38	0,23–0,47	0,29–0,59
	5	50	**60**	80	mm/r	0,08–0,14	0,10–0,16	0,12–0,20	0,16–0,24	0,20–0,28	0,24–0,32	0,28–0,40	0,32–0,48
	6	40	**50**	70	mm/r	0,05–0,08	0,06–0,10	0,08–0,14	0,10–0,18	0,13–0,22	0,14–0,24	0,18–0,32	0,23–0,41
K	1	80	**130**	170	mm/r	0,11–0,22	0,12–0,24	0,16–0,31	0,20–0,38	0,23–0,44	0,25–0,49	0,31–0,06	0,38–0,47
	2	90	**110**	120	mm/r	0,10–0,17	0,12–0,19	0,16–0,25	0,20–0,31	0,23–0,36	0,25–0,40	0,31–0,48	0,38–0,60
	3	80	**110**	130	mm/r	0,07–0,15	0,09–0,19	0,12–0,25	0,14–0,30	0,17–0,35	0,19–0,40	0,25–0,48	0,30–0,60
H	1	20	**35**	45	mm/r	0,03–0,06	0,04–0,08	0,06–0,10	0,08–0,12	0,09–0,13	0,10–0,14	0,12–0,16	0,14–0,18
	2	15	**30**	45	mm/r	0,02–0,04	0,03–0,06	0,05–0,08	0,07–0,10	0,08–0,11	0,09–0,12	0,10–0,14	0,11–0,16
	3	15	**25**	40	mm/r	0,02–0,04	0,02–0,05	0,04–0,07	0,06–0,09	0,07–0,10	0,08–0,11	0,09–0,13	0,10–0,15
	4	15	**20**	35	mm/r	0,02–0,04	0,03–0,06	0,05–0,08	0,07–0,10	0,08–0,11	0,09–0,12	0,10–0,14	0,11–0,16

Kenna Universal™ Drills

Primary Application

Kenna Universal Drills (B96/B97_ Series) are engineered to deliver superior performance in steel, cast iron, and stainless steel applications making it ideal for small- and medium-sized shops. The universal application profile reduces tool change times and the number of drills in inventory. Covering a large spectrum of off-the-shelf diameters and a broad range of applications makes Kenna Universal Drills an excellent alternative to other high-performance products.

The B976Z series is available from 2,383–3mm making it the first standard offering in less than 3mm. This extended diameter offering covers all common tap drill sizes, including an expanded selection of wire, fractional, and letter sizes.

The new B967 series satisfies the demand for non-coolant drills up to 5 x D for applications with flood coolant or dry.

Use as Pilot Drill

- Ideal point angle and tolerance make the Kenna Universal drill the preferred pilot drill for B27_ series solid carbide deep-hole drills.

Features and Benefits

Kenna Universal Drill-Point Design

- Low thrust. Works well on a variety of machines.
- Excellent centring capabilities.
- Easy to regrind.

Four-Margin Land Design

- Improves hole straightness and roundness.
- Provides good alignment and stability in tough drilling applications — even when drilling through cross holes.

KC7315™ Grade

- A multilayer, TiAlN-based coating with high hot hardness enables 30% higher cutting speeds and constant tool life.
- Surface finish ensures chip evacuation when drilling deep holes.

Universal application profile, problem solver, and pilot drill.

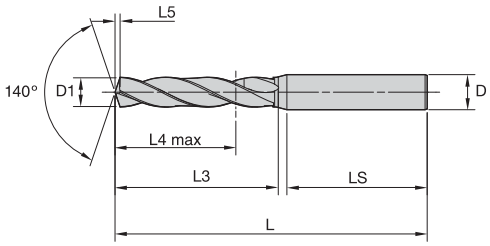


Customisation

- Intermediate diameters available as semi-standards.
- Length variations and step drills available as engineered solutions.





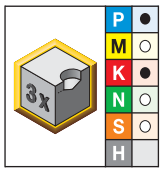


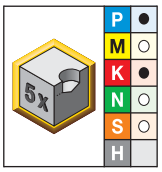




For information on L, L3, and L4 max, see the Solid Carbide Drills foldout table.

B966A/B967A • ~3 x D/~5 x D



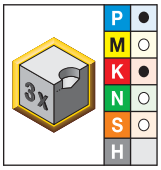


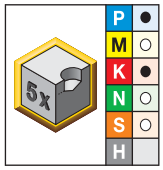
● first choice
○ alternate choice

short • KC7315	long • KC7315	D1 diameter mm	D1 diameter in	L5	LS	D
B966A03000	B967A03000	3,000	.1181	0,5	36	6
B966A03100	B967A03100	3,100	.1220	0,5	36	6
B966A03200	B967A03200	3,200	.1260	0,5	36	6
B966A03300	B967A03300	3,300	.1299	0,5	36	6
B966A03400	–	3,400	.1339	0,6	36	6
B966A03500	B967A03500	3,500	.1378	0,6	36	6
B966A03600	–	3,600	.1417	0,6	36	6
B966A03700	–	3,700	.1457	0,6	36	6
B966A03800	B967A03800	3,800	.1496	0,6	36	6
B966A03900	–	3,900	.1535	0,6	36	6
B966A03960	–	3,960	.1559	0,7	36	6
B966A04000	B967A04000	4,000	.1575	0,7	36	6
B966A04100	–	4,100	.1614	0,7	36	6
B966A04200	B967A04200	4,200	.1654	0,7	36	6
B966A04300	B967A04300	4,300	.1693	0,7	36	6
B966A04400	–	4,400	.1732	0,7	36	6
B966A04500	B967A04500	4,500	.1772	0,7	36	6
B966A04600	–	4,600	.1811	0,8	36	6
B966A04700	–	4,700	.1850	0,8	36	6
B966A04800	B967A04800	4,800	.1890	0,8	36	6
B966A04900	–	4,900	.1929	0,8	36	6
B966A05000	B967A05000	5,000	.1969	0,8	36	6
B966A05040	–	5,040	.1984	0,8	36	6
B966A05100	B967A05100	5,100	.2008	0,8	36	6
B966A05200	B967A05200	5,200	.2047	0,9	36	6
B966A05300	–	5,300	.2087	0,9	36	6
B966A05400	–	5,400	.2126	0,9	36	6
B966A05500	B967A05500	5,500	.2165	0,9	36	6
B966A05600	–	5,600	.2205	0,9	36	6
B966A05700	–	5,700	.2244	1,0	36	6
B966A05800	B967A05800	5,800	.2283	1,0	36	6
B966A05900	–	5,900	.2323	1,0	36	6
B966A06000	B967A06000	6,000	.2362	1,0	36	6
B966A06050	–	6,050	.2382	1,0	36	8
B966A06100	B967A06100	6,100	.2402	1,0	36	8
B966A06200	–	6,200	.2441	1,0	36	8

(continued)

(B966A/B967A • ~3 x D/~5 x D — continued)



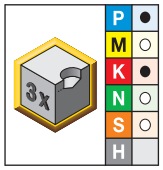


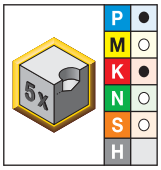
● first choice
○ alternate choice

short • KC7315	long • KC7315	D1 diameter mm	D1 diameter in	L5	LS	D
B966A06300	–	6,300	.2480	1,1	36	8
B966A06350	–	6,350	.2500	1,1	36	8
B966A06400	–	6,400	.2520	1,1	36	8
B966A06500	B967A06500	6,500	.2559	1,1	36	8
B966A06600	B967A06600	6,600	.2598	1,1	36	8
B966A06700	B967A06700	6,700	.2638	1,1	36	8
B966A06800	B967A06800	6,800	.2677	1,1	36	8
B966A06900	–	6,900	.2717	1,2	36	8
B966A07000	B967A07000	7,000	.2756	1,2	36	8
B966A07100	–	7,100	.2795	1,2	36	8
B966A07200	–	7,200	.2835	1,2	36	8
B966A07300	–	7,300	.2874	1,2	36	8
B966A07400	B967A07400	7,400	.2913	1,3	36	8
B966A07500	B967A07500	7,500	.2953	1,3	36	8
B966A07600	–	7,600	.2992	1,3	36	8
B966A07700	–	7,700	.3031	1,3	36	8
B966A07800	B967A07800	7,800	.3071	1,3	36	8
B966A07900	–	7,900	.3110	1,3	36	8
B966A08000	B967A08000	8,000	.3150	1,4	36	8
B966A08100	B967A08100	8,100	.3189	1,4	40	10
B966A08200	–	8,200	.3228	1,4	40	10
B966A08300	–	8,300	.3268	1,4	40	10
B966A08400	–	8,400	.3307	1,4	40	10
B966A08500	B967A08500	8,500	.3346	1,4	40	10
B966A08600	B967A08600	8,600	.3386	1,5	40	10
B966A08700	B967A08700	8,700	.3425	1,5	40	10
B966A08800	B967A08800	8,800	.3465	1,5	40	10
B966A08900	–	8,900	.3504	1,5	40	10
B966A09000	B967A09000	9,000	.3543	1,5	40	10
B966A09100	–	9,100	.3583	1,5	40	10
B966A09200	–	9,200	.3622	1,6	40	10
B966A09300	B967A09300	9,300	.3661	1,6	40	10
B966A09400	–	9,400	.3701	1,6	40	10
B966A09500	B967A09500	9,500	.3740	1,6	40	10
B966A09600	–	9,600	.3780	1,6	40	10
B966A09700	–	9,700	.3819	1,7	40	10
B966A09800	B967A09800	9,800	.3858	1,7	40	10
B966A09900	–	9,900	.3898	1,7	40	10
B966A10000	B967A10000	10,000	.3937	1,7	40	10
B966A10100	–	10,100	.3976	1,7	45	12
B966A10200	B967A10200	10,200	.4016	1,7	45	12
B966A10300	–	10,300	.4055	1,8	45	12
B966A10400	–	10,400	.4094	1,8	45	12
B966A10500	B967A10500	10,500	.4134	1,8	45	12
B966A10600	–	10,600	.4173	1,8	45	12
B966A10700	B967A10700	10,700	.4213	1,8	45	12
B966A10800	B967A10800	10,800	.4252	1,8	45	12
B966A10900	–	10,900	.4291	1,9	45	12
B966A11000	B967A11000	11,000	.4331	1,9	45	12
B966A11100	–	11,100	.4370	1,9	45	12
B966A11200	–	11,200	.4409	1,9	45	12
B966A11300	B967A11300	11,300	.4449	1,9	45	12

(continued)

(B966A/B967A • ~3 x D/~5 x D — continued)





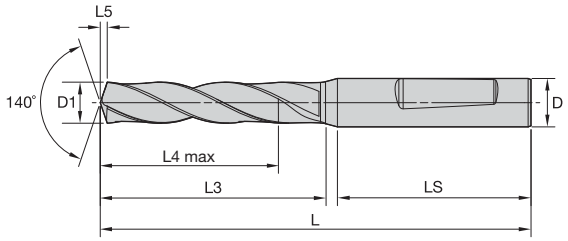
● first choice
○ alternate choice

short • KC7315	long • KC7315	D1 diameter mm	D1 diameter in	L5	LS	D
B966A11400	–	11,400	.4488	2,0	45	12
B966A11500	**B967A11500**	11,500	.4528	2,0	45	12
B966A11600	–	11,600	.4567	2,0	45	12
B966A11700	–	11,700	.4606	2,0	45	12
B966A11800	**B967A11800**	11,800	.4646	2,0	45	12
B966A11900	–	11,900	.4685	2,0	45	12
B966A12000	**B967A12000**	12,000	.4724	2,1	45	12
B966A12100	–	12,100	.4764	2,1	45	14
B966A12200	–	12,200	.4803	2,1	45	14
B966A12300	–	12,300	.4843	2,1	45	14
B966A12400	–	12,400	.4882	2,1	45	14
B966A12500	**B967A12500**	12,500	.4921	2,1	45	14
B966A12600	–	12,600	.4961	2,2	45	14
B966A12700	**B967A12700**	12,700	.5000	2,2	45	14
B966A12800	**B967A12800**	12,800	.5039	2,2	45	14
B966A12900	–	12,900	.5079	2,2	45	14
B966A13000	**B967A13000**	13,000	.5118	2,2	45	14
B966A13100	–	13,100	.5157	2,3	45	14
B966A13200	–	13,200	.5197	2,3	45	14
B966A13300	–	13,300	.5236	2,3	45	14
B966A13400	–	13,400	.5276	2,3	45	14
B966A13500	**B967A13500**	13,500	.5315	2,3	45	14
B966A13700	–	13,700	.5394	2,4	45	14
B966A14000	**B967A14000**	14,000	.5512	2,4	45	14
B966A14200	–	14,200	.5591	2,5	48	16
B966A14300	–	14,300	.5630	2,5	48	16
B966A14500	**B967A14500**	14,500	.5709	2,5	48	16
B966A14700	–	14,700	.5787	2,5	48	16
B966A14800	–	14,800	.5827	2,6	48	16
B966A15000	**B967A15000**	15,000	.5906	2,6	48	16
–	**B967A15300**	15,300	.6024	2,6	48	16
B966A15500	**B967A15500**	15,500	.6102	2,7	48	16
B966A15700	–	15,700	.6181	2,7	48	16
B966A16000	**B967A16000**	16,000	.6299	2,8	48	16
B966A16500	**B967A16500**	16,500	.6496	2,9	48	18
B966A17000	–	17,000	.6693	2,9	48	18
B966A17500	–	17,500	.6890	3,0	48	18
B966A18000	–	18,000	.7087	3,1	48	18
B966A20000	–	20,000	.7874	3,5	50	20

Tolerance • Metric

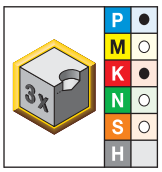
nominal size range	D1 tolerance m7	D tolerance h6
>3–6	0,004/0,016	0,000/-0,008
>6–10	0,006/0,021	0,000/-0,009
>10–18	0,007/0,025	0,000/-0,011
>18–25,4	0,008/0,029	0,000/-0,013







B966F • ~3 x D

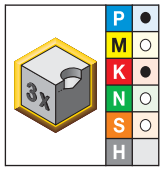


● first choice
○ alternate choice

short • KC7315	D1 diameter mm	in	L	L3	L4 max	L5	LS	D
B966F03000	3,000	.1181	62	20	14	0,5	36	6
B966F03300	3,300	.1299	62	20	14	0,5	36	6
B966F03400	3,400	.1339	62	20	14	0,6	36	6
B966F03500	3,500	.1378	62	20	14	0,6	36	6
B966F03600 *	3,600	.1417	62	20	14	0,6	36	6
B966F04000	4,000	.1575	66	24	17	0,7	36	6
B966F04200	4,200	.1654	66	24	17	0,7	36	6
B966F05000	5,000	.1969	66	28	20	0,8	36	6
B966F05100 *	5,100	.2008	66	28	20	0,8	36	6
B966F05300 *	5,300	.2087	66	28	20	0,9	36	6
B966F05500	5,500	.2165	66	28	20	0,9	36	6
B966F05600 *	5,600	.2205	66	28	20	0,9	36	6
B966F06000	6,000	.2362	66	28	20	1,0	36	6
B966F06300	6,300	.2480	79	34	24	1,1	36	8
B966F06400	6,400	.2520	79	34	24	1,1	36	8
B966F06500	6,500	.2559	79	34	24	1,1	36	8
B966F06700 *	6,700	.2638	79	34	24	1,1	36	8
B966F06800	6,800	.2677	79	34	24	1,1	36	8
B966F07000	7,000	.2756	79	34	24	1,2	36	8
B966F07100 *	7,100	.2795	79	41	29	1,2	36	8
B966F07300 *	7,300	.2874	79	41	29	1,2	36	8
B966F07400 *	7,400	.2913	79	41	29	1,3	36	8
B966F07600 *	7,600	.2992	79	41	29	1,3	36	8
B966F08000	8,000	.3150	79	41	29	1,4	36	8
B966F08200	8,200	.3228	89	47	35	1,4	40	10
B966F08400	8,400	.3307	89	47	35	1,4	40	10
B966F08500	8,500	.3346	89	47	35	1,4	40	10
B966F09000	9,000	.3543	89	47	35	1,5	40	10
B966F09100	9,100	.3583	89	47	35	1,5	40	10
B966F09500	9,500	.3740	89	47	35	1,6	40	10
B966F10000	10,000	.3937	89	47	35	1,7	40	10
B966F10200	10,200	.4016	102	55	40	1,7	45	12
B966F10400	10,400	.4094	102	55	40	1,8	45	12
B966F10500	10,500	.4134	102	55	40	1,8	45	12
B966F10600	10,600	.4173	102	55	40	1,8	45	12
B966F10700	10,700	.4213	102	55	40	1,8	45	12

(continued)

(B966F • ~3 x D — continued)



● first choice
○ alternate choice

short • KC7315	D1 diameter mm	in	L	L3	L4 max	L5	LS	D
B966F10800	10,800	.4252	102	55	40	1,8	45	12
B966F11000	11,000	.4331	102	55	40	1,9	45	12
B966F11800	11,800	.4646	102	55	40	2,0	45	12
B966F12000	12,000	.4724	102	55	40	2,1	45	12
B966F12100 *	12,100	.4764	107	60	43	2,1	45	14
B966F12200	12,200	.4803	107	60	43	2,1	45	14
B966F12500	12,500	.4921	107	60	43	2,1	45	14
B966F12700	12,700	.5000	107	60	43	2,2	45	14
B966F13000	13,000	.5118	107	60	43	2,2	45	14
B966F13500 *	13,500	.5315	107	60	43	2,3	45	14
B966F14000	14,000	.5512	107	60	43	2,4	45	14
B966F14500	14,500	.5709	115	65	45	2,5	48	16
B966F15000	15,000	.5906	115	65	45	2,6	48	16
B966F16000	16,000	.6299	115	65	45	2,8	48	16
B966F16500	16,500	.6496	123	73	51	2,9	48	18
B966F17000	17,000	.6693	123	73	51	2,9	48	18
B966F17500 *	17,500	.6890	123	73	51	3,0	48	18
B966F18000	18,000	.7087	123	73	51	3,1	48	18

NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Tolerance • Metric

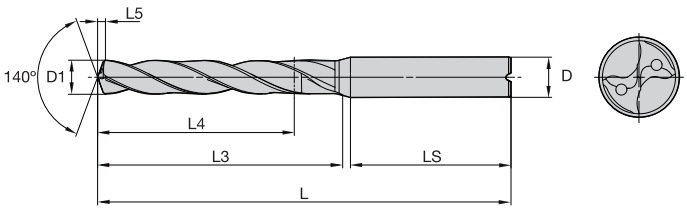
nominal size range	D1 tolerance m7	D tolerance h6
>3–6	0,004/0,016	0,000/-0,008
>6–10	0,006/0,021	0,000/-0,009
>10–18	0,007/0,025	0,000/-0,011
>18–25,4	0,008/0,029	0,000/-0,013

Kenna Universal™ Drills • B966, B967 Series • Grade KC7315™ • Flood Coolant • Drill Diameters 3–20mm • Metric



Material Group		Cutting Speed — vc			Metric								
		Range — m/min			Recommended Feed Rate (f) by Diameter								
		min	Starting Value	max		3,0	4,0	6,0	8,0	10,0	12,0	16,0	20,0
P	0	70	**90**	115	mm/r	0,05–0,11	0,08–0,14	0,09–0,19	0,11–0,22	0,13–0,26	0,15–0,30	0,19–0,36	0,24–0,46
	1	60	**70**	100	mm/r	0,06–0,13	0,09–0,16	0,11–0,22	0,13–0,26	0,15–0,31	0,18–0,35	0,22–0,42	0,28–0,54
	2	80	**90**	100	mm/r	0,06–0,13	0,08–0,16	0,12–0,22	0,14–0,26	0,17–0,31	0,20–0,35	0,24–0,42	0,31–0,53
	3	50	**70**	90	mm/r	0,07–0,15	0,09–0,17	0,13–0,23	0,15–0,28	0,19–0,33	0,22–0,38	0,26–0,47	0,34–0,59
	4	50	**70**	100	mm/r	0,06–0,15	0,08–0,17	0,12–0,23	0,14–0,28	0,17–0,33	0,19–0,38	0,23–0,47	0,29–0,59
	5	40	**50**	70	mm/r	0,06–0,12	0,08–0,14	0,10–0,18	0,12–0,22	0,16–0,26	0,18–0,28	0,22–0,36	0,26–0,42
	6	30	**40**	60	mm/r	0,05–0,07	0,06–0,10	0,08–0,14	0,10–0,18	0,12–0,22	0,14–0,24	0,18–0,32	0,23–0,41
M	1	30	**40**	50	mm/r	0,04–0,07	0,05–0,09	0,08–0,11	0,09–0,12	0,10–0,14	0,12–0,16	0,14–0,18	0,16–0,20
	2	40	**50**	60	mm/r	0,04–0,08	0,06–0,10	0,08–0,12	0,09–0,14	0,10–0,16	0,12–0,18	0,14–0,20	0,16–0,22
	3	30	**40**	50	mm/r	0,04–0,07	0,06–0,09	0,08–0,11	0,09–0,12	0,10–0,14	0,12–0,16	0,14–0,18	0,16–0,20
K	1	80	**130**	170	mm/r	0,11–0,22	0,12–0,24	0,16–0,31	0,20–0,38	0,23–0,44	0,25–0,49	0,31–0,06	0,38–0,47
	2	90	**110**	120	mm/r	0,10–0,17	0,12–0,19	0,16–0,25	0,20–0,31	0,23–0,36	0,25–0,40	0,31–0,48	0,38–0,60
	3	80	**110**	130	mm/r	0,07–0,15	0,09–0,19	0,12–0,25	0,14–0,30	0,17–0,35	0,19–0,40	0,25–0,48	0,30–0,60
N	1	90	**230**	270	mm/r	0,08–0,14	0,10–0,16	0,12–0,20	0,16–0,24	0,20–0,28	0,24–0,32	0,28–0,40	0,32–0,48
	2	90	**220**	270	mm/r	0,08–0,16	0,10–0,20	0,12–0,24	0,16–0,28	0,20–0,32	0,24–0,36	0,28–0,44	0,32–0,52
	3	90	**180**	225	mm/r	0,12–0,14	0,13–0,16	0,14–0,20	0,16–0,24	0,20–0,28	0,24–0,32	0,28–0,40	0,32–0,44
	4	90	**130**	270	mm/r	0,08–0,16	0,10–0,20	0,12–0,24	0,16–0,28	0,20–0,32	0,24–0,36	0,28–0,40	0,32–0,48
S	1	20	**25**	30	mm/r	0,03–0,06	0,04–0,08	0,06–0,10	0,08–0,12	0,09–0,13	0,10–0,14	0,12–0,16	0,14–0,18
	2	10	**20**	30	mm/r	0,02–0,04	0,03–0,06	0,05–0,08	0,07–0,10	0,08–0,11	0,09–0,12	0,10–0,14	0,11–0,16
	3	20	**25**	40	mm/r	0,02–0,04	0,02–0,05	0,04–0,07	0,06–0,09	0,07–0,10	0,08–0,11	0,09–0,13	0,10–0,15
	4	20	**25**	50	mm/r	0,02–0,04	0,03–0,06	0,05–0,08	0,07–0,10	0,08–0,11	0,09–0,12	0,10–0,14	0,11–0,16

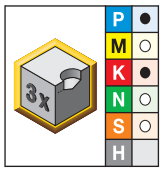


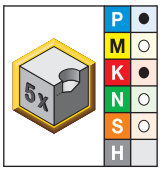




For information on L, L3, and L4 max, see the Solid Carbide Drills foldout table.

B976A/B977A • ~3 x D/~5 x D



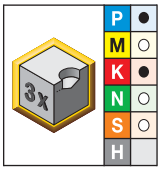


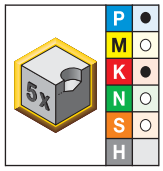
● first choice
○ alternate choice

short • KC7315	long • KC7315	D1 diameter mm	D1 diameter in	L5	LS	D
B976Z02383	–	2,383	.0938	0,4	28	3
B976Z02400	–	2,400	.0945	0,4	28	3
B976Z02439	–	2,439	.0960	0,4	28	3
B976Z02489	–	2,489	.0980	0,4	28	3
B976Z02500	–	2,500	.0984	0,4	28	3
B976Z02578	–	2,578	.1015	0,4	28	3
B976Z02600	–	2,600	.1024	0,4	28	3
B976Z02642	–	2,642	.1040	0,4	28	3
B976Z02705	–	2,705	.1065	0,4	28	3
B976Z02779	–	2,779	.1094	0,4	28	3
B976Z02800	–	2,800	.1102	0,5	28	3
B976Z02820	–	2,820	.1110	0,5	28	3
B976Z02870	–	2,870	.1130	0,5	28	3
B976Z02900	–	2,900	.1142	0,5	28	3
B976Z02947 *	–	2,947	.1160	0,5	28	3
B976A03000	B977A03000	3,000	.1181	0,5	36	6
B976A03100	B977A03100	3,100	.1220	0,5	36	6
B976A03175	B977A03175	3,175	.1250	0,5	36	6
B976A03180	–	3,180	.1252	0,5	36	6
B976A03200	B977A03200	3,200	.1260	0,5	36	6
–	B977A03250	3,250	.1280	0,5	36	6
B976A03300	B977A03300	3,300	.1299	0,5	36	6
–	B977A03400	3,400	.1339	0,6	36	6
B976A03454	B977A03454	3,454	.1360	0,6	36	6
B976A03500	B977A03500	3,500	.1378	0,6	36	6
B976A03600	B977A03600	3,600	.1417	0,6	36	6
B976A03700	B977A03700	3,700	.1457	0,6	36	6
B976A03734	B977A03734	3,734	.1470	0,6	36	6
B976A03797	B977A03797	3,797	.1495	0,6	36	6
B976A03800	B977A03800	3,800	.1496	0,6	36	6
B976A03900	B977A03900	3,900	.1535	0,6	36	6
B976A03970	B977A03970	3,970	.1563	0,7	36	6
B976A04000	B977A04000	4,000	.1575	0,7	36	6
B976A04039	B977A04039	4,039	.1590	0,7	36	6
B976A04100	B977A04100	4,100	.1614	0,7	36	6
B976A04200	B977A04200	4,200	.1654	0,7	36	6

(continued)

(B976A/B977A • ~3 x D/~5 x D — continued)



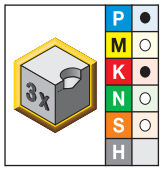


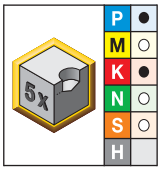
● first choice
○ alternate choice

short • KC7315	long • KC7315	D1 diameter mm	D1 diameter in	L5	LS	D
B976A04300	B977A04300	4,300	.1693	0,7	36	6
B976A04366	B977A04366	4,366	.1719	0,7	36	6
–	B977A04400	4,400	.1732	0,7	36	6
B976A04496	B977A04496	4,496	.1770	0,7	36	6
B976A04500	B977A04500	4,500	.1772	0,7	36	6
–	B977A04580	4,580	.1803	0,8	36	6
B976A04600	B977A04600	4,600	.1811	0,8	36	6
B976A04620	–	4,620	.1819	0,8	36	6
–	B977A04623	4,623	.1820	0,8	36	6
–	B977A04650	4,650	.1831	0,8	36	6
B976A04700	B977A04700	4,700	.1850	0,8	36	6
B976A04763	B977A04763	4,763	.1875	0,8	36	6
B976A04800	B977A04800	4,800	.1890	0,8	36	6
B976A04900	B977A04900	4,900	.1929	0,8	36	6
B976A05000	B977A05000	5,000	.1969	0,8	36	6
B976A05100	B977A05100	5,100	.2008	0,8	36	6
B976A05106	B977A05106	5,106	.2010	0,8	36	6
B976A05200	B977A05200	5,200	.2047	0,9	36	6
B976A05250	–	5,250	.2067	0,9	36	6
B976A05300	B977A05300	5,300	.2087	0,9	36	6
B976A05400	B977A05400	5,400	.2126	0,9	36	6
B976A05410	B977A05410	5,410	.2130	0,9	36	6
B976A05500	B977A05500	5,500	.2165	0,9	36	6
B976A05530	–	5,530	.2177	0,9	36	6
B976A05558	B977A05558	5,558	.2188	0,9	36	6
B976A05575	–	5,575	.2195	0,9	36	6
B976A05600	B977A05600	5,600	.2205	0,9	36	6
B976A05700	B977A05700	5,700	.2244	1,0	36	6
B976A05791	B977A05791	5,791	.2280	1,0	36	6
B976A05800	B977A05800	5,800	.2283	1,0	36	6
–	B977A05900	5,900	.2323	1,0	36	6
B976A05944	B977A05944	5,944	.2340	1,0	36	6
B976A06000	B977A06000	6,000	.2362	1,0	36	6
B976A06100	B977A06100	6,100	.2402	1,0	36	8
–	B977A06150	6,150	.2421	1,0	36	8
B976A06200	B977A06200	6,200	.2441	1,0	36	8
–	B977A06300	6,300	.2480	1,1	36	8
B976A06350	B977A06350	6,350	.2500	1,1	36	8
–	B977A06400	6,400	.2520	1,1	36	8
B976A06500	B977A06500	6,500	.2559	1,1	36	8
B976A06528	B977A06528	6,528	.2570	1,1	36	8
B976A06530	–	6,530	.2571	1,1	36	8
B976A06600	B977A06600	6,600	.2598	1,1	36	8
B976A06700	B977A06700	6,700	.2638	1,1	36	8
B976A06746	–	6,746	.2656	1,1	36	8
B976A06750	–	6,750	.2657	1,1	36	8
B976A06800	B977A06800	6,800	.2677	1,1	36	8
B976A06900	B977A06900	6,900	.2717	1,2	36	8
B976A06909	B977A06909	6,909	.2720	1,2	36	8
B976A07000	B977A07000	7,000	.2756	1,2	36	8
B976A07100	B977A07100	7,100	.2795	1,2	36	8
B976A07145	B977A07145	7,145	.2813	1,2	36	8

(continued)

(B976A/B977A • ~3 x D/~5 x D — continued)



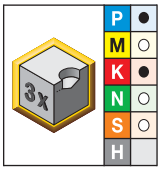


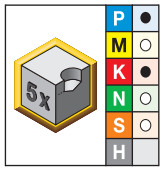
● first choice
○ alternate choice

short • KC7315	long • KC7315	D1 diameter mm	D1 diameter in	L5	LS	D
B976A07200	B977A07200	7,200	.2835	1,2	36	8
B976A07300	B977A07300	7,300	.2874	1,2	36	8
B976A07366	B977A07366	7,366	.2900	1,2	36	8
B976A07400	B977A07400	7,400	.2913	1,3	36	8
B976A07500	B977A07500	7,500	.2953	1,3	36	8
B976A07541	B977A07541	7,541	.2969	1,3	36	8
B976A07600	B977A07600	7,600	.2992	1,3	36	8
B976A07700	B977A07700	7,700	.3031	1,3	36	8
B976A07800	B977A07800	7,800	.3071	1,3	36	8
B976A07900	B977A07900	7,900	.3110	1,3	36	8
B976A07938	B977A07938	7,938	.3125	1,3	36	8
B976A08000	B977A08000	8,000	.3150	1,4	36	8
B976A08020	B977A08020	8,020	.3157	1,4	40	10
B976A08100	B977A08100	8,100	.3189	1,4	40	10
B976A08200	B977A08200	8,200	.3228	1,4	40	10
B976A08300	B977A08300	8,300	.3268	1,4	40	10
B976A08334	B977A08334	8,334	.3281	1,4	40	10
–	B977A08400	8,400	.3307	1,4	40	10
B976A08430	–	8,430	.3319	1,4	40	10
B976A08433	B977A08433	8,433	.3320	1,4	40	10
B976A08500	B977A08500	8,500	.3346	1,4	40	10
B976A08600	B977A08600	8,600	.3386	1,5	40	10
B976A08700	B977A08700	8,700	.3425	1,5	40	10
B976A08733	B977A08733	8,733	.3438	1,5	40	10
B976A08800	B977A08800	8,800	.3465	1,5	40	10
B976A08839	B977A08839	8,839	.3480	1,5	40	10
–	B977A08900	8,900	.3504	1,5	40	10
B976A09000	B977A09000	9,000	.3543	1,5	40	10
B976A09093	B977A09093	9,093	.3580	1,5	40	10
B976A09100	B977A09100	9,100	.3583	1,5	40	10
B976A09129	B977A09129	9,129	.3594	1,6	40	10
B976A09200	B977A09200	9,200	.3622	1,6	40	10
B976A09300	B977A09300	9,300	.3661	1,6	40	10
–	B977A09347	9,347	.3680	1,6	40	10
B976A09400	B977A09400	9,400	.3701	1,6	40	10
B976A09500	B977A09500	9,500	.3740	1,6	40	10
B976A09525	B977A09525	9,525	.3750	1,6	40	10
B976A09600	B977A09600	9,600	.3780	1,6	40	10
B976A09700	B977A09700	9,700	.3819	1,7	40	10
–	B977A09746	9,746	.3837	1,7	40	10
B976A09750	–	9,750	.3839	1,7	40	10
B976A09800	B977A09800	9,800	.3858	1,7	40	10
–	B977A09900	9,900	.3898	1,7	40	10
B976A09921	B977A09921	9,921	.3906	1,7	40	10
B976A10000	B977A10000	10,000	.3937	1,7	40	10
–	B977A10100	10,100	.3976	1,7	45	12
B976A10200	B977A10200	10,200	.4016	1,7	45	12
B976A10262	B977A10262	10,262	.4040	1,8	45	12
B976A10300	B977A10300	10,300	.4055	1,8	45	12
B976A10320	B977A10320	10,320	.4063	1,8	45	12
B976A10400	B977A10400	10,400	.4094	1,8	45	12
B976A10500	B977A10500	10,500	.4134	1,8	45	12

(continued)

(B976A/B977A • ~3 x D/~5 x D — continued)



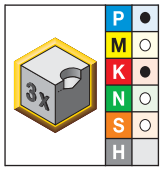


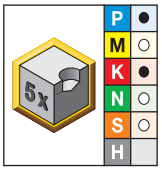
● first choice
○ alternate choice

short • KC7315	long • KC7315	D1 diameter mm	D1 diameter in	L5	LS	D
B976A10600	B977A10600	10,600	.4173	1,8	45	12
B976A10700	B977A10700	10,700	.4213	1,8	45	12
B976A10716	B977A10716	10,716	.4219	1,8	45	12
B976A10800	B977A10800	10,800	.4252	1,8	45	12
–	B977A10900	10,900	.4291	1,9	45	12
B976A11000	B977A11000	11,000	.4331	1,9	45	12
–	B977A11100	11,100	.4370	1,9	45	12
B976A11113	B977A11113	11,113	.4375	1,9	45	12
B976A11200	B977A11200	11,200	.4409	1,9	45	12
B976A11300	B977A11300	11,300	.4449	1,9	45	12
–	B977A11400	11,400	.4488	2,0	45	12
B976A11500	B977A11500	11,500	.4528	2,0	45	12
B976A11509	B977A11509	11,509	.4531	2,0	45	12
B976A11600	B977A11600	11,600	.4567	2,0	45	12
B976A11700	B977A11700	11,700	.4606	2,0	45	12
B976A11800	B977A11800	11,800	.4646	2,0	45	12
–	B977A11900	11,900	.4685	2,0	45	12
B976A11908	B977A11908	11,908	.4688	2,0	45	12
B976A12000	B977A12000	12,000	.4724	2,1	45	12
–	B977A12100	12,100	.4764	2,1	45	14
–	B977A12200	12,200	.4803	2,1	45	14
B976A12300	B977A12300	12,300	.4843	2,1	45	14
B976A12304	B977A12304	12,304	.4844	2,1	45	14
–	B977A12400	12,400	.4882	2,1	45	14
B976A12500	B977A12500	12,500	.4921	2,1	45	14
–	B977A12600	12,600	.4961	2,2	45	14
B976A12700	B977A12700	12,700	.5000	2,2	45	14
B976A12800	B977A12800	12,800	.5039	2,2	45	14
–	B977A12900	12,900	.5079	2,2	45	14
B976A13000	B977A13000	13,000	.5118	2,2	45	14
–	B977A13096	13,096	.5156	2,3	45	14
–	B977A13100	13,100	.5157	2,3	45	14
–	B977A13200	13,200	.5197	2,3	45	14
B976A13300	B977A13300	13,300	.5236	2,3	45	14
B976A13495	B977A13495	13,495	.5313	2,3	45	14
B976A13500	B977A13500	13,500	.5315	2,3	45	14
B976A13700	B977A13700	13,700	.5394	2,4	45	14
–	B977A13800	13,800	.5433	2,4	45	14
B976A14000	B977A14000	14,000	.5512	2,4	45	14
B976A14100	B977A14100	14,100	.5551	2,4	48	16
B976A14200	B977A14200	14,200	.5591	2,5	48	16
B976A14288	B977A14288	14,288	.5625	2,5	48	16
B976A14500	B977A14500	14,500	.5709	2,5	48	16
–	B977A14600	14,600	.5748	2,5	48	16
B976A14700	B977A14700	14,700	.5787	2,5	48	16
–	B977A14900	14,900	.5866	2,6	48	16
B976A15000	B977A15000	15,000	.5906	2,6	48	16
–	B977A15100	15,100	.5945	2,6	48	16
–	B977A15200	15,200	.5984	2,6	48	16
–	B977A15300	15,300	.6024	2,6	48	16
B976A15500	B977A15500	15,500	.6102	2,7	48	16
–	B977A15700	15,700	.6181	2,7	48	16

(continued)

(B976A/B977A • ~3 x D/~5 x D — continued)



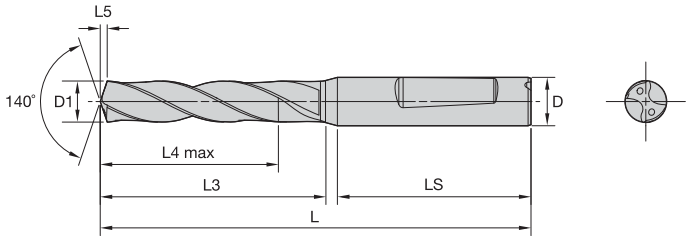


● first choice
○ alternate choice

short • KC7315	long • KC7315	D1 diameter mm	D1 diameter in	L5	LS	D
–	B977A15800	15,800	.6220	2,7	48	16
B976A15875	B977A15875	15,875	.6250	2,7	48	16
–	B977A15900	15,900	.6260	2,8	48	16
B976A16000	B977A16000	16,000	.6299	2,8	48	16
–	B977A16078	16,078	.6330	2,8	48	18
B976A16200	B977A16200	16,200	.6378	2,8	48	18
–	B977A16300	16,300	.6417	2,8	48	18
–	B977A16400	16,400	.6457	2,8	48	18
B976A16500	B977A16500	16,500	.6496	2,9	48	18
–	B977A16600	16,600	.6535	2,9	48	18
B976A16670	B977A16670	16,670	.6563	2,9	48	18
–	B977A16700	16,700	.6575	2,9	48	18
B976A16800	–	16,800	.6614	2,9	48	18
B976A17000	B977A17000	17,000	.6693	2,9	48	18
B976A17100	–	17,100	.6732	3,0	48	18
B976A17463	B977A17463	17,463	.6875	3,0	48	18
B976A17500	B977A17500	17,500	.6890	3,0	48	18
–	B977A17700	17,700	.6969	3,1	48	18
B976A18000	B977A18000	18,000	.7087	3,1	48	18
–	B977A18400	18,400	.7244	3,2	50	20
B976A18500	B977A18500	18,500	.7283	3,2	50	20
–	B977A18600	18,600	.7323	3,2	50	20
–	B977A18800	18,800	.7402	3,3	50	20
B976A19000	B977A19000	19,000	.7480	3,3	50	20
B976A19050	B977A19050	19,050	.7500	3,3	50	20
–	B977A19200	19,200	.7559	3,3	50	20
–	B977A19253	19,253	.7580	3,3	50	20
–	B977A19446	19,446	.7656	3,4	50	20
B976A19500	B977A19500	19,500	.7677	3,4	50	20
B976A19700	B977A19700	19,700	.7756	3,4	50	20
B976A19840 *	B977A19840	19,840	.7811	3,5	50	20
B976A20000	B977A20000	20,000	.7874	3,5	50	20
–	B977A21000	21,000	.8268	3,7	50	20

NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

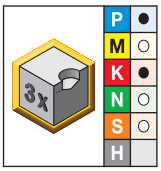


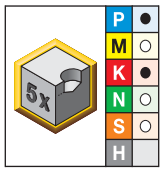




For information on L, L3, and L4 max, see the Solid Carbide Drills foldout table.

B976F/B977F • ~3 x D/~5 x D



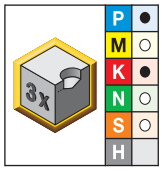


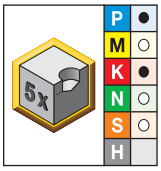
● first choice
○ alternate choice

short • KC7315	long • KC7315	D1 diameter mm	D1 diameter in	L5	LS	D
B976F03000	B977F03000	3,000	.1181	0,5	36	6
–	B977F03100	3,100	.1220	0,5	36	6
–	B977F03200	3,200	.1260	0,5	36	6
–	B977F03300	3,300	.1299	0,5	36	6
–	B977F03400	3,400	.1339	0,6	36	6
–	B977F03500	3,500	.1378	0,6	36	6
–	B977F03600	3,600	.1417	0,6	36	6
–	B977F03700	3,700	.1457	0,6	36	6
–	B977F03800	3,800	.1496	0,6	36	6
B976F03900 *	B977F03900	3,900	.1535	0,6	36	6
–	B977F04000	4,000	.1575	0,7	36	6
–	B977F04100	4,100	.1614	0,7	36	6
B976F04200 *	B977F04200	4,200	.1654	0,7	36	6
–	B977F04300	4,300	.1693	0,7	36	6
B976F04500 *	B977F04500	4,500	.1772	0,7	36	6
–	B977F04550	4,550	.1791	0,8	36	6
B976F04600 *	B977F04600	4,600	.1811	0,8	36	6
–	B977F04650	4,650	.1831	0,8	36	6
–	B977F04700	4,700	.1850	0,8	36	6
–	B977F04800	4,800	.1890	0,8	36	6
–	B977F04900	4,900	.1929	0,8	36	6
–	B977F05000	5,000	.1969	0,8	36	6
B976F05000	–	5,000	.1969	1,4	36	6
B976F05100 *	B977F05100	5,100	.2008	0,8	36	6
B976F05200 *	B977F05200	5,200	.2047	0,9	36	6
–	B977F05300	5,300	.2087	0,9	36	6
–	B977F05400	5,400	.2126	0,9	36	6
B976F05500	B977F05500	5,500	.2165	0,9	36	6
–	B977F05550	5,550	.2185	0,9	36	6
–	B977F05558	5,558	.2188	0,9	36	6
B976F05600	B977F05600	5,600	.2205	0,9	36	6
–	B977F05700	5,700	.2244	1,0	36	6

(continued)

(B976F/B977F • ~3 x D/~5 x D — continued)



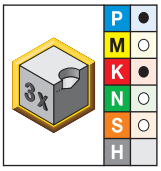


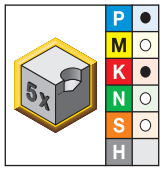
● first choice
○ alternate choice

short • KC7315	long • KC7315	D1 diameter mm	D1 diameter in	L5	LS	D
B976F05800	B977F05800	5,800	.2283	1,0	36	6
–	B977F05900	5,900	.2323	1,0	36	6
B976F06000	B977F06000	6,000	.2362	1,0	36	6
–	B977F06100	6,100	.2402	1,0	36	8
–	B977F06200	6,200	.2441	1,0	36	8
B976F06300	–	6,300	.2480	1,1	36	8
B976F06400	B977F06400	6,400	.2520	1,1	36	8
–	B977F06500	6,500	.2559	1,1	36	8
–	B977F06600	6,600	.2598	1,1	36	8
–	B977F06700	6,700	.2638	1,1	36	8
B976F06800	B977F06800	6,800	.2677	1,1	36	8
–	B977F06900	6,900	.2717	1,2	36	8
B976F07000	B977F07000	7,000	.2756	1,2	36	8
B976F07100	B977F07100	7,100	.2795	1,2	36	8
–	B977F07400	7,400	.2913	1,3	36	8
–	B977F07500	7,500	.2953	1,3	36	8
B976F07800	B977F07800	7,800	.3071	1,3	36	8
B976F08000	B977F08000	8,000	.3150	1,4	36	8
–	B977F08100	8,100	.3189	1,4	40	10
–	B977F08200	8,200	.3228	1,4	40	10
B976F08300 *	–	8,300	.3268	1,4	40	10
B976F08500	B977F08500	8,500	.3346	1,4	40	10
B976F08600 *	B977F08600	8,600	.3386	1,5	40	10
B976F08700	B977F08700	8,700	.3425	1,5	40	10
B976F08800 *	B977F08800	8,800	.3465	1,5	40	10
B976F09000	B977F09000	9,000	.3543	1,5	40	10
–	B977F09100	9,100	.3583	1,5	40	10
–	B977F09300	9,300	.3661	1,6	40	10
–	B977F09500	9,500	.3740	1,6	40	10
–	B977F09800	9,800	.3858	1,7	40	10
–	B977F09900	9,900	.3898	1,7	40	10
B976F10000	B977F10000	10,000	.3937	1,7	40	10
–	B977F10100 *	10,100	.3976	1,7	45	12
B976F10200	B977F10200	10,200	.4016	1,7	45	12
–	B977F10300	10,300	.4055	1,8	45	12
–	B977F10400	10,400	.4094	1,8	45	12
B976F10500 *	B977F10500	10,500	.4134	1,8	45	12
B976F10700 *	B977F10700	10,700	.4213	1,8	45	12
B976F10800	B977F10800	10,800	.4252	1,8	45	12
B976F11000	B977F11000	11,000	.4331	1,9	45	12
–	B977F11200	11,200	.4409	1,9	45	12
–	B977F11500	11,500	.4528	2,0	45	12
B976F11700	B977F11700	11,700	.4606	2,0	45	12
–	B977F11800	11,800	.4646	2,0	45	12
B976F12000	B977F12000	12,000	.4724	2,1	45	12
B976F12500	B977F12500	12,500	.4921	2,1	45	14
B976F12700 *	B977F12700	12,700	.5000	2,2	45	14
B976F13000	B977F13000	13,000	.5118	2,2	45	14

(continued)

(B976F/B977F • ~3 x D/~5 x D — continued)





● first choice
○ alternate choice

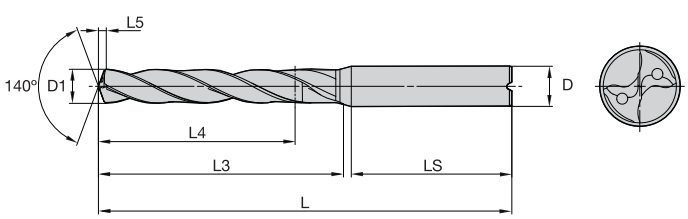
short • KC7315	long • KC7315	D1 diameter mm	D1 diameter in	L5	LS	D
B976F13500	**B977F13500**	13,500	.5315	2,3	45	14
B976F13700 *	–	13,700	.5394	2,4	45	14
–	**B977F13800** *	13,800	.5433	2,4	45	14
B976F14000	**B977F14000**	14,000	.5512	2,4	45	14
–	**B977F14200**	14,200	.5591	2,5	48	16
B976F14500 *	**B977F14500**	14,500	.5709	2,5	48	16
B976F15000	**B977F15000**	15,000	.5906	2,6	48	16
–	**B977F15200**	15,200	.5984	2,6	48	16
B976F15400	–	15,400	.6063	2,7	48	16
–	**B977F15500**	15,500	.6102	2,7	48	16
–	**B977F15700**	15,700	.6181	2,7	48	16
–	**B977F15800**	15,800	.6220	2,7	48	16
B976F16000	**B977F16000**	16,000	.6299	2,8	48	16
B976F16500	**B977F16500**	16,500	.6496	2,9	48	18
B976F17000	**B977F17000**	17,000	.6693	2,9	48	18
B976F17500	**B977F17500**	17,500	.6890	3,0	48	18
B976F18000	**B977F18000**	18,000	.7087	3,1	48	18
B976F18500	**B977F18500**	18,500	.7283	3,2	50	20
–	**B977F19000**	19,000	.7480	3,3	50	20
–	**B977F19500**	19,500	.7677	3,4	50	20
–	**B977F20000**	20,000	.7874	3,5	50	20
–	**B977F21000**	21,000	.8268	3,7	50	20

NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Tolerance • Metric

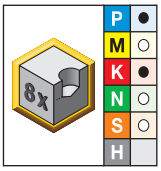
nominal size range	D1 tolerance m7	D tolerance h6
>3–6	0,004/0,016	0,000/-0,008
>6–10	0,006/0,021	0,000/-0,009
>10–18	0,007/0,025	0,000/-0,011
>18–25,4	0,008/0,029	0,000/-0,013







B978A • ~8 x D

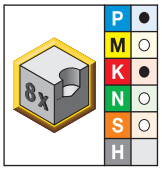


● first choice
○ alternate choice

extra long • KC7315	D1 diameter mm	in	L	L3	L4 max	L5	LS	D
B978A03000	3,000	.1181	78	40	33	0,6	36	6
B978A03300	3,300	.1299	78	40	33	0,7	36	6
B978A03400	3,400	.1339	78	40	33	0,7	36	6
B978A03600	3,600	.1417	78	40	33	0,7	36	6
B978A03700	3,700	.1457	78	40	33	0,8	36	6
B978A03800	3,800	.1496	87	49	41	0,8	36	6
B978A03970	3,970	.1563	87	49	41	0,8	36	6
B978A04000	4,000	.1575	87	49	41	0,8	36	6
B978A04200	4,200	.1654	87	49	41	0,9	36	6
B978A04500	4,500	.1772	87	49	41	0,9	36	6
B978A04600	4,600	.1811	87	49	41	0,9	36	6
B978A04763	4,763	.1875	94	56	48	1,0	36	6
B978A04800	4,800	.1890	94	56	48	1,0	36	6
B978A05000	5,000	.1969	94	56	48	1,0	36	6
B978A05100	5,100	.2008	94	56	48	1,1	36	6
B978A05200	5,200	.2047	94	56	48	1,1	36	6
B978A05300	5,300	.2087	94	56	48	1,1	36	6
B978A05500	5,500	.2165	94	56	48	1,1	36	6
B978A05558	5,558	.2188	94	56	48	1,2	36	6
B978A05600	5,600	.2205	94	56	48	1,2	36	6
B978A05700	5,700	.2244	94	56	48	1,2	36	6
B978A05800	5,800	.2283	94	56	48	1,2	36	6
B978A05900	5,900	.2323	94	56	48	1,2	36	6
B978A06000	6,000	.2362	94	56	48	1,2	36	6
B978A06100	6,100	.2402	105	67	57	1,3	36	8
B978A06200	6,200	.2441	105	67	57	1,3	36	8
B978A06300	6,300	.2480	105	67	57	1,3	36	8
B978A06350	6,350	.2500	105	67	57	1,3	36	8
B978A06400	6,400	.2520	105	67	57	1,3	36	8
B978A06500	6,500	.2559	105	67	57	1,4	36	8
B978A06600	6,600	.2598	105	67	57	1,4	36	8
B978A06700	6,700	.2638	105	67	57	1,4	36	8
B978A06746	6,746	.2656	105	67	57	1,4	36	8
B978A06800	6,800	.2677	105	67	57	1,4	36	8
B978A07000	7,000	.2756	105	67	57	1,5	36	8
B978A07145	7,145	.2813	110	72	61	1,5	36	8

(continued)

(B978A • ~8 x D — continued)

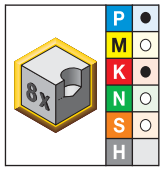


● first choice
○ alternate choice

extra long • KC7315	D1 diameter mm	in	L	L3	L4 max	L5	LS	D
B978A07400	7,400	.2913	110	72	61	1,6	36	8
B978A07500	7,500	.2953	110	72	61	1,6	36	8
B978A07541	7,541	.2969	110	72	61	1,6	36	8
B978A07700	7,700	.3031	110	72	61	1,6	36	8
B978A07800	7,800	.3071	110	72	61	1,6	36	8
B978A07938	7,938	.3125	110	72	61	1,7	36	8
B978A08000	8,000	.3150	110	72	61	1,7	36	8
B978A08100	8,100	.3189	122	80	68	1,7	40	10
B978A08200	8,200	.3228	122	80	68	1,7	40	10
B978A08334	8,334	.3281	122	80	68	1,8	40	10
B978A08500	8,500	.3346	122	80	68	1,8	40	10
B978A08600	8,600	.3386	122	80	68	1,8	40	10
B978A08700	8,700	.3425	122	80	68	1,8	40	10
B978A08733	8,733	.3438	122	80	68	1,8	40	10
B978A08800	8,800	.3465	122	80	68	1,9	40	10
B978A09000	9,000	.3543	122	80	68	1,9	40	10
B978A09100	9,100	.3583	122	80	68	1,9	40	10
B978A09129	9,129	.3594	122	80	68	1,9	40	10
B978A09300	9,300	.3661	122	80	68	2,0	40	10
B978A09500	9,500	.3740	122	80	68	2,0	40	10
B978A09525	9,525	.3750	122	80	68	2,0	40	10
B978A09700	9,700	.3819	122	80	68	2,0	40	10
B978A09750	9,750	.3839	122	80	68	2,1	40	10
B978A09800	9,800	.3858	122	80	68	2,1	40	10
B978A09900	9,900	.3898	122	80	68	2,1	40	10
B978A09921	9,921	.3906	122	80	68	2,1	40	10
B978A10000	10,000	.3937	122	80	68	2,1	40	10
B978A10100	10,100	.3976	141	94	79	2,1	45	12
B978A10200	10,200	.4016	141	94	79	2,2	45	12
B978A10300	10,300	.4055	141	94	79	2,2	45	12
B978A10320	10,320	.4063	141	94	79	2,2	45	12
B978A10500	10,500	.4134	141	94	79	2,2	45	12
B978A10716	10,716	.4219	141	94	79	2,3	45	12
B978A10800	10,800	.4252	141	94	79	2,3	45	12
B978A11000	11,000	.4331	141	94	79	2,3	45	12
B978A11113	11,113	.4375	141	94	79	2,4	45	12
B978A11200	11,200	.4409	141	94	79	2,4	45	12
B978A11300	11,300	.4449	141	94	79	2,4	45	12
B978A11400	11,400	.4488	141	94	79	2,4	45	12
B978A11500	11,500	.4528	141	94	79	2,4	45	12
B978A11509	11,509	.4531	141	94	79	2,4	45	12
B978A11700	11,700	.4606	141	94	79	2,5	45	12
B978A11800	11,800	.4646	141	94	79	2,5	45	12
B978A11908	11,908	.4688	141	94	79	2,5	45	12
B978A12000	12,000	.4724	141	94	79	2,5	45	12
B978A12304 *	12,304	.4844	155	108	91	2,6	45	14
B978A12500	12,500	.4921	155	108	91	2,7	45	14
B978A12700	12,700	.5000	155	108	91	2,7	45	14

(continued)

(B978A • ~8 x D — continued)



● first choice
○ alternate choice

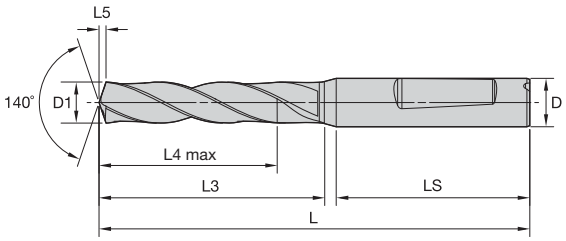
extra long • KC7315	D1 diameter mm	D1 diameter in	L	L3	L4 max	L5	LS	D
B978A12800	12,800	.5039	155	108	91	2,7	45	14
B978A13000	13,000	.5118	155	108	91	2,8	45	14
B978A13100	13,100	.5157	155	108	91	2,8	45	14
B978A13500	13,500	.5315	155	108	91	2,9	45	14
B978A14000	14,000	.5512	155	108	91	3,0	45	14
B978A14288	14,288	.5625	171	121	101	3,0	48	16
B978A14500	14,500	.5709	171	121	101	3,1	48	16
B978A15000	15,000	.5906	171	121	101	3,2	48	16
B978A15100	15,100	.5945	171	121	101	3,2	48	16
B978A15200	15,200	.5984	171	121	101	3,2	48	16
B978A15300	15,300	.6024	171	121	101	3,3	48	16
B978A15500	15,500	.6102	171	121	101	3,3	48	16
B978A15800	15,800	.6220	171	121	101	3,4	48	16
B978A15875	15,875	.6250	171	121	101	3,4	48	16
B978A16000	16,000	.6299	171	121	101	3,4	48	16
B978A16078	16,078	.6330	185	135	113	3,4	48	18
B978A16200	16,200	.6378	185	135	113	3,5	48	18
B978A16500	16,500	.6496	185	135	113	3,5	48	18
B978A17000	17,000	.6693	185	135	113	3,6	48	18
B978A17463	17,463	.6875	185	135	113	3,7	48	18
B978A17500	17,500	.6890	185	135	113	3,7	48	18
B978A18000	18,000	.7087	185	135	113	3,9	48	18
B978A18500	18,500	.7283	200	148	124	4,0	50	20
B978A19000	19,000	.7480	200	148	124	4,1	50	20
B978A19050 *	19,050	.7500	200	148	124	4,1	50	20
B978A19253 *	19,253	.7580	200	148	124	4,1	50	20
B978A19500 *	19,500	.7677	200	148	124	4,2	50	20
B978A19800	19,800	.7795	200	148	124	4,2	50	20
B978A19840	19,840	.7811	200	148	124	4,3	50	20
B978A20000	20,000	.7874	200	148	124	4,3	50	20

NOTE: The point angle on B978 series is 132°.
*Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Tolerance • Metric

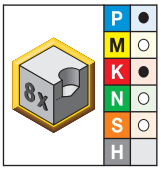
nominal size range	D1 tolerance m7	D tolerance h6
>3–6	0,004/0,016	0,000/-0,008
>6–10	0,006/0,021	0,000/-0,009
>10–18	0,007/0,025	0,000/-0,011
>18–25,4	0,008/0,029	0,000/-0,013







B978F • ~8 x D



● first choice
○ alternate choice

extra long • KC7315	D1 diameter mm	D1 diameter in	L	L3	L4 max	L5	LS	D
B978F03600	3,600	.1417	78	40	33	0,7	36	6
B978F04700 *	4,700	.1850	87	49	41	1,0	36	6
B978F05000	5,000	.1969	94	56	48	1,0	36	6
B978F06800	6,800	.2677	105	67	57	1,4	36	8
B978F07000	7,000	.2756	105	67	57	1,5	36	8
B978F07400 *	7,400	.2913	110	72	61	1,6	36	8
B978F07500	7,500	.2953	110	72	61	1,6	36	8
B978F08500	8,500	.3346	122	80	68	1,8	40	10
B978F09000	9,000	.3543	122	80	68	1,9	40	10
B978F09500	9,500	.3740	122	80	68	2,0	40	10
B978F10200	10,200	.4016	141	94	79	2,2	45	12
B978F12000	12,000	.4724	141	94	79	2,5	45	12
B978F12500 *	12,500	.4921	155	108	91	2,7	45	14
B978F13000	13,000	.5118	155	108	91	2,8	45	14
B978F14000	14,000	.5512	155	108	91	3,0	45	14
B978F14500 *	14,500	.5709	171	121	101	3,1	48	16
B978F15000	15,000	.5906	171	121	101	3,2	48	16
B978F16000	16,000	.6299	171	121	101	3,4	48	16
B978F17000 *	17,000	.6693	185	135	113	3,6	48	18
B978F17500	17,500	.6890	185	135	113	3,7	48	18
B978F18000 *	18,000	.7087	185	135	113	3,9	48	18
B978F20000 *	20,000	.7874	200	148	124	4,3	50	20

NOTE: The point angle on B978 series is 132°.
*Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Tolerance • Metric

nominal size range	D1 tolerance m7	D tolerance h6
>3–6	0,004/0,016	0,000/-0,008
>6–10	0,006/0,021	0,000/-0,009
>10–18	0,007/0,025	0,000/-0,011
>18–25,4	0,008/0,029	0,000/-0,013

Kenna Universal™ Drills • B97_Series • Grade KC7315™ • Through Coolant • Drill Diameters 2–20mm • Metric

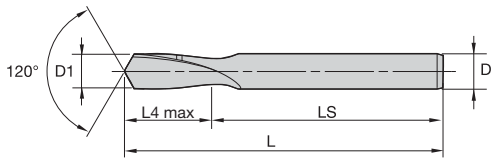




Material Group		Cutting Speed — vc Range — m/min			Metric Recommended Feed Rate (f) by Diameter									
		min	Starting Value	max		2,0	3,0	4,0	6,0	8,0	10,0	12,0	16,0	20,0
P	0	80	**120**	160	mm/r	0,04–0,10	0,06–0,12	0,07–0,14	0,09–0,19	0,11–0,22	0,13–0,26	0,15–0,30	0,19–0,36	0,24–0,46
	1	70	**100**	140	mm/r	0,05–0,12	0,07–0,14	0,08–0,16	0,11–0,22	0,13–0,26	0,15–0,31	0,18–0,35	0,22–0,42	0,28–0,54
	2	90	**120**	140	mm/r	0,05–0,12	0,07–0,14	0,08–0,16	0,12–0,22	0,14–0,26	0,17–0,31	0,20–0,35	0,24–0,42	0,31–0,53
	3	60	**80**	100	mm/r	0,06–0,13	0,08–0,15	0,09–0,17	0,13–0,23	0,15–0,28	0,19–0,33	0,22–0,38	0,26–0,47	0,34–0,59
	4	50	**80**	100	mm/r	0,06–0,13	0,07–0,15	0,08–0,17	0,12–0,23	0,14–0,28	0,17–0,33	0,19–0,38	0,23–0,47	0,29–0,59
	5	50	**60**	80	mm/r	0,06–0,12	0,08–0,13	0,10–0,15	0,12–0,19	0,16–0,24	0,20–0,27	0,24–0,30	0,28–0,38	0,32–0,44
	6	40	**50**	70	mm/r	0,04–0,06	0,05–0,08	0,06–0,10	0,08–0,14	0,10–0,18	0,13–0,22	0,14–0,24	0,18–0,32	0,23–0,41
M	1	30	**40**	50	mm/r	0,03–0,06	0,04–0,07	0,05–0,09	0,08–0,11	0,09–0,12	0,10–0,14	0,12–0,16	0,14–0,18	0,16–0,20
	2	40	**50**	60	mm/r	0,03–0,07	0,04–0,08	0,06–0,10	0,08–0,12	0,09–0,14	0,10–0,16	0,12–0,18	0,14–0,20	0,16–0,22
	3	30	**40**	50	mm/r	0,03–0,06	0,04–0,07	0,05–0,09	0,08–0,11	0,09–0,12	0,10–0,14	0,12–0,16	0,14–0,18	0,16–0,20
K	1	80	**120**	170	mm/r	0,09–0,17	0,11–0,22	0,12–0,24	0,16–0,31	0,20–0,38	0,23–0,44	0,25–0,49	0,31–0,60	0,38–0,74
	2	80	**110**	140	mm/r	0,11–0,15	0,12–0,16	0,13–0,19	0,16–0,25	0,20–0,31	0,23–0,36	0,25–0,40	0,31–0,48	0,38–0,60
	3	80	**100**	130	mm/r	0,07–0,15	0,08–0,17	0,09–0,19	0,12–0,25	0,14–0,30	0,17–0,35	0,19–0,40	0,24–0,48	0,30–0,60
N	1	90	**230**	315	mm/r	0,06–0,13	0,08–0,14	0,10–0,16	0,12–0,20	0,16–0,24	0,20–0,28	0,24–0,32	0,28–0,40	0,32–0,48
	2	90	**225**	270	mm/r	0,06–0,12	0,08–0,16	0,10–0,20	0,12–0,24	0,16–0,28	0,20–0,32	0,24–0,36	0,28–0,44	0,32–0,52
	3	90	**180**	270	mm/r	0,11–0,14	0,12–0,14	0,13–0,16	0,14–0,20	0,16–0,24	0,20–0,28	0,24–0,32	0,28–0,40	0,32–0,44
	4	90	**135**	180	mm/r	0,06–0,12	0,08–0,16	0,01–0,20	0,12–0,24	0,16–0,28	0,20–0,32	0,24–0,36	0,28–0,40	0,32–0,48
S	1	10	**25**	30	mm/r	0,02–0,05	0,03–0,06	0,04–0,08	0,06–0,10	0,08–0,12	0,09–0,13	0,10–0,14	0,12–0,16	0,14–0,18
	2	10	**20**	25	mm/r	0,02–0,03	0,02–0,04	0,03–0,06	0,05–0,08	0,07–0,10	0,08–0,11	0,09–0,12	0,10–0,14	0,11–0,16
	3	10	**25**	30	mm/r	0,02–0,03	0,02–0,04	0,02–0,05	0,04–0,07	0,06–0,09	0,07–0,10	0,08–0,11	0,09–0,13	0,10–0,15
	4	10	**25**	40	mm/r	0,02–0,03	0,02–0,04	0,03–0,06	0,05–0,08	0,07–0,10	0,08–0,11	0,09–0,12	0,10–0,14	0,11–0,16

KENNAMETAL®









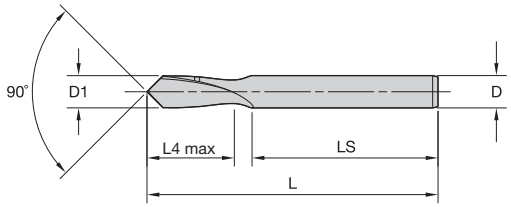
B501 • 120°



● first choice
○ alternate choice

D1 diameter

B501 • K10	mm	in	L	L4 max	LS	D
B501Z04000	4,000	.1575	54	7	33	6
B501Z06000	6,000	.2362	54	9	33	6
B501Z10000	10,000	.3937	66	12	45	10
B501Z12000	12,000	.4724	73	14	52	12







B505 • 90°



● first choice
○ alternate choice

D1 diameter

B505 • K10	mm	in	L	L4 max	LS	D
B505Z04000	4,000	.1575	54	7	33	4
B505Z06000	6,000	.2362	54	9	33	6
B505Z08000	8,000	.3150	58	11	37	8
B505Z10000	10,000	.3937	66	12	40	10
B505Z12000	12,000	.4724	73	14	52	12
B505Z16000	16,000	.6299	82	16	61	16
B505Z20000	20,000	.7874	92	18	71	20

Tolerance • Metric

D1	tolerance h8	tolerance h6
>3-6	0,000/-0,018	0,000/-0,008
>6-10	0,000/-0,022	0,000/-0,009
>10-18	0,000/-0,027	0,000/-0,011

Non-Coolant Spot Drills • B50_ Series • Grade K10 • Dry and Flood Coolant Drill • Diameters 3–20mm • Metric





Material Group		Cutting Speed — vc Range — m/min			Metric Recommended Feed Rate (f) by Diameter								
		min	Starting Value	max		3,0	4,0	6,0	8,0	10,0	12,0	16,0	20,0
P	0	50	**65**	100	mm/r	0,05–0,10	0,06–0,12	0,08–0,14	0,10–0,16	0,12–0,18	0,14–0,20	0,16–0,24	0,18–0,28
	1	40	**55**	80	mm/r	0,05–0,10	0,06–0,12	0,08–0,14	0,10–0,16	0,12–0,18	0,14–0,20	0,16–0,24	0,18–0,28
	2	40	**55**	80	mm/r	0,05–0,10	0,06–0,12	0,08–0,14	0,10–0,16	0,12–0,18	0,14–0,20	0,16–0,24	0,18–0,28
	3	40	**55**	80	mm/r	0,05–0,10	0,06–0,12	0,08–0,14	0,10–0,16	0,12–0,18	0,14–0,20	0,16–0,24	0,18–0,28
	4	40	**55**	80	mm/r	0,05–0,08	0,05–0,10	0,06–0,12	0,08–0,14	0,10–0,16	0,12–0,18	0,14–0,22	0,16–0,24
	5	30	**40**	60	mm/r	0,03–0,05	0,03–0,06	0,04–0,08	0,06–0,10	0,08–0,12	0,10–0,14	0,12–0,18	0,14–0,20
	6	30	**40**	60	mm/r	0,03–0,05	0,03–0,06	0,04–0,08	0,06–0,10	0,08–0,12	0,10–0,14	0,12–0,18	0,14–0,20
M	1	30	**35**	50	mm/r	0,04–0,07	0,05–0,09	0,06–0,11	0,80–0,13	0,09–0,15	0,10–0,17	0,11–0,20	0,12–0,23
	2	30	**40**	50	mm/r	0,03–0,05	0,04–0,08	0,05–0,09	0,06–0,10	0,07–0,12	0,08–0,14	0,09–0,17	0,10–0,20
	3	25	**30**	40	mm/r	0,03–0,05	0,04–0,08	0,05–0,09	0,06–0,10	0,07–0,12	0,08–0,14	0,09–0,17	0,10–0,20
K	1	60	**90**	120	mm/r	0,06–0,12	0,08–0,14	0,10–0,16	0,12–0,18	0,14–0,20	0,16–0,22	0,18–0,26	0,20–0,30
	2	60	**80**	100	mm/r	0,06–0,12	0,08–0,14	0,10–0,16	0,12–0,18	0,14–0,20	0,16–0,22	0,18–0,26	0,20–0,30
	3	60	**90**	120	mm/r	0,06–0,12	0,08–0,14	0,10–0,16	0,12–0,18	0,14–0,20	0,16–0,22	0,18–0,26	0,20–0,30
N	1	90	**230**	270	mm/r	0,06–0,13	0,08–0,15	0,10–0,18	0,12–0,25	0,15–0,28	0,18–0,32	0,20–0,34	0,22–0,38
	2	90	**220**	270	mm/r	0,06–0,13	0,08–0,15	0,10–0,18	0,12–0,25	0,15–0,28	0,18–0,32	0,20–0,34	0,22–0,38
	3	90	**180**	225	mm/r	0,06–0,13	0,08–0,15	0,10–0,18	0,12–0,25	0,15–0,28	0,18–0,32	0,20–0,34	0,22–0,38
	4	90	**130**	270	mm/r	0,06–0,13	0,08–0,15	0,10–0,18	0,12–0,25	0,15–0,28	0,18–0,32	0,20–0,34	0,22–0,38
S	1	20	**25**	30	mm/r	0,03–0,05	0,04–0,07	0,05–0,09	0,06–0,10	0,07–0,11	0,08–0,13	0,09–0,16	0,10–0,20
	2	10	**20**	30	mm/r	0,03–0,05	0,04–0,07	0,05–0,09	0,06–0,10	0,07–0,11	0,08–0,13	0,09–0,16	0,10–0,20
	3	20	**25**	40	mm/r	0,03–0,05	0,04–0,07	0,05–0,09	0,06–0,10	0,07–0,11	0,08–0,13	0,09–0,16	0,10–0,20
	4	20	**25**	50	mm/r	0,03–0,05	0,04–0,07	0,05–0,09	0,06–0,10	0,07–0,11	0,08–0,13	0,09–0,16	0,10–0,20



Modular Drills

Introduction **H2–H5**

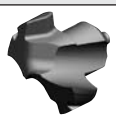
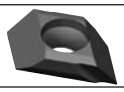
KenTIP FS **H6–H23**

KenTIP **H24–H37**

KSEM **H38–H77**

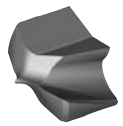
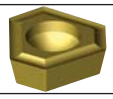
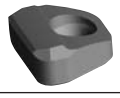
Tube Sheet Grooving Tool H74–H77

KSEM PLUS **H78–H106**

modular drills with internal coolant channel		grade/series	standard* ● first choice ○ alternate choice P	M	K	N	S	H	hole tolerance	standard range diameter range D1 mm min–max	D1 inch min–max	drilling depth L/D1
KenTIP™ FS For smaller diameters. Easy front clamping and disposable inserts.												
	**KenTIP FS inserts**	**KCP15A HPG**	●		○				IT9–IT11	6,00–26,00	.2362–1.0236	—
		KC7410 HPC			●							
		KCMS15 HPL		●								
	**KenTIP FS bodies**	**SS SF SCF**	—						—	6,00≤Ø<9,50	.2362≤Ø<.3740	1.5–12 x D
										9,50≤Ø<11,00	.3740≤Ø<.4331	
										11,00≤Ø<12,50	.4331≤Ø<.4921	
										12,50≤Ø<14,00	.4921≤Ø<.5512	
										14,00≤Ø<15,50	.5512≤Ø<.6102	
										15,50≤Ø<16,50	.6102≤Ø<.6496	
										16,50≤Ø<20,00	.6496≤Ø<.7874	
										20,00≤Ø<21,00	.7874≤Ø<.8268	SCF shank only
										21,00≤Ø<26,00	.8268≤Ø<1.0236	
KenTIP™												
	**KenTIP inserts**	**KCP15 HP**	●		○				IT9–IT11	7,94–27,99	.3125–1.1020	—
		KCPM45™ FEG	●	○	○					7,94–27,99	.3125–.7874	
	**FAS chamfering inserts**	**KC7014 FAS-GD**	○	○	○	●	○			Made-to-order toolholders required. Also available for KenTIP FS.		
		KC7215 FAS-GD	●	○	●	○	●					
	**CFM tangential chamfering and counterboring**	**KCU40 CFM-HP**	●	○	○	●	●					
	**KenTIP bodies**	**SS SCF**	—						—	7,94≤Ø<9,50	.3125≤Ø<.3740	1.5–12 x D
										9,50≤Ø<11,00	.3740≤Ø<.4331	
										11,00≤Ø<12,50	.4331≤Ø<.4921	
										12,50≤Ø<14,00	.4921≤Ø<.5512	
										14,00≤Ø<15,50	.5512≤Ø<.6102	
										15,50≤Ø<16,50	.6102≤Ø<.6496	
										16,50≤Ø<20,50	.6496≤Ø<.8071	
										20,50≤Ø<21,00	.8071≤Ø<.8268	
										21,00≤Ø<27,99	.8268≤Ø<1.1020	

■ Standard Product
□ Engineered Solutions

engineered solution range / diameter range			coolant	drilling	inclined exit	stacked plates	flat bottom	countersinking	counterboring	cross hole	2 flute 2 margin cooled	2 flute 4 margin cooled	corner chamfer	plain shank ≤H6	Whistle Notch 2°	WD shank	flat shank	SSF shank	KM™ shank	HSK shank	page(s)
D1 mm min–max	**D1 inch min–max**	**max drilling depth**																			
KenTIP™ FS For smaller diameters. Easy front clamping and disposable inserts. *(continued)*																					
6,00–26,00	.2362–1.0236	—		■	■	■		□	□	■	■	□	□								H8
			■	■	■			□	□	■		■	■								
			■	■	■			□	□	■	■	□	□								
6,00≤Ø<9,50	.2362≤Ø<.3740	12 x D	■					□	□					■	□	□	■	□	□	□	H16
9,50≤Ø<11,00	.3740≤Ø<.4331	13 x D	■					□	□					■	□	□	■	□	□	□	
11,00≤Ø<12,50	.4331≤Ø<.4921	14 x D	■					□	□					■	□	□	■	□	□	□	
12,50≤Ø<14,00	.4921≤Ø<.5512	15 x D	■					□	□					■	□	□	■	□	□	□	
14,00≤Ø<15,50	.5512≤Ø<.6102	16 x D	■					□	□					■	□	□	■	□	□	□	
15,50≤Ø<16,50	.6102≤Ø<.6496	17 x D	■					□	□					■	□	□	■	□	□	□	
16,50≤Ø<20,00	.6496≤Ø<.7874	18 x D	■					□	□					■	□	□	■	□	□	□	
20,00≤Ø<21,00	.7874≤Ø<.8268	20 x D	■					□	□					■	□	□	■	□	□	□	
21,00≤Ø<26,00	.8268≤Ø<1.0236	550mm	■					□	□					■	□	□	■	□	□	□	
KenTIP™ *(continued)*																					
7,94–27,99	.3125–1.1020	—		■	□						■	□	□								H26
				■	■			■	■	■	□	■	■								
12,50–36,01	.4921–1.4177							■													H33
								■													
10,00–31,20	.3937–1.2283							■	■												H34
7,94≤Ø<9,50	.3125≤Ø<.3740	12 x D	■					□**	□					■	□	□	■	□	□	□	H31
9,50≤Ø<11,00	.3740≤Ø<.4331	13 x D	■					□**	□					■	□	□	■	□	□	□	
11,00≤Ø<12,50	.5424≤Ø<.4921	14 x D	■					□**	□					■	□	□	■	□	□	□	
12,50≤Ø<14,00	.4921≤Ø<.5512	15 x D	■					□**	□					■	□	□	■	□	□	□	
14,00≤Ø<15,00	.5512≤Ø<.6102	16 x D	■					□**	□					■	□	□	■	□	□	□	
15,50≤Ø<16,50	.6102≤Ø<.6496	17 x D	■					□**	□					■	□	□	■	□	□	□	
16,50≤Ø<20,50	.6496≤Ø<.8070	18 x D	■					□**	□					■	□	□	■	□	□	□	
20,50≤Ø<21,00	.8070≤Ø<.8267	20 x D	■					□**	□					■	□	□	■	□	□	□	
21,00≤Ø<28,00	.8267≤Ø<1.1024	550mm	■					□**	□					■	□	□	■	□	□	□	

modular drills with internal coolant channel		grade/series	standard* ● first choice ○ alternate choice P	M	K	N	S	H	hole tolerance	standard range diameter range D1 mm min–max	D1 inch min–max	drilling depth L/D1
KSEM™ For larger diameters. Very robust pocket and regrindable inserts.												
	KSEM inserts	KC7315 HP/HPG	●		○				IT9–IT11	12,50–40,00	.4921–1.5748	—
		KCPM45 HPG	●	○						12,50–40,00	.4921–1.5748	
		KC7410 HPCCL			●					12,70–40,00	.5000–1.5748	
		KC7320 HPL		●						12,50–40,00	.4921–1.5748	
		KCMS35 SPL	○	●		○	●			12,50–40,00	.4921–1.5748	
		KCPM45 FEG	●	○	○		○			16,00–40,00	.6230–1.5748	
		KC7135 PC	●		●					12,50–40,00	.4921–1.5748	
	chamfering inserts	KC7015 TPGX-GD		●		○				12,50–40,00	.4921–1.5748	—
		KC7140 TPGX-GD	●	○	○	●	○					
		KC7315™ TPGX-GD	○	○	●	○	●					
	KSEM bodies	WN (Metric), SS (inch), SSF (inch)	—						—	12,50≤Ø<16,50	.4921≤Ø<.6496	1–10 x D (SSF only up to 8 x D) (WN only up to Ø32mm)
										16,50≤Ø<20,00	.6496≤Ø<.7874	
										20,00≤Ø≤32,00	.7874≤Ø≤1.2598	
		WD (Metric)	—						—	32,00<Ø≤40,00	1.2598<Ø≤1.5748	1–5 x D
		WN, SSF with chamfer	—						—	12,50≤Ø<16,50	.4921≤Ø<.6496	1 x D
										16,50≤Ø<20,00	.6496≤Ø<.7874	
										20,00≤Ø≤32,00	.7874<Ø≤1.2598	
		WD, SSF with chamfer	—						—	32,00<Ø≤40,00	1.2598<Ø<1.5748	1 x D
KSEM PLUS™ High-performance drilling for the largest diameters.												
	KSEM PLUS heads	A1 style							IT9–IT11	28,00<Ø≤101,40	1.1020<Ø≤4.0000	—
		B1 style										
	KSEM PLUS centre inserts	KSEMP KC7315 HPG	●	●	○	○	○			13,00–40,00 mm PDD reference only		
		KSEM KC7410 HPCCL			●							
		KSEM KC7135 PC		●								
	DFR™ inserts	KCU25 DFR-GD	●	○	●	○	○			DFR inserts for A1 Heads with FDS28		—
		KCU40 DFR-GD	●	○	○	○	●			28,00–31,00	1.1024–1.2204	
		KC7140 DFR-MD	●	●	○	○	○					
		KC7225 DFR-LD	○	○	●	●	○					
	DFT™ inserts	KCU25 DFT-HP	●	○	●	○	○			DFT inserts for A1 Heads FDS32 and above		
		KCU40 DFT-HP	●	○	○	○	●			31,75–101,40	1.2500–4.0000	
		KCU40 DFC-DS	●	○		○	○					
		KC7140 DFT-MD	●	●	○	○	○					
	DFC™ inserts (B1 Heads)	KCU25 DFC-HP	●	○	●	○	○			DFC inserts for B1 Heads, all FDS sizes		
		KCU40 DFC-HP	●	○	○	○	●			28,00–101,40	1.1024–4.0000	
		KCU40 DFC-DS	●	○		○	○					
		KC7140 DFC-MD	●	●	○	○	○					
	DPA guide pads (B1 Heads)	KCU40 DPA	—							Available for all standard B1 Head Diameters		
	KSEM PLUS bodies	WD (Metric)	—						—	28,00≤Ø≤70,00	1.1024≤Ø≤2.7560	1.5–10 x D
		SSF (Inch)								70,00≤Ø≤101,40	2.7560≤Ø≤4.0000	1.5–5 x D

* Apart from our standard drills, we can offer you a wide variety of special coating solutions and edge preparations to fulfill all your needs. If a specific drill is not suitable for your workpiece material, please contact our **Engineered Solutions Department**.

■ Standard Product
□ Engineered Solutions

engineered solution range / diameter range			coolant	drilling	inclined exit	stacked plates	flat bottom	countersinking	counterboring	cross hole	2 flute 2 margin cooled	2 flute 4 margin cooled	corner chamfer	plain shank ≤H6	Whistle Notch 2°	WD shank	flat shank	SSF shank	KM™ shank	HSK shank	page(s)
D1 mm min–max	D1 inch min–max	max drilling depth																			
KSEM™ For larger diameters. Very robust pocket and regrindable inserts. *(continued)*																					
12,50–40,00	.4921–1.5748	—		■	■	■					■	□	□								H40
				■	■	■				■	■	□	□								
				■	■	■					■	□	■								
				■	■						■	□	□								
				■	■	■				■	■	□	□								
				■	■	■	■	■	■	■	□	■	■								
				■	■	■					■	□	■								
12,50–40,00	.4921–1.5748	—						■													H63
								■													
								■													
12,50≤Ø<16,50	.4921≤Ø<.6496	15 x D	■					□	□	□				■	■	□	□	■	□	□	H58
16,50≤Ø<20,00	.6496≤Ø<.7874	18 x D	■					□	□	□				■	■	□	□	■	□	□	
20,00≤Ø≤40,00	.7874≤Ø≤1.5748	20 x D	■					□	□	□				■	■	□	□	■	□	□	
32,00<Ø≤40,00	1.2598<Ø≤1.5748	20 x D (max 800mm)	■					□	□	□				□	□	■	□	□	□	□	
12,50≤Ø<16,50	.4921≤Ø<.6496	chamfer step drills available as custom solutions in various lengths	■					■	□	□				□	■	□	□	□	□	□	
16,50≤Ø<20,00	.6496≤Ø<.7874		■					■	□	□				□	■	□	□	□	□	□	
20,00≤Ø≤32,00	.7874≤Ø≤1.2598		■					■	□	□				□	■	□	□	■	□	□	
32,00<Ø≤40,00	1.2598<Ø≤1.5748		■					■	□	□				□		■	□	■	□	□	
KSEM PLUS™ High-performance drilling for the largest diameters. *(continued)*																					
28,00<Ø≤127,00	1.1020<Ø≤5.0000	—	■	■			□	□	□		■	□ (DPA)									H91
			■	■	■	■	□	□	□	■		■									
13,00–40,00 mm PDD reference only																					H87
DFR inserts for A1 Heads with FDS28																					H89
28,00≤Ø<31,75	1.1024≤Ø<1.2500																				
DFT inserts for A1 Heads FDS32 and above																					H88
31,75≤Ø≤127,00	1.2500≤Ø≤5.0000																				
DFC inserts for B1 Heads, all FDS sizes																					H90
28,00≤Ø≤127,00	1.1024≤Ø≤5.0000																				
DPA are supporting various solutions				■	■	■	□			■											H90
28,00≤Ø≤127,00	1.1020≤Ø≤5.0000	3–20 x D (max 1250mm)	■					□	□	□				□		■	□	■	□	□	H102

** Alternative chamfering solutions are available in combination with SEFAS™ or BF; see page I1.
Please use this table for orientation purposes only. Detailed information on available products (inserts, toolholders, etc.) can be found on the indicated pages of this catalogue.

KenTIP™ FS

The Perfect Fusion of a Solid Carbide and an Indexable Drill

The new modular drill KenTIP FS covers more applications and provides better performance than any other modular system, delivering substantial cost savings and process simplifications on your shop floor.

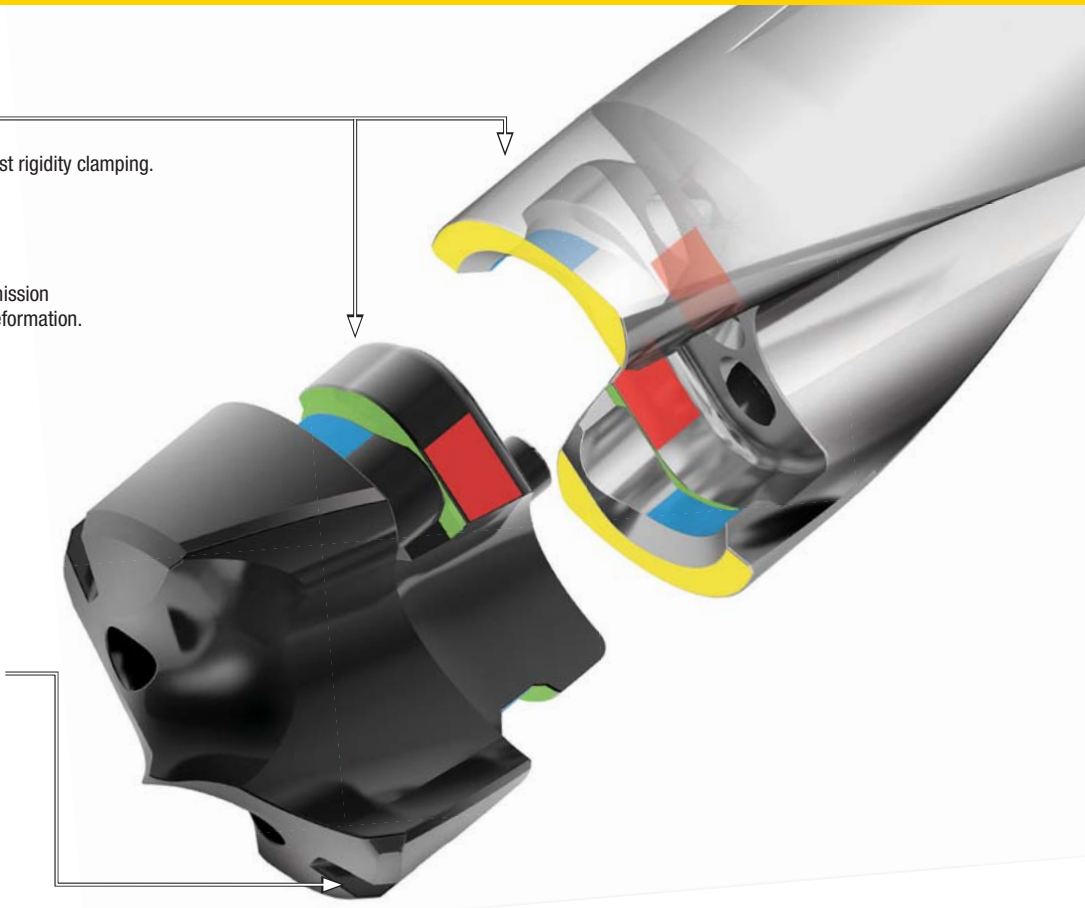
3-point geometries, 3 high-performance grades, 3 different shank styles.
This modular drilling system covers a 6–26mm diameter range.
Up to 12 x D drilling depths.
Applicable in steel, stainless steel, and cast iron.

Intelligent Interface

- Taper interface uniquely designed for highest rigidity clamping.
- Retention lock prevents insert pullout.
- Large bearing surface positioned for transmission of highest torsional loads without pocket deformation.
- Large face contact surface.

Maximum performance and long tool life, even in unstable conditions.

Quick Release
Every drill body comes with a KenTIP smart wrench. Insert exchange in the machine becomes easy and saves idle time. And that saves money.



Recycling Instead of Reconditioning
KenTIP™ FS provides the same stable and repeatable performance with every new insert. Lower your operational expenses with less tooling inventory and simplified processes. Recoup cost by providing your used carbide inserts to our recycling service.

Fast Flow
Large, ultra-high polished chip flutes guarantee hassle-free chip evacuation, enhancing tool life and performance.

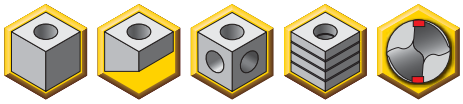
Multi-Coolant
Coolant delivery to the drill point and to the rake face for guaranteed coolant delivery where it is needed.

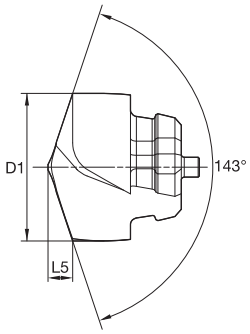
Unique Point Geometries
3 material-specific, self-centering point designs enable excellent hole quality and optimum tool performance.



Full Solid Carbide Front
KenTIP FS inserts cover the entire front part of the drill. The coupling is completely protected from chip flow and contact with workpiece.

- HPG-point geometry for steels.
- Great positioning and centring capabilities for drilling without precentring, even in deeper holes.
- KCP15A™ is an AlTiN PVD monolayer coating.
- Enhanced thermal stability.
- Excellent balance between toughness and wear resistance.
- Without internal coolant.

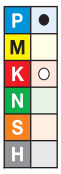




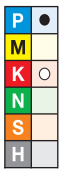


HPG Geometry

KenTIP FS Inserts • HPG KCP15A • No Internal Coolant Channels



KCP15A	D1 mm	D1 in	L5 mm	L5 in	seat size
KTFSS06000HPGM	6,000	.2362	1,370	.0539	A
KTFSS06100HPGM	6,100	.2402	1,380	.0543	A
KTFSS06200HPGM	6,200	.2441	1,400	.0551	A
KTFSS06300HPGM	6,300	.2480	1,440	.0567	B
KTFSS06350HPGM	6,350	.2500	1,450	.0571	B
KTFSS06400HPGM *	6,400	.2520	1,450	.0571	B
KTFSS06500HPGM	6,500	.2559	1,470	.0579	B
KTFSS06530HPGM	6,530	.2571	1,480	.0583	B
KTFSS06600HPGM	6,600	.2598	1,490	.0587	C
KTFSS06629HPGM *	6,629	.2610	1,500	.0591	C
KTFSS06700HPGM	6,700	.2638	1,510	.0594	C
KTFSS06746HPGM	6,746	.2656	1,520	.0598	C
KTFSS06800HPGM	6,800	.2677	1,530	.0602	C
KTFSS06900HPGM *	6,900	.2717	1,540	.0606	C
KTFSS06909HPGM	6,909	.2720	1,540	.0606	C
KTFSS07000HPGM	7,000	.2756	1,590	.0626	D
KTFSS07100HPGM *	7,100	.2795	1,610	.0634	D
KTFSS07145HPGM	7,145	.2813	1,610	.0634	D
KTFSS07200HPGM *	7,200	.2835	1,620	.0638	D
KTFSS07366HPGM	7,366	.2900	1,650	.0650	D
KTFSS07400HPGM	7,400	.2913	1,660	.0654	D
KTFSS07500HPGM	7,500	.2953	1,680	.0661	E
KTFSS07541HPGM	7,541	.2969	1,690	.0665	E
KTFSS07600HPGM *	7,600	.2992	1,700	.0669	E
KTFSS07700HPGM *	7,700	.3031	1,710	.0673	E
KTFSS07800HPGM *	7,800	.3071	1,730	.0681	E
KTFSS07900HPGM *	7,900	.3110	1,750	.0689	E
KTFSS07938HPGM	7,938	.3125	1,750	.0689	E
KTFSS08000HPGM	8,000	.3150	1,800	.0709	F
KTFSS08100HPGM	8,100	.3189	1,820	.0717	F
KTFSS08164HPGM	8,164	.3214	1,830	.0720	F
KTFSS08204HPGM	8,204	.3230	1,840	.0724	F
KTFSS08300HPGM	8,300	.3268	1,850	.0728	F
KTFSS08334HPGM	8,334	.3281	1,860	.0732	F
KTFSS08400HPGM	8,400	.3307	1,870	.0736	F
KTFSS08433HPGM	8,433	.3320	1,870	.0736	F
KTFSS08500HPGM	8,500	.3346	1,890	.0744	G
KTFSS08600HPGM	8,600	.3386	1,910	.0752	G
KTFSS08611HPGM *	8,611	.3390	1,910	.0752	G
KTFSS08700HPGM	8,700	.3425	1,920	.0756	G

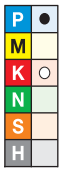


● first choice
○ alternate choice

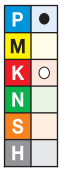
KCP15A	D1 mm	D1 in	L5 mm	L5 in	seat size
KTFSS08733HPGM	8,732	.3438	1,930	.0760	G
KTFSS08800HPGM	8,800	.3465	1,940	.0764	G
KTFSS08839HPGM *	8,839	.3480	1,950	.0768	G
KTFSS08900HPGM *	8,900	.3504	1,960	.0772	G
KTFSS09000HPGM	9,000	.3543	2,010	.0791	H
KTFSS09093HPGM *	9,093	.3580	2,030	.0799	H
KTFSS09100HPGM	9,100	.3583	2,030	.0799	H
KTFSS09129HPGM *	9,129	.3594	2,030	.0799	H
KTFSS09200HPGM	9,200	.3622	2,040	.0803	H
KTFSS09300HPGM	9,300	.3661	2,060	.0811	H
KTFSS09347HPGM	9,347	.3680	2,070	.0815	H
KTFSS09400HPGM	9,400	.3701	2,080	.0819	H
KTFSS09500HPGM	9,500	.3740	2,100	.0827	I
KTFSS09525HPGM	9,525	.3750	2,110	.0831	I
KTFSS09558HPGM	9,558	.3763	2,110	.0831	I
KTFSS09600HPGM	9,600	.3780	2,120	.0835	I
KTFSS09700HPGM	9,700	.3819	2,130	.0839	I
KTFSS09800HPGM	9,800	.3858	2,150	.0846	I
KTFSS09900HPGM	9,900	.3898	2,170	.0854	I
KTFSS09921HPGM	9,921	.3906	2,170	.0854	I
KTFSS10000HPGM	10,000	.3937	2,220	.0874	J
KTFSS10023HPGM *	10,023	.3946	2,220	.0874	J
KTFSS10084HPGM *	10,084	.3970	2,230	.0878	J
KTFSS10100HPGM	10,100	.3976	2,240	.0882	J
KTFSS10200HPGM	10,200	.4016	2,250	.0886	J
KTFSS10262HPGM *	10,262	.4040	2,260	.0890	J
KTFSS10300HPGM	10,300	.4055	2,270	.0894	J
KTFSS10320HPGM	10,320	.4063	2,270	.0894	J
KTFSS10400HPGM	10,400	.4094	2,290	.0902	J
KTFSS10490HPGM	10,490	.4130	2,300	.0906	J
KTFSS10500HPGM	10,500	.4134	2,310	.0909	K
KTFSS10600HPGM	10,600	.4173	2,330	.0917	K
KTFSS10700HPGM	10,700	.4213	2,340	.0921	K
KTFSS10716HPGM	10,716	.4219	2,350	.0925	K
KTFSS10800HPGM	10,800	.4252	2,360	.0929	K
KTFSS10900HPGM	10,900	.4291	2,380	.0937	K
KTFSS11000HPGM	11,000	.4331	2,430	.0957	L
KTFSS11100HPGM	11,100	.4370	2,450	.0965	L
KTFSS11113HPGM	11,112	.4375	2,450	.0965	L
KTFSS11200HPGM	11,200	.4409	2,460	.0969	L

(continued)

(KenTIP FS Inserts • HPG KCP15A™ • No Internal Coolant Channels — continued)



KCP15A	D1 mm	D1 in	L5 mm	L5 in	seat size
KTFSS11300HPGM	11,300	.4449	2,480	.0976	L
KTFSS11400HPGM	11,400	.4488	2,500	.0984	L
KTFSS11500HPGM	11,500	.4528	2,520	.0992	M
KTFSS11509HPGM	11,509	.4531	2,520	.0992	M
KTFSS11600HPGM	11,600	.4567	2,540	.1000	M
KTFSS11700HPGM	11,700	.4606	2,550	.1004	M
KTFSS11800HPGM	11,800	.4646	2,570	.1012	M
KTFSS11900HPGM	11,900	.4685	2,590	.1020	M
KTFSS11908HPGM	11,908	.4688	2,590	.1020	M
KTFSS12000HPGM	12,000	.4724	2,640	.1039	N
KTFSS12100HPGM	12,100	.4764	2,650	.1043	N
KTFSS12200HPGM	12,200	.4803	2,670	.1051	N
KTFSS12304HPGM	12,304	.4844	2,690	.1059	N
KTFSS12400HPGM	12,400	.4882	2,700	.1063	N
KTFSS12474HPGM	12,474	.4911	2,720	.1071	N
KTFSS12500HPGM	12,500	.4921	2,730	.1075	O
KTFSS12600HPGM	12,600	.4961	2,740	.1079	O
KTFSS12700HPGM	12,700	.5000	2,760	.1087	O
KTFSS12800HPGM	12,800	.5039	2,780	.1094	O
KTFSS12900HPGM	12,900	.5079	2,790	.1098	O
KTFSS13000HPGM	13,000	.5118	2,850	.1122	P
KTFSS13096HPGM	13,096	.5156	2,860	.1126	P
KTFSS13200HPGM	13,200	.5197	2,880	.1134	P
KTFSS13280HPGM	13,280	.5228	2,890	.1138	P
KTFSS13300HPGM	13,300	.5236	2,900	.1142	P
KTFSS13380HPGM	13,380	.5268	2,910	.1146	P
KTFSS13400HPGM	13,400	.5276	2,910	.1146	P
KTFSS13492HPGM	13,492	.5312	2,930	.1154	P
KTFSS13500HPGM	13,500	.5315	2,930	.1154	Q
KTFSS13600HPGM	13,600	.5354	2,950	.1161	Q
KTFSS13700HPGM	13,700	.5394	2,970	.1169	Q
KTFSS13800HPGM	13,800	.5433	2,980	.1173	Q
KTFSS13891HPGM	13,891	.5469	3,000	.1181	Q
KTFSS13896HPGM *	13,896	.5471	3,000	.1181	Q
KTFSS13940HPGM	13,940	.5488	3,010	.1185	Q
KTFSS14000HPGM	14,000	.5512	3,050	.1201	R
KTFSS14100HPGM	14,100	.5551	3,070	.1209	R
KTFSS14200HPGM	14,200	.5591	3,090	.1217	R
KTFSS14288HPGM	14,288	.5625	3,100	.1220	R
KTFSS14300HPGM	14,300	.5630	3,100	.1220	R
KTFSS14400HPGM	14,400	.5669	3,120	.1228	R
KTFSS14500HPGM	14,500	.5709	3,140	.1236	S
KTFSS14600HPGM	14,600	.5748	3,160	.1244	S
KTFSS14666HPGM *	14,666	.5774	3,170	.1248	S
KTFSS14684HPGM	14,684	.5781	3,170	.1248	S
KTFSS14700HPGM	14,700	.5787	3,170	.1248	S
KTFSS14800HPGM	14,800	.5827	3,190	.1256	S
KTFSS14900HPGM *	14,900	.5866	3,210	.1264	S
KTFSS15000HPGM	15,000	.5906	3,260	.1283	T
KTFSS15083HPGM	15,082	.5938	3,270	.1287	T
KTFSS15100HPGM	15,100	.5945	3,280	.1291	T
KTFSS15200HPGM	15,200	.5984	3,290	.1295	T
KTFSS15300HPGM	15,300	.6024	3,310	.1303	T
KTFSS15380HPGM	15,380	.6055	3,320	.1307	T
KTFSS15400HPGM	15,400	.6063	3,330	.1311	T
KTFSS15479HPGM	15,479	.6094	3,340	.1315	T



● first choice
○ alternate choice

KCP15A	D1 mm	D1 in	L5 mm	L5 in	seat size
KTFSS15500HPGM	15,500	.6102	3,340	.1315	T
KTFSS15600HPGM	15,600	.6142	3,360	.1323	T
KTFSS15700HPGM	15,700	.6181	3,380	.1331	T
KTFSS15800HPGM	15,800	.6220	3,390	.1335	T
KTFSS15875HPGM	15,875	.6250	3,410	.1343	T
KTFSS15900HPGM *	15,900	.6260	3,410	.1343	T
KTFSS16000HPGM	16,000	.6299	3,480	.1370	U
KTFSS16027HPGM *	16,027	.6310	3,490	.1374	U
KTFSS16080HPGM *	16,080	.6331	3,490	.1374	U
KTFSS16100HPGM	16,100	.6339	3,500	.1378	U
KTFSS16104HPGM	16,104	.6340	3,500	.1378	U
KTFSS16200HPGM	16,200	.6378	3,510	.1382	U
KTFSS16271HPGM	16,271	.6406	3,530	.1390	U
KTFSS16300HPGM	16,300	.6417	3,530	.1390	U
KTFSS16400HPGM	16,400	.6457	3,550	.1398	U
KTFSS16500HPGM	16,500	.6496	3,570	.1406	U
KTFSS16600HPGM	16,600	.6535	3,580	.1409	U
KTFSS16670HPGM	16,670	.6563	3,590	.1413	U
KTFSS16700HPGM	16,700	.6575	3,600	.1417	U
KTFSS16800HPGM	16,800	.6614	3,620	.1425	U
KTFSS16900HPGM	16,900	.6654	3,630	.1429	U
KTFSS17000HPGM	17,000	.6693	3,660	.1441	V
KTFSS17066HPGM	17,066	.6719	3,670	.1445	V
KTFSS17100HPGM	17,100	.6732	3,670	.1445	V
KTFSS17200HPGM	17,200	.6772	3,690	.1453	V
KTFSS17300HPGM *	17,300	.6811	3,710	.1461	V
KTFSS17400HPGM	17,400	.6850	3,720	.1465	V
KTFSS17463HPGM	17,462	.6875	3,740	.1472	V
KTFSS17480HPGM	17,480	.6882	3,740	.1472	V
KTFSS17500HPGM	17,500	.6890	3,740	.1472	V
KTFSS17600HPGM	17,600	.6929	3,760	.1480	V
KTFSS17700HPGM	17,700	.6969	3,770	.1484	V
KTFSS17800HPGM	17,800	.7008	3,790	.1492	V
KTFSS17859HPGM	17,859	.7031	3,800	.1496	V
KTFSS17900HPGM	17,900	.7047	3,810	.1500	V
KTFSS18000HPGM	18,000	.7087	3,890	.1531	W
KTFSS18100HPGM	18,100	.7126	3,910	.1539	W
KTFSS18200HPGM	18,200	.7165	3,930	.1547	W
KTFSS18258HPGM	18,258	.7188	3,940	.1551	W
KTFSS18300HPGM	18,300	.7205	3,940	.1551	W
KTFSS18400HPGM	18,400	.7244	3,960	.1559	W
KTFSS18500HPGM	18,500	.7283	3,980	.1567	W
KTFSS18600HPGM	18,600	.7323	3,990	.1571	W
KTFSS18654HPGM	18,654	.7344	4,000	.1575	W
KTFSS18700HPGM	18,700	.7362	4,010	.1579	W
KTFSS18800HPGM	18,800	.7402	4,030	.1587	W
KTFSS18900HPGM	18,900	.7441	4,040	.1591	W
KTFSS19000HPGM	19,000	.7480	4,070	.1602	X
KTFSS19050HPGM	19,050	.7500	4,080	.1606	X
KTFSS19100HPGM	19,100	.7520	4,090	.1610	X
KTFSS19200HPGM	19,200	.7559	4,100	.1614	X
KTFSS19228HPGM	19,228	.7570	4,110	.1618	X
KTFSS19253HPGM *	19,253	.7580	4,110	.1618	X
KTFSS19279HPGM	19,279	.7590	4,120	.1622	X
KTFSS19300HPGM	19,300	.7598	4,120	.1622	X
KTFSS19355HPGM *	19,355	.7620	4,130	.1626	X

(continued)

(KenTIP FS Inserts • HPG KCP15A™ • No Internal Coolant Channels — continued)

P ● M K ○ N S H

● first choice
○ alternate choice

KCP15A	D1 mm	D1 in	L5 mm	L5 in	seat size
KTFSS19400HPGM	19,400	.7638	4,140	.1630	X
KTFSS19446HPGM	19,446	.7656	4,140	.1630	X
KTFSS19460HPGM	19,460	.7661	4,150	.1634	X
KTFSS19500HPGM	19,500	.7677	4,150	.1634	X
KTFSS19600HPGM	19,600	.7717	4,170	.1642	X
KTFSS19700HPGM	19,700	.7756	4,190	.1650	X
KTFSS19800HPGM	19,800	.7795	4,200	.1654	X
KTFSS19845HPGM	19,845	.7813	4,210	.1657	X
KTFSS19900HPGM	19,900	.7835	4,220	.1661	X
KTFSS20000HPGM	20,000	.7874	4,310	.1697	Y
KTFSS20100HPGM	20,100	.7913	4,320	.1701	Y
KTFSS20200HPGM	20,200	.7953	4,340	.1709	Y
KTFSS20241HPGM *	20,241	.7969	4,350	.1713	Y
KTFSS20300HPGM	20,300	.7992	4,360	.1717	Y
KTFSS20500HPGM	20,500	.8071	4,390	.1728	Y
KTFSS20600HPGM	20,600	.8110	4,410	.1736	Y
KTFSS20638HPGM	20,638	.8125	4,410	.1736	Y
KTFSS20700HPGM *	20,700	.8150	4,420	.1740	Y
KTFSS20800HPGM	20,800	.8189	4,440	.1748	Y
KTFSS20900HPGM *	20,900	.8228	4,460	.1756	Y
KTFSS20990HPGM *	20,990	.8264	4,470	.1760	Y
KTFSS21000HPGM	21,000	.8268	4,480	.1764	Z
KTFSS21100HPGM *	21,100	.8307	4,500	.1772	Z
KTFSS21200HPGM	21,200	.8346	4,510	.1776	Z
KTFSS21300HPGM *	21,300	.8386	4,530	.1783	Z
KTFSS21400HPGM *	21,400	.8425	4,550	.1791	Z
KTFSS21433HPGM	21,432	.8438	4,550	.1791	Z
KTFSS21500HPGM	21,500	.8465	4,560	.1795	Z
KTFSS21700HPGM	21,700	.8543	4,600	.1811	Z
KTFSS21800HPGM *	21,800	.8583	4,610	.1815	Z
KTFSS21829HPGM	21,829	.8594	4,620	.1819	Z
KTFSS21900HPGM *	21,900	.8622	4,630	.1823	Z
KTFSS22000HPGM	22,000	.8661	4,720	.1858	ZA
KTFSS22100HPGM *	22,100	.8701	4,730	.1862	ZA
KTFSS22200HPGM *	22,200	.8740	4,750	.1870	ZA
KTFSS22225HPGM	22,225	.8750	4,750	.1870	ZA
KTFSS22400HPGM *	22,400	.8819	4,780	.1882	ZA
KTFSS22500HPGM	22,500	.8858	4,800	.1890	ZA
KTFSS22600HPGM *	22,600	.8898	4,820	.1898	ZA
KTFSS22700HPGM *	22,700	.8937	4,830	.1902	ZA

KCP15A	D1 mm	D1 in	L5 mm	L5 in	seat size
KTFSS22800HPGM	22,800	.8976	4,850	.1909	ZA
KTFSS22900HPGM *	22,900	.9016	4,870	.1917	ZA
KTFSS23000HPGM	23,000	.9055	4,890	.1925	ZB
KTFSS23100HPGM	23,100	.9094	4,910	.1933	ZB
KTFSS23200HPGM *	23,200	.9134	4,920	.1937	ZB
KTFSS23300HPGM	23,300	.9173	4,940	.1945	ZB
KTFSS23400HPGM *	23,400	.9213	4,960	.1953	ZB
KTFSS23416HPGM	23,416	.9219	4,960	.1953	ZB
KTFSS23500HPGM	23,500	.9252	4,980	.1961	ZB
KTFSS23600HPGM *	23,600	.9291	4,990	.1965	ZB
KTFSS23700HPGM *	23,700	.9331	5,010	.1972	ZB
KTFSS23800HPGM *	23,800	.9370	5,030	.1980	ZB
KTFSS23813HPGM	23,812	.9375	5,030	.1980	ZB
KTFSS23900HPGM *	23,900	.9409	5,040	.1984	ZB
KTFSS24000HPGM	24,000	.9449	5,130	.2020	ZC
KTFSS24100HPGM *	24,100	.9488	5,140	.2024	ZC
KTFSS24200HPGM *	24,200	.9528	5,160	.2031	ZC
KTFSS24300HPGM	24,300	.9567	5,180	.2039	ZC
KTFSS24400HPGM *	24,400	.9606	5,190	.2043	ZC
KTFSS24500HPGM	24,500	.9646	5,210	.2051	ZC
KTFSS24600HPGM *	24,600	.9685	5,230	.2059	ZC
KTFSS24608HPGM	24,608	.9688	5,230	.2059	ZC
KTFSS24700HPGM *	24,700	.9724	5,240	.2063	ZC
KTFSS24800HPGM *	24,800	.9764	5,260	.2071	ZC
KTFSS24900HPGM *	24,900	.9803	5,280	.2079	ZC
KTFSS25000HPGM	25,000	.9843	5,300	.2087	ZD
KTFSS25100HPGM *	25,100	.9882	5,320	.2094	ZD
KTFSS25200HPGM *	25,200	.9921	5,330	.2098	ZD
KTFSS25250HPGM *	25,250	.9941	5,340	.2102	ZD
KTFSS25300HPGM *	25,300	.9961	5,350	.2106	ZD
KTFSS25400HPGM	25,400	1.0000	5,370	.2114	ZD
KTFSS25500HPGM *	25,500	1.0039	5,380	.2118	ZD
KTFSS25540HPGM	25,540	1.0055	5,390	.2122	ZD
KTFSS25600HPGM	25,600	1.0079	5,400	.2126	ZD
KTFSS25679HPGM	25,679	1.0110	5,410	.2130	ZD
KTFSS25700HPGM *	25,700	1.0118	5,420	.2134	ZD
KTFSS25800HPGM *	25,800	1.0157	5,440	.2142	ZD
KTFSS25806HPGM	25,806	1.0160	5,440	.2142	ZD
KTFSS25900HPGM *	25,900	1.0197	5,450	.2146	ZD
KTFSS26000HPGM	26,000	1.0236	5,470	.2154	ZD

NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.
Products with D1 ≥ 20mm will be available by January 1st, 2018.

KenTIP FS HPG Geometry

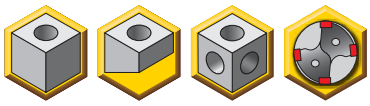
Tolerance

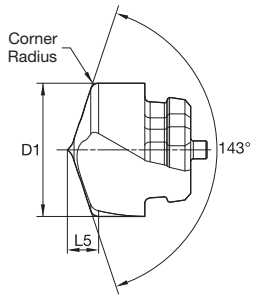
D1 metric	tolerance k8
6	0,000/+0,018
>6–10	0,000/+0,022
>10–18	0,000/+0,027
>18–26	0,000/+0,033

Modular Drill Carbide Insert Blades • KenTIP™ FS • HPG Geometry • Grade KCP15A™ • No Internal Coolant Channels on the Insert • Through Coolant on the Body • Metric

Material Group		Cutting Speed — vc Range — m/min			Metric						
					Recommended Feed Rate per Rev						
		min	Starting Value	max		8,0	10,0	12,0	14,0	16,0	20,0
P	1	90	**130**	170	mm/r	0,11–0,22	0,13–0,28	0,14–0,34	0,17–0,43	0,19–0,50	0,25–0,53
	2	100	**140**	180	mm/r	0,11–0,26	0,13–0,32	0,14–0,36	0,17–0,40	0,19–0,50	0,25–0,53
	3	60	**100**	130	mm/r	0,11–0,31	0,12–0,39	0,16–0,41	0,21–0,51	0,23–0,51	0,30–0,56
	4	60	**100**	130	mm/r	0,11–0,31	0,12–0,39	0,16–0,41	0,17–0,51	0,18–0,51	0,23–0,51
	5	60	**70**	100	mm/r	0,10–0,22	0,10–0,25	0,10–0,28	0,14–0,32	0,16–0,35	0,20–0,46
	6	60	**70**	70	mm/r	0,10–0,22	0,10–0,25	0,10–0,28	0,14–0,32	0,16–0,35	0,20–0,46
K	1	80	**120**	170	mm/r	0,15–0,32	0,16–0,35	0,17–0,39	0,21–0,46	0,25–0,53	0,31–0,65
	2	80	**110**	120	mm/r	0,15–0,32	0,16–0,33	0,17–0,36	0,21–0,45	0,25–0,53	0,31–0,65
	3	50	**80**	100	mm/r	0,16–0,33	0,17–0,36	0,18–0,40	0,20–0,45	0,21–0,48	0,23–0,53

- HPC-point geometry for all cast irons.
- 4-margin lands ensure hole straightness.
- Large corner radius prevents chipping and reduces exit burs when drilling through holes.
- KC7410™ is an AlCr PVD multilayer coating.
- Superb wear resistance.
- With internal coolant.







HPC Geometry

KenTIP FS Inserts • HPC KC7410 • With Internal Coolant Channels

P M K● N S H

KC7410	D1 mm	D1 in	L5 mm	L5 in	seat size
KTFST06000HPCM	6,000	.2362	1,410	.0555	A
KTFST06200HPCM	6,200	.2441	1,440	.0567	A
KTFST06350HPCM	6,350	.2500	1,490	.0587	B
KTFST06500HPCM	6,500	.2559	1,510	.0594	B
KTFST06530HPCM	6,530	.2571	1,520	.0598	B
KTFST06700HPCM	6,700	.2638	1,570	.0618	C
KTFST06746HPCM	6,746	.2656	1,570	.0618	C
KTFST06800HPCM	6,800	.2677	1,580	.0622	C
KTFST07000HPCM	7,000	.2756	1,640	.0646	D
KTFST07145HPCM	7,145	.2813	1,670	.0657	D
KTFST07300HPCM	7,300	.2874	1,690	.0665	D
KTFST07500HPCM	7,500	.2953	1,760	.0693	E
KTFST07600HPCM	7,600	.2992	1,780	.0701	E
KTFST07800HPCM	7,800	.3071	1,810	.0713	E
KTFST07938HPCM	7,938	.3125	1,830	.0720	E
KTFST08000HPCM	8,000	.3150	1,880	.0740	F
KTFST08100HPCM *	8,100	.3189	1,890	.0744	F
KTFST08204HPCM *	8,204	.3230	1,910	.0752	F
KTFST08500HPCM	8,500	.3346	1,990	.0783	G
KTFST08600HPCM *	8,600	.3386	2,010	.0791	G
KTFST08700HPCM *	8,700	.3425	2,030	.0799	G
KTFST08733HPCM *	8,732	.3438	2,030	.0799	G
KTFST09000HPCM	9,000	.3543	2,110	.0831	H
KTFST09100HPCM *	9,100	.3583	2,130	.0839	H
KTFST09500HPCM	9,500	.3740	2,230	.0878	I
KTFST09525HPCM	9,525	.3750	2,230	.0878	I
KTFST09600HPCM *	9,600	.3780	2,250	.0886	I
KTFST09700HPCM *	9,700	.3819	2,260	.0890	I
KTFST09800HPCM *	9,800	.3858	2,280	.0898	I
KTFST09921HPCM	9,921	.3906	2,300	.0906	I
KTFST10000HPCM	10,000	.3937	2,350	.0925	J
KTFST10023HPCM *	10,023	.3946	2,350	.0925	J
KTFST10200HPCM	10,200	.4016	2,380	.0937	J
KTFST10300HPCM	10,300	.4055	2,400	.0945	J
KTFST10320HPCM *	10,320	.4063	2,400	.0945	J
KTFST10500HPCM	10,500	.4134	2,460	.0969	K

P M K● N S H

● first choice
○ alternate choice

KC7410	D1 mm	D1 in	L5 mm	L5 in	seat size
KTFST10600HPCM *	10,600	.4173	2,480	.0976	K
KTFST10700HPCM *	10,700	.4213	2,500	.0984	K
KTFST10716HPCM	10,716	.4219	2,500	.0984	K
KTFST10800HPCM	10,800	.4252	2,510	.0988	K
KTFST11000HPCM	11,000	.4331	2,580	.1016	L
KTFST11100HPCM	11,100	.4370	2,600	.1024	L
KTFST11113HPCM	11,112	.4375	2,600	.1024	L
KTFST11400HPCM	11,400	.4488	2,650	.1043	L
KTFST11500HPCM	11,500	.4528	2,700	.1063	M
KTFST11800HPCM *	11,800	.4646	2,750	.1083	M
KTFST11908HPCM *	11,908	.4688	2,770	.1091	M
KTFST12000HPCM	12,000	.4724	2,820	.1110	N
KTFST12304HPCM *	12,304	.4844	2,870	.1130	N
KTFST12500HPCM	12,500	.4921	2,930	.1154	O
KTFST12700HPCM	12,700	.5000	2,970	.1169	O
KTFST13000HPCM	13,000	.5118	3,050	.1201	P
KTFST13096HPCM	13,096	.5156	3,070	.1209	P
KTFST13200HPCM *	13,200	.5197	3,080	.1213	P
KTFST13300HPCM	13,300	.5236	3,100	.1220	P
KTFST13492HPCM	13,492	.5312	3,130	.1232	P
KTFST13500HPCM	13,500	.5315	3,170	.1248	Q
KTFST13600HPCM	13,600	.5354	3,180	.1252	Q
KTFST13800HPCM	13,800	.5433	3,220	.1268	Q
KTFST13891HPCM	13,891	.5469	3,230	.1272	Q
KTFST14000HPCM	14,000	.5512	3,290	.1295	R
KTFST14100HPCM *	14,100	.5551	3,300	.1299	R
KTFST14288HPCM	14,288	.5625	3,330	.1311	R
KTFST14500HPCM	14,500	.5709	3,400	.1339	S
KTFST14600HPCM *	14,600	.5748	3,420	.1346	S
KTFST14684HPCM *	14,684	.5781	3,430	.1350	S
KTFST14800HPCM *	14,800	.5827	3,450	.1358	S
KTFST15000HPCM	15,000	.5906	3,520	.1386	T
KTFST15083HPCM *	15,082	.5938	3,530	.1390	T
KTFST15100HPCM	15,100	.5945	3,540	.1394	T
KTFST15200HPCM *	15,200	.5984	3,550	.1398	T
KTFST15300HPCM *	15,300	.6024	3,570	.1406	T

(continued)

(KenTIP FS Inserts • HPC KC7410™ • With Internal Coolant Channels — continued)



KC7410	D1 mm	D1 in	L5 mm	L5 in	seat size
KTFST15500HPCM	15,500	.6102	3,600	.1417	T
KTFST15600HPCM *	15,600	.6142	3,620	.1425	T
KTFST15800HPCM	15,800	.6220	3,650	.1437	T
KTFST15875HPCM *	15,875	.6250	3,670	.1445	T
KTFST16000HPCM	16,000	.6299	3,750	.1476	U
KTFST16100HPCM	16,100	.6339	3,770	.1484	U
KTFST16104HPCM *	16,104	.6340	3,770	.1484	U
KTFST16200HPCM *	16,200	.6378	3,790	.1492	U
KTFST16271HPCM *	16,271	.6406	3,800	.1496	U
KTFST16300HPCM *	16,300	.6417	3,800	.1496	U
KTFST16500HPCM	16,500	.6496	3,840	.1512	U
KTFST16550HPCM *	16,550	.6516	3,850	.1516	U
KTFST16600HPCM	16,600	.6535	3,850	.1516	U
KTFST16670HPCM	16,670	.6563	3,870	.1524	U
KTFST17000HPCM	17,000	.6693	3,990	.1571	V
KTFST17066HPCM *	17,066	.6719	4,000	.1575	V
KTFST17100HPCM *	17,100	.6732	4,010	.1579	V
KTFST17200HPCM	17,200	.6772	4,020	.1583	V
KTFST17300HPCM	17,300	.6811	4,040	.1591	V
KTFST17463HPCM *	17,462	.6875	4,070	.1602	V
KTFST17500HPCM	17,500	.6890	4,070	.1602	V
KTFST17550HPCM *	17,550	.6909	4,080	.1606	V
KTFST17600HPCM	17,600	.6929	4,090	.1610	V
KTFST17700HPCM *	17,700	.6969	4,110	.1618	V
KTFST17800HPCM	17,800	.7008	4,120	.1622	V
KTFST18000HPCM	18,000	.7087	4,220	.1661	W
KTFST18100HPCM *	18,100	.7126	4,240	.1669	W
KTFST18258HPCM *	18,258	.7188	4,270	.1681	W
KTFST18500HPCM	18,500	.7283	4,310	.1697	W
KTFST18600HPCM	18,600	.7323	4,320	.1701	W
KTFST18700HPCM *	18,700	.7362	4,340	.1709	W
KTFST19000HPCM	19,000	.7480	4,460	.1756	X



● first choice
○ alternate choice

KC7410	D1 mm	D1 in	L5 mm	L5 in	seat size
KTFST19050HPCM	19,050	.7500	4,470	.1760	X
KTFST19279HPCM *	19,279	.7590	4,500	.1772	X
KTFST19446HPCM *	19,446	.7656	4,530	.1783	X
KTFST19500HPCM	19,500	.7677	4,540	.1787	X
KTFST19800HPCM *	19,800	.7795	4,590	.1807	X
KTFST20000HPCM	20,000	.7874	4,690	.1846	Y
KTFST20241HPCM	20,241	.7969	4,730	.1862	Y
KTFST20300HPCM *	20,300	.7992	4,740	.1866	Y
KTFST20500HPCM	20,500	.8071	4,780	.1882	Y
KTFST20638HPCM	20,638	.8125	4,800	.1890	Y
KTFST21000HPCM	21,000	.8268	4,930	.1941	Z
KTFST21433HPCM *	21,432	.8438	5,000	.1969	Z
KTFST21500HPCM *	21,500	.8465	5,010	.1972	Z
KTFST22000HPCM	22,000	.8661	5,160	.2031	ZA
KTFST22225HPCM *	22,225	.8750	5,200	.2047	ZA
KTFST22440HPCM *	22,440	.8835	5,240	.2063	ZA
KTFST22500HPCM *	22,500	.8858	5,250	.2067	ZA
KTFST23000HPCM	23,000	.9055	5,400	.2126	ZB
KTFST23416HPCM *	23,416	.9219	5,470	.2154	ZB
KTFST23500HPCM *	23,500	.9252	5,480	.2157	ZB
KTFST23813HPCM *	23,812	.9375	5,530	.2177	ZB
KTFST24000HPCM	24,000	.9449	5,630	.2217	ZC
KTFST24500HPCM *	24,500	.9646	5,720	.2252	ZC
KTFST24608HPCM *	24,608	.9688	5,730	.2256	ZC
KTFST25000HPCM	25,000	.9843	5,870	.2311	ZD
KTFST25070HPCM *	25,070	.9870	5,880	.2315	ZD
KTFST25400HPCM	25,400	1.0000	5,930	.2335	ZD
KTFST25500HPCM *	25,500	1.0039	5,950	.2343	ZD
KTFST25679HPCM *	25,679	1.0110	5,980	.2354	ZD
KTFST25806HPCM *	25,806	1.0160	6,000	.2362	ZD
KTFST26000HPCM	26,000	1.0236	6,030	.2374	ZD

NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.
Products with D1 ≤ 19,999mm will be available in November 2017.
Products with D1 ≥ 20mm will be available by January 1st, 2018.

KenTIP FS HPC Geometry
Tolerance

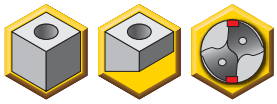
D1 metric	tolerance k8
6	0,000/+0,018
>6–10	0,000/+0,022
>10–18	0,000/+0,027
>18–26	0,000/+0,033

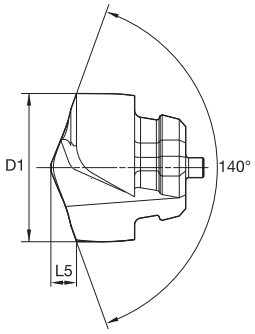
Application Data

Modular Drill Carbide Insert Blades • KenTIP™ FS • HPC Geometry • Grade KC7410™ • Through Coolant • Metric

Material Group		Cutting Speed — vc Range — m/min min	Starting Value	max	Metric Recommended Feed Rate per Rev	8,0	10,0	12,0	14,0	16,0	20,0
K	1	100	**175**	200	mm/r	0,14–0,34	0,16–0,39	0,19–0,45	0,23–0,50	0,26–0,58	0,3–0,64
	2	100	**160**	180	mm/r	0,14–0,34	0,16–0,39	0,19–0,45	0,23–0,50	0,26–0,58	0,3–0,64
	3	70	**85**	120	mm/r	0,13–0,27	0,15–0,33	0,17–0,37	0,19–0,42	0,21–0,46	0,28–0,54

- HPL-point geometry for stainless steels.
- Forms 2 chips per cutting edge for an uninterrupted and smooth chip flow.
- KCMS15™ is an AlTiN PVD monolayer coating.
- Prevents edge built-up, which delivers superior hole quality.
- Very high metal removal rates.
- With internal coolant.

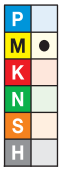






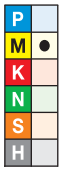
HPL Geometry

KenTIP FS Inserts • HPL KCMS15 • With Internal Coolant Channels



● first choice
○ alternate choice

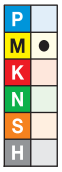
KCMS15	D1 mm	D1 in	L5 mm	L5 in	seat size
KTFST06000HPLM	6,000	.2362	1,340	.0528	A
KTFST06350HPLM	6,350	.2500	1,400	.0551	B
KTFST06500HPLM	6,500	.2559	1,430	.0563	B
KTFST06629HPLM	6,629	.2610	1,460	.0575	C
KTFST06800HPLM	6,800	.2677	1,490	.0587	C
KTFST07000HPLM	7,000	.2756	1,530	.0602	D
KTFST07500HPLM	7,500	.2953	1,630	.0642	E
KTFST07800HPLM	7,800	.3071	1,680	.0661	E
KTFST07938HPLM	7,938	.3125	1,710	.0673	E
KTFST08000HPLM	8,000	.3150	1,720	.0677	F
KTFST08100HPLM *	8,100	.3189	1,740	.0685	F
KTFST08204HPLM *	8,204	.3230	1,760	.0693	F
KTFST08334HPLM *	8,334	.3281	1,790	.0705	F
KTFST08400HPLM *	8,400	.3307	1,800	.0709	F
KTFST08500HPLM	8,500	.3346	1,820	.0717	G
KTFST08600HPLM *	8,600	.3386	1,840	.0724	G
KTFST08700HPLM *	8,700	.3425	1,860	.0732	G
KTFST08800HPLM *	8,800	.3465	1,880	.0740	G
KTFST08900HPLM	8,900	.3504	1,900	.0748	G
KTFST09000HPLM	9,000	.3543	1,930	.0760	H
KTFST09100HPLM *	9,100	.3583	1,950	.0768	H
KTFST09200HPLM	9,200	.3622	1,970	.0776	H
KTFST09400HPLM *	9,400	.3701	2,000	.0787	H
KTFST09500HPLM	9,500	.3740	2,030	.0799	I
KTFST09558HPLM *	9,558	.3763	2,040	.0803	I
KTFST09600HPLM	9,600	.3780	2,050	.0807	I
KTFST09700HPLM *	9,700	.3819	2,070	.0815	I
KTFST09800HPLM	9,800	.3858	2,090	.0823	I
KTFST09900HPLM	9,900	.3898	2,110	.0831	I
KTFST10000HPLM	10,000	.3937	2,130	.0839	J
KTFST10100HPLM	10,100	.3976	2,150	.0846	J
KTFST10200HPLM	10,200	.4016	2,170	.0854	J
KTFST10300HPLM	10,300	.4055	2,190	.0862	J
KTFST10320HPLM	10,320	.4063	2,190	.0862	J
KTFST10400HPLM *	10,400	.4094	2,210	.0870	J
KTFST10500HPLM	10,500	.4134	2,230	.0878	K



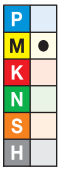
KCMS15	D1 mm	D1 in	L5 mm	L5 in	seat size
KTFST10600HPLM *	10,600	.4173	2,250	.0886	K
KTFST10700HPLM	10,700	.4213	2,270	.0894	K
KTFST10800HPLM *	10,800	.4252	2,290	.0902	K
KTFST10900HPLM *	10,900	.4291	2,310	.0909	K
KTFST11000HPLM	11,000	.4331	2,340	.0921	L
KTFST11100HPLM	11,100	.4370	2,350	.0925	L
KTFST11113HPLM	11,112	.4375	2,360	.0929	L
KTFST11200HPLM *	11,200	.4409	2,370	.0933	L
KTFST11400HPLM *	11,400	.4488	2,410	.0949	L
KTFST11500HPLM	11,500	.4528	2,440	.0961	M
KTFST11600HPLM *	11,600	.4567	2,460	.0969	M
KTFST11800HPLM *	11,800	.4646	2,490	.0980	M
KTFST11908HPLM	11,908	.4688	2,520	.0992	M
KTFST12000HPLM	12,000	.4724	2,540	.1000	N
KTFST12200HPLM *	12,200	.4803	2,580	.1016	N
KTFST12304HPLM	12,304	.4844	2,600	.1024	N
KTFST12500HPLM	12,500	.4921	2,640	.1039	O
KTFST12700HPLM	12,700	.5000	2,680	.1055	O
KTFST12800HPLM *	12,800	.5039	2,700	.1063	O
KTFST12900HPLM *	12,900	.5079	2,720	.1071	O
KTFST13000HPLM	13,000	.5118	2,740	.1079	P
KTFST13096HPLM	13,096	.5156	2,760	.1087	P
KTFST13200HPLM *	13,200	.5197	2,780	.1094	P
KTFST13492HPLM *	13,492	.5312	2,840	.1118	P
KTFST13500HPLM	13,500	.5315	2,840	.1118	Q
KTFST13800HPLM *	13,800	.5433	2,900	.1142	Q
KTFST13891HPLM *	13,891	.5469	2,920	.1150	Q
KTFST13896HPLM *	13,896	.5471	2,920	.1150	Q
KTFST14000HPLM	14,000	.5512	2,950	.1161	R
KTFST14100HPLM *	14,100	.5551	2,960	.1165	R
KTFST14200HPLM *	14,200	.5591	2,980	.1173	R
KTFST14288HPLM	14,288	.5625	3,000	.1181	R
KTFST14300HPLM	14,300	.5630	3,000	.1181	R
KTFST14400HPLM *	14,400	.5669	3,020	.1189	R
KTFST14500HPLM	14,500	.5709	3,050	.1201	S
KTFST14684HPLM *	14,684	.5781	3,080	.1213	S

(continued)

(KenTIP FS Inserts • HPL KCMS15™ • With Internal Coolant Channels — continued)



KCMS15	D1 mm	D1 in	L5 mm	L5 in	seat size
KTFST14800HPLM *	14,800	.5827	3,100	.1220	S
KTFST15000HPLM	15,000	.5906	3,150	.1240	T
KTFST15100HPLM *	15,100	.5945	3,170	.1248	T
KTFST15200HPLM *	15,200	.5984	3,190	.1256	T
KTFST15500HPLM	15,500	.6102	3,240	.1276	T
KTFST15875HPLM	15,875	.6250	3,310	.1303	T
KTFST16000HPLM	16,000	.6299	3,350	.1319	U
KTFST16100HPLM *	16,100	.6339	3,370	.1327	U
KTFST16104HPLM	16,104	.6340	3,370	.1327	U
KTFST16150HPLM	16,150	.6358	3,380	.1331	U
KTFST16271HPLM	16,271	.6406	3,400	.1339	U
KTFST16500HPLM	16,500	.6496	3,450	.1358	U
KTFST16670HPLM	16,670	.6563	3,480	.1370	U
KTFST17000HPLM	17,000	.6693	3,550	.1398	V
KTFST17463HPLM *	17,462	.6875	3,640	.1433	V
KTFST17480HPLM	17,480	.6882	3,640	.1433	V
KTFST17500HPLM	17,500	.6890	3,650	.1437	V
KTFST17700HPLM *	17,700	.6969	3,690	.1453	V
KTFST18000HPLM	18,000	.7087	3,760	.1480	W
KTFST18258HPLM *	18,258	.7188	3,800	.1496	W
KTFST18500HPLM	18,500	.7283	3,850	.1516	W
KTFST18654HPLM *	18,654	.7344	3,880	.1528	W
KTFST19000HPLM	19,000	.7480	3,960	.1559	X
KTFST19050HPLM	19,050	.7500	3,970	.1563	X
KTFST19200HPLM *	19,200	.7559	3,990	.1571	X
KTFST19228HPLM *	19,228	.7570	4,000	.1575	X
KTFST19253HPLM	19,253	.7580	4,000	.1575	X
KTFST19279HPLM	19,279	.7590	4,010	.1579	X



● first choice
○ alternate choice

KCMS15	D1 mm	D1 in	L5 mm	L5 in	seat size
KTFST19355HPLM *	19,355	.7620	4,020	.1583	X
KTFST19446HPLM	19,446	.7656	4,040	.1591	X
KTFST19460HPLM *	19,460	.7661	4,040	.1591	X
KTFST19500HPLM	19,500	.7677	4,050	.1594	X
KTFST19845HPLM	19,845	.7813	4,120	.1622	X
KTFST19850HPLM *	19,850	.7815	4,120	.1622	X
KTFST20000HPLM	20,000	.7874	4,160	.1638	Y
KTFST20500HPLM	20,500	.8071	4,250	.1673	Y
KTFST20638HPLM	20,638	.8125	4,280	.1685	Y
KTFST21000HPLM	21,000	.8268	4,360	.1717	Z
KTFST21150HPLM *	21,150	.8327	4,390	.1728	Z
KTFST21500HPLM	21,500	.8465	4,450	.1752	Z
KTFST22000HPLM	22,000	.8661	4,560	.1795	ZA
KTFST22225HPLM	22,225	.8750	4,600	.1811	ZA
KTFST22500HPLM	22,500	.8858	4,660	.1835	ZA
KTFST23000HPLM	23,000	.9055	4,760	.1874	ZB
KTFST23500HPLM	23,500	.9252	4,860	.1913	ZB
KTFST23813HPLM	23,812	.9375	4,920	.1937	ZB
KTFST24000HPLM	24,000	.9449	4,960	.1953	ZC
KTFST24500HPLM	24,500	.9646	5,060	.1992	ZC
KTFST25000HPLM	25,000	.9843	5,170	.2035	ZD
KTFST25400HPLM	25,400	1.0000	5,240	.2063	ZD
KTFST25500HPLM	25,500	1.0039	5,260	.2071	ZD
KTFST25600HPLM	25,600	1.0079	5,280	.2079	ZD
KTFST25650HPLM	25,650	1.0098	5,290	.2083	ZD
KTFST25679HPLM	25,679	1.0110	5,290	.2083	ZD
KTFST25806HPLM	25,806	1.0160	5,320	.2094	ZD
KTFST26000HPLM	26,000	1.0236	5,370	.2114	ZD

NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.
Products with D1 ≥ 20mm will be available by January 1st, 2018.

KenTIP FS HPL Geometry

Tolerance

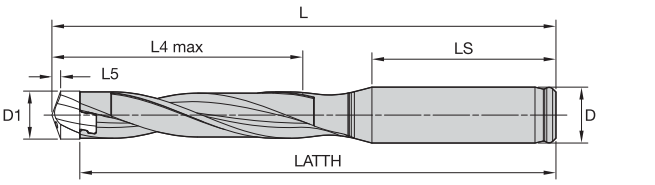
D1 metric	tolerance k8
6	0,000/+0,018
>6–10	0,000/+0,022
>10–18	0,000/+0,027
>18–26	0,000/+0,033

Application Data

Modular Drill Carbide Insert Blades • KenTIP™ FS • HPL Geometry • Grade KCMS15™ • Through Coolant • Metric

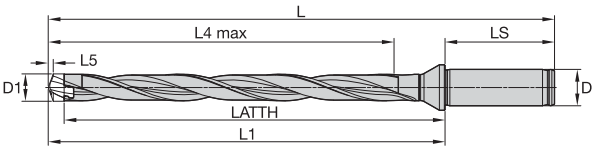
Material Group		Cutting Speed — vc Range — m/min min	Starting Value	max	Metric Recommended Feed Rate per Rev	8,0	10,0	12,0	14,0	16,0	20,0
M	1	50	**60**	90	mm/r	0,08–0,15	0,09–0,18	0,11–0,20	0,12–0,22	0,13–0,24	0,16–0,28
	2	30	**60**	90	mm/r	0,08–0,15	0,09–0,18	0,11–0,20	0,12–0,22	0,13–0,24	0,16–0,28
	3	20	**50**	60	mm/r	0,08–0,15	0,09–0,18	0,11–0,20	0,12–0,22	0,13–0,24	0,16–0,28

- KenTIP FS toolholder with straight cylindrical round metric shank.
- 12 x D holders feature a flanged shank for improved stiffness.
- Multi-coolant provides an advanced coolant channel layout with four coolant exits in each holder.
- Each tool body is shipped with related insert wrench.

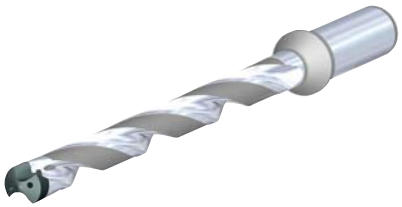


Straight Round Shank (SS Shank)





Flanged Round Shank (SF Shank)

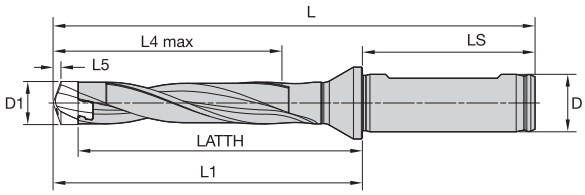


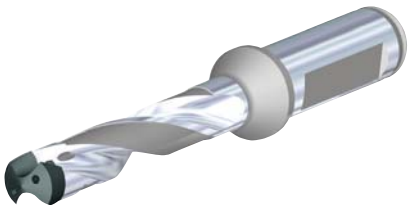
KenTIP FS Round Shank • 1.5 x D/3 x D/5 x D/8 x D/12 x D • Metric

1.5 x D SS	3 x D SS	5 x D SS	8 x D SS	12 x D SF	D1 mm	D1 in	D1 max mm	D1 max in	seat size	KenTIP wrench
KTFS060R01SS8M	KTFS060R03SS8M	KTFS060R05SS8M	KTFS060R08SS8M	KTFS060R12SF12M	6,000	.2363	6,299	.2480	A	170.319
KTFS063R01SS8M	KTFS063R03SS8M	KTFS063R05SS8M	KTFS063R08SS8M	KTFS063R12SF12M	6,300	.2481	6,599	.2598	B	170.319
KTFS066R01SS8M	KTFS066R03SS8M	KTFS066R05SS8M	KTFS066R08SS8M	KTFS066R12SF12M	6,600	.2599	6,999	.2755	C	170.319
KTFS070R01SS8M	KTFS070R03SS8M	KTFS070R05SS8M	KTFS070R08SS8M	KTFS070R12SF12M	7,000	.2756	7,499	.2952	D	170.319
KTFS075R01SS8M	KTFS075R03SS8M	KTFS075R05SS8M	KTFS075R08SS8M	KTFS075R12SF12M	7,500	.2953	7,999	.3149	E	170.319
KTFS080R01SS10M	KTFS080R03SS10M	KTFS080R05SS10M	KTFS080R08SS10M	KTFS080R12SF12M	8,000	.3150	8,499	.3346	F	170.306
KTFS085R01SS10M	KTFS085R03SS10M	KTFS085R05SS10M	KTFS085R08SS10M	KTFS085R12SF12M	8,500	.3346	8,999	.3543	G	170.306
KTFS090R01SS10M	KTFS090R03SS10M	KTFS090R05SS10M	KTFS090R08SS10M	KTFS090R12SF12M	9,000	.3544	9,499	.3739	H	170.306
KTFS095R01SS10M	KTFS095R03SS10M	KTFS095R05SS10M	KTFS095R08SS10M	KTFS095R12SF12M	9,500	.3740	9,999	.3936	I	170.306
KTFS100R01SS12M	KTFS100R03SS12M	KTFS100R05SS12M	KTFS100R08SS12M	KTFS100R12SF16M	10,000	.3937	10,499	.4133	J	170.307
KTFS105R01SS12M	KTFS105R03SS12M	KTFS105R05SS12M	KTFS105R08SS12M	KTFS105R12SF16M	10,500	.4134	10,999	.4330	K	170.307
KTFS110R01SS12M	KTFS110R03SS12M	KTFS110R05SS12M	KTFS110R08SS12M	KTFS110R12SF16M	11,000	.4331	11,499	.4527	L	170.307
KTFS115R01SS12M	KTFS115R03SS12M	KTFS115R05SS12M	KTFS115R08SS12M	KTFS115R12SF16M	11,500	.4528	11,999	.4724	M	170.307
KTFS120R01SS14M	KTFS120R03SS14M	KTFS120R05SS14M	KTFS120R08SS14M	KTFS120R12SF16M	12,000	.4725	12,499	.4921	N	170.308
KTFS125R01SS14M	KTFS125R03SS14M	KTFS125R05SS14M	KTFS125R08SS14M	KTFS125R12SF16M	12,500	.4922	12,999	.5117	O	170.308
KTFS130R01SS14M	KTFS130R03SS14M	KTFS130R05SS14M	KTFS130R08SS14M	KTFS130R12SF16M	13,000	.5118	13,499	.5314	P	170.308
KTFS135R01SS14M	KTFS135R03SS14M	KTFS135R05SS14M	KTFS135R08SS14M	KTFS135R12SF16M	13,500	.5315	13,999	.5511	Q	170.308
KTFS140R01SS16M	KTFS140R03SS16M	KTFS140R05SS16M	KTFS140R08SS16M	KTFS140R12SF16M	14,000	.5512	14,499	.5708	R	170.309
KTFS145R01SS16M	KTFS145R03SS16M	KTFS145R05SS16M	KTFS145R08SS16M	KTFS145R12SF16M	14,500	.5709	14,999	.5905	S	170.309
KTFS150R01SS16M	KTFS150R03SS16M	KTFS150R05SS16M	KTFS150R08SS16M	KTFS150R12SF20M	15,000	.5906	15,999	.6299	T	170.309
KTFS160R01SS16M	KTFS160R03SS16M	KTFS160R05SS16M	KTFS160R08SS16M	KTFS160R12SF20M	16,000	.6300	16,999	.6692	U	170.309
KTFS170R01SS20M	KTFS170R03SS20M	KTFS170R05SS20M	KTFS170R08SS20M	KTFS170R12SF20M	17,000	.6693	17,999	.7086	V	170.314
KTFS180R01SS20M	KTFS180R03SS20M	KTFS180R05SS20M	KTFS180R08SS20M	KTFS180R12SF25M	18,000	.7087	18,999	.7479	W	170.314
KTFS190R01SS20M	KTFS190R03SS20M	KTFS190R05SS20M	KTFS190R08SS20M	KTFS190R12SF25M	19,000	.7480	19,999	.7873	X	170.314

- KenTIP FS toolholder with flanged shank and 90° flat metric shank.
- Multi-coolant provides an advanced coolant channel layout with four coolant exits in each holder.
- Each tool body is shipped with related insert wrench.







Flanged Shank with Flat (SCF Shank)

KenTIP FS Flanged Shank with Flat • 1.5 x D/3 x D/5 x D/8 x D/12 x D • Metric

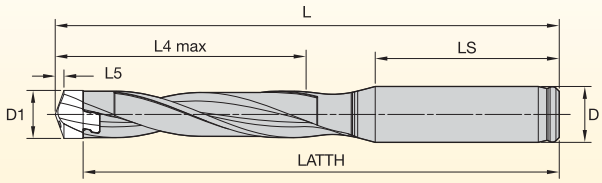
1.5 x D SCF	3 x D SCF	5 x D SCF	8 x D SCF	12 x D SCF	D1 mm	D1 in	D1 max mm	D1 max in	seat size	KenTIP wrench
–	KTFS080R03SCF12M	KTFS080R05SCF12M	KTFS080R08SCF12M	–	8,000	.3150	8,499	.3346	F	170.306
–	KTFS085R03SCF12M	KTFS085R05SCF12M	KTFS085R08SCF12M	–	8,500	.3346	8,999	.3543	G	170.306
–	KTFS090R03SCF12M	KTFS090R05SCF12M	KTFS090R08SCF12M	–	9,000	.3544	9,499	.3739	H	170.306
–	KTFS095R03SCF12M	KTFS095R05SCF12M	KTFS095R08SCF12M	–	9,500	.3740	9,999	.3936	I	170.306
–	KTFS100R03SCF16M	KTFS100R05SCF16M	KTFS100R08SCF16M	–	10,000	.3937	10,499	.4133	J	170.307
–	KTFS105R03SCF16M	KTFS105R05SCF16M	KTFS105R08SCF16M	–	10,500	.4134	10,999	.4330	K	170.307
–	KTFS110R03SCF16M	KTFS110R05SCF16M	KTFS110R08SCF16M	–	11,000	.4331	11,499	.4527	L	170.307
–	KTFS115R03SCF16M	KTFS115R05SCF16M	KTFS115R08SCF16M	–	11,500	.4528	11,999	.4724	M	170.307
–	KTFS120R03SCF16M	KTFS120R05SCF16M	KTFS120R08SCF16M	–	12,000	.4725	12,499	.4921	N	170.308
–	KTFS125R03SCF16M	KTFS125R05SCF16M	KTFS125R08SCF16M	–	12,500	.4922	12,999	.5117	O	170.308
–	KTFS130R03SCF16M	KTFS130R05SCF16M	KTFS130R08SCF16M	–	13,000	.5118	13,499	.5314	P	170.308
–	KTFS135R03SCF16M	KTFS135R05SCF16M	KTFS135R08SCF16M	–	13,500	.5315	13,999	.5511	Q	170.308
–	KTFS140R03SCF16M	KTFS140R05SCF16M	KTFS140R08SCF16M	–	14,000	.5512	14,499	.5708	R	170.309
–	KTFS145R03SCF16M	KTFS145R05SCF16M	KTFS145R08SCF16M	–	14,500	.5709	14,999	.5905	S	170.309
–	KTFS150R03SCF20M	KTFS150R05SCF20M	KTFS150R08SCF20M	–	15,000	.5906	15,999	.6299	T	170.309
–	KTFS160R03SCF20M	KTFS160R05SCF20M	KTFS160R08SCF20M	–	16,000	.6300	16,999	.6692	U	170.309
–	KTFS170R03SCF20M	KTFS170R05SCF20M	KTFS170R08SCF20M	–	17,000	.6693	17,999	.7086	V	170.314
–	KTFS180R03SCF25M	KTFS180R05SCF25M	KTFS180R08SCF25M	–	18,000	.7087	18,999	.7479	W	170.314
–	KTFS190R03SCF25M	KTFS190R05SCF25M	KTFS190R08SCF25M	–	19,000	.7480	19,999	.7873	X	170.314
KTFS200R01SCF25M	KTFS200R03SCF25M	KTFS200R05SCF25M	KTFS200R08SCF25M	KTFS200R12SCF25M	20,000	.7874	20,999	.8267	Y	170.314
KTFS210R01SCF25M	KTFS210R03SCF25M	KTFS210R05SCF25M	KTFS210R08SCF25M	KTFS210R12SCF25M	21,000	.8268	21,999	.8661	Z	170.314
KTFS220R01SCF25M	KTFS220R03SCF25M	KTFS220R05SCF25M	KTFS220R08SCF25M	KTFS220R12SCF25M	22,000	.8662	22,999	.9054	ZA	170.314
KTFS230R01SCF25M	KTFS230R03SCF25M	KTFS230R05SCF25M	KTFS230R08SCF25M	KTFS230R12SCF25M	23,000	.9055	23,999	.9448	ZB	170.314
KTFS240R01SCF25M	KTFS240R03SCF25M	KTFS240R05SCF25M	KTFS240R08SCF25M	KTFS240R12SCF25M	24,000	.9449	24,999	.9842	ZC	170.314
KTFS250R01SCF25M	KTFS250R03SCF25M	KTFS250R05SCF25M	KTFS250R08SCF25M	KTFS250R12SCF25M	25,000	.9843	25,999	1.0236	ZD	170.314

NOTE: **Products with D1 ≥ 20mm will be available by January 1st, 2018.**

Modular Drills • Dimension Tables

Straight Round Shank • Metric





					1.5 x D SS			3 x D SS			5 x D SS			8 x D SS		
D1 min	D1 max	Seat	LS	round D	LATTH	L	L4 max	LATTH	L	L4 max	LATTH	L	L4 max	LATTH	L	L4 max
6,000	6,299	A	37	8	53,5	57	9	63,5	67	19	76,5	80	32	94,5	98	50
6,300	6,599	B	37	8	54,3	58	10	64,3	68	20	77,3	81	33	97,3	101	53
6,600	6,999	C	37	8	55,2	59	10	66,2	70	21	80,2	84	35	101,2	105	56
7,000	7,499	D	37	8	55,9	60	11	66,9	71	22	82,9	87	38	104,9	109	60
7,500	7,999	E	37	8	56,7	61	12	68,7	73	24	84,7	89	40	108,7	113	64
8,000	8,499	F	41	10	63,4	68	13	76,4	81	26	92,4	97	42	118,4	123	68
8,500	8,999	G	41	10	64,1	69	14	77,1	82	27	95,1	100	45	122,1	127	72
9,000	9,499	H	41	10	63,8	69	14	77,8	83	28	97,8	103	48	125,8	131	76
9,500	9,999	I	41	10	64,5	70	15	79,5	85	30	99,5	105	50	129,5	135	80
10,000	10,499	J	46	12	72,2	78	16	88,2	94	32	108,2	114	52	140,2	146	84
10,500	10,999	K	46	12	71,9	78	16	88,9	95	33	110,9	117	55	143,9	150	88
11,000	11,499	L	46	12	72,6	79	17	89,6	96	34	113,6	120	58	147,6	154	92
11,500	11,999	M	46	12	73,3	80	18	91,3	98	36	115,3	122	60	151,3	158	96
12,000	12,499	N	46	14	76,0	83	19	95,0	102	38	119,0	126	62	157,0	164	100
12,500	12,999	O	46	14	76,8	84	20	95,8	103	39	121,8	129	65	160,8	168	104
13,000	13,499	P	46	14	76,5	84	20	96,5	104	40	124,5	132	68	164,5	172	108
13,500	13,999	Q	46	14	77,2	85	21	98,2	106	42	126,2	134	70	168,2	176	112
14,000	14,499	R	49	16	81,9	90	22	103,9	112	44	131,9	140	72	175,9	184	116
14,500	14,999	S	49	16	81,6	90	22	104,6	113	45	134,6	143	75	179,6	188	120
15,000	15,999	T	49	16	83,3	92	24	107,3	116	48	139,3	148	80	187,3	196	128
16,000	16,999	U	49	16	84,7	94	26	109,7	119	51	143,7	153	85	194,7	204	136
17,000	17,999	V	51	20	90,1	100	27	117,1	127	54	153,1	163	90	207,1	217	144
18,000	18,999	W	51	20	90,6	101	28	119,6	130	57	157,6	168	95	214,6	225	152
19,000	19,999	X	51	20	92,0	103	30	122,0	133	60	162,0	173	100	222,0	233	160

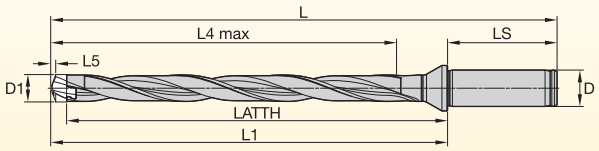
NOTE: Toolholder dimensions:
L: Total length of drill
L4: Max. drilling depth
L5: Protruding length (Insert specific. See related insert pages)
LATTH: Pocket seat reference length
LS: Shank length

(continued)

Modular Drills • Dimension Tables *(continued)*

Flanged Round Shank • Metric





					12 x D SF			
D1 min	D1 max	Seat	LS	flanged D	LATTH	L	L1	L4 max
6,000	6,299	A	45	12	92,5	141	96	76
6,300	6,599	B	45	12	95,3	144	99	79
6,600	6,999	C	45	12	101,2	150	105	84
7,000	7,499	D	45	12	106,9	156	111	90
7,500	7,999	E	45	12	112,7	162	117	96
8,000	8,499	F	45	12	118,4	168	123	102
8,500	8,999	G	45	12	124,1	174	129	108
9,000	9,499	H	45	12	129,8	180	135	114
9,500	9,999	I	45	12	135,5	186	141	120
10,000	10,499	J	48	16	144,2	198	150	126
10,500	10,999	K	48	16	149,9	204	156	132
11,000	11,499	L	48	16	155,6	210	162	138
11,500	11,999	M	48	16	161,3	216	168	144
12,000	12,499	N	48	16	167,0	222	174	150
12,500	12,999	O	48	16	172,8	228	180	156
13,000	13,499	P	48	16	178,5	234	186	162
13,500	13,999	Q	48	16	184,2	240	192	168
14,000	14,499	R	48	16	189,9	246	198	174
14,500	14,999	S	48	16	195,6	252	204	180
15,000	15,999	T	50	20	210,3	269	219	192
16,000	16,999	U	50	20	221,7	281	231	204
17,000	17,999	V	50	20	233,1	293	243	216
18,000	18,999	W	56	25	247,6	314	258	228
19,000	19,999	X	56	25	259,0	326	270	240

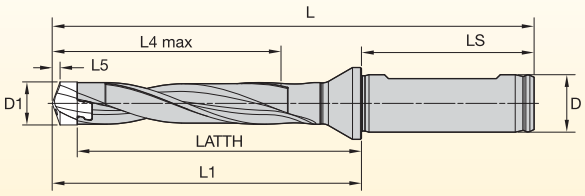
NOTE: Toolholder dimensions:
L: Total length of drill
L1: Drill length including flange
L4: Max. drilling depth
L5: Protruding length (Insert specific. See related insert pages)
LATTH: Pocket seat reference length
LS: Shank length

(continued)

Modular Drills • Dimension Tables *(continued)*

Flanged Shank with Flat • Metric

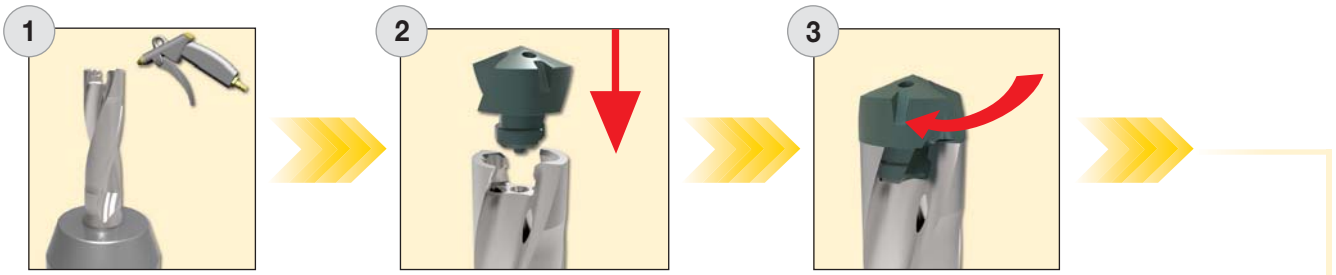




					1.5 x D SCF				3 x D SCF				5 x D SCF				8 x D SCF				12 x D SCF			
D1 min	D1 max	Seat	LS	flanged D	LATTH	L	L1	L4 max	LATTH	L	L1	L4 max	LATTH	L	L1	L4 max	LATTH	L	L1	L4 max	LATTH	L	L1	L4 max
8,000	8,499	F	45	12	–	–	–	–	42,4	92	2	26	58,4	108	2	42	84,4	134	4	68	–	–	–	–
8,500	8,999	G	45	12	–	–	–	–	43,1	93	2	27	61,1	111	3	45	88,1	138	4	72	–	–	–	–
9,000	9,499	H	45	12	–	–	–	–	43,8	94	2	28	63,8	114	3	48	91,8	142	4	76	–	–	–	–
9,500	9,999	I	45	12	–	–	–	–	45,5	96	2	30	65,5	116	3	50	95,5	146	4	80	–	–	–	–
10,000	10,499	J	48	16	–	–	–	–	50,2	104	2	32	70,2	124	3	52	102,2	156	4	84	–	–	–	–
10,500	10,999	K	48	16	–	–	–	–	50,9	105	2	33	72,9	127	3	55	105,9	160	4	88	–	–	–	–
11,000	11,499	L	48	16	–	–	–	–	51,6	106	2	34	75,6	130	3	58	109,6	164	5	92	–	–	–	–
11,500	11,999	M	48	16	–	–	–	–	53,3	108	2	36	77,3	132	3	60	113,3	168	5	96	–	–	–	–
12,000	12,499	N	48	16	–	–	–	–	55,0	110	2	38	79,0	134	3	62	117,0	172	5	100	–	–	–	–
12,500	12,999	O	48	16	–	–	–	–	55,8	111	2	39	81,8	137	4	65	120,8	176	5	104	–	–	–	–
13,000	13,499	P	48	16	–	–	–	–	56,5	112	3	40	84,5	140	4	68	124,5	180	5	108	–	–	–	–
13,500	13,999	Q	48	16	–	–	–	–	58,2	114	3	42	86,2	142	4	70	128,2	184	5	112	–	–	–	–
14,000	14,499	R	48	16	–	–	–	–	59,9	116	3	44	87,9	144	4	72	131,9	188	6	116	–	–	–	–
14,500	14,999	S	48	16	–	–	–	–	60,6	117	3	45	90,6	147	4	75	135,6	192	6	120	–	–	–	–
15,000	15,999	T	50	20	–	–	–	–	66,3	125	3	48	98,3	157	4	80	146,3	205	6	128	–	–	–	–
16,000	16,999	U	50	20	–	–	–	–	68,7	128	3	51	102,7	162	4	85	153,7	213	6	136	–	–	–	–
17,000	17,999	V	50	20	–	–	–	–	71,1	131	3	54	107,1	167	5	90	161,1	221	7	144	–	–	–	–
18,000	18,999	W	56	25	–	–	–	–	76,6	143	3	57	114,6	181	5	95	171,6	238	7	152	–	–	–	–
19,000	19,999	X	56	25	–	–	–	–	79,0	146	4	60	119,0	186	5	100	179,0	246	7	160	–	–	–	–
20,000	20,999	Y	56	25	50,4	118	2	32	81,4	149	4	63	123,4	191	5	105	186,4	254	8	168	270,4	338	11	252
21,000	21,999	Z	56	25	50,8	119	2	33	83,8	152	4	66	127,8	196	6	110	193,8	262	8	176	281,8	350	12	264
22,000	22,999	ZA	56	25	51,2	120	3	34	86,2	155	4	69	132,2	201	6	115	201,2	270	8	184	293,2	362	12	276
23,000	23,999	ZB	56	25	52,7	122	3	36	88,7	158	4	72	136,7	206	6	120	208,7	278	9	192	304,7	374	13	288
24,000	24,999	ZC	56	25	54,1	124	3	38	91,1	161	4	75	141,1	211	6	125	216,1	286	9	200	316,1	386	13	300
25,000	25,999	ZD	56	25	54,5	125	3	39	93,5	164	4	78	145,5	216	6	130	223,5	294	9	208	327,5	398	13	312

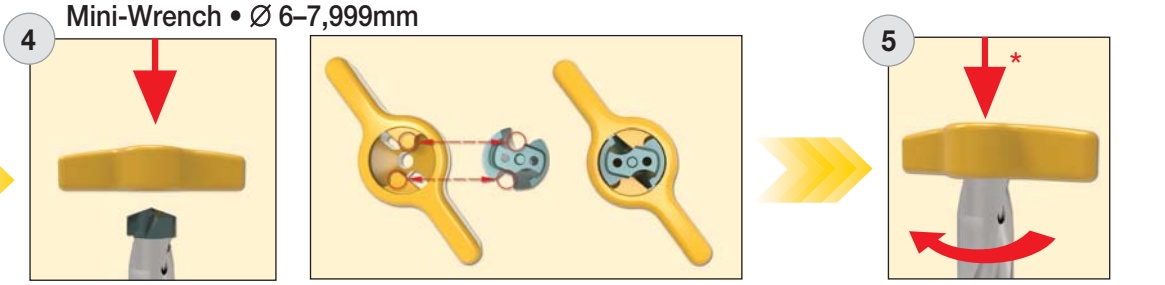
NOTE: Toolholder dimensions:
L: Total length of drill
L1: Drill length including flange
L4: Max. drilling depth
L5: Protruding length (Insert specific. See related insert pages)
LATTH: Pocket seat reference length
LS: Shank length

Mounting



1. Protect your eyes and hands. Fix holder. Clean pocket with air blast.
2. Put insert into pocket seat so it rests firmly on the holder.
3. Turn slightly in clockwise direction using your fingers.

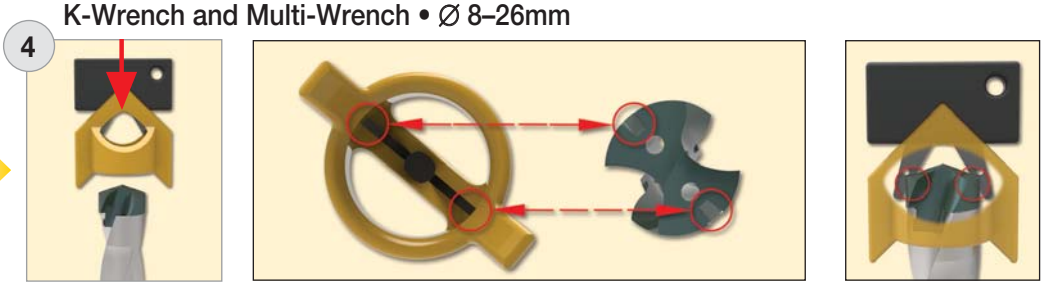
Mini-Wrench • Ø 6–7,999mm



4. Set wrench properly onto insert: Wrench noses must fit firmly into the chip grooves.

*For unmounting, firmly press wrench on insert to avoid slipping.

K-Wrench and Multi-Wrench • Ø 8–26mm



4. Set wrench properly onto insert: Wrench blade must fit firmly into slots on insert flanks.

Available Smart Wrenches

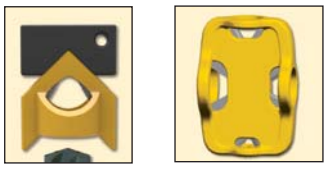
Mini-Wrench

Wrench noses must fit into the chip grooves.

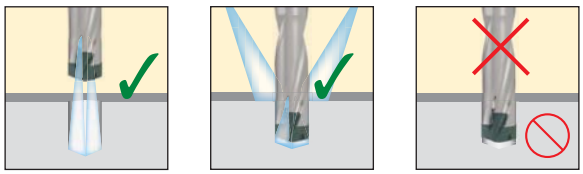


K-Wrench **Multi-Wrench**

Wrench blades must fit into insert slots.



Coolant



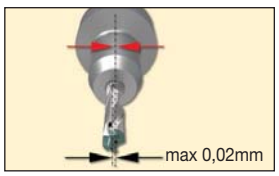
Internal coolant is recommended for all applications.

Flood coolant only for drilling depth ≤ 3 x D.

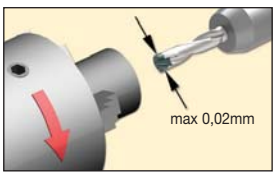
Dry cutting is not recommended. MQL ability is limited.

Core Deviation

Machining Center



Stationary Drill/Lathe

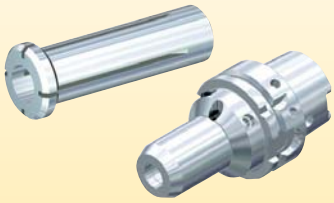


Rotating Applications

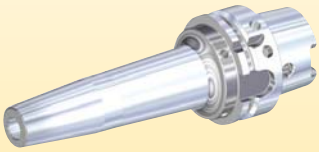
KenTIP FS holders with straight cylindrical SS and SF shanks (no flats) are designed for rotating applications where the drill rotates while the workpiece remains stationary. The shank to drill-point location of these drills is held to an extremely close tolerance. To maintain accuracy and gain maximum performance, please use the approved toolholding method shown below.



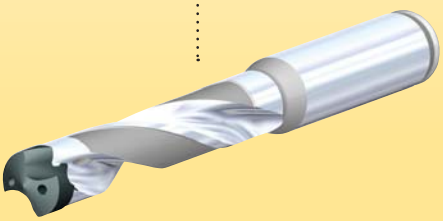
ERICKSON™ ER collet chucks



ERICKSON Hydrochuck HP Line

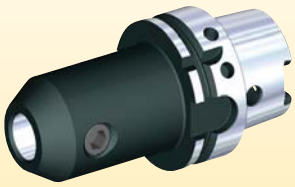


ERICKSON Shrink Fit toolholders for general purpose

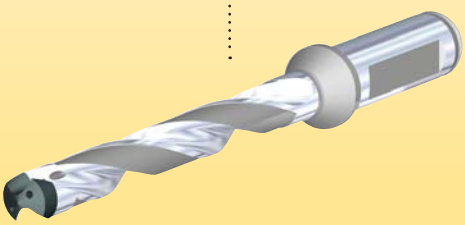


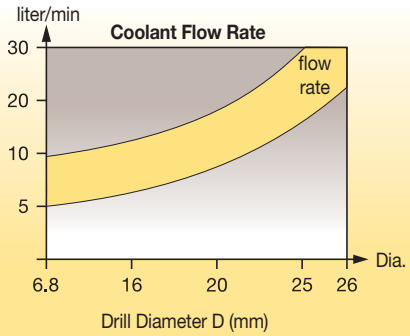
Rotating and Stationary Applications

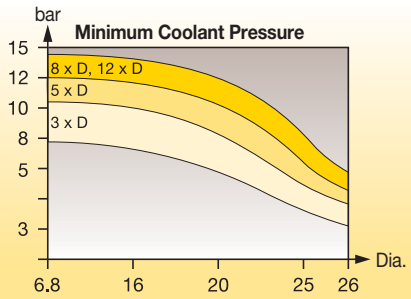
KenTIP FS holders with SCF shanks (Cylindrical with 90° flat and flange) are reducing deflections and represent a stiffer holder solution. As the shank is compatible with End Mill adaptors, these holders are very flexible in use. SCF shanks can be used in any rotating applications and are suited for lathe and other settings where the tool is stationary.



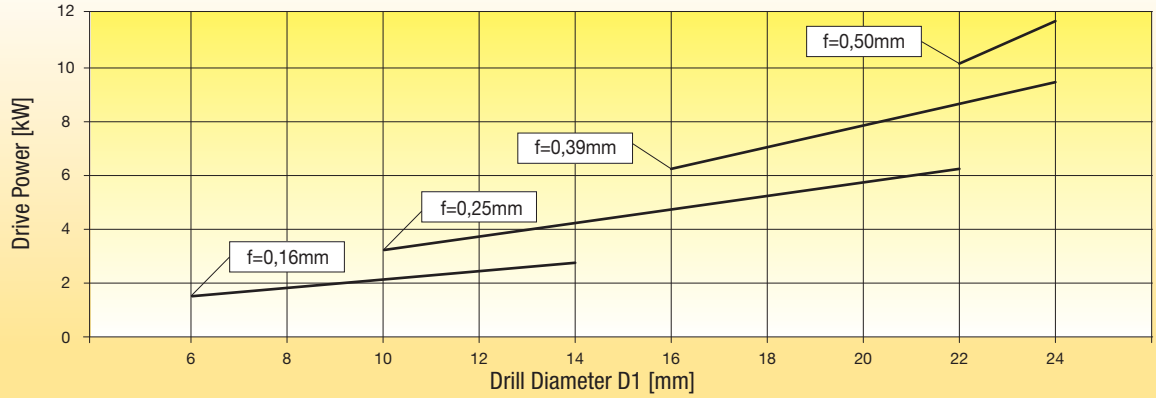
EM adaptors



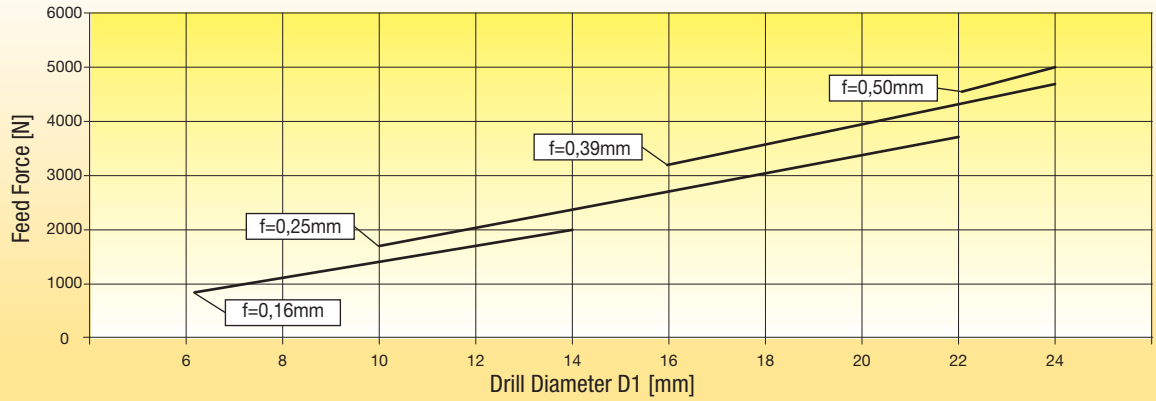




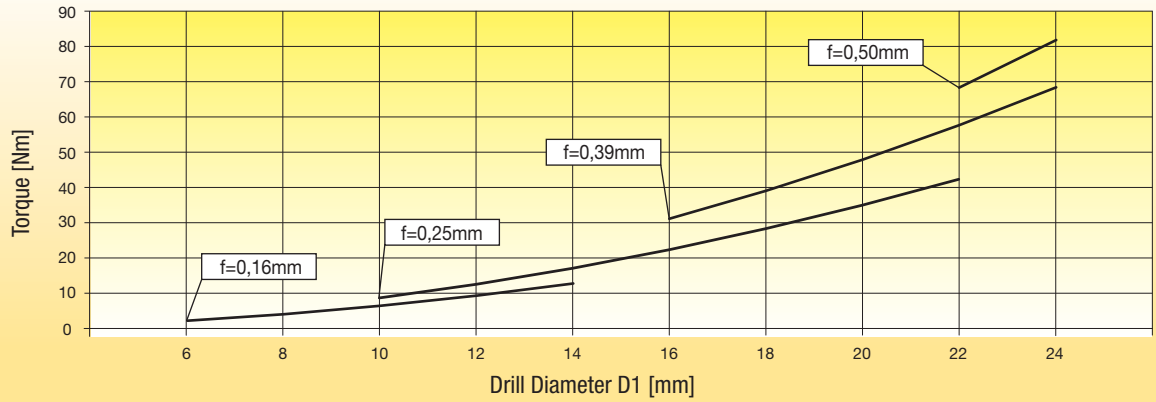
Drive Power (kW)



Feed Force (N)



Torque (Nm)



NOTE: The diagrams above are used to determine the drive power, feed force, and torque. They are based on cutting force measurement in tempered steels with a tensile strength: Rm = 750 N/mm^2. The base cutting speed used is: vc = 80 m/min.

KenTIP™ Modular Drill System

Primary Application

The KenTIP modular drill system offers performance levels commonly achieved with solid carbide drills. The proprietary locking system enables inserts to be changed inside the machine tool. Use KenTIP in steel, cast iron, ductile iron, and stainless steel applications. KenTIP modular drills are available up to diameter 27,99mm (1.1020"). Change drilling inserts within the machine without taking the body off, saving setup time and manufacturing costs.

With our new FEG Flat bottom E-shape inserts, the KenTIP modular drill system now offers an easy and very reliable solution to drill blind holes that performs on a very wide range of difficult applications.

Features and Benefits

Advanced Interface

- Strong pocket seats on all inserts and bodies.
- Long tip and body life in unstable conditions, especially when side loads occur.

Disposable Inserts

- No reconditioning costs.
- Consistent performance.
- Eliminates number of tools waiting for reconditioning, providing significant cost savings.

HP Drill-Point Design

- Very high feed rates possible.
- Low thrust prevents workpiece flexing.
- Excellent centring capabilities.

Tailored Grades and Geometries

- KCP15™ grade has a new PVD coating enabling longer tool life in all steel applications.
- KCPM45™ grade combines a very tough, fine-grain carbide substrate with a TiAlN PVD coating. It is used on our FEG flat-bottom inserts.
- For applications in cast iron and stainless steel, we recommend to use our new KenTIP FS modular drill. Please see page H6 for drills.
- For further availability on KC7320™ HPL and KC7410™ HPC inserts for KenTIP, please refer to NOVO™ or contact your sales representative.

Easy Insert Change

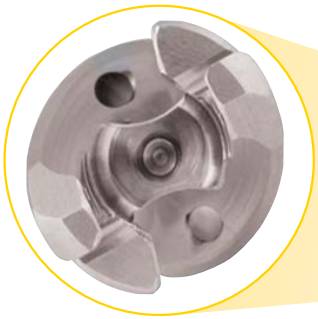
- Locking method requires no screws or clamps.
- Insert blades can be changed with a simple provided tool and do not require drill body removal from the machine or holder.

NEW!

FEG Style, E-shape Flat-Bottom Inserts

KenTIP™ FEG inserts create blind holes, through holes, and countersinks. These inserts are focused on versatility and will support you in many essential drilling applications.







Drill Body Portfolio

- Standard 12 x D holders with round shanks available, inch and metric. This covers the complete KenTIP diameter range.
- Standard 3, 5, and 8 x D tool bodies with round and flanged shank available, inch and metric.
- Standard 1.5 x D bodies available, especially for piloting operations on metric drill bodies.

Customisation

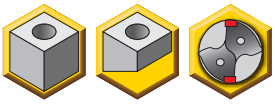
- Intermediate diameters available as semi-standards.
- Close tolerance tips available for precision holes.
- Chamfering insert pockets available.
- Multiple steps possible.
- CounterFix Micro tangential inserts for small diameter step drills.

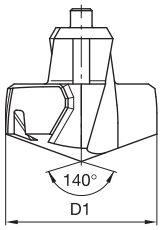


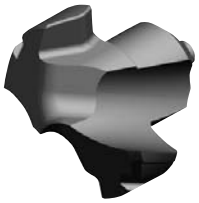
NEW!

CounterFix Micro Tangential Inserts

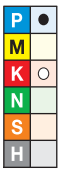
- KenTIP KCP15™ HP cutting edges enable high metal removal rates and superior tool life for steel applications.
- KenTIP HP geometry works with low cutting and feed forces and provides very good centring. Reinforced cutting edges and good chip forming improve tool life due to high wear and edge chipping resistance.
- KCP15 is a fine grain carbide with a TiAlN-based PVD nanolayer coating with greatly improved layer bonding for higher tool life. Its increased Al content provides better thermal and chemical stability, which makes it more suitable for higher cutting speeds.
- KenTIP KCP15 HP cutting edges are perfectly suited to drill alloyed and high alloy steels.
- Use KenTIP KCP15 HP cutting edges as an alternative in cast iron materials.





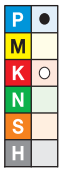

HP

KenTIP Inserts • HP KCP15



● first choice
○ alternate choice

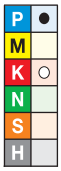
KCP15	D1 mm	D1 in	seat size
KTIP0794HPM	7,938	.3125	F
KTIP0800HPM	8,000	.3150	F
KTIP0810HPM	8,100	.3189	F
KTIP0816HPM	8,164	.3214	F
KTIP0820HPM	8,204	.3230	F
KTIP0830HPM	8,300	.3268	F
KTIP0833HPM	8,334	.3281	F
KTIP0840HPM	8,400	.3307	F
KTIP0843HPM	8,433	.3320	F
KTIP0850HPM	8,500	.3346	G
KTIP0860HPM	8,600	.3386	G
KTIP0861HPM	8,611	.3390	G
KTIP0870HPM	8,700	.3425	G
KTIP0873HPM	8,733	.3438	G
KTIP0880HPM	8,800	.3465	G
KTIP0884HPM	8,839	.3480	G
KTIP0890HPM	8,900	.3504	G
KTIP0900HPM	9,000	.3543	H
KTIP0909HPM	9,093	.3580	H
KTIP0910HPM	9,100	.3583	H
KTIP0913HPM	9,129	.3594	H
KTIP0920HPM	9,200	.3622	H
KTIP0930HPM	9,300	.3661	H
KTIP0935HPM	9,347	.3680	H
KTIP0940HPM	9,400	.3701	H
KTIP0950HPM	9,500	.3740	I
KTIP0953HPM	9,525	.3750	I
KTIP0956HPM	9,558	.3763	I
KTIP0958HPM	9,576	.3770	I
KTIP0960HPM	9,600	.3780	I
KTIP0970HPM	9,703	.3820	I
KTIP0980HPM	9,804	.3860	I



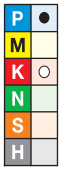
KCP15	D1 mm	D1 in	seat size
KTIP0983HPM	9,830	.3870	I
KTIP0990HPM	9,900	.3898	I
KTIP0992HPM	9,921	.3906	I
KTIP1000HPM	10,000	.3937	J
KTIP1002HPM	10,023	.3946	J
KTIP1008HPM	10,084	.3970	J
KTIP1010HPM	10,100	.3976	J
KTIP1020HPM	10,200	.4016	J
KTIP1026HPM	10,262	.4040	J
KTIP1030HPM	10,300	.4055	J
KTIP1032HPM	10,320	.4063	J
KTIP1040HPM	10,400	.4094	J
KTIP1049HPM	10,490	.4130	J
KTIP1050HPM	10,500	.4134	K
KTIP1060HPM	10,600	.4173	K
KTIP1070HPM	10,700	.4213	K
KTIP1072HPM	10,716	.4219	K
KTIP1080HPM	10,800	.4252	K
KTIP1090HPM	10,900	.4291	K
KTIP1100HPM	11,000	.4331	L
KTIP1110HPM	11,100	.4370	L
KTIP1111HPM	11,113	.4375	L
KTIP1120HPM	11,200	.4409	L
KTIP1130HPM	11,300	.4449	L
KTIP1140HPM	11,400	.4488	L
KTIP1150HPM	11,500	.4528	M
KTIP1151HPM	11,509	.4531	M
KTIP1160HPM	11,600	.4567	M
KTIP1161HPM	11,610	.4571	M
KTIP1170HPM	11,700	.4606	M
KTIP1180HPM	11,800	.4646	M
KTIP1190HPM	11,900	.4685	M

(continued)

(KenTIP Inserts • HP KCP15™ — continued)



KCP15	D1 mm	D1 in	seat size
KTIP1191HPM	11,908	.4688	M
KTIP1200HPM	12,000	.4724	N
KTIP1210HPM	12,100	.4764	N
KTIP1220HPM	12,200	.4803	N
KTIP1230HPM	12,304	.4844	N
KTIP1240HPM	12,400	.4882	N
KTIP1247HPM	12,474	.4911	N
KTIP1250HPM	12,500	.4921	O
KTIP1260HPM	12,600	.4961	O
KTIP1270HPM	12,700	.5000	O
KTIP1280HPM	12,800	.5039	O
KTIP1290HPM	12,903	.5080	O
KTIP1300HPM	13,000	.5118	P
KTIP1310HPM	13,096	.5156	P
KTIP1320HPM	13,200	.5197	P
KTIP1328HPM	13,280	.5228	P
KTIP1330HPM	13,300	.5236	P
KTIP1338HPM	13,380	.5268	P
KTIP1340HPM	13,400	.5276	P
KTIP1349HPM	13,494	.5313	P
KTIP1350HPM	13,500	.5315	Q
KTIP1360HPM	13,600	.5354	Q
KTIP1370HPM	13,700	.5394	Q
KTIP1380HPM	13,800	.5433	Q
KTIP1389HPM	13,891	.5469	Q
KTIP1390HPM	13,896	.5471	Q
KTIP1394HPM	13,940	.5488	Q
KTIP1400HPM	14,000	.5512	R
KTIP1410HPM	14,100	.5551	R
KTIP1420HPM	14,200	.5591	R
KTIP1429HPM	14,288	.5625	R
KTIP1430HPM	14,300	.5630	R
KTIP1440HPM	14,400	.5669	R
KTIP1450HPM	14,500	.5709	S
KTIP1460HPM	14,600	.5748	S
KTIP1467HPM	14,666	.5774	S
KTIP1468HPM	14,684	.5781	S
KTIP1470HPM	14,700	.5787	S
KTIP1480HPM	14,800	.5827	S
KTIP1490HPM	14,900	.5866	S
KTIP1500HPM	15,000	.5906	T
KTIP1508HPM	15,083	.5938	T
KTIP1510HPM	15,100	.5945	T
KTIP1520HPM	15,200	.5984	T
KTIP1530HPM	15,300	.6024	T
KTIP1538HPM	15,380	.6055	T
KTIP1540HPM	15,400	.6063	T
KTIP1548HPM	15,479	.6094	T
KTIP1550HPM	15,500	.6102	T
KTIP1560HPM	15,600	.6142	T
KTIP1570HPM	15,700	.6181	T
KTIP1580HPM	15,800	.6220	T



● first choice
○ alternate choice

KCP15	D1 mm	D1 in	seat size
KTIP1588HPM	15,875	.6250	T
KTIP1600HPM	16,000	.6299	U
KTIP1603HPM	16,027	.6310	U
KTIP1608HPM	16,078	.6330	U
KTIP1610HPM	16,100	.6339	U
KTIP1620HPM	16,200	.6378	U
KTIP1627HPM	16,271	.6406	U
KTIP1630HPM	16,300	.6417	U
KTIP1640HPM	16,400	.6457	U
KTIP1650HPM	16,500	.6496	U
KTIP1660HPM	16,600	.6535	U
KTIP1667HPM	16,670	.6563	U
KTIP1670HPM	16,700	.6575	U
KTIP1680HPM	16,800	.6614	U
KTIP1690HPM	16,900	.6654	U
KTIP1700HPM	17,000	.6693	V
KTIP1707HPM	17,066	.6719	V
KTIP1710HPM	17,100	.6732	V
KTIP1720HPM	17,200	.6772	V
KTIP1730HPM	17,300	.6811	V
KTIP1740HPM	17,400	.6850	V
KTIP1748HPM	17,463	.6875	V
KTIP1750HPM	17,500	.6890	V
KTIP1760HPM	17,600	.6929	V
KTIP1770HPM	17,700	.6969	V
KTIP1780HPM	17,800	.7008	V
KTIP1786HPM	17,859	.7031	V
KTIP1790HPM	17,900	.7047	V
KTIP1800HPM	18,000	.7087	W
KTIP1810HPM	18,100	.7126	W
KTIP1820HPM	18,200	.7165	W
KTIP1826HPM	18,258	.7188	W
KTIP1830HPM	18,300	.7205	W
KTIP1840HPM	18,400	.7244	W
KTIP1850HPM	18,500	.7283	W
KTIP1860HPM	18,600	.7323	W
KTIP1865HPM	18,654	.7344	W
KTIP1870HPM	18,700	.7362	W
KTIP1880HPM	18,800	.7402	W
KTIP1890HPM	18,900	.7441	W
KTIP1900HPM	19,000	.7480	X
KTIP1905HPM	19,050	.7500	X
KTIP1910HPM	19,100	.7520	X
KTIP1920HPM	19,200	.7559	X
KTIP1923HPM	19,228	.7570	X
KTIP1925HPM	19,253	.7580	X
KTIP1930HPM	19,300	.7598	X
KTIP1935HPM	19,350	.7620	X
KTIP1940HPM	19,400	.7638	X
KTIP1946HPM	19,446	.7656	X
KTIP1950HPM	19,500	.7677	X
KTIP1960HPM	19,600	.7717	X

(continued)

(KenTIP Inserts • HP KCP15™ — continued)

P ● M K ○ N S H	D1		
KCP15	mm	in	seat size
KTIP1970HPM	19,700	.7756	X
KTIP1980HPM	19,800	.7795	X
KTIP1984HPM	19,844	.7813	X
KTIP1990HPM	19,900	.7835	X
KTIP2000HPM	20,000	.7874	Y
KTIP2010HPM	20,100	.7913	Y
KTIP2020HPM	20,200	.7953	Y
KTIP2024HPM	20,241	.7969	Y
KTIP2030HPM	20,300	.7992	Y
KTIP2050HPM	20,500	.8071	Y
KTIP2060HPM	20,600	.8110	Y
KTIP2064HPM	20,638	.8125	Y
KTIP2070HPM	20,700	.8150	Y
KTIP2080HPM	20,800	.8189	Y
KTIP2090HPM	20,900	.8228	Y
KTIP2099HPM	20,990	.8264	Y
KTIP2100HPM	21,000	.8268	Z
KTIP2110HPM	21,100	.8307	Z
KTIP2143HPM	21,432	.8438	Z
KTIP2150HPM	21,500	.8465	Z
KTIP2200HPM	22,000	.8661	ZA
KTIP2223HPM	22,225	.8750	ZA
KTIP2250HPM	22,500	.8858	ZA
KTIP2280HPM	22,800	.8976	ZA

P ● M K ○ N S H	D1		
KCP15	mm	in	seat size
KTIP2300HPM	23,000	.9055	ZB
KTIP2350HPM	23,500	.9252	ZB
KTIP2381HPM	23,813	.9375	ZB
KTIP2400HPM	24,000	.9449	ZC
KTIP2450HPM	24,500	.9646	ZC
KTIP2461HPM	24,608	.9688	ZC
KTIP2500HPM	25,000	.9843	ZD
KTIP2540HPM	25,400	1.0000	ZD
KTIP2550HPM	25,500	1.0039	ZD
KTIP2567HPM	25,679	1.0110	ZD
KTIP2581HPM	25,806	1.0160	ZD
KTIP2599HPM	25,990	1.0232	ZD
KTIP2600HPM	26,000	1.0236	ZE
KTIP2619HPM	26,187	1.0310	ZE
KTIP2650HPM	26,500	1.0433	ZE
KTIP2659HPM	26,590	1.0469	ZE
KTIP2700HPM	27,000	1.0630	ZE
KTIP2750HPM	27,500	1.0827	ZE
KTIP2778HPM	27,780	1.0938	ZE
KTIP2799HPM	27,990	1.1020	ZE

● first choice
○ alternate choice

KenTIP HP Geometry

Tolerance

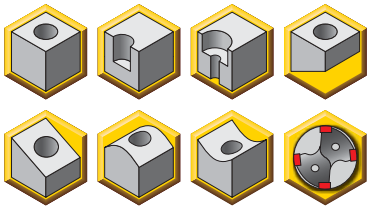
D1 metric	tolerance k8
8–10	0,000/+0,022
>10–17	0,000/+0,027
>17–18	0,000/+0,027
>18–28	0,000/+0,033

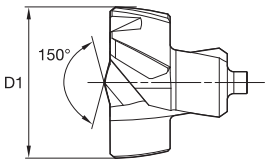
Application Data

Modular Drill Carbide Insert Blades • KenTIP™ • HP Geometry • Grade KCP15™ • Through Coolant • Metric

Material Group		Cutting Speed — vc Range — m/min			Metric								
					Recommended Feed Rate (f) by Diameter								
		min	Starting Value	max		8,0	10,0	12,0	14,0	16,0	20,0	24,0	28,0
P	1	90	**130**	180	mm/r	0,12–0,21	0,14–0,26	0,15–0,33	0,18–0,41	0,20–0,47	0,26–0,50	0,27–0,51	0,30–0,54
	2	110	**150**	190	mm/r	0,12–0,25	0,14–0,30	0,15–0,35	0,18–0,38	0,20–0,47	0,26–0,50	0,27–0,51	0,30–0,54
	3	50	**80**	110	mm/r	0,12–0,29	0,13–0,37	0,17–0,39	0,22–0,48	0,24–0,48	0,32–0,54	0,32–0,54	0,35–0,56
	4	50	**80**	110	mm/r	0,12–0,29	0,13–0,37	0,17–0,39	0,18–0,48	0,19–0,48	0,24–0,48	0,35–0,46	0,27–0,46
K	1	60	**100**	180	mm/r	0,16–0,30	0,17–0,34	0,18–0,37	0,22–0,44	0,26–0,50	0,33–0,62	0,35–0,65	0,40-0,70
	2	60	**80**	90	mm/r	0,16–0,30	0,17–0,32	0,18–0,35	0,22–0,43	0,26–0,50	0,33–0,62	0,35–0,65	0,40–0,70
	3	40	**70**	90	mm/r	0,17–0,32	0,18–0,35	0,19–0,38	0,21–0,43	0,22–0,46	0,24–0,50	0,25–0,51	0,40-0,70

- KenTIP FEG flat-bottom inserts create 180° flat holes — only a small cavity remains in the centre of the hole ground. KenTIP offers easy-to-change disposable inserts and low cutting forces for your flat-bottom applications.
- Whether it is a blind hole, a through hole, or if you need to countersink, these inserts are focused on versatility and will support you in many essential drilling applications.
- KenTIP FEG inserts feature a small centring point as well as double margin lands for improved guidance and hole straightness. A corner chamfer serves to reduce bur formation and to improve tool life.
- KCPM45™ combines a very tough, fine-grain carbide substrate with an advanced multilayer TiAlN coating. It is capable of machining steel even in the most demanding conditions.
- Use KenTIP FEG KCPM45 cutting edges as an effective alternative in cast iron and stainless steel.







KenTIP Inserts • FEG (Flat Bottom)

P ● M ○ K ○ N S H

KCPM45	D1 mm	D1 in	seat size
KTIP0794FEGM	7,938	.3125	F
KTIP0800FEGM	8,000	.3150	F
KTIP0850FEGM	8,500	.3346	G
KTIP0852FEGM	8,520	.3354	G
KTIP0900FEGM	9,000	.3543	H
KTIP0913FEGM	9,130	.3594	H
KTIP0950FEGM	9,500	.3740	I
KTIP1000FEGM	10,000	.3937	J
KTIP1010FEGM	10,100	.3976	J
KTIP1050FEGM	10,500	.4134	K
KTIP1080FEGM	10,800	.4252	K
KTIP1100FEGM	11,000	.4331	L
KTIP1150FEGM	11,500	.4528	M
KTIP1170FEGM	11,700	.4606	M
KTIP1200FEGM	12,000	.4724	N
KTIP1250FEGM	12,500	.4921	O
KTIP1270FEGM	12,700	.5000	O
KTIP1300FEGM	13,000	.5118	P
KTIP1350FEGM	13,500	.5315	Q
KTIP1400FEGM	14,000	.5512	R

P ● M ○ K ○ N S H

● first choice
○ alternate choice

KCPM45	D1 mm	D1 in	seat size
KTIP1450FEGM	14,500	.5709	S
KTIP1490FEGM	14,900	.5866	S
KTIP1500FEGM	15,000	.5906	T
KTIP1550FEGM	15,500	.6102	T
KTIP1595FEGM	15,950	.6280	T
KTIP1600FEGM	16,000	.6299	U
KTIP1650FEGM	16,500	.6496	U
KTIP1700FEGM	17,000	.6693	V
KTIP1750FEGM	17,500	.6890	V
KTIP1770FEGM	17,700	.6969	V
KTIP1800FEGM	18,000	.7087	W
KTIP1850FEGM	18,500	.7283	W
KTIP1900FEGM	19,000	.7480	X
KTIP1905FEGM	19,050	.7500	X
KTIP1950FEGM	19,500	.7677	X
KTIP2000FEGM	20,000	.7874	Y

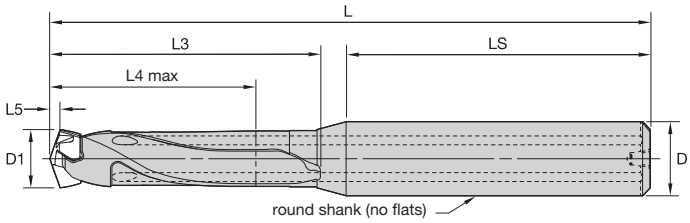
KenTIP FEG Geometry Tolerance

D1 metric	tolerance s7
8–10	+0,023/+0,038
>10–18	+0,028/+0,046
>18–28	+0,035/+0,056

Modular Drill Carbide Insert Blades • KenTIP™ • FEG Geometry • Grade KCPM45™ • Through Coolant • Metric

Material Group		Cutting Speed — vc Range — m/min			Metric								
					Recommended Feed Rate (f) by Diameter								
		min	Starting Value	max		8,0	10,0	12,0	14,0	16,0	20,0	24,0	28,0
P	1	110	**140**	170	mm/r	0,14–0,23	0,14–0,23	0,14–0,23	0,14–0,23	0,17–0,25	0,19–0,29	0,23–0,38	0,23–0,38
	2	100	**120**	140	mm/r	0,17–0,23	0,17–0,23	0,17–0,23	0,17–0,23	0,19–0,25	0,22–0,29	0,29–0,38	0,29–0,38
	3	80	**100**	120	mm/r	0,14–0,20	0,14–0,20	0,14–0,20	0,14–0,20	0,15–0,23	0,17–0,25	0,23–0,34	0,23–0,34
	4	70	**90**	110	mm/r	0,11–0,20	0,11–0,20	0,11–0,20	0,11–0,20	0,13–0,23	0,14–0,25	0,18–0,34	0,18–0,34
M	1	40	**60**	80	mm/r	0,09–0,14	0,09–0,14	0,09–0,14	0,09–0,14	0,11–0,17	0,13–0,20	0,16–0,25	0,16–0,25
	2	35	**55**	70	mm/r	0,09–0,14	0,09–0,14	0,09–0,14	0,09–0,14	0,11–0,17	0,13–0,20	0,16–0,25	0,16–0,25
K	1	90	**135**	175	mm/r	0,18–0,24	0,18–0,24	0,18–0,24	0,18–0,24	0,21–0,28	0,23–0,31	0,28–0,37	0,28–0,37
	2	80	**120**	140	mm/r	0,18–0,24	0,18–0,24	0,18–0,24	0,18–0,24	0,21–0,28	0,23–0,31	0,28–0,37	0,28–0,37
	3	70	**110**	125	mm/r	0,15–0,24	0,15–0,24	0,15–0,24	0,15–0,24	0,18–0,26	0,21–0,29	0,23–0,37	0,23–0,37

- Tool body shipped with insert wrench.



For information on L, L3, and L4 max, see the Modular Drills Dimension Tables on page H35.

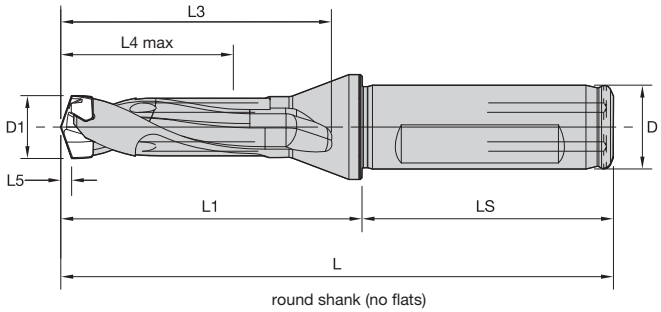


KenTIP Round Shank • 1.5 x D/3 x D/5 x D/8 x D/12 x D • Metric

1.5 x D	3 x D	5 x D	8 x D	12 x D	D1 mm	D1 in	D1 max mm	D1 max in	seat size	KenTIP wrench
KTIP080R1SS10M	KTIP080R3SS10M	KTIP080R5SS10M	KTIP080R8SS10M	KTIP080R12SS10M	8,000	.3150	8,499	.3346	F	170.306
KTIP085R1SS10M	KTIP085R3SS10M	KTIP085R5SS10M	KTIP085R8SS10M	KTIP085R12SS10M	8,500	.3346	8,999	.3543	G	170.306
KTIP090R1SS10M	KTIP090R3SS10M	KTIP090R5SS10M	KTIP090R8SS10M	KTIP090R12SS10M	9,000	.3543	9,499	.3740	H	170.306
KTIP095R1SS10M	KTIP095R3SS10M	KTIP095R5SS10M	KTIP095R8SS10M	KTIP095R12SS10M	9,500	.3740	9,999	.3937	I	170.306
KTIP100R1SS12M	KTIP100R3SS12M	KTIP100R5SS12M	KTIP100R8SS12M	KTIP100R12SS12M	10,000	.3937	10,499	.4133	J	170.307
KTIP105R1SS12M	KTIP105R3SS12M	KTIP105R5SS12M	KTIP105R8SS12M	KTIP105R12SS12M	10,500	.4134	10,999	.4330	K	170.307
KTIP110R1SS12M	KTIP110R3SS12M	KTIP110R5SS12M	KTIP110R8SS12M	KTIP110R12SS12M	11,000	.4331	11,499	.4527	L	170.307
KTIP115R1SS12M	KTIP115R3SS12M	KTIP115R5SS12M	KTIP115R8SS12M	KTIP115R12SS12M	11,500	.4528	11,999	.4724	M	170.307
KTIP120R1SS14M	KTIP120R3SS14M	KTIP120R5SS14M	KTIP120R8SS14M	KTIP120R12SS14M	12,000	.4724	12,499	.4921	N	170.308
KTIP125R1SS14M	KTIP125R3SS14M	KTIP125R5SS14M	KTIP125R8SS14M	KTIP125R12SS14M	12,500	.4921	12,999	.5118	O	170.308
KTIP130R1SS14M	KTIP130R3SS14M	KTIP130R5SS14M	KTIP130R8SS14M	KTIP130R12SS14M	13,000	.5118	13,499	.5315	P	170.308
KTIP135R1SS14M	KTIP135R3SS14M	KTIP135R5SS14M	KTIP135R8SS14M	KTIP135R12SS14M	13,500	.5315	13,999	.5511	Q	170.308
KTIP140R1SS16M	KTIP140R3SS16M	KTIP140R5SS16M	KTIP140R8SS16M	KTIP140R12SS16M	14,000	.5512	14,499	.5708	R	170.309
KTIP145R1SS16M	KTIP145R3SS16M	KTIP145R5SS16M	KTIP145R8SS16M	KTIP145R12SS16M	14,500	.5709	14,999	.5905	S	170.309
KTIP150R1SS16M	KTIP150R3SS16M	KTIP150R5SS16M	KTIP150R8SS16M	KTIP150R12SS16M	15,000	.5906	15,999	.6299	T	170.309
KTIP160R1SS18M	KTIP160R3SS18M	KTIP160R5SS18M	KTIP160R8SS18M	KTIP160R12SS18M	16,000	.6299	16,999	.6693	U	170.309
KTIP170R1SS18M	KTIP170R3SS18M	KTIP170R5SS18M	KTIP170R8SS18M	KTIP170R12SS18M	17,000	.6693	17,999	.7086	V	170.314
KTIP180R1SS20M	KTIP180R3SS20M	KTIP180R5SS20M	KTIP180R8SS20M	KTIP180R12SS20M	18,000	.7087	18,999	.7480	W	170.314
KTIP190R1SS20M	KTIP190R3SS20M	KTIP190R5SS20M	KTIP190R8SS20M	KTIP190R12SS20M	19,000	.7480	19,999	.7874	X	170.314
KTIP200R1SS25M	KTIP200R3SS25M	KTIP200R5SS25M	KTIP200R8SS25M	KTIP200R12SS25M	20,000	.7874	20,999	.8267	Y	170.314
KTIP210R1SS25M	KTIP210R3SS25M	KTIP210R5SS25M	KTIP210R8SS25M	KTIP210R12SS25M	21,000	.8268	21,999	.8661	Z	170.314
KTIP220R1SS25M	KTIP220R3SS25M	KTIP220R5SS25M	KTIP220R8SS25M	KTIP220R12SS25M	22,000	.8661	22,999	.9055	ZA	170.314
KTIP230R1SS25M	KTIP230R3SS25M	KTIP230R5SS25M	KTIP230R8SS25M	KTIP230R12SS25M	23,000	.9055	23,999	.9448	ZB	170.314
KTIP240R1SS25M	KTIP240R3SS25M	KTIP240R5SS25M	KTIP240R8SS25M	KTIP240R12SS25M	24,000	.9449	24,999	.9842	ZC	170.314
KTIP250R1SS32M	KTIP250R3SS32M	KTIP250R5SS32M	KTIP250R8SS32M	KTIP250R12SS32M	25,000	.9843	25,999	1.0236	ZD	170.314
KTIP260R1SS32M	KTIP260R3SS32M	KTIP260R5SS32M	KTIP260R8SS32M	KTIP260R12SS32M	26,000	1.0236	26,999	1.0630	ZE	170.314
KTIP270R1SS32M	KTIP270R3SS32M	KTIP270R5SS32M	KTIP270R8SS32M	KTIP270R12SS32M	27,000	1.0630	27,999	1.1023	ZE	170.314

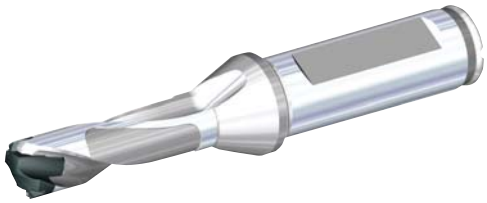
- Tool body shipped with insert wrench.





round shank (no flats)

For information on L, L3, and L4 max, see the Modular Drills Dimension Tables on page H36.



KenTIP Flanged Shank • 1.5 x D/3 x D/5 x D/8 x D • Metric

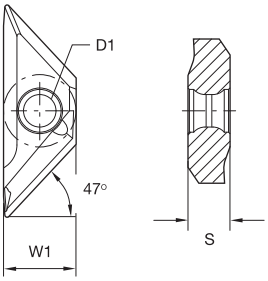
1.5 x D	3 x D	5 x D	8 x D	D1 mm	D1 in	D1 max mm	D1 max in	seat size	KenTIP wrench
KTIP080R1SCF12M	KTIP080R3SCF12M	KTIP080R5SCF12M	KTIP080R8SCF12M	8,000	.3150	8,499	.3346	F	170.306
KTIP085R1SCF12M	KTIP085R3SCF12M	KTIP085R5SCF12M	KTIP085R8SCF12M	8,500	.3346	8,999	.3543	G	170.306
KTIP090R1SCF12M	KTIP090R3SCF12M	KTIP090R5SCF12M	KTIP090R8SCF12M	9,000	.3543	9,499	.3740	H	170.306
KTIP095R1SCF12M	KTIP095R3SCF12M	KTIP095R5SCF12M	KTIP095R8SCF12M	9,500	.3740	9,999	.3937	I	170.306
KTIP100R1SCF16M	KTIP100R3SCF16M	KTIP100R5SCF16M	KTIP100R8SCF16M	10,000	.3937	10,499	.4133	J	170.307
KTIP105R1SCF16M	KTIP105R3SCF16M	KTIP105R5SCF16M	KTIP105R8SCF16M	10,500	.4134	10,999	.4330	K	170.307
KTIP110R1SCF16M	KTIP110R3SCF16M	KTIP110R5SCF16M	KTIP110R8SCF16M	11,000	.4331	11,499	.4527	L	170.307
KTIP115R1SCF16M	KTIP115R3SCF16M	KTIP115R5SCF16M	KTIP115R8SCF16M	11,500	.4528	11,999	.4724	M	170.307
KTIP120R1SCF16M	KTIP120R3SCF16M	KTIP120R5SCF16M	KTIP120R8SCF16M	12,000	.4724	12,499	.4921	N	170.308
KTIP125R1SCF16M	KTIP125R3SCF16M	KTIP125R5SCF16M	KTIP125R8SCF16M	12,500	.4921	12,999	.5118	O	170.308
KTIP130R1SCF16M	KTIP130R3SCF16M	KTIP130R5SCF16M	KTIP130R8SCF16M	13,000	.5118	13,499	.5315	P	170.308
KTIP135R1SCF16M	KTIP135R3SCF16M	KTIP135R5SCF16M	KTIP135R8SCF16M	13,500	.5315	13,999	.5511	Q	170.308
KTIP140R1SCF16M	KTIP140R3SCF16M	KTIP140R5SCF16M	KTIP140R8SCF16M	14,000	.5512	14,499	.5708	R	170.309
KTIP145R1SCF16M	KTIP145R3SCF16M	KTIP145R5SCF16M	KTIP145R8SCF16M	14,500	.5709	14,999	.5905	S	170.309
KTIP150R1SCF20M	KTIP150R3SCF20M	KTIP150R5SCF20M	KTIP150R8SCF20M	15,000	.5906	15,999	.6299	T	170.309
KTIP160R1SCF20M	KTIP160R3SCF20M	KTIP160R5SCF20M	KTIP160R8SCF20M	16,000	.6299	16,999	.6693	U	170.309
KTIP170R1SCF20M	KTIP170R3SCF20M	KTIP170R5SCF20M	KTIP170R8SCF20M	17,000	.6693	17,999	.7086	V	170.314
KTIP180R1SCF25M	KTIP180R3SCF25M	KTIP180R5SCF25M	KTIP180R8SCF25M	18,000	.7087	18,999	.7480	W	170.314
KTIP190R1SCF25M	KTIP190R3SCF25M	KTIP190R5SCF25M	KTIP190R8SCF25M	19,000	.7480	19,999	.7874	X	170.314
KTIP200R1SCF25M	KTIP200R3SCF25M	KTIP200R5SCF25M	KTIP200R8SCF25M	20,000	.7874	20,999	.8267	Y	170.314
KTIP210R1SCF25M	KTIP210R3SCF25M	KTIP210R5SCF25M	KTIP210R8SCF25M	21,000	.8268	21,999	.8661	Z	170.314
KTIP220R1SCF25M	KTIP220R3SCF25M	KTIP220R5SCF25M	KTIP220R8SCF25M	22,000	.8661	22,999	.9055	ZA	170.314
KTIP230R1SCF25M	KTIP230R3SCF25M	KTIP230R5SCF25M	KTIP230R8SCF25M	23,000	.9055	23,999	.9448	ZB	170.314
KTIP240R1SCF25M	KTIP240R3SCF25M	KTIP240R5SCF25M	KTIP240R8SCF25M	24,000	.9449	24,999	.9842	ZC	170.314
KTIP250R1SCF25M	KTIP250R3SCF25M	KTIP250R5SCF25M	KTIP250R8SCF25M	25,000	.9843	25,999	1.0236	ZD	170.314
KTIP260R1SCF25M	KTIP260R3SCF25M	KTIP260R5SCF25M	KTIP260R8SCF25M	26,000	1.0236	26,999	1.0630	ZE	170.314
KTIP270R1SCF25M	KTIP270R3SCF25M	KTIP270R5SCF25M	KTIP270R8SCF25M	27,000	1.0630	27,999	1.1023	ZE	170.314

- Drilling and chamfering in one operation using the KenTIP drilling system.
- Low setup time — no height adjustment required.
- Use standard chamfering inserts with our universal -GD geometry style.
- Selection of two grade choices:
  - — KC7215 offering the highest level of wear resistance for higher cutting speeds in stable conditions.
  - — KC7015 for medium cutting speeds and normal conditions.
- Tool bodies with chamfer pockets available as custom solutions.

● first choice
○ alternate choice

P	○	●
M	○	○
K	○	●
N	●	○
S	○	●
H		





FAS-GD • Chamfering Insert

catalogue number	W1 mm	W1 in	D1 mm	D1 in	S mm	S in	KC7215	KC7015
FAS100302GD	6,35	.250	2,85	.112	3,48	.137	●	●

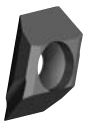


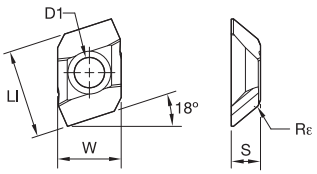
Made-to-order KenTIP holders with chamfering step using standard FAS inserts. Also available for KenTIP FS upon request.

- Very small incremental diameter changes for step drills.
- Best reliability and hole quality.
- Improved chip control and very low tendency for chattering.
- High tool life per edge; 2x indexable.
- Can be used with KenTIP and KSEM™ as well as Drill Fix™ indexable made-to-order step drills.
- CFM inserts are perfectly suited for usage on made-to-order indexable countersinking tools.

● first choice
○ alternate choice

P		●
M		○
K		○
N		●
S		●
H		





CounterFix Micro • Tangential Chamfer and Counterboring Inserts

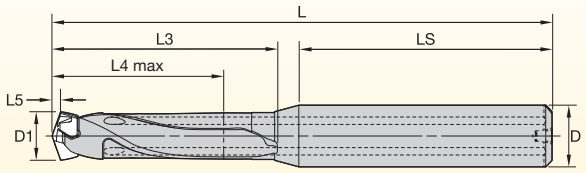
catalogue number	D1	LI	W	S	Rε	KCU40
CFM0402R00RHP	2,05	6,000	4,25	1,98	0,20	●
CFM0402R30RHP	2,05	6,000	4,25	1,98	0,20	●
CFM0402R45RHP	2,05	6,000	4,25	1,98	0,20	●



Made-to-order KenTIP holder with two very small counterboring steps using CounterFix Micro Inserts. Also available for KenTIP FS upon request.

Modular Drills • Dimension Tables

Dimensions for KenTIP™ Modular Drills • Round Shank • Metric



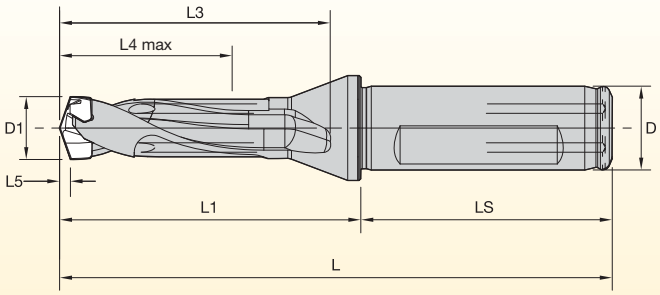


D1 mm	D1 max	seat	L5	LS	round D	1.5 x D L	1.5 x D L3	1.5 x D L4 max	3 x D L	3 x D L3	3 x D L4 max	5 x D L	5 x D L3	5 x D L4 max	8 x D L	8 x D L3	8 x D L4 max	12 x D L	12 x D L3	12 x D L4 max	wrench
8,000	8,499	F	1,4	41	10	67	23	13	79	35	26	97	53	43	123	79	68	157	113	102	**170.306**
8,500	8,999	G	1,5	41	10	68	24	14	81	37	27	100	56	45	127	83	72	163	119	108	**170.306**
9,000	9,499	H	1,6	41	10	69	25	14	83	39	29	103	58	48	132	88	76	170	126	114	**170.306**
9,500	9,999	I	1,6	41	10	70	26	15	85	41	30	107	63	50	137	92	80	177	133	120	**170.306**
10,000	10,499	J	1,7	46	12	77	28	16	92	43	32	115	66	53	147	98	84	189	140	126	**170.307**
10,500	10,999	K	1,8	46	12	78	29	17	94	45	33	118	68	55	151	101	88	195	146	132	**170.307**
11,000	11,499	L	1,9	46	12	79	30	17	96	47	35	121	71	58	156	105	92	202	153	138	**170.307**
11,500	11,999	M	2,0	46	12	80	31	18	98	49	36	124	75	60	160	110	96	208	159	144	**170.307**
12,000	12,499	N	2,1	46	14	83	34	19	101	52	38	127	78	63	165	116	100	215	166	150	**170.308**
12,500	12,999	O	2,2	46	14	84	35	20	103	54	39	130	81	65	169	120	104	221	172	156	**170.308**
13,000	13,499	P	2,2	46	14	85	36	20	105	56	41	133	84	68	174	125	108	228	179	162	**170.308**
13,500	13,999	Q	2,3	46	14	86	37	21	107	58	42	137	88	70	179	130	112	235	186	168	**170.308**
14,000	14,499	R	2,4	49	16	91	39	22	112	60	44	143	91	73	187	135	116	245	193	174	**170.309**
14,500	14,999	S	2,5	49	16	92	40	23	114	62	45	146	94	75	191	139	120	251	199	180	**170.309**
15,000	15,999	T	2,6	49	16	94	42	24	118	66	48	152	100	80	200	148	128	264	212	192	**170.309**
16,000	16,999	U	2,8	49	18	97	45	26	122	70	51	158	106	85	209	157	136	277	225	204	**170.309**
17,000	17,999	V	2,9	49	18	100	48	27	127	75	54	165	113	90	219	167	144	291	239	216	**170.314**
18,000	18,999	W	3,1	51	20	105	51	29	133	79	57	173	119	95	230	176	152	306	252	228	**170.314**
19,000	19,999	X	3,3	51	20	107	53	30	137	83	60	179	125	100	239	185	160	319	265	240	**170.314**
20,000	20,999	Y	3,5	57	25	116	56	32	147	87	63	191	131	105	254	200	168	344	284	252	**170.314**
21,000	21,999	Z	3,6	57	25	118	58	33	151	91	66	198	138	110	264	204	176	352	292	264	**170.314**
22,000	22,999	ZA	3,8	57	25	122	62	35	156	96	69	204	144	115	273	213	184	365	305	276	**170.314**
23,000	23,999	ZB	4,0	57	25	124	64	36	160	100	72	210	150	120	282	222	192	378	318	288	**170.314**
24,000	24,999	ZC	4,1	57	25	127	67	38	164	104	75	216	156	125	291	231	200	391	331	300	**170.314**
25,000	25,999	ZD	4,3	61	32	133	69	39	172	108	78	227	163	130	305	241	208	409	345	312	**170.314**
26,000	26,999	ZE	4,5	61	32	138	74	41	178	114	81	232	168	135	315	251	216	423	359	324	**170.314**
27,000	27,999	ZE	4,7	61	32	139	75	42	181	117	84	239	175	140	323	259	224	435	371	336	**170.314**

(continued)

Modular Drills • Dimension Tables *(continued)*

Dimensions for KenTIP™ Modular Drills • Flanged Shank • Metric





D1 mm	D1 max	seat	L5	LS	Flanged D	1.5 x D L	L3	L4 max	3 x D L	L3	L4 max	5 x D L	L3	L4 max	8 x D L	L3	L4 max	wrench
8,000	8,490	F	1,4	45	12	73	23	13	86	35	26	104	53	43	129	79	68	**170.306**
8,500	8,990	G	1,5	45	12	74	24	14	88	37	27	107	56	45	134	83	72	**170.306**
9,000	9,490	H	1,6	45	12	76	25	14	90	39	29	110	59	48	138	88	76	**170.306**
9,500	9,990	I	1,6	45	12	77	26	15	92	41	30	114	63	50	144	93	80	**170.306**
10,000	10,490	J	1,7	48	16	81	28	16	97	43	32	120	66	53	151	97	84	**170.307**
10,500	10,990	K	1,8	48	16	82	29	17	99	45	33	123	69	55	156	102	88	**170.307**
11,000	11,490	L	1,9	48	16	84	30	17	101	47	35	126	72	58	160	107	92	**170.307**
11,500	11,990	M	2,0	48	16	85	31	18	103	49	36	129	75	60	165	111	96	**170.307**
12,000	12,490	N	2,1	48	16	87	34	19	106	52	38	132	78	63	169	116	100	**170.308**
12,500	12,990	O	2,2	48	16	88	35	20	108	54	39	135	81	65	174	120	104	**170.308**
13,000	13,490	P	2,2	48	16	90	36	20	110	56	41	138	84	68	178	124	108	**170.308**
13,500	13,990	Q	2,3	48	16	91	37	21	112	58	42	142	88	70	184	130	112	**170.308**
14,000	14,490	R	2,4	48	16	92	39	22	114	60	44	145	91	73	188	134	116	**170.309**
14,500	14,990	S	2,5	48	16	93	40	23	116	62	45	148	94	75	193	139	120	**170.309**
15,000	15,990	T	2,6	50	20	98	42	24	122	66	48	156	100	80	204	148	128	**170.309**
16,000	16,990	U	2,8	50	20	100	45	26	126	70	51	162	106	85	213	157	136	**170.309**
17,000	17,990	V	2,9	50	20	104	48	27	131	75	54	169	113	90	223	167	144	**170.314**
18,000	18,990	W	3,1	56	25	112	51	29	141	79	57	181	119	95	238	176	152	**170.314**
19,000	19,990	X	3,3	56	25	115	53	30	144	83	60	187	125	100	247	185	160	**170.314**
20,000	20,990	Y	3,5	56	25	117	56	32	149	87	63	193	131	105	256	194	168	**170.314**
21,000	21,990	Z	3,6	56	25	120	58	33	153	91	66	200	138	110	266	204	176	**170.314**
22,000	22,990	ZA	3,8	56	25	123	62	35	158	96	69	206	144	115	275	213	184	**170.314**
23,000	23,990	ZB	4,0	56	25	126	64	36	162	100	72	212	150	120	284	222	192	**170.314**
24,000	24,990	ZC	4,1	56	25	128	67	38	166	104	75	218	156	125	293	231	200	**170.314**
25,000	25,990	ZD	4,3	56	25	131	69	39	170	108	78	225	163	130	303	241	208	**170.314**
26,000	26,990	ZE	4,5	56	25	135	74	41	176	114	81	230	168	135	313	251	216	**170.314**
27,000	27,990	ZE	4,7	56	25	137	75	42	179	117	84	237	175	140	321	259	224	**170.314**

Mounting the KenTIP Inserts



1) Fix drill holder on arbour. For insert exchange, fix arbour on the machine or set on tool presetter.



2) Remove dust using air blast.



3) Put insert into drill holder (use gloves to protect your hands).



4) Turn lightly in a clockwise direction (use gloves to protect your hands).



5) Set the wrench properly.



6) Make sure the wrench fits with the insert slot (check size and alignment of wrench and insert slots to avoid injury).





7) Slowly turn the wrench in a clockwise direction.



8) Complete.

Cooling the KenTIP Drill



1) Internal coolant is recommended.



2) In case of external coolant, cutting depth must be 3 x D or less.

Only when using the 3 x D tool bodies

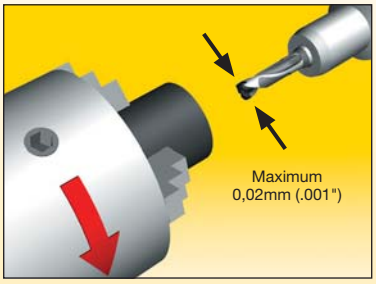


3) Dry cutting is not recommended. Limited applicability in cast iron materials, MQL strongly recommended.

Dry machining

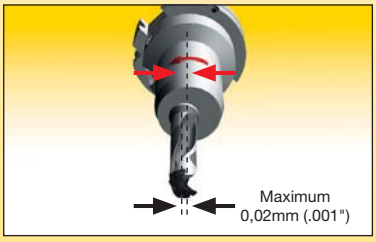
Usage Precautions
Core Deviation

1) For Turning Machines



Set deviation amount under 0,02mm between workpiece and drill.

2) For Machining Centres



Do not use any arbour with a damaged attachment surface. Centre of arbour deviation must be within 0,02mm.

KSEM™ Modular Drill System

Primary Application

The KSEM™ modular drill system offers extended length and drilling diameters beyond the KenTIP™ modular drill system. The KSEM system enables very aggressive feed rates in many applications to enable very high productivity levels. It offers a very robust pocket for its exchangeable inserts to increase tool life for both steel holder and carbide tip. This makes the KSEM system a very economic and reliable system for drilling in the intermediate diameter range.
Hole depths of 10 x D and drilling diameters from 12,5–40mm (.4921–1.5748") are covered by our standard tooling range. Various grades are available for drilling applications in almost any materials.

Features and Benefits

HP Drill-Point styles

- Low thrust prevents workpiece flexing.
- Excellent centring capabilities.
- Application specific selection of geometries for unmatched performance.

Strong Pocket, Easy Insert Change

- Robust pocket design for increased insert and holder life.
- Four-wall pocket provides insert stability.
- Requires only a simple wrench for insert removal.

Regrindable Inserts

- All geometries except SPL can be reconditioned to improve tool economy.
- Quick and reliable regrinding services offered by Kennametal and our partners.

Tailored Grades

- KC7315™ grade TiAlN-based PVD multilayer coating for high cutting speeds, primarily in steel applications.
- KCPM45™ grade multilayer TiAlN coated, very tough carbide substrate. Improved chipping resistance in demanding machining conditions.
- KC7320™ grade AlTiN-based PVD coating for the demands of drilling stainless steels.
- KCMS35™ grade with high Al content TiAlN PVD coating specifically for M3 and S-type materials.
- KC7410™ grade contains multiple layers of PVD coating offering outstanding wear resistance for drilling cast irons.
- KC7135™ grade with thin TiCN-TiN PVD coating for universal usage in all materials.

NEW!



KSEM™ SPL inserts offer extraordinary drilling performance in stainless steels, super alloys, and other demanding environments.

NEW!



KSEM FEG inserts create blind holes, through holes, and countersinks. These inserts are focused on versatility and will support you in many essential drilling applications.



Drill Body Portfolio

- Standard 1, 3, 5, 7, and 10 x D tool bodies with round shanks (inch) and Whistle Notch shanks (metric) available.
- Flanged shanks with 2 flats and entry for external coolant supply in 1, 3, 5, and 8 x D.
- KSEM mountable chamfering ring with FAS carbide chamfer inserts.

Customisation

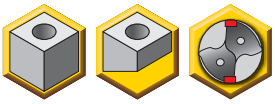
- Intermediate diameters available as semi-standards.
- Extensive step drill capabilities to support advanced applications and for one-shot counterboring and chamfering drills.
- Nearly all shank styles for toolholders available as semi-standards.
- Very high L x D ratios possible up to 25 x D and even higher (depending on drill diameter).

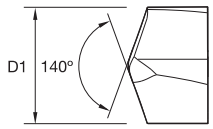
NEW!



Need to create very small diameter steps for chamfering and counterboring?
CFM inserts fit KSEM made-to-order step drills perfectly.
Find them in the KenTIP™ modular drill system section page H34

- KSEM KC7315™ HP cutting edges enable high metal removal rates and superior tool life for steel applications.
- HP geometry offers a wide and strong HP-style chiseled edge that prevents material quenching in the centre, enabling high feed rates. Sickle shaped, honed cutting edges provide excellent chip forming and tool life, even in long chipping materials.
- KC7315 is a fine-grain carbide with a TiAlN-based PVD multilayer coating. Its high wear resistance enables very high cutting speeds in stable conditions.
- KC7315 HP cutting edges are perfectly suited to drill alloyed and high-alloy steels.
- Use KC7315 HP cutting edges as an alternative to cast iron materials.







HP

KSEM Inserts • HP KC7315

P ●
M
K ○
N
S
H

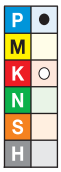
● first choice
○ alternate choice

KC7315	D1 mm	D1 in	seat size
KSEM1250HPM	12,500	.4921	C
KSEM1270HPM	12,700	.5000	C
KSEM1280HPM	12,800	.5039	C
KSEM1300HPM	13,000	.5118	C
KSEM1310HPM	13,100	.5160	C
KSEM1320HPM	13,200	.5197	C
KSEM1350HPM	13,500	.5310	C
KSEM1370HPM	13,700	.5394	B
KSEM1380HPM	13,800	.5433	B
KSEM1389HPM	13,890	.5470	B
KSEM1400HPM	14,000	.5512	B
KSEM1410HPM	14,100	.5551	B
KSEM1420HPM	14,200	.5591	B
KSEM1429HPM	14,290	.5630	B
KSEM1440HPM	14,400	.5669	B
KSEM1450HPM	14,500	.5709	B
KSEM1468HPM	14,680	.5780	A
KSEM1480HPM	14,800	.5827	A
KSEM1500HPM	15,000	.5906	A
KSEM1508HPM	15,080	.5940	A
KSEM1530HPM	15,300	.6024	A
KSEM1550HPM	15,500	.6102	A
KSEM1560HPM	15,600	.6142	A
KSEM1570HPM	15,700	.6181	A
KSEM1580HPM	15,800	.6220	A
KSEM1588HPM	15,880	.6250	1
KSEM1600HPM	16,000	.6299	1
KSEM1609HPM	16,090	.6340	1
KSEM1620HPM	16,200	.6378	1
KSEM1627HPM	16,270	.6410	1
KSEM1650HPM	16,500	.6496	1
KSEM1667HPM	16,670	.6560	1
KSEM1700HPM	17,000	.6693	1
KSEM1707HPM	17,070	.6720	1
KSEM1746HPM	17,460	.6875	1
KSEM1750HPM	17,500	.6890	1

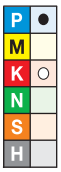
KC7315	D1 mm	D1 in	seat size
KSEM1786HPM	17,860	.7030	1
KSEM1800HPM	18,000	.7087	1
KSEM1826HPM	18,260	.7190	2
KSEM1850HPM	18,500	.7283	2
KSEM1865HPM	18,650	.7340	2
KSEM1900HPM	19,000	.7480	2
KSEM1905HPM	19,050	.7500	2
KSEM1923HPM	19,228	.7570	2
KSEM1927HPM	19,270	.7590	2
KSEM1945HPM	19,450	.7660	2
KSEM1950HPM	19,500	.7677	2
KSEM1984HPM	19,840	.7810	2
KSEM2000HPM	20,000	.7874	3
KSEM2024HPM	20,240	.7970	3
KSEM2050HPM	20,500	.8071	3
KSEM2064HPM	20,640	.8125	3
KSEM2100HPM	21,000	.8268	3
KSEM2143HPM	21,430	.8440	3
KSEM2150HPM	21,500	.8460	3
KSEM2183HPM	21,830	.8590	3
KSEM2200HPM	22,000	.8661	3
KSEM2223HPM	22,230	.8750	4
KSEM2244HPM	22,440	.8840	4
KSEM2250HPM	22,500	.8858	4
KSEM2300HPM	23,000	.9055	4
KSEM2342HPM	23,420	.9220	4
KSEM2350HPM	23,500	.9252	4
KSEM2381HPM	23,810	.9375	4
KSEM2400HPM	24,000	.9449	4
KSEM2450HPM	24,500	.9646	5
KSEM2461HPM	24,610	.9690	5
KSEM2500HPM	25,000	.9843	5
KSEM2540HPM	25,400	1.0000	5
KSEM2550HPM	25,500	1.0039	5
KSEM2560HPM	25,610	1.0080	5
KSEM2567HPM	25,670	1.0110	5

(continued)

(KSEM Inserts • HP KC7315™ — continued)



KC7315	D1 mm	D1 in	seat size
KSEM2600HPM	26,000	1.0236	5
KSEM2619HPM	26,190	1.0310	6
KSEM2650HPM	26,500	1.0433	6
KSEM2659HPM	26,590	1.0470	6
KSEM2700HPM	27,000	1.0630	6
KSEM2750HPM	27,500	1.0827	6
KSEM2778HPM	27,780	1.0940	6
KSEM2800HPM	28,000	1.1024	6
KSEM2818HPM	28,180	1.1090	7
KSEM2850HPM	28,500	1.1220	7
KSEM2858HPM	28,580	1.1250	7
KSEM2900HPM	29,000	1.1417	7
KSEM2937HPM	29,370	1.1563	7
KSEM2950HPM	29,500	1.1614	7
KSEM2977HPM	29,770	1.1720	7
KSEM3000HPM	30,000	1.1811	7
KSEM3016HPM	30,160	1.1875	8
KSEM3050HPM	30,500	1.2008	8
KSEM3096HPM	30,960	1.2190	8
KSEM3100HPM	31,000	1.2205	8



● first choice
○ alternate choice

KC7315	D1 mm	D1 in	seat size
KSEM3150HPM	31,500	1.2402	8
KSEM3175HPM	31,750	1.2500	8
KSEM3200HPM	32,000	1.2598	8
KSEM3250HPM	32,500	1.2795	9
KSEM3300HPM	33,000	1.2992	9
KSEM3334HPM	33,340	1.3130	9
KSEM3400HPM	34,000	1.3386	9
KSEM3413HPM	34,130	1.3440	9
KSEM3493HPM	34,930	1.3750	9
KSEM3500HPM	35,000	1.3780	9
KSEM3550HPM	35,500	1.3976	9
KSEM3600HPM	36,000	1.4173	9
KSEM3750HPM	37,500	1.4764	10
KSEM3800HPM	38,000	1.4961	10
KSEM3810HPM	38,100	1.5000	10
KSEM3850HPM	38,500	1.5157	10
KSEM3900HPM	39,000	1.5354	10
KSEM3950HPM	39,500	1.5551	10
KSEM4000HPM	40,000	1.5748	10

Tolerance HP • Metric

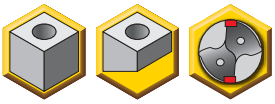
D1 metric	tolerance h8
12,5–18	+0,000/-0,027
>18–30	+0,000/-0,033
>30–40	+0,000/-0,039

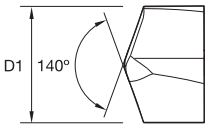
Application Data

Modular Drill Carbide Insert Blades • KSEM • HP Geometry • Grade KC7315 • Through Coolant • Metric

Material Group		Cutting Speed — vc Range — m/min min	Starting Value	max		Metric Recommended Feed Rate (f) by Diameter 12,5	16,0	20,0	25,4	32,0	40,0
P	1	70	**90**	110	mm/r	0,15–0,31	0,17–0,36	0,19–0,41	0,25–0,53	0,29–0,60	0,33–0,69
	2	80	**100**	120	mm/r	0,15–0,31	0,17–0,36	0,19–0,41	0,25–0,53	0,29–0,60	0,33–0,69
	3	65	**75**	80	mm/r	0,15–0,28	0,17–0,31	0,19–0,36	0,25–0,46	0,23–0,53	0,33–0,60
	4	50	**65**	75	mm/r	0,12–0,28	0,14–0,31	0,16–0,36	0,20–0,46	0,23–0,53	0,30–0,60
	5	45	**50**	65	mm/r	0,09–0,15	0,11–0,18	0,12–0,21	0,15 –0,25	0,17–0,29	0,20–0,33
	6	45	**50**	65	mm/r	0,12–0,23	0,14–0,26	0,16–0,29	0,20 –0,38	0,23 –0,43	0,26–0,54

- KSEM KC7315™ HPG cutting edges enable high metal removal rates and superior tool life for steel applications.
- HPG geometry works with low cutting and feed forces and provides very good centring. Reinforced cutting edges and good chip forming improve tool life due to high wear and edge chipping resistance.
- KC7315 is a fine-grain carbide with a TiAlN-based PVD multilayer coating. Its high wear resistance enables very high cutting speeds in stable conditions.
- KC7315 HPG cutting edges are perfectly suited to drill alloyed and high-alloy steels.
- Use KC7315 HPG cutting edges as an alternative to cast iron materials.

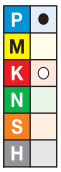




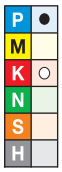


HPG

KSEM Inserts • HPG KC7315



KC7315	D1 mm	D1 in	seat size
KSEM1250HPGM	12,500	.4921	C
KSEM1260HPGM	12,600	.4961	C
KSEM1270HPGM	12,700	.5000	C
KSEM1280HPGM	12,800	.5039	C
KSEM1293HPGM	12,930	.5090	C
KSEM1300HPGM	13,000	.5118	C
KSEM1310HPGM	13,100	.5160	C
KSEM1320HPGM	13,200	.5197	C
KSEM1350HPGM	13,500	.5310	C
KSEM1360HPGM	13,600	.5354	B
KSEM1370HPGM	13,700	.5394	B
KSEM1380HPGM	13,800	.5433	B
KSEM1389HPGM	13,890	.5470	B
KSEM1400HPGM	14,000	.5512	B
KSEM1410HPGM	14,100	.5551	B
KSEM1420HPGM	14,200	.5591	B
KSEM1429HPGM	14,290	.5630	B
KSEM1440HPGM	14,400	.5669	B
KSEM1450HPGM	14,500	.5709	B
KSEM1460HPGM	14,600	.5748	A
KSEM1468HPGM	14,680	.5780	A
KSEM1480HPGM	14,800	.5827	A
KSEM1500HPGM	15,000	.5906	A
KSEM1508HPGM	15,080	.5940	A
KSEM1530HPGM	15,300	.6024	A
KSEM1548HPGM	15,480	.6090	A
KSEM1550HPGM	15,500	.6102	A
KSEM1560HPGM	15,600	.6142	A
KSEM1570HPGM	15,700	.6181	A
KSEM1580HPGM	15,800	.6220	A
KSEM1588HPGM	15,880	.6250	1
KSEM1600HPGM	16,000	.6299	1
KSEM1604HPGM	16,040	.6315	1
KSEM1609HPGM	16,090	.6340	1
KSEM1619HPGM	16,190	.6374	1
KSEM1620HPGM	16,200	.6378	1

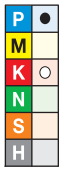


● first choice
○ alternate choice

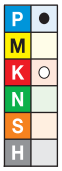
KC7315	D1 mm	D1 in	seat size
KSEM1627HPGM	16,270	.6410	1
KSEM1650HPGM	16,500	.6496	1
KSEM1660HPGM	16,600	.6535	1
KSEM1667HPGM	16,670	.6560	1
KSEM1700HPGM	17,000	.6693	1
KSEM1707HPGM	17,070	.6720	1
KSEM1735HPGM	17,350	.6831	1
KSEM1746HPGM	17,460	.6875	1
KSEM1750HPGM	17,500	.6890	1
KSEM1760HPGM	17,600	.6929	1
KSEM1770HPGM	17,700	.6969	1
KSEM1786HPGM	17,860	.7030	1
KSEM1800HPGM	18,000	.7087	1
KSEM1826HPGM	18,260	.7190	2
KSEM1850HPGM	18,500	.7283	2
KSEM1860HPGM	18,600	.7323	2
KSEM1865HPGM	18,650	.7340	2
KSEM1880HPGM	18,800	.7402	2
KSEM1900HPGM	19,000	.7480	2
KSEM1905HPGM	19,050	.7500	2
KSEM1925HPGM	19,250	.7579	2
KSEM1927HPGM	19,270	.7590	2
KSEM1932HPGM	19,320	.7606	2
KSEM1935HPGM	19,350	.7618	2
KSEM1945HPGM	19,450	.7660	2
KSEM1950HPGM	19,500	.7677	2
KSEM1970HPGM	19,700	.7756	2
KSEM1984HPGM	19,840	.7810	2
KSEM2000HPGM	20,000	.7874	3
KSEM2024HPGM	20,240	.7969	3
KSEM2050HPGM	20,500	.8071	3
KSEM2064HPGM	20,640	.8125	3
KSEM2070HPGM	20,700	.8150	3
KSEM2100HPGM	21,000	.8268	3
KSEM2110HPGM	21,100	.8307	3
KSEM2120HPGM	21,200	.8346	3

(continued)

(KSEM Inserts • HPG KC7315™ — continued)



KC7315	D1 mm	D1 in	seat size
KSEM2133HPGM	21,330	.8398	3
KSEM2143HPGM	21,430	.8440	3
KSEM2150HPGM	21,500	.8460	3
KSEM2170HPGM	21,700	.8543	3
KSEM2183HPGM	21,830	.8590	3
KSEM2200HPGM	22,000	.8661	3
KSEM2210HPGM	22,100	.8701	4
KSEM2215HPGM	22,150	.8720	4
KSEM2223HPGM	22,230	.8750	4
KSEM2244HPGM	22,440	.8840	4
KSEM2250HPGM	22,500	.8858	4
KSEM2262HPGM	22,620	.8906	4
KSEM2300HPGM	23,000	.9055	4
KSEM2305HPGM	23,050	.9075	4
KSEM2310HPGM	23,100	.9094	4
KSEM2325HPGM	23,250	.9154	4
KSEM2330HPGM	23,300	.9173	4
KSEM2342HPGM	23,420	.9220	4
KSEM2350HPGM	23,500	.9252	4
KSEM2381HPGM	23,810	.9375	4
KSEM2400HPGM	24,000	.9449	4
KSEM2430HPGM	24,300	.9567	5
KSEM2450HPGM	24,500	.9646	5
KSEM2461HPGM	24,610	.9690	5
KSEM2470HPGM	24,700	.9724	5
KSEM2500HPGM	25,000	.9843	5
KSEM2540HPGM	25,400	1.0000	5
KSEM2550HPGM	25,500	1.0039	5
KSEM2554HPGM	25,540	1.0055	5
KSEM2560HPGM	25,600	1.0080	5
KSEM2565HPGM	25,654	1.0100	5
KSEM2567HPGM	25,670	1.0110	5
KSEM2600HPGM	26,000	1.0236	5
KSEM2619HPGM	26,190	1.0310	6
KSEM2650HPGM	26,500	1.0433	6
KSEM2653HPGM	26,530	1.0445	6
KSEM2659HPGM	26,590	1.0470	6
KSEM2670HPGM	26,700	1.0512	6
KSEM2700HPGM	27,000	1.0630	6
KSEM2750HPGM	27,500	1.0827	6
KSEM2778HPGM	27,780	1.0940	6
KSEM2800HPGM	28,000	1.1024	6
KSEM2818HPGM	28,180	1.1090	7
KSEM2850HPGM	28,500	1.1220	7
KSEM2858HPGM	28,580	1.1250	7
KSEM2900HPGM	29,000	1.1417	7
KSEM2937HPGM	29,370	1.1563	7
KSEM2950HPGM	29,500	1.1614	7



● first choice
○ alternate choice

KC7315	D1 mm	D1 in	seat size
KSEM2955HPGM	29,550	1.1634	7
KSEM2973HPGM	29,730	1.1705	7
KSEM2977HPGM	29,770	1.1720	7
KSEM3000HPGM	30,000	1.1811	7
KSEM3016HPGM	30,160	1.1875	8
KSEM3050HPGM	30,500	1.2008	8
KSEM3056HPGM	30,560	1.2030	8
KSEM3096HPGM	30,960	1.2190	8
KSEM3100HPGM	31,000	1.2205	8
KSEM3125HPGM	31,250	1.2303	8
KSEM3150HPGM	31,500	1.2402	8
KSEM3175HPGM	31,750	1.2500	8
KSEM3200HPGM	32,000	1.2598	8
KSEM3220HPGM	32,200	1.2677	9
KSEM3234HPGM	32,340	1.2732	9
KSEM3250HPGM	32,500	1.2795	9
KSEM3254HPGM	32,540	1.2810	9
KSEM3294HPGM	32,940	1.2970	9
KSEM3300HPGM	33,000	1.2992	9
KSEM3334HPGM	33,340	1.3130	9
KSEM3350HPGM	33,500	1.3189	9
KSEM3373HPGM	33,730	1.3280	9
KSEM3400HPGM	34,000	1.3386	9
KSEM3413HPGM	34,130	1.3440	9
KSEM3450HPGM	34,500	1.3583	9
KSEM3493HPGM	34,930	1.3750	9
KSEM3500HPGM	35,000	1.3780	9
KSEM3550HPGM	35,500	1.3976	9
KSEM3572HPGM	35,720	1.4060	9
KSEM3600HPGM	36,000	1.4173	9
KSEM3612HPGM	36,120	1.4220	10
KSEM3650HPGM	36,500	1.4375	10
KSEM3651HPGM	36,510	1.4375	10
KSEM3700HPGM	37,000	1.4567	10
KSEM3731HPGM	37,310	1.4690	10
KSEM3750HPGM	37,500	1.4764	10
KSEM3800HPGM	38,000	1.4961	10
KSEM3810HPGM	38,100	1.5000	10
KSEM3846HPGM	38,460	1.5142	10
KSEM3850HPGM	38,500	1.5157	10
KSEM3900HPGM	39,000	1.5354	10
KSEM3950HPGM	39,500	1.5551	10
KSEM3975HPGM	39,750	1.5650	10
KSEM4000HPGM	40,000	1.5748	10

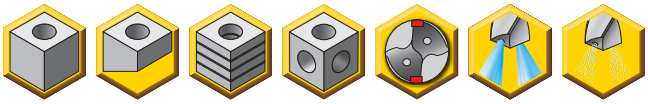
Tolerance HPG • Metric

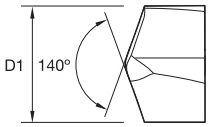
D1 metric	tolerance h8
12,5–18	+0,000/-0,027
>18–30	+0,000/-0,033
>30–40	+0,000/-0,039

Modular Drill Carbide Insert Blades • KSEM™ • HPG Geometry • Grade KC7315™ • Through Coolant • Metric

Material Group		Cutting Speed — vc Range — m/min			Metric						
					Recommended Feed Rate (f) by Diameter						
		min	Starting Value	max		12,5	16,0	20,0	25,4	32,0	40,0
P	1	75	**110**	140	mm/r	0,15–0,34	0,17–0,40	0,19–0,45	0,25–0,58	0,29–0,66	0,33–0,76
	2	90	**120**	150	mm/r	0,15–0,34	0,17–0,40	0,19–0,45	0,25–0,58	0,29–0,66	0,33–0,76
	3	50	**75**	100	mm/r	0,15–0,28	0,17–0,34	0,19–0,40	0,25–0,51	0,29–0,58	0,33–0,66
	4	55	**75**	95	mm/r	0,12–0,31	0,14–0,34	0,16–0,40	0,20–0,51	0,23–0,58	0,26–0,66
	5	50	**65**	80	mm/r	0,09–0,17	0,11–0,20	0,12–0,23	0,15–0,28	0,17–0,32	0,20–0,36
	6	50	**65**	80	mm/r	0,12–0,25	0,14–0,29	0,16–0,32	0,20–0,42	0,23–0,47	0,26–0,54
K	1	90	**135**	175	mm/r	0,17–0,35	0,21–0,42	0,25–0,48	0,31–0,59	0,37–0,70	0,43–0,81
	2	90	**110**	125	mm/r	0,17–0,33	0,21–0,41	0,25–0,48	0,31–0,59	0,37–0,70	0,43–0,81
	3	40	**95**	125	mm/r	0,18–0,36	0,20–0,41	0,21–0,44	0,23–0,48	0,25–0,53	0,27–0,57

- KSEM KCPM45™ HPG cutting edges provide increased productivity and improved tool life in steel in difficult conditions.
- HPG geometry works with low cutting and feed forces and provides very good centring. Reinforced cutting edges and good chip forming improve tool life due to high wear and edge chipping resistance.
- KCPM45 combines a very tough, fine-grain carbide substrate with an advanced multilayer TiAlN coating. It is capable of machining steel even in the most demanding conditions.
- Material snap back, stacked plates, cross holes, and inclined exits are some examples of where KCPM45 HPG edges will do a great job in your operations.
- Use KCPM45 HPG cutting edges as an effective alternative in stainless steel as well.







HPG

KSEM Inserts • HPG KCPM45

P ● M ○ K N S H

● first choice
○ alternate choice

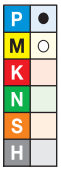
KCPM45	D1 mm	D1 in	seat size
KSEM1250HPGM	12,500	.4921	C
KSEM1270HPGM	12,700	.5000	C
KSEM1280HPGM	12,800	.5039	C
KSEM1293HPGM	12,930	.5090	C
KSEM1300HPGM	13,000	.5118	C
KSEM1350HPGM	13,500	.5310	C
KSEM1360HPGM	13,600	.5354	B
KSEM1380HPGM	13,800	.5433	B
KSEM1389HPGM	13,890	.5470	B
KSEM1400HPGM	14,000	.5512	B
KSEM1410HPGM	14,100	.5551	B
KSEM1429HPGM	14,290	.5630	B
KSEM1450HPGM	14,500	.5709	B
KSEM1468HPGM	14,680	.5780	A
KSEM1500HPGM	15,000	.5906	A
KSEM1508HPGM	15,080	.5940	A
KSEM1550HPGM	15,500	.6102	A
KSEM1580HPGM	15,800	.6220	A
KSEM1588HPGM	15,880	.6250	1
KSEM1600HPGM	16,000	.6299	1
KSEM1609HPGM	16,090	.6340	1
KSEM1620HPGM	16,200	.6378	1
KSEM1627HPGM	16,270	.6410	1
KSEM1650HPGM	16,500	.6496	1
KSEM1667HPGM	16,670	.6560	1
KSEM1700HPGM	17,000	.6693	1
KSEM1707HPGM	17,070	.6720	1
KSEM1746HPGM	17,460	.6875	1
KSEM1750HPGM	17,500	.6890	1
KSEM1786HPGM	17,860	.7030	1
KSEM1800HPGM	18,000	.7087	1
KSEM1826HPGM	18,260	.7190	2

P ● M ○ K N S H

KCPM45	D1 mm	D1 in	seat size
KSEM1850HPGM	18,500	.7283	2
KSEM1865HPGM	18,650	.7340	2
KSEM1900HPGM	19,000	.7480	2
KSEM1905HPGM	19,050	.7500	2
KSEM1920HPGM	19,200	.7559	2
KSEM1923HPGM	19,228	.7570	2
KSEM1925HPGM	19,250	.7579	2
KSEM1927HPGM	19,270	.7590	2
KSEM1945HPGM	19,450	.7660	2
KSEM1950HPGM	19,500	.7677	2
KSEM1965HPGM	19,650	.7736	2
KSEM1984HPGM	19,840	.7810	2
KSEM2000HPGM	20,000	.7874	3
KSEM2024HPGM	20,240	.7969	3
KSEM2050HPGM	20,500	.8071	3
KSEM2064HPGM	20,640	.8125	3
KSEM2100HPGM	21,000	.8268	3
KSEM2143HPGM	21,430	.8440	3
KSEM2150HPGM	21,500	.8460	3
KSEM2183HPGM	21,830	.8590	3
KSEM2200HPGM	22,000	.8661	3
KSEM2223HPGM	22,230	.8750	4
KSEM2244HPGM	22,440	.8840	4
KSEM2250HPGM	22,500	.8858	4
KSEM2300HPGM	23,000	.9055	4
KSEM2342HPGM	23,420	.9220	4
KSEM2350HPGM	23,500	.9252	4
KSEM2360HPGM	23,600	.9291	4
KSEM2370HPGM	23,700	.9331	4
KSEM2381HPGM	23,810	.9375	4
KSEM2400HPGM	24,000	.9449	4
KSEM2450HPGM	24,500	.9646	5

(continued)

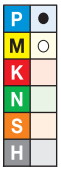
(KSEM Inserts • HPG KCPM45™ — continued)



KCPM45	D1 mm	D1 in	seat size
KSEM2461HPGM	24,610	.9690	5
KSEM2500HPGM	25,000	.9843	5
KSEM2540HPGM	25,400	1.0000	5
KSEM2550HPGM	25,500	1.0039	5
KSEM2560HPGM	25,600	1.0080	5
KSEM2565HPGM	25,654	1.0100	5
KSEM2567HPGM	25,670	1.0106	5
KSEM2581HPGM	25,810	1.0161	5
KSEM2600HPGM	26,000	1.0236	5
KSEM2619HPGM	26,190	1.0310	6
KSEM2650HPGM	26,500	1.0433	6
KSEM2659HPGM	26,590	1.0470	6
KSEM2700HPGM	27,000	1.0630	6
KSEM2750HPGM	27,500	1.0827	6
KSEM2778HPGM	27,780	1.0940	6
KSEM2800HPGM	28,000	1.1024	6
KSEM2818HPGM	28,180	1.1090	7
KSEM2835HPGM	28,350	1.1161	7
KSEM2850HPGM	28,500	1.1220	7
KSEM2858HPGM	28,580	1.1250	7
KSEM2900HPGM	29,000	1.1417	7
KSEM2937HPGM	29,370	1.1563	7
KSEM2950HPGM	29,500	1.1614	7
KSEM2977HPGM	29,770	1.1720	7
KSEM3000HPGM	30,000	1.1811	7
KSEM3016HPGM	30,160	1.1875	8
KSEM3050HPGM	30,500	1.2008	8
KSEM3096HPGM	30,960	1.2190	8

Tolerance HPG • Metric

D1 metric	tolerance h8
12,5–18	+0,000/-0,027
>18–30	+0,000/-0,033
>30–40	+0,000/-0,039



● first choice
○ alternate choice

KCPM45	D1 mm	D1 in	seat size
KSEM3100HPGM	31,000	1.2205	8
KSEM3115HPGM	31,150	1.2264	8
KSEM3150HPGM	31,500	1.2402	8
KSEM3175HPGM	31,750	1.2500	8
KSEM3200HPGM	32,000	1.2598	8
KSEM3250HPGM	32,500	1.2795	9
KSEM3254HPGM	32,540	1.2810	9
KSEM3300HPGM	33,000	1.2992	9
KSEM3334HPGM	33,340	1.3130	9
KSEM3350HPGM	33,500	1.3189	9
KSEM3400HPGM	34,000	1.3386	9
KSEM3450HPGM	34,500	1.3583	9
KSEM3493HPGM	34,930	1.3750	9
KSEM3500HPGM	35,000	1.3780	9
KSEM3600HPGM	36,000	1.4173	9
KSEM3651HPGM	36,510	1.4375	10
KSEM3700HPGM	37,000	1.4567	10
KSEM3731HPGM	37,310	1.4690	10
KSEM3750HPGM	37,500	1.4764	10
KSEM3800HPGM	38,000	1.4961	10
KSEM3810HPGM	38,100	1.5000	10
KSEM3846HPGM	38,460	1.5142	10
KSEM3900HPGM	39,000	1.5354	10
KSEM4000HPGM	40,000	1.5748	10

Modular Drill Carbide Insert Blades • KSEM™ • HPG Geometry • Grade KCPM45™ • Through Coolant • Metric

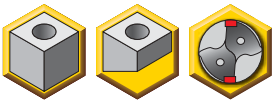
Material Group		Cutting Speed — vc Range — m/min			Metric						
					Recommended Feed Rate (f) by Diameter						
		min	Starting Value	max		12,5	16,0	20,0	25,4	32,0	40,0
P	1	100	**110**	120	mm/r	0,15–0,31	0,17–0,36	0,19–0,41	0,25–0,53	0,29–0,60	0,33–0,69
	2	80	**95**	110	mm/r	0,15–0,31	0,17–0,36	0,19–0,41	0,25–0,53	0,29–0,60	0,33–0,69
	3	65	**70**	80	mm/r	0,15–0,31	0,17–0,36	0,19–0,41	0,25–0,53	0,29–0,60	0,33–0,69
M	1	30	**60**	90	mm/r	0,09–0,14	0,11–0,17	0,13–0,20	0,16–0,25	0,18–0,28	0,21–0,31
	2	30	**50**	90	mm/r	0,09–0,14	0,11–0,17	0,13–0,20	0,16–0,25	0,18–0,28	0,21–0,31
	3	20	**40**	60	mm/r	0,09–0,14	0,11–0,17	0,13–0,20	0,16–0,25	0,18–0,28	0,21–0,31

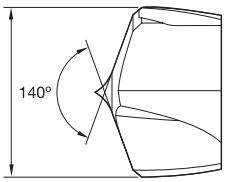
Modular Drill Carbide Insert Blades • KSEM • HPG Geometry • Grade KCPM45 • MQL* • Metric

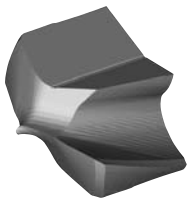
Material Group		Cutting Speed — vc Range — m/min			Metric						
					Recommended Feed Rate (f) by Diameter						
		min	Starting Value	max		12,5	16,0	20,0	25,4	32,0	40,0
P	1	60	**70**	80	mm/r	0,15–0,31	0,17–0,36	0,19–0,41	0,25–0,53	0,29–0,60	0,33–0,69
	2	50	**60**	70	mm/r	0,15–0,31	0,17–0,36	0,19–0,41	0,25–0,53	0,29–0,60	0,33–0,69
	3	65	**45**	80	mm/r	0,15–0,31	0,17–0,36	0,19–0,41	0,25–0,53	0,29–0,60	0,33–0,69
M	1	30	**40**	50	mm/r	0,09–0,14	0,11–0,17	0,13–0,20	0,16–0,25	0,18–0,28	0,21–0,31
	2	25	**30**	35	mm/r	0,09–0,14	0,11–0,17	0,13–0,20	0,16–0,25	0,18–0,28	0,21–0,31
	3	20	**25**	30	mm/r	0,09–0,14	0,11–0,17	0,13–0,20	0,16–0,25	0,18–0,28	0,21–0,31

*Recommended for drilling depths ≤1.5 x D.

- KSEM KC7410™ HPCCL focuses on tool life and process reliability in cast iron materials in all cast iron materials. It offers increased feed forces in increases your productivity.
- HPCCL geometry offers a wide and strong HP-style chiseled edge that prevents material quenching in the centre, enabling high feed rates. With a corner chamfer and strong edges, it creates high quality holes and increased tool life.
- KC7410 is a multilayer AlCr-based coating over fine-grain carbide. It is extraordinarily wear resistant in cast iron applications due to its high hot hardness.
- Use KC7410 HPCCL in all cast iron applications, especially when working in difficult conditions and CGI or ADI irons.



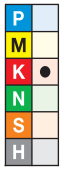



HPCCL

KSEM Inserts • HPCCL KC7410



KC7410	D1 mm	D1 in	seat size
KSEM1250HPCCLM	12,500	.4921	C
KSEM1270HPCCLM *	12,700	.5000	C
KSEM1293HPCCLM	12,930	.5091	C
KSEM1300HPCCLM	13,000	.5118	C
KSEM1310HPCCLM	13,100	.5157	C
KSEM1350HPCCLM	13,500	.5315	C
KSEM1389HPCCLM	13,890	.5469	B
KSEM1400HPCCLM	14,000	.5512	B
KSEM1429HPCCLM	14,290	.5626	B
KSEM1450HPCCLM	14,500	.5709	B
KSEM1468HPCCLM	14,680	.5780	A
KSEM1500HPCCLM	15,000	.5906	A
KSEM1548HPCCLM *	15,480	.6094	A
KSEM1550HPCCLM	15,500	.6102	A
KSEM1588HPCCLM *	15,880	.6252	1
KSEM1600HPCCLM	16,000	.6299	1
KSEM1609HPCCLM	16,090	.6335	1
KSEM1627HPCCLM	16,270	.6406	1
KSEM1650HPCCLM	16,500	.6496	1
KSEM1667HPCCLM	16,670	.6563	1
KSEM1700HPCCLM	17,000	.6693	1
KSEM1707HPCCLM	17,070	.6720	1
KSEM1746HPCCLM	17,460	.6874	1
KSEM1750HPCCLM	17,500	.6890	1
KSEM1760HPCCLM	17,600	.6929	1
KSEM1800HPCCLM	18,000	.7087	1
KSEM1826HPCCLM	18,260	.7189	2
KSEM1850HPCCLM	18,500	.7283	2
KSEM1900HPCCLM	19,000	.7480	2
KSEM1905HPCCLM	19,050	.7500	2
KSEM1927HPCCLM *	19,270	.7587	2
KSEM1945HPCCLM *	19,450	.7657	2



● first choice
○ alternate choice

KC7410	D1 mm	D1 in	seat size
KSEM1950HPCCLM	19,500	.7677	2
KSEM1984HPCCLM	19,840	.7811	2
KSEM2000HPCCLM	20,000	.7874	3
KSEM2024HPCCLM	20,240	.7969	3
KSEM2050HPCCLM	20,500	.8071	3
KSEM2064HPCCLM	20,640	.8126	3
KSEM2100HPCCLM	21,000	.8268	3
KSEM2143HPCCLM	21,430	.8437	3
KSEM2150HPCCLM	21,500	.8465	3
KSEM2200HPCCLM	22,000	.8661	3
KSEM2210HPCCLM	22,100	.8701	4
KSEM2223HPCCLM	22,230	.8752	4
KSEM2244HPCCLM	22,440	.8835	4
KSEM2250HPCCLM	22,500	.8858	4
KSEM2300HPCCLM	23,000	.9055	4
KSEM2342HPCCLM	23,420	.9220	4
KSEM2350HPCCLM	23,500	.9252	4
KSEM2381HPCCLM	23,810	.9374	4
KSEM2400HPCCLM	24,000	.9449	4
KSEM2450HPCCLM	24,500	.9646	5
KSEM2461HPCCLM	24,610	.9689	5
KSEM2500HPCCLM	25,000	.9843	5
KSEM2540HPCCLM	25,400	1.0000	5
KSEM2550HPCCLM	25,500	1.0039	5
KSEM2567HPCCLM	25,670	1.0106	5
KSEM2600HPCCLM	26,000	1.0236	5
KSEM2619HPCCLM	26,190	1.0311	6
KSEM2650HPCCLM	26,500	1.0433	6
KSEM2659HPCCLM	26,590	1.0469	6
KSEM2700HPCCLM	27,000	1.0630	6
KSEM2750HPCCLM	27,500	1.0827	6
KSEM2778HPCCLM	27,780	1.0937	6

(continued)

(KSEM Inserts • HPCCL KC7410™ — continued)



KC7410	D1 mm	D1 in	seat size
KSEM2800HPCCLM	28,000	1.1024	6
KSEM2818HPCCLM *	28,180	1.0940	7
KSEM2850HPCCLM	28,500	1.1220	7
KSEM2858HPCCLM	28,580	1.1250	7
KSEM2900HPCCLM	29,000	1.1417	7
KSEM2937HPCCLM	29,370	1.1563	7
KSEM2950HPCCLM *	29,500	1.1614	7
KSEM2977HPCCLM	29,770	1.1720	7
KSEM3000HPCCLM	30,000	1.1811	7
KSEM3016HPCCLM	30,160	1.1875	8
KSEM3050HPCCLM	30,500	1.2008	8
KSEM3100HPCCLM	31,000	1.2205	8



● first choice
○ alternate choice

KC7410	D1 mm	D1 in	seat size
KSEM3175HPCCLM	31,750	1.2500	8
KSEM3200HPCCLM	32,000	1.2598	8
KSEM3300HPCCLM	33,000	1.2992	9
KSEM3400HPCCLM *	34,000	1.3386	9
KSEM3500HPCCLM	35,000	1.3780	9
KSEM3600HPCCLM	36,000	1.4173	9
KSEM3700HPCCLM	37,000	1.4567	10
KSEM3800HPCCLM	38,000	1.4961	10
KSEM3900HPCCLM	39,000	1.5354	10
KSEM3920HPCCLM	39,200	1.5433	10
KSEM4000HPCCLM *	40,000	1.5748	10

NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Tolerance HPCCL • Metric

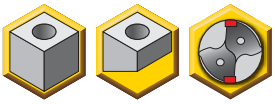
D1	tolerance h8
12,5–18	+0,000/-0,027
>18–30	+0,000/-0,033
>30–40	+0,000/-0,039

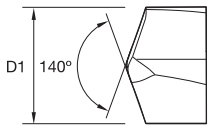
Application Data

Modular Drill Carbide Insert Blades • KSEM™ • HPCCL Geometry • Grade KC7410™ • Through Coolant • Metric

Material Group		Cutting Speed — vc Range — m/min min	Starting Value	max	Metric Recommended Feed Rate (f) by Diameter		12,5	16,0	20,0	25,4	32,0	40,0
K	1	100	**175**	200	mm/r	0,17–0,35	0,21–0,42	0,25–0,48	0,31–0,59	0,37–0,70	0,43–0,81
K	2	100	**160**	180	mm/r	0,17–0,33	0,21–0,41	0,25–0,48	0,31–0,59	0,37–0,70	0,43–0,81
K	3	70	**85**	100	mm/r	0,18–0,36	0,20–0,41	0,21–0,44	0,23–0,48	0,25–0,53	0,27–0,57

- KSEM KC7320™ HPL cutting edges provide perfect results and very high productivity in stainless steel.
- HPL geometry forms two chips per cutting edge for an uninterrupted, smooth chip flow. Very high metal removal rates and a reliable drilling process up to 10 x D makes HPL the superior solution for drilling in stainless steels.
- Grade KC7320 features a high Al content TiAlN coating on a universal fine-grain carbide. Its excellent oxidation stability and carbide toughness enables a high level of wear resistance in austenitic and other stainless steels.







HPL

KSEM Inserts • HPL KC7320

P M ● K N S H

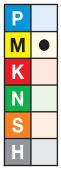
● first choice
○ alternate choice

KC7320	D1 mm	D1 in	seat size
KSEM1250HPLM	12,500	.4921	C
KSEM1270HPLM	12,700	.5000	C
KSEM1280HPLM	12,800	.5039	C
KSEM1293HPLM	12,930	.5090	C
KSEM1300HPLM	13,000	.5118	C
KSEM1311HPLM	13,100	.5157	C
KSEM1350HPLM	13,500	.5310	C
KSEM1360HPLM	13,600	.5354	B
KSEM1380HPLM	13,800	.5433	B
KSEM1389HPLM	13,890	.5470	B
KSEM1400HPLM	14,000	.5512	B
KSEM1410HPLM	14,100	.5551	B
KSEM1415HPLM	14,150	.5571	B
KSEM1420HPLM	14,200	.5591	B
KSEM1429HPLM	14,290	.5630	B
KSEM1450HPLM	14,500	.5709	B
KSEM1460HPLM	14,600	.5748	A
KSEM1468HPLM	14,680	.5780	A
KSEM1480HPLM	14,800	.5827	A
KSEM1500HPLM	15,000	.5906	A
KSEM1508HPLM	15,080	.5940	A
KSEM1548HPLM	15,480	.6090	A
KSEM1550HPLM	15,500	.6102	A
KSEM1560HPLM	15,600	.6142	A
KSEM1588HPLM	15,880	.6250	1
KSEM1600HPLM	16,000	.6299	1
KSEM1609HPLM	16,090	.6340	1
KSEM1610HPLM	16,100	.6339	1
KSEM1615HPLM	16,150	.6358	1
KSEM1620HPLM	16,200	.6378	1
KSEM1627HPLM	16,270	.6410	1
KSEM1650HPLM	16,500	.6496	1
KSEM1667HPLM	16,670	.6560	1
KSEM1700HPLM	17,000	.6693	1
KSEM1707HPLM	17,070	.6720	1
KSEM1746HPLM	17,460	.6875	1
KSEM1750HPLM	17,500	.6890	1
KSEM1775HPLM	17,750	.6988	1
KSEM1780HPLM	17,800	.7008	1
KSEM1786HPLM	17,860	.7030	1
KSEM1790HPLM	17,900	.7047	1
KSEM1800HPLM	18,000	.7087	1
KSEM1826HPLM	18,260	.7190	2
KSEM1850HPLM	18,500	.7283	2

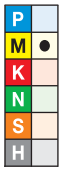
KC7320	D1 mm	D1 in	seat size
KSEM1860HPLM	18,600	.7323	2
KSEM1865HPLM	18,650	.7340	2
KSEM1890HPLM	18,900	.7441	2
KSEM1900HPLM	19,000	.7480	2
KSEM1905HPLM	19,050	.7500	2
KSEM1920HPLM	19,200	.7559	2
KSEM1923HPLM	19,228	.7570	2
KSEM1925HPLM	19,250	.7579	2
KSEM1927HPLM	19,270	.7590	2
KSEM1935HPLM	19,350	.7618	2
KSEM1936HPLM	19,360	.7622	2
KSEM1938HPLM	19,380	.7630	2
KSEM1945HPLM	19,450	.7660	2
KSEM1950HPLM	19,500	.7677	2
KSEM1984HPLM	19,840	.7810	2
KSEM2000HPLM	20,000	.7874	3
KSEM2010HPLM	20,100	.7913	3
KSEM2024HPLM	20,240	.7970	3
KSEM2035HPLM	20,350	.8012	3
KSEM2050HPLM	20,500	.8071	3
KSEM2064HPLM	20,640	.8125	3
KSEM2100HPLM	21,000	.8268	3
KSEM2115HPLM	21,150	.8327	3
KSEM2133HPLM	21,330	.8398	3
KSEM2143HPLM	21,430	.8440	3
KSEM2150HPLM	21,500	.8460	3
KSEM2183HPLM	21,830	.8590	3
KSEM2200HPLM	22,000	.8661	3
KSEM2223HPLM	22,230	.8750	4
KSEM2244HPLM	22,440	.8840	4
KSEM2250HPLM	22,500	.8858	4
KSEM2277HPLM	22,770	.8965	4
KSEM2300HPLM	23,000	.9055	4
KSEM2342HPLM	23,420	.9220	4
KSEM2350HPLM	23,500	.9252	4
KSEM2381HPLM	23,810	.9375	4
KSEM2400HPLM	24,000	.9449	4
KSEM2450HPLM	24,500	.9646	5
KSEM2461HPLM	24,610	.9690	5
KSEM2500HPLM	25,000	.9843	5
KSEM2507HPLM	25,070	.9870	5
KSEM2540HPLM	25,400	1.0000	5
KSEM2550HPLM	25,500	1.0039	5
KSEM2560HPLM	25,600	1.0080	5

(continued)

(KSEM Inserts • HPL KC7320™ — continued)



KC7320	D1 mm	D1 in	seat size
KSEM2565HPLM	25,650	1.0098	5
KSEM2567HPLM	25,670	1.0110	5
KSEM2581HPLM	25,810	1.0161	5
KSEM2600HPLM	26,000	1.0236	5
KSEM2619HPLM	26,190	1.0310	6
KSEM2650HPLM	26,500	1.0433	6
KSEM2659HPLM	26,590	1.0470	6
KSEM2670HPLM	26,700	1.0512	6
KSEM2700HPLM	27,000	1.0630	6
KSEM2750HPLM	27,500	1.0827	6
KSEM2779HPLM	27,780	1.0940	6
KSEM2800HPLM	28,000	1.1024	6
KSEM2810HPLM	28,100	1.1063	7
KSEM2817HPLM	28,180	1.1090	7
KSEM2850HPLM	28,500	1.1220	7
KSEM2858HPLM	28,580	1.1250	7
KSEM2900HPLM	29,000	1.1417	7
KSEM2937HPLM	29,370	1.1563	7
KSEM2950HPLM	29,500	1.1614	7
KSEM2977HPLM	29,770	1.1720	7



● first choice
○ alternate choice

KC7320	D1 mm	D1 in	seat size
KSEM3000HPLM	30,000	1.1811	7
KSEM3016HPLM	30,160	1.1875	8
KSEM3050HPLM	30,500	1.2008	8
KSEM3100HPLM	31,000	1.2205	8
KSEM3150HPLM	31,500	1.2402	8
KSEM3175HPLM	31,750	1.2500	8
KSEM3200HPLM	32,000	1.2598	8
KSEM3254HPLM	32,540	1.2810	9
KSEM3300HPLM	33,000	1.2992	9
KSEM3335HPLM	33,400	1.3130	9
KSEM3400HPLM	34,000	1.3386	9
KSEM3493HPLM	34,930	1.3750	9
KSEM3500HPLM	35,000	1.3780	9
KSEM3571HPLM	35,720	1.4060	9
KSEM3600HPLM	36,000	1.4173	9
KSEM3700HPLM	37,000	1.4567	10
KSEM3750HPLM	37,500	1.4764	10
KSEM3800HPLM	38,000	1.4961	10
KSEM3810HPLM	38,100	1.5000	10
KSEM3846HPLM	38,460	1.5140	10
KSEM3900HPLM	39,000	1.5354	10
KSEM4000HPLM	40,000	1.5748	10

Tolerance HPL • Metric

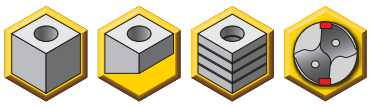
D1 metric	tolerance h8
12,5–18	+0,000/-0,027
>18–30	+0,000/-0,033
>30–40	+0,000/-0,039

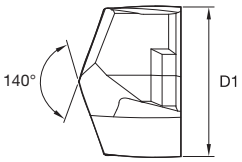
Application Data

Modular Drill Carbide Insert Blades • KSEM • HPL Geometry • Grade KC7320 • Through Coolant • Metric

Material Group		Cutting Speed — vc Range — m/min min	Starting Value	max		Metric Recommended Feed Rate (f) by Diameter 12,5	16,0	20,0	25,4	32,0	40,0
M	1	30	**60**	90	mm/r	0,09–0,14	0,11–0,17	0,13–0,20	0,16–0,25	0,18–0,28	0,21–0,31
M	2	30	**50**	90	mm/r	0,09–0,14	0,11–0,17	0,13–0,20	0,16–0,25	0,18–0,28	0,21–0,31
M	3	20	**40**	60	mm/r	0,09–0,14	0,11–0,17	0,13–0,20	0,16–0,25	0,18–0,28	0,21–0,31

- KSEM SPL geometry was made to offer extraordinary drilling performance in stainless steels, super alloys, and other demanding environments.
- KSEM SPL provides process reliability, ensuring longer tool life and productivity in difficult-to-machine materials. Its advanced-point geometry and web design greatly reduces cutting forces.
- KCMS35™ is based on a very tough, fine-grain carbide substrate with a high Al content TiAlN PVD coating. It offers a high level of wear resistance and oxidation stability in parallel with chipping resistance for centre point and cutting edges.
- This insert style is ideally suited to drill heavy-duty and corrosion-resistant tube end sheets and other heat exchanger components (especially from M3 and type S materials).
- Use KSEM KCMS35 SPL inserts as an effective alternative for plain and alloyed steels, as well as in the most important Al and Cu applications.

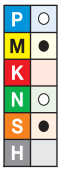




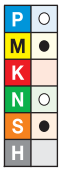


SPL

KSEM Inserts • SPL KCMS35



KCMS35	D1 mm	D1 in	seat size
KSEM1250SPLM	12,500	.4921	C
KSEM1270SPLM	12,700	.5000	C
KSEM1300SPLM	13,000	.5118	C
KSEM1350SPLM	13,500	.5315	C
KSEM1400SPLM	14,000	.5512	B
KSEM1429SPLM	14,290	.5626	B
KSEM1450SPLM	14,500	.5709	B
KSEM1500SPLM	15,000	.5906	A
KSEM1550SPLM	15,500	.6102	A
KSEM1588SPLM	15,880	.6252	1
KSEM1600SPLM	16,000	.6299	1
KSEM1609SPLM	16,090	.6335	1
KSEM1615SPLM	16,150	.6358	1
KSEM1627SPLM	16,270	.6406	1
KSEM1650SPLM	16,500	.6496	1
KSEM1667SPLM	16,670	.6563	1
KSEM1700SPLM	17,000	.6693	1
KSEM1746SPLM	17,460	.6874	1
KSEM1750SPLM	17,500	.6890	1
KSEM1800SPLM	18,000	.7087	1
KSEM1830SPLM	18,300	.7205	2
KSEM1850SPLM	18,500	.7283	2
KSEM1900SPLM	19,000	.7480	2
KSEM1905SPLM	19,050	.7500	2
KSEM1920SPLM	19,200	.7559	2
KSEM1923SPLM	19,230	.7571	2
KSEM1925SPLM	19,250	.7579	2
KSEM1927SPLM	19,270	.7587	2
KSEM1935SPLM	19,350	.7618	2
KSEM1945SPLM	19,450	.7657	2
KSEM1950SPLM	19,500	.7677	2
KSEM1984SPLM	19,840	.7811	2

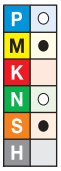


● first choice
○ alternate choice

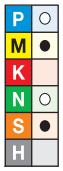
KCMS35	D1 mm	D1 in	seat size
KSEM2000SPLM	20,000	.7874	3
KSEM2024SPLM	20,240	.7969	3
KSEM2050SPLM	20,500	.8071	3
KSEM2064SPLM	20,640	.8126	3
KSEM2100SPLM	21,000	.8268	3
KSEM2150SPLM	21,500	.8465	3
KSEM2200SPLM	22,000	.8661	3
KSEM2223SPLM	22,230	.8752	4
KSEM2250SPLM	22,500	.8858	4
KSEM2300SPLM	23,000	.9055	4
KSEM2350SPLM	23,500	.9252	4
KSEM2381SPLM	23,810	.9374	4
KSEM2400SPLM	24,000	.9449	4
KSEM2450SPLM	24,500	.9646	5
KSEM2500SPLM	25,000	.9843	5
KSEM2525SPLM	25,250	.9941	5
KSEM2530SPLM	25,300	.9961	5
KSEM2540SPLM	25,400	1.0000	5
KSEM2550SPLM	25,500	1.0039	5
KSEM2560SPLM	25,600	1.0079	5
KSEM2565SPLM	25,650	1.0098	5
KSEM2567SPLM	25,670	1.0106	5
KSEM2581SPLM	25,810	1.0161	5
KSEM2600SPLM	26,000	1.0236	5
KSEM2619SPLM	26,190	1.0311	6
KSEM2630SPLM	26,300	1.0354	6
KSEM2650SPLM	26,500	1.0433	6
KSEM2659SPLM	26,590	1.0469	6
KSEM2700SPLM	27,000	1.0630	6
KSEM2750SPLM	27,500	1.0827	6
KSEM2800SPLM	28,000	1.1024	6
KSEM2850SPLM	28,500	1.1220	7

(continued)

(KSEM Inserts • SPL KCMS35™ — continued)



KCMS35	D1 mm	D1 in	seat size
KSEM2858SPLM	28,580	1.1252	7
KSEM2900SPLM	29,000	1.1417	7
KSEM2950SPLM	29,500	1.1614	7
KSEM3000SPLM	30,000	1.1811	7
KSEM3050SPLM	30,500	1.2008	8
KSEM3100SPLM	31,000	1.2205	8
KSEM3150SPLM	31,500	1.2402	8
KSEM3175SPLM	31,750	1.2500	8
KSEM3200SPLM	32,000	1.2598	8
KSEM3250SPLM	32,500	1.2795	9
KSEM3350SPLM	33,500	1.3189	9
KSEM3400SPLM	34,000	1.3386	9



● first choice
○ alternate choice

KCMS35	D1 mm	D1 in	seat size
KSEM3450SPLM	34,500	1.3583	9
KSEM3500SPLM	35,000	1.3780	9
KSEM3550SPLM	35,500	1.3976	9
KSEM3600SPLM	36,000	1.4173	9
KSEM3650SPLM	36,500	1.4370	10
KSEM3700SPLM	37,000	1.4567	10
KSEM3750SPLM	37,500	1.4764	10
KSEM3800SPLM	38,000	1.4961	10
KSEM3846SPLM	38,460	1.5142	10
KSEM3850SPLM	38,500	1.5157	10
KSEM3900SPLM	39,000	1.5354	10
KSEM3950SPLM	39,500	1.5551	10
KSEM4000SPLM	40,000	1.5748	10

Tolerance SPL • Metric

D1 metric	tolerance h8
12,5–18	+0,000/-0,027
>18–30	+0,000/-0,033
>30–40	+0,000/-0,039

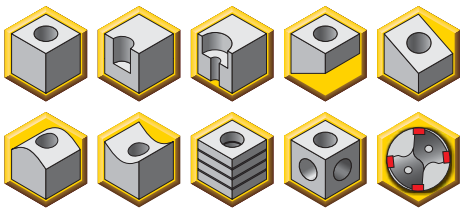
Application Data

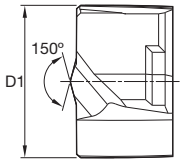
Modular Drill Carbide Insert Blades • KSEM™ • SPL Geometry • Grade KCMS35™ • Through Coolant • Metric

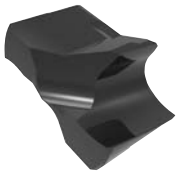
Material Group		Cutting Speed — vc Range — m/min min	Starting Value	max	Metric Recommended Feed Rate (f) by Diameter	12,5	16,0	20,0	25,4	32,0	40,0
P	1	110	**140**	170	mm/r	0,15–0,31	0,17–0,36	0,19–0,41	0,25–0,53	0,29–0,60	0,33–0,69
	2	100	**120**	140	mm/r	0,15–0,31	0,17–0,36	0,19–0,41	0,25–0,53	0,29–0,60	0,33–0,69
	3	80	**100**	120	mm/r	0,15–0,31	0,17–0,36	0,19–0,41	0,25–0,53	0,29–0,60	0,33–0,69
M	1	40	**60**	80	mm/r	0,09–0,14	0,11–0,17	0,13–0,20	0,16–0,25	0,18–0,28	0,21–0,31
	2	35	**55**	70	mm/r	0,09–0,14	0,11–0,17	0,13–0,20	0,16–0,25	0,18–0,28	0,21–0,31
	3	20	**40**	60	mm/r	0,09–0,14	0,11–0,17	0,13–0,20	0,16–0,25	0,18–0,28	0,21–0,31
N	1	90	**155**	220	mm/r	0,19–0,40	0,25–0,50	0,28–0,56	0,32–0,63	0,32–0,70	0,32–0,70
	2	90	**155**	220	mm/r	0,19–0,40	0,25–0,50	0,28–0,56	0,32–0,63	0,32–0,70	0,32–0,70
	3	80	**120**	160	mm/r	0,19–0,40	0,25–0,50	0,28–0,56	0,32–0,63	0,32–0,70	0,32–0,70
	4	90	**155**	220	mm/r	0,19–0,40	0,25–0,50	0,28–0,56	0,32–0,63	0,32–0,70	0,32–0,70
S	1	20	**40**	60	mm/r	0,05–0,10	0,07–0,12	0,09–0,14	0,11–0,17	0,13–0,20	0,16–0,25
	2	15	**30**	45	mm/r	0,05–0,10	0,07–0,12	0,09–0,14	0,11–0,17	0,13–0,20	0,16–0,25
	3	15	**30**	45	mm/r	0,05–0,10	0,07–0,12	0,09–0,14	0,11–0,17	0,13–0,20	0,16–0,25
	4	10	**25**	40	mm/r	0,05–0,10	0,07–0,12	0,13–0,20	0,16–0,25	0,18–0,28	0,21–0,31

Application recommendation: We recommend pre-centring when drilling with SPL inserts >5 x D.
For deeper holes (> = 10 x D), and for drilling M1 and M2 materials in general, we recommend using KSEM HPL inserts as a first choice.

- KSEM FEG flat-bottom inserts create 180° flat holes — only a small cavity remains in the centre of the hole ground. KSEM offers an extraordinarily strong pocket seat for your demanding flat-bottom applications.
- Whether it is a blind hole, a through hole, or if you need to countersink, these inserts are focused on versatility and will support you in many essential drilling applications.
- KSEM FEG inserts feature a small centring point as well as double margin lands for improved guidance and hole straightness. A corner chamfer serves to reduce bur formation and to improve tool life.
- KCPM45™ combines a very tough, fine-grain carbide substrate with an advanced multilayer TiAlN coating. It is capable of machining steel even in the most demanding conditions.
- Use KSEM FEG KCPM45 cutting edges as an effective alternative in cast iron, stainless steel, and high-temp alloys.

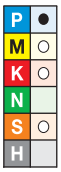






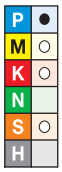
FEG

KSEM Inserts • FEG KCPM45



● first choice
○ alternate choice

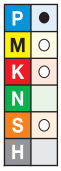
KCPM45	D1 mm	D1 in	seat size
KSEM1600FEGM	16,000	.6299	1
KSEM1650FEGM	16,500	.6496	1
KSEM1700FEGM	17,000	.6693	1
KSEM1750FEGM	17,500	.6890	1
KSEM1800FEGM	18,000	.7087	1
KSEM1850FEGM	18,500	.7283	2
KSEM1900FEGM	19,000	.7480	2
KSEM1905FEGM	19,050	.7500	2
KSEM1950FEGM	19,500	.7677	2
KSEM1984FEGM	19,840	.7811	2
KSEM2000FEGM	20,000	.7874	3
KSEM2050FEGM	20,500	.8071	3
KSEM2100FEGM	21,000	.8268	3
KSEM2150FEGM	21,500	.8465	3
KSEM2200FEGM	22,000	.8661	3
KSEM2250FEGM	22,500	.8858	4
KSEM2300FEGM	23,000	.9055	4
KSEM2350FEGM	23,500	.9252	4
KSEM2400FEGM	24,000	.9449	4
KSEM2450FEGM	24,500	.9646	5
KSEM2500FEGM	25,000	.9843	5
KSEM2540FEGM	25,400	1.0000	5
KSEM2550FEGM	25,500	1.0039	5
KSEM2580FEGM	25,800	1.0157	5



KCPM45	D1 mm	D1 in	seat size
KSEM2581FEGM	25,810	1.0161	5
KSEM2600FEGM	26,000	1.0236	5
KSEM2619FEGM	26,190	1.0311	6
KSEM2650FEGM	26,500	1.0433	6
KSEM2670FEGM	26,700	1.0512	6
KSEM2700FEGM	27,000	1.0630	6
KSEM2750FEGM	27,500	1.0827	6
KSEM2800FEGM	28,000	1.1024	6
KSEM2850FEGM	28,500	1.1220	7
KSEM2900FEGM	29,000	1.1417	7
KSEM2950FEGM	29,500	1.1614	7
KSEM3000FEGM	30,000	1.1811	7
KSEM3050FEGM	30,500	1.2008	8
KSEM3100FEGM	31,000	1.2205	8
KSEM3150FEGM	31,500	1.2402	8
KSEM3175FEGM	31,750	1.2500	8
KSEM3200FEGM	32,000	1.2598	8
KSEM3250FEGM	32,500	1.2795	9
KSEM3300FEGM	33,000	1.2992	9
KSEM3350FEGM	33,500	1.3189	9
KSEM3400FEGM	34,000	1.3386	9
KSEM3450FEGM	34,500	1.3583	9
KSEM3500FEGM	35,000	1.3780	9
KSEM3550FEGM	35,500	1.3976	9

(continued)

(KSEM Inserts • FEG KCPM45™ — continued)



● first choice
○ alternate choice

KCPM45	D1 mm	D1 in	seat size
KSEM3600FEGM	36,000	1.4173	9
KSEM3650FEGM	36,500	1.4370	10
KSEM3700FEGM	37,000	1.4567	10
KSEM3750FEGM	37,500	1.4764	10
KSEM3800FEGM	38,000	1.4961	10
KSEM3810FEGM	38,100	1.5000	10
KSEM3850FEGM	38,500	1.5157	10
KSEM3900FEGM	39,000	1.5354	10
KSEM3950FEGM	39,500	1.5551	10
KSEM4000FEGM	40,000	1.5748	10

Tolerance FEG • Metric

D1 metric	tolerance k7
12,5–18	+0,001/+ 0,019
>18–30	+0,002/+ 0,023
>30–40	+0,002/+ 0,027

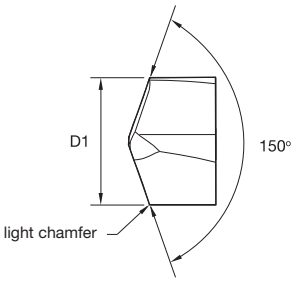
Application Data

Modular Drill Carbide Insert Blades • KSEM™ • FEG Geometry • Grade KCPM45™ • Through Coolant • Metric

Material Group		Cutting Speed — vc Range — m/min min	Starting Value	max	Metric	Recommended Feed Rate (f) by Diameter 12,5	16,0	20,0	25,4	32,0	40,0
P	1	110	**140**	170	mm/r	0,14–0,23	0,17–0,25	0,19–0,29	0,23–0,38	0,26–0,43	0,33–0,76
	2	100	**120**	140	mm/r	0,17–0,23	0,19–0,25	0,22–0,29	0,29–0,38	0,32–0,43	0,33–0,76
	3	80	**100**	120	mm/r	0,14–0,20	0,15–0,23	0,17–0,25	0,23–0,34	0,26–0,38	0,33–0,66
	4	70	**90**	110	mm/r	0,11–0,20	0,13–0,23	0,14–0,25	0,18–0,34	0,21–0,38	0,26–0,66
M	1	40	**60**	80	mm/r	0,09–0,14	0,11–0,17	0,13–0,20	0,16–0,25	0,18–0,28	0,21–0,31
	2	35	**55**	70	mm/r	0,09–0,14	0,11–0,17	0,13–0,20	0,16–0,25	0,18–0,28	0,21–0,31
	3	20	**40**	60	mm/r	0,09–0,14	0,11–0,17	0,13–0,20	0,16–0,25	0,18–0,28	0,21–0,31
K	1	90	**135**	175	mm/r	0,17–0,23	0,19–0,25	0,22–0,29	0,29– 0,38	0,32–0,43	0,33–0,76
	2	80	**120**	140	mm/r	0,17–0,23	0,19–0,25	0,22–0,29	0,29–0,38	0,32–0,43	0,33–0,76
	3	70	**110**	125	mm/r	0,15–0,24	0,18–0,26	0,21–0,29	0,23–0,37	0,25–0,42	0,27–0,57
S	1	20	**40**	60	mm/r	0,09–0,14	0,11–0,17	0,13–0,20	0,16–0,25	0,18–0,28	0,21–0,31
	3	15	**30**	45	mm/r	0,09–0,14	0,11–0,17	0,13–0,20	0,16–0,25	0,18–0,28	0,21–0,31

- KSEM PC cutting edges serve mainly as precentring inserts, but can also be used in demanding conditions.
- Steep 150° degree angle with a light corner chamfer. Very good centring capability and edge chipping resistance.
- KC7135™ is a very resistant grade featuring a TiCN-TiN PVD coating.







KSEM Inserts • PC KC7135

P ● M K ● N S H

● first choice
○ alternate choice

KC7135	D1 mm	D1 in	seat size
KSEM1250PCM	12,500	.4921	C
KSEM1280PCM	12,800	.5039	C
KSEM1300PCM	13,000	.5118	C
KSEM1350PCM	13,500	.5310	C
KSEM1380PCM	13,800	.5433	B
KSEM1400PCM	14,000	.5512	B
KSEM1410PCM	14,100	.5551	B
KSEM1450PCM	14,500	.5709	B
KSEM1460PCM	14,600	.5748	A
KSEM1480PCM	14,800	.5827	A
KSEM1500PCM	15,000	.5906	A
KSEM1550PCM	15,500	.6102	A
KSEM1560PCM	15,600	.6142	A
KSEM1580PCM	15,800	.6220	A
KSEM1600PCM	16,000	.6299	1
KSEM1620PCM	16,200	.6378	1
KSEM1650PCM	16,500	.6496	1
KSEM1700PCM	17,000	.6693	1
KSEM1750PCM	17,500	.6890	1
KSEM1800PCM	18,000	.7087	1
KSEM1850PCM	18,500	.7283	2
KSEM1900PCM	19,000	.7480	2
KSEM1950PCM	19,500	.7677	2
KSEM2000PCM	20,000	.7874	3
KSEM2050PCM	20,500	.8071	3
KSEM2100PCM	21,000	.8268	3
KSEM2150PCM	21,500	.8460	3
KSEM2200PCM	22,000	.8661	3

P ● M K ● N S H

KC7135	D1 mm	D1 in	seat size
KSEM2250PCM	22,500	.8858	4
KSEM2300PCM	23,000	.9055	4
KSEM2350PCM	23,500	.9252	4
KSEM2400PCM	24,000	.9449	4
KSEM2450PCM	24,500	.9646	5
KSEM2500PCM	25,000	.9843	5
KSEM2550PCM	25,500	1.0039	5
KSEM2600PCM	26,000	1.0236	5
KSEM2650PCM	26,500	1.0433	6
KSEM2700PCM	27,000	1.0630	6
KSEM2800PCM	28,000	1.1024	6
KSEM2850PCM	28,500	1.1220	7
KSEM2900PCM	29,000	1.1417	7
KSEM2950PCM	29,500	1.1614	7
KSEM3000PCM	30,000	1.1811	7
KSEM3050PCM	30,500	1.2008	8
KSEM3100PCM	31,000	1.2205	8
KSEM3200PCM	32,000	1.2598	8
KSEM3300PCM	33,000	1.2992	9
KSEM3400PCM	34,000	1.3386	9
KSEM3500PCM	35,000	1.3780	9
KSEM3600PCM	36,000	1.4173	9
KSEM3700PCM	37,000	1.4567	10
KSEM3800PCM	38,000	1.4961	10
KSEM3900PCM	39,000	1.5354	10
KSEM4000PCM	40,000	1.5748	10

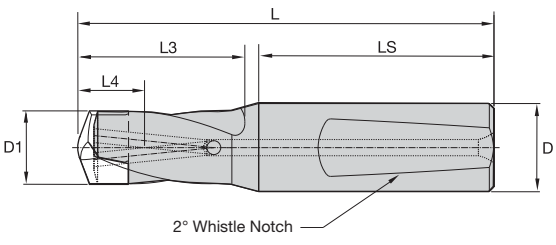
Tolerance PC • Metric

D1 metric	tolerance k7
12,5–18	+0,001/+0,019
>18–30	+0,002/+0,023
>30–40	+0,002/+0,027

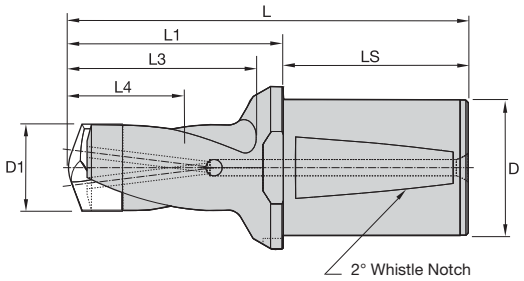
Modular Drill Carbide Insert Blades • KSEM™ • PC Geometry • Grade KC7135™ • Through Coolant • Metric

Material Group		Cutting Speed — vc Range — m/min			Metric					
					Recommended Feed Rate (f) by Diameter					
		min	Starting Value	max		12,5	16,0	20,0	25,4	32,0
P	1	90	**100**	110	mm/r	0,14–0,23	0,17–0,25	0,19–0,29	0,23–0,38	0,26–0,43
	2	80	**90**	100	mm/r	0,17–0,23	0,19–0,25	0,22–0,29	0,29–0,38	0,32–0,43
	3	55	**65**	75	mm/r	0,14–0,20	0,15–0,23	0,17–0,25	0,23–0,34	0,26–0,38
	4	50	**60**	70	mm/r	0,11–0,20	0,13–0,23	0,14–0,25	0,18–0,34	0,21–0,38
	5	45	**50**	60	mm/r	0,08–0,11	0,10–0,13	0,11–0,14	0,14–0,18	0,15–0,20
	6	45	**55**	65	mm/r	0,11–0,17	0,13–0,18	0,14–0,20	0,18–0,28	0,21–0,31
K	1	60	**60**	90	mm/r	0,08–0,24	0,09–0,28	0,11–0,31	0,14–0,43	0,15–0,48
	2	60	**60**	75	mm/r	0,18–0,24	0,21–0,28	0,23–0,31	0,28–0,37	0,32–0,42
	3	40	**40**	75	mm/r	0,15–0,24	0,18–0,26	0,21–0,29	0,23–0,37	0,25–0,42

- Use designated insert blade with each drill body.
- For alternatives, see insert blade fitment chart on page H68–H69.
- Drill shipped with central lock screw, wrench, and side pipe plug.
- Order insert blade separately; see pages H38–H57.



Whistle Notch shank D1≤32mm



Whistle Notch shank with Drive D1≥32mm

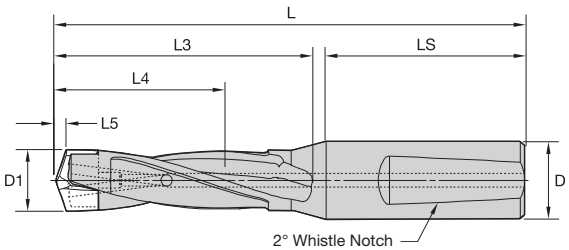


KSEM WN/WD50 Shank • 1 x D • Metric

1 x D	D1 mm	D1 in	D1 max mm	D1 max in	L	L1	L4 max	L5	LS	D	seat size	central lock screw	wrench
KSEM125R1WN16M	12,500	.4921	13,500	.5314	78	—	14	2,0	48	16	C	**364.017**	**170.294**
KSEM136R1WN16M	13,510	.5319	14,500	.5708	81	—	15	2,2	48	16	B	**364.016**	**170.289**
KSEM146R1WN20M	14,510	.5713	15,874	.6249	85	—	16	2,3	50	20	A	**364.016**	**170.289**
KSEM160R1WN20M	16,000	.6299	18,000	.7086	88	—	18	2,5	50	20	1	**364.010**	**170.270**
KSEM181R1WN25M	18,010	.7091	19,999	.7873	99	—	20	2,9	56	25	2	**364.010**	**170.270**
KSEM200R1WN25M	20,000	.7874	22,000	.8661	102	—	22	3,2	56	25	3	**364.011**	**170.272**
KSEM221R1WN25M	22,010	.8665	24,000	.9448	107	—	24	3,5	56	25	4	**364.011**	**170.272**
KSEM241R1WN32M	24,010	.9453	26,000	1.0236	115	—	26	3,8	60	32	5	**364.012**	**170.274**
KSEM261R1WN32M	26,010	1.0240	28,000	1.1023	119	—	28	4,0	60	32	6	**364.012**	**170.274**
KSEM281R1WN32M	28,016	1.1030	30,000	1.1811	123	—	30	4,3	60	32	7	**364.013**	**170.276**
KSEM301R1WN32M	30,010	1.1815	32,000	1.2598	127	—	32	4,6	60	32	8	**364.013**	**170.276**
KSEM321R1WD50M	32,010	1.2602	36,000	1.4173	147	79	36	4,9	68	50	9	**364.015**	**170.276**
KSEM361R1WD50M	36,010	1.4177	40,000	1.5748	155	87	40	5,5	68	50	10	**364.015**	**170.276**

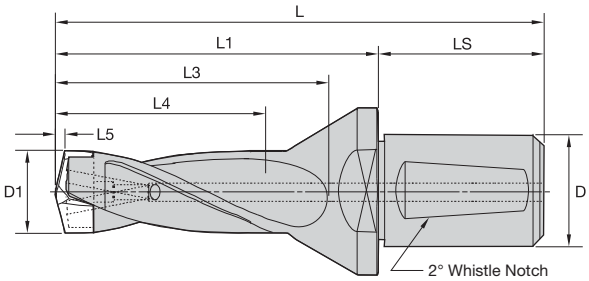
- Use designated insert blade with each drill body.
- For alternatives, see insert blade fitment chart on page H68–H69.
- Drill shipped with central lock screw, wrench, and side pipe plug.
- Order insert blade separately; see pages H38–H57.



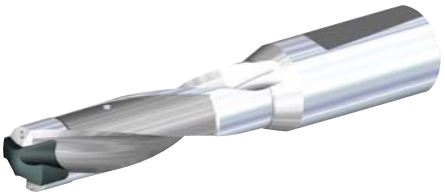


for diameters < 16mm, DIN 6535 - HE
for diameters > 16mm, DIN 1835 part 1 form E

Whistle Notch shank D1≤32mm



Whistle Notch shank with Drive D1≥32mm



KSEM WN/WD50 Shank • 3 x D/5 x D • Metric

3 x D	5 x D	D1 mm	D1 in	D1 max mm	D1 max in	L5	LS	D	seat size	central lock screw
KSEM125R3WN16M	**KSEM125R5WN16M**	12,500	.4921	13,000	.5118	2,0	48	16	C	**364.017**
KSEM130R3WN16M	**KSEM130R5WN16M**	13,000	.5118	13,500	.5314	2,1	48	16	C	**364.017**
KSEM135R3WN16M	**KSEM135R5WN16M**	13,500	.5315	13,500	.5314	2,1	48	16	C	**364.017**
KSEM136R3WN16M	**KSEM136R5WN16M**	13,510	.5319	14,000	.5512	2,2	48	16	B	**364.016**
KSEM140R3WN16M	**KSEM140R5WN16M**	14,000	.5512	14,500	.5708	2,2	48	16	B	**364.016**
KSEM145R3WN20M	**KSEM145R5WN20M**	14,500	.5709	14,500	.5708	2,3	50	20	B	**364.016**
KSEM146R3WN20M	**KSEM146R5WN20M**	14,510	.5713	15,000	.5906	2,3	50	20	A	**364.016**
KSEM150R3WN20M	**KSEM150R5WN20M**	15,000	.5906	15,500	.6102	2,4	50	20	A	**364.016**
KSEM155R3WN20M	**KSEM155R5WN20M**	15,500	.6102	15,874	.6249	2,5	50	20	A	**364.016**
KSEM160R3WN20M	**KSEM160R5WN20M**	16,000	.6299	16,500	.6496	2,5	50	20	1	**364.010**
KSEM165R3WN20M	**KSEM165R5WN20M**	16,500	.6496	17,000	.6693	2,6	50	20	1	**364.010**
KSEM170R3WN20M	**KSEM170R5WN20M**	17,000	.6693	17,500	.6890	2,7	50	20	1	**364.010**
KSEM175R3WN20M	**KSEM175R5WN20M**	17,500	.6890	18,000	.7086	2,8	50	20	1	**364.010**
KSEM180R3WN20M	**KSEM180R5WN20M**	18,000	.7087	18,000	.7086	2,9	50	20	1	**364.010**
–	**KSEM181R5WN25M**	18,010	.7091	18,500	.7283	2,9	56	25	2	**364.010**
KSEM185R3WN25M	**KSEM185R5WN25M**	18,500	.7283	19,000	.7480	2,9	56	25	2	**364.010**
KSEM190R3WN25M	**KSEM190R5WN25M**	19,000	.7480	19,500	.7677	3,0	56	25	2	**364.010**
KSEM195R3WN25M	**KSEM195R5WN25M**	19,500	.7677	19,999	.7873	3,1	56	25	2	**364.010**
KSEM200R3WN25M	**KSEM200R5WN25M**	20,000	.7874	20,500	.8071	3,2	56	25	3	**364.011**
KSEM205R3WN25M	**KSEM205R5WN25M**	20,500	.8071	21,000	.8268	3,3	56	25	3	**364.011**
KSEM210R3WN25M	**KSEM210R5WN25M**	21,000	.8268	21,500	.8465	3,3	56	25	3	**364.011**
KSEM215R3WN25M	**KSEM215R5WN25M**	21,500	.8465	22,000	.8661	3,4	56	25	3	**364.011**
KSEM220R3WN25M	**KSEM220R5WN25M**	22,000	.8661	22,000	.8661	3,5	56	25	3	**364.011**
–	**KSEM221R5WN25M**	22,010	.8665	22,500	.8858	3,5	56	25	4	**364.011**

(*continued*)

(KSEM WN/WD50 Shank • 3 x D/5 x D • Metric — continued)

3 x D	5 x D	D1 mm	D1 in	D1 max mm	D1 max in	L5	LS	D	seat size	central lock screw
KSEM225R3WN25M	KSEM225R5WN25M	22,500	.8858	23,000	.9055	3,6	56	25	4	364.011
KSEM230R3WN25M	KSEM230R5WN25M	23,000	.9055	23,500	.9252	3,7	56	25	4	364.011
KSEM235R3WN25M	KSEM235R5WN25M	23,500	.9252	24,000	.9448	3,7	56	25	4	364.011
KSEM240R3WN25M	KSEM240R5WN25M	24,000	.9449	24,000	.9448	3,8	56	25	4	364.011
–	KSEM241R5WN32M	24,010	.9453	24,500	.9646	3,8	60	32	5	364.012
KSEM245R3WN32M	KSEM245R5WN32M	24,500	.9646	25,000	.9843	3,9	60	32	5	364.012
KSEM250R3WN32M	KSEM250R5WN32M	25,000	.9843	25,500	1.0039	3,8	60	32	5	364.012
KSEM255R3WN32M	KSEM255R5WN32M	25,500	1.0039	26,000	1.0236	3,9	60	32	5	364.012
KSEM260R3WN32M	KSEM260R5WN32M	26,000	1.0236	26,000	1.0236	4,0	60	32	5	364.012
–	KSEM261R5WN32M	26,010	1.0240	26,500	1.0433	4,0	60	32	6	364.012
KSEM265R3WN32M	KSEM265R5WN32M	26,500	1.0433	27,000	1.0630	4,1	60	32	6	364.012
KSEM270R3WN32M	KSEM270R5WN32M	27,000	1.0630	27,500	1.0827	4,2	60	32	6	364.012
KSEM275R3WN32M	KSEM275R5WN32M	27,500	1.0827	28,000	1.1023	4,2	60	32	6	364.012
KSEM280R3WN32M	KSEM280R5WN32M	28,000	1.1024	28,000	1.1023	4,3	60	32	6	364.012
–	KSEM281R5WN32M	28,016	1.1030	28,500	1.1220	4,3	60	32	7	364.013
KSEM285R3WN32M	KSEM285R5WN32M	28,500	1.1220	29,000	1.1417	4,4	60	32	7	364.013
KSEM290R3WN32M	KSEM290R5WN32M	29,000	1.1417	29,500	1.1614	4,5	60	32	7	364.013
KSEM295R3WN32M	KSEM295R5WN32M	29,500	1.1614	30,000	1.1811	4,5	60	32	7	364.013
KSEM300R3WN32M	KSEM300R5WN32M	30,000	1.1811	30,000	1.1811	4,6	60	32	7	364.013
–	KSEM301R5WN32M	30,010	1.1815	30,500	1.2008	4,6	60	32	8	364.013
KSEM305R3WN32M	KSEM305R5WN32M	30,500	1.2008	31,000	1.2205	4,7	60	32	8	364.013
KSEM310R3WN32M	KSEM310R5WN32M	31,000	1.2205	31,500	1.2402	4,8	60	32	8	364.013
KSEM315R3WN32M	KSEM315R5WN32M	31,500	1.2402	32,000	1.2598	4,8	60	32	8	364.013
KSEM320R3WN32M	KSEM320R5WN32M	32,000	1.2598	32,000	1.2598	4,9	60	32	8	364.013
KSEM321R3WD50M	KSEM321R5WD50M	32,010	1.2602	33,000	1.2992	4,9	68	50	9	364.015
KSEM330R3WD50M	KSEM330R5WD50M	33,000	1.2992	34,000	1.3386	5,1	68	50	9	364.015
KSEM340R3WD50M	KSEM340R5WD50M	34,000	1.3386	35,000	1.3780	5,2	68	50	9	364.015
KSEM350R3WD50M	KSEM350R5WD50M	35,000	1.3780	36,000	1.4173	5,4	68	50	9	364.015
KSEM360R3WD50M	KSEM360R5WD50M	36,000	1.4173	36,000	1.4173	5,5	68	50	9	364.015
KSEM361R3WD50M	KSEM361R5WD50M	36,010	1.4177	37,000	1.4567	5,5	68	50	10	364.015
KSEM370R3WD50M	KSEM370R5WD50M	37,000	1.4567	38,000	1.4961	5,7	68	50	10	364.015
KSEM380R3WD50M	KSEM380R5WD50M	38,000	1.4961	39,000	1.5354	5,8	68	50	10	364.015
KSEM390R3WD50M	KSEM390R5WD50M	39,000	1.5354	40,000	1.5748	6,0	68	50	10	364.015
KSEM400R3WD50M	KSEM400R5WD50M	40,000	1.5748	40,000	1.5748	6,2	68	50	10	364.015

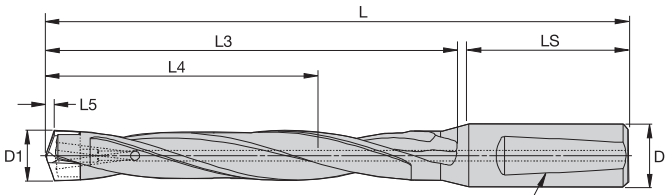


KSEM WD40 Shank • 3 x D/5 x D • Metric

3 x D	5 x D	D1 mm	D1 in	L5	LS	D	seat size	central lock screw
KSEM321R3WD40M	KSEM321R5WD40M	32,010	1.2602	5,6	68	40	9	364.015
KSEM330R3WD40M	KSEM330R5WD40M	33,000	1.2992	5,8	68	40	9	364.015
KSEM340R3WD40M	KSEM340R5WD40M	34,000	1.3386	6,0	68	40	9	364.015
KSEM350R3WD40M	KSEM350R5WD40M	35,000	1.3780	6,1	68	40	9	364.015
KSEM360R3WD40M	KSEM360R5WD40M	36,000	1.4173	6,3	68	40	9	364.015
KSEM361R3WD40M	KSEM361R5WD40M	36,010	1.4177	6,3	68	40	10	364.015
KSEM370R3WD40M	KSEM370R5WD40M	37,000	1.4567	6,5	68	40	10	364.015
KSEM380R3WD40M	KSEM380R5WD40M	38,000	1.4961	6,7	68	40	10	364.015
KSEM390R3WD40M	KSEM390R5WD40M	39,000	1.5354	6,9	68	40	10	364.015
KSEM400R3WD40M	KSEM400R5WD40M	40,000	1.5748	7,0	68	40	10	364.015

- Use designated insert blade with each drill body.
- For alternatives, see insert blade fitment chart on page H68–H69.
- Drill shipped with central lock screw, wrench, and side pipe plug.
- Order insert blade separately; see pages H38–H57.





for diameter <16mm DIN 6535 — HE
for diameter >16mm DIN 1835 part 1 form E

For information on L, L3, and L4 max, see the Modular Drills Dimension Tables on page H72–H73.



KSEM WN Shank • 7 x D/10 x D • Metric

7 x D	10 x D	D1 mm	D1 in	D1 max mm	D1 max in	L5	LS	D	seat size	central lock screw
KSEM125R7WN16M	**KSEM125R10WN16M**	12,500	.4921	13,000	.5118	2,0	48	16	C	**364.017**
KSEM130R7WN16M	**KSEM130R10WN16M**	13,000	.5118	13,500	.5314	2,1	48	16	C	**364.017**
KSEM135R7WN16M	**KSEM135R10WN16M**	13,500	.5315	13,500	.5314	2,1	48	16	C	**364.017**
KSEM136R7WN16M	**KSEM136R10WN16M**	13,510	.5319	14,000	.5512	2,2	48	16	B	**364.016**
KSEM140R7WN16M	**KSEM140R10WN16M**	14,000	.5512	14,500	.5708	2,2	48	16	B	**364.016**
KSEM145R7WN20M	**KSEM145R10WN20M**	14,500	.5709	14,500	.5708	2,3	50	20	B	**364.016**
KSEM146R7WN20M	**KSEM146R10WN20M**	14,510	.5713	15,000	.5906	2,3	50	20	A	**364.016**
KSEM150R7WN20M	**KSEM150R10WN20M**	15,000	.5906	15,500	.6102	2,4	50	20	A	**364.016**
KSEM155R7WN20M	**KSEM155R10WN20M**	15,500	.6102	15,874	.6249	2,5	50	20	A	**364.016**
KSEM160R7WN20M	**KSEM160R10WN20M**	16,000	.6299	16,500	.6496	2,5	50	20	1	**364.010**
KSEM165R7WN20M	**KSEM165R10WN20M**	16,500	.6496	17,000	.6693	2,6	50	20	1	**364.010**
KSEM170R7WN20M	**KSEM170R10WN20M**	17,000	.6693	17,500	.6890	2,7	50	20	1	**364.010**
KSEM175R7WN20M	**KSEM175R10WN20M**	17,500	.6890	18,000	.7086	2,8	50	20	1	**364.010**
KSEM180R7WN20M	**KSEM180R10WN20M**	18,000	.7087	18,000	.7086	2,9	50	20	1	**364.010**
—	**KSEM181R10WN25M**	18,010	.7091	18,500	.7283	2,9	56	25	2	**364.010**
KSEM185R7WN25M	**KSEM185R10WN25M**	18,500	.7283	19,000	.7480	2,9	56	25	2	**364.010**
KSEM190R7WN25M	**KSEM190R10WN25M**	19,000	.7480	19,500	.7677	3,0	56	25	2	**364.010**
KSEM195R7WN25M	**KSEM195R10WN25M**	19,500	.7677	19,999	.7873	3,1	56	25	2	**364.010**
KSEM200R7WN25M	**KSEM200R10WN25M**	20,000	.7874	20,500	.8071	3,2	56	25	3	**364.011**
KSEM205R7WN25M	**KSEM205R10WN25M**	20,500	.8071	21,000	.8268	3,3	56	25	3	**364.011**
KSEM210R7WN25M	**KSEM210R10WN25M**	21,000	.8268	21,500	.8465	3,3	56	25	3	**364.011**
KSEM215R7WN25M	**KSEM215R10WN25M**	21,500	.8465	22,000	.8661	3,4	56	25	3	**364.011**
KSEM220R7WN25M	**KSEM220R10WN25M**	22,000	.8661	22,000	.8661	3,5	56	25	3	**364.011**
—	**KSEM221R10WN25M**	22,010	.8665	22,500	.8858	3,5	56	25	4	**364.011**
KSEM225R7WN25M	**KSEM225R10WN25M**	22,500	.8858	23,000	.9055	3,6	56	25	4	**364.011**
KSEM230R7WN25M	**KSEM230R10WN25M**	23,000	.9055	23,500	.9252	3,7	56	25	4	**364.011**
KSEM235R7WN25M	**KSEM235R10WN25M**	23,500	.9252	24,000	.9448	3,7	56	25	4	**364.011**
KSEM240R7WN25M	**KSEM240R10WN25M**	24,000	.9449	24,000	.9448	3,8	56	25	4	**364.011**
—	**KSEM241R10WN32M**	24,010	.9453	24,500	.9646	3,8	60	32	5	**364.012**
KSEM245R7WN32M	**KSEM245R10WN32M**	24,500	.9646	25,000	.9843	3,9	60	32	5	**364.012**
KSEM250R7WN32M	**KSEM250R10WN32M**	25,000	.9843	25,500	1.0039	3,8	60	32	5	**364.012**
KSEM255R7WN32M	**KSEM255R10WN32M**	25,500	1.0039	26,000	1.0236	3,9	60	32	5	**364.012**

(continued)

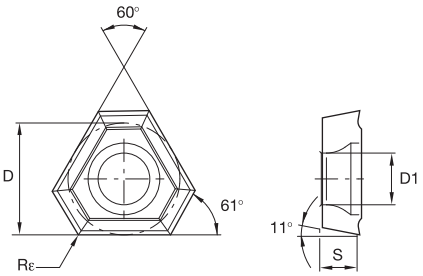
(KSEM WN Shank • 7 x D/10 x D • Metric — continued)

		D1		D1 max						
7 x D	10 x D	mm	in	mm	in	L5	LS	D	seat size	central lock screw
KSEM260R7WN32M	**KSEM260R10WN32M**	26,000	1.0236	26,000	1.0236	4,0	60	32	5	**364.012**
–	**KSEM261R10WN32M**	26,010	1.0240	26,500	1.0433	4,0	60	32	6	**364.012**
KSEM265R7WN32M	**KSEM265R10WN32M**	26,500	1.0433	27,000	1.0630	4,1	60	32	6	**364.012**
KSEM270R7WN32M	**KSEM270R10WN32M**	27,000	1.0630	27,500	1.0827	4,2	60	32	6	**364.012**
KSEM275R7WN32M	**KSEM275R10WN32M**	27,500	1.0827	28,000	1.1023	4,2	60	32	6	**364.012**
KSEM280R7WN32M	**KSEM280R10WN32M**	28,000	1.1024	28,000	1.1023	4,3	60	32	6	**364.012**
–	**KSEM281R10WN32M**	28,016	1.1030	28,500	1.1220	4,3	60	32	7	**364.013**
KSEM285R7WN32M	**KSEM285R10WN32M**	28,500	1.1220	29,000	1.1417	4,4	60	32	7	**364.013**
KSEM290R7WN32M	**KSEM290R10WN32M**	29,000	1.1417	29,500	1.1614	4,5	60	32	7	**364.013**
KSEM295R7WN32M	**KSEM295R10WN32M**	29,500	1.1614	30,000	1.1811	4,5	60	32	7	**364.013**
KSEM300R7WN32M	**KSEM300R10WN32M**	30,000	1.1811	30,000	1.1811	4,6	60	32	7	**364.013**
–	**KSEM301R10WN32M**	30,010	1.1815	30,500	1.2008	4,6	60	32	8	**364.013**
KSEM305R7WN32M	**–**	30,500	1.2008	31,000	1.2205	4,7	60	32	8	**364.013**
KSEM310R7WN32M	**KSEM310R10WN32M**	31,000	1.2205	31,500	1.2402	4,8	60	32	8	**364.013**
KSEM315R7WN32M	**–**	31,500	1.2402	32,000	1.2598	4,8	60	32	8	**364.013**
KSEM320R7WN32M	**KSEM320R10WN32M**	32,000	1.2598	32,000	1.2598	4,9	60	32	8	**364.013**

KSEM Chamfering Solutions

- Drilling and chamfering in one operation.
- No height adjustment required.
- Low setup time.
- Use standard inserts.
- Tool bodies available as standard.





● first choice
○ alternate choice

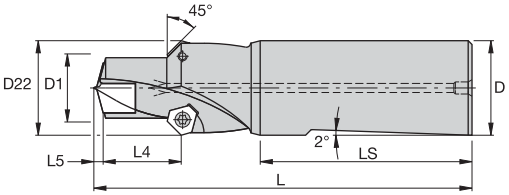
P			●	○
M		●	○	○
K			○	●
N		○	●	○
S			○	●
H				

TPGX-GD Geometry

catalogue number	D	S	Rε	D1	KC7015	KC7315	KC7140
TPGX0902ZPRGD	5,56	2,38	0,20	2,50	●	●	●
TPGX1102ZPRGD	6,35	2,38	0,20	2,85	●	●	●
TPGX1303ZPRGD	7,94	3,18	0,20	3,40	●	●	●
TPGX1603ZPRGD	9,52	3,18	0,20	4,40	●	●	●

- Use any KSEM insert blade diameter within the designated seat size.
- Drill shipped with central lock screw, insert screw, and wrenches.
- Order insert blades separately; see pages H38–H57.
- Order TPGX chamfering insert separately; see page H63.



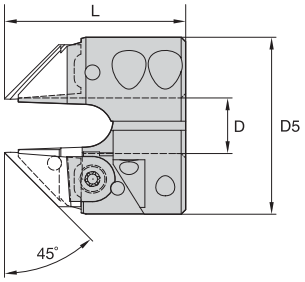




KSEM Bodies • WN/WD50 Shank with Chamfer • 1 x D • Metric

1 x D	D1 mm	D1 in	D1 max mm	D1 max in	D22	L	L4 max	L5	LS	D	seat size	chamfer insert	central lock screw	wrench
KSEM125R1WN16F45M	12,500	.4921	13,500	.5314	18	107	14	2,0	48,0	16	C	KSEM1250	**364.017**	**170.051**
KSEM136R1WN16F45M	13,510	.5319	14,500	.5708	19	107	15	2,2	48,0	16	B	KSEM1351	**364.016**	**170.289**
KSEM146R1WN20F45M	14,510	.5713	15,874	.6249	20	109	16	2,3	50,0	20	A	KSEM1451	**364.016**	**170.289**
KSEM160R1WN20F45M	16,000	.6299	18,000	.7086	22	110	18	2,5	50,0	20	1	KSEM1600	**364.010**	**170.270**
KSEM181R1WN25F45M	18,010	.7091	19,999	.7873	25	118	20	2,9	56,0	25	2	KSEM1801	**364.010**	**170.270**
KSEM200R1WN25F45M	20,000	.7874	22,000	.8661	28	120	22	3,2	56,0	25	3	KSEM2000	**364.011**	**170.272**
KSEM221R1WN25F45M	22,010	.8665	24,000	.9448	30	123	24	3,5	56,0	25	4	KSEM2201	**364.011**	**170.272**
KSEM241R1WN32F45M	24,010	.9453	26,000	1.0236	34	129	26	3,8	60,0	32	5	KSEM2401	**364.012**	**170.055**
KSEM261R1WN32F45M	26,010	1.0240	28,000	1.1023	36	131	28	4,0	60,0	32	6	KSEM2601	**364.012**	**170.055**
KSEM281R1WN32F45M	28,016	1.1030	30,000	1.1811	38	134	30	4,3	60,0	32	7	KSEM2801	**364.013**	**170.276**
KSEM301R1WN32F45M	30,010	1.1815	32,000	1.2598	40	136	32	4,6	60,0	32	8	KSEM3001	**364.013**	**170.276**
KSEM321R1WD50F45M	32,010	1.2602	36,000	1.4173	42	155	36	4,9	68,0	50	9	KSEM3201	**364.015**	**170.276**
KSEM361R1WD50F45M	36,010	1.4177	40,000	1.5748	46	165	40	5,5	68,0	50	10	KSEM3601	**364.015**	**170.276**

- The NEW chamfering rings for KSEM are available in a diameter range of 12,5–32mm.
- The KSEM SEF ring is double-edged, features a more rigid design to withstand high feed rates, and reduces time-consuming deburring and small chamfer operations.
- Reduce machining time — combine drilling and chamfering in one operation.
- Short-term availability — standard tooling off-the-shelf — KSEM body and inserts, SEF ring, and SEFAS™ inserts.
- Flexibility — adjustable drilling depth.
- For speed and feed recommendations, please refer to catalogue recommendations based on geometry and tool body length of the carrying KSEM tool.
- Small chamfers up to 1mm do not need further feed reduction.
- At deeper chamfers, a feed rate reduction of 50% is highly recommended to avoid vibrations and movement of the ring during operation.
- For inserts, please refer to SEFAS System.

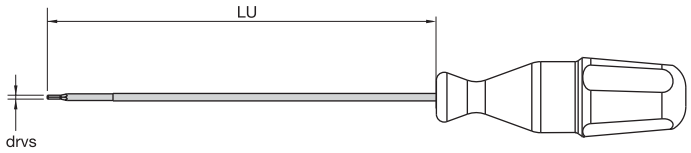


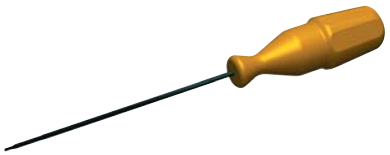


KSEM Chamfer Rings

	D		L		D5					
catalogue number	mm	in	mm	in	mm	in	clamp assembly	chip deflector	chip deflector screw	drill clamp screw
KSEM125SEFM	12,5	.4921	40	1.57	39	1.54	**360.551**	**360.660**	**128.508**	**191.726**
KSEM130SEFM	13,0	.5118	40	1.57	39	1.54	**360.551**	**360.660**	**128.508**	**191.726**
KSEM135SEFM	13,5	.5315	40	1.57	39	1.54	**360.551**	**360.660**	**128.508**	**191.726**
KSEM140SEFM	14,0	.5512	40	1.57	40	1.57	**360.551**	**360.661**	**128.508**	**199.123**
KSEM145SEFM	14,5	.5709	40	1.57	40	1.57	**360.551**	**360.661**	**128.508**	**199.123**
KSEM150SEFM	15,0	.5906	40	1.57	40	1.57	**360.551**	**360.662**	**128.508**	**199.123**
KSEM155SEFM	15,5	.6102	40	1.57	40	1.57	**360.551**	**360.662**	**128.508**	**199.123**
KSEM160SEFM	16,0	.6299	42	1.65	43	1.69	**360.551**	**360.663**	**128.508**	**199.123**
KSEM165SEFM	16,5	.6496	42	1.65	43	1.69	**360.551**	**360.663**	**128.508**	**199.123**
KSEM170SEFM	17,0	.6693	42	1.65	43	1.69	**360.551**	**360.663**	**128.508**	**199.123**
KSEM175SEFM	17,5	.6890	42	1.65	43	1.69	**360.551**	**360.663**	**128.508**	**199.123**
KSEM180SEFM	18,0	.7087	42	1.65	43	1.69	**360.551**	**360.663**	**128.508**	**199.123**
KSEM185SEFM	18,5	.7283	42	1.65	43	1.69	**360.551**	**360.664**	**128.508**	**199.123**
KSEM190SEFM	19,0	.7480	42	1.65	43	1.69	**360.551**	**360.664**	**128.508**	**199.123**
KSEM195SEFM	19,5	.7677	42	1.65	43	1.69	**360.551**	**360.664**	**128.508**	**199.123**
KSEM200SEFM	20,0	.7874	48	1.89	50	1.97	**360.551**	**360.665**	**128.510**	**199.123**
KSEM205SEFM	20,5	.8071	48	1.89	50	1.97	**360.551**	**360.665**	**128.510**	**199.123**
KSEM210SEFM	21,0	.8268	48	1.89	50	1.97	**360.551**	**360.665**	**128.510**	**199.123**
KSEM215SEFM	21,5	.8465	48	1.89	50	1.97	**360.551**	**360.665**	**128.510**	**199.123**
KSEM220SEFM	22,0	.8661	48	1.89	50	1.97	**360.551**	**360.665**	**128.510**	**199.123**
KSEM225SEFM	22,5	.8858	50	1.97	50	1.97	**360.551**	**360.666**	**128.510**	**–**
KSEM230SEFM	23,0	.9055	50	1.97	50	1.97	**360.551**	**360.666**	**128.510**	**–**
KSEM235SEFM	23,5	.9252	50	1.97	50	1.97	**360.551**	**360.666**	**128.510**	**–**
KSEM240SEFM	24,0	.9449	50	1.97	50	1.97	**360.551**	**360.666**	**128.510**	**–**
KSEM245SEFM	24,5	.9646	54	2.13	55	2.17	**360.551**	**360.667**	**128.510**	**–**
KSEM250SEFM	25,0	.9843	54	2.13	55	2.17	**360.551**	**360.667**	**128.510**	**–**
KSEM255SEFM	25,5	1.0039	54	2.13	55	2.17	**360.551**	**360.667**	**128.510**	**–**
KSEM260SEFM	26,0	1.0236	54	2.13	55	2.17	**360.551**	**360.667**	**128.510**	**–**
KSEM265SEFM	26,5	1.0433	56	2.20	55	2.17	**360.551**	**360.668**	**128.510**	**–**
KSEM270SEFM	27,0	1.0630	56	2.20	55	2.17	**360.551**	**360.668**	**128.510**	**–**
KSEM275SEFM	27,5	1.0827	56	2.20	55	2.17	**360.551**	**360.668**	**128.510**	**–**
KSEM280SEFM	28,0	1.1024	56	2.20	55	2.17	**360.551**	**360.668**	**128.510**	**–**
KSEM285SEFM	28,5	1.1220	61	2.40	60	2.36	**360.551**	**360.669**	**128.510**	**–**
KSEM290SEFM	29,0	1.1417	61	2.40	60	2.36	**360.551**	**360.669**	**128.510**	**–**
KSEM295SEFM	29,5	1.1614	61	2.40	60	2.36	**360.551**	**360.669**	**128.510**	**–**
KSEM300SEFM	30,0	1.1811	61	2.40	60	2.36	**360.551**	**360.669**	**128.510**	**–**
KSEM305SEFM	30,5	1.2008	61	2.40	60	2.36	**360.551**	**360.670**	**128.510**	**–**
KSEM310SEFM	31,0	1.2205	61	2.40	60	2.36	**360.551**	**360.670**	**128.510**	**–**
KSEM315SEFM	31,5	1.2402	61	2.40	60	2.36	**360.551**	**360.670**	**128.510**	**–**
KSEM320SEFM	32,0	1.2598	61	2.40	60	2.36	**360.551**	**360.670**	**128.510**	**–**

NOTE: Order inserts separately; see the SEFAS system on page I27.



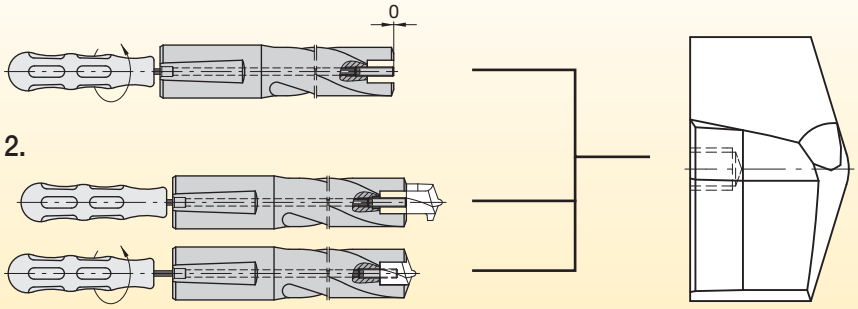


KSEM Wrenches

order number	catalogue number	central lock screw D1<32mm	central lock screw D1≥32mm	DRVS	LU mm	LU in
1126021	**170.270**	364.010	–	1.5 mm	185,00	7
1126032	**170.271**	364.010	–	1.5 mm	225,00	9
1510773	**170.281**	364.010	–	1.5 mm	297,00	12
1255899	**170.285**	364.010	–	1.5 mm	351,00	14
1126040	**170.272**	364.011	–	2 mm	210,00	8
1126049	**170.273**	364.011	–	2 mm	260,00	10
1510776	**170.282**	364.011	–	2 mm	343,00	14
1255900	**170.286**	364.011	–	2 mm	405,00	16
1126066	**170.274**	364.012	–	2.5 mm	240,00	9
1126072	**170.275**	364.012	–	2.5 mm	295,00	12
1510779	**170.283**	364.012	–	2.5 mm	393,00	15
1255901	**170.287**	364.012	–	2.5 mm	459,00	18
1126079	**170.276**	364.101	364.015	3 mm	265,00	10
1126088	**170.277**	364.101	364.015	3 mm	330,00	13
1510781	**170.284**	364.101	364.015	3 mm	439,00	17
1255902	**170.288**	364.101	364.015	3 mm	513,00	20
1834819	**170.294**	364.017	–	T5	156,00	6
1836470	**170.295**	364.017	–	T5	188,00	7
1836471	**170.296**	364.017	–	T5	290,00	11
1795811	**170.289**	364.016	–	T6	156,00	6
1795956	**170.290**	364.016	–	T6	188,00	7
1795960	**170.291**	364.016	–	T6	290,00	11

Mounting the Inserts

1.



Inserts (<32mm) without Connector Pin

1) Use the screwdriver to set the threaded pin:
   - For inserts up to Ø 32mm, flush with the drill face.
   - For inserts bigger Ø 32mm, set 2mm below the drill face.

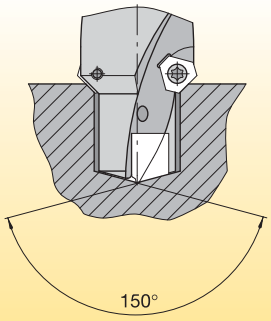
2) Tighten the insert using the screwdriver to fit securely in the insert seat.

To change the insert, turn the clamping screw anti-clockwise until the insert is released.

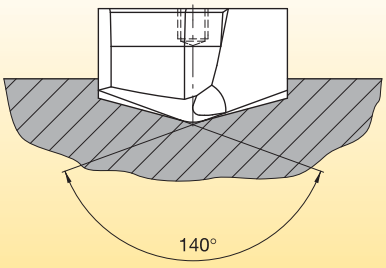
Repair of Damaged Threaded Pin

In the event that the central threaded pin becomes damaged, it can be removed after severing it in the tool body. To do this, drill beneath the insert seat in the tool body. The insert and threaded pin can then be removed. For information regarding the position and diameter of this repair hole, please refer to the manual (sheet **290.001 D/GB**) supplied with the tool body.

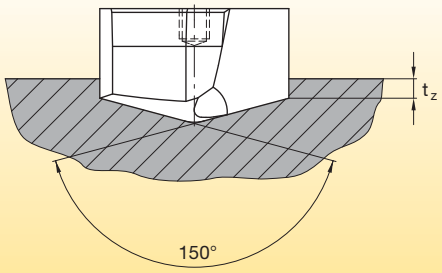
NOTE: For inserts without a connector pin, avoid jamming during mounting through precise positioning.



Pre-centring with FAS centring tool



HP inserts of the follower drill



Centring using PC inserts

Why is pre-centring necessary?

- Generally speaking, for drilling depths 5x the nominal diameter and above (5 x D).
- In unstable conditions (workpiece and tool clamping).

Why pre-centre using PC inserts?

- Soft-cut entry of follower drill due to 150° point angle of the PC insert.
- No extension of the follower drill in the entry area.
- Prevent chipping and breaking on the cutting edges.
- To avoid deflection, it is recommended to pre-centre with PC inserts using toolholders as short as possible (1 x D).

What happens if...
...a centre cannot be used for technical reasons?

- Spot drill with normal insert at normal and reduced cutting data (approximately 1/2 vc and approximately 1/2 vf), then continue drilling with regular cutting data without lifting off/stopping.

...there is no suitable PC cutting insert in the standard range (ø)?

- Use a made-to-order PC insert with k7 tolerance in the required nominal diameter.

OR

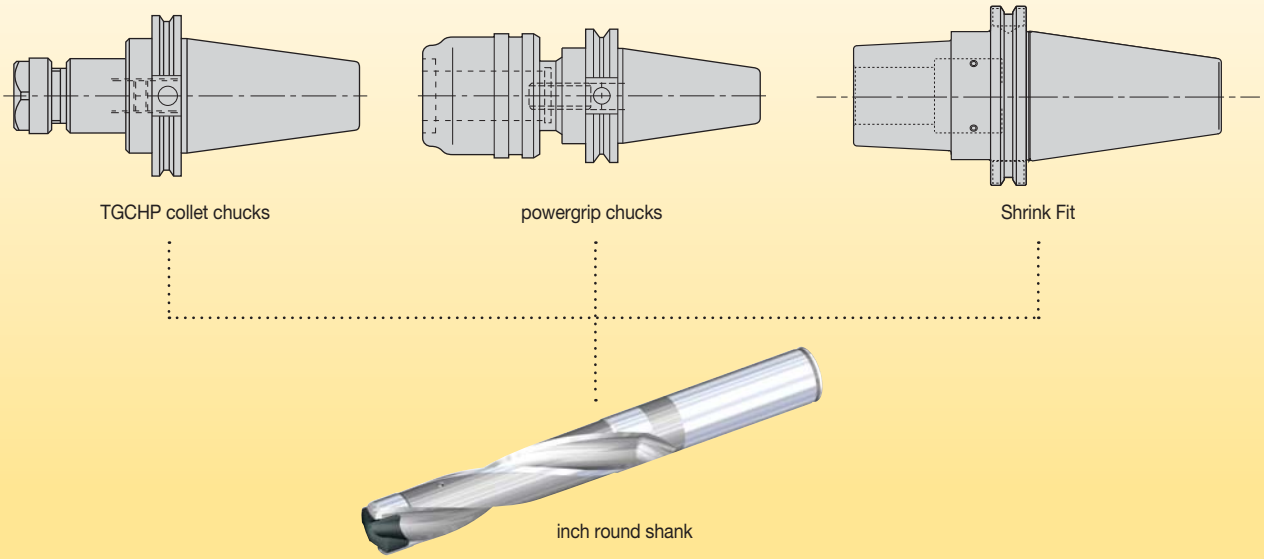
- Pre-centre, using the same cutting insert as used for the follower drill but without the cutting edges penetrating the workpiece (spot drill ø approximately 90% of drill ø D1).

...only one tool body is required?

- Enter the workpiece with 50% feed until the cutting edges and the heels have penetrated the hole, then continue drilling without lifting off/stopping using regular cutting data.

Rotating Applications

KSEM inch drills with round shanks (no flats) are specifically designed for rotating applications where the drill rotates and the workpiece remains stationary. The shank to drill-point location of these drills is held to an extremely close tolerance. To maintain accuracy, and get maximum performance from the KSEM drill, use only the approved toolholding method shown below.



TGCHP collet chucks | powergrip chucks | Shrink Fit

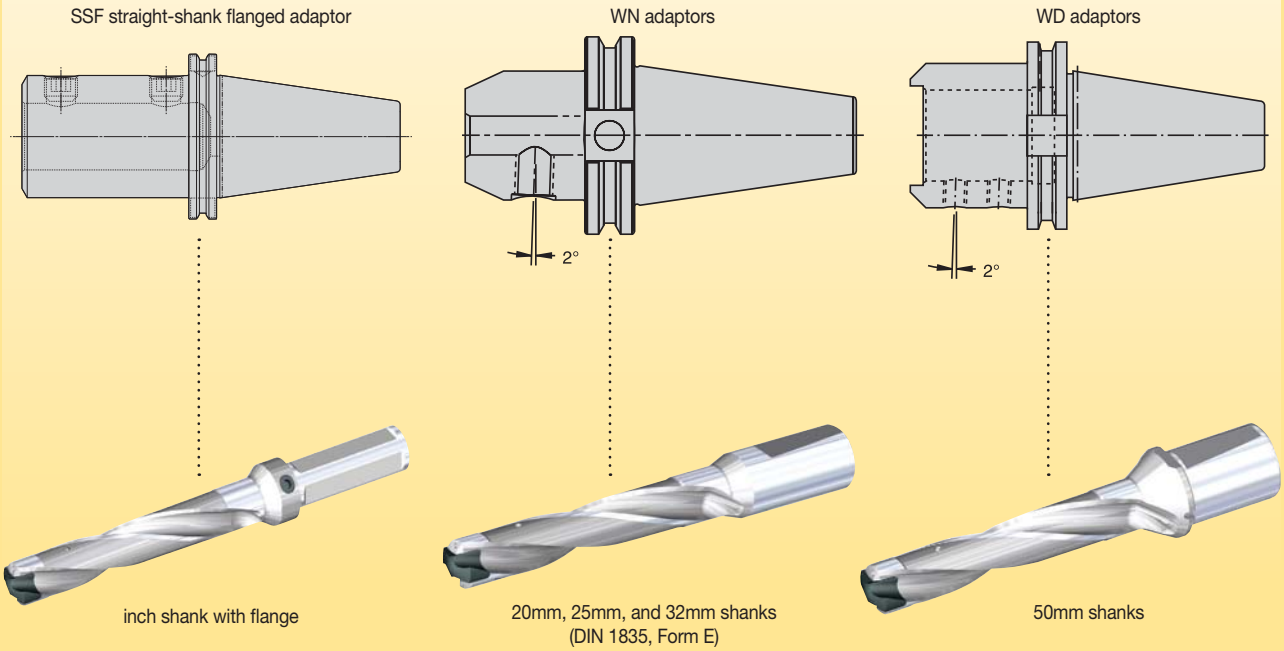
inch round shank

Inch Drill Bodies with Flange

KSEM inch drills with a flange can be used in rotating applications where the drill rotates and the workpiece remains stationary. To maintain accuracy and get maximum performance from the drill, use only the approved toolholding method shown here.

Metric Drill Bodies with a 2° Whistle Notch

KSEM metric drills come equipped with 2° Whistle Notch shanks. The 20mm, 25mm, and 32mm diameter shanks use WN adaptors. The 50mm shank uses a WD adaptor. Choose the correct adaptor to minimise runout and securely hold the drill.



SSF straight-shank flanged adaptor | WN adaptors | WD adaptors

inch shank with flange

20mm, 25mm, and 32mm shanks
(DIN 1835, Form E)

50mm shanks

Insert blades may be used, within limits, on different drill bodies. The insert blade must be of the same seat size. Overhang (see Figure 1) must be kept under 0,250mm (.0098") per side. For best drilling performance, rigidity, and efficient chip evacuation, always use the first-choice steel body. Performance may be compromised by using alternatives. In some applications, chips may bind between the drill body and the hole wall — especially when machining long-chipping materials like austenitic stainless steel and low-carbon steel.

(does not apply to stub length drills)

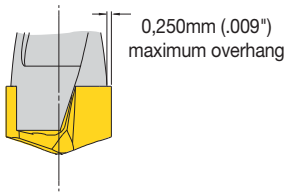


Figure 1

diameter D

inch	mm	insert blade	seat size	first choice	alternate body 1	alternate body 2	alternate body 3	alternate body 4
.492	12,50	KSEM1250	C	KSEM125..M	–	–	–	–
.500	12,70	KSEM0500	C	KSEM0500..	KSEM125..M	–	–	–
.509	12,93	KSEM0509	C	KSEM0509..	KSEM0500..	KSEM125..M	–	–
.512	13,00	KSEM1300	C	KSEM130..M	KSEM0509..	KSEM0500..	KSEM125..M	–
.516	13,10	KSEM0516	C	KSEM0516..	KSEM130..M	KSEM0509..	KSEM0500..	–
.531	13,50	KSEM1350	C	KSEM135..M	KSEM0531..	KSEM0516..	KSEM130..M	–
.547	13.89	KSEM0547	B	KSEM0547..	KSEM136..M	–	–	–
.551	14,00	KSEM1400	B	KSEM140..M	KSEM136..M	KSEM0547..	–	–
.563	14,29	KSEM0563	B	KSEM0563..	KSEM140..M	KSEM0547..	–	–
.571	14,50	KSEM1450	B	KSEM145..M	KSEM0563..	KSEM140..M	–	–
.578	14,68	KSEM0578	A	KSEM0578..	KSEM146..M	–	–	–
.591	15,00	KSEM1500	A	KSEM150..M	KSEM146..M	KSEM0578..	–	–
.594	15,08	KSEM0594	A	KSEM0594..	KSEM150..M	KSEM0578..	–	–
.609	15,48	KSEM0609	A	KSEM0609..	KSEM0594..	KSEM150..M	–	–
.610	15,50	KSEM1550	A	KSEM155..M	KSEM0609..	KSEM0594..	KSEM150..M	–
.625	15,88	KSEM0625	1	KSEM0625..	–	–	–	–
.630	16,00	KSEM1600	1	KSEM160..M	KSEM0625..	–	–	–
.634	16,09	KSEM0634	1	KSEM0634..	KSEM160..M	KSEM0625..	–	–
.641	16,27	KSEM0641	1	KSEM0641..	KSEM0634..	KSEM160..M	KSEM0625..	–
.650	16,50	KSEM1650	1	KSEM165..M	KSEM0641..	KSEM0634..	–	–
.656	16,67	KSEM0656	1	KSEM0656..	KSEM165..M	KSEM0641..	–	–
.669	17,00	KSEM1700	1	KSEM170..M	KSEM0656..	KSEM165..M	–	–
.672	17,07	KSEM0672	1	KSEM0672..	KSEM170..M	KSEM0656..	–	–
.688	17,46	KSEM0688	1	KSEM0688..	KSEM0672..	KSEM170..M	–	–
.689	17,50	KSEM1750	1	KSEM175..M	KSEM0688..	KSEM0672..	KSEM170..M	–
.700	17,78	KSEM0700	1	N/A	KSEM175..M	KSEM0688..	–	–
.703	17,86	KSEM0703	1	KSEM0703..	KSEM175..M	KSEM0688..	–	–
.709	18,00	KSEM1800	1	KSEM180..M	KSEM0703..	KSEM175..M	–	–
.719	18,26	KSEM0719	2	KSEM0719..	KSEM181..M	–	–	–
.728	18,50	KSEM1850	2	KSEM185..M	KSEM0719..	KSEM181..M	–	–
.734	18,65	KSEM0734	2	KSEM0734..	KSEM185..M	KSEM0719..	–	–
.748	19,00	KSEM1900	2	KSEM190..M	KSEM0734..	KSEM185..M	–	–
.750	19,05	KSEM0750	2	KSEM0750..	KSEM190..M	KSEM0734..	–	–
.759	19,27	KSEM0759	2	KSEM0759..	KSEM0750..	KSEM190..M	–	–
.766	19,45	KSEM0766	2	KSEM0766..	KSEM0759..	KSEM0750..	KSEM190..M	–
.768	19,50	KSEM1950	2	KSEM195..M	KSEM0766..	KSEM0759..	KSEM0750..	KSEM190..M
.781	19,84	KSEM0781	2	KSEM0781..	KSEM195..M	KSEM0766..	–	–
.787	20,00	KSEM2000	3	KSEM200..M	–	–	–	–
.797	20,24	KSEM0797	3	KSEM0797..	KSEM200..M	–	–	–
.800	20,32	KSEM0800	3	N/A	KSEM0797..	KSEM200..M	–	–
.807	20,50	KSEM2050	3	KSEM205..M	KSEM0797..	KSEM200..M	–	–
.813	20,64	KSEM0813	3	KSEM0813..	KSEM205..M	KSEM0797..	–	–
.827	21,00	KSEM2100	3	KSEM210..M	KSEM0813..	KSEM205..M	–	–
.844	21,43	KSEM0844	3	KSEM0844..	KSEM210..M	–	–	–
.847	21,50	KSEM2150	3	KSEM215..M	KSEM0844..	KSEM210..M	–	–
.859	21,83	KSEM0859	3	KSEM0859..	KSEM215..M	KSEM0844..	–	–
.866	22,00	KSEM2200	3	KSEM220..M	KSEM0859..	KSEM215..M	–	–
.875	22,23	KSEM0875	4	KSEM0875..	KSEM221..M	–	–	–
.884	22,44	KSEM0884	4	KSEM0884..	KSEM0875..	KSEM221..M	–	–
.886	22,50	KSEM2250	4	KSEM225..M	KSEM0884..	KSEM0875..	KSEM221..M	–
.906	23,00	KSEM2300	4	KSEM230..M	KSEM0906..	KSEM225..M	–	–
.922	23,42	KSEM0922	4	KSEM0922..	KSEM230..M	–	–	–
.925	23,50	KSEM2350	4	KSEM235..M	KSEM0922..	KSEM230..M	–	–
.938	23,81	KSEM0938	4	KSEM0938..	KSEM235..M	KSEM0922..	–	–
.945	24,00	KSEM2400	4	KSEM240..M	KSEM0938..	KSEM235..M	–	–

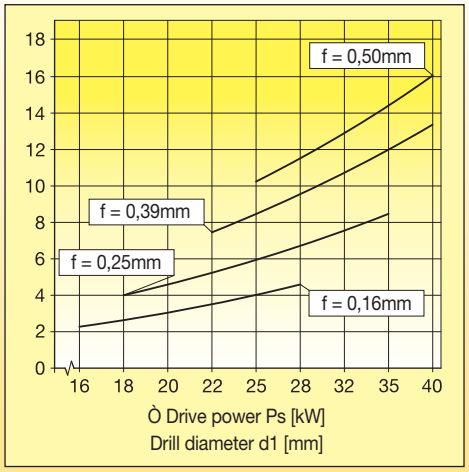
(continued)

(continued)

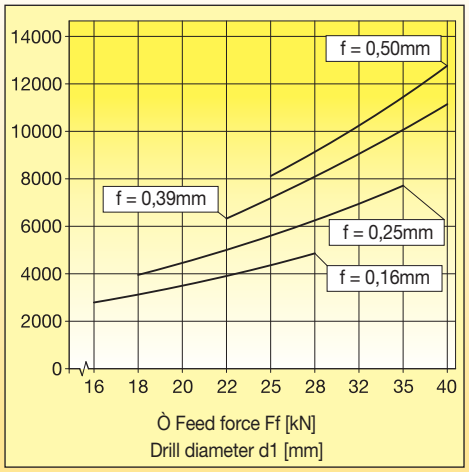
diameter D

inch	mm	insert blade	seat size	first choice	alternate body 1	alternate body 2	alternate body 3	alternate body 4
.965	24,50	KSEM2450	5	KSEM245..M	KSEM241..M	–	–	–
.969	24,61	KSEM0969	5	KSEM0969..	KSEM245..M	–	–	–
.984	25,00	KSEM2500	5	KSEM250..M	KSEM0984..	KSEM0969..	KSEM245..M	–
1.000	25,40	KSEM1000	5	KSEM1000..	KSEM250..M	–	–	–
1.004	25,50	KSEM2550	5	KSEM255..M	KSEM1000..	KSEM250..M	–	–
1.011	25,67	KSEM1011	5	KSEM1011..	KSEM255..M	–	–	–
1.024	26,00	KSEM2600	5	KSEM260..M	KSEM1011..	KSEM255..M	–	–
1.031	26,19	KSEM1031	6	KSEM1031..	KSEM261..M	–	–	–
1.043	26,50	KSEM2650	6	KSEM265..M	KSEM1031..	KSEM261..M	–	–
1.047	26,59	KSEM1047	6	KSEM1047..	KSEM265..M	KSEM1031..	KSEM261..M	–
1.063	27,00	KSEM2700	6	KSEM270..M	KSEM1063..	KSEM1047..	KSEM265..M	–
1.083	27,50	KSEM2750	6	KSEM275..M	KSEM270..M	KSEM1063..	–	–
1.094	27,78	KSEM1094	6	KSEM1094..	KSEM275..M	–	–	–
1.102	28,00	KSEM2800	6	KSEM280..M	KSEM1094..	KSEM275..M	–	–
1.109	28,18	KSEM1109	7	KSEM1109..	KSEM281..M	–	–	–
1.122	28,50	KSEM2850	7	KSEM285..M	KSEM1109..	KSEM281..M	–	–
1.125	28,58	KSEM1125	7	KSEM1125..	KSEM285..M	KSEM1109..	KSEM281..M	–
1.142	29,00	KSEM2900	7	KSEM290..M	KSEM1125..	KSEM285..M	–	–
1.156	29,37	KSEM1156	7	KSEM1156..	KSEM290..M	–	–	–
1.161	29,50	KSEM2950	7	KSEM295..M	KSEM1156..	KSEM290..M	–	–
1.172	29,77	KSEM1172	7	KSEM1172..	KSEM295..M	KSEM1156..	–	–
1.181	30,00	KSEM3000	7	KSEM300..M	KSEM1172..	KSEM295..M	–	–
1.188	30,16	KSEM1188	8	KSEM1188..	KSEM301..M	–	–	–
1.201	30,50	KSEM3050	8	KSEM305..M	KSEM1188..	KSEM301..M	–	–
1.203	30,56	KSEM1203	8	KSEM1203..	KSEM305..M	KSEM1188..	KSEM301..M	–
1.219	30,96	KSEM1219	8	KSEM1219..	KSEM1203..	KSEM305..M	–	–
1.220	31,00	KSEM3100	8	KSEM310..M	KSEM1219..	KSEM1203..	KSEM305..M	–
1.240	31,50	KSEM3150	8	KSEM315..M	KSEM310..M	–	–	–
1.250	31,75	KSEM1250	8	KSEM1250..	KSEM315..M	–	–	–
1.260	32,00	KSEM3200	8	KSEM320..M	KSEM1250..	KSEM315..M	–	–
1.280	32,50	KSEM3250	9	–	KSEM321..M	–	–	–
1.281	32,54	KSEM1281	9	KSEM1281..	KSEM321..M	–	–	–
1.297	32,94	KSEM1297	9	KSEM1297..	KSEM1281..	–	–	–
1.299	33,00	KSEM3300	9	KSEM330..M	KSEM1297..	KSEM1281..	–	–
1.313	33,34	KSEM1313	9	KSEM1313..	KSEM330..M	KSEM1297..	–	–
1.319	33,50	KSEM3350	9	–	–	KSEM1313..	KSEM330..M	–
1.328	33,73	KSEM1328	9	KSEM1328..	KSEM1313..	–	–	–
1.339	34,00	KSEM3400	9	KSEM340..M	KSEM1328..	–	–	–
1.344	34,13	KSEM1344	9	KSEM1344..	KSEM340..M	KSEM1328..	–	–
1.358	34,50	KSEM3450	9	–	–	KSEM1344..	KSEM340..M	–
1.375	34,93	KSEM1375	9	KSEM1375..	–	–	–	–
1.378	35,00	KSEM3500	9	KSEM350..M	KSEM1375..	–	–	–
1.398	35,50	KSEM3550	9	–	–	KSEM350..M	–	–
1.406	35,72	KSEM1406	9	KSEM1406..	–	–	–	–
1.417	36,00	KSEM3600	9	KSEM360..M	KSEM1406..	–	–	–
1.422	36,12	KSEM1422	10	KSEM1422..	KSEM361..M	–	–	–
1.437	36,50	KSEM3650	10	–	–	KSEM1422..	KSEM361..M	–
1.438	36,51	KSEM1438	10	KSEM1438..	KSEM1422..	KSEM361..M	–	–
1.457	37,00	KSEM3700	10	KSEM370..M	KSEM1438..	–	–	–
1.469	37,31	KSEM1469	10	KSEM1469..	KSEM370..M	–	–	–
1.476	37,50	KSEM3750	10	–	–	KSEM1469..	KSEM370..M	–
1.496	38,00	KSEM3800	10	KSEM380..M	–	–	–	–
1.500	38,10	KSEM1500	10	KSEM1500..	KSEM380..M	–	–	–
1.514	38,46	KSEM1514	10	KSEM1514..	KSEM1500..	KSEM380..M	–	–
1.516	38,50	KSEM3850	10	–	–	KSEM1514..	KSEM1500..	KSEM380..M
1.535	39,00	KSEM3900	10	KSEM390..M	–	–	–	–
1.555	39,50	KSEM3950	10	–	–	KSEM390..M	–	–
1.575	40,00	KSEM4000	10	KSEM400..M	–	–	–	–

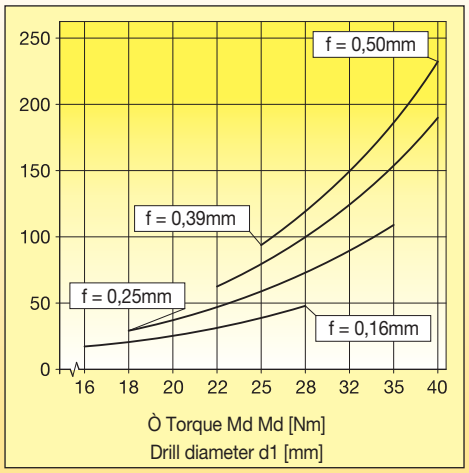
Drive Power (kW)



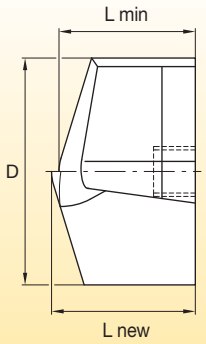
Feed Force (kN)



Torque (Nm)



NOTE: The diagrams above are used to determine the drive power, feed force, and torque. They are based on cutting force measurement in tempered steels in Cgr. 6. Tensile strength: Rm = 600 N/mm^2. The base cutting speed used is: vc = 80 m/min.



The following coolant pressure is recommended:

relative drilling depth	coolant pressure
1–3 x D	8 bars
5 x D	12 bars
7 x D	20 bars
10 x D	30 bars

insert seat size	diameter range D (mm)	L min. (mm)	L new (mm)
C	12,50–13,50	8,5	9,6
B	13,51–14,50	8,9	10,1
A	14,51–15,88	9,4	10,6
1	15,88–18,00	10,3	11,6
2	18,01–19,99	11,2	12,6
3	20,00–22,00	12,1	13,6
4	22,01–24,00	13,0	14,6
5	24,01–26,00	13,9	15,6
6	26,01–28,00	14,8	16,6
7	28,01–30,00	15,7	17,6
8	30,01–32,00	16,6	18,6
9	32,01–36,00	18,4	20,6
10	36,01–40,00	20,2	22,6

A Natural Fit…

Tube Sheet Finishing with Kennametal



Our advanced drilling and hole finishing solutions provide the performance and reliability you need to succeed in your challenging business. We offer a complete holemaking range for working with tube sheets, support baffles, and many other components.

RHR™ Reaming System

- For H7 fits in tube sheets.
- Very fast and economical with a replaceble head disc reamer.
- New KCU05 grade for a great finish and long tool life.

Find RHR Reamers on pages K24, K27–K28, and K36.

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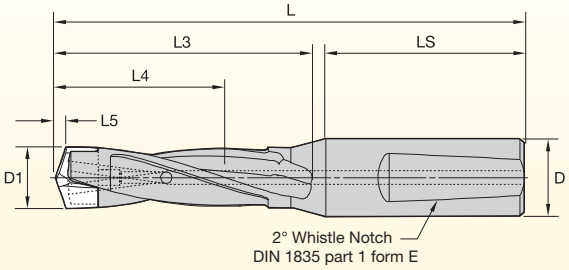
Modular Drills • Dimension Tables

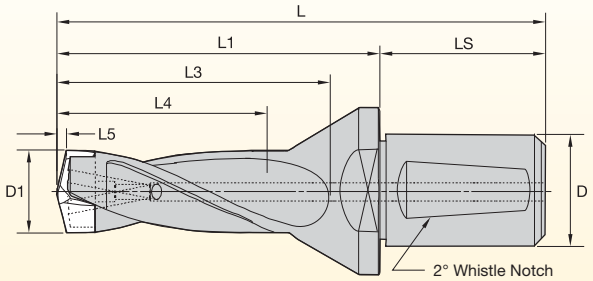
Dimensions for KSEM™ Whistle Notch Shank • WN/WD 3 x D to 10 x D • Metric





for diameters < 16mm, DIN 6535 - HE
for diameters > 16mm, DIN 1835 part 1 form E

Whistle Notch shank D1≤32mm



Whistle Notch shank with Drive D1≥32mm

D1		WN/WD Shank Metric								WN Shank Metric					
		3 x D				5 x D				7 x D			10 x D		
mm	inch	L	L1	L4 max	wrench	L	L1	L4 max	wrench	L	L4 max	wrench	L	L4 max	wrench
12,50	.4921	111	–	42	**170.294**	139	–	70	**170.294**	167	98	170.295	195	125	**170.296**
13,00	.5118	111	–	42	**170.294**	139	–	70	**170.294**	167	98	170.295	200	130	**170.296**
13,50	.5315	111	–	42	**170.294**	139	–	70	**170.294**	167	98	170.295	205	135	**170.296**
13,51	.5319	111	–	42	**170.289**	139	–	70	**170.289**	167	98	170.290	205	135	**170.291**
14,00	.5512	111	–	42	**170.289**	139	–	70	**170.289**	167	98	170.290	210	140	**170.291**
14,50	.5709	122	–	48	**170.289**	154	–	80	**170.289**	186	112	170.290	220	145	**170.291**
14,51	.5713	122	–	48	**170.289**	154	–	80	**170.289**	186	112	170.290	220	145	**170.291**
15,00	.5906	122	–	48	**170.289**	154	–	80	**170.289**	186	112	170.290	225	150	**170.291**
15,50	.6102	122	–	48	**170.289**	154	–	80	**170.289**	186	112	170.290	230	155	**170.291**
16,00	.6299	122	–	48	**170.270**	154	–	80	**170.270**	186	112	170.270	234	160	**170.271**
16,50	.6496	130	–	54	**170.270**	166	–	90	**170.270**	202	126	170.271	241	165	**170.281**
17,00	.6693	130	–	54	**170.270**	166	–	90	**170.270**	202	126	170.271	246	170	**170.281**
17,50	.6890	130	–	54	**170.270**	166	–	90	**170.270**	202	126	170.271	251	175	**170.281**
18,00	.7087	130	–	54	**170.270**	166	–	90	**170.270**	202	126	170.271	256	180	**170.281**
18,01	.7091	–	–	–	**–**	184	–	100	**170.270**	–	–	170.271	269	185	**170.281**
18,50	.7283	144	–	60	**170.270**	184	–	100	**170.270**	224	140	170.271	269	185	**170.281**
19,00	.7480	144	–	60	**170.270**	184	–	100	**170.270**	224	140	170.271	274	190	**170.281**
19,50	.7677	144	–	60	**170.270**	184	–	100	**170.270**	224	140	170.271	279	195	**170.281**
20,00	.7874	153	–	60	**170.272**	197	–	100	**170.272**	241	140	170.273	297	200	**170.282**
20,50	.8071	153	–	66	**170.272**	197	–	110	**170.272**	241	154	170.273	297	205	**170.282**
21,00	.8268	153	–	66	**170.272**	197	–	110	**170.272**	241	154	170.273	297	210	**170.282**
21,50	.8465	153	–	66	**170.272**	197	–	110	**170.272**	241	154	170.273	307	215	**170.282**
22,00	.8661	153	–	66	**170.272**	197	–	110	**170.272**	241	154	170.273	307	220	**170.282**
22,01	.8665	–	–	–	**–**	209	–	120	**170.272**	–	–	170.273	319	225	**170.282**
22,50	.8858	161	–	72	**170.272**	209	–	120	**170.272**	257	168	170.273	319	225	**170.282**
23,00	.9055	161	–	72	**170.272**	209	–	120	**170.272**	257	168	170.273	319	230	**170.282**
23,50	.9252	161	–	72	**170.272**	209	–	120	**170.272**	257	168	170.273	329	235	**170.282**
24,00	.9449	161	–	72	**170.272**	209	–	120	**170.272**	257	168	170.273	329	240	**170.282**
24,01	.9453	–	–	–	**–**	226	–	130	**170.274**	–	–	–	346	245	**170.283**
24,50	.9646	174	–	78	**170.274**	226	–	130	**170.274**	278	182	170.275	346	245	**170.283**
25,00	.9843	174	–	78	**170.274**	226	–	130	**170.274**	278	182	170.275	346	250	**170.283**
25,50	10.039	174	–	78	**170.274**	226	–	130	**170.274**	278	182	170.275	356	255	**170.283**
26,00	10.236	174	–	78	**170.274**	226	–	130	**170.274**	278	182	170.275	356	260	**170.283**
26,01	10.240	–	–	–	**–**	238	–	140	**170.274**	–	–	170.275	363	265	**170.283**
26,50	10.433	182	–	84	**170.274**	238	–	140	**170.274**	294	196	170.275	363	265	**170.283**

(continued)

Modular Drills • Dimension Tables *(continued)*

Dimensions for KSEM™ Whistle Notch Shank • WN/WD 3 x D to 10 x D • Metric



D1		WN/WD Shank Metric								WN Shank Metric					
		3 x D				5 x D				7 x D			10 x D		
mm	inch	L	L1	L4 max	wrench	L	L1	L4 max	wrench	L	L4 max	wrench	L	L4 max	wrench
27,00	10.630	182	–	84	**170.274**	238	–	140	**170.274**	294	196	170.275	368	270	**170.283**
27,50	10.827	182	–	84	**170.274**	238	–	140	**170.274**	294	196	170.275	378	275	**170.283**
28,00	11.024	182	–	84	**170.274**	238	–	140	**170.274**	294	196	170.275	378	280	**170.283**
28,02	11.028	–	–	–	**–**	250	–	150	**170.276**	–	–	–	390	285	**170.284**
28,50	11.220	190	–	90	**170.276**	250	–	150	**170.276**	310	210	170.277	390	285	**170.284**
29,00	11.417	190	–	90	**170.276**	250	–	150	**170.276**	310	210	170.277	390	290	**170.284**
29,50	11.614	190	–	90	**170.276**	250	–	150	**170.276**	310	210	170.277	400	295	**170.284**
30,00	11.811	190	–	90	**170.276**	250	–	150	**170.276**	310	210	170.277	400	300	**170.284**
30,01	11.815	–	–	–	**–**	264	–	160	**170.276**	–	–	170.277	414	305	**170.284**
30,50	12.008	200	–	96	**170.276**	264	–	160	**170.276**	328	224	170.277	–	–	**–**
31,00	12.205	200	–	96	**170.276**	264	–	160	**170.276**	328	224	170.277	414	310	**170.284**
31,50	12.402	200	–	96	**170.276**	264	–	160	**170.276**	328	224	170.277	–	–	**–**
32,00	12.598	200	–	96	**170.276**	264	–	160	**170.276**	328	224	170.277	424	320	**170.284**
32,01	12.602	220	159	99	**170.276**	293	225	165	**170.277**	–	–	–	–	–	**–**
33,00	12.992	227	159	99	**170.276**	293	225	165	**170.277**	–	–	–	–	–	**–**
34,00	13.386	225	157	102	**170.276**	293	225	170	**170.277**	–	–	–	–	–	**–**
35,00	13.780	235	167	105	**170.276**	305	237	175	**170.277**	–	–	–	–	–	**–**
36,00	14.173	233	165	108	**170.276**	305	237	180	**170.277**	–	–	–	–	–	**–**
36,01	14.177	237	176	111	**170.276**	318	250	185	**170.277**	–	–	–	–	–	**–**
37,00	14.567	244	176	111	**170.276**	318	250	185	**170.277**	–	–	–	–	–	**–**
38,00	14.961	242	174	114	**170.276**	318	250	190	**170.277**	–	–	–	–	–	**–**
39,00	15.354	252	184	117	**170.276**	330	262	195	**170.277**	–	–	–	–	–	**–**
40,00	15.748	250	182	120	**170.276**	330	262	200	**170.277**	–	–	–	–	–	**–**

KGEM Tube Sheet Grooving Tool

Primary Application

The new Kennametal grooving tool features a unique approach for manufacturing two grooves simultaneously in minimal time, especially in heat exchanger manufacturing. All tubes need a finish operation to connect them. This new grooving insert features a geometry designed for bur-free cutting and is made with KCU45™, a special grade for machining a wide variety of materials in the heat exchanger industry, including A516-grade 70 low-carbon steel, 304 stainless steel, duplex, and Hastelloy™. The minimal amount of tungsten carbide in the insert eliminates the need for refurbishment, enabling the tool to work faster with a lower cost per hole.

Features and Benefits

Higher Productivity and Profitablity

- Two edges per insert.
- Up to four inserts working at the same time.
- Rigid tool body design for highest productivity and grooving quality.
- Milling tool for maximum flexibility in hole diameter and interrupted cut for chip control.
- KCU45 grade for machining a variety of materials used for heat exchangers.
- Internal coolant supply for optimal tool life, groove quality, and chip evacuation.
- One-path-to-finish tool.
- Flexibility in groove position.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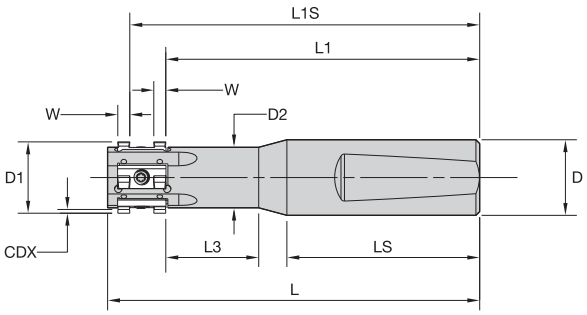




KGEM Groover Body • Metric

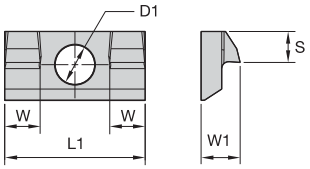


order number	catalogue number	D1	D2	D	L	LS	L1	L1S	L3	CDX	insert screw
5408657	**KGEM1588R1WN20M**	15,88	13,50	20,00	101,00	51,00	85,00	94,52	25,63	1,00	**MS1861**
5134143	**KGEM1905R1WN20M**	18,87	16,00	20,00	98,42	50,80	83,03	92,55	24,58	1,00	**MS1861**
5134145	**KGEM1905R3WN20M**	18,87	16,00	20,00	123,82	50,80	108,44	117,96	49,99	1,00	**MS1861**

NOTE: The above dimensions are used when ordering engineered-solution reamers on this page unless otherwise specified.

KSEM™ Support Tooling • KGEM™ Tube Sheet Groover Insert





● first choice
○ alternative choice

P	●
M	●
K	
N	
S	●
H	

KGEM Groover Insert

order number	catalogue number	D1 mm	D1 in	W1 mm	W1 in	W mm	W in	S mm	S in	KCU45
5134141	**KGIP0125N0189GD**	2,80	.110	3,56	.140	3,18	.125	2,82	.111	●
5986819	**KGIP0300N0189GD**	2,80	.110	3,56	.140	3,00	.118	2,82	.111	●

P	A516-Grade70
M	304SS/Duplex
S	Hastelloy

KGEM Tube Sheet Groover • KGIP GD Geometry • Grade KCU45™ • Through Coolant • Metric

Material Group	fz (mm/tooth)	tooth	RPM	vc (m/min)	VFC (mm/min)	VFL (mm/min)	DH (mm)	DT (mm)
P	0,05–0,075	4	1300–1500	77–89	2,46–4,27	264–457	19,05	18,87
M	0,05–0,075	4	600–900	35–53	1,70–2,57	183–274	19,05	18,87
S	0,05–0,075	4	250–300	15–18	0,48–0,86	51–91	19,05	18,87

Nomenclature:
fz: feed per tooth
VFL: linear feed rate = fz x number of tooth x RPM
VFC: compensated feed = VFL x (DH - DT)/DH
DT: tool diameter
DH: hole diameter

NOTE: Choose low-feed (fz) for long tools and less rigid machine tools.
Choose low RPM for lower coolant.

KSEM PLUS™ Modular Drill System

Our KSEM PLUS drill concept is simple but effective. It combines the benefits of the KSEM™ modular drill (high feeds and length-to-diameter [L/D] ratios) with the benefits of an indexable drill (high speeds and low consumable costs). The KSEM PLUS system is a modular drilling platform, offering a pre-mountable HSS head with pocket seats for carbide inserts. The KSEM PLUS modular drill system features two head styles that are interchangeable on fitting tool bodies with our flexible FDS interface.

Primary Application

The KSEM PLUS system performs in steel, cast iron, stainless steel, and advanced materials. It is perfectly suited to exchange older HSS tools or low performance indexable drills for a very high performance drilling solution. The KSEM PLUS range comprises 28–101mm (1.102–4") from 1.5–10 x D. There is a wide range of applications in the energy market, and in general engineering (e.g., bearing rings for windmills, hydraulic manifolds, large engine parts, generator housings, etc.). This tool will deliver vast improvements in productivity, and greatly attribute to increasing your machining capacity.

Features and Benefits

Replaceable Heads with FDS-Interface Coupling

- Quickly and easily replace inserts or drill heads without removing tool bodies from the machine.
- Save money and reduce tool stock by replacing just the worn drill head.
- Use one tool body for different sizes and styles of drill head (a head fits any drill body of the same FDS size).

Two Effective Cutting Edges

- The KSEM PLUS system has two full cutting edges in action when operating.
- Achieve up to 100% increased productivity versus an indexable drill of the same diameter.
- High L/D ratios possible from 1.5 x D up to 10 x D as stocked standards. Longer drills are possible as custom solutions.

KSEM PLUS A1 Heads

- High metal removal rates.
- Very stable in normal cutting conditions.
- Cost-effective indexable Drill Fix™ DFT inserts.

KSEM PLUS Pilot Insert

- Very high feed rates, comparable to modular drills.
- Very long tool life of KSEM PLUS centre inserts and modular heads due to better chip flow.
- No precentring necessary for drill depths up to 5 x D.

KSEM PLUS B1 Heads

- High-speed drilling in difficult conditions.
- Drills stacked plates and cored holes.
- Capable of machining through cross holes.
- Works with slanted exits up to 15°.

DFR™/DFT™/DFC™ Outboard Inserts

- Very high cutting speeds for high metal removal rates.
- Improved stability in all cutting conditions.
- Indexable inserts provide good surface finish and hole diameter accuracy.

KSEM PLUS™ A1 Heads
Economic, high-performance drilling.





KSEM PLUS B1 Heads
High-performance drilling in difficult conditions.







NEW! All KSEMP Heads >70mm now available in 1mm and 1/8" pitch as standard product.

NEW! DS geometry for long chipping materials.

NEW! 1.5 x D toolholders now available with WD and SSF shanks.

Tailored Grades

Centre Inserts

- KC7315™ grade — TiAlN-based PVD grade for superior performance in steel and stainless steel applications.
- KC7410™ grade — multilayered PVD coating for outstanding wear resistance when drilling cast irons.
- KC7135™ grade — chip-resistant universal grade with a TiCN-TiN PVD coating for challenging applications in steel and stainless steel materials.

Drill Fix™ Lateral Inserts

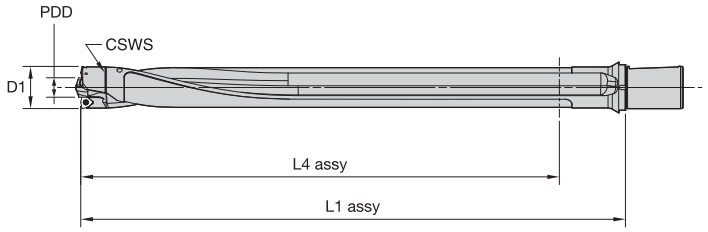
- KCU25™ grade — high metal removal rates, advanced TiCN-Al-CVD coating, and superior tool life in stable working conditions.
- KCU40™ grade — multilayered TiAlN-PVD coating with high wear resistance and reliability in most materials at medium cutting speeds.
- KC7140™ grade — TiCN-based, PVD-coated alloyed carbide for machining alloyed steel and stainless steel on KSEM PLUS systems.
- KC7225™ grade — TiAlN PVD-coated fine-grain carbide offers extreme process safety for non-ferrous materials, super alloys, and titanium.

NEW! DFT™ and DFC™ Lateral Inserts with DS Geometry

- Excellent performance and process stability in applications with long-chipping materials.
- Use for low carbon steel, difficult stainless steel, and non-ferrous materials where long chips can be an issue.
- Available in the KCU40™ grade.

Customisation

- Heads are available in intermediate diameters, and up to Ø 127mm as semi-standards.
- Tool bodies available in all popular shank styles up to shank length of 1200mm. Some restrictions with L/D ratios over 20 x D apply.
- Toolholders can be designed with helical chip flutes for better chip evacuation (e.g. drilling in cast iron).
- Heads for use with reground center inserts are available as semi-standards.
- The KSEM PLUS system features a high level of available customisation. Please contact us about for your individual metalcutting applications.



available KSEM PLUS heads				requested insert size reference per head			available tool bodies per CSWS connecting size 3 x D, 5 x D, 8 x D, 10 x D (metric and inch bodies)				
D1		KSEM PLUS head order number	KSEM PLUS head ANSI catalogue number	PDD (mm) centre insert size reference	outboard insert Drill Fix™ DFR/DFT	CSWS	KSEM PLUS body order number	KSEM PLUS body ANSI catalogue number	L/D ratio	L4 assembly (mm)	L1 assembly (mm)
mm	in										
28.000	1.1024	**4000408**	**KSEMP2800FDS28A1M**	14.000	DFR040304D28	28	**6123570**	**WD32FDS28076M**	1.5 x D	57	101
28.575	1.1250	**4047811**	**KSEMP1125FDS28A1**	15.000	DFR040304D28		**4000409**	**WD32FDS28128M**	3 x D	96	153
29.000	1.1417	**4047812**	**KSEMP2900FDS28A1M**	15.000	DFR040304D28		**4051136**	**WD32FDS28190M**	5 x D	158	215
29.362	1.1563	**4047823**	**KSEMP1156FDS28A1**	16.000	DFR040304D28		**4051137**	**WD32FDS28283M**	8 x D	251	308
30.000	1.1811	**4047824**	**KSEMP3000FDS28A1M**	16.000	DFR040304D28		**4000411**	**WD32FDS28345M**	10 x D	313	370
30.175	1.1875	**4047825**	**KSEMP1188FDS28A1**	17.000	DFR040304D28		**6123582**	**SSF150FDS280299**	1.5 x D	57	101
30.963	1.2188	**4047826**	**KSEMP1219FDS28A1**	17.000	DFR040304D28		**4051138**	**SSF150FDS280502**	3 x D	96	153
31.000	1.2205	**4047827**	**KSEMP3100FDS28A1M**	17.000	DFR040304D28		**4051139**	**SSF150FDS280746**	5 x D	158	215
							4051140	**SSF150FDS281112**	8 x D	251	308
							4051141	**SSF150FDS281356**	10 x D	313	370
31.750	1.2500	**3794916**	**KSEMP1250FDS32A1**	15.000	DFT05T308D32	32	**6123571**	**WD32FDS32082M**	1.5 x D	59	107
32.000	1.2598	**3794291**	**KSEMP3200FDS32A1M**	15.000	DFT05T308D32		**3950219**	**WD32FDS32146M**	3 x D	110	171
33.000	1.2992	**3742210**	**KSEMP3300FDS32A1M**	16.000	DFT05T308D33		**3794428**	**WD32FDS32216M**	5 x D	180	241
33.200	1.3071	**3793949**	**KSEMP3320FDS32A1M**	16.000	DFT05T308D33		**3742293**	**WD32FDS32321M**	8 x D	285	346
33.350	1.3130	**3794917**	**KSEMP1313FDS32A1**	17.000	DFT05T308D33		**3794429**	**WD32FDS32391M**	10 x D	355	416
34.000	1.3386	**3794292**	**KSEMP3400FDS32A1M**	17.000	DFT05T308D33		**6123583**	**SSF150FDS320323**	1.5 x D	59	107
34.925	1.3750	**3794918**	**KSEMP1375FDS32A1**	18.000	DFT05T308D33		**3952192**	**SSF150FDS320573**	3 x D	110	171
35.000	1.3780	**3794393**	**KSEMP3500FDS32A1M**	18.000	DFT05T308D33		**3794835**	**SSF150FDS320850**	5 x D	180	241
							3794836	**SSF150FDS321263**	8 x D	285	346
							3794837	**SSF150FDS321539**	10 x D	355	416
36.000	1.4173	**3794394**	**KSEMP3600FDS36A1M**	13.000	DFT06T308D36	36	**6123572**	**WD32FDS36092M**	1.5 x D	65	117
36.525	1.4380	**3794919**	**KSEMP1438FDS36A1**	14.000	DFT06T308D36		**3950220**	**WD32FDS36166M**	3 x D	122	191
37.000	1.4567	**3794395**	**KSEMP3700FDS36A1M**	14.000	DFT06T308D36		**3794430**	**WD32FDS36244M**	5 x D	200	269
37.500	1.4764	**3794427**	**KSEMP3750FDS36A1M**	15.000	DFT06T308D36		**3794431**	**WD32FDS36361M**	8 x D	317	386
38.000	1.4961	**3794396**	**KSEMP3800FDS36A1M**	15.000	DFT06T308D36		**3794432**	**WD32FDS36439M**	10 x D	395	464
38.100	1.5000	**3794920**	**KSEMP1500FDS36A1**	15.000	DFT06T308D36		**6123584**	**SSF150FDS360362**	1.5 x D	65	117
39.000	1.5354	**3794397**	**KSEMP3900FDS36A1M**	16.000	DFT06T308D39		**3952343**	**SSF150FDS360652**	3 x D	122	191
39.200	1.5433	**3793950**	**KSEMP3920FDS36A1M**	16.000	DFT06T308D39		**3794838**	**SSF150FDS360960**	5 x D	200	269
39.700	1.5630	**3794921**	**KSEMP1563FDS36A1**	17.000	DFT06T308D39		**3794839**	**SSF150FDS361421**	8 x D	317	386
							3794840	**SSF150FDS361728**	10 x D	395	464
40.000	1.5748	**3794398**	**KSEMP4000FDS40A1M**	17.000	DFT06T308D39	40	**6123573**	**WD50FDS40100M**	1.5 x D	73	125
41.000	1.6142	**3794399**	**KSEMP4100FDS40A1M**	18.000	DFT06T308D39		**3872075**	**WD50FDS40183M**	3 x D	137	213
41.275	1.6250	**3794922**	**KSEMP1625FDS40A1**	18.000	DFT06T308D39		**3794443**	**WD50FDS40271M**	5 x D	225	301
42.000	1.6535	**3794400**	**KSEMP4200FDS40A1M**	19.000	DFT06T308D39		**3794444**	**WD50FDS40403M**	8 x D	357	433
43.000	1.6929	**3794401**	**KSEMP4300FDS40A1M**	20.000	DFT06T308D39		**3794445**	**WD50FDS40491M**	10 x D	445	521
44.000	1.7323	**3794402**	**KSEMP4400FDS40A1M**	21.000	DFT06T308D44		**6123585**	**SSF200FDS400394**	1.5 x D	73	125
44.450	1.7500	**3794933**	**KSEMP1750FDS40A1**	22.000	DFT06T308D44		**3952344**	**SSF200FDS400721**	3 x D	137	213
							3794841	**SSF200FDS401066**	5 x D	225	301
							3794842	**SSF200FDS401586**	8 x D	357	433
							3794903	**SSF200FDS401933**	10 x D	445	521

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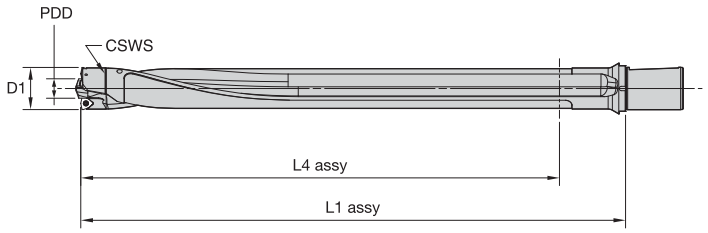
(KSEM PLUS Overview and Assembly for Systems Using A1 Heads — continued)



available KSEM PLUS heads				requested insert size reference per head			available tool bodies per CSWS connecting size 3 x D, 5 x D, 8 x D, 10 x D (metric and inch bodies)				
D1		KSEM PLUS head order number	KSEM PLUS head ANSI catalogue number	PDD (mm) centre insert size reference	outboard insert Drill Fix™ DFC DPA guiding pads	CSWS	KSEM PLUS body order number	KSEM PLUS body ANSI catalogue number	L/D ratio	L4 assembly (mm)	L1 assembly (mm)
mm	in										
45.000	1.7717	**3794403**	**KSEMP4500FDS45A1M**	18.000	DFT070408D45	45	**6123575**	**WD50FDS45112M**	1.5 x D	85	147
46.000	1.8110	**3794404**	**KSEMP4600FDS45A1M**	19.000	DFT070408D45		**3872709**	**WD50FDS45206M**	3 x D	152	236
47.000	1.8504	**3794405**	**KSEMP4700FDS45A1M**	20.000	DFT070408D45		**3794446**	**WD50FDS45304M**	5 x D	250	334
47.625	1.8750	**3794934**	**KSEMP1875FDS45A1**	21.000	DFT070408D45		**3794447**	**WD50FDS45451M**	8 x D	397	481
48.000	1.8898	**3794406**	**KSEMP4800FDS45A1M**	21.000	DFT070408D45		**3794448**	**WD50FDS45549M**	10 x D	495	579
49.000	1.9291	**3794407**	**KSEMP4900FDS45A1M**	22.000	DFT070408D45		**6123586**	**SSF200FDS450441**	1.5 x D	85	147
							3952345	**SSF200FDS450809**	3 x D	152	236
							3794904	**SSF200FDS451196**	5 x D	250	334
							3794905	**SSF200FDS451775**	8 x D	397	481
							3794906	**SSF200FDS452161**	10 x D	495	579
50.000	1.9685	**3742211**	**KSEMP5000FDS50A1M**	23.000	DFT070408D50	50	**6123576**	**WD50FDS50122M**	1.5 x D	89	157
50.800	2.0000	**3794935**	**KSEMP2000FDS50A1**	24.000	DFT070408D50		**3950221**	**WD50FDS50228M**	3 x D	170	263
51.000	2.0079	**3794408**	**KSEMP5100FDS50A1M**	24.000	DFT070408D50		**3794449**	**WD50FDS50338M**	5 x D	280	373
52.000	2.0472	**3794409**	**KSEMP5200FDS50A1M**	25.000	DFT070408D50		**3742294**	**WD50FDS50503M**	8 x D	445	538
53.000	2.0866	**3794410**	**KSEMP5300FDS50A1M**	26.000	DFT070408D50		**3794450**	**WD50FDS50613M**	10 x D	555	648
53.975	2.1250	**3794936**	**KSEMP2125FDS50A1**	27.000	DFT070408D50		**6123587**	**SSF200FDS500480**	1.5 x D	89	157
54.000	2.1260	**3794411**	**KSEMP5400FDS50A1M**	27.000	DFT070408D50		**3952346**	**SSF200FDS500896**	3 x D	170	263
55.000	2.1654	**3794412**	**KSEMP5500FDS50A1M**	28.000	DFT070408D50		**3794907**	**SSF200FDS501330**	5 x D	280	373
							3794908	**SSF200FDS501980**	8 x D	445	538
							3794909	**SSF200FDS502413**	10 x D	555	648
56.000	2.2047	**3794413**	**KSEMP5600FDS56A1M**	20.000	DFT090508D56	56	**6123577**	**WD50FDS56140M**	1.5 x D	130	175
57.000	2.2441	**3794414**	**KSEMP5700FDS56A1M**	21.000	DFT090508D56		**3950222**	**WD50FDS56259M**	3 x D	191	294
57.150	2.2500	**3794937**	**KSEMP2250FDS56A1**	21.000	DFT090508D56		**3794451**	**WD50FDS56383M**	5 x D	315	418
58.000	2.2835	**3794415**	**KSEMP5800FDS56A1M**	22.000	DFT090508D56		**3794452**	**WD50FDS56569M**	8 x D	501	604
59.000	2.3228	**3794416**	**KSEMP5900FDS56A1M**	23.000	DFT090508D56		**3794453**	**WD50FDS56693M**	10 x D	625	728
60.000	2.3622	**3794417**	**KSEMP6000FDS56A1M**	24.000	DFT090508D56		**6123588**	**SSF200FDS560551**	1.5 x D	130	175
60.330	2.3750	**3794938**	**KSEMP2375FDS56A1**	24.000	DFT090508D56		**3952347**	**SSF200FDS561020**	3 x D	191	294
61.000	2.4016	**3794418**	**KSEMP6100FDS56A1M**	25.000	DFT090508D56		**3794910**	**SSF200FDS561507**	5 x D	315	418
62.000	2.4409	**3794419**	**KSEMP6200FDS56A1M**	26.000	DFT090508D56		**3794911**	**SSF200FDS562240**	8 x D	501	604
							3794912	**SSF200FDS562783**	10 x D	625	728
63.000	2.4803	**3794420**	**KSEMP6300FDS63A1M**	27.000	DFT090508D63	63	**6123578**	**WD50FDS63154M**	1.5 x D	111	194
63.500	2.5000	**3794939**	**KSEMP2500FDS63A1**	28.000	DFT090508D63		**3950333**	**WD50FDS63289M**	3 x D	214	329
64.000	2.5197	**3794421**	**KSEMP6400FDS63A1M**	28.000	DFT090508D63		**3794454**	**WD50FDS63429M**	5 x D	354	469
65.000	2.5591	**3794422**	**KSEMP6500FDS63A1M**	29.000	DFT090508D63		**3794455**	**WD50FDS63639M**	8 x D	564	679
66.000	2.5984	**3794423**	**KSEMP6600FDS63A1M**	30.000	DFT090508D63		**3742296**	**WD50FDS63779M**	10 x D	704	819
66.680	2.6250	**3794940**	**KSEMP2625FDS63A1**	31.000	DFT090508D63		**6123589**	**SSF200FDS630606**	1.5 x D	111	194
67.000	2.6378	**3794424**	**KSEMP6700FDS63A1M**	31.000	DFT090508D63		**3952348**	**SSF200FDS631138**	3 x D	214	329
68.000	2.6772	**3794425**	**KSEMP6800FDS63A1M**	32.000	DFT090508D63		**3794913**	**SSF200FDS631688**	5 x D	354	469
69.000	2.7165	**3794426**	**KSEMP6900FDS63A1M**	33.000	DFT090508D63		**3794914**	**SSF200FDS632515**	8 x D	564	679
69.850	2.7500	**3794941**	**KSEMP2750FDS63A1**	34.000	DFT090508D63		**3794915**	**SSF200FDS633066**	10 x D	704	819
70.000	2.7559	**3742212**	**KSEMP7000FDS63A1M**	34.000	DFT090508D63						

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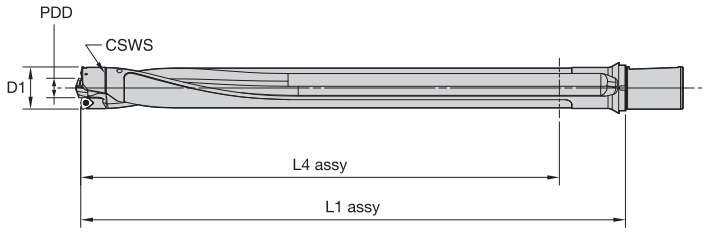
(KSEM PLUS Overview and Assembly for Systems Using A1 Heads — continued)



available KSEM PLUS heads				requested insert size reference per head			available tool bodies per CSWS connecting size 3 x D, 5 x D, 8 x D, 10 x D (metric and inch bodies)				
D1		KSEM PLUS head order number	KSEM PLUS head ANSI catalogue number	PDD (mm) centre insert size reference	outboard insert Drill Fix™ DFC DPA guiding pads	CSWS	KSEM PLUS body order number	KSEM PLUS body ANSI catalogue number	L/D ratio	L4 assembly (mm)	L1 assembly (mm)
mm	in										
71.000	2.7950	**6041904**	**KSEMP7100FDS71A1M**	26.000	4x DFT06T308D44	71	**6123579**	**WD50FDS71172M**	1.5 x D	128	217
72.000	2.8350	**5397513**	**KSEMP7200FDS71A1M**	27.000			**5397942**	**WD50FDS71292M**	3 x D	241	333
73.000	2.8740	**6041906**	**KSEMP7300FDS71A1M**	28.000			**5397943**	**WD50FDS71452M**	5 x D	401	493
73.025	2.8750	**6041931**	**KSEMP2875FDS71A1**	28.000			**6123590**	**SSF200FDS710677**	1.5 x D	128	217
74.000	2.9130	**5397514**	**KSEMP7400FDS71A1M**	29.000			**5397948**	**SSF200FDS711150**	3 x D	241	333
75.000	2.9530	**6041907**	**KSEMP7500FDS71A1M**	30.000			**5397949**	**SSF200FDS711780**	5 x D	401	493
76.000	2.9920	**5397515**	**KSEMP7600FDS71A1M**	31.000							
76.200	3.0000	**5397516**	**KSEMP3000FDS71A1**	31.000							
77.000	3.0310	**6041908**	**KSEMP7700FDS71A1M**	32.000							
78.000	3.0710	**5397517**	**KSEMP7800FDS71A1M**	33.000							
79.000	3.1100	**6041909**	**KSEMP7900FDS71A1M**	34.000							
79.375	3.1250	**6041932**	**KSEMP3125FDS80A1**	31.000	2x DFT06T308D44 & 2x DFT070408D50	80	**6123580**	**WD50FDS80192M**	1.5 x D	145	247
80.000	3.1500	**5397518**	**KSEMP8000FDS80A1M**	31.000			**5397944**	**WD50FDS80327M**	3 x D	271	373
81.000	3.1890	**6041910**	**KSEMP8100FDS80A1M**	32.000			**5397945**	**WD50FDS80507M**	5 x D	451	553
82.000	3.2280	**5397519**	**KSEMP8200FDS80A1M**	33.000			**6123591**	**SSF200FDS800756**	1.5 x D	145	247
83.000	3.2680	**6041921**	**KSEMP8300FDS80A1M**	34.000			**5398010**	**SSF200FDS801287**	3 x D	271	373
82.550	3.2500	**5397550**	**KSEMP3250FDS80A1**	34.000			**5398011**	**SSF200FDS801996**	5 x D	451	553
84.000	3.3070	**5397551**	**KSEMP8400FDS80A1M**	35.000							
85.000	3.3070	**6041922**	**KSEMP8500FDS80A1M**	36.000							
85.725	3.3750	**6041933**	**KSEMP3375FDS80A1**	37.000							
86.000	3.3860	**5397552**	**KSEMP8600FDS80A1M**	37.000							
87.000	3.4250	**6041923**	**KSEMP8700FDS80A1M**	38.000							
88.000	3.4650	**5397553**	**KSEMP8800FDS80A1M**	39.000							
88.900	3.5000	**5397554**	**KSEMP3500FDS80A1**	40.000							
89.000	3.5040	**6041924**	**KSEMP8900FDS80A1M**	40.000							
90.000	3.5430	**5397555**	**KSEMP9000FDS90A1M**	37.000	4x DFT070408D50	90	**6123581**	**WD50FDS90212M**	1.5 x D	160	272
91.000	3.5830	**6041925**	**KSEMP9100FDS90A1M**	38.000			**5397946**	**WD50FDS90362M**	3 x D	302	414
92.000	3.6220	**5397556**	**KSEMP9200FDS90A1M**	39.000			**5397947**	**WD50FDS90562M**	5 x D	502	614
92.075	3.6250	**6041934**	**KSEMP3625FDS90A1**	39.000			**6123592**	**SSF200FDS900835**	1.5 x D	160	272
93.000	3.6610	**6041926**	**KSEMP9300FDS90A1M**	40.000			**5398012**	**SSF200FDS901425**	3 x D	302	414
							5398013	**SSF200FDS902213**	5 x D	502	614
94.000	3.7010	**5397557**	**KSEMP9400FDS90A1M**	26.000	6x DFT06T308D44						
95.000	3.7400	**6041927**	**KSEMP9500FDS90A1M**	27.000							
95.250	3.7500	**5397558**	**KSEMP3750FDS90A1**	27.000							
96.000	3.7800	**5397559**	**KSEMP9600FDS90A1M**	28.000							
97.000	3.8190	**6041928**	**KSEMP9700FDS90A1M**	29.000							
98.000	3.8580	**5397560**	**KSEMP9800FDS90A1M**	30.000							
98.425	3.8750	**6041935**	**KSEMP3875FDS90A1**	31.000							
99.000	3.8980	**6041929**	**KSEMP9900FDS90A1M**	31.000							
100.000	3.9370	**6041930**	**KSEMP10000FDS90A1M**	32.000							
101.600	4.0000	**5397561**	**KSEMP4000FDS90A1**	34.000							

Keep it Short and **Simple…**





Achieve short chips in long-chipping materials with our new DS/LP geometries for indexable drills and KSEM PLUS™.

- High metal removal rates without long chips, especially in low-carbon steel applications.
- Improved control of chip flow, chip breakage, and chip curling. Eliminates chip jamming by providing excellent chip forming and chipbreaking capabilities.
- Avoid bird nesting and long, stringy chips to reduce idle time and improve process stability.

See pages J4–J50 for Drill Fix™ Indexable Drills.

See pages H80–H82, H84–H101, and H106 for KSEM PLUS A1 and B1 head systems.





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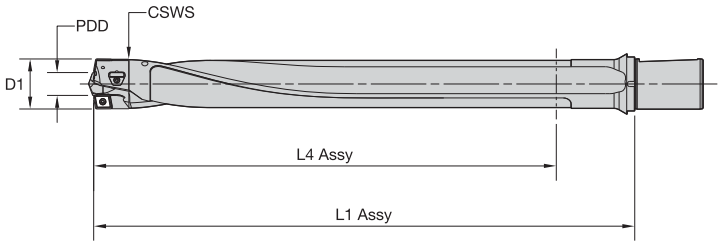

available KSEM PLUS heads				requested insert size reference per head			available tool bodies per CSWS connecting size 3 x D, 5 x D, 8 x D, 10 x D (metric and inch bodies)				
D1		KSEM PLUS head order number	KSEM PLUS head ANSI catalogue number	PDD (mm) centre insert size reference	outboard insert Drill Fix™ DFC DPA guiding pads	CSWS	KSEM PLUS body order number	KSEM PLUS body ANSI catalogue number	L/D ratio	L4 assembly (mm)	L1 assembly (mm)
mm	in										
28.000	1.1020	**5115736**	**KSEMP2800FDS28B1M**	14.000	**DFC inserts** DFC040310D28 **DPA guiding pads** DPA07T3D25	28	**6123570**	**WD32FDS28076M**	1.5 x D	54	98
28.575	1.1250	**5115737**	**KSEMP1125FDS28B1**	15.000			**4000409**	**WD32FDS28128M**	3 x D	93	150
29.000	1.1420	**5115738**	**KSEMP2900FDS28B1M**	15.000			**4051136**	**WD32FDS28190M**	5 x D	155	212
29.362	1.1560	**5115739**	**KSEMP1156FDS28B1**	16.000			**4051137**	**WD32FDS28283M**	8 x D	248	305
30.000	1.1810	**5116010**	**KSEMP3000FDS28B1M**	16.000			**4000411**	**WD32FDS28345M**	10 x D	310	367
30.175	1.1880	**5116011**	**KSEMP1188FDS28B1**	17.000			**6123582**	**SSF150FDS280299**	1.5 x D	54	98
30.963	1.2190	**5116012**	**KSEMP1219FDS28B1**	17.000			**4051138**	**SSF150FDS280502**	3 x D	93	150
31.000	1.2200	**5116013**	**KSEMP3100FDS28B1M**	17.000			**4051139**	**SSF150FDS280746**	5 x D	155	212
							4051140	**SSF150FDS281112**	8 x D	248	305
							4051141	**SSF150FDS281356**	10 x D	310	367
31.750	1.2500	**5116014**	**KSEMP1250FDS32B1**	15.000	**DFC inserts** DFC05T312D32 **DPA guiding pads** DPA09T4D32	32	**6123571**	**WD32FDS32082M**	1.5 x D	54	102
32.000	1.2600	**5116015**	**KSEMP3200FDS32B1M**	15.000			**3950219**	**WD32FDS32146M**	3 x D	105	166
33.000	1.2990	**5116016**	**KSEMP3300FDS32B1M**	16.000			**3794428**	**WD32FDS32216M**	5 x D	175	236
33.200	1.3070	**5116017**	**KSEMP3320FDS32B1M**	16.000			**3742293**	**WD32FDS32321M**	8 x D	280	341
33.350	1.3130	**5116018**	**KSEMP1313FDS32B1**	17.000			**3794429**	**WD32FDS32391M**	10 x D	350	411
34.000	1.3390	**5116019**	**KSEMP3400FDS32B1M**	17.000			**6123583**	**SSF150FDS320323**	1.5 x D	54	102
34.925	1.3750	**5116030**	**KSEMP1375FDS32B1**	18.000			**3952192**	**SSF150FDS320573**	3 x D	105	166
35.000	1.3780	**5116031**	**KSEMP3500FDS32B1M**	18.000			**3794835**	**SSF150FDS320850**	5 x D	175	236
							3794836	**SSF150FDS321263**	8 x D	280	341
							3794837	**SSF150FDS321539**	10 x D	350	411
36.000	1.4170	**5116032**	**KSEMP3600FDS36B1M**	13.000	**DFC inserts** DFC06T312D36 **DPA guiding pads** DPA09T4D32	36	**6123572**	**WD32FDS36092M**	1.5 x D	60	112
36.525	1.4380	**5116033**	**KSEMP1438FDS36B1**	14.000			**3950220**	**WD32FDS36166M**	3 x D	117	186
37.000	1.4570	**5116034**	**KSEMP3700FDS36B1M**	14.000			**3794430**	**WD32FDS36244M**	5 x D	195	264
37.500	1.4760	**5116035**	**KSEMP3750FDS36B1M**	15.000			**3794431**	**WD32FDS36361M**	8 x D	312	381
38.000	1.4960	**5116036**	**KSEMP3800FDS36B1M**	15.000			**3794432**	**WD32FDS36439M**	10 x D	390	459
38.100	1.5000	**5116037**	**KSEMP1500FDS36B1**	15.000			**6123584**	**SSF150FDS360362**	1.5 x D	60	112
39.000	1.5350	**5116038**	**KSEMP3900FDS36B1M**	16.000			**3952343**	**SSF150FDS360652**	3 x D	117	186
39.200	1.5430	**5116039**	**KSEMP3920FDS36B1M**	16.000			**3794838**	**SSF150FDS360960**	5 x D	195	264
39.700	1.5630	**5116040**	**KSEMP1563FDS36B1**	17.000			**3794839**	**SSF150FDS361421**	8 x D	312	381
							3794840	**SSF150FDS361728**	10 x D	390	459
40.000	1.5750	**5116041**	**KSEMP4000FDS40B1M**	17.000	**DFC inserts** DFC06T312D36 **DPA guiding pads** DPA09T4D32	40	**6123573**	**WD50FDS40100M**	1.5 x D	68	120
41.000	1.6140	**5116042**	**KSEMP4100FDS40B1M**	18.000			**3872075**	**WD50FDS40183M**	3 x D	132	208
41.275	1.6250	**5116043**	**KSEMP1625FDS40B1**	18.000			**3794443**	**WD50FDS40271M**	5 x D	220	296
42.000	1.6540	**5116044**	**KSEMP4200FDS40B1M**	19.000			**3794444**	**WD50FDS40403M**	8 x D	352	428
43.000	1.6930	**5116045**	**KSEMP4300FDS40B1M**	20.000			**3794445**	**WD50FDS40491M**	10 x D	440	516
44.000	1.7320	**5116046**	**KSEMP4400FDS40B1M**	21.000			**6123585**	**SSF200FDS400394**	1.5 x D	68	120
44.450	1.7500	**5116047**	**KSEMP1750FDS40B1**	22.000			**3952344**	**SSF200FDS400721**	3 x D	132	208
							3794841	**SSF200FDS401066**	5 x D	220	296
							3794842	**SSF200FDS401586**	8 x D	352	428
							3794903	**SSF200FDS401933**	10 x D	440	516

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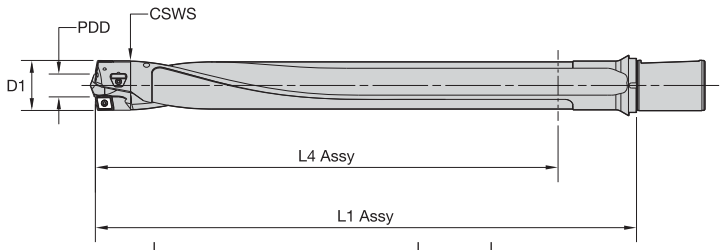
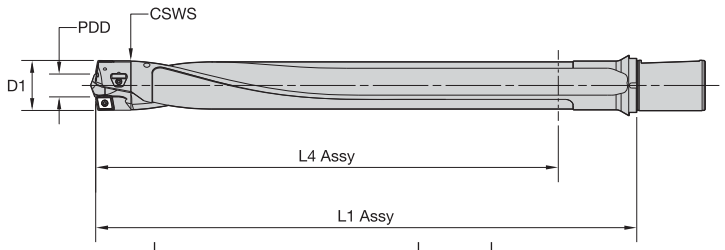
(KSEM PLUS Overview and Assembly for Systems Using B1 Heads — continued)



available KSEM PLUS heads				requested insert size reference per head			available tool bodies per CSWS connecting size 3 x D, 5 x D, 8 x D, 10 x D (metric and inch bodies)				
D1		KSEM PLUS head order number	KSEM PLUS head ANSI catalogue number	PDD (mm) centre insert size reference	outboard insert Drill Fix™ DFC DPA guiding pads	CSWS	KSEM PLUS body order number	KSEM PLUS body ANSI catalogue number	L/D ratio	L4 assembly (mm)	L1 assembly (mm)
mm	in										
45.000	1.7720	**5116098**	**KSEMP4500FDS45B1M**	18.000	**DFC inserts** DFC070416D45 **DPA guiding pads** DPA09T4D32	45	**6123575**	**WD50FDS45112M**	1.5 x D	80	142
46.000	1.8110	**5116099**	**KSEMP4600FDS45B1M**	19.000			**3872709**	**WD50FDS45206M**	3 x D	147	231
47.000	1.8500	**5116110**	**KSEMP4700FDS45B1M**	20.000			**3794446**	**WD50FDS45304M**	5 x D	245	329
47.625	1.8750	**5116111**	**KSEMP1875FDS45B1**	21.000			**3794447**	**WD50FDS45451M**	8 x D	392	476
48.000	1.8900	**5116112**	**KSEMP4800FDS45B1M**	21.000			**3794448**	**WD50FDS45549M**	10 x D	490	574
49.000	1.9290	**5116113**	**KSEMP4900FDS45B1M**	22.000			**6123586**	**SSF200FDS450441**	1.5 x D	80	142
							3952345	**SSF200FDS450809**	3 x D	147	231
							3794904	**SSF200FDS451196**	5 x D	245	329
							3794905	**SSF200FDS451775**	8 x D	392	476
							3794906	**SSF200FDS452161**	10 x D	490	574
50.000	1.9690	**5116114**	**KSEMP5000FDS50B1M**	23.000	**DFC inserts** DFC070416D45 **DPA guiding pads** DPA13T5D50	50	**6123576**	**WD50FDS50122M**	1.5 x D	84	152
50.800	2.0000	**5116115**	**KSEMP2000FDS50B1**	24.000			**3950221**	**WD50FDS50228M**	3 x D	165	258
51.000	2.0080	**5116116**	**KSEMP5100FDS50B1M**	24.000			**3794449**	**WD50FDS50338M**	5 x D	275	368
52.000	2.0470	**5116117**	**KSEMP5200FDS50B1M**	25.000			**3742294**	**WD50FDS50503M**	8 x D	440	533
53.000	2.0870	**5116118**	**KSEMP5300FDS50B1M**	26.000			**3794450**	**WD50FDS50613M**	10 x D	550	643
53.975	2.1250	**5116119**	**KSEMP2125FDS50B1**	27.000			**6123587**	**SSF200FDS500480**	1.5 x D	84	152
54.000	2.1260	**5116120**	**KSEMP5400FDS50B1M**	27.000			**3952346**	**SSF200FDS500896**	3 x D	165	258
55.000	2.1650	**5116121**	**KSEMP5500FDS50B1M**	28.000			**3794907**	**SSF200FDS501330**	5 x D	275	368
							3794908	**SSF200FDS501980**	8 x D	440	533
							3794909	**SSF200FDS502413**	10 x D	550	643
56.000	2.2050	**5116122**	**KSEMP5600FDS56B1M**	20.000	**DFC inserts** DFC090520D56 **DPA guiding pads** DPA13T5D50	56	**6123577**	**WD50FDS56140M**	1.5 x D	125	170
57.000	2.2440	**5116123**	**KSEMP5700FDS56B1M**	21.000			**3950222**	**WD50FDS56259M**	3 x D	186	289
57.150	2.2500	**5116124**	**KSEMP2250FDS56B1**	21.000			**3794451**	**WD50FDS56383M**	5 x D	310	413
58.000	2.2830	**5116125**	**KSEMP5800FDS56B1M**	22.000			**3794452**	**WD50FDS56569M**	8 x D	496	599
59.000	2.3230	**5116126**	**KSEMP5900FDS56B1M**	23.000			**3794453**	**WD50FDS56693M**	10 x D	620	723
60.000	2.3620	**5116127**	**KSEMP6000FDS56B1M**	24.000			**6123588**	**SSF200FDS560551**	1.5 x D	125	170
60.330	2.3750	**5116128**	**KSEMP2375FDS56B1**	24.000			**3952347**	**SSF200FDS561020**	3 x D	186	289
61.000	2.4020	**5116129**	**KSEMP6100FDS56B1M**	25.000			**3794910**	**SSF200FDS561507**	5 x D	310	413
62.000	2.4410	**5116130**	**KSEMP6200FDS56B1M**	26.000			**3794911**	**SSF200FDS562240**	8 x D	496	599
							3794912	**SSF200FDS562783**	10 x D	620	723
63.000	2.4800	**5116131**	**KSEMP6300FDS63B1M**	27.000	**DFC inserts** DFC090520D56 **DPA guiding pads** DPA13T5D50	63	**6123578**	**WD50FDS63154M**	1.5 x D	107	190
63.500	2.5000	**5116132**	**KSEMP2500FDS63B1**	28.000			**3950333**	**WD50FDS63289M**	3 x D	210	325
64.000	2.5200	**5116133**	**KSEMP6400FDS63B1M**	28.000			**3794454**	**WD50FDS63429M**	5 x D	350	465
65.000	2.5590	**5116134**	**KSEMP6500FDS63B1M**	29.000			**3794455**	**WD50FDS63639M**	8 x D	560	675
66.000	2.5980	**5116135**	**KSEMP6600FDS63B1M**	30.000			**3742296**	**WD50FDS63779M**	10 x D	700	815
66.680	2.6250	**5116136**	**KSEMP2625FDS63B1**	31.000			**6123589**	**SSF200FDS630606**	1.5 x D	107	190
67.000	2.6380	**5116137**	**KSEMP6700FDS63B1M**	31.000			**3952348**	**SSF200FDS631138**	3 x D	210	325
68.000	2.6770	**5116138**	**KSEMP6800FDS63B1M**	32.000			**3794913**	**SSF200FDS631688**	5 x D	350	465
69.000	2.7170	**5116139**	**KSEMP6900FDS63B1M**	33.000			**3794914**	**SSF200FDS632515**	8 x D	560	675
69.850	2.7500	**5116140**	**KSEMP2750FDS63B1**	34.000			**3794915**	**SSF200FDS633066**	10 x D	700	815
70.000	2.7560	**5116141**	**KSEMP7000FDS63B1M**	34.000							

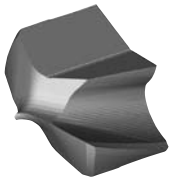
(continued)

(KSEM PLUS Overview and Assembly for Systems Using B1 Heads — continued)



available KSEM PLUS heads				requested insert size reference per head			available tool bodies per CSWS connecting size 3 x D, 5 x D, 8 x D, 10 x D (metric and inch bodies)				
D1		KSEM PLUS head order number	KSEM PLUS head ANSI catalogue number	PDD (mm) centre insert size reference	outboard insert Drill Fix™ DFC DPA guiding pads	CSWS	KSEM PLUS body order number	KSEM PLUS body ANSI catalogue number	L/D ratio	L4 assembly (mm)	L1 assembly (mm)
mm	in										
71.000	2.7950	**6041937**	**KSEMP7100FDS71B1M**	26.000	**DFC inserts** 4x DFC06T312D36 **DPA guiding pads** DPA13T5D50	71	**6123579**	**WD50FDS71172M**	1.5 x D	127	216
72.000	2.8350	**6041797**	**KSEMP7200FDS71B1M**	27.000			**5397942**	**WD50FDS71292M**	3 x D	240	332
73.000	2.8740	**6041938**	**KSEMP7300FDS71B1M**	28.000			**5397943**	**WD50FDS71452M**	5 x D	400	492
73.025	2.8750	**6042002**	**KSEMP2875FDS71B1**	28.000			**6123590**	**SSF200FDS710677**	1.5 x D	127	216
74.000	2.9130	**6041798**	**KSEMP7400FDS71B1M**	29.000			**5397948**	**SSF200FDS711150**	3 x D	240	332
75.000	2.9530	**6041939**	**KSEMP7500FDS71B1M**	30.000			**5397949**	**SSF200FDS711780**	5 x D	400	492
76.000	2.9920	**6041799**	**KSEMP7600FDS71B1M**	31.000							
77.000	3.0310	**6041940**	**KSEMP7700FDS71B1M**	32.000							
76.200	3.0000	**5397562**	**KSEMP3000FDS71B1**	31.000							
78.000	3.0710	**6041800**	**KSEMP7800FDS71B1M**	33.000							
79.000	3.1100	**6041991**	**KSEMP7900FDS71B1M**	34.000							
79.375	3.1250	**6042003**	**KSEMP3125FDS80B1**	31.000	**DFC inserts** 2x DFC06T312D36 & 2x DFC070416D45 **DPA guiding pads** DPA13T5D50	80	**6123580**	**WD50FDS80192M**	1.5 x D	144	246
80.000	3.1500	**6041881**	**KSEMP8000FDS80B1M**	31.000			**5397944**	**WD50FDS80327M**	3 x D	270	372
81.000	3.1890	**6041992**	**KSEMP8100FDS80B1M**	32.000			**5397945**	**WD50FDS80507M**	5 x D	450	552
82.000	3.2280	**6041882**	**KSEMP8200FDS80B1M**	33.000			**6123591**	**SSF200FDS800756**	1.5 x D	144	246
82.550	3.2500	**5397563**	**KSEMP3250FDS80B1**	34.000			**5398010**	**SSF200FDS801287**	3 x D	270	372
83.000	3.2680	**6041993**	**KSEMP8300FDS80B1M**	34.000			**5398011**	**SSF200FDS801996**	5 x D	450	552
84.000	3.3070	**6041883**	**KSEMP8400FDS80B1M**	35.000							
85.000	3.3460	**6041994**	**KSEMP8500FDS80B1M**	36.000							
85.725	3.3750	**6042004**	**KSEMP3375FDS80B1**	37.000							
86.000	3.3860	**6041884**	**KSEMP8600FDS80B1M**	37.000							
87.000	3.4250	**6041995**	**KSEMP8700FDS80B1M**	38.000							
88.000	3.4650	**6041885**	**KSEMP8800FDS80B1M**	39.000							
88.900	3.5000	**5397564**	**KSEMP3500FDS80B1**	40.000							
89.000	3.5040	**6041996**	**KSEMP8900FDS80B1M**	40.000							
90.000	3.5430	**6041886**	**KSEMP9000FDS90B1M**	37.000	**DFC inserts** 4x DFC070416D45 **DPA guiding pads** DPA13T5D50	90	**6123581**	**WD50FDS90212M**	1.5 x D	158	270
91.000	3.5830	**6041997**	**KSEMP9100FDS90B1M**	38.000			**5397946**	**WD50FDS90362M**	3 x D	300	412
92.000	3.6220	**6041887**	**KSEMP9200FDS90B1M**	39.000			**5397947**	**WD50FDS90562M**	5 x D	500	612
92.075	3.6250	**6042005**	**KSEMP3625FDS90B1**	39.000			**6123592**	**SSF200FDS900835**	1.5 x D	158	270
93.000	3.6610	**6041998**	**KSEMP9300FDS90B1M**	40.000			**5398012**	**SSF200FDS901425**	3 x D	300	412
							5398013	**SSF200FDS902213**	5 x D	500	612
94.000	3.7010	**6041888**	**KSEMP9400FDS90B1M**	26.000	**DFC inserts** 6x DFC06T312D36 **DPA guiding pads** DPA13T5D50						
95.000	3.7400	**6041999**	**KSEMP9500FDS90B1M**	27.000							
95.250	3.7500	**5397565**	**KSEMP3750FDS90B1**	27.000							
96.000	3.7800	**6041889**	**KSEMP9600FDS90B1M**	28.000							
97.000	3.8190	**6042000**	**KSEMP9700FDS90B1M**	29.000							
98.000	3.8580	**6041890**	**KSEMP9800FDS90B1M**	30.000							
98.425	3.8750	**6042006**	**KSEMP3875FDS90B1**	31.000							
99.000	3.8980	**6042001**	**KSEMP9900FDS90B1M**	31.000							
100.000	3.9370	**6041901**	**KSEMP10000FDS90B1M**	32.000							
101.600	4.0000	**5397566**	**KSEMP4000FDS90B1**	34.000							

- To ensure 100% system stability, KSEM™ inserts used for KSEM PLUS should not be reground.
- The callout D1 (mm) = PDD. PDD is used in reference to the KSEM PLUS heads.
- Please refer to KSEMP insert recommendation on page H106 to configure your insert setup depending on the application.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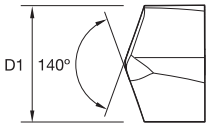
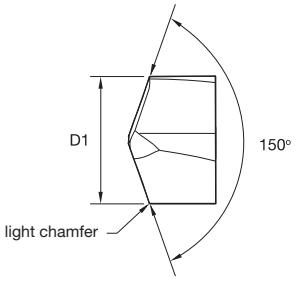


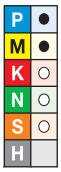
D1 (mm) = PDD

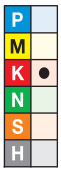

PC

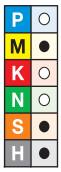


D1 (mm) = PDD

KSEM PLUS Centre Inserts







● first choice
○ alternate choice

HPG • KC7315	HPCCL • KC7410	PC • KC7135	D1 mm	D1 in	seat size
KSEMP1300HPGM	KSEM1300HPCCLM	KSEM1300PCM	13,000	.5118	C
KSEMP1400HPGM	KSEM1400HPCCLM	KSEM1400PCM	14,000	.5512	B
KSEMP1500HPGM	KSEM1500HPCCLM	KSEM1500PCM	15,000	.5906	A
KSEMP1600HPGM	KSEM1600HPCCLM	KSEM1600PCM	16,000	.6299	1
KSEMP1700HPGM	KSEM1700HPCCLM	KSEM1700PCM	17,000	.6693	1
KSEMP1800HPGM	KSEM1800HPCCLM	KSEM1800PCM	18,000	.7087	1
KSEMP1900HPGM	KSEM1900HPCCLM	KSEM1900PCM	19,000	.7480	2
KSEMP2000HPGM	KSEM2000HPCCLM	KSEM2000PCM	20,000	.7874	3
KSEMP2100HPGM	KSEM2100HPCCLM	KSEM2100PCM	21,000	.8268	3
KSEMP2200HPGM	KSEM2200HPCCLM	KSEM2200PCM	22,000	.8661	3
KSEMP2300HPGM	KSEM2300HPCCLM	KSEM2300PCM	23,000	.9055	4
KSEMP2400HPGM	KSEM2400HPCCLM	KSEM2400PCM	24,000	.9449	4
KSEMP2500HPGM	KSEM2500HPCCLM	KSEM2500PCM	25,000	.9843	5
KSEMP2600HPGM	KSEM2600HPCCLM	KSEM2600PCM	26,000	1.0236	5
KSEMP2700HPGM	KSEM2700HPCCLM	KSEM2700PCM	27,000	1.0630	6
KSEMP2800HPGM	KSEM2800HPCCLM	KSEM2800PCM	28,000	1.1024	6
KSEMP2900HPGM	KSEM2900HPCCLM	KSEM2900PCM	29,000	1.1417	7
KSEMP3000HPGM	KSEM3000HPCCLM	KSEM3000PCM	30,000	1.1811	7
KSEMP3100HPGM	KSEM3100HPCCLM	KSEM3100PCM	31,000	1.2205	8
KSEMP3200HPGM	KSEM3200HPCCLM	KSEM3200PCM	32,000	1.2598	8
KSEMP3300HPGM	KSEM3300HPCCLM	KSEM3300PCM	33,000	1.2992	9
KSEMP3400HPGM	KSEM3400HPCCLM	KSEM3400PCM	34,000	1.3386	9
KSEMP3500HPGM	KSEM3500HPCCLM	KSEM3500PCM	35,000	1.3780	9
KSEMP3600HPGM	KSEM3600HPCCLM	KSEM3600PCM	36,000	1.4173	9
KSEMP3700HPGM	KSEM3700HPCCLM	KSEM3700PCM	37,000	1.4567	10
KSEMP3800HPGM	KSEM3800HPCCLM	KSEM3800PCM	38,000	1.4961	10
KSEMP3900HPGM	KSEM3900HPCCLM	KSEM3900PCM	39,000	1.5354	10
KSEMP4000HPGM	KSEM4000HPCCLM	KSEM4000PCM	40,000	1.5748	10

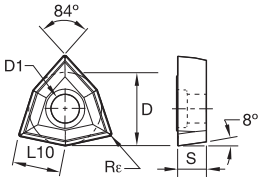
Tolerance KSEMP HPG • KSEM HPCCL • Metric

D1	tolerance h8
12,5–18	+0,000/-0,027
>18–30	+0,000/-0,033
>30–40	+0,000/-0,039

Tolerance KSEM PC • Metric

D1 metric	tolerance k7
12,5–18	+0,001/+ 0,019
>18–30	+0,002/+ 0,023
>30–40	+0,002/+ 0,027



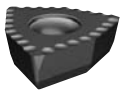


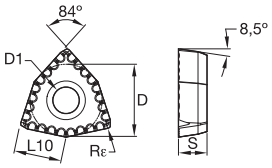
● first choice
○ alternate choice

P	●	●
M	○	○
K	●	○
N	○	○
S	○	●
H		

DFT-HP

catalogue number	L10	D	D1	S	Rε	KCU25	KCU40
DFT05T308D32HP	5,29	8,00	3,40	3,75	0,80	●	●
DFT05T308D33HP	5,29	8,00	3,40	3,75	0,80	●	●
DFT06T308D36HP	6,62	10,00	4,40	3,75	0,80	●	●
DFT06T308D39HP	6,62	10,00	4,40	3,75	0,80	●	●
DFT06T308D44HP	6,62	10,00	4,40	3,75	0,80	●	●
DFT070408D45HP	7,94	12,00	4,40	4,75	0,80	●	●
DFT070408D50HP	7,94	12,00	4,40	4,75	0,80	●	●
DFT090508D56HP	9,92	15,00	5,50	5,25	0,80	●	●
DFT090508D63HP	9,92	15,00	5,50	5,25	0,80	●	●



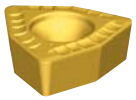


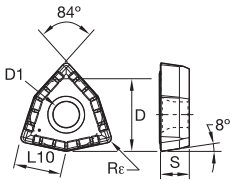
● first choice
○ alternate choice

P	●	
M	○	
K		
N	○	
S	○	
H		

DFT • DS

catalogue number	L10	D	D1	S	Rε	KCU40
DFT05T308D32DS	5,29	8,00	3,40	3,75	0,80	●
DFT05T308D33DS	5,29	8,00	3,40	3,75	0,80	●
DFT06T308D36DS	6,62	10,00	4,40	3,75	0,80	●
DFT06T308D39DS	6,62	10,00	4,40	3,75	0,80	●
DFT06T308D44DS	6,62	10,00	4,40	3,75	0,80	●
DFT070408D45DS	7,94	12,00	4,40	4,75	0,80	●
DFT070408D50DS	7,94	12,00	4,40	4,75	0,80	●
DFT090508D56DS	9,92	15,00	5,50	5,25	0,80	●
DFT090508D63DS	9,92	15,00	5,50	5,25	0,80	●





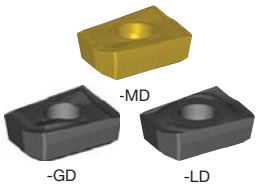
● first choice
○ alternate choice

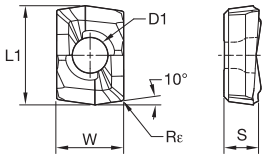
P		●
M		●
K		○
N		○
S		○
H		

DFT-MD

catalogue number	L10	D	D1	S	Rε	KC7140
DFT05T308D32MD	5,29	8,00	3,40	3,75	0,80	●
DFT05T308D33MD	5,29	8,00	3,40	3,75	0,80	●
DFT06T308D36MD	6,62	10,00	4,40	3,75	0,80	●
DFT06T308D39MD	6,62	10,00	4,40	3,75	0,80	●
DFT06T308D44MD	6,62	10,00	4,40	3,75	0,80	●
DFT070408D45MD	7,94	12,00	4,40	4,75	0,80	●
DFT070408D50MD	7,94	12,00	4,40	4,75	0,80	●
DFT090508D56MD	9,92	15,00	5,50	5,25	0,80	●
DFT090508D63MD	9,92	15,00	5,50	5,25	0,80	●

KSEM PLUS A1 Heads • Drill Fix DFR™ Inserts





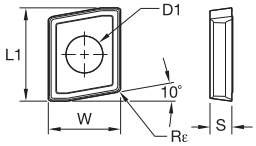
● first choice
○ alternate choice

P		●	○	●	●
M		●	○	○	○
K		○	●	●	○
N		○	●	○	○
S		○	○	○	●
H					

DFR-GD, -MD, -LD

catalogue number	LI	W	D1	S	Rε	KC7140	KC7225	KCU25	KCU40
DFR040304D28GD	10,76	7,26	2,85	3,79	0,40	–	–	●	●
DFR040304D28LD	10,76	7,26	2,85	3,78	0,40	–	●	–	–
DFR040304D28MD	10,76	7,26	2,85	3,79	0,40	●	–	–	–



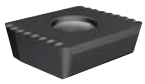


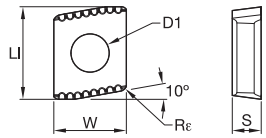
● first choice
○ alternate choice

P	●	●
M	○	○
K	●	○
N	○	●
S	○	●
H		

DFC-HP

catalogue number	LI	W	D1	S	Rε	KCU25	KCU40
DFC040310D28HP	10,00	7,60	2,85	3,18	0,50	●	●
DFC05T312D32HP	12,00	9,40	3,40	3,75	0,80	●	●
DFC06T312D36HP	16,00	12,40	4,40	3,75	0,80	●	●
DFC070416D45HP	18,00	14,50	4,40	4,75	0,80	●	●
DFC090520D56HP	24,00	19,00	5,50	5,25	0,80	●	●





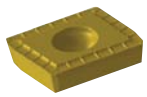
● first choice
○ alternate choice

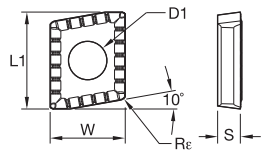
P	●	
M	○	
K	○	
N	●	
S	●	
H		

DFC-DS

NEW!

catalogue number	LI	W	D1	S	Rε	KCU40
DFC040310D28DS	10,00	7,60	2,85	3,18	0,50	●
DFC05T312D32DS	12,00	9,40	3,40	3,75	0,80	●
DFC06T312D36DS	16,00	12,40	4,40	3,75	0,80	●
DFC070416D45DS	18,00	14,50	4,40	4,75	0,80	●
DFC090520D56DS	24,00	19,00	5,50	5,25	0,80	●



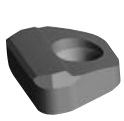


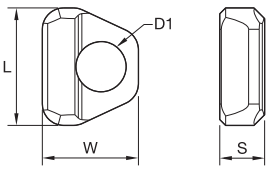
● first choice
○ alternate choice

P	●	
M	●	
K	○	
N	○	
S	○	
H		

DFC-MD

catalogue number	LI	W	D1	S	Rε	KC7140
DFC040310D28MD	10,00	7,60	2,85	3,18	0,50	●
DFC05T312D32MD	12,00	9,40	3,40	3,75	0,80	●
DFC06T312D36MD	16,00	12,40	4,40	3,75	0,80	●
DFC070416D45MD	18,00	14,50	4,40	4,75	0,80	●
DFC090520D56MD	24,00	19,00	5,50	5,25	0,80	●





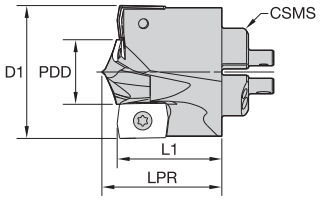
● first choice
○ alternate choice

P	●	
M	●	
K	●	
N	●	
S	●	
H		

DPA Guiding Pads

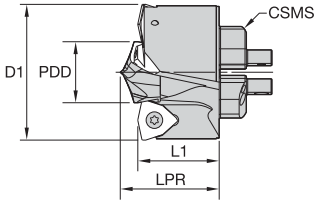
	L		W		D1		S		
catalogue number	mm	in	mm	in	mm	in	mm	in	KCU40
DPA07T3D25	8,60	.3390	7,00	.2760	2,85	.1120	3,50	.1380	●
DPA09T4D32	11,00	.4330	9,00	.3540	3,40	.1340	4,20	.1650	●
DPA13T5D50	16,00	.6300	13,00	.5120	4,40	.1730	5,20	.2050	●

- To ensure 100% system stability, KSEM™ inserts used for KSEM PLUS should not be reground.
- KSEM PLUS heads are shipped with all insert screws.
- KSEM PLUS heads are shipped with two wrenches, one for the KSEM insert and one to be used for the DFT™/DFR™ inserts as well as for the assembly of the body to the head.
- Order KSEM PLUS shanks using connection coupling size (CSMS) to determine which heads go with each shank.
- PDD in the callout drawing refers to the D1 of the KSEM HPG and HPCCL inserts for use with KSEM PLUS.
- Order inserts (KSEM, DFT, and DFR) for KSEM PLUS separately.



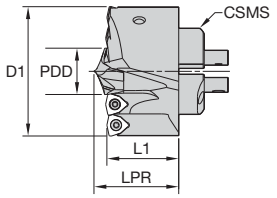


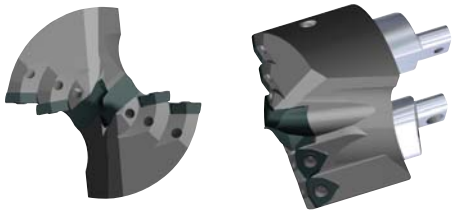
2 x DFR
diameter: 28–<31,75mm



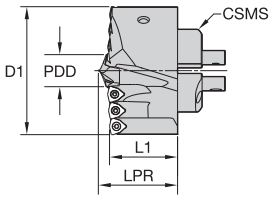


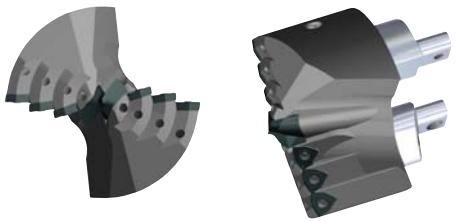
2 x DFT
diameter: 31,75–70,34mm





4 x DFT
diameter: 70,35–93,34mm





6 x DFT
diameter: 93,35–127mm

KSEM PLUS A1 Heads 28–101,60mm (1.102–4")

ISO catalogue number	ANSI catalogue number	D1		PDD		LPR		L1		CSMS system size
order number		mm	in	mm	in	mm	in	mm	in	
4000408	KSEMP2800FDS28A1M	KSEMP2800FDS28A1M	28,00	1.102	14,00	.5512	24,9	.980	22,0	.866	FDS28
4047811	KSEMP2858FDS28A1M	KSEMP1125FDS28A1	28,58	1.125	15,00	.5906	25,0	.984	22,0	.866	FDS28
4047812	KSEMP2900FDS28A1M	KSEMP2900FDS28A1M	29,00	1.142	15,00	.5906	25,0	.984	22,0	.866	FDS28
4047823	KSEMP2937FDS28A1M	KSEMP1156FDS28A1	29,36	1.156	16,00	.6299	25,2	.992	22,0	.866	FDS28
4047824	KSEMP3000FDS28A1M	KSEMP3000FDS28A1M	30,00	1.181	16,00	.6299	25,2	.992	22,0	.866	FDS28
4047825	KSEMP3017FDS28A1M	KSEMP1188FDS28A1	30,18	1.188	17,00	.6693	25,4	1.000	22,0	.866	FDS28
4047826	KSEMP3096FDS28A1M	KSEMP1219FDS28A1	30,96	1.219	17,00	.6693	25,4	1.000	22,0	.866	FDS28
4047827	KSEMP3100FDS28A1M	KSEMP3100FDS28A1M	31,00	1.221	17,00	.6693	25,4	1.000	22,0	.866	FDS28
3794916	KSEMP3175FDS32A1M	KSEMP1250FDS32A1	31,75	1.250	15,00	.5906	23,0	.907	20,0	.787	FDS32
3794291	KSEMP3200FDS32A1M	KSEMP3200FDS32A1M	32,00	1.260	15,00	.5906	23,0	.907	20,0	.787	FDS32
3742210	KSEMP3300FDS32A1M	KSEMP3300FDS32A1M	33,00	1.299	16,00	.6299	23,2	.913	20,0	.787	FDS32
3793949	KSEMP3320FDS32A1M	KSEMP3320FDS32A1M	33,20	1.307	16,00	.6299	23,2	.913	20,0	.787	FDS32
3794917	KSEMP3334FDS32A1M	KSEMP1313FDS32A1	33,35	1.313	17,00	.6693	23,4	.920	20,0	.787	FDS32
3794292	KSEMP3400FDS32A1M	KSEMP3400FDS32A1M	34,00	1.339	17,00	.6693	23,4	.920	20,0	.787	FDS32
3794918	KSEMP3493FDS32A1M	KSEMP1375FDS32A1	34,93	1.375	18,00	.7087	23,6	.928	20,0	.787	FDS32
3794393	KSEMP3500FDS32A1M	KSEMP3500FDS32A1M	35,00	1.378	18,00	.7087	23,6	.928	20,0	.787	FDS32

(continued)

(KSEM PLUS A1 Heads 28–101,60mm (1.102–4") — continued)

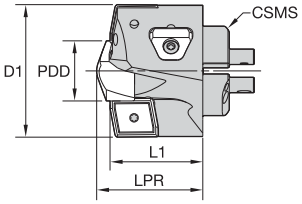
order number	ISO catalogue number	ANSI catalogue number	D1 mm	D1 in	PDD mm	PDD in	LPR mm	LPR in	L1 mm	L1 in	CSMS system size
3794394	KSEMP3600FDS36A1M	KSEMP3600FDS36A1M	36,00	1.417	13,00	.5118	22,7	.893	20,0	.787	FDS36
3794919	KSEMP3651FDS36A1M	KSEMP1438FDS36A1	36,53	1.438	14,00	.5512	22,9	.900	20,0	.787	FDS36
3794395	KSEMP3700FDS36A1M	KSEMP3700FDS36A1M	37,00	1.457	14,00	.5512	22,9	.900	20,0	.787	FDS36
3794427	KSEMP3750FDS36A1M	KSEMP3750FDS36A1M	37,50	1.476	15,00	.5906	23,0	.907	20,0	.787	FDS36
3794396	KSEMP3800FDS36A1M	KSEMP3800FDS36A1M	38,00	1.496	15,00	.5906	23,0	.907	20,0	.787	FDS36
3794920	KSEMP3810FDS36A1M	KSEMP1500FDS36A1	38,10	1.500	15,00	.5906	23,0	.907	20,0	.787	FDS36
3794397	KSEMP3900FDS36A1M	KSEMP3900FDS36A1M	39,00	1.535	16,00	.6299	23,2	.913	20,0	.787	FDS36
3793950	KSEMP3920FDS36A1M	KSEMP3920FDS36A1M	39,20	1.543	16,00	.6299	23,2	.913	20,0	.787	FDS36
3794921	KSEMP3970FDS36A1M	KSEMP1563FDS36A1	39,70	1.563	17,00	.6693	23,4	.920	20,0	.787	FDS36
3794398	KSEMP4000FDS40A1M	KSEMP4000FDS40A1M	40,00	1.575	17,00	.6693	28,6	1.125	25,0	.984	FDS40
3794399	KSEMP4100FDS40A1M	KSEMP4100FDS40A1M	41,00	1.614	18,00	.7087	28,8	1.132	25,0	.984	FDS40
3794922	KSEMP4128FDS40A1M	KSEMP1625FDS40A1	41,28	1.625	18,00	.7087	28,8	1.132	25,0	.984	FDS40
3794400	KSEMP4200FDS40A1M	KSEMP4200FDS40A1M	42,00	1.654	19,00	.7480	28,9	1.139	25,0	.984	FDS40
3794401	KSEMP4300FDS40A1M	KSEMP4300FDS40A1M	43,00	1.693	20,00	.7874	29,1	1.146	25,0	.984	FDS40
3794402	KSEMP4400FDS40A1M	KSEMP4400FDS40A1M	44,00	1.732	21,00	.8268	29,3	1.153	25,0	.984	FDS40
3794933	KSEMP4445FDS40A1M	KSEMP1750FDS40A1	44,45	1.750	22,00	.8661	29,5	1.160	25,0	.984	FDS40
3794403	KSEMP4500FDS45A1M	KSEMP4500FDS45A1M	45,00	1.772	18,00	.7087	28,8	1.132	25,0	.984	FDS45
3794404	KSEMP4600FDS45A1M	KSEMP4600FDS45A1M	46,00	1.811	19,00	.7480	28,9	1.139	25,0	.984	FDS45
3794405	KSEMP4700FDS45A1M	KSEMP4700FDS45A1M	47,00	1.850	20,00	.7874	29,1	1.146	25,0	.984	FDS45
3794934	KSEMP4763FDS45A1M	KSEMP1875FDS45A1	47,63	1.875	21,00	.8268	29,3	1.153	25,0	.984	FDS45
3794406	KSEMP4800FDS45A1M	KSEMP4800FDS45A1M	48,00	1.890	21,00	.8268	29,3	1.153	25,0	.984	FDS45
3794407	KSEMP4900FDS45A1M	KSEMP4900FDS45A1M	49,00	1.929	22,00	.8661	29,5	1.160	25,0	.984	FDS45
3742211	KSEMP5000FDS50A1M	KSEMP5000FDS50A1M	50,00	1.969	23,00	.9055	34,8	1.372	30,0	1.181	FDS50
3794935	KSEMP5080FDS50A1M	KSEMP2000FDS50A1	50,80	2.000	24,00	.9449	35,0	1.379	30,0	1.181	FDS50
3794408	KSEMP5100FDS50A1M	KSEMP5100FDS50A1M	51,00	2.008	24,00	.9449	35,0	1.379	30,0	1.181	FDS50
3794409	KSEMP5200FDS50A1M	KSEMP5200FDS50A1M	52,00	2.047	25,00	.9843	35,2	1.386	30,0	1.181	FDS50
3794410	KSEMP5300FDS50A1M	KSEMP5300FDS50A1M	53,00	2.087	26,00	1.0236	35,4	1.392	30,0	1.181	FDS50
3794936	KSEMP5398FDS50A1M	KSEMP2125FDS50A1	53,98	2.125	27,00	1.0630	35,6	1.399	30,0	1.181	FDS50
3794411	KSEMP5400FDS50A1M	KSEMP5400FDS50A1M	54,00	2.126	27,00	1.0630	35,6	1.399	30,0	1.181	FDS50
3794412	KSEMP5500FDS50A1M	KSEMP5500FDS50A1M	55,00	2.165	28,00	1.1024	35,7	1.406	30,0	1.181	FDS50
3794413	KSEMP5600FDS56A1M	KSEMP5600FDS56A1M	56,00	2.205	20,00	.7874	34,3	1.351	30,0	1.181	FDS56
3794414	KSEMP5700FDS56A1M	KSEMP5700FDS56A1M	57,00	2.244	21,00	.8268	34,5	1.358	30,0	1.181	FDS56
3794937	KSEMP5715FDS56A1M	KSEMP2250FDS56A1	57,15	2.250	21,00	.8268	34,5	1.358	30,0	1.181	FDS56
3794415	KSEMP5800FDS56A1M	KSEMP5800FDS56A1M	58,00	2.284	22,00	.8661	34,7	1.365	30,0	1.181	FDS56
3794416	KSEMP5900FDS56A1M	KSEMP5900FDS56A1M	59,00	2.323	23,00	.9055	34,8	1.372	30,0	1.181	FDS56
3794417	KSEMP6000FDS56A1M	KSEMP6000FDS56A1M	60,00	2.362	24,00	.9449	35,0	1.379	30,0	1.181	FDS56
3794938	KSEMP6033FDS56A1M	KSEMP2375FDS56A1	60,33	2.375	24,00	.9449	35,0	1.379	30,0	1.181	FDS56
3794418	KSEMP6100FDS56A1M	KSEMP6100FDS56A1M	61,00	2.402	25,00	.9843	35,2	1.386	30,0	1.181	FDS56
3794419	KSEMP6200FDS56A1M	KSEMP6200FDS56A1M	62,00	2.441	26,00	1.0236	35,4	1.392	30,0	1.181	FDS56
3794420	KSEMP6300FDS63A1M	KSEMP6300FDS63A1M	63,00	2.480	27,00	1.0630	41,8	1.643	36,0	1.417	FDS63
3794939	KSEMP6350FDS63A1M	KSEMP2500FDS63A1	63,50	2.500	28,00	1.1024	41,9	1.650	36,0	1.417	FDS63
3794421	KSEMP6400FDS63A1M	KSEMP6400FDS63A1M	64,00	2.520	28,00	1.1024	41,9	1.650	36,0	1.417	FDS63
3794422	KSEMP6500FDS63A1M	KSEMP6500FDS63A1M	65,00	2.559	29,00	1.1417	42,1	1.657	36,0	1.417	FDS63
3794423	KSEMP6600FDS63A1M	KSEMP6600FDS63A1M	66,00	2.598	30,00	1.1811	42,3	1.664	36,0	1.417	FDS63
3794940	KSEMP6668FDS63A1M	KSEMP2625FDS63A1	66,68	2.625	31,00	1.2205	42,5	1.671	36,0	1.417	FDS63
3794424	KSEMP6700FDS63A1M	KSEMP6700FDS63A1M	67,00	2.638	31,00	1.2205	42,5	1.671	36,0	1.417	FDS63
3794425	KSEMP6800FDS63A1M	KSEMP6800FDS63A1M	68,00	2.677	32,00	1.2598	42,6	1.678	36,0	1.417	FDS63
3794426	KSEMP6900FDS63A1M	KSEMP6900FDS63A1M	69,00	2.717	33,00	1.2992	42,8	1.685	36,0	1.417	FDS63
3794941	KSEMP6985FDS63A1M	KSEMP2750FDS63A1	69,85	2.750	34,00	1.3386	43,0	1.692	36,0	1.417	FDS63
3742212	KSEMP7000FDS63A1M	KSEMP7000FDS63A1M	70,00	2.756	34,00	1.3386	43,0	1.692	36,0	1.417	FDS63
6041904	KSEMP7100FDS71A1M	KSEMP7100FDS71A1M	71,00	2.795	26,00	1.0240	46,8	1.842	46,8	1.842	FDS71
5397513	KSEMP7200FDS71A1M	KSEMP7200FDS71A1M	72,00	2.835	27,00	1.0630	47,0	1.849	47,0	1.849	FDS71
6041906	KSEMP7300FDS71A1M	KSEMP7300FDS71A1M	73,00	2.874	28,00	1.1020	47,1	1.855	47,1	1.855	FDS71
6041931	KSEMP7303FDS71A1M	KSEMP2875FDS71A1	73,03	2.875	28,00	1.1020	47,1	1.855	47,1	1.855	FDS71
5397514	KSEMP7400FDS71A1M	KSEMP7400FDS71A1M	74,00	2.913	29,00	1.1420	47,3	1.863	47,3	1.863	FDS71
6041907	KSEMP7500FDS71A1M	KSEMP7500FDS71A1M	75,00	2.953	30,00	1.1810	47,5	1.869	47,5	1.869	FDS71

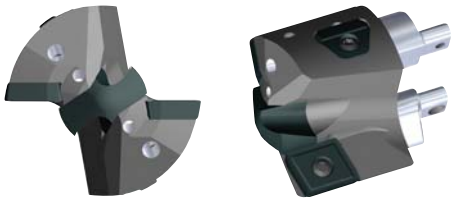
(continued)

(KSEM PLUS A1 Heads 28–101,60mm (1.102–4") — continued)

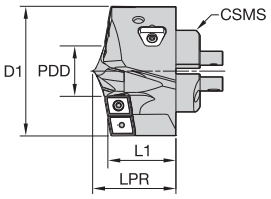
order number	ISO catalogue number	ANSI catalogue number	D1 mm	D1 in	PDD mm	PDD in	LPR mm	LPR in	L1 mm	L1 in	CSMS system size
5397515	KSEMP7600FDS71A1M	KSEMP7600FDS71A1M	76,00	2.992	31,00	1.2200	47,7	1.876	47,7	1.876	FDS71
5397516	KSEMP7620FDS71A1M	KSEMP3000FDS71A1	76,20	3.000	31,00	1.2200	47,7	1.876	47,7	1.876	FDS71
6041908	KSEMP7700FDS71A1M	KSEMP7700FDS71A1M	77,00	3.031	32,00	1.2600	47,8	1.883	47,8	1.883	FDS71
5397517	KSEMP7800FDS71A1M	KSEMP7800FDS71A1M	78,00	3.071	33,00	1.2990	48,0	1.890	48,0	1.890	FDS71
6041909	KSEMP7900FDS71A1M	KSEMP7900FDS71A1M	79,00	3.110	34,00	1.3390	48,2	1.897	48,2	1.897	FDS71
6041932	KSEMP7938FDS80A1M	KSEMP3125FDS80A1	79,38	3.125	31,00	1.2200	52,8	2.077	52,8	2.077	FDS80
5397518	KSEMP8000FDS80A1M	KSEMP8000FDS80A1M	80,00	3.150	31,00	1.2200	52,8	2.077	52,8	2.077	FDS80
6041910	KSEMP8100FDS80A1M	KSEMP8100FDS80A1M	81,00	3.189	32,00	1.2600	52,9	2.085	52,9	2.085	FDS80
5397519	KSEMP8200FDS80A1M	KSEMP8200FDS80A1M	82,00	3.228	33,00	1.2992	53,1	2.091	53,1	2.091	FDS80
5397550	KSEMP8255FDS80A1M	KSEMP3250FDS80A1	82,55	3.250	34,00	1.3386	53,3	2.098	53,3	2.098	FDS80
6041921	KSEMP8300FDS80A1M	KSEMP8300FDS80A1M	83,00	3.268	34,00	1.3390	53,3	2.098	53,3	2.098	FDS80
5397551	KSEMP8400FDS80A1M	KSEMP8400FDS80A1M	84,00	3.307	35,00	1.3780	53,5	2.105	53,5	2.105	FDS80
6041922	KSEMP8500FDS80A1M	KSEMP8500FDS80A1M	85,00	3.346	36,00	1.4170	53,6	2.112	53,6	2.112	FDS80
6041933	KSEMP8573FDS80A1M	KSEMP3375FDS80A1	85,73	3.375	37,00	1.4570	53,8	2.119	53,8	2.119	FDS80
5397552	KSEMP8600FDS80A1M	KSEMP8600FDS80A1M	86,00	3.386	37,00	1.4567	53,8	2.119	53,8	2.119	FDS80
6041923	KSEMP8700FDS80A1M	KSEMP8700FDS80A1M	87,00	3.425	38,00	1.4960	54,0	2.126	54,0	2.126	FDS80
5397553	KSEMP8800FDS80A1M	KSEMP8800FDS80A1M	88,00	3.465	39,00	1.5354	54,2	2.133	54,2	2.133	FDS80
5397554	KSEMP8890FDS80A1M	KSEMP3500FDS80A1	88,90	3.500	40,00	1.5748	54,3	2.140	54,3	2.140	FDS80
6041924	KSEMP8900FDS80A1M	KSEMP8900FDS80A1M	89,00	3.504	40,00	1.5750	54,3	2.140	54,3	2.140	FDS80
5397555	KSEMP9000FDS90A1M	KSEMP9000FDS90A1M	90,00	3.543	37,00	1.4567	59,2	2.332	59,2	2.332	FDS90
6041925	KSEMP9100FDS90A1M	KSEMP9100FDS90A1M	91,00	3.583	38,00	1.4960	59,4	2.339	59,4	2.339	FDS90
5397556	KSEMP9200FDS90A1M	KSEMP9200FDS90A1M	92,00	3.622	39,00	1.5354	59,6	2.346	59,6	2.346	FDS90
6041934	KSEMP9208FDS90A1M	KSEMP3625FDS90A1	92,08	3.625	39,00	1.5350	59,6	2.346	59,6	2.346	FDS90
6041926	KSEMP9300FDS90A1M	KSEMP9300FDS90A1M	93,00	3.661	40,00	1.5750	59,7	2.352	59,7	2.352	FDS90
5397557	KSEMP9400FDS90A1M	KSEMP9400FDS90A1M	94,00	3.701	26,00	1.0236	58,0	2.283	58,0	2.283	FDS90
6041927	KSEMP9500FDS90A1M	KSEMP9500FDS90A1M	95,00	3.740	27,00	1.0630	58,2	2.290	58,2	2.290	FDS90
5397558	KSEMP9525FDS90A1M	KSEMP3750FDS90A1	95,25	3.750	27,00	1.0630	58,3	2.297	58,3	2.297	FDS90
5397559	KSEMP9600FDS90A1M	KSEMP9600FDS90A1M	96,00	3.780	28,00	1.1024	58,3	2.297	58,3	2.297	FDS90
6041928	KSEMP9700FDS90A1M	KSEMP9700FDS90A1M	97,00	3.819	29,00	1.1420	58,5	2.304	58,5	2.304	FDS90
5397560	KSEMP9800FDS90A1M	KSEMP9800FDS90A1M	98,00	3.858	30,00	1.1811	58,7	2.311	58,7	2.311	FDS90
6041935	KSEMP9843FDS90A1M	KSEMP3875FDS90A1	98,43	3.875	31,00	1.2200	58,9	2.317	58,9	2.317	FDS90
6041929	KSEMP9900FDS90A1M	KSEMP9900FDS90A1M	99,00	3.898	31,00	1.2200	58,9	2.317	58,9	2.317	FDS90
6041930	KSEMP10000FDS90A1M	KSEMP10000FDS90A1M	100,00	3.937	32,00	1.2600	59,0	2.324	59,0	2.324	FDS90
5397561	KSEMP10160FDS90A1M	KSEMP4000FDS90A1	101,60	4.000	34,00	1.3390	59,4	2.338	59,4	2.338	FDS90

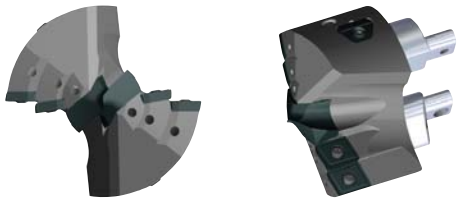
- To ensure 100% system stability, KSEM™ inserts used for KSEM PLUS should not be reground.
- KSEM PLUS heads are shipped with all insert screws.
- KSEM PLUS B1 heads are shipped with two or three wrenches, one for the KSEM insert, one for DFC™ inserts and DPA guiding pads, as well as for assembling the head onto the tool body. One additional wrench might be added depending on the size of the guiding pad.
- Order KSEM PLUS shanks using connection coupling size (CSMS) to determine which heads go with each shank.
- PDD in the callout drawing refers to the D1 of the KSEM, HPGM, and HPCM inserts for use with KSEM PLUS.
- Order inserts (KSEM, DFC) for KSEM PLUS separately.



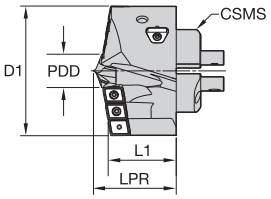


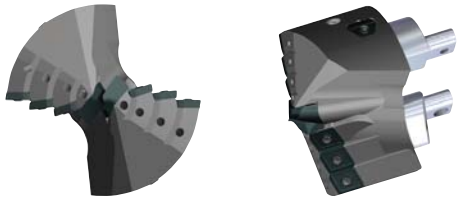
2 x DFC
diameter: 28–70,34mm





4 x DFC
diameter: 70,35–93,34mm





6 x DFC
diameter: 93,35–127mm

KSEM PLUS B1 Heads 28–101,60mm (1.102–4")

order number	ISO catalogue number	ANSI catalogue number	D1		PDD		LPR		L1		CSMS system size
			mm	in	mm	in	mm	in	mm	in	
5115736	KSEMP2800FDS28B1M	KSEMP2800FDS28B1M	28,00	1.102	14,00	.5512	28,1	1.105	25,0	.984	FDS28
5115737	KSEMP2858FDS28B1M	KSEMP1125FDS28B1	28,58	1.125	15,00	.5906	28,2	1.110	25,0	.984	FDS28
5115738	KSEMP2900FDS28B1M	KSEMP2900FDS28B1M	29,00	1.142	15,00	.5906	28,2	1.111	25,0	.984	FDS28
5115739	KSEMP2937FDS28B1M	KSEMP1156FDS28B1	29,36	1.156	16,00	.6299	28,4	1.118	25,0	.984	FDS28
5116010	KSEMP3000FDS28B1M	KSEMP3000FDS28B1M	30,00	1.181	16,00	.6299	28,4	1.118	25,0	.984	FDS28
5116011	KSEMP3017FDS28B1M	KSEMP1188FDS28B1	30,18	1.188	17,00	.6693	28,6	1.125	25,0	.984	FDS28
5116012	KSEMP3096FDS28B1M	KSEMP1219FDS28B1	30,96	1.219	17,00	.6693	28,6	1.125	25,0	.984	FDS28
5116013	KSEMP3100FDS28B1M	KSEMP3100FDS28B1M	31,00	1.220	17,00	.6693	28,6	1.125	25,0	.984	FDS28
5116014	KSEMP3175FDS32B1M	KSEMP1250FDS32B1	31,75	1.250	15,00	.5906	28,2	1.111	25,0	.984	FDS32
5116015	KSEMP3200FDS32B1M	KSEMP3200FDS32B1M	32,00	1.260	15,00	.5906	28,2	1.111	25,0	.984	FDS32
5116016	KSEMP3300FDS32B1M	KSEMP3300FDS32B1M	33,00	1.299	16,00	.6299	28,4	1.118	25,0	.984	FDS32
5116017	KSEMP3320FDS32B1M	KSEMP3320FDS32B1M	33,20	1.307	16,00	.6299	28,4	1.118	25,0	.984	FDS32
5116018	KSEMP3334FDS32B1M	KSEMP1313FDS32B1	33,35	1.313	17,00	.6693	28,6	1.125	25,0	.984	FDS32
5116019	KSEMP3400FDS32B1M	KSEMP3400FDS32B1M	34,00	1.339	17,00	.6693	28,6	1.125	25,0	.984	FDS32
5116030	KSEMP3493FDS32B1M	KSEMP1375FDS32B1	34,93	1.375	18,00	.7087	28,8	1.132	25,0	.984	FDS32
5116031	KSEMP3500FDS32B1M	KSEMP3500FDS32B1M	35,00	1.378	18,00	.7087	28,8	1.132	25,0	.984	FDS32
5116032	KSEMP3600FDS36B1M	KSEMP3600FDS36B1M	36,00	1.417	13,00	.5118	27,9	1.098	25,0	.984	FDS36
5116033	KSEMP3651FDS36B1M	KSEMP1438FDS36B1	36,53	1.438	14,00	.5512	28,1	1.105	25,0	.984	FDS36
5116034	KSEMP3700FDS36B1M	KSEMP3700FDS36B1M	37,00	1.457	14,00	.5512	28,1	1.105	25,0	.984	FDS36
5116035	KSEMP3750FDS36B1M	KSEMP3750FDS36B1M	37,50	1.476	15,00	.5906	28,2	1.111	25,0	.984	FDS36

(continued)

(KSEM PLUS B1 Heads 28–101,60mm (1.102–4") — continued)

order number	ISO catalogue number	ANSI catalogue number	D1		PDD		LPR		L1		CSMS system size
			mm	in	mm	in	mm	in	mm	in	
5116036	KSEMP3800FDS36B1M	KSEMP3800FDS36B1M	38,00	1.496	15,00	.5906	28,2	1.111	25,0	.984	FDS36
5116037	KSEMP3810FDS36B1M	KSEMP1500FDS36B1	38,10	1.500	15,00	.5906	28,2	1.111	25,0	.984	FDS36
5116038	KSEMP3900FDS36B1M	KSEMP3900FDS36B1M	39,00	1.535	16,00	.6299	28,4	1.118	25,0	.984	FDS36
5116039	KSEMP3920FDS36B1M	KSEMP3920FDS36B1M	39,20	1.543	16,00	.6299	28,4	1.118	25,0	.984	FDS36
5116040	KSEMP3970FDS36B1M	KSEMP1563FDS36B1	39,70	1.563	17,00	.6693	28,6	1.125	25,0	.984	FDS36
5116041	KSEMP4000FDS40B1M	KSEMP4000FDS40B1M	40,00	1.575	17,00	.6693	33,8	1.330	30,0	1.181	FDS40
5116042	KSEMP4100FDS40B1M	KSEMP4100FDS40B1M	41,00	1.614	18,00	.7087	34,0	1.337	30,0	1.181	FDS40
5116043	KSEMP4128FDS40B1M	KSEMP1625FDS40B1	41,28	1.625	18,00	.7087	34,0	1.337	30,0	1.181	FDS40
5116044	KSEMP4200FDS40B1M	KSEMP4200FDS40B1M	42,00	1.654	19,00	.7480	34,1	1.344	30,0	1.181	FDS40
5116045	KSEMP4300FDS40B1M	KSEMP4300FDS40B1M	43,00	1.693	20,00	.7874	34,3	1.351	30,0	1.181	FDS40
5116046	KSEMP4400FDS40B1M	KSEMP4400FDS40B1M	44,00	1.732	21,00	.8268	34,5	1.358	30,0	1.181	FDS40
5116047	KSEMP4445FDS40B1M	KSEMP1750FDS40B1	44,45	1.750	22,00	.8661	34,7	1.365	30,0	1.181	FDS40
5116098	KSEMP4500FDS45B1M	KSEMP4500FDS45B1M	45,00	1.772	18,00	.7087	34,0	1.337	30,0	1.181	FDS45
5116099	KSEMP4600FDS45B1M	KSEMP4600FDS45B1M	46,00	1.811	19,00	.7480	34,1	1.344	30,0	1.181	FDS45
5116110	KSEMP4700FDS45B1M	KSEMP4700FDS45B1M	47,00	1.850	20,00	.7874	34,3	1.351	30,0	1.181	FDS45
5116111	KSEMP4763FDS45B1M	KSEMP1875FDS45B1	47,63	1.875	21,00	.8268	34,5	1.358	30,0	1.181	FDS45
5116112	KSEMP4800FDS45B1M	KSEMP4800FDS45B1M	48,00	1.890	21,00	.8268	34,5	1.358	30,0	1.181	FDS45
5116113	KSEMP4900FDS45B1M	KSEMP4900FDS45B1M	49,00	1.929	22,00	.8661	34,7	1.365	30,0	1.181	FDS45
5116114	KSEMP5000FDS50B1M	KSEMP5000FDS50B1M	50,00	1.969	23,00	.9055	40,0	1.577	35,0	1.378	FDS50
5116115	KSEMP5080FDS50B1M	KSEMP2000FDS50B1	50,80	2.000	24,00	.9449	40,2	1.584	35,0	1.378	FDS50
5116116	KSEMP5100FDS50B1M	KSEMP5100FDS50B1M	51,00	2.008	24,00	.9449	40,2	1.584	35,0	1.378	FDS50
5116117	KSEMP5200FDS50B1M	KSEMP5200FDS50B1M	52,00	2.047	25,00	.9843	40,4	1.590	35,0	1.378	FDS50
5116118	KSEMP5300FDS50B1M	KSEMP5300FDS50B1M	53,00	2.087	26,00	1.0236	40,6	1.597	35,0	1.378	FDS50
5116119	KSEMP5398FDS50B1M	KSEMP2125FDS50B1	53,98	2.125	27,00	1.0630	40,8	1.604	35,0	1.378	FDS50
5116120	KSEMP5400FDS50B1M	KSEMP5400FDS50B1M	54,00	2.126	27,00	1.0630	40,8	1.604	35,0	1.378	FDS50
5116121	KSEMP5500FDS50B1M	KSEMP5500FDS50B1M	55,00	2.165	28,00	1.1024	40,9	1.611	35,0	1.378	FDS50
5116122	KSEMP5600FDS56B1M	KSEMP5600FDS56B1M	56,00	2.205	20,00	.7874	39,5	1.556	35,0	1.378	FDS56
5116123	KSEMP5700FDS56B1M	KSEMP5700FDS56B1M	57,00	2.244	21,00	.8268	39,7	1.563	35,0	1.378	FDS56
5116124	KSEMP5715FDS56B1M	KSEMP2250FDS56B1	57,15	2.250	21,00	.8268	39,7	1.563	35,0	1.378	FDS56
5116125	KSEMP5800FDS56B1M	KSEMP5800FDS56B1M	58,00	2.283	22,00	.8661	39,9	1.570	35,0	1.378	FDS56
5116126	KSEMP5900FDS56B1M	KSEMP5900FDS56B1M	59,00	2.323	23,00	.9055	40,0	1.577	35,0	1.378	FDS56
5116127	KSEMP6000FDS56B1M	KSEMP6000FDS56B1M	60,00	2.362	24,00	.9449	40,2	1.584	35,0	1.378	FDS56
5116128	KSEMP6033FDS56B1M	KSEMP2375FDS56B1	60,33	2.375	24,00	.9449	40,2	1.584	35,0	1.378	FDS56
5116129	KSEMP6100FDS56B1M	KSEMP6100FDS56B1M	61,00	2.402	25,00	.9843	40,4	1.590	35,0	1.378	FDS56
5116130	KSEMP6200FDS56B1M	KSEMP6200FDS56B1M	62,00	2.441	26,00	1.0236	40,6	1.597	35,0	1.378	FDS56
5116131	KSEMP6300FDS63B1M	KSEMP6300FDS63B1M	63,00	2.480	27,00	1.0630	46,0	1.809	40,0	1.575	FDS63
5116132	KSEMP6350FDS63B1M	KSEMP2500FDS63B1	63,50	2.500	28,00	1.1024	46,1	1.816	40,0	1.575	FDS63
5116133	KSEMP6400FDS63B1M	KSEMP6400FDS63B1M	64,00	2.520	28,00	1.1024	46,1	1.816	40,0	1.575	FDS63
5116134	KSEMP6500FDS63B1M	KSEMP6500FDS63B1M	65,00	2.559	29,00	1.1417	46,3	1.823	40,0	1.575	FDS63
5116135	KSEMP6600FDS63B1M	KSEMP6600FDS63B1M	66,00	2.598	30,00	1.1811	46,5	1.830	40,0	1.575	FDS63
5116136	KSEMP6668FDS63B1M	KSEMP2625FDS63B1	66,68	2.625	31,00	1.2205	46,7	1.837	40,0	1.575	FDS63
5116137	KSEMP6700FDS63B1M	KSEMP6700FDS63B1M	67,00	2.638	31,00	1.2205	46,7	1.837	40,0	1.575	FDS63
5116138	KSEMP6800FDS63B1M	KSEMP6800FDS63B1M	68,00	2.677	32,00	1.2598	46,8	1.844	40,0	1.575	FDS63
5116139	KSEMP6900FDS63B1M	KSEMP6900FDS63B1M	69,00	2.717	33,00	1.2992	47,0	1.851	40,0	1.575	FDS63
5116140	KSEMP6985FDS63B1M	KSEMP2750FDS63B1	69,85	2.750	34,00	1.3386	47,2	1.858	40,0	1.575	FDS63
5116141	KSEMP7000FDS63B1M	KSEMP7000FDS63B1M	70,00	2.756	34,00	1.3386	47,2	1.858	40,0	1.575	FDS63
6041937	KSEMP7100FDS71B1M	KSEMP7100FDS71B1M	71,00	2.795	26,00	1.0240	47,9	1.885	40,0	1.575	FDS71
6041797	KSEMP7200FDS71B1M	KSEMP7200FDS71B1M	72,00	2.835	27,00	1.0630	48,1	1.892	40,0	1.575	FDS71
6041938	KSEMP7300FDS71B1M	KSEMP7300FDS71B1M	73,00	2.874	28,00	1.1020	48,2	1.899	40,0	1.575	FDS71
6042002	KSEMP7303FDS71B1M	KSEMP2875FDS71B1	73,03	2.875	28,00	1.1020	48,2	1.899	40,0	1.575	FDS71
6041798	KSEMP7400FDS71B1M	KSEMP7400FDS71B1M	74,00	2.913	29,00	1.1420	48,4	1.906	40,0	1.575	FDS71
6041939	KSEMP7500FDS71B1M	KSEMP7500FDS71B1M	75,00	2.953	30,00	1.1810	48,6	1.913	40,0	1.575	FDS71
6041799	KSEMP7600FDS71B1M	KSEMP7600FDS71B1M	76,00	2.992	31,00	1.2200	48,8	1.919	40,0	1.575	FDS71
5397562	KSEMP7620FDS71B1M	KSEMP3000FDS71B1	76,20	3.000	31,00	1.2200	48,8	1.919	48,8	1.919	FDS71
6041940	KSEMP7700FDS71B1M	KSEMP7700FDS71B1M	77,00	3.031	32,00	1.2600	48,9	1.927	40,0	1.575	FDS71
6041800	KSEMP7800FDS71B1M	KSEMP7800FDS71B1M	78,00	3.071	33,00	1.2990	49,1	1.933	40,0	1.575	FDS71

(continued)

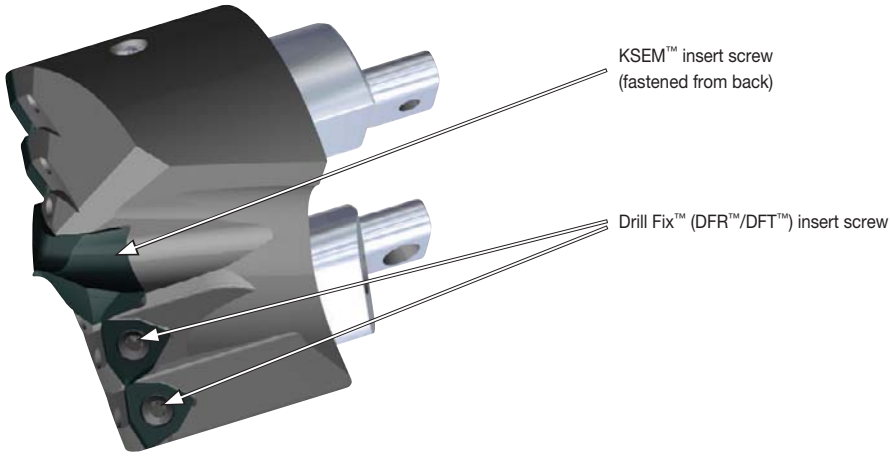
(KSEM PLUS B1 Heads 28–101,60mm (1.102–4") — continued)

order number	ISO catalogue number	ANSI catalogue number	D1		PDD		LPR		L1		CSMS system size
			mm	in	mm	in	mm	in	mm	in	
6041991	**KSEMP7900FDS71B1M**	**KSEMP7900FDS71B1M**	79,00	3.110	34,00	1.3390	49,3	1.940	40,0	1.575	FDS71
6042003	**KSEMP7938FDS80B1M**	**KSEMP3125FDS80B1**	79,38	3.125	31,00	1.2200	54,1	2.128	45,0	1.772	FDS80
6041881	**KSEMP8000FDS80B1M**	**KSEMP8000FDS80B1M**	80,00	3.150	31,00	1.2200	54,1	2.128	45,0	1.772	FDS80
6041992	**KSEMP8100FDS80B1M**	**KSEMP8100FDS80B1M**	81,00	3.189	32,00	1.2600	54,2	2.135	45,0	1.772	FDS80
6041882	**KSEMP8200FDS80B1M**	**KSEMP8200FDS80B1M**	82,00	3.228	33,00	1.2990	54,4	2.142	45,0	1.772	FDS80
5397563	**KSEMP8255FDS80B1M**	**KSEMP3250FDS80B1**	82,55	3.250	34,00	1.3386	54,6	2.149	54,6	2.149	FDS80
6041993	**KSEMP8300FDS80B1M**	**KSEMP8300FDS80B1M**	83,00	3.268	34,00	1.3390	54,6	2.149	45,0	1.772	FDS80
6041883	**KSEMP8400FDS80B1M**	**KSEMP8400FDS80B1M**	84,00	3.307	35,00	1.3780	54,8	2.156	45,0	1.772	FDS80
6041994	**KSEMP8500FDS80B1M**	**KSEMP8500FDS80B1M**	85,00	3.346	36,00	1.4170	54,9	2.163	45,0	1.772	FDS80
6042004	**KSEMP8573FDS80B1M**	**KSEMP3375FDS80B1**	85,73	3.375	37,00	1.4570	55,1	2.170	45,0	1.772	FDS80
6041884	**KSEMP8600FDS80B1M**	**KSEMP8600FDS80B1M**	86,00	3.386	37,00	1.4570	55,1	2.170	45,0	1.772	FDS80
6041995	**KSEMP8700FDS80B1M**	**KSEMP8700FDS80B1M**	87,00	3.425	38,00	1.4960	55,3	2.177	45,0	1.772	FDS80
6041885	**KSEMP8800FDS80B1M**	**KSEMP8800FDS80B1M**	88,00	3.465	39,00	1.5350	55,5	2.184	45,0	1.772	FDS80
5397564	**KSEMP8890FDS80B1M**	**KSEMP3500FDS80B1**	88,90	3.500	40,00	1.5748	55,6	2.190	55,6	2.190	FDS80
6041996	**KSEMP8900FDS80B1M**	**KSEMP8900FDS80B1M**	89,00	3.504	40,00	1.5750	55,6	2.190	45,0	1.772	FDS80
6041886	**KSEMP9000FDS90B1M**	**KSEMP9000FDS90B1M**	90,00	3.543	37,00	1.4570	60,3	2.375	50,0	1.969	FDS90
6041997	**KSEMP9100FDS90B1M**	**KSEMP9100FDS90B1M**	91,00	3.583	38,00	1.4960	60,5	2.382	50,0	1.969	FDS90
6041887	**KSEMP9200FDS90B1M**	**KSEMP9200FDS90B1M**	92,00	3.622	39,00	1.5350	60,7	2.389	50,0	1.969	FDS90
6042005	**KSEMP9208FDS90B1M**	**KSEMP3625FDS90B1**	92,08	3.625	39,00	1.5350	60,7	2.389	50,0	1.969	FDS90
6041998	**KSEMP9300FDS90B1M**	**KSEMP9300FDS90B1M**	93,00	3.661	40,00	1.5750	60,8	2.395	50,0	1.969	FDS90
6041888	**KSEMP9400FDS90B1M**	**KSEMP9400FDS90B1M**	94,00	3.701	26,00	1.0240	60,4	2.376	50,0	1.968	FDS90
6041999	**KSEMP9500FDS90B1M**	**KSEMP9500FDS90B1M**	95,00	3.740	27,00	1.0630	60,6	2.383	50,0	1.968	FDS90
5397565	**KSEMP9525FDS90B1M**	**KSEMP3750FDS90B1**	95,25	3.750	27,00	1.0630	60,6	2.383	60,6	2.383	FDS90
6041889	**KSEMP9600FDS90B1M**	**KSEMP9600FDS90B1M**	96,00	3.780	28,00	1.1020	60,7	2.390	50,0	1.968	FDS90
6042000	**KSEMP9700FDS90B1M**	**KSEMP9700FDS90B1M**	97,00	3.819	29,00	1.1420	60,9	2.398	50,0	1.968	FDS90
6041890	**KSEMP9800FDS90B1M**	**KSEMP9800FDS90B1M**	98,00	3.858	30,00	1.1810	61,1	2.404	50,0	1.968	FDS90
6042006	**KSEMP9843FDS90B1M**	**KSEMP3875FDS90B1**	98,43	3.875	31,00	1.2200	61,3	2.411	50,0	1.968	FDS90
6042001	**KSEMP9900FDS90B1M**	**KSEMP9900FDS90B1M**	99,00	3.898	31,00	1.2200	61,3	2.412	50,0	1.969	FDS90
6041901	**KSEMP10000FDS90B1M**	**KSEMP10000FDS90B1M**	100,00	3.937	32,00	1.2600	61,4	2.418	50,0	1.968	FDS90
5397566	**KSEMP10160FDS90B1M**	**KSEMP4000FDS90B1**	101,60	4.000	34,00	1.3390	61,8	2.432	61,8	2.432	FDS90

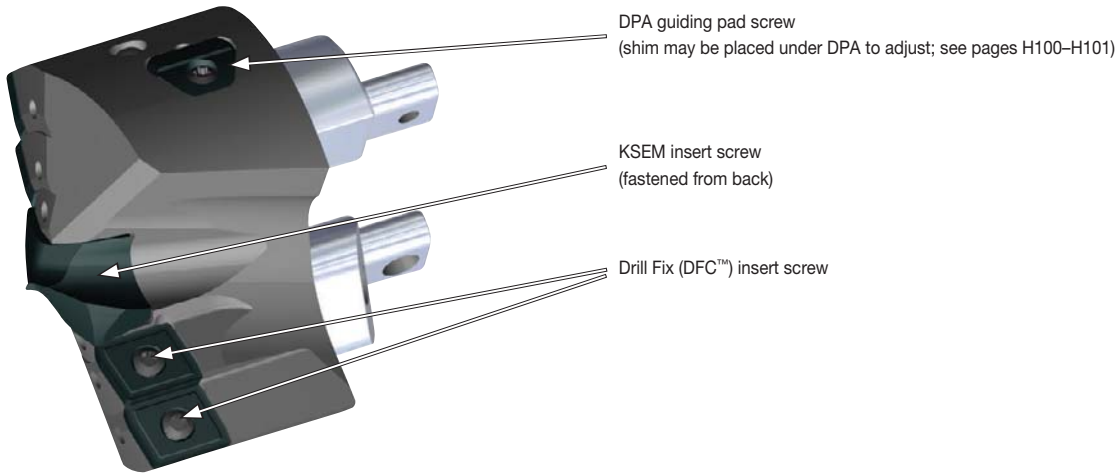
NOTE: When one screw is listed, it is for both insert and guiding pad. When two screws are listed, the first one is for the insert screw, and the second one is for the guiding pad. Find complete KSEM PLUS B1 product overview on pages H84-H86.

- The following pages consolidate required spare parts for KSEM PLUS heads.
- Tables show each spare part followed by required screw driver (if applicable).
- Adjustment shims for DPA guide pads on KSEM PLUS B1 heads come as easy-to-use shim packs.
- Please find reference for spare part location below.

KSEM PLUS A1 Heads • Spare Parts



KSEM PLUS B1 Heads • Spare Parts



KSEM PLUS A1 Heads 28–101,60mm (1.102–4") • Spare Parts

D1		PDD						
mm	in	mm	in	CSMS system size	KSEM insert screw	KSEM wrench	Drill Fix insert screw	Drill Fix wrench
28,00	1.102	14,00	.551	FDS28	364.016	170.350	192.432	170.352
28,58	1.125	15,00	.591	FDS28	364.016	170.350	192.432	170.352
29,00	1.142	15,00	.591	FDS28	364.016	170.350	192.432	170.352
29,36	1.156	16,00	.630	FDS28	364.010	170.345	192.432	170.352
30,00	1.181	16,00	.630	FDS28	364.010	170.345	192.432	170.352
30,18	1.188	17,00	.669	FDS28	364.010	170.345	192.432	170.352
30,96	1.219	17,00	.669	FDS28	364.010	170.345	192.432	170.352
31,00	1.221	17,00	.669	FDS28	364.010	170.345	192.432	170.352
31,75	1.250	15,00	.591	FDS32	364.016	170.350	191.924	170.353
32,00	1.260	15,00	.591	FDS32	364.016	170.350	191.924	170.353
33,00	1.299	16,00	.630	FDS32	364.010	170.345	191.924	170.353
33,20	1.307	16,00	.630	FDS32	364.010	170.345	191.924	170.353
33,35	1.313	17,00	.669	FDS32	364.010	170.345	191.924	170.353
34,00	1.339	17,00	.669	FDS32	364.010	170.345	191.924	170.353
34,93	1.375	18,00	.709	FDS32	364.010	170.345	191.924	170.353
35,00	1.378	18,00	.709	FDS32	364.010	170.345	191.924	170.353
36,00	1.417	13,00	.512	FDS36	364.016	170.350	191.916	170.355
36,53	1.438	14,00	.551	FDS36	364.016	170.350	191.916	170.355
37,00	1.457	14,00	.551	FDS36	364.016	170.350	191.916	170.355
37,50	1.476	15,00	.591	FDS36	364.016	170.350	191.916	170.355
38,00	1.496	15,00	.591	FDS36	364.016	170.350	191.916	170.355
38,10	1.500	15,00	.591	FDS36	364.016	170.350	191.916	170.355
39,00	1.535	16,00	.630	FDS36	364.010	170.345	191.916	170.355
39,20	1.543	16,00	.630	FDS36	364.010	170.345	191.916	170.355
39,70	1.563	17,00	.669	FDS36	364.010	170.345	191.916	170.355
40,00	1.575	17,00	.669	FDS40	364.010	170.345	191.916	170.355
41,00	1.614	18,00	.709	FDS40	364.010	170.345	191.916	170.355
41,28	1.625	18,00	.709	FDS40	364.010	170.345	191.916	170.355
42,00	1.654	19,00	.748	FDS40	364.010	170.345	191.916	170.355
43,00	1.693	20,00	.787	FDS40	364.011	170.346	191.916	170.355
44,00	1.732	21,00	.827	FDS40	364.011	170.346	191.916	170.355
44,45	1.750	22,00	.866	FDS40	364.011	170.346	191.916	170.355
45,00	1.772	18,00	.709	FDS45	364.010	170.345	191.698	170.355
46,00	1.811	19,00	.748	FDS45	364.010	170.345	191.698	170.355
47,00	1.850	20,00	.787	FDS45	364.011	170.346	191.698	170.355
47,63	1.875	21,00	.827	FDS45	364.011	170.346	191.698	170.355
48,00	1.890	21,00	.827	FDS45	364.011	170.346	191.698	170.355
49,00	1.929	22,00	.866	FDS45	364.011	170.346	191.698	170.355
50,00	1.969	23,00	.906	FDS50	364.011	170.346	191.698	170.355
50,80	2.000	24,00	.945	FDS50	364.011	170.346	191.698	170.355
51,00	2.008	24,00	.945	FDS50	364.011	170.346	191.698	170.355
52,00	2.047	25,00	.984	FDS50	364.012	170.347	191.698	170.355
53,00	2.087	26,00	1.024	FDS50	364.012	170.347	191.698	170.355
53,98	2.125	27,00	1.063	FDS50	364.012	170.347	191.698	170.355
54,00	2.126	27,00	1.063	FDS50	364.012	170.347	191.698	170.355
55,00	2.165	28,00	1.102	FDS50	364.012	170.347	191.698	170.355
56,00	2.205	20,00	.787	FDS56	364.011	170.346	191.726	170.356
57,00	2.244	21,00	.827	FDS56	364.011	170.346	191.726	170.356
57,15	2.250	21,00	.827	FDS56	364.011	170.346	191.726	170.356
58,00	2.284	22,00	.866	FDS56	364.011	170.346	191.726	170.356
59,00	2.323	23,00	.906	FDS56	364.011	170.346	191.726	170.356
60,00	2.362	24,00	.945	FDS56	364.011	170.346	191.726	170.356
60,33	2.375	24,00	.945	FDS56	364.011	170.346	191.726	170.356
61,00	2.402	25,00	.984	FDS56	364.012	170.347	191.726	170.356
62,00	2.441	26,00	1.024	FDS56	364.012	170.347	191.726	170.356
63,00	2.480	27,00	1.063	FDS63	364.012	170.347	191.726	170.356

(continued)

(KSEM PLUS A1 Heads 28–101,60mm (1.102–4") • Spare Parts — continued)

D1		PDD						
mm	in	mm	in	CSMS system size	KSEM insert screw	KSEM wrench	Drill Fix insert screw	Drill Fix wrench
63,50	2.500	28,00	1.102	FDS63	364.012	170.347	191.726	170.356
64,00	2.520	28,00	1.102	FDS63	364.012	170.347	191.726	170.356
65,00	2.559	29,00	1.142	FDS63	364.013	170.348	191.726	170.356
66,00	2.598	30,00	1.181	FDS63	364.013	170.348	191.726	170.356
66,68	2.625	31,00	1.221	FDS63	364.013	170.348	191.726	170.356
67,00	2.638	31,00	1.221	FDS63	364.013	170.348	191.726	170.356
68,00	2.677	32,00	1.260	FDS63	364.013	170.348	191.726	170.356
69,00	2.717	33,00	1.299	FDS63	364.015	170.348	191.726	170.356
69,85	2.750	34,00	1.339	FDS63	364.015	170.348	191.726	170.356
70,00	2.756	34,00	1.339	FDS63	364.015	170.348	191.726	170.356
71,00	2.795	26,00	1.024	FDS71	364.012	170.347	191.916	170.355
72,00	2.835	27,00	1.063	FDS71	364.012	170.347	191.916	170.355
73,00	2.874	28,00	1.102	FDS71	364.012	170.347	191.916	170.355
73,03	2.875	28,00	1.102	FDS71	364.012	170.347	191.916	170.355
74,00	2.913	29,00	1.142	FDS71	364.013	170.365	191.916	170.355
75,00	2.953	30,00	1.181	FDS71	364.013	170.365	191.916	170.355
76,00	2.992	31,00	1.220	FDS71	364.013	170.365	191.916	170.355
76,20	3.000	31,00	1.220	FDS71	364.013	170.365	191.916	170.355
77,00	3.031	32,00	1.260	FDS71	364.013	170.365	191.916	170.355
78,00	3.071	33,00	1.299	FDS71	364.015	170.365	191.916	170.355
79,00	3.110	34,00	1.339	FDS71	364.015	170.365	191.916	170.355
79,38	3.125	31,00	1.220	FDS80	364.013	170.365	191.916	170.355
80,00	3.150	31,00	1.220	FDS80	364.013	170.365	191.916	170.355
81,00	3.189	32,00	1.260	FDS80	364.013	170.365	191.916	170.355
82,00	3.228	33,00	1.299	FDS80	364.015	170.365	191.916	170.355
82,55	3.250	34,00	1.339	FDS80	364.015	170.365	191.916	170.355
83,00	3.268	34,00	1.339	FDS80	364.015	170.365	191.916	170.355
84,00	3.307	35,00	1.378	FDS80	364.015	170.365	191.916	170.355
85,00	3.346	36,00	1.417	FDS80	364.015	170.365	191.916	170.355
85,73	3.375	37,00	1.457	FDS80	364.015	170.365	191.916	170.355
86,00	3.386	37,00	1.457	FDS80	364.015	170.365	191.916	170.355
87,00	3.425	38,00	1.496	FDS80	364.015	170.365	191.916	170.355
88,00	3.465	39,00	1.535	FDS80	364.015	170.365	191.916	170.355
88,90	3.500	40,00	1.575	FDS80	364.015	170.365	191.916	170.355
89,00	3.504	40,00	1.575	FDS80	364.015	170.365	191.916	170.355
90,00	3.543	37,00	1.457	FDS90	364.015	170.365	191.916	170.355
91,00	3.583	38,00	1.496	FDS90	364.015	170.365	191.916	170.355
92,00	3.622	39,00	1.535	FDS90	364.015	170.365	191.916	170.355
92,08	3.625	39,00	1.535	FDS90	364.015	170.365	191.916	170.355
93,00	3.661	40,00	1.575	FDS90	364.015	170.365	191.916	170.355
94,00	3.701	26,00	1.024	FDS90	364.012	170.355	191.916	170.355
95,00	3.740	27,00	1.063	FDS90	364.012	170.355	191.916	170.355
95,25	3.750	27,00	1.063	FDS90	364.012	170.355	191.916	170.355
96,00	3.780	28,00	1.102	FDS90	364.012	170.355	191.916	170.355
97,00	3.819	29,00	1.142	FDS90	364.013	170.365	191.916	170.355
98,00	3.858	30,00	1.181	FDS90	364.013	170.365	191.916	170.355
98,43	3.875	31,00	1.220	FDS90	364.013	170.365	191.916	170.355
99,00	3.898	31,00	1.220	FDS90	364.013	170.365	191.916	170.355
100,00	3.937	32,00	1.260	FDS90	364.013	170.365	191.916	170.355
101,60	4.000	34,00	1.339	FDS90	364.015	170.365	191.916	170.355

KSEM PLUS B1 Heads 28–101,60mm (1.102–4") • Spare Parts

D1		PDD									
mm	in	mm	in	CSMS system size	KSEM insert screw	Torx wrench	DFC insert screw	Torx wrench	DPA guiding pad screw	Torx wrench	shim pack
28,00	1.102	14,00	.551	FDS28	364.016	170.350	192.432	170.352	192.432	170.352	193.554
28,58	1.125	15,00	.591	FDS28	364.016	170.350	192.432	170.352	192.432	170.352	193.554
29,00	1.142	15,00	.591	FDS28	364.016	170.350	192.432	170.352	192.432	170.352	193.554
29,36	1.156	16,00	.630	FDS28	364.010	170.345	192.432	170.352	192.432	170.352	193.554
30,00	1.181	16,00	.630	FDS28	364.010	170.345	192.432	170.352	192.432	170.352	193.554
30,18	1.188	17,00	.669	FDS28	364.010	170.345	192.432	170.352	192.432	170.352	193.554
30,96	1.219	17,00	.669	FDS28	364.010	170.345	192.432	170.352	192.432	170.352	193.554
31,00	1.220	17,00	.669	FDS28	364.010	170.345	192.432	170.352	192.432	170.352	193.554
31,75	1.250	15,00	.591	FDS32	364.016	170.350	191.924	170.353	191.924	170.353	193.555
32,00	1.260	15,00	.591	FDS32	364.016	170.350	191.924	170.353	191.924	170.353	193.555
33,00	1.299	16,00	.630	FDS32	364.010	170.345	191.924	170.353	191.924	170.353	193.555
33,20	1.307	16,00	.630	FDS32	364.010	170.345	191.924	170.353	191.924	170.353	193.555
33,35	1.313	17,00	.669	FDS32	364.010	170.345	191.924	170.353	191.924	170.353	193.555
34,00	1.339	17,00	.669	FDS32	364.010	170.345	191.924	170.353	191.924	170.353	193.555
34,93	1.375	18,00	.709	FDS32	364.010	170.345	191.924	170.353	191.924	170.353	193.555
35,00	1.378	18,00	.709	FDS32	364.010	170.345	191.924	170.353	191.924	170.353	193.555
36,00	1.417	13,00	.512	FDS36	364.016	170.350	191.916	170.355	191.924	170.353	193.555
36,53	1.438	14,00	.551	FDS36	364.016	170.350	191.916	170.355	191.924	170.353	193.555
37,00	1.457	14,00	.551	FDS36	364.016	170.350	191.916	170.355	191.924	170.353	193.555
37,50	1.476	15,00	.591	FDS36	364.016	170.350	191.916	170.355	191.924	170.353	193.555
38,00	1.496	15,00	.591	FDS36	364.016	170.350	191.916	170.355	191.924	170.353	193.555
38,10	1.500	15,00	.591	FDS36	364.016	170.350	191.916	170.355	191.924	170.353	193.555
39,00	1.535	16,00	.630	FDS36	364.010	170.345	191.916	170.355	191.924	170.353	193.555
39,20	1.543	16,00	.630	FDS36	364.010	170.345	191.916	170.355	191.924	170.353	193.555
39,70	1.563	17,00	.669	FDS36	364.010	170.345	191.916	170.355	191.924	170.353	193.555
40,00	1.575	17,00	.669	FDS40	364.010	170.345	191.916	170.355	191.924	170.353	193.555
41,00	1.614	18,00	.709	FDS40	364.010	170.345	191.916	170.355	191.924	170.353	193.555
41,28	1.625	18,00	.709	FDS40	364.010	170.345	191.916	170.355	191.924	170.353	193.555
42,00	1.654	19,00	.748	FDS40	364.010	170.345	191.916	170.355	191.924	170.353	193.555
43,00	1.693	20,00	.787	FDS40	364.011	170.346	191.916	170.355	191.924	170.353	193.555
44,00	1.732	21,00	.827	FDS40	364.011	170.346	191.916	170.355	191.924	170.353	193.555
44,45	1.750	22,00	.866	FDS40	364.011	170.346	191.916	170.355	191.924	170.353	193.555
45,00	1.772	18,00	.709	FDS45	364.010	170.345	191.916	170.355	191.924	170.353	193.555
46,00	1.811	19,00	.748	FDS45	364.010	170.345	191.916	170.355	191.924	170.353	193.555
47,00	1.850	20,00	.787	FDS45	364.011	170.346	191.916	170.355	191.924	170.353	193.555
47,63	1.875	21,00	.827	FDS45	364.011	170.346	191.916	170.355	191.924	170.353	193.555
48,00	1.890	21,00	.827	FDS45	364.011	170.346	191.916	170.355	191.924	170.353	193.555
49,00	1.929	22,00	.866	FDS45	364.011	170.346	191.916	170.355	191.924	170.353	193.555
50,00	1.969	23,00	.906	FDS50	364.011	170.346	191.916	170.355	191.916	170.355	193.556
50,80	2.000	24,00	.945	FDS50	364.011	170.346	191.916	170.355	191.916	170.355	193.556
51,00	2.008	24,00	.945	FDS50	364.011	170.346	191.916	170.355	191.916	170.355	193.556
52,00	2.047	25,00	.984	FDS50	364.012	170.347	191.916	170.355	191.916	170.355	193.556
53,00	2.087	26,00	1.024	FDS50	364.012	170.347	191.916	170.355	191.916	170.355	193.556
53,98	2.125	27,00	1.063	FDS50	364.012	170.347	191.916	170.355	191.916	170.355	193.556
54,00	2.126	27,00	1.063	FDS50	364.012	170.347	191.916	170.355	191.916	170.355	193.556
55,00	2.165	28,00	1.102	FDS50	364.012	170.347	191.916	170.355	191.916	170.355	193.556
56,00	2.205	20,00	.787	FDS56	364.011	170.346	191.726	170.356	191.916	170.355	193.556
57,00	2.244	21,00	.827	FDS56	364.011	170.346	191.726	170.356	191.916	170.355	193.556
57,15	2.250	21,00	.827	FDS56	364.011	170.346	191.726	170.356	191.916	170.355	193.556
58,00	2.283	22,00	.866	FDS56	364.011	170.346	191.726	170.356	191.916	170.355	193.556
59,00	2.323	23,00	.906	FDS56	364.011	170.346	191.726	170.356	191.916	170.355	193.556
60,00	2.362	24,00	.945	FDS56	364.011	170.346	191.726	170.356	191.916	170.355	193.556
60,33	2.375	24,00	.945	FDS56	364.011	170.346	191.726	170.356	191.916	170.355	193.556
61,00	2.402	25,00	.984	FDS56	364.012	170.347	191.726	170.356	191.916	170.355	193.556
62,00	2.441	26,00	1.024	FDS56	364.012	170.347	191.726	170.356	191.916	170.355	193.556
63,00	2.480	27,00	1.063	FDS63	364.012	170.347	191.726	170.356	191.916	170.355	193.556

(continued)

(KSEM PLUS B1 Heads 28–101,60mm (1.102–4") • Spare Parts — continued)



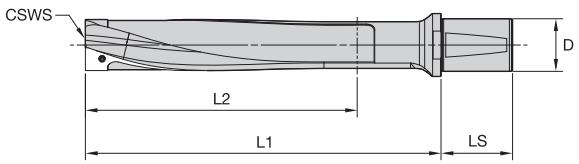






D1		PDD									
mm	in	mm	in	CSMS system size	KSEM insert screw	Torx wrench	DFC insert screw	Torx wrench	DPA guiding pad screw	Torx wrench	shim pack
63,50	2.500	28,00	1.102	FDS63	**364.012**	**170.347**	**191.726**	**170.356**	**191.916**	**170.355**	**193.556**
64,00	2.520	28,00	1.102	FDS63	**364.012**	**170.347**	**191.726**	**170.356**	**191.916**	**170.355**	**193.556**
65,00	2.559	29,00	1.142	FDS63	**364.013**	**170.348**	**191.726**	**170.356**	**191.916**	**170.355**	**193.556**
66,00	2.598	30,00	1.181	FDS63	**364.013**	**170.348**	**191.726**	**170.356**	**191.916**	**170.355**	**193.556**
66,68	2.625	31,00	1.221	FDS63	**364.013**	**170.348**	**191.726**	**170.356**	**191.916**	**170.355**	**193.556**
67,00	2.638	31,00	1.221	FDS63	**364.013**	**170.348**	**191.726**	**170.356**	**191.916**	**170.355**	**193.556**
68,00	2.677	32,00	1.260	FDS63	**364.013**	**170.348**	**191.726**	**170.356**	**191.916**	**170.355**	**193.556**
69,00	2.717	33,00	1.299	FDS63	**364.015**	**170.348**	**191.726**	**170.356**	**191.916**	**170.355**	**193.556**
69,85	2.750	34,00	1.339	FDS63	**364.015**	**170.348**	**191.726**	**170.356**	**191.916**	**170.355**	**193.556**
70,00	2.756	34,00	1.339	FDS63	**364.015**	**170.348**	**191.726**	**170.356**	**191.916**	**170.355**	**193.556**
71,00	2.795	26,00	1.024	FDS71	**364.012**	**170.347**	**191.916**	**170.356**	**191.916**	**170.355**	**193.556**
72,00	2.835	27,00	1.063	FDS71	**364.012**	**170.347**	**191.916**	**170.356**	**191.916**	**170.355**	**193.556**
73,00	2.874	28,00	1.102	FDS71	**364.012**	**170.347**	**191.916**	**170.356**	**191.916**	**170.355**	**193.556**
73,03	2.875	28,00	1.102	FDS71	**364.012**	**170.347**	**191.916**	**170.356**	**191.916**	**170.355**	**193.556**
74,00	2.913	29,00	1.142	FDS71	**364.013**	**170.365**	**191.916**	**170.356**	**191.916**	**170.355**	**193.556**
75,00	2.953	30,00	1.181	FDS71	**364.013**	**170.365**	**191.916**	**170.356**	**191.916**	**170.355**	**193.556**
76,00	2.992	31,00	1.220	FDS71	**364.013**	**170.365**	**191.916**	**170.356**	**191.916**	**170.355**	**193.556**
76,20	3.000	31,00	1.220	FDS71	**364.013**	**170.365**	**191.916**	**170.355**	**191.916**	**170.356**	**193.556**
77,00	3.031	32,00	1.260	FDS71	**364.013**	**170.365**	**191.916**	**170.355**	**191.916**	**170.356**	**193.556**
78,00	3.071	33,00	1.299	FDS71	**364.015**	**170.365**	**191.916**	**170.355**	**191.916**	**170.356**	**193.556**
79,00	3.110	34,00	1.339	FDS71	**364.015**	**170.365**	**191.916**	**170.355**	**191.916**	**170.356**	**193.556**
79,38	3.125	31,00	1.220	FDS80	**364.013**	**170.365**	**191.916**	**170.355**	**191.916**	**170.356**	**193.556**
80,00	3.150	31,00	1.220	FDS80	**364.013**	**170.365**	**191.916**	**170.355**	**191.916**	**170.356**	**193.556**
81,00	3.189	32,00	1.260	FDS80	**364.013**	**170.365**	**191.916**	**170.355**	**191.916**	**170.356**	**193.556**
82,00	3.228	33,00	1.299	FDS80	**364.015**	**170.365**	**191.916**	**170.355**	**191.916**	**170.356**	**193.556**
82,55	3.250	34,00	1.339	FDS80	**364.015**	**170.355**	**191.916**	**170.355**	**191.916**	**170.356**	**193.556**
83,00	3.268	34,00	1.339	FDS80	**364.015**	**170.355**	**191.916**	**170.355**	**191.916**	**170.356**	**193.556**
84,00	3.307	35,00	1.378	FDS80	**364.015**	**170.355**	**191.916**	**170.355**	**191.916**	**170.356**	**193.556**
85,00	3.346	36,00	1.417	FDS80	**364.015**	**170.355**	**191.916**	**170.355**	**191.916**	**170.356**	**193.556**
85,73	3.375	37,00	1.457	FDS80	**364.015**	**170.355**	**191.916**	**170.355**	**191.916**	**170.356**	**193.556**
86,00	3.386	37,00	1.457	FDS80	**364.015**	**170.355**	**191.916**	**170.355**	**191.916**	**170.356**	**193.556**
87,00	3.425	38,00	1.496	FDS80	**364.015**	**170.355**	**191.916**	**170.355**	**191.916**	**170.356**	**193.556**
88,00	3.465	39,00	1.535	FDS80	**364.015**	**170.355**	**191.916**	**170.355**	**191.916**	**170.356**	**193.556**
88,90	3.500	40,00	1.575	FDS80	**364.015**	**170.355**	**191.916**	**170.355**	**191.916**	**170.356**	**193.556**
89,00	3.504	40,00	1.575	FDS80	**364.015**	**170.355**	**191.916**	**170.355**	**191.916**	**170.356**	**193.556**
90,00	3.543	37,00	1.457	FDS90	**364.015**	**170.355**	**191.916**	**170.355**	**191.916**	**170.356**	**193.556**
91,00	3.583	38,00	1.496	FDS90	**364.015**	**170.355**	**191.916**	**170.355**	**191.916**	**170.356**	**193.556**
92,00	3.622	39,00	1.535	FDS90	**364.015**	**170.355**	**191.916**	**170.355**	**191.916**	**170.356**	**193.556**
92,08	3.625	39,00	1.535	FDS90	**364.015**	**170.355**	**191.916**	**170.355**	**191.916**	**170.356**	**193.556**
93,00	3.661	40,00	1.575	FDS90	**364.015**	**170.355**	**191.916**	**170.355**	**191.916**	**170.356**	**193.556**
94,00	3.701	26,00	1.024	FDS90	**364.012**	**170.355**	**191.916**	**170.355**	**191.916**	**170.356**	**193.556**
95,00	3.740	27,00	1.063	FDS90	**364.012**	**170.355**	**191.916**	**170.355**	**191.916**	**170.356**	**193.556**
95,25	3.750	27,00	1.063	FDS90	**364.012**	**170.355**	**191.916**	**170.355**	**191.916**	**170.356**	**193.556**
96,00	3.780	28,00	1.102	FDS90	**364.012**	**170.355**	**191.916**	**170.355**	**191.916**	**170.356**	**193.556**
97,00	3.819	29,00	1.142	FDS90	**364.013**	**170.355**	**191.916**	**170.355**	**191.916**	**170.356**	**193.556**
98,00	3.858	30,00	1.181	FDS90	**364.013**	**170.355**	**191.916**	**170.355**	**191.916**	**170.356**	**193.556**
98,43	3.875	31,00	1.220	FDS90	**364.013**	**170.355**	**191.916**	**170.355**	**191.916**	**170.356**	**193.556**
99,00	3.898	31,00	1.220	FDS90	**364.013**	**170.355**	**191.916**	**170.355**	**191.916**	**170.356**	**193.556**
100,00	3.937	32,00	1.260	FDS90	**364.013**	**170.355**	**191.916**	**170.355**	**191.916**	**170.356**	**193.556**
101,60	4.000	34,00	1.339	FDS90	**364.015**	**170.365**	**191.916**	**170.355**	**191.916**	**170.356**	**193.556**

- Order KSEM PLUS heads according to the connection coupling size (CSWS).
- Order KSEM PLUS heads separately; see page H91–H96.
- Wrench will be shipped with KSEM PLUS head.
- Custom solution for cast iron application with twisted flutes available.





KSEM PLUS WD Shanks • 1.5 x D • Metric

1.5 x D catalogue number	CSWS system size	D	L1	L2	LS	clamp screw
WD32FDS28076M	FDS28	32	76	32	58	**193.537**
WD32FDS32082M	FDS32	32	82	34	58	**193.523**
WD32FDS36092M	FDS36	32	92	40	58	**193.524**
WD50FDS40100M	FDS40	50	100	43	68	**193.524**
WD50FDS45112M	FDS45	50	112	50	68	**193.525**
WD50FDS50122M	FDS50	50	122	54	68	**193.525**
WD50FDS56140M	FDS56	50	140	65	68	**193.526**
WD50FDS63154M	FDS63	50	154	71	68	**193.526**
WD50FDS71172M	FDS71	50	172	80	68	**193.526**
WD50FDS80192M	FDS80	50	192	90	68	**193.545**
WD50FDS90212M	FDS90	50	212	100	68	**193.545**

KSEM PLUS WD Shanks • 3 x D • Metric

3 x D catalogue number	CSWS system size	D	L1	L2	LS	clamp screw
WD32FDS28128M	FDS28	32	128	71	58	**193.537**
WD32FDS32146M	FDS32	32	146	85	58	**193.523**
WD32FDS36166M	FDS36	32	166	97	58	**193.524**
WD50FDS40183M	FDS40	50	183	107	68	**193.524**
WD50FDS45206M	FDS45	50	206	122	68	**193.525**
WD50FDS50228M	FDS50	50	228	135	68	**193.525**
WD50FDS56259M	FDS56	50	259	156	68	**193.526**
WD50FDS63289M	FDS63	50	289	174	68	**193.526**
WD50FDS71292M	FDS71	50	292	200	68	**193.526**
WD50FDS80327M	FDS80	50	327	225	68	**193.545**
WD50FDS90362M	FDS90	50	362	250	68	**193.545**

KSEM PLUS WD Shanks • 5 x D • Metric





5 x D catalogue number	CSWS system size	D	L1	L2	LS	clamp screw
WD32FDS28190M	FDS28	32	190	133	58	**193.537**
WD32FDS32216M	FDS32	32	216	155	58	**193.523**
WD32FDS36244M	FDS36	32	244	175	58	**193.524**
WD50FDS40271M	FDS40	50	271	195	68	**193.524**
WD50FDS45304M	FDS45	50	304	220	68	**193.525**
WD50FDS50338M	FDS50	50	338	245	68	**193.525**
WD50FDS56383M	FDS56	50	383	280	68	**193.526**
WD50FDS63429M	FDS63	50	429	314	68	**193.526**
WD50FDS71452M	FDS71	50	452	360	68	**193.526**
WD50FDS80507M	FDS80	50	507	405	68	**193.545**
WD50FDS90562M	FDS90	50	562	450	68	**193.545**

KSEM PLUS WD Shanks • 8 x D • Metric





8 x D catalogue number	CSWS system size	D	L1	L2	LS	clamp screw
WD32FDS28283M	FDS28	32	283	226	58	**193.537**
WD32FDS32321M	FDS32	32	321	260	58	**193.523**
WD32FDS36361M	FDS36	32	361	292	58	**193.524**
WD50FDS40403M	FDS40	50	403	327	68	**193.524**
WD50FDS45451M	FDS45	50	451	367	68	**193.525**
WD50FDS50503M	FDS50	50	503	410	68	**193.525**
WD50FDS56569M	FDS56	50	569	466	68	**193.526**
WD50FDS63639M	FDS63	50	639	524	68	**193.526**

KSEM PLUS WD Shanks • 10 x D • Metric





10 x D catalogue number	CSWS system size	D	L1	L2	LS	clamp screw
WD32FDS28345M	FDS28	32	345	288	58	**193.537**
WD32FDS32391M	FDS32	32	391	330	58	**193.523**
WD32FDS36439M	FDS36	32	439	370	58	**193.524**
WD50FDS40491M	FDS40	50	491	415	68	**193.524**
WD50FDS45549M	FDS45	50	549	465	68	**193.525**
WD50FDS50613M	FDS50	50	613	520	68	**193.525**
WD50FDS56693M	FDS56	50	693	590	68	**193.526**
WD50FDS63779M	FDS63	50	779	664	68	**193.526**

KSEM PLUS Carbide Insert Recommendations

Material Group	Outboard/ Inboard	Insert Style	Grade	Page(s)	Comments
P	O	DFR-GD	KCU25, KCU40	H89	Recommended outboard insert style for working in all P-materials. Start with KCU40™ and use KCU25™ in stable conditions to achieve higher tool life.
		DFC-/DFT-HP		H90, H88	
		DFC-/DFT-DS	KCU40	H90, H88	Reduce feed rate by 10% to further improve chip formation in long-chipping steels and low carbon steel.
	I	KSEMP-HPG	KC7315	H87	Must use KSEMP centre inserts in P-materials to avoid excessive wear on head & inserts.
M	O	DFR-MD	KC7140	H89	Recommended outboard insert style for working in all M-materials.
		DFC-/DFT-MD		H90, H89	
		DFC-/DFT-DS	KCU40	H90, H88	Reduce feed rate by 20% to further improve chip formation and/or run with lower power consumption.
	I	KSEMP-HPG	KC7315	H87	Recommended inboard insert style for working in all M-materials.
		KSEM-PC	KC7135	H56, H87	For unstable conditions in stainless steel, use KSEM PC inserts.
		KSEM-HPL	KC7320	H50	If chip control issue resulting from centre insert occurs in M-materials, use KSEM HPL insert inboard. Reduction of feed rate up to 20% is recommended.
K	O	DFR-LD	KCU25	H89	Recommended insert styles for working in all K-Materials.
		DFC-/DFT-HP		H90, H88	
	I	KSEM-HPCCL	KC7410	H48, H87	
N	O	DFR-GD	KC7225	H89	Recommended outboard insert styles for working in all non-ferrous materials.
		DFC-/DFT-HP	KCU40	H90, H88	
		DFC-/DFT-DS	KCU40	H90, H88	Reduce feed rate by 15% for diameters <56mm and up to 50% for larger diameters to improve chip formation.
		DFR/DFT-ST	KD1425	J85	Use PCD tipped outboard when working with CFRP, CFRP/metal stacks and plastics (N3, N5, and N6).
	I	KSEMP-HPG	KC7315	H87	Recommended inboard insert style for working in all non-ferrous materials.
		KSEM-HPS	K715	—	This is a made-to-order item (uncoated/sharp) — use it to improve your results in N3, N5, and N6, if required.
S	O	DFR-GD	KC7140	H89	Recommended outboard insert style for working in all S-materials.
		DFC-/DFT-HP	KCU40	H90, H88	
		DFC-/DFT-DS	KCU40	H90, H88	Reduce feed rate by 20% to further improve chip formation and/or run with lower power consumption.
	I	KSEM-PC	KC7135	H56, H87	If centre breakage is an issue in S-materials, use KSEM PC insert inboard.



Need help with bad chip formation?

Our new DS geometry for DFT™ and DFC™ inserts on KSEM PLUS helps you to improve your performance in long chipping materials.

If chip formation is an issue, you may use our new DFT and DFC DS style inserts with the recommendations for feed rate adjustments given as indicated.

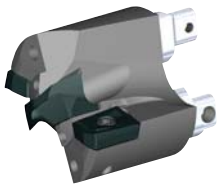
Modular Drill • KSEM PLUS™ • Metric • A1 and B1 Style

Metric											
Material Group		Condition	Cutting Speed — vc Range — m/min			Recommended Feed Rate (fz) by Diameter					
			min	Starting Value	max	Ø	KSEM 14….17 DFR/DFC04... 28.00–31,74	KSEM 15….18 DFT/DFC05... 31,74–35,99	KSEM 13….22 DFT/DFC06... 36,00–44,99	KSEM 18….28 DFT/DFC07... 45,00–55,99	KSEM 20….34 DFT/DFC09... 56,00–102,35
P	1	S	115	**235**	290	mm/r	0,130–0,250	0,130–0,250	0,160–0,280	0,160–0,320	0,200–0,360
		U	90	**160**	215	mm/r	0,130–0,250	0,130–0,250	0,160–0,280	0,160–0,320	0,200–0,360
		I	65	**100**	140	mm/r	0,130–0,250	0,130–0,250	0,160–0,280	0,160–0,320	0,200–0,360
	2	S	90	**190**	230	mm/r	0,160–0,280	0,160–0,280	0,200–0,360	0,200–0,400	0,200–0,450
		U	71	**130**	170	mm/r	0,160–0,280	0,160–0,280	0,200–0,360	0,200–0,400	0,200–0,450
		I	50	**80**	110	mm/r	0,160–0,280	0,160–0,280	0,200–0,320	0,200–0,400	0,200–0,450
	3	S	90	**180**	230	mm/r	0,160–0,280	0,160–0,280	0,200–0,320	0,200–0,400	0,200–0,450
		U	70	**120**	170	mm/r	0,160–0,280	0,160–0,280	0,200–0,320	0,200–0,400	0,200–0,450
		I	50	**70**	106	mm/r	0,160–0,280	0,160–0,280	0,200–0,320	0,200–0,400	0,200–0,450
	4	S	90	**140**	220	mm/r	0,160–0,280	0,160–0,280	0,200–0,320	0,200–0,400	0,200–0,450
		U	70	**110**	160	mm/r	0,160–0,280	0,160–0,280	0,200–0,320	0,200–0,400	0,200–0,450
		I	50	**80**	110	mm/r	0,160–0,280	0,160–0,280	0,200–0,320	0,200–0,400	0,200–0,450
	5	S	90	**130**	210	mm/r	0,160–0,280	0,160–0,280	0,200–0,320	0,200–0,400	0,200–0,450
		U	70	**100**	150	mm/r	0,160–0,280	0,160–0,280	0,200–0,320	0,200–0,400	0,200–0,450
		I	50	**70**	100	mm/r	0,160–0,280	0,160–0,280	0,200–0,320	0,200–0,400	0,200–0,450
	6	S	70	**90**	180	mm/r	0,160–0,280	0,160–0,280	0,200–0,320	0,200–0,400	0,200–0,450
		U	50	**75**	120	mm/r	0,160–0,280	0,160–0,280	0,200–0,320	0,200–0,400	0,200–0,450
		I	40	**60**	100	mm/r	0,160–0,280	0,160–0,280	0,200–0,320	0,200–0,400	0,200–0,450
M	1	S	60	**110**	135	mm/r	0,130–0,250	0,130–0,250	0,160–0,280	0,160–0,320	0,200–0,360
		U	40	**70**	90	mm/r	0,130–0,250	0,130–0,250	0,160–0,280	0,160–0,320	0,200–0,360
		I	30	**50**	65	mm/r	0,130–0,250	0,130–0,250	0,160–0,280	0,160–0,320	0,200–0,360
	2	S	60	**100**	135	mm/r	0,130–0,250	0,130–0,250	0,160–0,280	0,160–0,320	0,200–0,360
		U	40	**60**	90	mm/r	0,130–0,250	0,130–0,250	0,160–0,280	0,160–0,320	0,200–0,360
		I	30	**50**	65	mm/r	0,130–0,250	0,130–0,250	0,160–0,280	0,160–0,320	0,200–0,360
	3	S	50	**90**	135	mm/r	0,130–0,250	0,130–0,250	0,160–0,280	0,160–0,320	0,200–0,360
		U	40	**60**	90	mm/r	0,130–0,250	0,130–0,250	0,160–0,280	0,160–0,320	0,200–0,360
		I	25	**40**	65	mm/r	0,130–0,250	0,130–0,250	0,160–0,280	0,160–0,320	0,200–0,360
K	1	S	90	**170**	230	mm/r	0,180–0,300	0,180–0,300	0,216–0,360	0,240–0,420	0,300–0,480
		U	60	**120**	160	mm/r	0,180–0,300	0,180–0,300	0,216–0,360	0,240–0,420	0,300–0,480
		I	40	**70**	90	mm/r	0,180–0,300	0,180–0,300	0,216–0,360	0,240–0,420	0,300–0,480
	2	S	90	**160**	220	mm/r	0,180–0,300	0,180–0,300	0,216–0,360	0,240–0,420	0,300–0,480
		U	60	**110**	160	mm/r	0,180–0,300	0,180–0,300	0,216–0,360	0,240–0,420	0,300–0,480
		I	40	**70**	100	mm/r	0,180–0,300	0,180–0,300	0,216–0,360	0,240–0,420	0,300–0,480
	3	S	90	**150**	210	mm/r	0,180–0,300	0,180–0,300	0,216–0,360	0,240–0,420	0,300–0,480
		U	60	**100**	150	mm/r	0,180–0,300	0,180–0,300	0,216–0,360	0,240–0,420	0,300–0,480
		I	35	**60**	90	mm/r	0,180–0,300	0,180–0,300	0,216–0,360	0,240–0,420	0,300–0,480
N	1	S	150	**240**	360	mm/r	0,120–0,200	0,120–0,200	0,144–0,280	0,160–0,320	0,200–0,400
		U	100	**160**	240	mm/r	0,120–0,200	0,120–0,200	0,144–0,280	0,160–0,320	0,200–0,400
		I	60	**100**	160	mm/r	0,120–0,200	0,120–0,200	0,144–0,280	0,160–0,320	0,200–0,400
	2	S	150	**220**	360	mm/r	0,120–0,200	0,120–0,200	0,144–0,280	0,160–0,320	0,200–0,400
		U	100	**150**	240	mm/r	0,120–0,200	0,120–0,200	0,144–0,280	0,160–0,320	0,200–0,400
		I	60	**100**	160	mm/r	0,120–0,200	0,120–0,200	0,144–0,280	0,160–0,320	0,200–0,400
	3	S	150	**200**	360	mm/r	0,120–0,200	0,120–0,200	0,144–0,280	0,160–0,320	0,200–0,400
		U	100	**140**	240	mm/r	0,120–0,200	0,120–0,200	0,144–0,280	0,160–0,320	0,200–0,400
		I	60	**90**	160	mm/r	0,120–0,200	0,120–0,200	0,144–0,280	0,160–0,320	0,200–0,400
	4	S	150	**200**	360	mm/r	0,120–0,200	0,120–0,200	0,144–0,280	0,160–0,320	0,200–0,400
		U	100	**140**	240	mm/r	0,120–0,200	0,120–0,200	0,144–0,280	0,160–0,320	0,200–0,400
		I	60	**90**	160	mm/r	0,120–0,200	0,120–0,200	0,144–0,280	0,160–0,320	0,200–0,400
	5	S	150	**200**	360	mm/r	0,120–0,200	0,120–0,200	0,144–0,280	0,160–0,320	0,200–0,400
		U	100	**140**	240	mm/r	0,120–0,200	0,120–0,200	0,144–0,280	0,160–0,320	0,200–0,400
		I	60	**90**	160	mm/r	0,120–0,200	0,120–0,200	0,144–0,280	0,160–0,320	0,200–0,400
	6	S	150	**200**	360	mm/r	0,120–0,200	0,120–0,200	0,144–0,280	0,160–0,320	0,200–0,400
		U	100	**140**	240	mm/r	0,120–0,200	0,120–0,200	0,144–0,280	0,160–0,320	0,200–0,400
		I	60	**90**	160	mm/r	0,120–0,200	0,120–0,200	0,144–0,280	0,160–0,320	0,200–0,400
	7	S	110	**220**	260	mm/r	0,120–0,200	0,120–0,200	0,144–0,280	0,160–0,320	0,200–0,400
		U	70	**140**	170	mm/r	0,120–0,200	0,120–0,200	0,144–0,280	0,160–0,320	0,200–0,400
		I	45	**90**	110	mm/r	0,120–0,200	0,120–0,200	0,144–0,280	0,160–0,320	0,200–0,400
S	1	S	25	**50**	75	mm/r	0,130–0,250	0,130–0,250	0,160–0,280	0,160–0,320	0,200–0,360
		U	20	**40**	60	mm/r	0,130–0,250	0,130–0,250	0,160–0,280	0,160–0,320	0,200–0,360
		I	15	**30**	50	mm/r	0,130–0,250	0,130–0,250	0,160–0,280	0,160–0,320	0,200–0,360
	2	S	20	**40**	60	mm/r	0,130–0,250	0,130–0,250	0,160–0,280	0,160–0,320	0,200–0,360
		U	15	**30**	45	mm/r	0,130–0,250	0,130–0,250	0,160–0,280	0,160–0,320	0,200–0,360
		I	12	**25**	35	mm/r	0,130–0,250	0,130–0,250	0,160–0,280	0,160–0,320	0,200–0,360
	3	S	20	**40**	60	mm/r	0,130–0,250	0,130–0,250	0,160–0,280	0,160–0,320	0,200–0,360
		U	15	**30**	45	mm/r	0,130–0,250	0,130–0,250	0,160–0,280	0,160–0,320	0,200–0,360
		I	12	**25**	40	mm/r	0,130–0,250	0,130–0,250	0,160–0,280	0,160–0,320	0,200–0,360
	4	S	20	**40**	60	mm/r	0,130–0,250	0,130–0,250	0,160–0,280	0,160–0,320	0,200–0,360
		U	15	**30**	45	mm/r	0,130–0,250	0,130–0,250	0,160–0,280	0,160–0,320	0,200–0,360
		I	12	**25**	40	mm/r	0,130–0,250	0,130–0,250	0,160–0,280	0,160–0,320	0,200–0,360

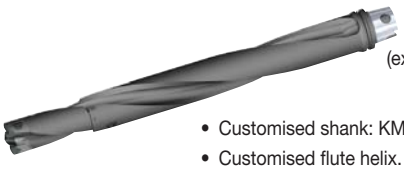


Application	Workpiece Shape	A1 Head	B1 Head
Flat Face		✓	✓
Cored Hole		✗	✓
Stacked Plates		✗	✓
Angled Exit (exit only!)		✓ <3°	✓ max 15°
Angled Entrance		✓ <3°	✓ <3°
Cross Holes		✗	✓ max 50% of D1

KSEM PLUS Customised Solution Capabilities:



- Intermediate head Ø.
- Custom head to use reground KSEM™ inserts.
- Heads for cross holes Ø = d1.



(example)

- Customised shank: KM™, HSK, VDI, ISO taper, etc.
- Customised flute helix.
- Step drill.

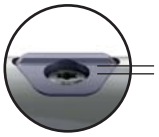


- Drill body up to L1 = 20 x D and total length of 1250mm.

Mounting DPA Guiding Pads on B1 Heads

All B1 heads are delivered with preset guiding pads.

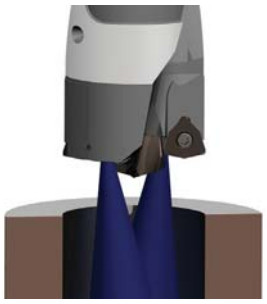




Measure radial undersize "A" of pad to cutting edge for both sides and adjust using shim set that comes with each head.

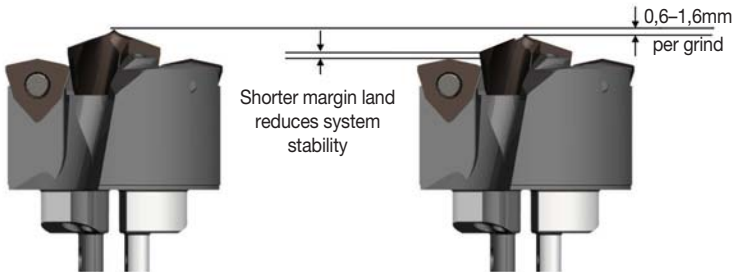
NOTE: For best results with slanted exits and in cross hole drilling, we recommend guiding pads adjustment results in an undersize of A = 30 µm (edge of guiding pads to cutting edges).

Coolant Recommendations



Internal coolant is recommended for optimum chip flow and tool life.

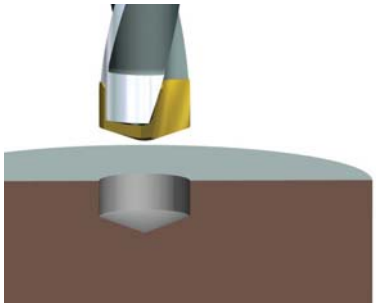
KSEM PLUS Piloting Insert SHOULD NOT Be Reground:



Only new KSEM PLUS inserts will provide consistency and process security on a KSEM PLUS modular drill system. If you want to regrind, refer to our custom solution A1 and B1 heads.

NOTE: Reground KSEM PLUS inserts can be used in KSEM™ drills.

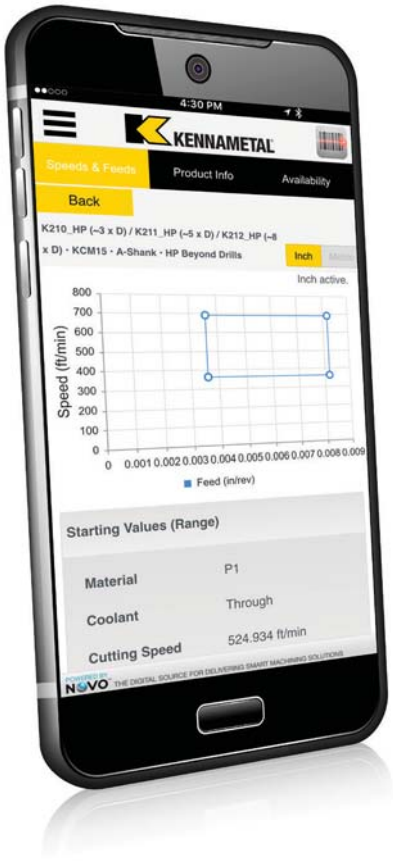
Piloting Instructions:



1. KSEM….PC Pilot drill Ø equal KSEMP Ø PDD
2. Drill 1mm deep from full diameter

Mobile App

The Kennametal mobile app makes it easy to access product information, calculators, and much more from iPhone® and Android™ devices.



FEATURES

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Combination Tools

Tool Selection Guide **I2–I3**

BF Combination Drilling System **I4–I19**

B343_HPG Drill for BF I8–I10

KenTIP for BF I11–I13

BF Bodies I14

BF Inserts I15–I16

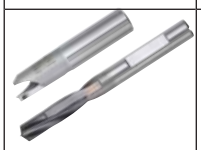
SEFAS Combination Drilling System **I20–I27**

SEFAS Bodies I23–I25

SEFAS Hardware I26

SEFAS Chamfering Inserts I27



		standard							standard range		customised solution range		
		● first choice ○ alternate choice							diameter range		diameter range		
		P	M	K	N	S	H	hole tolerance	D1 mm min–max	drilling depth L/D1	D1 mm min–max	drilling depth	
	**BF with Solid Carbide Drill** Combination Tool	●		●				IT7–11	3,4–18 (B343 drill)	approx. 3 x D	3,4–22,5	.1–5 x D	
	**BF with KenTIP™** Combination Tool	●	●	●				IT7–11	8–18,99	3 x D 4 x D 5 x D	8–25,99	3–5 x D	
	**SEFAS™** Combination Tool	●	○	●	●	○		IT7–11	4–20	approx. 3 x D 5 x D 8 x D 12 x D	3,4–25	1–5 x D	

In regard to insert and drill coatings, anything is possible. If a specific insert or drill is not suitable for your workpiece material, please contact our Engineered Solutions Department for an offer about special coatings and edge preparations.

[1] Other shank styles available as customised solution.

	coolant		■ standard and □ customised solution capabilities [1]			■ standard and □ customised solution capabilities [1]									page(s)
	■		■ ■			■			□		■	□		■	I8–I10
	■		■ ■			■			□		■	□		■	I11–I13
	■		■ ■		□	■			□		■			■	I23–I27

Combination Tools

Combination drilling tools are customisable using standard components and combine centring, drilling, and countersinking into a single operation to increase productivity by reducing cycle time and tool changes.

Both the BF and SEFAS™ combination systems provide high flexibility to adapt the tool to varying hole geometries and provide full through-coolant capabilities.



Features and Benefits

BF Combination Drilling System

- Drilling, chamfering, and countersinking in one tool.
- Uses solid carbide and modular KenTIP™ drills.
- Covered drill diameter range 3,4–18mm (.125–.750").
- A specific range of drill diameters can be applied for each drill body based upon drill shank size.
- Highly flexible system:
  - Chamfer insert with different angles.
  - Insert design enables special geometrical shapes.
  - Inserts can be easily interchanged.

NOTE: TF drills may be used with one insert in limited applications.
Consult your Kennametal Sales Representative for more information.



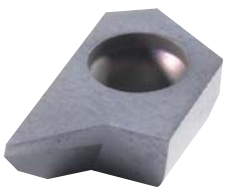
Provide high flexibility to adapt the tool to varying hole geometries.



SEFAS™ Combination Drilling System

- High-performance, self-centring drill and chamfer in one tool.
- Drill diameter range 4–18mm (.156–.750").
- Uses standard solid carbide drills in HP and TX styles as well as modular KenTIP™ drills.
- 90° and 82° angles available for chamfer inserts.
- Various shanks can be used with metric and inch diameter drills.





BF Combination Drilling System

Primary Application

Combines centring, drilling, and countersinking into a single operation, increasing productivity by reducing cycle time and number of tool changes. The modular design provides flexibility to adapt the tool to varying hole geometries in small- and medium-lot-size manufacturing.

With its slim design and full-through-coolant capabilities, the BF combination system can be used in even deeper holes, in critical materials, and with restricted workspace.

Features and Benefits

Productivity

- Reduce the number of tool changes and cycle time by combining drilling and countersinking into one operation.
- Use high-performance solid carbide drills and KenTIP™ drill bodies to achieve high speeds and feeds.
- Avoid the need for reconditioning by using KenTIP blades.

Versatility

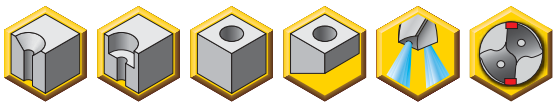
- Choose between solid carbide drills and KenTIP drill bodies.
- Various grades and insert styles.
- Flexible modular system for adjusting the drill length or insert style to manufacture different geometries.

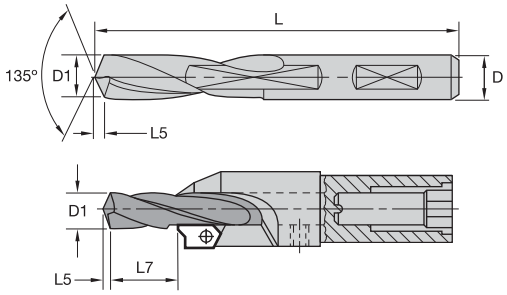
Choose between solid carbide drills and KenTIP™ drill bodies.

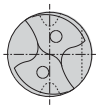


Customisation

- Length variations available as engineered solutions.
- TX drills for aluminium available as engineered solutions.
- BF inserts can be customised to almost any geometry.

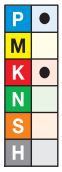








B343_HPG



● first choice
○ alternate choice

KC7315	D1	D	L	L7 min	L7 max	L5
B343S03175HPG	3,18	4	55	1,0	8,6	0,60
B343S03400HPG	3,40	4	55	1,0	10,0	0,63
B343S03500HPG	3,50	4	55	1,6	10,6	0,65
B343S03797HPG *	3,80	4	55	3,3	12,3	0,70
B343S03800HPG	3,80	4	55	3,3	12,3	0,70
B343S03970HPG	3,97	4	55	4,2	13,2	0,73
B343S04000HPG	4,00	4	55	4,4	13,4	0,74
B343S04100HPG	4,10	5	62	3,7	13,7	0,76
B343S04200HPG	4,20	5	62	4,2	14,2	0,78
B343S04300HPG	4,30	5	62	4,7	14,7	0,79
B343S04500HPG	4,50	5	62	5,6	15,6	0,83
B343S04600HPG *	4,60	5	62	5,8	15,8	0,85
B343S04623HPG	4,62	5	62	5,9	15,9	0,85
B343S04763HPG	4,76	5	62	6,6	16,6	0,88
B343S04900HPG *	4,90	5	62	7,2	17,2	0,90
B343S05000HPG	5,00	5	62	7,6	17,6	0,92
B343S05100HPG	5,10	6	66	6,8	17,8	0,60
B343S05200HPG	5,20	6	66	7,2	18,2	0,96
B343S05300HPG	5,30	6	66	7,6	18,6	0,98
B343S05400HPG	5,40	6	66	8,0	19,0	1,00
B343S05410HPG	5,41	6	66	8,0	19,0	1,00
B343S05500HPG	5,50	6	66	8,4	19,4	1,02
B343S05550HPG	5,55	6	66	8,3	19,3	1,02
B343S05558HPG *	5,56	6	66	8,4	19,4	1,03
B343S05600HPG	5,60	6	66	8,5	19,5	1,03
B343S05800HPG	5,80	6	66	9,3	20,3	1,07
B343S06000HPG	6,00	6	66	10,0	21,0	1,11
B343S06100HPG	6,10	7	74	9,1	21,1	1,13
B343S06200HPG	6,20	7	74	9,5	21,5	1,14
B343S06300HPG	6,30	7	74	9,8	21,8	1,16
B343S06350HPG	6,35	7	74	10,0	22,0	1,17
B343S06400HPG	6,40	7	74	10,2	22,2	1,18
B343S06500HPG	6,50	7	74	10,5	22,5	1,20
B343S06528HPG	6,53	7	74	10,6	22,6	1,21
B343S06600HPG	6,60	7	74	10,9	22,9	1,22
B343S06700HPG	6,70	7	74	11,2	23,2	1,24

(continued)

(B343_HPG — continued)



● first choice
○ alternate choice

KC7315	D1	D	L	L7 min	L7 max	L5
B343S06746HPG	6,75	7	74	11,4	23,4	1,25
B343S06800HPG	6,80	7	74	11,5	23,5	1,26
B343S06900HPG	6,90	7	74	11,9	23,9	1,27
B343S07000HPG	7,00	7	74	12,2	24,2	1,29
B343S07145HPG	7,14	8	79	11,1	24,1	1,32
B343S07300HPG	7,30	8	79	11,6	24,6	1,35
B343S07400HPG	7,40	8	79	11,9	24,9	1,37
B343S07500HPG	7,50	8	79	12,3	25,3	1,38
B343S07541HPG *	7,54	8	79	12,4	25,4	1,39
B343S07800HPG	7,80	8	79	13,2	26,2	1,44
B343S07900HPG	7,90	8	79	13,5	26,5	1,46
B343S07938HPG	7,94	8	79	13,6	26,6	1,47
B343S08000HPG	8,00	8	79	13,8	26,8	1,48
B343S08100HPG	8,10	9	84	12,6	26,6	1,50
B343S08200HPG	8,20	9	84	12,8	26,8	1,51
B343S08300HPG	8,30	9	84	13,1	27,1	1,53
B343S08334HPG *	8,33	9	84	13,2	27,2	1,54
B343S08400HPG	8,40	9	84	13,4	27,4	1,55
B343S08433HPG *	8,43	9	84	13,5	27,5	1,56
B343S08500HPG	8,50	9	84	13,7	27,7	1,57
B343S08600HPG	8,60	9	84	14,0	28,0	1,59
B343S08700HPG	8,70	9	84	14,3	28,3	1,61
B343S08733HPG *	8,73	9	84	14,4	28,4	1,61
B343S08800HPG	8,80	9	84	14,5	28,5	1,62
B343S09000HPG	9,00	9	84	15,1	29,1	1,66
B343S09100HPG	9,10	10	89	14,3	28,8	1,68
B343S09347HPG	9,35	10	89	15,0	29,5	1,73
B343S09400HPG *	9,40	10	89	15,1	29,6	1,74
B343S09500HPG *	9,50	10	89	15,4	29,9	1,75
B343S09525HPG *	9,53	10	89	15,4	29,9	1,76
B343S09700HPG *	9,70	10	89	15,9	30,4	1,79
B343S09800HPG	9,80	10	89	16,2	30,7	1,81
B343S09921HPG *	9,92	10	89	16,5	31,0	1,83
B343S10000HPG	10,00	10	89	16,7	31,2	1,85
B343S10100HPG	10,10	11	95	15,9	30,9	1,86
B343S10200HPG	10,20	11	95	16,2	31,2	1,88
B343S10300HPG	10,30	11	95	16,4	31,4	1,90
B343S10320HPG	10,32	11	95	16,5	31,5	1,91
B343S10400HPG	10,40	11	95	16,7	31,7	1,92
B343S10500HPG	10,50	11	95	16,9	31,9	1,94
B343S10600HPG	10,60	11	95	17,2	32,2	1,96
B343S10700HPG	10,70	11	95	17,4	32,4	1,98
B343S10710HPG	10,71	11	95	17,4	32,4	1,98
B343S10800HPG	10,80	11	95	17,7	32,7	1,99
B343S11000HPG	11,00	11	95	18,1	33,1	2,03
B343S11100HPG	11,10	12	102	17,4	32,9	2,05
B343S11110HPG	11,11	12	102	17,4	32,9	2,05
B343S11200HPG *	11,20	12	102	17,6	33,1	2,07
B343S11300HPG *	11,30	12	102	17,9	33,4	2,09
B343S11500HPG	11,50	12	102	18,3	33,8	2,12
B343S11508HPG *	11,51	12	102	18,3	33,8	2,12
B343S11700HPG	11,70	12	102	18,8	34,3	2,16

(continued)

(B343_HPG — continued)



● first choice
○ alternate choice

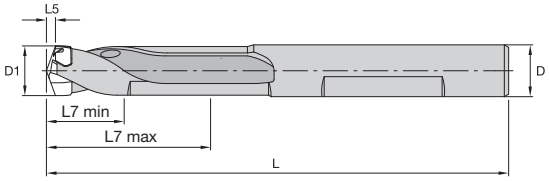
KC7315	D1	D	L	L7 min	L7 max	L5
B343S11800HPG	11,80	12	102	19,0	34,5	2,18
B343S11900HPG	11,90	12	102	19,3	34,8	2,20
B343S12000HPG	12,00	12	102	19,5	35,0	2,22
B343S12200HPG	12,20	13	102	18,9	34,9	2,25
B343S12500HPG	12,50	13	102	19,6	35,6	2,31
B343S12700HPG *	12,70	13	102	20,1	36,1	2,34
B343S12800HPG	12,80	13	102	20,3	36,3	2,36
B343S13000HPG	13,00	13	102	20,7	36,7	2,40
B343S13200HPG	13,20	14	107	20,4	36,9	2,44
B343S13500HPG	13,50	14	107	21,1	37,6	2,49
B343S14000HPG	14,00	14	107	22,1	38,6	2,58
B343S14200HPG	14,20	15	111	21,5	38,5	2,62
B343S14280HPG	14,28	15	111	21,7	38,7	2,64
B343S15000HPG	15,00	15	111	23,2	40,2	2,77
B343S15500HPG	15,50	16	115	23,2	40,7	2,86
B343S15870HPG	15,87	16	115	23,9	41,4	2,93
B343S16000HPG	16,00	16	115	24,2	41,7	2,95
B343S16500HPG	16,50	17	115	24,2	42,2	3,05
B343S16670HPG *	16,67	17	115	24,5	42,5	3,08
B343S17000HPG	17,00	17	115	25,1	43,1	3,14
B343S17500HPG	17,50	18	117	25,1	43,6	3,23
B343S17700HPG	17,70	18	117	25,5	44,0	3,27
B343S18000HPG	18,00	18	117	26,0	44,5	3,32

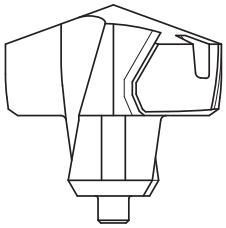
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Tolerance			
D1	**Tolerance h7**	**D**	**Tolerance h6**
>3–6	0,000/-0,012	6	0,000/-0,008
>6–10	0,000/-0,016	8–10	0,000/-0,009
>10–18	0,000/-0,018	12–18	0,000/-0,011

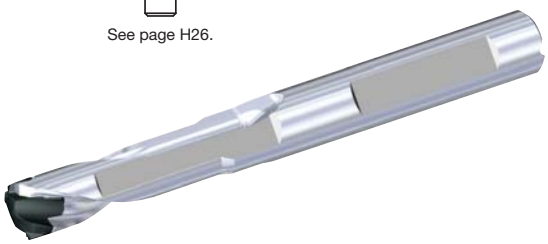
- Tool body with insert wrench included.
- Order KenTIP blades separately.







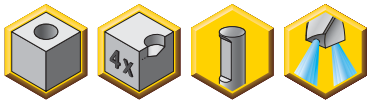
See page H26.

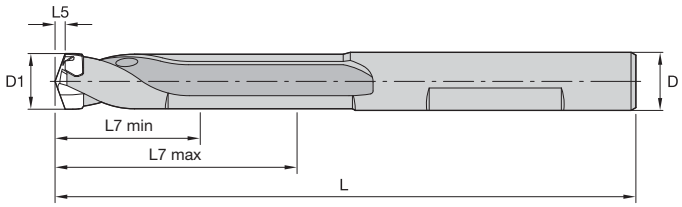


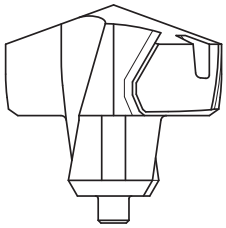
KenTIP • 3 x D • Metric

catalogue number	D1	D1 max	D	L	L7 min	L7 max	L5	insert blade seat size
KTIP080R3BF08M	8,00	8,50	8,0	80,0	11,5	25,5	1,4	F
KTIP080R3BF09M	8,00	8,50	9,0	81,0	11,5	25,5	1,4	F
KTIP085R3BF09M	8,50	9,00	9,0	82,0	12,5	27,0	1,5	G
KTIP090R3BF09M	9,00	9,50	9,0	82,0	13,5	28,5	1,6	H
KTIP090R3BF10M	9,00	9,50	10,0	91,0	13,5	28,5	1,6	H
KTIP095R3BF10M	9,50	10,00	10,0	92,0	15,0	30,0	1,6	I
KTIP100R3BF10M	10,00	10,50	10,0	93,0	16,0	31,5	1,7	J
KTIP100R3BF11M	10,00	10,50	11,0	94,0	16,0	31,5	1,7	J
KTIP105R3BF11M	10,50	11,00	11,0	94,0	17,0	33,0	1,8	K
KTIP110R3BF11M	11,00	11,50	11,0	96,0	18,5	34,5	1,9	L
KTIP110R3BF12M	11,00	11,50	12,0	106,0	18,5	34,5	1,9	L
KTIP115R3BF12M	11,50	12,00	12,0	107,0	19,5	36,0	2,0	M
KTIP120R3BF12M	12,00	12,50	12,0	108,0	20,5	37,5	2,1	N
KTIP120R3BF13M	12,00	12,50	13,0	108,0	20,5	37,5	2,1	N
KTIP125R3BF13M	12,50	13,00	13,0	110,0	22,0	39,0	2,2	O
KTIP130R3BF13M	13,00	13,50	13,0	111,0	23,0	40,5	2,2	P
KTIP130R3BF14M	13,00	13,50	14,0	111,0	23,0	40,5	2,2	P
KTIP135R3BF14M	13,50	14,00	14,0	112,0	24,5	42,0	2,3	Q
KTIP140R3BF14M	14,00	14,50	14,0	113,0	25,5	43,5	2,4	R
KTIP140R3BF15M	14,00	14,50	15,0	118,0	25,5	43,5	2,4	R
KTIP145R3BF15M	14,50	15,00	15,0	118,0	26,5	45,0	2,5	S
KTIP150R3BF15M	15,00	16,00	15,0	121,0	29,0	48,0	2,6	T
KTIP150R3BF16M	15,00	16,00	16,0	121,0	29,0	48,0	2,6	T
KTIP160R3BF16M	16,00	17,00	16,0	123,0	31,5	51,0	2,8	U
KTIP160R3BF17M	16,00	17,00	17,0	124,0	31,5	51,0	2,8	U
KTIP170R3BF17M	17,00	18,00	17,0	127,0	34,0	54,0	2,9	V
KTIP170R3BF18M	17,00	18,00	18,0	127,0	34,0	54,0	2,9	V
KTIP180R3BF18M	18,00	19,00	18,0	130,0	36,5	57,0	3,1	W

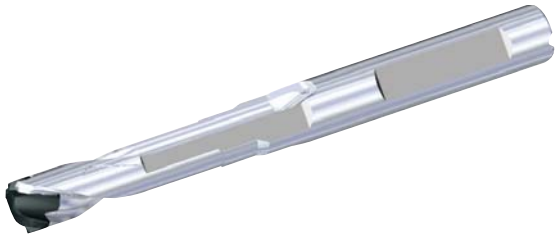
- Tool body with insert wrench included.
- Order KenTIP blades separately.







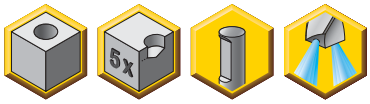
See page H26.

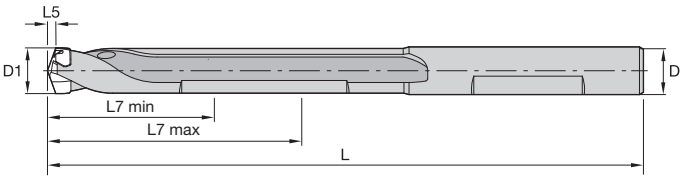


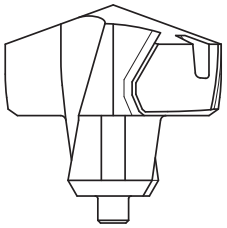
KenTIP • 4 x D • Metric

catalogue number	D1	D1 max	D	L	L7 min	L7 max	L5	insert blade seat size
KTIP080R4BF09M	8,00	8,50	9,0	89,5	20,0	34,0	1,4	F
KTIP085R4BF09M	8,50	9,00	9,0	91,0	21,5	36,0	1,5	G
KTIP090R4BF10M	9,00	9,50	10,0	100,5	23,0	38,0	1,6	H
KTIP095R4BF10M	9,50	10,00	10,0	102,0	25,0	40,0	1,6	I
KTIP100R4BF11M	10,00	10,50	11,0	104,5	26,5	42,0	1,7	J
KTIP105R4BF11M	10,50	11,00	11,0	105,0	28,0	44,0	1,8	K
KTIP110R4BF12M	11,00	11,50	12,0	117,5	30,0	46,0	1,9	L
KTIP115R4BF12M	11,50	12,00	12,0	119,0	31,5	48,0	2,0	M
KTIP120R4BF13M	12,00	12,50	13,0	120,5	33,0	50,0	2,1	N
KTIP125R4BF13M	12,50	13,00	13,0	123,0	35,0	52,0	2,2	O
KTIP130R4BF14M	13,00	13,50	14,0	124,5	36,5	54,0	2,2	P
KTIP135R4BF14M	13,50	14,00	14,0	126,0	38,5	56,0	2,3	Q
KTIP140R4BF15M	14,00	14,50	15,0	132,5	40,0	58,0	2,4	R
KTIP145R4BF15M	14,50	15,00	15,0	133,0	41,5	60,0	2,5	S
KTIP150R4BF16M	15,00	16,00	16,0	137,0	45,0	64,0	2,6	T
KTIP160R4BF17M	16,00	17,00	17,0	141,0	48,5	68,0	2,8	U
KTIP170R4BF18M	17,00	18,00	18,0	145,0	52,0	72,0	2,9	V
KTIP180R4BF18M	18,00	19,00	18,0	149,0	55,5	76,0	3,1	W

- Tool body with insert wrench included.
- Order KenTIP blades separately.







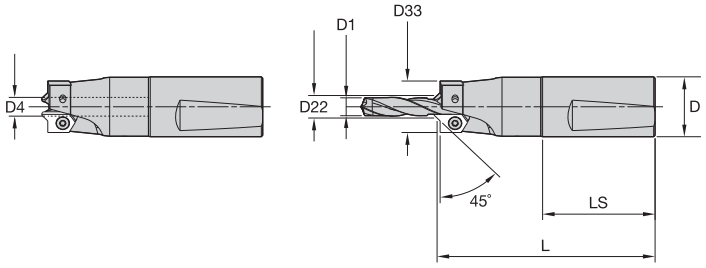
See page H26.



KenTIP • 5 x D • Metric

catalogue number	D1	D1 max	D	L	L7 min	L7 max	L5	insert blade seat size
KTIP080R5BF09M	8,00	8,50	9,0	98,0	28,5	42,5	1,4	F
KTIP085R5BF09M	8,50	9,00	9,0	100,0	30,5	45,0	1,5	G
KTIP090R5BF10M	9,00	9,50	10,0	110,0	32,5	47,5	1,6	H
KTIP095R5BF10M	9,50	10,00	10,0	112,0	35,0	50,0	1,6	I
KTIP100R5BF11M	10,00	10,50	11,0	115,0	37,0	52,5	1,7	J
KTIP105R5BF11M	10,50	11,00	11,0	116,0	39,0	55,0	1,8	K
KTIP110R5BF12M	11,00	11,50	12,0	129,0	41,5	57,5	1,9	L
KTIP115R5BF12M	11,50	12,00	12,0	131,0	43,5	60,0	2,0	M
KTIP120R5BF13M	12,00	12,50	13,0	133,0	45,5	62,5	2,1	N
KTIP125R5BF13M	12,50	13,00	13,0	136,0	48,0	65,0	2,2	O
KTIP130R5BF14M	13,00	13,50	14,0	138,0	50,0	67,5	2,2	P
KTIP135R5BF14M	13,50	14,00	14,0	140,0	52,5	70,0	2,3	Q
KTIP140R5BF15M	14,00	14,50	15,0	147,0	54,5	72,5	2,4	R
KTIP145R5BF15M	14,50	15,00	15,0	148,0	56,5	75,0	2,5	S
KTIP150R5BF16M	15,00	16,00	16,0	153,0	61,0	80,0	2,6	T
KTIP160R5BF17M	16,00	17,00	17,0	158,0	65,5	85,0	2,8	U
KTIP170R5BF18M	17,00	18,00	18,0	163,0	70,0	90,0	2,9	V
KTIP180R5BF18M	18,00	19,00	18,0	168,0	74,5	95,0	3,1	W

- Drill body shipped with all screws and wrenches.
- Order the inserts and drills separately.
- Drills with shanks up to and including 9,10mm use only one insert.





Round Shank • 2° Whistle Notch Shank • Metric

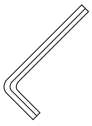



DIN 1835 Form A	DIN 1835 Form E	D1	D1 max	D4	D	D22	D33	L	LS	insert
3.37042R320	**3.37042R820**	3,40	4,00	4,00	20,0	9,0	14,9	87,5	50,0	3.41020..
3.37051R320	**3.37051R820** *	4,10	4,50	5,00	20,0	9,5	15,4	87,5	50,0	3.41020..
3.37052R320	**3.37052R820**	4,60	5,00	5,00	20,0	10,0	15,9	87,5	50,0	3.41020..
3.37061R320	**3.37061R820**	5,10	5,50	6,00	20,0	10,5	16,4	87,5	50,0	3.41020..
3.37062R320	**3.37062R820**	5,55	6,00	6,00	20,0	11,0	16,9	87,5	50,0	3.41020..
3.37071R320	**3.37071R820**	6,10	7,00	7,00	20,0	11,5	17,4	97,3	50,0	3.41020..
3.37081R320	**3.37081R820**	7,30	8,00	8,00	20,0	12,6	18,4	97,3	50,0	3.41020..
3.37091R320	**3.37091R820**	8,10	9,00	9,00	20,0	13,6	19,4	97,3	50,0	3.41020..
3.37092R320	**3.37092R820**	8,10	9,00	9,00	20,0	13,7	19,4	97,3	50,0	3.41020..
3.37101R332	**3.37101R832**	9,10	10,00	10,00	32,0	14,7	27,9	117,4	60,0	3.41220..
3.37111R332	**3.37111R832**	10,10	11,00	11,00	32,0	15,7	28,9	117,4	60,0	3.41220..
3.37121R332	**3.37121R832**	11,10	12,00	12,00	32,0	16,7	29,9	127,4	60,0	3.41220..
3.37131R332	**3.37131R832**	12,20	13,00	13,00	32,0	17,7	31,0	127,4	60,0	3.41220..
3.37141R332	**–**	13,10	14,00	14,00	32,0	18,2	31,5	127,1	60,0	3.41220..
–	**3.37141R832**	13,10	14,00	14,00	32,0	18,2	31,5	127,4	60,0	3.41220..
3.37151R332	**–**	14,10	15,00	15,00	32,0	19,3	32,5	127,4	60,0	3.41220..
–	**3.37151R832**	14,10	15,00	15,00	32,0	19,3	32,5	127,1	60,0	3.41220..
3.37161R332	**3.37161R832**	15,50	16,00	16,00	32,0	20,3	33,5	127,1	60,0	3.41220..
3.37171R332 *	**3.37171R832**	16,50	17,00	17,00	32,0	21,3	34,5	127,1	60,0	3.41220..
3.37181R332	**3.37181R832**	17,50	18,00	18,00	32,0	22,3	35,5	127,1	60,0	3.41220..

NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Spare Parts



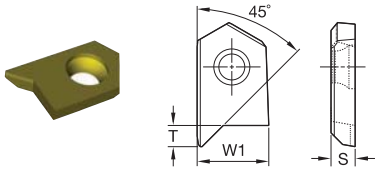




D1	back-up screw	drill clamp screw	hex wrench	insert screw	wrench
3,40	**192.888**	**192.718**	**170.003**	**192.432**	**170.028**
4,10	**192.888**	**192.718**	**170.003**	**192.432**	**170.028**
4,60	**192.888**	**192.718**	**170.003**	**192.432**	**170.028**
5,10	**192.888**	**192.718**	**170.003**	**192.432**	**170.028**
5,55	**192.888**	**192.718**	**170.003**	**192.432**	**170.028**
6,10	**192.888**	**192.718**	**170.003**	**192.432**	**170.028**
7,30	**192.888**	**192.718**	**170.003**	**192.432**	**170.028**
8,10	**192.888**	**192.718**	**170.003**	**192.432**	**170.028**
9,10	**192.889**	**192.720**	**170.005**	**191.725**	**170.025**
10,10	**192.889**	**192.720**	**170.005**	**191.725**	**170.025**
11,10	**192.889**	**192.720**	**170.005**	**191.725**	**170.025**
12,20	**192.889**	**192.720**	**170.005**	**191.725**	**170.025**
13,10	**192.889**	**192.720**	**170.005**	**191.725**	**170.025**
14,10	**192.889**	**192.720**	**170.005**	**191.725**	**170.025**
15,50	**192.889**	**192.720**	**170.005**	**191.725**	**170.025**
16,50	**192.889**	**192.720**	**170.005**	**191.725**	**170.025**
17,50	**192.889**	**192.720**	**170.005**	**191.725**	**170.025**

NOTE: Dimensions are factored with a 45° insert positioned in insert pocket.

- Standard steel drill bodies are designed for inserts with 41° and 45° chamfers.

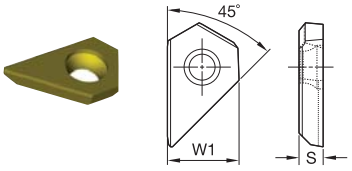


● first choice
○ alternate choice

P		●	●
M		●	
K		●	●
N			
S			
H			

BF Insert R901 • 45° with Spot Face

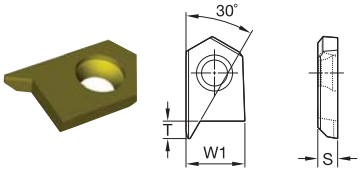
catalogue number	S	W1	T	CS5	KC7315
3.41020R901	3,00	6,10	2,90	●	●
3.41220R901	3,50	10,10	3,05	●	●



BF Insert R902 • 45°

catalogue number	S	W1	CS5	KC7315
3.41020R902	3,00	6,10	●	●
3.41220R902	3,50	10,10	●	●

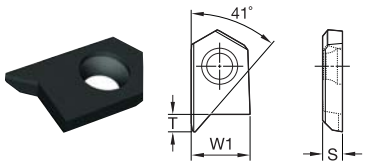
- When using the 60° insert or special insert, the assembled tool should be inspected.
- These insert combinations require that the steel body be altered to provide insert coverage.



BF Insert R903 • 60° with Spot Face

catalogue number	S	W1	T	CS5	KC7315
3.41020R903	3,00	6,10	2,90	●	●
3.41220R903	3,50	10,10	3,05	●	●

- Standard steel drill bodies are designed for inserts with 41° and 45° chamfers.

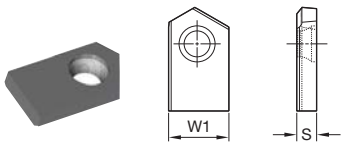


● first choice
○ alternate choice

P	●
M	
K	●
N	
S	
H	

BF Insert R904 • 41° with Spot Face

catalogue number	S	W1	T	KC7315
3.41020R904	3,00	6,10	2,90	●
3.41220R904	3,50	10,10	3,05	●

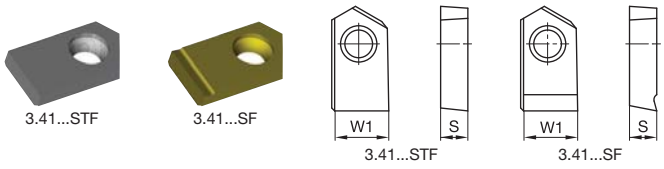


● first choice
○ alternate choice

P	
M	
K	○
N	●
S	
H	

BF Insert R900 • Semi-Finished

catalogue number	S	W1	KMF
3.41020R900	3,00	6,10	●
3.41220R900	3,50	10,10	●



● first choice
○ alternate choice

P	●	
M	●	
K	●	○
N		●
S		
H		

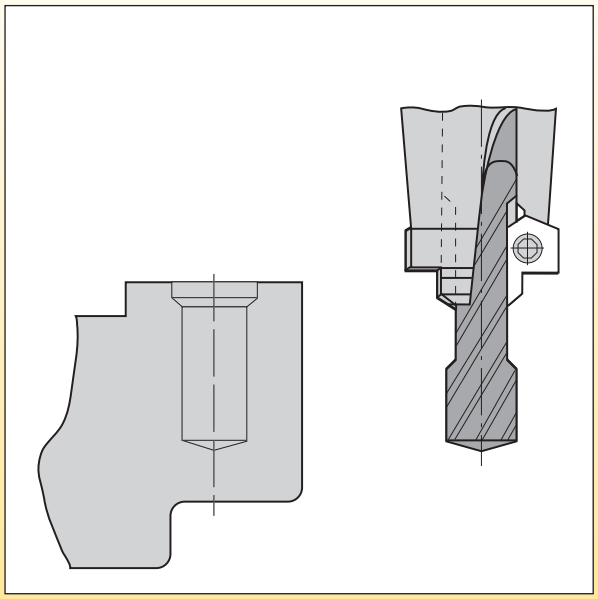
BF Insert R900 S(T)F • Semi-Finished

catalogue number	S	W1	CS5	KMF
3.41020R900STF	3,00	6,10	●	–
3.41220R900SF	3,50	10,10	–	●
3.41220R900STF	3,50	10,10	●	–

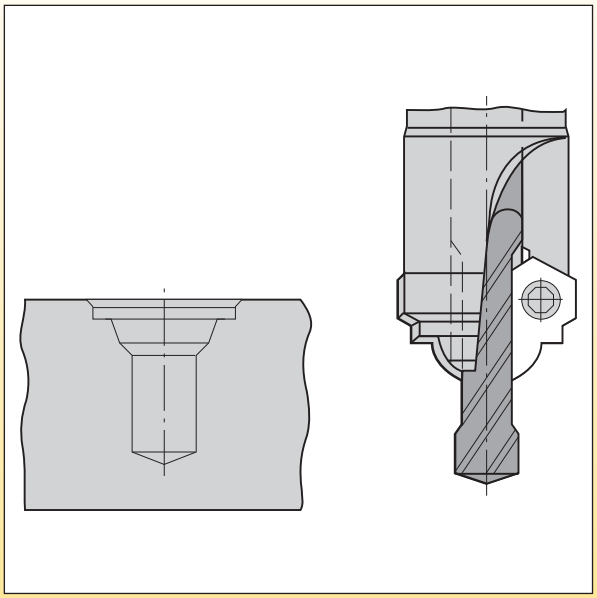
Engineered Solutions Available!



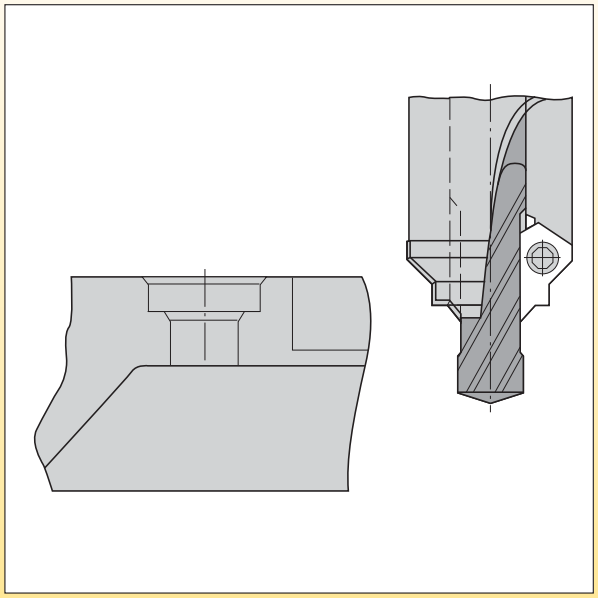
Tapped Hole with Protection Countersinking



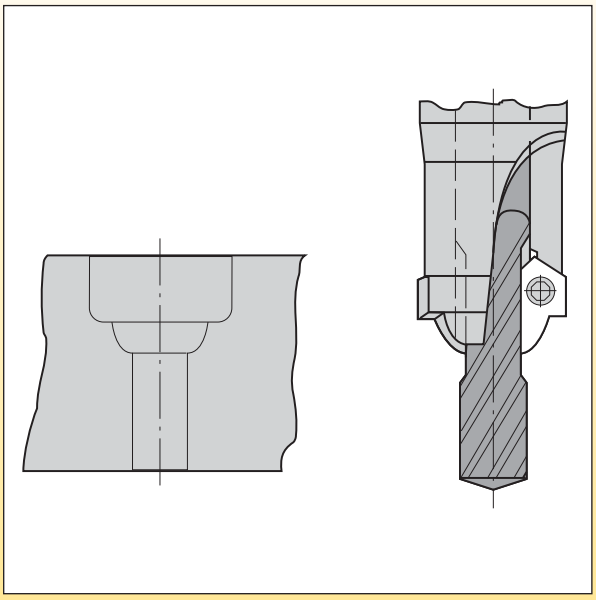
Countersinking for Round Sealing Rings



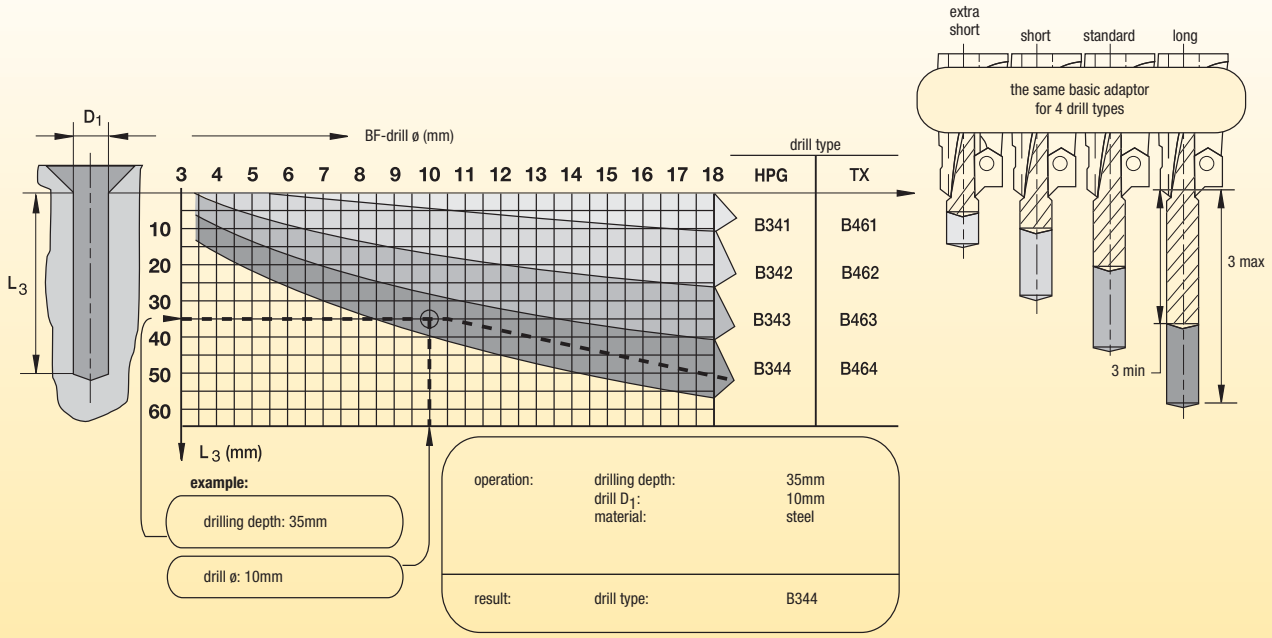
Countersinking for Countersunk Head Screws



Countersinking for Aluminium Rim



Possible Drilling Depths • Semi-Standard Series

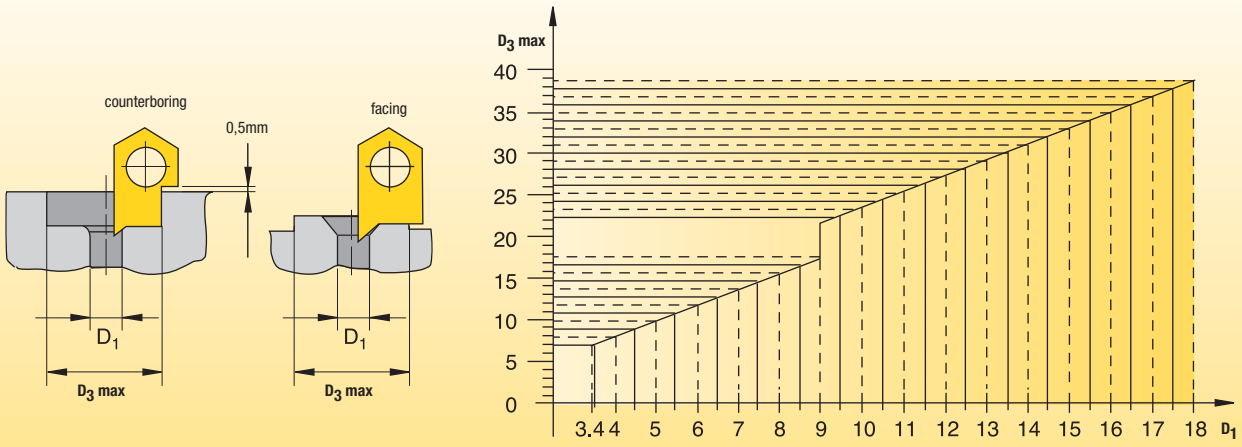


Possible Facing and Counterboring Diameters

90º insert blanks are available to grind special geometry forms for other multiprofile applications. Contact your local Kennametal Representative for special insert profile designs and quoting.

Use the table below to determine the maximum facing or counterboring diameter for a given BF drill diameter. Reference your chosen drill diameter across the bottom axis of the table and then read up and across to the left axis to find the maximum facing or counterboring diameter.

Possible Facing and Countersinking Diameter • Machining Steel



HP Drills • B343HPG Series • Grade KC7315™ • Through Coolant • Metric



Material Group		Cutting Speed — vc			Metric								
		Range — m/min			Recommended Feed Rate (f) by Diameter								
		min	Starting Value	max		3,0	4,0	6,0	8,0	10,0	12,0	16,0	18,0
P	1	100	**140**	180	mm/r	0,07–0,16	0,08–0,19	0,10–0,23	0,13–0,29	0,15–0,33	0,17–0,37	0,19–0,44	0,22–0,44
	2	90	**115**	140	mm/r	0,07–0,13	0,08–0,17	0,10–0,19	0,13–0,23	0,15–0,27	0,17–0,30	0,19–0,35	0,22–0,39
	3	80	**100**	120	mm/r	0,10–0,16	0,11–0,19	0,13–0,23	0,16–0,29	0,19–0,33	0,21–0,37	0,25–0,44	0,28–0,49
	4	70	**90**	110	mm/r	0,08–0,16	0,10–0,19	0,11–0,22	0,12–0,25	0,14–0,29	0,16–0,32	0,21–0,41	0,24–0,46
	5	70	**85**	110	mm/r	0,07–0,12	0,08–0,14	0,10–0,16	0,12–0,20	0,14–0,23	0,16–0,26	0,18–0,31	0,21–0,34
K	1	100	**120**	140	mm/r	0,09–0,17	0,10–0,21	0,12–0,25	0,15–0,31	0,17–0,35	0,20–0,39	0,23–0,46	0,26–0,52
	2	80	**105**	130	mm/r	0,09–0,15	0,10–0,18	0,12–0,21	0,15–0,26	0,18–0,30	0,20–0,33	0,23–0,39	0,26–0,44
	3	70	**85**	100	mm/r	0,08–0,13	0,10–0,15	0,11–0,19	0,14–0,23	0,16–0,26	0,18–0,30	0,21–0,35	0,23–0,39

SEFAS™ Combination Drilling System

Primary Application

Combines centring, drilling, and chamfering into a single operation, increasing productivity by reducing cycle time and number of tool changes.

Achieve productivity gains by still using standard solid carbide or KenTIP™ drills. The SEFAS system provides full through coolant capabilities.



Features and Benefits

Productivity

- Reduce the number of tool changes and cycle time by combining drilling and countersinking into one operation.
- Achieve highest metal removal rates by applying an HP-style drill.
- Reduce inventory and avoid reconditioning by using KenTIP blades.
- Easily change tool within the machine by using KenTIP.

Versatility

- Any style of standard HP drill can be used for highest metal removal rates.
- Use TX drills to achieve excellent hole quality and tool life in non-ferrous materials.
- For increased accuracy and tool life, use the Kennametal hydraulic chuck recommended for cylindrical tool shanks.
- Range of insert styles for use in most workpiece materials.

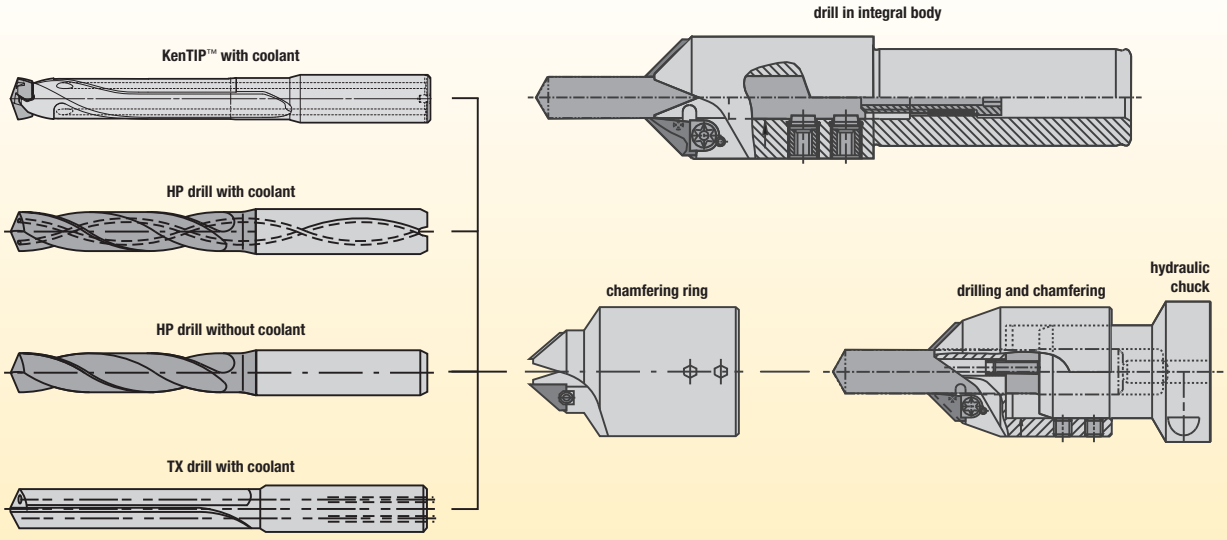
Reduce the number of tool changes and cycle time by combining drilling and countersinking into one operation.





Customisation

- Length variations available as engineered solutions.

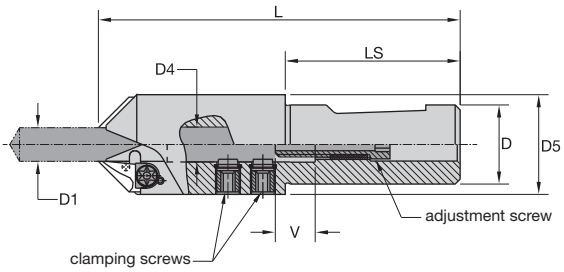


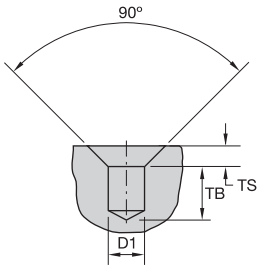
The SEFAS combination drilling system may be used in most workpiece materials. The design and flexibility of the system can be used with a wide variety of solid carbide drills.

Three types of SEFAS chamfering tools are offered: (1) integral bodies with a compact design that provides additional workpiece and work-holding clearance; (2) chamfering rings that may be mounted to Kennametal hydraulic chucks for optimal drill performance and increased productivity; and (3) high-performance HSK bodies (available as customised solutions) for new machine spindles and high-output applications.



- Drill body shipped with all screws, clamps, and wrenches.
- Order the inserts and drills separately.
- Two chamfer inserts required per body.



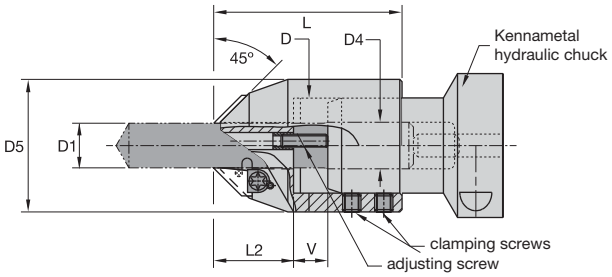


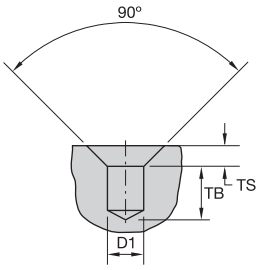


2° Whistle Notch (WN) Shank • For Use with Metric Drills • Metric

catalogue number	D1	D1 max	D	D4	D5	L	LS	V	gage insert	insert clamp	Torx wrench	drill clamp screw	adjusting screw
3.37060R720	4,000	6,0	20,0	6,0	24,0	102,0	52,0	18,0	3.42805..	**360.550**	**170.024**	**360.630**	**360.510**
3.37080R720	>6,000	8,0	20,0	8,0	26,0	108,0	52,0	18,0	3.42805..	**360.550**	**170.024**	**360.634**	**360.510**
3.37100R720	>8,000	10,0	20,0	10,0	29,0	122,0	52,0	17,0	3.42805..	**360.550**	**170.024**	**360.631**	**360.510**
3.37120R732	>10,000	12,0	32,0	12,0	38,0	133,0	62,0	21,0	3.42807..	**360.551**	**170.025**	**360.635**	**360.513**
3.37140R732	>12,000	14,0	32,0	14,0	40,0	137,0	62,0	16,0	3.42807..	**360.551**	**170.025**	**360.636**	**360.511**
3.37160R732	>14,000	16,0	32,0	16,0	41,5	141,0	62,0	19,0	3.42807..	**360.551**	**170.025**	**360.632**	**360.511**
3.37180R732	>16,000	18,0	32,0	18,0	47,0	144,0	62,0	15,0	3.42807..	**360.551**	**170.025**	**360.633**	**360.511**

- Drill body shipped with all screws, clamps, and wrenches.
- Order the inserts and drills separately.
- Use only with hydraulic chucks.







Chamfer Rings • For Use with Metric Kennametal Hydraulic Chucks • For Use with Inch or Metric Drills



catalogue number	D1	D1 max	D	D4	D5	L	L2	V	gage insert	insert clamp	Torx wrench	drill clamp screw	adjusting screw	adjusting screw
3.37526R006	4,000	6,0	25,70	6,00	38,00	49,50	21,00	5,00	3.42805..	**360.550**	**170.024**	**190.195**	–	**192.057**
3.37528R008	>6,000	8,0	27,70	8,00	40,00	50,00	21,00	6,00	3.42805..	**360.550**	**170.024**	**190.195**	**190.371**	–
3.37530R010	>8,000	10,0	29,70	10,00	41,50	56,50	22,00	8,00	3.42805..	**360.550**	**170.024**	**190.195**	**193.113**	–
3.37532R012	>10,000	12,0	31,60	12,00	48,00	68,00	29,00	12,00	3.42807..	**360.551**	**170.025**	**190.076**	**193.114**	–
3.37534R014	>12,000	14,0	33,60	14,00	50,00	70,50	29,00	12,00	3.42807..	**360.551**	**170.025**	**190.076**	**193.114**	–
3.37538R016	>14,000	16,0	37,60	16,00	54,00	78,00	32,00	12,00	3.42807..	**360.551**	**170.025**	**190.076**	**193.115**	–
3.37540R018	>16,000	18,0	39,60	18,00	56,00	80,50	34,00	15,00	3.42807..	**360.551**	**170.025**	**190.076**	**193.116**	–
3.37542R020	>18,000	20,0	41,60	20,00	58,00	82,50	35,00	15,00	3.42807..	**360.551**	**170.025**	**190.076**	**193.116**	–

Achievable Drilling (TB) and Sink Depths (TS)



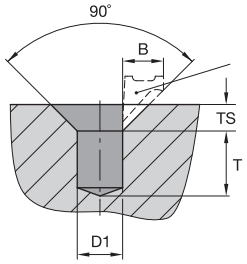
	B210, B221, B224, B254, B284, B291, B707, B966, B976		B211, B222, B225, B285, B292, B411, B708, B977		B212, B256, B709, B978		B269		unalloyed and low-alloy steel; unalloyed and alloy steel, and cast iron, high-alloy steel and stainless steel		
drill diameter D1	TB_{min}	TB_{max}	TB_{min}	TB_{max}	TB_{min}	TB_{max}	TB_{min}	TB_{max}	TS_{100}	TS_{80}	TS_{max}
4,0–4,7	4	17	12	29	20	36	45	62	1,2	1,8	2,5
>4,7–6,0	4	20	20	35	27	43	63	80	1,5	2,2	3,0
>6,0–7,0	11	24	23	40	32	49	71	88	2	3,0	4,0
>7,0–8,0	11	28	23	40	42	59	85	102	2,5	4,0	5,0
>8,0–10,0	13	29	27	43	46	62	109	125	2,5	4,0	5,0
>10,0–12,0	15	35	31	51	54	74	131	151	3,5	5,0	7,0
>12,0–14,0	21	36	38	53	69	84	160	175	4,0	6,0	8,0
>14,0–16,0	22	40	40	58	78	96	184	202	4,0	6,0	8,0
>16,0–18,0	31	45	51	65	93	107	213	227	4,0	6,0	8,0
>18,0–20,0	34	50	56	72	103	119	237	253	4,0	6,0	8,0

(continued)

(Achievable Drilling (TB) and Sink Depths (TS) — continued)

drill diameter D1	K210, K254, K284		K211, K222, K255, K285, K411		K212, K256		unalloyed and low-alloy steel, unalloyed and alloy steel, and cast iron, high-alloy steel and stainless steel		
	TB_{min}	TB_{max}	TB_{min}	TB_{max}	TB_{min}	TB_{max}	TS_{100}	TS_{80}	TS_{max}
.156–.250	not applicable (drill shank diameter > chamfer ring inside diameter), not applicable (metric ring and hydraulic chuck are not interchangeable)								
>.250–.313									
>.313–.375	.748	1.339	1.229	1.890	2.165	2.756	.098	.157	.197
>.375–.500	not applicable (drill shank diameter > chamfer ring inside diameter), not applicable (metric ring and hydraulic chuck are not interchangeable)								
>.500–.563									
>.563–.625	.906	1.732	1.614	2.441	3.110	3.937	.157	.236	.315
>.625–.709	not applicable (metric ring and hydraulic chuck are not interchangeable)								
>.709–.750	1.142	2.087	1.890	2.835	3.819	4.764	.157	.236	.315

NOTE: TS_{100}: maximum sink depths at which the full feed values can be maintained during chamfering and sinking.
TS_{80}: maximum sink depths that can be achieved without chipbreak cycles and at a 20% feed reduction.
TS_{max}: maximum sink depths that can be achieved without chipbreak cycles and at a 50% feed reduction.
When using SEFAS with GOdrill™, please contact your Kennametal Representative for application support.

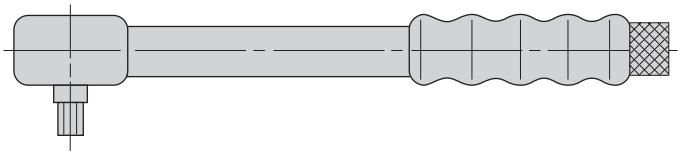




Achievable Drilling (T) and Sink Depths (TS) with KenTIP Tool Bodies

D1 mm	drilling depths (T) with SEFAS compact tools 3x T	3x T_{max}	5x T	5x T_{max}	8x T	8x T_{max}	drilling depths (T) with SEFAS chamfer rings 3x T	3x T_{max}	5x T	5x T_{max}	8x T	8x T_{max}	sink depths (TS) TS_{100}	TS_{80}	TS_{max}
8,00–8,49	11	19	21	37	47	63	11	22	22	40	48	66	2,5	4,0	5,0
8,50–8,99	12	21	24	40	51	67	12	24	25	43	52	70	2,5	4,0	5,0
9,00–9,49	12	23	27	43	56	72	12	26	28	46	57	75	2,5	4,0	5,0
9,50–9,99	13	25	31	47	61	77	13	28	32	50	62	80	2,5	4,0	5,0
10,00–10,49	13	26	28	49	60	81	13	28	29	51	61	83	3,5	5,0	7,0
10,50–10,99	14	28	31	52	64	85	14	30	32	54	65	87	3,5	5,0	7,0
11,00–11,49	14	30	34	55	69	90	14	32	35	57	70	92	3,5	5,0	7,0
11,50–11,99	15	32	37	58	73	94	15	34	38	60	74	96	3,5	5,0	7,0
12,00–12,49	15	30	41	56	79	94	15	32	36	58	74	96	4,0	6,0	8,0
12,50–12,99	17	32	44	59	83	98	16	34	39	61	78	100	4,0	6,0	8,0
13,00–13,49	19	34	47	62	88	103	16	36	42	64	83	105	4,0	6,0	8,0
13,50–13,99	21	36	51	66	93	108	17	38	46	68	88	110	4,0	6,0	8,0
14,00–14,49	19	37	50	68	94	112	18	40	49	71	93	115	4,0	6,0	8,0
14,50–14,99	21	39	53	71	98	116	20	42	52	74	97	119	4,0	6,0	8,0
15,00–15,99	25	43	59	77	107	125	24	46	58	80	106	128	4,0	6,0	8,0
16,00–16,99	29	47	65	83	117	135	28	50	64	85	115	136	4,0	6,0	8,0
17,00–17,99	35	49	73	87	127	141	30	54	68	92	122	146	4,0	6,0	8,0
18,00–18,99	36	52	76	92	133	149	33	57	73	97	130	154	4,0	6,0	8,0
19,00–19,99	40	56	82	98	142	158	37	61	79	103	139	163	4,0	6,0	8,0

NOTE: TS_{100}: maximum sink depths at which the full feed values can be maintained during chamfering and sinking.
TS_{80}: maximum sink depths that can be achieved without chipbreak cycles and at a 20% feed reduction.
TS_{max}: maximum sink depths that can be achieved without chipbreak cycles and at a 50% feed reduction.
T: minimum drilling depth that can be achieved due to the protruded length of the drill.
T_{max}: maximum drilling depth that can be achieved due to the protruded length of the drill.



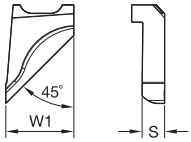
Torque Wrench • Metric





drill diameter D1	torque wrench	tightening torque Nm	SW	drill clamp screw	wrench adaptor
4,0–6,0	**170.190**	7	3	**360.630**	**170.240**
>6,0–8,0	**170.190**	8	3	**360.635**	**170.240**
>8,0–10,0	**170.190**	10	4	**360.631**	**170.232**
>10,0–12,0	**170.190**	15	4	**360.635**	**170.232**
>12,0–14,0	**170.190**	20	5	**360.636**	**170.233**
>14,0–16,0	**170.190**	30	5	**360.632**	**170.233**
>16,0–18,0	**170.190**	45	6	**360.633**	**170.234**
>18,0–20,0	**170.190**	45	6	**360.637**	**170.234**





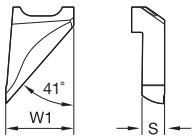
● first choice
○ alternate choice

P	●
M	
K	●
N	●
S	
H	

SEFAS Chamfering Inserts for Solid Carbide Drills • 45°

catalogue number	angle	S	W1	CS5	KC7215	KMF
3.42805R001	45	2,83	8,00	●	●	●
3.42807R001	45	3,98	12,00	●	●	●





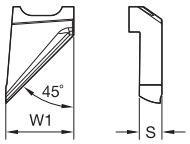
● first choice
○ alternate choice

P	
M	
K	●
N	●
S	
H	

SEFAS Chamfering Inserts for Solid Carbide Drills • 41°

catalogue number	angle	S	W1	KC7215
3.42805R081	41	2,83	8,00	●
3.42807R081	41	3,98	12,00	●





● first choice
○ alternate choice

P	●
M	●
K	●
N	●
S	
H	

SEFAS Chamfering Inserts for KenTIP™ Drills • 45°

catalogue number	angle	S	W1	CS5	KC7015	KC7215	KC7315	KMF
3.42805R001	45	2,83	8,00	●	–	●	–	●
3.42805R021	45	2,83	8,00	–	●	–	●	–
3.42807R001	45	3,98	12,00	●	–	●	–	●
3.42807R021	45	3,98	12,00	–	●	–	●	–



Indexable Drills

Tool Selection Guide **J2–J3**

Drill Fix DFR, DFSP, and DFT **J4–J50**

Drill Fix DFR J4, J8–J18

Drill Fix DFSP J4, J20–J40

Drill Fix DFT J5, J42–J46, J48–J50

HTS Series Indexable Deep-Hole Drilling System **J52–J83**

HTS and HTS-R Indexable Drill System J52–J83

Indexable Drill Inserts **J84–J94**

Drill Fix DFR Inserts J84–J86

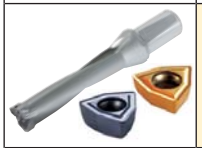
Drill Fix DFT Inserts J85–J88

Drill Fix DFSP Inserts J89–J90

CTR Counterboring Tools **J96–J101**

Counterboring Inserts J99–J101



		standard							standard range		customised solution range	
		● first choice ○ alternate choice							diameter range		diameter range	
		P	M	K	N	S	H	hole tolerance	D1 mm min–max	drilling depth L/D1	D1 mm min–max	drilling depth
	**DFR™** Indexable Drill Body *Short-Hole Drilling*	●	●	●	●	●		IT9–11	12,5–25	2 x D 3 x D 4 X D	12,5–26	1–5 x D
	**DFSP™** Indexable Drill Body *Short-Hole Drilling*	●	●	●	●	●		IT9–11	14–55	2 x D 3 x D 4 x D 5 x D	14–85	1–5 x D
	**DFT™** Indexable Drill Body *Short-Hole Drilling*	●	●	●	●	●		IT9–11	16–83	2.5 x D 4 x D	15,8–83	1–5 x D
	**HTS-R** Indexable Drilling Tool *Deep-Hole Drilling*	●	●	●	●	●		IT9–11	40–55	10 x D	40–55	1–10 x D
	**HTS** Indexable Drilling Tool *Deep-Hole Drilling*	●	●	●	●	●		IT9–11	45–270	10 x D	45–540	1–10 x D
	**S2 S Countersinking** Countersinking Tool	●	●	●	●	●		IT9–11	15,1–46,2	1 x D	11,5–150	1–5 x D

In regard to insert and drill coatings, anything is possible. If a specific insert or drill is not suitable for your workpiece material, please contact our Engineered Solutions Department for an offer about special coatings and edge preparations.
*Except for L/D 5 x D.
[1] Other shank styles available as customised solution.

	coolant		■ standard capabilities [1]						■ standard and □ customised solution capabilities									page(s)
		■		■	■				■	■	■	■	■	□	□			J10–J18
		■		■	■	■			■	■	■	■	■*	□	□		□	J22–J40
		■		■	■	■			■	■	■	■	■	□	□			J44–J50
		■			■		■	■	■									J67–J70
		■			■		■	■	■									J72–J83
		■	■												■	□		J98–J101

Drill Fix™ DFR™, DFSP™, and DFT™

Primary Application

Drill short holes up to 5 x D with DFR, DFSP, and DFT indexable drills in steel, cast iron, ductile iron, stainless steel, and non-ferrous materials. The Drill Fix portfolio covers the diameter range 12,5–85mm (.500–3.250").

Features and Benefits

Drill Fix DFR

- Diameter range of 12,5–24mm (.500–1.000") in 2 x D, 3 x D, and 4 x D.
- Rectangular-shaped inserts offer the highest stability and feed rates at smaller sizes.
- Long tool life due to soft starting cut, short chips, and low cutting forces.
- X-offset design to adjust diameter size on turning machines and optimise tolerances on machining centres.

Drill Fix DFSP

- Combines the benefits of a trigon-style DFT inboard and a square-style SP..X outboard insert.
- Standard diameter range from 14–55mm (.551–2.125") in 2 x D, 3 x D, 4 x D, and new 5 x D.
- Squared-outboard insert has four economic cutting edges.
- Highest feed rates and cutting speeds due to highly stable tool body design.
- X-offset design to adjust diameter size on turning machines and optimise tolerances on machining centres.
- Beyond™ grades to achieve highest productivity and outstanding results in steel, stainless steel, and cast iron.

Use where speed and economy are prime considerations.

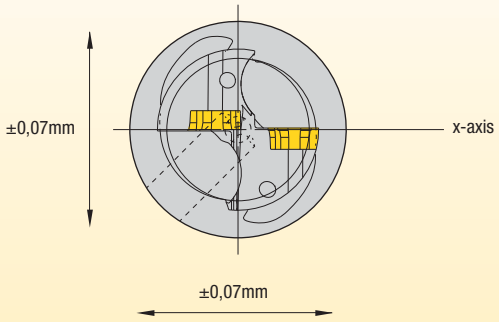


Drill Fix™ DFT™

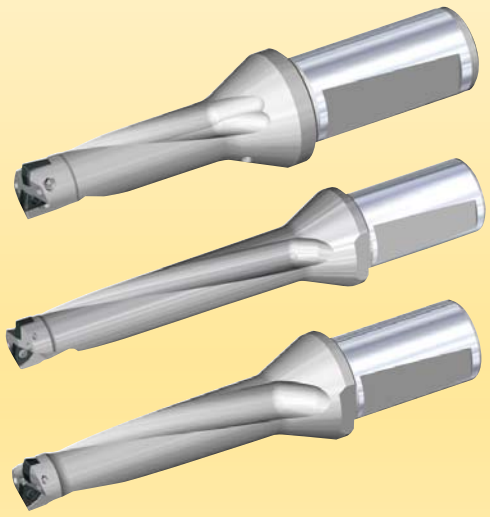
- One drill system that covers a large diameter range, from 24–82mm (1.000–3.250") in 2.5 x D and 4 x D.
- Best centring capabilities due to trigon-shaped inserts used as inboard and outboard inserts.
- Various insert grades and geometries available.
- Balanced cutting forces in the shank centre for highest tool body stability.
- X-offset design to adjust diameter size on turning machines and optimise tolerances on machining centres.
- The Drill Fix DFT system has an inner insert for best centring capabilities.

Stationary Applications

Metric Drill Bodies with 2° Whistle Notch



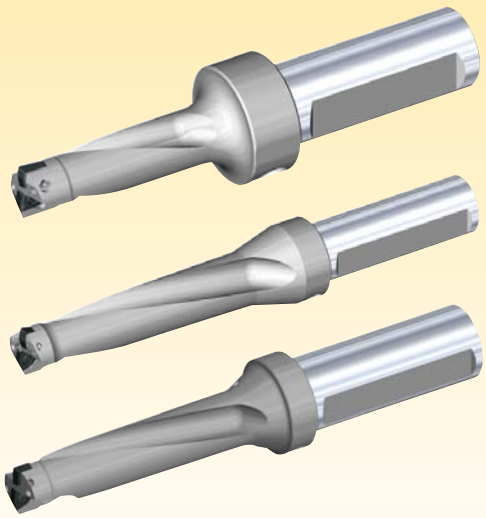
Metric shank drills with a 2° Whistle Notch shank are easily mounted into inch turrets using a WD adaptor. Align the X-axis of the drill with the X-axis of the machine tool as described above. Accurate alignment is absolutely essential for good performance. The drill must be on centre within the tolerance shown above. Angularity must not exceed 0,07mm.



Inch Bodies • Flange

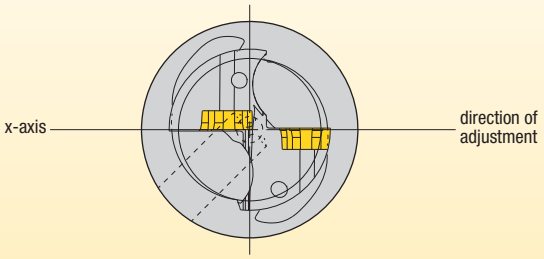
Drill Fix™ inch drills, with a flange, were designed for use on lathes or any machine where the tool remains stationary and the workpiece rotates. An “x” is marked on the flat of the X-axis of the drill to aid insert orientation on the machine tool.

It is important to align the X-axis of the drill with the X-axis on the machine tool. Accurate alignment is absolutely essential for good performance. The drill must be on centre, within the tolerance shown here. Angularity must not exceed 0,07mm within the designated drill depth.



Drill Fix™ X-Adjustment

Application Examples

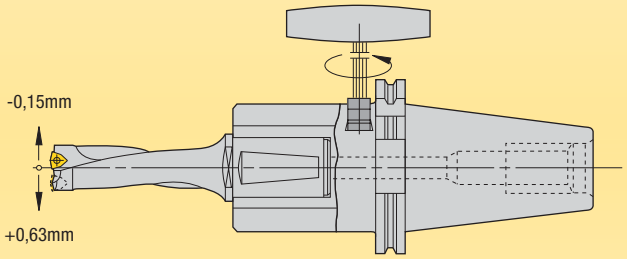


Stationary Tool

The X-adjustment must be made at the outer cutting edge, parallel to the surface of the outer insert when the turret of the turning machine is offset along the X-axis.

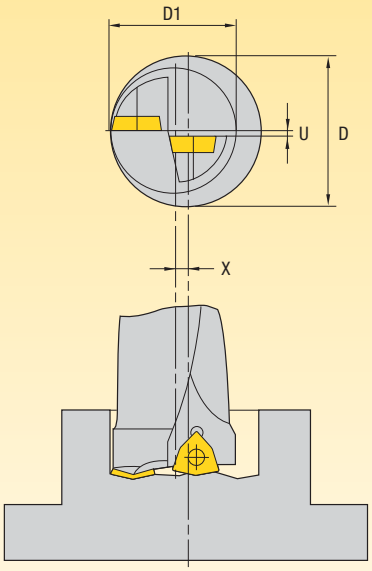
Rotating Tool • Straight Shank

Use an adjustable eccentric chuck with a steep taper to help offset the drill along the X-axis when machining with a rotating tool on a machining centre.



X-Adjustment Description

Different diameter holes can be drilled using the same Drill Fix drill. Holes with a diameter greater than the nominal diameter can be drilled directly into a solid. Intermediate dimensions are produced by means of the X-adjustment.



Benefits

- Eliminates the need for special tools for intermediate dimensions.
- Just a few drills cover a wide application range.
- Once precise adjustment of the desired diameter is made, tolerances of ±0,05mm are achieved.

Additional information on X-adjustment, as well as additional information on Drill Fix tools, is available on the Kennametal website, ***kennametal.com****.*

Drill Fix™ DFR™

The Drill Fix DFR platform offers maximum feed rates at a diameter range of 12,5–24mm (.500–1.000") for 2 x D, 3 x D, and 4 x D applications. Using rectangular-shaped inboard and outboard inserts enables soft starting cuts, short chips, and higher feed rates compared to small-size symmetrical-trigon or square inserts. The Drill Fix DFR platform's low cutting forces provide long tool life and high stability at the smallest diameters.

Features and Benefits

Productivity and Profitability

- Achieve high feed rates with rectangular-shaped inserts that offer a soft starting cut and greater stability.
- Use X-offset on turning machines to adjust drill, and eliminate the need for specials in many applications, and on machining centres to reach tolerance optimisation.
- Same insert size is used in each pocket, reducing inventory costs.

Versatility

- Diameter range covering 12,5–24mm (.500-1.000").
- 2 x D, 3 x D, and 4 x D L/D ratios as standard.
- Various shanks as standard available: WD, SSF, and new WB, a Weldon® shank.
- Multiple insert grades and geometries available.
- Use where feed rates are the limiting factor.
- Apply in straight holes, inclined entries and exits, interrupted cuts, and rough or welded entry surfaces.
- Eccentric chuck available as standard.

Low cutting forces provide long tool body life and high stability at the smallest diameters.



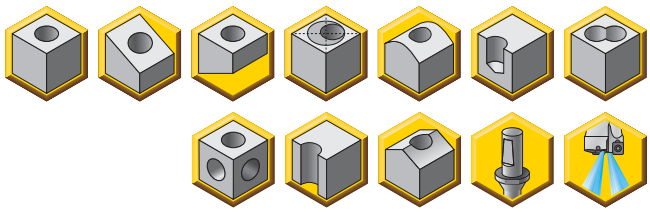
Reliability

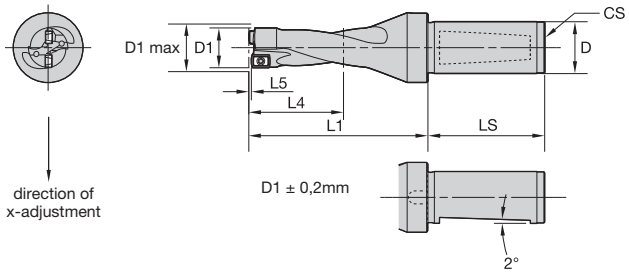
- High stability in smaller sizes due to rectangular-shaped insert.
- Same insert can be used as inboard or outboard insert. No risk of mixing up inner and outer inserts.
- Low cutting forces result in long body tool life.

Customisation

- Intermediate diameters available as semi-standards.
- Engineered solutions available.
- Multistep drills available upon request.
- Left-hand version available.

- Drill shipped with insert screws and Torx wrench.
- See pages J84–J85 for inserts.







WN/WD Shank • 2 x D • Metric

D							
20	32	D1	D1 max	L1	L4 max	L5	gage insert
DFR125R2WD20M	–	12,50	13,50	47,4	25,0	0,5	DFR0202..
DFR127R2WD20M	–	12,70	13,70	47,8	25,4	0,5	DFR0202..
DFR130R2WD20M	–	13,00	14,00	48,4	26,0	0,5	DFR0202..
DFR135R2WD20M	–	13,50	14,50	49,4	27,0	0,5	DFR0202..
DFR140R2WD20M	–	14,00	15,00	50,4	28,0	0,5	DFR0202..
DFR145R2WD20M	–	14,50	15,50	53,4	29,0	0,5	DFR0202..
DFR150R2WD20M	–	15,00	16,00	54,4	30,0	0,5	DFR0202..
DFR155R2WD20M	–	15,50	16,50	55,4	31,0	0,5	DFR0202..
DFR160R2WD20M	–	16,00	17,00	56,4	32,0	0,5	DFR0202..
–	**DFR165R2WD32M**	16,50	17,50	62,4	33,0	0,6	DFR0302..
–	**DFR170R2WD32M**	17,00	18,00	63,4	34,0	0,6	DFR0302..
–	**DFR175R2WD32M**	17,50	18,50	64,4	35,0	0,6	DFR0302..
–	**DFR180R2WD32M**	18,00	19,00	65,4	36,0	0,6	DFR0302..
–	**DFR185R2WD32M**	18,50	19,50	66,4	37,0	0,6	DFR0302..
–	**DFR190R2WD32M**	19,00	20,00	67,4	38,0	0,6	DFR0302..
–	**DFR195R2WD32M**	19,50	20,50	68,4	39,0	0,6	DFR0302..
–	**DFR200R2WD32M**	20,00	21,00	72,4	40,0	0,6	DFR0302..
–	**DFR205R2WD32M**	20,50	21,50	73,6	41,0	0,8	DFR0403..
–	**DFR210R2WD32M**	21,00	22,00	74,6	42,0	0,8	DFR0403..
–	**DFR220R2WD32M**	22,00	23,00	76,6	44,0	0,8	DFR0403..
–	**DFR230R2WD32M**	23,00	24,00	78,6	46,0	0,8	DFR0403..
–	**DFR240R2WD32M**	24,00	25,00	80,6	48,0	0,8	DFR0403..

WARNING
During through-hole operations, a slug or disc is produced as the tool breaks through the workpiece. When the drill is stationary and the workpiece is rotating, this slug may be hurled from the chuck by centrifugal force. Provide adequate shielding to protect bystanders.

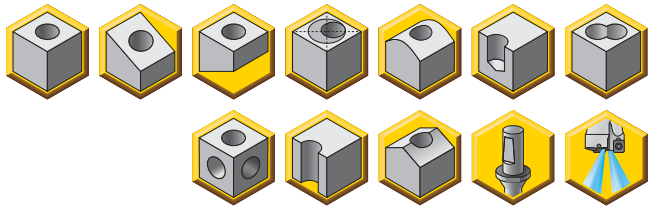


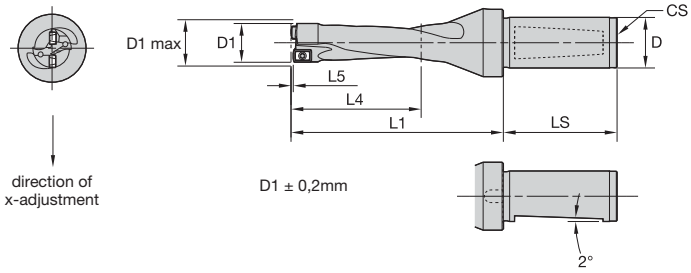


gage insert	insert screw	Torx wrench	Torx size
DFR0202..	**193.281**	**170.027**	6
DFR0302..	**192.416**	**170.023**	7
DFR0403..	**192.432**	**170.028**	8

D	LS	CS
20	45	R 1/8 BSP
32	58	R 1/4 BSP

- Drill shipped with insert screws and Torx wrench.
- See pages J84–J85 for inserts.







WN/WD Shank • 3 x D • Metric

D								
20	25	32	D1	D1 max	L1	L4 max	L5	gage insert
DFR125R3WD20M	–	–	12,50	13,50	59,9	37,5	0,5	DFR0202..
DFR127R3WD20M	–	–	12,70	13,70	60,5	38,1	0,5	DFR0202..
DFR130R3WD20M	–	–	13,00	14,00	61,4	39,0	0,5	DFR0202..
DFR135R3WD20M	–	–	13,50	14,50	62,9	40,5	0,5	DFR0202..
DFR140R3WD20M	–	–	14,00	15,00	64,4	42,0	0,5	DFR0202..
DFR145R3WD20M	–	–	14,50	15,50	67,9	43,5	0,5	DFR0202..
DFR150R3WD20M	–	–	15,00	16,00	69,4	45,0	0,5	DFR0202..
DFR155R3WD20M	–	–	15,50	16,50	70,9	46,5	0,5	DFR0202..
DFR160R3WD20M	–	–	16,00	17,00	72,4	48,0	0,5	DFR0202..
–	–	DFR165R3WD32M	16,50	17,50	78,9	49,5	0,6	DFR0302..
–	–	DFR170R3WD32M	17,00	18,00	80,4	51,0	0,6	DFR0302..
–	DFR175R3WD25M	DFR175R3WD32M	17,50	18,50	81,9	52,5	0,6	DFR0302..
–	DFR180R3WD25M	DFR180R3WD32M	18,00	19,00	83,4	54,0	0,6	DFR0302..
–	DFR185R3WD25M	DFR185R3WD32M	18,50	19,50	84,9	55,5	0,6	DFR0302..
–	DFR190R3WD25M	DFR190R3WD32M	19,00	20,00	86,4	57,0	0,6	DFR0302..
–	DFR195R3WD25M	DFR195R3WD32M	19,50	20,50	87,9	58,5	0,6	DFR0302..
–	DFR200R3WD25M	DFR200R3WD32M	20,00	21,00	92,4	60,0	0,6	DFR0302..
–	DFR205R3WD25M	DFR205R3WD32M	20,50	21,50	94,1	61,5	0,8	DFR0403..
–	DFR210R3WD25M	DFR210R3WD32M	21,00	22,00	95,6	63,0	0,8	DFR0403..
–	DFR220R3WD25M	DFR220R3WD32M	22,00	23,00	98,6	66,0	0,8	DFR0403..
–	DFR230R3WD25M	DFR230R3WD32M	23,00	24,00	101,6	69,0	0,8	DFR0403..
–	DFR240R3WD25M	DFR240R3WD32M	24,00	25,00	104,6	72,0	0,8	DFR0403..

WARNING
During through-hole operations, a slug or disc is produced as the tool breaks through the workpiece. When the drill is stationary and the workpiece is rotating, this slug may be hurled from the chuck by centrifugal force. Provide adequate shielding to protect bystanders.

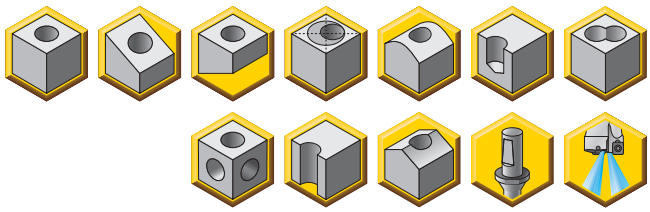


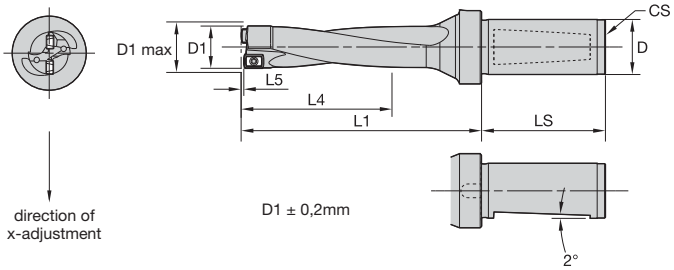


gage insert	insert screw	Torx wrench	Torx size
DFR0202..	**193.281**	**170.027**	6
DFR0302..	**192.416**	**170.023**	7
DFR0403..	**192.432**	**170.028**	8

D	LS	CS
20	45	R 1/8 BSP
25	45	R 1/4 BSP
32	58	R 1/4 BSP

- Drill shipped with insert screws and Torx wrench.
- See pages J84–J85 for inserts.







WN/WD Shank • 4 x D • Metric

D							
20	32	D1	D1 max	L1	L4 max	L5	gage insert
DFR125R4WD20M	–	12,50	13,50	72,4	50,0	0,5	DFR0202..
DFR127R4WD20M	–	12,70	13,70	73,2	50,8	0,5	DFR0202..
DFR130R4WD20M	–	13,00	14,00	74,4	52,0	0,5	DFR0202..
DFR135R4WD20M	–	13,50	14,50	76,4	54,0	0,5	DFR0202..
DFR140R4WD20M	–	14,00	15,00	78,4	56,0	0,5	DFR0202..
DFR145R4WD20M	–	14,50	15,50	82,4	58,0	0,5	DFR0202..
DFR150R4WD20M	–	15,00	16,00	84,4	60,0	0,5	DFR0202..
DFR155R4WD20M	–	15,50	16,50	86,4	62,0	0,5	DFR0202..
DFR160R4WD20M	–	16,00	17,00	88,4	64,0	0,5	DFR0202..
–	**DFR165R4WD32M**	16,50	17,50	95,4	66,0	0,6	DFR0302..
–	**DFR170R4WD32M**	17,00	18,00	97,4	68,0	0,6	DFR0302..
–	**DFR175R4WD32M**	17,50	18,50	99,4	70,0	0,6	DFR0302..
–	**DFR180R4WD32M**	18,00	19,00	101,4	72,0	0,6	DFR0302..
–	**DFR185R4WD32M**	18,50	19,50	103,4	74,0	0,6	DFR0302..
–	**DFR190R4WD32M**	19,00	20,00	105,4	76,0	0,6	DFR0302..
–	**DFR195R4WD32M**	19,50	20,50	107,4	78,0	0,6	DFR0302..
–	**DFR200R4WD32M**	20,00	21,00	109,4	80,0	0,6	DFR0302..
–	**DFR205R4WD32M**	20,50	21,50	111,6	82,0	0,8	DFR0403..
–	**DFR210R4WD32M**	21,00	22,00	113,6	84,0	0,8	DFR0403..
–	**DFR220R4WD32M**	22,00	23,00	117,6	88,0	0,8	DFR0403..
–	**DFR230R4WD32M**	23,00	24,00	121,6	92,0	0,8	DFR0403..
–	**DFR240R4WD32M**	24,00	25,00	125,6	96,0	0,8	DFR0403..

WARNING
During through-hole operations, a slug or disc is produced as the tool breaks through the workpiece. When the drill is stationary and the workpiece is rotating, this slug may be hurled from the chuck by centrifugal force. Provide adequate shielding to protect bystanders.

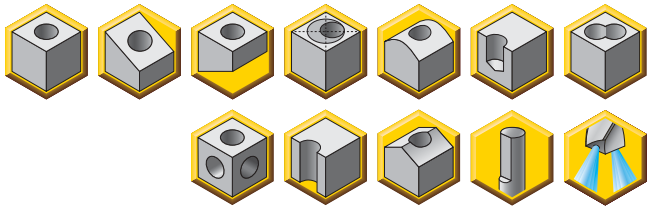


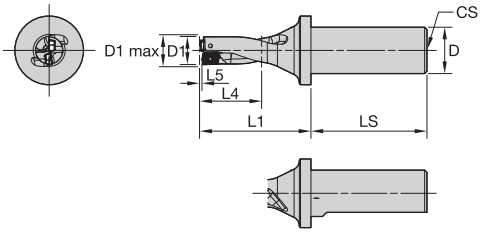


gage insert	insert screw	Torx wrench	Torx size
DFR0202..	**193.281**	**170.027**	6
DFR0302..	**192.416**	**170.023**	7
DFR0403..	**192.432**	**170.028**	8

D	LS	CS
20	45	R 1/8 BSP
32	58	R 1/4 BSP

- Drill shipped with insert screws and Torx wrench.
- See pages J84–J85 for inserts.







Weldon® Shank • DIN 1835-1 Form B • 2 x D • Metric

D 20	D1	D1 max	L1	L4 max	L5	gage insert
DFR125R2WB20M	12,50	13,50	47,0	25,0	0,5	DFR0202..
DFR127R2WB20M	12,70	13,70	47,4	25,0	0,5	DFR0202..
DFR130R2WB20M	13,00	14,00	48,0	26,0	0,5	DFR0202..
DFR135R2WB20M	13,50	14,50	49,0	27,0	0,5	DFR0202..
DFR140R2WB20M	14,00	15,00	50,0	28,0	0,5	DFR0202..
DFR145R2WB20M	14,50	15,50	53,0	29,0	0,5	DFR0202..
DFR150R2WB20M	15,00	16,00	54,0	30,0	0,5	DFR0202..
DFR155R2WB20M	15,50	16,50	55,0	31,0	0,5	DFR0202..
DFR160R2WB20M	16,00	17,00	56,0	32,0	0,5	DFR0202..
DFR165R2WB20M	16,50	17,50	62,0	33,0	0,6	DFR0302..
DFR170R2WB20M	17,00	18,00	63,0	34,0	0,6	DFR0302..

NOTE for D1 max: Diameter can be adjusted. It is highly recommended to not adjust the diameter more than +1mm.

Spare Parts



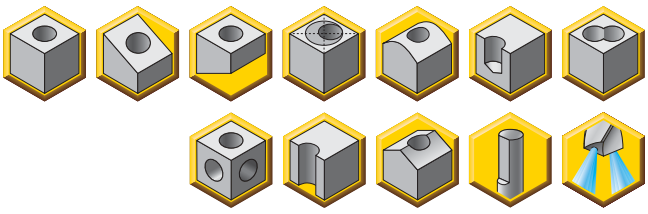


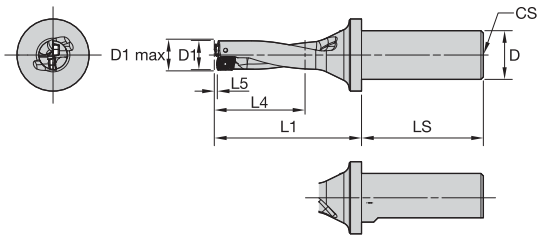
gage insert	insert screw	Torx wrench	Torx size
DFR0202..	**193.281**	**170.027**	6
DFR0302..	**192.416**	**170.023**	7

WARNING
During through-hole operations, a slug or disc is produced as the tool breaks through the workpiece. When the drill is stationary and the workpiece is rotating, this slug may be hurled from the chuck by centrifugal force. Provide adequate shielding to protect bystanders.

D	LS	CS
20	50	R 1/8 BSP

- Drill shipped with insert screws and Torx wrench.
- See pages J84–J85 for inserts.







Weldon® Shank • DIN 1835-1 Form B • 3 x D • Metric

D 20	D1	D1 max	L1	L4 max	L5	gage insert
DFR125R3WB20M	12,50	13,50	59,5	37,5	0,5	DFR0202..
DFR127R3WB20M	12,70	13,70	60,5	38,1	0,5	DFR0202..
DFR130R3WB20M	13,00	14,00	61,0	39,0	0,5	DFR0202..
DFR135R3WB20M	13,50	14,50	62,5	40,5	0,5	DFR0202..
DFR140R3WB20M	14,00	15,00	64,0	42,0	0,5	DFR0202..
DFR145R3WB20M	14,50	15,50	67,5	43,5	0,5	DFR0202..
DFR150R3WB20M	15,00	16,00	69,0	45,0	0,5	DFR0202..
DFR155R3WB20M	15,50	16,50	70,5	46,5	0,5	DFR0202..
DFR160R3WB20M	16,00	17,00	72,0	48,0	0,5	DFR0202..
DFR165R3WB20M	16,50	17,50	78,5	49,5	0,6	DFR0302..
DFR170R3WB20M	17,00	18,00	80,0	51,0	0,6	DFR0302..

NOTE for D1 max: Diameter can be adjusted. It is highly recommended to not adjust the diameter more than +1mm.

Spare Parts



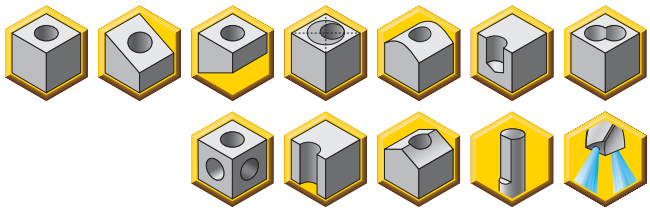


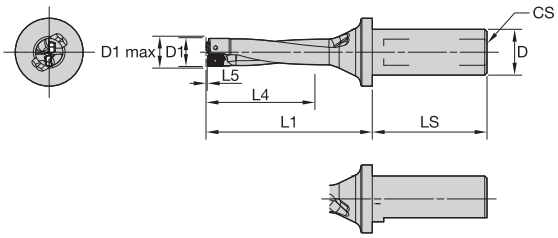
gage insert	insert screw	Torx wrench	Torx size
DFR0202..	**193.281**	**170.027**	6
DFR0302..	**192.416**	**170.023**	7

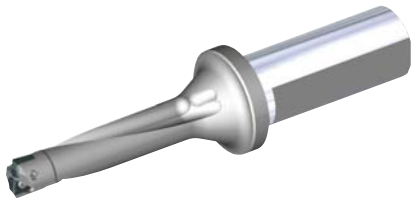
WARNING
During through-hole operations, a slug or disc is produced as the tool breaks through the workpiece. When the drill is stationary and the workpiece is rotating, this slug may be hurled from the chuck by centrifugal force. Provide adequate shielding to protect bystanders.

D	LS	CS
20	50	R 1/8 BSP

- Drill shipped with insert screws and Torx wrench.
- See pages J84–J85 for inserts.







Weldon® Shank • DIN 1835-1 Form B • 4 x D • Metric

D 20	D1	D1 max	L1	L4 max	L5	gage insert
DFR125R4WB20M	12,50	13,50	72,0	50,0	0,5	DFR0202..
DFR127R4WB20M	12,70	13,70	72,8	50,8	0,5	DFR0202..
DFR130R4WB20M	13,00	14,00	74,0	52,0	0,5	DFR0202..
DFR135R4WB20M	13,50	14,50	76,0	54,0	0,5	DFR0202..
DFR140R4WB20M	14,00	15,00	78,0	56,0	0,5	DFR0202..
DFR145R4WB20M	14,50	15,50	82,0	58,0	0,5	DFR0202..
DFR150R4WB20M	15,00	16,00	84,0	60,0	0,5	DFR0202..
DFR155R4WB20M	15,50	16,50	86,0	62,0	0,5	DFR0202..
DFR160R4WB20M	16,00	17,00	88,0	64,0	0,5	DFR0202..
DFR165R4WB20M	16,50	17,50	95,0	66,0	0,5	DFR0302..
DFR170R4WB20M	17,00	18,00	97,0	68,0	0,6	DFR0302..

NOTE for D1 max: Diameter can be adjusted. It is highly recommended to not adjust the diameter more than +1mm.

Spare Parts





gage insert	insert screw	Torx wrench	Torx size
DFR0202..	**193.281**	**170.027**	6
DFR0302..	**192.416**	**170.023**	7

WARNING
During through-hole operations, a slug or disc is produced as the tool breaks through the workpiece. When the drill is stationary and the workpiece is rotating, this slug may be hurled from the chuck by centrifugal force. Provide adequate shielding to protect bystanders.

D	LS	CS
20	50	R 1/8 BSP

Drill Fix™ DFR™ • Metric

Metric												
Material Group		Condition	Pocket Seat	Geometry	Grade	Cutting Speed — vc Range — m/min			Recommended Feed Rate (fz) by Diameter			
						min	Starting Value	max	Ø	DFR02... 12,50–16,00mm	DFR03... 16,50–20,00mm	DFR04... 20,50–24,00mm
P	1	S	O	MD	KCU25	310	**325**	360	mm/r	0,09–0,15	0,11–0,18	0,15–0,25
			I	MD	KC7140							
		U	O	MD	KCU40	200	**215**	230	mm/r	0,09–0,15	0,11–0,18	0,15–0,25
			I	MD	KC7140							
		I	O	MD	KC7140	130	**135**	150	mm/r	0,09–0,15	0,11–0,18	0,15–0,25
			I	MD	KC7140							
	2	S	O	GD	KCPK10	310	**325**	360	mm/r	0,09–0,15	0,11–0,18	0,15–0,25
			I	LD	KC7140							
		U	O	GD	KCU40	200	**215**	230	mm/r	0,09–0,15	0,11–0,18	0,15–0,25
			I	LD	KC7140							
		I	O	MD	KC7140	130	**135**	150	mm/r	0,09–0,15	0,11–0,18	0,15–0,25
			I	LD	KC7140							
	3	S	O	GD	KCPK10	260	**285**	320	mm/r	0,09–0,15	0,11–0,18	0,15–0,25
			I	LD	KC7140							
		U	O	GD	KCU40	180	**195**	220	mm/r	0,09–0,15	0,11–0,18	0,15–0,25
			I	LD	KC7140							
		I	O	GD	KC7140	110	**120**	140	mm/r	0,09–0,15	0,11–0,18	0,15–0,25
			I	LD	KC7140							
	4	S	O	GD	KCU25	220	**250**	300	mm/r	0,09–0,15	0,11–0,18	0,15–0,25
			I	LD	KC7140							
		U	O	GD	KCU40	150	**180**	220	mm/r	0,09–0,15	0,11–0,18	0,15–0,25
			I	LD	KC7140							
		I	O	GD	KC7140	90	**110**	140	mm/r	0,09–0,15	0,11–0,18	0,15–0,25
			I	LD	KC7140							
	5	S	O	GD	KCU25	180	**200**	220	mm/r	0,07–0,13	0,09–0,15	0,11–0,18
			I	LD	KC7140							
		U	O	GD	KCU40	120	**135**	150	mm/r	0,07–0,13	0,09–0,15	0,11–0,18
			I	LD	KC7140							
		I	O	GD	KC7140	70	**85**	100	mm/r	0,07–0,13	0,09–0,15	0,11–0,18
			I	LD	KC7140							
	6	S	O	GD	KCU25	180	**200**	220	mm/r	0,07–0,13	0,09–0,15	0,11–0,18
			I	LD	KC7140							
		U	O	GD	KCU40	120	**135**	150	mm/r	0,07–0,13	0,09–0,15	0,11–0,18
			I	LD	KC7140							
		I	O	GD	KC7140	70	**85**	100	mm/r	0,07–0,13	0,09–0,15	0,11–0,18
			I	LD	KC7140							
M	1	S	O	MD	KC7140	150	**190**	230	mm/r	0,07–0,13	0,08–0,16	0,10–0,18
			I	MD	KC7140							
		U	O	MD	KC7140	100	**130**	160	mm/r	0,07–0,13	0,08–0,16	0,10–0,18
			I	MD	KC7140							
		I	O	MD	KC7140	60	**80**	100	mm/r	0,07–0,13	0,08–0,16	0,10–0,18
			I	MD	KC7140							
	2	S	O	MD	KC7140	150	**180**	210	mm/r	0,07–0,13	0,08–0,16	0,10–0,18
			I	MD	KC7140							
		U	O	MD	KC7140	100	**130**	160	mm/r	0,07–0,13	0,08–0,16	0,10–0,18
			I	MD	KC7140							
		I	O	MD	KC7140	60	**80**	100	mm/r	0,07–0,13	0,08–0,16	0,10–0,18
			I	MD	KC7140							
	3	S	O	MD	KC7140	100	**130**	160	mm/r	0,07–0,13	0,08–0,16	0,10–0,18
			I	MD	KC7140							
		U	O	MD	KC7140	80	**110**	140	mm/r	0,07–0,13	0,08–0,16	0,10–0,18
			I	MD	KC7140							
		I	O	MD	KC7140	50	**70**	90	mm/r	0,07–0,13	0,08–0,16	0,10–0,18
			I	MD	KC7140							

Condition: S = Stable cutting conditions;
U = Unstable cutting conditions;
I = Interrupted cutting conditions

Pocket seat: I = Inboard insert;
O = Outboard insert

Drill Fix™ DFR™ • Metric

Metric											
Material Group		Condition	Pocket Seat	Geometry	Grade	Cutting Speed — vc Range — m/min			Recommended Feed Rate (fz) by Diameter			
						min	Starting Value	max	Ø	DFR02... 12,50–16,00mm	DFR03... 16,50–20,00mm	DFR04... 20,50–24,00mm
K	1	S	O	GD	KCPK10	200	**240**	300	mm/r	0,10–0,18	0,12–0,20	0,14–0,24
			I	LD	KCU40							
		U	O	GD	KCU25	120	**155**	200	mm/r	0,10–0,18	0,12–0,20	0,14–0,24
			I	LD	KC7140							
		I	O	GD	KCU40	80	**100**	125	mm/r	0,10–0,18	0,12–0,20	0,14–0,24
			I	LD	KC7140							
	2	S	O	GD	KCPK10	180	**220**	260	mm/r	0,10–0,18	0,12–0,20	0,14–0,24
			I	LD	KCU40							
		U	O	GD	KCU25	110	**140**	170	mm/r	0,10–0,18	0,12–0,20	0,14–0,24
			I	LD	KC7140							
		I	O	GD	KCU40	80	**100**	120	mm/r	0,10–0,18	0,12–0,20	0,14–0,24
			I	LD	KC7140							
	3	S	O	GD	KCPK10	180	**220**	260	mm/r	0,10–0,18	0,12–0,20	0,14–0,24
			I	LD	KCU40							
		U	O	GD	KCU25	110	**140**	170	mm/r	0,10–0,18	0,12–0,20	0,14–0,24
			I	LD	KC7140							
		I	O	GD	KCU40	80	**100**	120	mm/r	0,10–0,18	0,12–0,20	0,14–0,24
			I	LD	KC7140							
N	1	S	O	ST	KD1425	400	**600**	800	mm/r	0,07–0,09	0,10–0,14	0,12–0,16
			I	ST	KD1425							
		U	O	LD	KCU40	300	**400**	500	mm/r	0,07–0,09	0,10–0,14	0,12–0,16
			I	LD	KCU40							
		I	O	LD	KCU40	200	**300**	400	mm/r	0,07–0,09	0,10–0,14	0,12–0,16
			I	LD	KCU40							
	2	S	O	ST	KD1425	375	**550**	775	mm/r	0,07–0,09	0,10–0,14	0,12–0,16
			I	ST	KD1425							
		U	O	LD	KCU40	250	**350**	450	mm/r	0,07–0,09	0,10–0,14	0,12–0,16
			I	LD	KCU40							
		I	O	LD	KCU40	175	**250**	325	mm/r	0,07–0,09	0,10–0,14	0,12–0,16
			I	LD	KCU40							
	3	S	O	ST	KD1425	350	**500**	650	mm/r	0,07–0,09	0,10–0,14	0,12–0,16
			I	ST	KD1425							
		U	O	LD	KCU40	250	**350**	450	mm/r	0,07–0,09	0,10–0,14	0,12–0,16
			I	LD	KCU40							
		I	O	LD	KCU40	150	**250**	350	mm/r	0,07–0,09	0,10–0,14	0,12–0,16
			I	LD	KCU40							
	4	S	O	ST	KD1425	400	**600**	800	mm/r	0,07–0,09	0,10–0,14	0,12–0,16
			I	ST	KD1425							
		U	O	LD	KCU40	250	**350**	450	mm/r	0,07–0,09	0,10–0,14	0,12–0,16
			I	LD	KCU40							
		I	O	LD	KCU40	200	**300**	400	mm/r	0,07–0,09	0,10–0,14	0,12–0,16
			I	LD	KCU40							
	5	S	O	ST	KD1425	400	**600**	800	mm/r	0,07–0,09	0,10–0,14	0,12–0,16
			I	ST	KD1425							
		U	O	LD	KCU40	250	**350**	450	mm/r	0,07–0,09	0,10–0,14	0,12–0,16
			I	LD	KCU40							
		I	O	LD	KCU40	200	**300**	400	mm/r	0,07–0,09	0,10–0,14	0,12–0,16
			I	LD	KCU40							
	6	S	O	ST	KD1425	400	**600**	800	mm/r	0,07–0,09	0,10–0,14	0,12–0,16
			I	ST	KD1425							
		U	O	GD	KCU40	250	**350**	450	mm/r	0,07–0,09	0,10–0,14	0,12–0,16
			I	GD	KCU40							
		I	O	GD	KMF	200	**300**	400	mm/r	0,07–0,09	0,10–0,14	0,12–0,16
			I	GD	KMF							

Condition: S = Stable cutting conditions;
U = Unstable cutting conditions;
I = Interrupted cutting conditions

Pocket seat: I = Inboard insert;
O = Outboard insert

Drill Fix™ DFR™ • Metric

Metric											
Material Group		Condition	Pocket Seat	Geometry	Grade	Cutting Speed — vc Range — m/min			Recommended Feed Rate (fz) by Diameter		
						min	Starting Value	max	Ø	DFR02... 12,50–16,00mm	DFR03... 16,50–20,00mm	DFR04... 20,50–24,00mm
S	1	S	O	GD	KCU40	60	**70**	75	mm/r	0,04–0,06	0,05–0,08	0,06–0,10
			I	LD	KCU40							
		U	O	GD	KCU40	40	**50**	60	mm/r	0,04–0,06	0,05–0,08	0,06–0,10
			I	LD	KC7140							
		I	O	MD	KC7140	25	**30**	40	mm/r	0,04–0,06	0,05–0,08	0,06–0,10
			I	MD	KC7140							
	2	S	O	GD	KCU40	50	**60**	70	mm/r	0,04–0,06	0,05–0,08	0,06–0,10
			I	LD	KCU40							
		U	O	GD	KCU40	30	**40**	50	mm/r	0,04–0,06	0,05–0,08	0,06–0,10
			I	LD	KC7140							
		I	O	MD	KC7140	25	**30**	40	mm/r	0,04–0,06	0,05–0,08	0,06–0,10
			I	MD	KC7140							
	3	S	O	GD	KCU40	70	**80**	90	mm/r	0,05–0,08	0,06–0,10	0,06–0,10
			I	LD	KCU40							
		U	O	GD	KCU40	50	**60**	70	mm/r	0,05–0,08	0,06–0,10	0,06–0,10
			I	LD	KC7140							
		I	O	MD	KC7140	30	**40**	50	mm/r	0,05–0,08	0,06–0,10	0,06–0,10
			I	MD	KC7140							
	4	S	O	GD	KCU40	70	**80**	90	mm/r	0,05–0,08	0,06–0,10	0,06–0,10
			I	LD	KCU40							
		U	O	GD	KCU40	50	**60**	70	mm/r	0,05–0,08	0,06–0,10	0,06–0,10
			I	LD	KC7140							
		I	O	MD	KC7140	30	**40**	50	mm/r	0,05–0,08	0,06–0,10	0,06–0,10
			I	MD	KC7140							

Condition: S = Stable cutting conditions;
U = Unstable cutting conditions;
I = Interrupted cutting conditions

Pocket seat: I = Inboard insert;
O = Outboard insert

NOVO KNOWS SEARCH

Searching for a tool has been enhanced by Advise and Select functions from NOVO™ applications — saving you time and money.

ADVISE

Uses a rules-based approach to provide cutting tool recommendations:

- Define Machining Feature (face milling, slotting, blind hole, etc.)
- Apply Constraint Requirements (geometric, material, tolerance, etc.)
- Set Machining Sequence (single or multi-step operations, rough then finish, etc.)
- Receive Ranked Results

SELECT

A method of selecting cutting tools from a tree structure via a hierarchy or parametric search:

- If you know which product you are looking for, a quick search can be performed by just the catalogue number or product description.
- Smart filters significantly reduce the amount of potential tooling solutions.
- After the tool is selected, NOVO also provides cutting and adaptive item options that fit with your solution.

NOVO applications can ensure you have the right tools on your machines, in the right sequence. Resulting in flawless execution that accelerates every job, and maximises every shift. **kennametal.com/novo**

Drill Fix™ DFSP™

DFSP is the new name of the now-extended Drill Fix DFS™ indexable drilling platform. The standard diameter range is now expanded starting from 14–55mm (.551–2.125") in L/D ratios 2 x D, 3 x D, 4 x D, and 5 x D. Like the DFS platform, the DFSP platform combines the economically squared outboard insert with the superior centring capabilities of the trigon inboard insert. DFSP indexable drills offer increased metal removal rates combined with high surface quality and hole straightness.

Boost your productivity even further and achieve outstanding results in steel, stainless steel, and cast iron with the latest Beyond™ insert grades.

Features and Benefits

Higher Productivity and Profitability

- Achieve highest metal removal rates and excellent chip evacuation from advanced chip flutes and non-central and increased cooling channels.
- Squared outboard inserts offer four economic cutting edges.
- Complete product portfolio offers standard L/D ratios up to 5 x D.

Versatility

- Drill holes up to 5 x D in steel, cast iron, ductile iron, stainless steel, and non-ferrous materials.
- Use where speed and economy are prime considerations.
- Use DFSP drills in straight holes, inclined entries and exits, interrupted cuts, and rough or welded entry surfaces.
- Use X-offset on turning machines to adjust the drill diameter and eliminate the need for specials in many applications, and on machining centres to reach tolerance optimisation.
- Eccentric chuck available as standard.
- Quick and easy insert grade and/or geometry change to address material and application changes.

Boost your productivity even further with the latest Beyond™ insert grades.



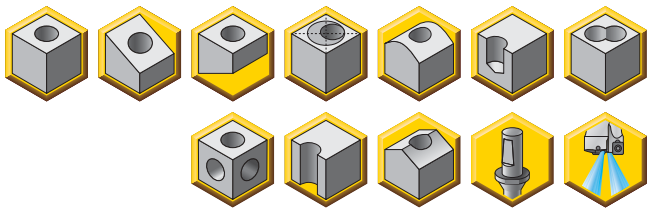
Reliability

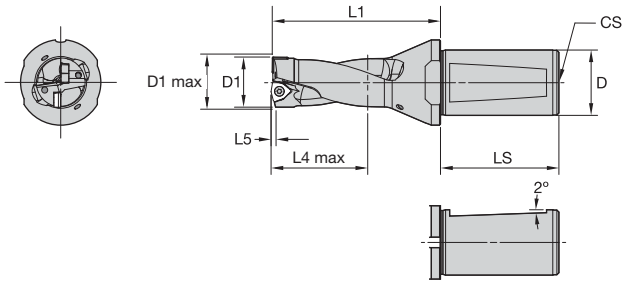
- High accuracy holes in any feed rates.
- Gain outstanding results using Beyond grades for DFT™ and SPGX/SPPX inserts.
- High wear resistance in interrupted cuts due to squared outboard insert.

Customisation

- Use DFSP cartridges to extend diameter range up to 85mm (3.35") in L/D ratios up to 5 x D.
- Intermediate diameters, multistep drills, and other non-standard shanks are available.
- Contact our engineered solutions team for recommendations.

- DFSP combines the economical squared outboard insert with the superior centring capabilities of the trigon inboard insert.
- Drill shipped with insert screws and Torx wrench.
- Order inserts for DFSP separately.
  See pages J89–J90 for inserts.







WD Shank • 2 x D • Metric

D										
20	32	40	50	D1	D1 max	L1	L4 max	L5	gage insert outside	gage insert inside
DFSP140R2WD20M	–	–	–	14,00	15,00	50,0	28,0	0,3	SPGX0502..	DFTX202..
DFSP145R2WD20M *	–	–	–	14,50	15,50	53,0	29,0	0,4	SPGX0502..	DFTX202..
DFSP150R2WD20M	–	–	–	15,00	16,00	54,0	30,0	0,4	SPGX0502..	DFTX202..
DFSP155R2WD20M	–	–	–	15,50	16,50	55,0	31,0	0,4	SPGX0502..	DFTX202..
DFSP160R2WD20M	–	–	–	16,00	17,00	56,0	32,0	0,4	SPGX0502..	DFTX202..
–	DFSP165R2WD32M	–	–	16,50	17,50	62,0	33,0	0,5	SPGX0502..	DFTX202..
–	DFSP170R2WD32M	–	–	17,00	18,00	63,0	34,0	0,5	SPGX0502..	DFTX202..
–	DFSP175R2WD32M	–	–	17,50	18,50	64,0	35,0	0,5	SPGX0603..	DFT0303..
–	DFSP180R2WD32M	–	–	18,00	19,00	65,0	36,0	0,5	SPGX0603..	DFT0303..
–	DFSP185R2WD32M	–	–	18,50	19,50	66,0	37,0	0,6	SPGX0603..	DFT0303..
–	DFSP190R2WD32M	–	–	19,00	20,00	67,0	38,0	0,6	SPGX0603..	DFT0303..
–	DFSP195R2WD32M	–	–	19,50	20,50	68,0	39,0	0,6	SPGX0603..	DFT0303..
–	DFSP200R2WD32M	–	–	20,00	21,00	72,0	40,0	0,6	SPGX0603..	DFT0303..
–	DFSP210R2WD32M	–	–	21,00	22,00	74,0	42,0	0,7	SPGX0603..	DFT0303..
–	DFSP220R2WD32M	–	–	22,00	23,00	76,0	44,0	0,5	SPGX0703..	DFT05T3..
–	DFSP230R2WD32M	–	–	23,00	24,00	78,0	46,0	0,6	SPGX0703..	DFT05T3..
–	DFSP240R2WD32M	–	–	24,00	25,00	80,0	48,0	0,6	SPGX0703..	DFT05T3..
–	DFSP250R2WD32M	–	–	25,00	26,00	83,0	50,0	0,7	SPGX0703..	DFT05T3..
–	DFSP260R2WD32M	–	–	26,00	27,00	86,0	52,0	0,7	SPPX09T3..	DFT05T3..
–	DFSP265R2WD32M	–	–	26,50	27,50	87,0	53,0	0,7	SPPX09T3..	DFT05T3..
–	DFSP270R2WD32M	–	–	27,00	28,00	89,0	54,0	0,8	SPPX09T3..	DFT05T3..
–	DFSP280R2WD32M	–	–	28,00	29,00	91,0	56,0	0,8	SPPX09T3..	DFT05T3..
–	DFSP290R2WD32M	–	–	29,00	30,00	94,0	58,0	0,9	SPPX09T3..	DFT05T3..
–	DFSP300R2WD32M	–	–	30,00	31,00	97,0	60,0	0,9	SPPX09T3..	DFT05T3..
–	DFSP310R2WD32M	–	–	31,00	32,00	100,0	62,0	0,9	SPPX09T3..	DFT05T3..
–	DFSP320R2WD32M	–	–	32,00	33,00	103,0	64,0	1,0	SPPX09T3..	DFT05T3..
–	DFSP330R2WD32M	–	–	33,00	34,00	105,0	66,0	0,9	SPPX1204..	DFT06T3..
–	DFSP340R2WD32M	–	–	34,00	35,00	108,0	68,0	0,9	SPPX1204..	DFT06T3..
–	DFSP350R2WD32M	–	–	35,00	36,00	111,0	70,0	1,0	SPPX1204..	DFT06T3..
–	DFSP360R2WD32M	–	–	36,00	37,00	114,0	72,0	1,0	SPPX1204..	DFT06T3..
–	DFSP370R2WD32M	–	–	37,00	38,00	117,0	74,0	1,1	SPPX1204..	DFT06T3..
–	DFSP375R2WD32M *	–	–	37,50	38,50	118,0	75,0	1,1	SPPX1204..	DFT06T3..
–	DFSP380R2WD32M	–	–	38,00	39,00	119,0	76,0	1,1	SPPX1204..	DFT06T3..
–	DFSP390R2WD32M	–	–	39,00	40,00	122,0	78,0	1,2	SPPX1204..	DFT06T3..
–	DFSP400R2WD32M	–	–	40,00	41,00	125,0	80,0	1,2	SPPX1204..	DFT06T3..
–	DFSP410R2WD32M	–	–	41,00	42,00	128,0	82,0	1,2	SPPX1204..	DFT0704..

(continued)

(WD Shank • 2 x D • Metric — continued)

D										
20	32	40	50	D1	D1 max	L1	L4 max	L5	gage insert outside	gage insert inside
–	**DFSP420R2WD32M**	–	–	42,00	43,00	131,0	84,0	1,3	SPPX1204..	DFT0704..
–	**DFSP430R2WD32M**	–	–	43,00	44,00	133,0	86,0	1,3	SPPX1204..	DFT0704..
–	**DFSP440R2WD32M**	–	–	44,00	45,00	135,0	88,0	1,4	SPPX15T5..	DFT0704..
–	–	**DFSP450R2WD40M**	–	45,00	46,00	137,0	90,0	1,4	SPPX15T5..	DFT0704..
–	–	**DFSP460R2WD40M**	–	46,00	47,00	140,0	92,0	1,5	SPPX15T5..	DFT0704..
–	–	**DFSP470R2WD40M**	–	47,00	48,00	142,0	94,0	1,5	SPPX15T5..	DFT0704..
–	–	**DFSP480R2WD40M**	–	48,00	49,00	144,0	96,0	1,5	SPPX15T5..	DFT0704..
–	–	**DFSP490R2WD40M**	–	49,00	50,00	146,0	98,0	1,4	SPPX15T5..	DFT0905..
–	–	**DFSP500R2WD40M**	–	50,00	51,00	148,0	100,0	1,5	SPPX15T5..	DFT0905..
–	–	**DFSP505R2WD40M**	–	50,50	51,50	148,0	100,0	1,5	SPPX15T5..	DFT0905..
–	–	**DFSP510R2WD40M**	–	51,00	52,00	150,0	102,0	1,6	SPPX15T5..	DFT0905..
–	–	**DFSP520R2WD40M**	–	52,00	53,00	152,0	104,0	1,6	SPPX15T5..	DFT0905..
–	–	**DFSP530R2WD40M**	–	53,00	54,00	154,0	106,0	1,7	SPPX15T5..	DFT0905..
–	–	**DFSP540R2WD40M**	–	54,00	55,00	156,0	108,0	1,7	SPPX15T5..	DFT0905..
–	–	–	**DFSP550R2WD50M**	55,00	56,00	158,0	110,0	1,8	SPPX15T5..	DFT0905..

NOTE for D1 max: Diameter can be adjusted. It is highly recommended to not adjust the diameter more than +1mm.
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Spare Parts







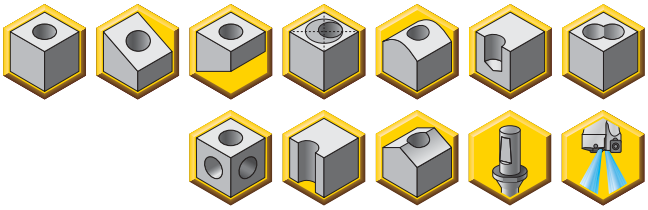
diameter range	gage insert inside	inboard insert screw	tightening torque Nm	gage insert outside	outboard insert screw	tightening torque Nm	Torx driver	Torx size
14.00–17.00	DFTX202..	**193.281**	0,6	SPGX0502..	**193.281**	0,6	**170.370**	T6
17.50–21.00	DFT0303..	**MS1152**	0,9	SPGX0603..	**MS1152**	0,9	**170.023**	T7
22.00–25.00	DFT05T3..	**193.491**	2,1	SPGX0703..	**192.432**	1,3	**170.028**	T8
26.00–32.00	DFT05T3..	**191.924**	2,1	SPPX09T3..	**191.924**	2,1	**170.024**	T9
33.00–40.00	DFT06T3..	**191.916**	4	SPPX1204..	**191.916**	4	**170.025**	T15
41.00–43.00	DFT0704..	**191.916**	6	SPPX1204..	**191.916**	3	**170.025**	T15
44.00–48.00	DFT0704..	**191.698**	6	SPPX15T5..	**192.433**	3	**170.025**	T15
49.00–55.00	DFT0905..	**192.433**	6	SPPX15T5..	**192.433**	6	**170.025**	T15

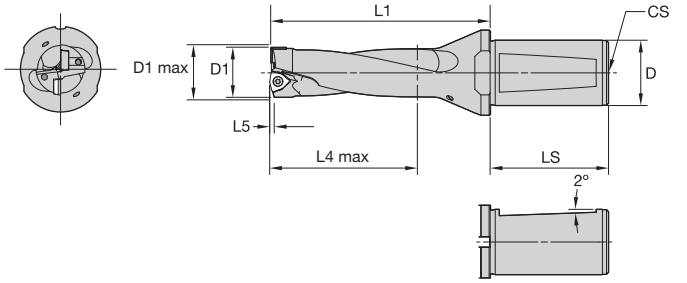
NOTE: To ensure proper clamping, two different screws for DFT™ inserts with different threads for diameter ranges 22–25,5mm and 41–48mm are necessary. Both screws have the same Torx size.

WARNING
During through-hole operations, a slug or disc is produced as the tool breaks through the workpiece. When the drill is stationary and the workpiece is rotating, this slug may be hurled from the chuck by centrifugal force. Provide adequate shielding to protect bystanders.

D	LS	CS
20	45	–
32	58	R 1/4 BSP
40	68	R 1/4 BSP
50	68	R 1/4 BSP

- DFSP combines the economical squared outboard insert with the superior centring capabilities of the trigon inboard insert.
- Drill shipped with insert screws and Torx wrench.
- Order inserts for DFSP separately.
  See pages J89–J90 for inserts.







WD Shank • 3 x D • Metric

D										
20	32	40	50	D1	D1 max	L1	L4 max	L5	gage insert outside	gage insert inside
DFSP140R3WD20M	–	–	–	14,00	15,00	64,0	42,0	0,3	SPGX0502..	DFTX202..
DFSP145R3WD20M	–	–	–	14,50	15,50	67,5	43,5	0,4	SPGX0502..	DFTX202..
DFSP150R3WD20M	–	–	–	15,00	16,00	69,0	45,0	0,4	SPGX0502..	DFTX202..
DFSP155R3WD20M	–	–	–	15,50	16,50	70,5	46,5	0,4	SPGX0502..	DFTX202..
DFSP160R3WD20M	–	–	–	16,00	17,00	72,0	48,0	0,4	SPGX0502..	DFTX202..
–	**DFSP165R3WD32M**	–	–	16,50	17,50	78,5	49,5	0,5	SPGX0502..	DFTX202..
–	**DFSP170R3WD32M**	–	–	17,00	18,00	80,0	51,0	0,5	SPGX0502..	DFTX202..
–	**DFSP175R3WD32M**	–	–	17,50	18,50	81,5	52,5	0,5	SPGX0603..	DFT0303..
–	**DFSP180R3WD32M**	–	–	18,00	19,00	83,0	54,0	0,5	SPGX0603..	DFT0303..
–	**DFSP185R3WD32M**	–	–	18,50	19,50	84,5	55,5	0,6	SPGX0603..	DFT0303..
–	**DFSP190R3WD32M**	–	–	19,00	20,00	86,0	57,0	0,6	SPGX0603..	DFT0303..
–	**DFSP195R3WD32M**	–	–	19,50	20,50	87,5	58,5	0,6	SPGX0603..	DFT0303..
–	**DFSP200R3WD32M**	–	–	20,00	21,00	92,0	60,0	0,6	SPGX0603..	DFT0303..
–	**DFSP210R3WD32M**	–	–	21,00	22,00	95,0	63,0	0,7	SPGX0603..	DFT0303..
–	**DFSP220R3WD32M**	–	–	22,00	23,00	98,0	66,0	0,5	SPGX0703..	DFT05T3..
–	**DFSP230R3WD32M**	–	–	23,00	24,00	101,0	69,0	0,6	SPGX0703..	DFT05T3..
–	**DFSP240R3WD32M**	–	–	24,00	25,00	104,0	72,0	0,6	SPGX0703..	DFT05T3..
–	**DFSP250R3WD32M**	–	–	25,00	26,00	108,0	75,0	0,7	SPGX0703..	DFT05T3..
–	**DFSP260R3WD32M**	–	–	26,00	27,00	112,0	78,0	0,7	SPPX09T3..	DFT05T3..
–	**DFSP265R3WD32M**	–	–	26,50	27,50	113,5	79,5	0,7	SPPX09T3..	DFT05T3..
–	**DFSP270R3WD32M**	–	–	27,00	28,00	116,0	81,0	0,8	SPPX09T3..	DFT05T3..
–	**DFSP280R3WD32M**	–	–	28,00	29,00	119,0	84,0	0,8	SPPX09T3..	DFT05T3..
–	**DFSP290R3WD32M**	–	–	29,00	30,00	123,0	87,0	0,9	SPPX09T3..	DFT05T3..
–	**DFSP300R3WD32M**	–	–	30,00	31,00	127,0	90,0	0,9	SPPX09T3..	DFT05T3..
–	**DFSP310R3WD32M**	–	–	31,00	32,00	131,0	93,0	0,9	SPPX09T3..	DFT05T3..
–	**DFSP320R3WD32M**	–	–	32,00	33,00	135,0	96,0	1,0	SPPX09T3..	DFT05T3..
–	**DFSP330R3WD32M**	–	–	33,00	34,00	138,0	99,0	0,9	SPPX1204..	DFT06T3..
–	**DFSP340R3WD32M**	–	–	34,00	35,00	142,0	102,0	0,9	SPPX1204..	DFT06T3..
–	**DFSP350R3WD32M**	–	–	35,00	36,00	146,0	105,0	1,0	SPPX1204..	DFT06T3..
–	**DFSP360R3WD32M**	–	–	36,00	37,00	150,0	108,0	1,0	SPPX1204..	DFT06T3..
–	**DFSP370R3WD32M**	–	–	37,00	38,00	154,0	111,0	1,1	SPPX1204..	DFT06T3..
–	**DFSP375R3WD32M**	–	–	37,50	38,50	155,5	112,5	1,1	SPPX1204..	DFT06T3..
–	**DFSP380R3WD32M**	–	–	38,00	39,00	157,0	114,0	1,1	SPPX1204..	DFT06T3..
–	**DFSP390R3WD32M**	–	–	39,00	40,00	161,0	117,0	1,2	SPPX1204..	DFT06T3..
–	**DFSP400R3WD32M**	–	–	40,00	41,00	165,0	120,0	1,2	SPPX1204..	DFT06T3..
–	**DFSP410R3WD32M**	–	–	41,00	42,00	169,0	123,0	1,2	SPPX1204..	DFT0704..

(continued)

(WD Shank • 3 x D • Metric — continued)

D										
20	32	40	50	D1	D1 max	L1	L4 max	L5	gage insert outside	gage insert inside
–	**DFSP420R3WD32M**	–	–	42,00	43,00	173,0	126,0	1,3	SPPX1204..	DFT0704..
–	**DFSP430R3WD32M**	–	–	43,00	44,00	176,0	129,0	1,3	SPPX1204..	DFT0704..
–	**DFSP440R3WD32M**	–	–	44,00	45,00	179,0	132,0	1,4	SPPX15T5..	DFT0704..
–	–	**DFSP450R3WD40M**	–	45,00	46,00	182,0	135,0	1,4	SPPX15T5..	DFT0704..
–	–	**DFSP460R3WD40M**	–	46,00	47,00	186,0	138,0	1,5	SPPX15T5..	DFT0704..
–	–	**DFSP470R3WD40M**	–	47,00	48,00	189,0	141,0	1,5	SPPX15T5..	DFT0704..
–	–	**DFSP480R3WD40M**	–	48,00	49,00	192,0	144,0	1,5	SPPX15T5..	DFT0704..
–	–	**DFSP490R3WD40M**	–	49,00	50,00	195,0	147,0	1,4	SPPX15T5..	DFT0905..
–	–	**DFSP500R3WD40M**	–	50,00	51,00	198,0	150,0	1,5	SPPX15T5..	DFT0905..
–	–	**DFSP505R3WD40M**	–	50,50	51,50	199,5	151,5	1,5	SPPX15T5..	DFT0905..
–	–	**DFSP510R3WD40M**	–	51,00	52,00	201,0	153,0	1,6	SPPX15T5..	DFT0905..
–	–	**DFSP520R3WD40M**	–	52,00	53,00	204,0	156,0	1,6	SPPX15T5..	DFT0905..
–	–	**DFSP530R3WD40M**	–	53,00	54,00	207,0	159,0	1,7	SPPX15T5..	DFT0905..
–	–	**DFSP540R3WD40M**	–	54,00	55,00	210,0	162,0	1,7	SPPX15T5..	DFT0905..
–	–	–	**DFSP550R3WD50M**	55,00	56,00	213,0	165,0	1,8	SPPX15T5..	DFT0905..

NOTE for D1 max: Diameter can be adjusted. It is highly recommended to not adjust the diameter more than +1mm.

Spare Parts







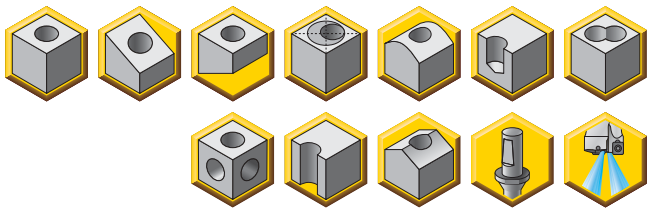
diameter range	gage insert inside	inboard insert screw	tightening torque Nm	gage insert outside	outboard insert screw	tightening torque Nm	Torx driver	Torx size
14.00–17.00	DFTX202..	**193.281**	0,6	SPGX0502..	**193.281**	0,6	**170.370**	T6
17.50–21.00	DFT0303..	**MS1152**	0,9	SPGX0603..	**MS1152**	0,9	**170.023**	T7
22.00–25.00	DFT05T3..	**193.491**	2,1	SPGX0703..	**192.432**	1,3	**170.028**	T8
26.00–32.00	DFT05T3..	**191.924**	2,1	SPPX09T3..	**191.924**	2,1	**170.024**	T9
33.00–40.00	DFT06T3..	**191.916**	4	SPPX1204..	**191.916**	4	**170.025**	T15
41.00–43.00	DFT0704..	**191.916**	6	SPPX1204..	**191.916**	3	**170.025**	T15
44.00–48.00	DFT0704..	**191.698**	6	SPPX15T5..	**192.433**	3	**170.025**	T15
49.00–55.00	DFT0905..	**192.433**	6	SPPX15T5..	**192.433**	6	**170.025**	T15

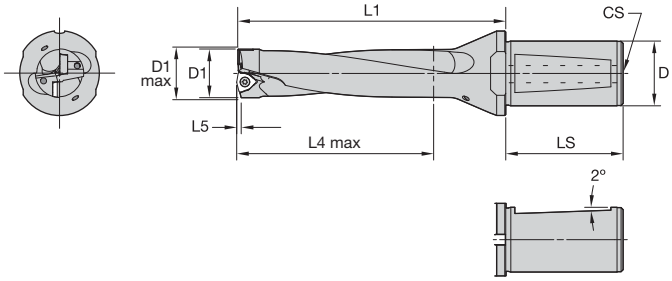
NOTE: To ensure proper clamping, two different screws for DFT™ inserts with different threads for diameter ranges 22–25mm and 41–48mm are necessary. Both screws have the same Torx size.

WARNING
During through-hole operations, a slug or disc is produced as the tool breaks through the workpiece. When the drill is stationary and the workpiece is rotating, this slug may be hurled from the chuck by centrifugal force. Provide adequate shielding to protect bystanders.

D	LS	CS
20	45	–
32	58	R 1/4 BSP
40	68	R 1/4 BSP
50	68	R 1/4 BSP

- DFSP combines the economical squared outboard insert with the superior centring capabilities of the trigon inboard insert.
- Drill shipped with insert screws and Torx wrench.
- Order inserts for DFSP separately.
  See pages J89–J90 for inserts.







WD Shank • 4 x D • Metric

D											
20	32	40	50	D1	D1 max	L1	L4 max	L5	gage insert outside	gage insert inside
DFSP140R4WD20M	–	–	–	14,00	15,00	78,0	56,0	0,3	SPGX0502..	DFTX202..
DFSP145R4WD20M	–	–	–	14,50	15,50	82,0	58,0	0,4	SPGX0502..	DFTX202..
DFSP150R4WD20M	–	–	–	15,00	16,00	84,0	60,0	0,4	SPGX0502..	DFTX202..
DFSP155R4WD20M *	–	–	–	15,50	16,50	86,0	62,0	0,4	SPGX0502..	DFTX202..
DFSP160R4WD20M	–	–	–	16,00	17,00	88,0	64,0	0,4	SPGX0502..	DFTX202..
DFSP165R4WD20M *	–	–	–	16,50	17,50	95,0	66,0	0,5	SPGX0502..	DFTX202..
DFSP170R4WD20M	–	–	–	17,00	18,00	97,0	68,0	0,5	SPGX0502..	DFTX202..
–	DFSP175R4WD32M	–	–	17,50	18,50	99,0	70,0	0,5	SPGX0603..	DFT0303..
–	DFSP180R4WD32M	–	–	18,00	19,00	101,0	72,0	0,5	SPGX0603..	DFT0303..
–	DFSP185R4WD32M	–	–	18,50	19,50	103,0	74,0	0,6	SPGX0603..	DFT0303..
–	DFSP190R4WD32M	–	–	19,00	20,00	105,0	76,0	0,6	SPGX0603..	DFT0303..
–	DFSP195R4WD32M	–	–	19,50	20,50	107,0	78,0	0,6	SPGX0603..	DFT0303..
–	DFSP200R4WD32M	–	–	20,00	21,00	112,0	80,0	0,6	SPGX0603..	DFT0303..
–	DFSP210R4WD32M	–	–	21,00	22,00	96,0	64,0	0,7	SPGX0603..	DFT0303..
–	DFSP220R4WD32M	–	–	22,00	23,00	120,0	88,0	0,5	SPGX0703..	DFT05T3..
–	DFSP230R4WD32M	–	–	23,00	24,00	124,0	92,0	0,6	SPGX0703..	DFT05T3..
–	DFSP240R4WD32M	–	–	24,00	25,00	128,0	96,0	0,6	SPGX0703..	DFT05T3..
–	DFSP250R4WD32M	–	–	25,00	26,00	133,0	100,0	0,7	SPGX0703..	DFT05T3..
–	DFSP260R4WD32M	–	–	26,00	27,00	138,0	104,0	0,7	SPPX09T3..	DFT05T3..
–	DFSP265R4WD32M	–	–	26,50	27,50	140,0	106,0	0,7	SPPX09T3..	DFT05T3..
–	DFSP270R4WD32M	–	–	27,00	28,00	143,0	108,0	0,8	SPPX09T3..	DFT05T3..
–	DFSP280R4WD32M	–	–	28,00	29,00	147,0	112,0	0,8	SPPX09T3..	DFT05T3..
–	DFSP290R4WD32M	–	–	29,00	30,00	152,0	116,0	0,9	SPPX09T3..	DFT05T3..
–	DFSP300R4WD32M	–	–	30,00	31,00	157,0	120,0	0,9	SPPX09T3..	DFT05T3..
–	DFSP310R4WD32M	–	–	31,00	32,00	162,0	124,0	0,9	SPPX09T3..	DFT05T3..
–	DFSP320R4WD32M	–	–	32,00	33,00	167,0	128,0	1,0	SPPX09T3..	DFT05T3..
–	DFSP330R4WD32M	–	–	33,00	34,00	171,0	132,0	0,9	SPPX1204..	DFT06T3..
–	DFSP340R4WD32M	–	–	34,00	35,00	176,0	136,0	0,9	SPPX1204..	DFT06T3..
–	DFSP350R4WD32M	–	–	35,00	36,00	181,0	140,0	1,0	SPPX1204..	DFT06T3..
–	DFSP360R4WD32M	–	–	36,00	37,00	186,0	144,0	1,0	SPPX1204..	DFT06T3..
–	DFSP370R4WD32M	–	–	37,00	38,00	191,0	148,0	1,1	SPPX1204..	DFT06T3..
–	DFSP375R4WD32M	–	–	37,50	38,50	193,0	150,0	1,1	SPPX1204..	DFT06T3..
–	DFSP380R4WD32M	–	–	38,00	39,00	195,0	152,0	1,1	SPPX1204..	DFT06T3..
–	DFSP390R4WD32M	–	–	39,00	40,00	200,0	156,0	1,2	SPPX1204..	DFT06T3..
–	DFSP400R4WD32M	–	–	40,00	41,00	205,0	160,0	1,2	SPPX1204..	DFT06T3..
–	DFSP410R4WD32M	–	–	41,00	42,00	210,0	164,0	1,2	SPPX1204..	DFT0704..

(continued)

(WD Shank • 4 x D • Metric — continued)

D										
20	32	40	50	D1	D1 max	L1	L4 max	L5	gage insert outside	gage insert inside
–	**DFSP420R4WD32M**	–	–	42,00	43,00	215,0	168,0	1,3	SPPX1204..	DFT0704..
–	**DFSP430R4WD32M**	–	–	43,00	44,00	219,0	172,0	1,3	SPPX1204..	DFT0704..
–	**DFSP440R4WD32M**	–	–	44,00	45,00	223,0	176,0	1,4	SPPX15T5..	DFT0704..
–	–	**DFSP450R4WD40M**	–	45,00	46,00	227,0	180,0	1,4	SPPX15T5..	DFT0704..
–	–	**DFSP460R4WD40M**	–	46,00	47,00	232,0	184,0	1,5	SPPX15T5..	DFT0704..
–	–	**DFSP470R4WD40M**	–	47,00	48,00	236,0	188,0	1,5	SPPX15T5..	DFT0704..
–	–	**DFSP480R4WD40M**	–	48,00	49,00	240,0	192,0	1,5	SPPX15T5..	DFT0704..
–	–	**DFSP490R4WD40M**	–	49,00	50,00	244,0	196,0	1,4	SPPX15T5..	DFT0905..
–	–	**DFSP500R4WD40M**	–	50,00	51,00	248,0	200,0	1,5	SPPX15T5..	DFT0905..
–	–	**DFSP510R4WD40M**	–	51,00	52,00	252,0	204,0	1,6	SPPX15T5..	DFT0905..
–	–	**DFSP520R4WD40M**	–	52,00	53,00	256,0	208,0	1,6	SPPX15T5..	DFT0905..
–	–	**DFSP530R4WD40M**	–	53,00	54,00	260,0	212,0	1,7	SPPX15T5..	DFT0905..
–	–	**DFSP540R4WD40M**	–	54,00	55,00	264,0	216,0	1,7	SPPX15T5..	DFT0905..
–	–	–	**DFSP550R4WD50M**	55,00	56,00	268,0	220,0	1,8	SPPX15T5..	DFT0905..

NOTE for D1 max: Diameter can be adjusted. It is highly recommended to not adjust the diameter more than +1mm.
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Spare Parts







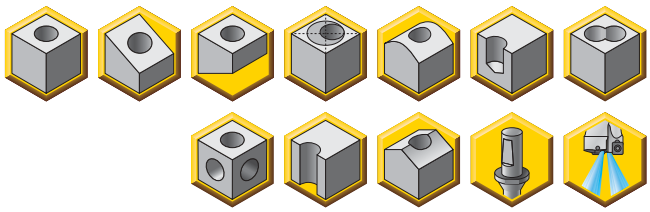
diameter range	gage insert inside	inboard insert screw	tightening torque Nm	gage insert outside	outboard insert screw	tightening torque Nm	Torx driver	Torx size
–	DFTX202..	–	–	SPGX0502..	–	–	–	T6
17.50–21.00	DFT0303..	**MS1152**	0,9	SPGX0603..	**MS1152**	0,9	**170.023**	T7
22.00–25.00	DFT05T3..	**193.491**	2,1	SPGX0703..	**192.432**	1,3	**170.028**	T8
26.00–32.00	DFT05T3..	**191.924**	2,1	SPPX09T3..	**191.924**	2,1	**170.024**	T9
33.00–40.00	DFT06T3..	**191.916**	4	SPPX1204..	**191.916**	4	**170.025**	T15
41.00–43.00	DFT0704..	**192.433**	6	SPPX1204..	**191.698**	3	**170.025**	T15
44.00–48.00	DFT0704..	**191.698**	6	SPPX15T5..	**191.698**	3	**170.025**	T15
49.00–55.00	DFT0905..	**192.433**	6	SPPX15T5..	**192.433**	6	**170.025**	T15

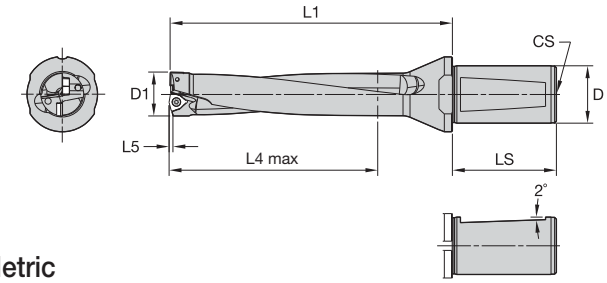
NOTE: To ensure proper clamping, two different screws for DFT™ inserts with different threads for diameter ranges 22–25mm and 41–48mm are necessary. Both screws have the same Torx size.

WARNING
During through-hole operations, a slug or disc is produced as the tool breaks through the workpiece. When the drill is stationary and the workpiece is rotating, this slug may be hurled from the chuck by centrifugal force. Provide adequate shielding to protect bystanders.

D	LS	CS
32	58	R 1/4 BSP
40	68	R 1/4 BSP
50	68	R 1/4 BSP

- DFSP combines the economical squared outboard insert with the superior centring capabilities of the trigon inboard insert.
- Drill shipped with insert screws and Torx wrench.
- Order inserts for DFSP separately.
  See pages J89–J90 for inserts.







WD Shank • 5 x D • Metric

D								
32	40	50	D1	L1	L4 max	L5	gage insert outside	gage insert inside
DFSP200R5WD32M	–	–	20,00	132,0	100,0	0,6	SPGX0603..	DFT0303..
DFSP210R5WD32M	–	–	21,00	137,0	105,0	0,7	SPGX0603..	DFT0303..
DFSP220R5WD32M	–	–	22,00	142,0	110,0	0,5	SPGX0703..	DFT05T3..
DFSP230R5WD32M	–	–	23,00	147,0	115,0	0,6	SPGX0703..	DFT05T3..
DFSP240R5WD32M	–	–	24,00	152,0	120,0	0,6	SPGX0703..	DFT05T3..
DFSP250R5WD32M	–	–	25,00	158,0	125,0	0,7	SPGX0703..	DFT05T3..
DFSP260R5WD32M	–	–	26,00	164,0	130,0	0,7	SPPX09T3..	DFT05T3..
DFSP265R5WD32M	–	–	26,50	166,5	132,5	0,7	SPPX09T3..	DFT05T3..
DFSP270R5WD32M	–	–	27,00	170,0	135,0	0,8	SPPX09T3..	DFT05T3..
DFSP280R5WD32M	–	–	28,00	175,0	140,0	0,8	SPPX09T3..	DFT05T3..
DFSP290R5WD32M	–	–	29,00	181,0	145,0	0,9	SPPX09T3..	DFT05T3..
DFSP300R5WD32M	–	–	30,00	187,0	150,0	0,9	SPPX09T3..	DFT05T3..
DFSP310R5WD32M	–	–	31,00	193,0	155,0	0,9	SPPX09T3..	DFT05T3..
DFSP320R5WD32M	–	–	32,00	199,0	160,0	1,0	SPPX09T3..	DFT05T3..
DFSP330R5WD32M	–	–	33,00	204,0	165,0	0,9	SPPX1204..	DFT06T3..
DFSP340R5WD32M	–	–	34,00	210,0	170,0	0,9	SPPX1204..	DFT06T3..
DFSP350R5WD32M	–	–	35,00	216,0	175,0	1,0	SPPX1204..	DFT06T3..
DFSP360R5WD32M	–	–	36,00	222,0	180,0	1,0	SPPX1204..	DFT06T3..
DFSP370R5WD32M	–	–	37,00	228,0	185,0	1,1	SPPX1204..	DFT06T3..
DFSP375R5WD32M	–	–	37,50	230,5	187,5	1,1	SPPX1204..	DFT06T3..
DFSP380R5WD32M	–	–	38,00	233,0	190,0	1,1	SPPX1204..	DFT06T3..
DFSP390R5WD32M	–	–	39,00	239,0	195,0	1,2	SPPX1204..	DFT06T3..
DFSP400R5WD32M	–	–	40,00	245,0	200,0	1,2	SPPX1204..	DFT06T3..
DFSP410R5WD32M	–	–	41,00	251,0	205,0	1,2	SPPX1204..	DFT0704..
DFSP420R5WD32M	–	–	42,00	257,0	210,0	1,3	SPPX1204..	DFT0704..
DFSP430R5WD32M	–	–	43,00	262,0	215,0	1,3	SPPX1204..	DFT0704..
DFSP440R5WD32M	–	–	44,00	267,0	220,0	1,4	SPPX15T5..	DFT0704..
–	DFSP450R5WD40M	–	45,00	272,0	225,0	1,4	SPPX15T5..	DFT0704..
–	DFSP460R5WD40M	–	46,00	278,0	230,0	1,5	SPPX15T5..	DFT0704..
–	DFSP470R5WD40M	–	47,00	283,0	235,0	1,5	SPPX15T5..	DFT0704..
–	DFSP480R5WD40M	–	48,00	288,0	240,0	1,5	SPPX15T5..	DFT0704..
–	DFSP490R5WD40M	–	49,00	293,0	245,0	1,4	SPPX15T5..	DFT0905..
–	DFSP500R5WD40M	–	50,00	298,0	250,0	1,5	SPPX15T5..	DFT0905..
–	DFSP510R5WD40M *	–	51,00	303,0	255,0	1,6	SPPX15T5..	DFT0905..
–	DFSP520R5WD40M	–	52,00	308,0	260,0	1,6	SPPX15T5..	DFT0905..
–	DFSP530R5WD40M	–	53,00	313,0	265,0	1,7	SPPX15T5..	DFT0905..
–	DFSP540R5WD40M	–	54,00	318,0	270,0	1,7	SPPX15T5..	DFT0905..
–	–	DFSP550R5WD50M	55,00	323,0	275,0	1,8	SPPX15T5..	DFT0905..

NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

(continued)

(WD Shank • 5 x D • Metric — continued)

Spare Parts







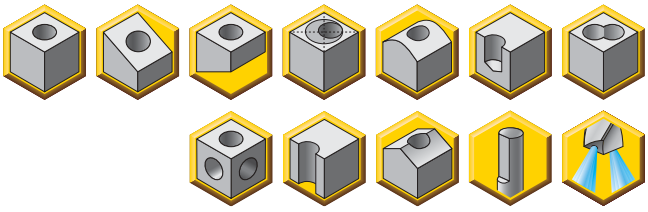
diameter range	gage insert inside	inboard insert screw	tightening torque Nm	gage insert outside	outboard insert screw	tightening torque Nm	Torx driver	Torx size
17.50–21.00	DFT0303..	**MS1152**	0,9	SPGX0603..	**MS1152**	0,9	**170.023**	T7
22.00–25.00	DFT05T3..	**193.491**	2,1	SPGX0703..	**192.432**	1,3	**170.028**	T8
26.00–32.00	DFT05T3..	**191.924**	2,1	SPPX09T3..	**191.924**	2,1	**170.024**	T9
33.00–40.00	DFT06T3..	**191.916**	4	SPPX1204..	**191.916**	4	**170.025**	T15
41.00–43.00	DFT0704..	**192.433**	6	SPPX1204..	**191.698**	3	**170.025**	T15
44.00–48.00	DFT0704..	**191.698**	6	SPPX15T5..	**192.433**	3	**170.025**	T15
49.00–55.00	DFT0905..	**192.433**	6	SPPX15T5..	**192.433**	6	**170.025**	T15

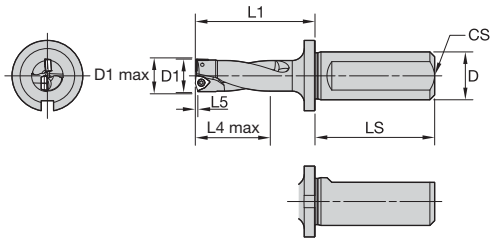
NOTE: To ensure proper clamping, two different screws for DFT™ inserts with different threads for diameter ranges 22–25mm and 41–48mm are necessary. Both screws have the same Torx size.

WARNING
During through-hole operations, a slug or disc is produced as the tool breaks through the workpiece. When the drill is stationary and the workpiece is rotating, this slug may be hurled from the chuck by centrifugal force. Provide adequate shielding to protect bystanders.

D	LS	CS
32	58	R 1/4 BSP
40	68	R 1/4 BSP
50	68	R 1/4 BSP

- DFSP combines the economical squared outboard insert with the superior centring capabilities of the trigon inboard insert.
- Drill shipped with insert screws, side pipe plug, and Torx wrench.
- Order inserts for DFSP separately.
See pages J89–J90 for inserts.







Weldon® Shank • DIN 1835-1 Form B • 2 x D • Metric

D											
20	25	32	40	D1	D1 max	L1	L4 max	L5	LS	gage insert outside	gage insert inside
DFSP140R2WB20M	–	–	–	14,00	15,00	50,0	28,0	0,3	50	SPGX0502..	DFTX202..
DFSP145R2WB20M	–	–	–	14,50	15,50	53,0	29,0	0,4	50	SPGX0502..	DFTX202..
DFSP150R2WB20M	–	–	–	15,00	16,00	54,0	30,0	0,4	50	SPGX0502..	DFTX202..
DFSP155R2WB20M	–	–	–	15,50	16,50	55,0	31,0	0,4	50	SPGX0502..	DFTX202..
DFSP160R2WB20M	–	–	–	16,00	17,00	56,0	32,0	0,4	50	SPGX0502..	DFTX202..
DFSP165R2WB20M	–	–	–	16,50	17,50	62,0	33,0	0,5	50	SPGX0502..	DFTX202..
DFSP170R2WB20M	–	–	–	17,00	18,00	63,0	34,0	0,5	50	SPGX0502..	DFTX202..
–	DFSP175R2WB25M	–	–	17,50	18,50	64,0	35,0	0,5	56	SPGX0603..	DFT0303..
–	DFSP180R2WB25M	–	–	18,00	19,00	65,0	36,0	0,5	56	SPGX0603..	DFT0303..
–	DFSP185R2WB25M	–	–	18,50	19,50	66,0	37,0	0,6	56	SPGX0603..	DFT0303..
–	DFSP190R2WB25M	–	–	19,00	20,00	67,0	38,0	0,6	56	SPGX0603..	DFT0303..
–	DFSP195R2WB25M	–	–	19,50	20,50	68,0	39,0	0,6	56	SPGX0603..	DFT0303..
–	DFSP200R2WB25M	–	–	20,00	21,00	72,0	40,0	0,6	56	SPGX0603..	DFT0303..
–	DFSP205R2WB25M	–	–	20,50	21,50	73,0	41,0	0,7	56	SPGX0603..	DFT0303..
–	DFSP209R2WB25M	–	–	20,90	21,90	73,8	41,8	0,7	56	SPGX0603..	DFT0303..
–	DFSP210R2WB25M	–	–	21,00	22,00	74,0	42,0	0,7	56	SPGX0603..	DFT0303..
–	DFSP215R2WB25M	–	–	21,50	22,50	75,0	43,0	0,7	56	SPGX0603..	DFT0303..
–	DFSP220R2WB25M	–	–	22,00	23,00	76,0	44,0	0,5	56	SPGX0703..	DFT05T3..
–	DFSP225R2WB25M	–	–	22,50	23,50	77,0	45,0	0,5	56	SPGX0703..	DFT05T3..
–	DFSP230R2WB25M	–	–	23,00	24,00	78,0	46,0	0,6	56	SPGX0703..	DFT05T3..
–	DFSP235R2WB25M	–	–	23,50	24,50	79,0	47,0	0,6	56	SPGX0703..	DFT05T3..
–	DFSP239R2WB25M	–	–	23,90	24,90	79,8	47,8	0,6	56	SPGX0703..	DFT05T3..
–	DFSP240R2WB25M	–	–	24,00	25,00	80,0	48,0	0,6	56	SPGX0703..	DFT05T3..
–	DFSP245R2WB25M	–	–	24,50	25,50	81,0	49,0	0,7	56	SPGX0703..	DFT05T3..
–	DFSP250R2WB25M	–	–	25,00	26,00	83,0	50,0	0,7	56	SPGX0703..	DFT05T3..
–	DFSP255R2WB25M	–	–	25,50	26,50	84,0	51,0	0,7	56	SPGX0703..	DFT05T3..
–	–	DFSP260R2WB32M	–	26,00	27,00	86,0	52,0	0,7	60	SPPX09T3..	DFT05T3..
–	–	DFSP264R2WB32M	–	26,40	27,40	86,8	52,8	0,7	60	SPPX09T3..	DFT05T3..
–	–	DFSP265R2WB32M	–	26,50	27,50	87,0	53,0	0,7	60	SPPX09T3..	DFT05T3..
–	–	DFSP270R2WB32M	–	27,00	28,00	89,0	54,0	0,8	60	SPPX09T3..	DFT05T3..
–	–	DFSP280R2WB32M	–	28,00	29,00	91,0	56,0	0,8	60	SPPX09T3..	DFT05T3..
–	–	DFSP290R2WB32M	–	29,00	30,00	94,0	58,0	0,9	60	SPPX09T3..	DFT05T3..
–	–	DFSP294R2WB32M	–	29,40	30,40	94,8	58,8	0,9	60	SPPX09T3..	DFT05T3..
–	–	DFSP300R2WB32M	–	30,00	31,00	97,0	60,0	0,9	60	SPPX09T3..	DFT05T3..
–	–	–	DFSP310R2WB40M	31,00	32,00	100,0	62,0	0,9	70	SPPX09T3..	DFT05T3..
–	–	–	DFSP320R2WB40M	32,00	33,00	103,0	64,0	1,0	70	SPPX09T3..	DFT05T3..

(continued)

(Weldon® Shank • DIN 1835-1 Form B • 2 x D • Metric — continued)

D											
20	25	32	40	D1	D1 max	L1	L4 max	L5	LS	gage insert outside	gage insert inside
–	–	–	**DFSP330R2WB40M**	33,00	34,00	105,0	66,0	0,9	70	SPPX1204..	DFT06T3..
–	–	–	**DFSP340R2WB40M**	34,00	35,00	108,0	68,0	0,9	70	SPPX1204..	DFT06T3..
–	–	–	**DFSP350R2WB40M**	35,00	36,00	111,0	70,0	1,0	70	SPPX1204..	DFT06T3..
–	–	–	**DFSP360R2WB40M**	36,00	37,00	114,0	72,0	1,0	70	SPPX1204..	DFT06T3..
–	–	–	**DFSP370R2WB40M**	37,00	38,00	117,0	74,0	1,1	70	SPPX1204..	DFT06T3..
–	–	–	**DFSP380R2WB40M**	38,00	39,00	119,0	76,0	1,1	70	SPPX1204..	DFT06T3..
–	–	–	**DFSP390R2WB40M**	39,00	40,00	122,0	78,0	1,2	70	SPPX1204..	DFT06T3..
–	–	–	**DFSP400R2WB40M**	40,00	41,00	125,0	80,0	1,2	70	SPPX1204..	DFT06T3..

NOTE for D1 max: Diameter can be adjusted. It is highly recommended to not adjust the diameter more than +1mm.

Spare Parts







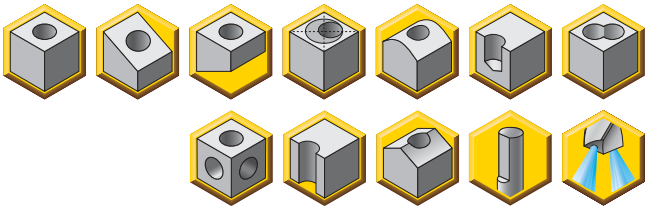
diameter range	gage insert inside	inboard insert screw	tightening torque Nm	gage insert outside	outboard insert screw	tightening torque Nm	Torx driver	Torx size
14.00–17.00	DFTX202..	**1175225**	0,66	SPGX0502..	**1175225**	0,66	**5694202**	T6
17.50–21.50	DFT0303..	**1021337**	0,90	SPGX0603..	**1021337**	0,90	**1138413**	T7
22.00–25.50	DFT05T3..	**3124549**	2,10	SPGX0703..	**1134385**	1,30	**1138465**	T8
26.00–32.00	DFT05T3..	**1105612**	2,10	SPPX09T3..	**1105612**	2,10	**1138430**	T9
33.00–40.00	DFT06T3..	**1132523**	4,00	SPPX1204..	**1132523**	4,00	**1138438**	T15

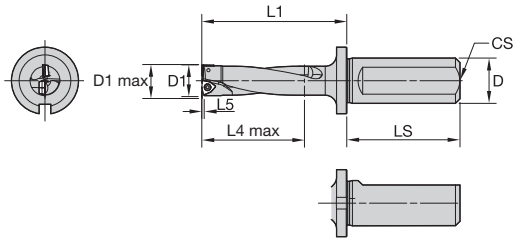
NOTE: To ensure proper clamping, two different screws for DFT™ inserts with different threads for diameter ranges 22–25mm and 41–48mm are necessary. Both screws have the same Torx size.

WARNING
During through-hole operations, a slug or disc is produced as the tool breaks through the workpiece. When the drill is stationary and the workpiece is rotating, this slug may be hurled from the chuck by centrifugal force. Provide adequate shielding to protect bystanders.

D	LS	CS
20	50	R 1/4 BSP
25	56	R 1/4 BSP
32	60	R 1/4 BSP
40	70	R 1/4 BSP

- DFSP combines the economical squared outboard insert with the superior centring capabilities of the trigon inboard insert.
- Drill shipped with insert screws, side pipe plug, and Torx wrench.
- Order inserts for DFSP separately.
See pages J89–J90 for inserts.







Weldon® Shank • DIN 1835-1 Form B • 3 x D • Metric

D											
20	25	32	40	D1	D1 max	L1	L4 max	L5	LS	gage insert outside	gage insert inside
DFSP140R3WB20M	–	–	–	14,00	15,00	64,0	42,0	0,3	50	SPGX0502..	DFTX202..
DFSP145R3WB20M	–	–	–	14,50	15,50	67,5	43,5	0,4	50	SPGX0502..	DFTX202..
DFSP150R3WB20M	–	–	–	15,00	16,00	69,0	45,0	0,4	50	SPGX0502..	DFTX202..
DFSP155R3WB20M	–	–	–	15,50	16,50	70,5	46,5	0,4	50	SPGX0502..	DFTX202..
DFSP160R3WB20M	–	–	–	16,00	17,00	72,0	48,0	0,4	50	SPGX0502..	DFTX202..
DFSP165R3WB20M	–	–	–	16,50	17,50	78,5	49,5	0,5	50	SPGX0502..	DFTX202..
DFSP170R3WB20M	–	–	–	17,00	18,00	80,0	51,0	0,5	50	SPGX0502..	DFTX202..
–	DFSP175R3WB25M	–	–	17,50	18,50	81,5	52,5	0,5	56	SPGX0603..	DFT0303..
–	DFSP180R3WB25M	–	–	18,00	19,00	83,0	54,0	0,5	56	SPGX0603..	DFT0303..
–	DFSP185R3WB25M	–	–	18,50	19,50	84,5	55,5	0,6	56	SPGX0603..	DFT0303..
–	DFSP190R3WB25M	–	–	19,00	20,00	86,0	57,0	0,6	56	SPGX0603..	DFT0303..
–	DFSP195R3WB25M	–	–	19,50	20,50	87,5	58,5	0,6	56	SPGX0603..	DFT0303..
–	DFSP200R3WB25M	–	–	20,00	21,00	92,0	60,0	0,6	56	SPGX0603..	DFT0303..
–	DFSP205R3WB25M	–	–	20,50	21,50	93,5	61,5	0,7	56	SPGX0603..	DFT0303..
–	DFSP209R3WB25M	–	–	20,90	21,90	94,7	62,7	0,7	56	SPGX0603..	DFT0303..
–	DFSP210R3WB25M	–	–	21,00	22,00	95,0	63,0	0,7	56	SPGX0603..	DFT0303..
–	DFSP215R3WB25M	–	–	21,50	22,50	96,5	64,5	0,7	56	SPGX0603..	DFT0303..
–	DFSP220R3WB25M	–	–	22,00	23,00	98,0	66,0	0,5	56	SPGX0703..	DFT05T3..
–	DFSP225R3WB25M	–	–	22,50	23,50	99,5	67,5	0,5	56	SPGX0703..	DFT05T3..
–	DFSP230R3WB25M	–	–	23,00	24,00	101,0	69,0	0,6	56	SPGX0703..	DFT05T3..
–	DFSP235R3WB25M	–	–	23,50	24,50	102,5	70,5	0,6	56	SPGX0703..	DFT05T3..
–	DFSP239R3WB25M	–	–	23,90	24,90	103,7	71,7	0,6	56	SPGX0703..	DFT05T3..
–	DFSP240R3WB25M	–	–	24,00	25,00	104,0	72,0	0,6	56	SPGX0703..	DFT05T3..
–	DFSP245R3WB25M	–	–	24,50	25,50	105,5	73,5	0,7	56	SPGX0703..	DFT05T3..
–	DFSP250R3WB25M	–	–	25,00	26,00	108,0	75,0	0,7	56	SPGX0703..	DFT05T3..
–	DFSP255R3WB25M	–	–	25,50	26,50	109,5	76,5	0,7	56	SPGX0703..	DFT05T3..
–	–	DFSP260R3WB32M	–	26,00	27,00	112,0	78,0	0,7	60	SPPX09T3..	DFT05T3..
–	–	DFSP264R3WB32M	–	26,40	27,40	113,2	79,2	0,7	60	SPPX09T3..	DFT05T3..
–	–	DFSP265R3WB32M	–	26,50	27,50	113,5	79,5	0,7	60	SPPX09T3..	DFT05T3..
–	–	DFSP270R3WB32M	–	27,00	28,00	116,0	81,0	0,8	60	SPPX09T3..	DFT05T3..
–	–	DFSP280R3WB32M	–	28,00	29,00	119,0	84,0	0,8	60	SPPX09T3..	DFT05T3..
–	–	DFSP290R3WB32M	–	29,00	30,00	123,0	87,0	0,9	60	SPPX09T3..	DFT05T3..

(continued)

(Weldon® Shank • DIN 1835-1 Form B • 3 x D • Metric — continued)

D											
20	25	32	40	D1	D1 max	L1	L4 max	L5	LS	gage insert outside	gage insert inside
–	–	**DFSP294R3WB32M**	–	29,40	30,40	124,2	88,2	0,9	60	SPPX09T3..	DFT05T3..
–	–	**DFSP300R3WB32M**	–	30,00	31,00	127,0	90,0	0,9	60	SPPX09T3..	DFT05T3..
–	–	–	**DFSP310R3WB40M**	31,00	32,00	131,0	93,0	0,9	70	SPPX09T3..	DFT05T3..
–	–	–	**DFSP320R3WB40M**	32,00	33,00	135,0	96,0	1,0	70	SPPX09T3..	DFT05T3..
–	–	–	**DFSP330R3WB40M**	33,00	34,00	138,0	99,0	0,9	70	SPPX1204..	DFT06T3..
–	–	–	**DFSP340R3WB40M**	34,00	35,00	142,0	102,0	0,9	70	SPPX1204..	DFT06T3..
–	–	–	**DFSP350R3WB40M**	35,00	36,00	146,0	105,0	1,0	70	SPPX1204..	DFT06T3..
–	–	–	**DFSP360R3WB40M**	36,00	37,00	150,0	108,0	1,0	70	SPPX1204..	DFT06T3..
–	–	–	**DFSP370R3WB40M**	37,00	38,00	154,0	111,0	1,1	70	SPPX1204..	DFT06T3..
–	–	–	**DFSP380R3WB40M**	38,00	39,00	157,0	114,0	1,1	70	SPPX1204..	DFT06T3..
–	–	–	**DFSP390R3WB40M**	39,00	40,00	161,0	117,0	1,2	70	SPPX1204..	DFT06T3..
–	–	–	**DFSP400R3WB40M**	40,00	41,00	165,0	120,0	1,2	70	SPPX1204..	DFT06T3..

NOTE for D1 max: Diameter can be adjusted. It is highly recommended to not adjust the diameter more than +1mm.

Spare Parts







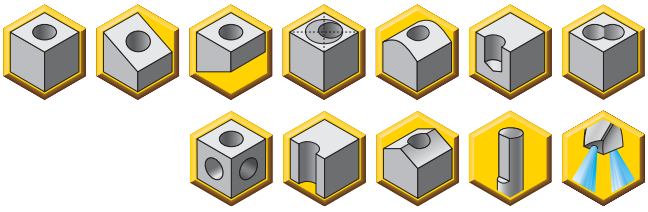
diameter range	gage insert inside	inboard insert screw	tightening torque Nm	gage insert outside	outboard insert screw	tightening torque Nm	Torx driver	Torx size
14.00–17.00	DFTX202..	**1175225**	0,66	SPGX0502..	**1175225**	0,66	**5694202**	T6
17.50–21.50	DFT0303..	**1021337**	0,90	SPGX0603..	**1021337**	0,90	**1138413**	T7
22.00–25.50	DFT05T3..	**3124549**	2,10	SPGX0703..	**1134385**	1,30	**1138465**	T8
26.00–32.00	DFT05T3..	**1105612**	2,10	SPPX09T3..	**1105612**	2,10	**1138430**	T9
33.00–40.00	DFT06T3..	**1132523**	4,00	SPPX1204..	**1132523**	4,00	**1138438**	T15

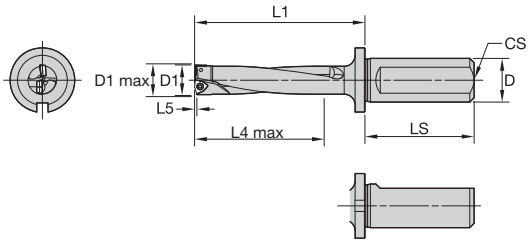
NOTE: To ensure proper clamping, two different screws for DFT™ inserts with different threads for diameter ranges 22–25mm and 41–48mm are necessary. Both screws have the same Torx size.

WARNING
During through-hole operations, a slug or disc is produced as the tool breaks through the workpiece. When the drill is stationary and the workpiece is rotating, this slug may be hurled from the chuck by centrifugal force. Provide adequate shielding to protect bystanders.

D	LS	CS
20	50	R 1/4 BSP
25	56	R 1/4 BSP
32	60	R 1/4 BSP
40	70	R 1/4 BSP

- DFSP combines the economical squared outboard insert with the superior centring capabilities of the trigon inboard insert.
- Drill shipped with insert screws, side pipe plug, and Torx wrench.
- Order inserts for DFSP separately.
See pages J89–J90 for inserts.







Weldon® Shank • DIN 1835-1 Form B • 4 x D • Metric

D											
20	25	32	40	D1	D1 max	L1	L4 max	L5	LS	gage insert outside	gage insert inside
DFSP140R4WB20M	–	–	–	14,00	15,00	78,0	56,0	0,3	50	SPGX0502..	DFTX202..
DFSP145R4WB20M	–	–	–	14,50	15,50	82,0	58,0	0,4	50	SPGX0502..	DFTX202..
DFSP150R4WB20M	–	–	–	15,00	16,00	84,0	60,0	0,4	50	SPGX0502..	DFTX202..
DFSP155R4WB20M	–	–	–	15,50	16,50	86,0	62,0	0,4	50	SPGX0502..	DFTX202..
DFSP160R4WB20M	–	–	–	16,00	17,00	88,0	64,0	0,4	50	SPGX0502..	DFTX202..
DFSP165R4WB20M	–	–	–	16,50	17,50	95,0	66,0	0,5	50	SPGX0502..	DFTX202..
DFSP170R4WB20M	–	–	–	17,00	18,00	97,0	68,0	0,5	50	SPGX0502..	DFTX202..
–	DFSP175R4WB25M	–	–	17,50	18,50	99,0	70,0	0,5	56	SPGX0603..	DFT0303..
–	DFSP180R4WB25M	–	–	18,00	19,00	101,0	72,0	0,5	56	SPGX0603..	DFT0303..
–	DFSP185R4WB25M	–	–	18,50	19,50	103,0	74,0	0,6	56	SPGX0603..	DFT0303..
–	DFSP190R4WB25M	–	–	19,00	20,00	105,0	76,0	0,6	56	SPGX0603..	DFT0303..
–	DFSP195R4WB25M	–	–	19,50	20,50	107,0	78,0	0,6	56	SPGX0603..	DFT0303..
–	DFSP200R4WB25M	–	–	20,00	21,00	112,0	80,0	0,6	56	SPGX0603..	DFT0303..
–	DFSP205R4WB25M	–	–	20,50	21,50	114,0	82,0	0,7	56	SPGX0603..	DFT0303..
–	DFSP209R4WB25M	–	–	20,90	21,90	115,6	83,6	0,7	56	SPGX0603..	DFT0303..
–	DFSP210R4WB25M	–	–	21,00	22,00	116,0	84,0	0,7	56	SPGX0603..	DFT0303..
–	DFSP215R4WB25M	–	–	21,50	22,50	118,0	86,0	0,7	56	SPGX0603..	DFT0303..
–	DFSP220R4WB25M	–	–	22,00	23,00	120,0	88,0	0,5	56	SPGX0703..	DFT05T3..
–	DFSP225R4WB25M	–	–	22,50	23,50	122,0	90,0	0,5	56	SPGX0703..	DFT05T3..
–	DFSP230R4WB25M	–	–	23,00	24,00	124,0	92,0	0,6	56	SPGX0703..	DFT05T3..
–	DFSP235R4WB25M	–	–	23,50	24,50	126,0	94,0	0,6	56	SPGX0703..	DFT05T3..
–	DFSP239R4WB25M	–	–	23,90	24,90	127,6	95,6	0,6	56	SPGX0703..	DFT05T3..
–	DFSP240R4WB25M	–	–	24,00	25,00	128,0	96,0	0,6	56	SPGX0703..	DFT05T3..
–	DFSP245R4WB25M	–	–	24,50	25,50	130,0	98,0	0,7	56	SPGX0703..	DFT05T3..
–	DFSP250R4WB25M	–	–	25,00	26,00	133,0	100,0	0,7	56	SPGX0703..	DFT05T3..
–	DFSP255R4WB25M	–	–	25,50	26,50	135,0	102,0	0,7	56	SPGX0703..	DFT05T3..
–	–	DFSP260R4WB32M	–	26,00	27,00	138,0	104,0	0,7	60	SPPX09T3..	DFT05T3..
–	–	DFSP264R4WB32M	–	26,40	27,40	139,6	105,6	0,7	60	SPPX09T3..	DFT05T3..
–	–	DFSP265R4WB32M	–	26,50	27,50	140,0	106,0	0,7	60	SPPX09T3..	DFT05T3..
–	–	DFSP270R4WB32M	–	27,00	28,00	143,0	108,0	0,8	60	SPPX09T3..	DFT05T3..
–	–	DFSP280R4WB32M	–	28,00	29,00	147,0	112,0	0,8	60	SPPX09T3..	DFT05T3..
–	–	DFSP290R4WB32M	–	29,00	30,00	152,0	116,0	0,9	60	SPPX09T3..	DFT05T3..

(continued)

(Weldon® Shank • DIN 1835-1 Form B • 4 x D • Metric — continued)

D											
20	25	32	40	D1	D1 max	L1	L4 max	L5	LS	gage insert outside	gage insert inside
–	–	**DFSP294R4WB32M**	–	29,40	30,40	153,6	117,6	0,9	60	SPPX09T3..	DFT05T3..
–	–	**DFSP300R4WB32M**	–	30,00	31,00	157,0	120,0	0,9	60	SPPX09T3..	DFT05T3..
–	–	–	**DFSP310R4WB40M**	31,00	32,00	162,0	124,0	0,9	70	SPPX09T3..	DFT05T3..
–	–	–	**DFSP320R4WB40M**	32,00	33,00	167,0	128,0	1,0	70	SPPX09T3..	DFT05T3..
–	–	–	**DFSP330R4WB40M**	33,00	34,00	171,0	132,0	0,9	70	SPPX1204..	DFT06T3..
–	–	–	**DFSP340R4WB40M**	34,00	35,00	176,0	136,0	0,9	70	SPPX1204..	DFT06T3..
–	–	–	**DFSP350R4WB40M**	35,00	36,00	181,0	140,0	1,0	70	SPPX1204..	DFT06T3..
–	–	–	**DFSP360R4WB40M**	36,00	37,00	186,0	144,0	1,0	70	SPPX1204..	DFT06T3..
–	–	–	**DFSP370R4WB40M**	37,00	38,00	191,0	148,0	1,1	70	SPPX1204..	DFT06T3..
–	–	–	**DFSP380R4WB40M**	38,00	39,00	195,0	152,0	1,1	70	SPPX1204..	DFT06T3..
–	–	–	**DFSP390R4WB40M**	39,00	40,00	200,0	156,0	1,2	70	SPPX1204..	DFT06T3..
–	–	–	**DFSP400R4WB40M**	40,00	41,00	205,0	160,0	1,2	70	SPPX1204..	DFT06T3..

NOTE for D1 max: Diameter can be adjusted. It is highly recommended to not adjust the diameter more than +1mm.

Spare Parts







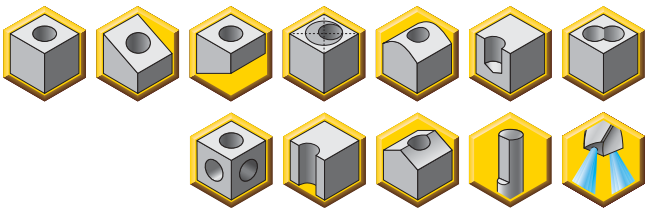
diameter range	gage insert inside	inboard insert screw	tightening torque Nm	gage insert outside	outboard insert screw	tightening torque Nm	Torx driver	Torx size
14.00–17.00	DFTX202..	**1175225**	0,66	SPGX0502..	**1175225**	0,66	**5694202**	T6
17.50–21.50	DFT0303..	**1021337**	0,90	SPGX0603..	**1021337**	0,90	**1138413**	T7
22.00–25.50	DFT05T3..	**3124549**	2,10	SPGX0703..	**1134385**	1,30	**1138465**	T8
26.00–32.00	DFT05T3..	**1105612**	2,10	SPPX09T3..	**1105612**	2,10	**1138430**	T9
33.00–40.00	DFT06T3..	**1132523**	4,00	SPPX1204..	**1132523**	4,00	**1138438**	T15

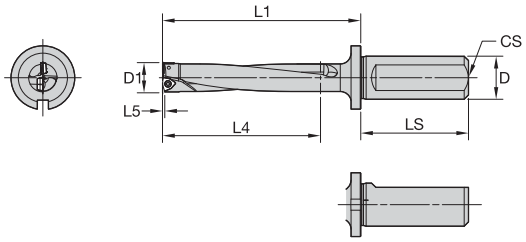
NOTE: To ensure proper clamping, two different screws for DFT™ inserts with different threads for diameter ranges 22–25mm and 41–48mm are necessary. Both screws have the same Torx size.

WARNING
During through-hole operations, a slug or disc is produced as the tool breaks through the workpiece. When the drill is stationary and the workpiece is rotating, this slug may be hurled from the chuck by centrifugal force. Provide adequate shielding to protect bystanders.

D	LS	CS
20	50	R 1/4 BSP
25	56	R 1/4 BSP
32	60	R 1/4 BSP
40	70	R 1/4 BSP

- DFSP combines the economical squared outboard insert with the superior centring capabilities of the trigon inboard insert.
- Drill shipped with insert screws, side pipe plug, and Torx wrench.
- Order inserts for DFSP separately.
See pages J89–J90 for inserts.







Weldon® Shank • DIN 1835-1 Form B • 5 x D • Metric

D										
20	25	32	40	D1	L1	L4 max	L5	LS	gage insert outside	gage insert inside
DFSP140R5WB20M	–	–	–	14,00	92,0	70,0	0,3	50	SPGX0502..	DFTX202..
DFSP145R5WB20M	–	–	–	14,50	96,5	72,5	0,4	50	SPGX0502..	DFTX202..
DFSP150R5WB20M	–	–	–	15,00	99,0	75,0	0,4	50	SPGX0502..	DFTX202..
DFSP155R5WB20M	–	–	–	15,50	101,5	77,5	0,4	50	SPGX0502..	DFTX202..
DFSP160R5WB20M	–	–	–	16,00	104,0	80,0	0,5	50	SPGX0502..	DFTX202..
DFSP165R5WB20M	–	–	–	16,50	111,5	82,5	0,5	50	SPGX0502..	DFTX202..
DFSP170R5WB20M	–	–	–	17,00	114,0	85,0	0,5	50	SPGX0502..	DFTX202..
–	DFSP175R5WB25M	–	–	17,50	116,5	87,5	0,5	56	SPGX0603..	DFT0303..
–	DFSP180R5WB25M	–	–	18,00	119,0	90,0	0,5	56	SPGX0603..	DFT0303..
–	DFSP185R5WB25M	–	–	18,50	121,5	92,5	0,6	56	SPGX0603..	DFT0303..
–	DFSP190R5WB25M	–	–	19,00	124,0	95,0	0,6	56	SPGX0603..	DFT0303..
–	DFSP195R5WB25M	–	–	19,50	126,5	97,5	0,6	56	SPGX0603..	DFT0303..
–	DFSP200R5WB25M	–	–	20,00	132,0	100,0	0,6	56	SPGX0603..	DFT0303..
–	DFSP205R5WB25M	–	–	20,50	134,5	102,5	0,7	56	SPGX0603..	DFT0303..
–	DFSP209R5WB25M	–	–	20,90	136,5	104,5	0,7	56	SPGX0603..	DFT0303..
–	DFSP210R5WB25M	–	–	21,00	137,0	105,0	0,7	56	SPGX0603..	DFT0303..
–	DFSP215R5WB25M	–	–	21,50	139,5	107,5	0,7	56	SPGX0603..	DFT0303..
–	DFSP220R5WB25M	–	–	22,00	142,0	110,0	0,5	56	SPGX0703..	DFT05T3..
–	DFSP225R5WB25M	–	–	22,50	144,5	112,5	0,5	56	SPGX0703..	DFT05T3..
–	DFSP230R5WB25M	–	–	23,00	147,0	115,0	0,6	56	SPGX0703..	DFT05T3..
–	DFSP235R5WB25M	–	–	23,50	149,5	117,5	0,6	56	SPGX0703..	DFT05T3..
–	DFSP239R5WB25M	–	–	23,90	151,5	119,5	0,6	56	SPGX0703..	DFT05T3..
–	DFSP240R5WB25M	–	–	24,00	152,0	120,0	0,6	56	SPGX0703..	DFT05T3..
–	DFSP245R5WB25M	–	–	24,50	154,5	122,5	0,7	56	SPGX0703..	DFT05T3..
–	DFSP250R5WB25M	–	–	25,00	158,0	125,0	0,7	56	SPGX0703..	DFT05T3..
–	DFSP255R5WB25M	–	–	25,50	160,5	127,5	0,7	56	SPGX0703..	DFT05T3..
–	–	DFSP260R5WB32M	–	26,00	163,0	130,0	0,7	60	SPPX09T3..	DFT05T3..
–	–	DFSP264R5WB32M	–	26,40	165,0	132,0	0,7	60	SPPX09T3..	DFT05T3..
–	–	DFSP265R5WB32M	–	26,50	165,5	132,5	0,7	60	SPPX09T3..	DFT05T3..
–	–	DFSP270R5WB32M	–	27,00	170,0	135,0	0,8	60	SPPX09T3..	DFT05T3..
–	–	DFSP280R5WB32M	–	28,00	175,0	140,0	0,8	60	SPPX09T3..	DFT05T3..
–	–	DFSP290R5WB32M	–	29,00	181,0	145,0	0,9	60	SPPX09T3..	DFT05T3..

(continued)

(Weldon® Shank • DIN 1835-1 Form B • 5 x D • Metric — continued)

D										
20	25	32	40	D1	L1	L4 max	L5	LS	gage insert outside	gage insert inside
–	–	**DFSP294R5WB32M**	–	29,40	183,0	147,0	0,9	60	SPPX09T3..	DFT05T3..
–	–	**DFSP300R5WB32M**	–	30,00	187,0	150,0	0,9	60	SPPX09T3..	DFT05T3..
–	–	–	**DFSP310R5WB40M**	31,00	193,0	155,0	0,9	70	SPPX09T3..	DFT05T3..
–	–	–	**DFSP320R5WB40M**	32,00	199,0	160,0	1,0	70	SPPX09T3..	DFT05T3..
–	–	–	**DFSP330R5WB40M**	33,00	204,0	165,0	0,9	70	SPPX1204..	DFT06T3..
–	–	–	**DFSP340R5WB40M**	34,00	210,0	170,0	0,9	70	SPPX1204..	DFT06T3..
–	–	–	**DFSP350R5WB40M**	35,00	216,0	175,0	1,0	70	SPPX1204..	DFT06T3..
–	–	–	**DFSP360R5WB40M**	36,00	222,0	180,0	1,0	70	SPPX1204..	DFT06T3..
–	–	–	**DFSP370R5WB40M**	37,00	228,0	18,0	1,1	70	SPPX1204..	DFT06T3..
–	–	–	**DFSP380R5WB40M**	38,00	233,0	190,0	1,1	70	SPPX1204..	DFT06T3..
–	–	–	**DFSP390R5WB40M**	39,00	239,0	195,0	1,2	70	SPPX1204..	DFT06T3..
–	–	–	**DFSP400R5WB40M**	40,00	245,0	200,0	1,2	70	SPPX1204..	DFT06T3..

NOTE for D1 max: Diameter can be adjusted. It is highly recommended to not adjust the diameter more than +1mm.

Spare Parts







diameter range	gage insert inside	inboard insert screw	tightening torque Nm	gage insert outside	outboard insert screw	tightening torque Nm	Torx driver	Torx size
14.00–17.00	DFTX202..	**1175225**	0,66	SPGX0502..	**1175225**	0,66	**5694202**	T6
17.50–21.50	DFT0303..	**1021337**	0,90	SPGX0603..	**1021337**	0,90	**1138413**	T7
22.00–25.50	DFT05T3..	**3124549**	2,10	SPGX0703..	**1134385**	1,30	**1138465**	T8
26.00–32.00	DFT05T3..	**1105612**	2,10	SPPX09T3..	**1105612**	2,10	**1138430**	T9
33.00–40.00	DFT06T3..	**1132523**	4,00	SPPX1204..	**1132523**	4,00	**1138438**	T15

NOTE: To ensure proper clamping, two different screws for DFT™ inserts with different threads for diameter ranges 22–25mm and 41–48mm are necessary. Both screws have the same Torx size.

WARNING
During through-hole operations, a slug or disc is produced as the tool breaks through the workpiece. When the drill is stationary and the workpiece is rotating, this slug may be hurled from the chuck by centrifugal force. Provide adequate shielding to protect bystanders.

D	LS	CS
20	50	R 1/4 BSP
25	56	R 1/4 BSP
32	60	R 1/4 BSP
40	70	R 1/4 BSP

Drill Fix™ DFSP™ • Metric

Material Group		Condition	Pocket Seat	Geometry	Grade	Cutting Speed — vc Range — m/min min	Starting Value	max	Ø	Recommended Feed Rate (fz) by Diameter SPGX05 DFTX2 14,00–18,00mm	SPGX06 DFT03 18,00–21,99mm	SPGX07 DFT05 22,00–25,99mm	SPGX09 DFT05 26,00–32,99mm	SPGX12 DFT06/..07 33,00–43,99mm	SPGX15 DFT07/..09 44,00–55,00mm
P	0	S	O	LP	KCU40	310	**325**	360	mm/r	0,06–0,10	0,06–0,11	0,08–0,14	0,12–0,21	0,14–0,26	0,16–0,26
			I	DS	KCU40										
		U	O	LP	KCU40	200	**215**	230	mm/r	0,05–0,07	0,06–0,08	0,07–0,10	0,07–0,12	0,09–0,15	0,11–0,21
			I	HP	KCU40										
		I	O	HP	KCU40	130	**135**	150	mm/r	0,05–0,07	0,06–0,08	0,07–0,10	0,07–0,12	0,09–0,15	0,11–0,21
			I	HP	KCU40										
	1	S	O	FP	KCPK10	310	**325**	360	mm/r	0,06–0,11	0,08–0,14	0,10–0,18	0,14–0,25	0,16–0,30	0,18–0,30
			I	HP	KC7140										
		U	O	FP	KCU25	200	**215**	230	mm/r	0,04–0,06	0,05–0,08	0,06–0,10	0,09–0,15	0,11–0,18	0,13–0,25
			I	HP	KC7140										
		I	O	HP	KCU40	130	**135**	150	mm/r	0,04–0,06	0,05–0,08	0,06–0,10	0,09–0,15	0,11–0,18	0,13–0,25
			I	HP	KC7140										
	2	S	O	FP	KCPK10	310	**325**	360	mm/r	0,06–0,11	0,08–0,14	0,10–0,18	0,14–0,25	0,16–0,30	0,18–0,30
			I	HP	KC7140										
		U	O	FP	KCU25	200	**215**	230	mm/r	0,04–0,06	0,05–0,08	0,06–0,10	0,09–0,15	0,11–0,18	0,13–0,25
			I	HP	KC7140										
		I	O	HP	KCU40	130	**135**	150	mm/r	0,04–0,06	0,05–0,08	0,06–0,10	0,09–0,15	0,11–0,18	0,13–0,25
			I	HP	KC7140										
	3	S	O	FP	KCPK10	260	**285**	320	mm/r	0,06–0,11	0,08–0,14	0,10–0,18	0,14–0,25	0,16–0,30	0,18–0,30
			I	HP	KC7140										
		U	O	HP	KCU25	180	**195**	220	mm/r	0,04–0,06	0,05–0,08	0,06–0,10	0,09–0,15	0,11–0,18	0,13–0,25
			I	HP	KC7140										
		I	O	HP	KCU40	110	**120**	140	mm/r	0,04–0,06	0,05–0,08	0,06–0,10	0,09–0,15	0,11–0,18	0,13–0,25
			I	HP	KC7140										
	4	S	O	FP	KCPK10	220	**250**	300	mm/r	0,06–0,11	0,08–0,14	0,10–0,18	0,14–0,25	0,16–0,30	0,18–0,30
			I	HP	KC7140										
		U	O	HP	KCU25	150	**180**	220	mm/r	0,04–0,06	0,05–0,08	0,06–0,10	0,09–0,15	0,11–0,18	0,13–0,25
			I	HP	KC7140										
		I	O	HP	KCU40	90	**110**	140	mm/r	0,04–0,06	0,05–0,08	0,06–0,10	0,09–0,15	0,11–0,18	0,13–0,25
			I	HP	KC7140										
	5	S	O	HP	KCU25	180	**200**	220	mm/r	0,06–0,11	0,08–0,14	0,10–0,18	0,14–0,25	0,16–0,30	0,18–0,30
			I	HP	KC7140										
		U	O	HP	KCU40	120	**135**	150	mm/r	0,04–0,06	0,05–0,08	0,06–0,10	0,09–0,15	0,11–0,18	0,13–0,25
			I	HP	KC7140										
		I	O	HP	KC7140	70	**85**	100	mm/r	0,04–0,06	0,05–0,08	0,06–0,10	0,09–0,15	0,11–0,18	0,13–0,25
			I	HP	KC7140										
	6	S	O	HP	KCU25	180	**200**	220	mm/r	0,06–0,11	0,08–0,14	0,10–0,18	0,14–0,25	0,16–0,30	0,18–0,30
			I	HP	KC7140										
		U	O	HP	KCU40	120	**135**	150	mm/r	0,04–0,06	0,05–0,08	0,06–0,10	0,09–0,15	0,11–0,18	0,13–0,25
			I	HP	KC7140										
		I	O	HP	KC7140	70	**85**	100	mm/r	0,04–0,06	0,05–0,08	0,06–0,10	0,09–0,15	0,11–0,18	0,13–0,25
			I	HP	KC7140										
M	1	S	O	LP	KCU40	150	**190**	230	mm/r	0,05–0,08	0,06–0,10	0,07–0,12	0,10–0,16	0,12–0,21	0,14–0,24
			I	DS	KCU40										
		U	O	LP	KCU40	100	**130**	160	mm/r	0,05–0,07	0,06–0,08	0,07–0,10	0,05–0,10	0,06–0,13	0,08–0,16
			I	DS	KCU40										
		I	O	MD	KC7140	60	**80**	100	mm/r	0,03–0,05	0,04–0,07	0,05–0,09	0,07–0,13	0,08–0,16	0,10–0,18
			I	MD	KC7140										
	2	S	O	LP	KCU40	150	**180**	210	mm/r	0,05–0,08	0,06–0,10	0,07–0,12	0,10–0,16	0,12–0,21	0,14–0,24
			I	DS	KCU40										
		U	O	MD	KCU40	100	**130**	160	mm/r	0,03–0,05	0,04–0,07	0,05–0,09	0,07–0,13	0,08–0,16	0,10–0,20
			I	MD	KC7140										
		I	O	MD	KC7140	60	**80**	100	mm/r	0,03–0,05	0,04–0,07	0,05–0,09	0,07–0,13	0,08–0,16	0,10–0,18
			I	MD	KC7140										
	3	S	O	LP	KCU40	100	**130**	160	mm/r	0,05–0,07	0,06–0,08	0,07–0,10	0,05–0,10	0,06–0,13	0,08–0,16
			I	DS	KCU40										
		U	O	HP	KCU40	80	**110**	140	mm/r	0,03–0,05	0,04–0,07	0,05–0,09	0,07–0,13	0,08–0,16	0,10–0,20
			I	HP	KC7140										
		I	O	MD	KC7140	50	**70**	90	mm/r	0,03–0,05	0,04–0,07	0,05–0,09	0,07–0,13	0,08–0,16	0,10–0,18
			I	MD	KC7140										

NOTE: Applying Drill Fix™ DFSP 5 x D requires high stability. It is highly recommended to be conservative in regard to speeds and feeds, and start with minimum values indicated.

Condition: S = Stable cutting conditions;
U = Unstable cutting conditions;
I = Interrupted cutting conditions

Pocket seat: I = Inboard insert;
O = Outboard insert

Drill Fix™ DFSP™ • Metric

Metric														
Material Group		Condition	Pocket Seat	Geometry	Grade	Cutting Speed — vc Range — m/min			Recommended Feed Rate (fz) by Diameter					
						min	Starting Value	max	Ø	SPGX05 DFTX2 14,00–18,00mm	SPGX06 DFT03 18,00–21,99mm	SPGX07 DFT05 22,00–25,99mm	SPGX09 DFT05 26,00–32,99mm	SPGX12 DFT06/..07 33,00–43,99mm	SPGX15 DFT07/..09 44,00–55,00mm
K	1	S	O	FP	KCPK10	200	**240**	300	mm/r	0,07–0,12	0,10–0,16	0,12–0,20	0,16–0,28	0,18–0,32	0,20–0,34
			I	HP	KCU40										
		U	O	FP	KCU25	120	**155**	200	mm/r	0,05–0,09	0,06–0,12	0,08–0,15	0,12–0,20	0,14–0,25	0,16–0,28
			I	HP	KC7140										
		I	O	FP	KC7140	80	**100**	125	mm/r	0,04–0,06	0,05–0,08	0,06–0,10	0,09–0,15	0,11–0,18	0,13–0,25
			I	HP	KC7140										
	2	S	O	FP	KCPK10	180	**220**	260	mm/r	0,07–0,12	0,10–0,16	0,12–0,20	0,16–0,28	0,18–0,32	0,20–0,34
			I	HP	KCU40										
		U	O	HP	KCU25	110	**140**	170	mm/r	0,05–0,09	0,06–0,12	0,08–0,15	0,12–0,20	0,14–0,25	0,16–0,28
			I	HP	KC7140										
		I	O	HP	KC7140	80	**100**	120	mm/r	0,04–0,06	0,05–0,08	0,06–0,10	0,09–0,15	0,11–0,18	0,13–0,25
			I	HP	KC7140										
	3	S	O	HP	KCPK10	180	**220**	260	mm/r	0,07–0,12	0,10–0,16	0,12–0,20	0,16–0,28	0,18–0,32	0,20–0,34
			I	HP	KCU40										
		U	O	HP	KCU25	110	**140**	170	mm/r	0,05–0,09	0,06–0,12	0,08–0,15	0,12–0,20	0,14–0,25	0,16–0,28
			I	HP	KC7140										
		I	O	HP	KC7140	80	**100**	120	mm/r	0,04–0,06	0,05–0,08	0,06–0,10	0,09–0,15	0,11–0,18	0,13–0,25
			I	HP	KC7140										
N	1	S	O	HP	KCPK10	350	**500**	650	mm/r	0,07–0,12	0,10–0,16	0,12–0,20	0,16–0,28	0,18–0,32	0,20–0,34
			I	HP	KMF										
		U	O	HP	KCU40	300	**400**	500	mm/r	0,05–0,09	0,06–0,12	0,08–0,15	0,12–0,20	0,14–0,25	0,16–0,28
			I	HP	KMF										
		I	O	HP	KCU40	200	**300**	400	mm/r	0,04–0,06	0,05–0,08	0,06–0,10	0,09–0,15	0,11–0,18	0,13–0,25
			I	HP	KMF										
	2	S	O	HP	KCPK10	300	**400**	500	mm/r	0,07–0,12	0,10–0,16	0,12–0,20	0,16–0,28	0,18–0,32	0,20–0,34
			I	HP	KMF										
		U	O	HP	KCU40	250	**350**	450	mm/r	0,05–0,09	0,06–0,12	0,08–0,15	0,12–0,20	0,14–0,25	0,16–0,28
			I	HP	KMF										
		I	O	HP	KCU40	175	**250**	325	mm/r	0,04–0,06	0,05–0,08	0,06–0,10	0,09–0,15	0,11–0,18	0,13–0,25
			I	HP	KMF										
	3	S	O	HP	KCPK10	300	**400**	500	mm/r	0,07–0,12	0,10–0,16	0,12–0,20	0,16–0,28	0,18–0,32	0,20–0,34
			I	HP	KMF										
		U	O	HP	KCU40	250	**350**	450	mm/r	0,05–0,09	0,06–0,12	0,08–0,15	0,12–0,20	0,14–0,25	0,16–0,28
			I	HP	KMF										
		I	O	HP	KCU40	150	**250**	350	mm/r	0,04–0,06	0,05–0,08	0,06–0,10	0,09–0,15	0,11–0,18	0,13–0,25
			I	HP	KMF										
	4	S	O	HP	KCU25	300	**400**	500	mm/r	0,07–0,12	0,10–0,16	0,12–0,20	0,16–0,28	0,18–0,32	0,20–0,34
			I	HP	KC7140										
		U	O	HP	KCU40	250	**350**	450	mm/r	0,05–0,09	0,06–0,12	0,08–0,15	0,12–0,20	0,14–0,25	0,16–0,28
			I	HP	KC7140										
		I	O	HP	KCU40	200	**300**	400	mm/r	0,04–0,06	0,05–0,08	0,06–0,10	0,09–0,15	0,11–0,18	0,13–0,25
			I	HP	KC7140										
	5	S	O	HP	KCU25	300	**400**	500	mm/r	0,07–0,12	0,10–0,16	0,12–0,20	0,16–0,28	0,18–0,32	0,20–0,34
			I	HP	KC7140										
		U	O	HP	KCU40	250	**350**	450	mm/r	0,05–0,09	0,06–0,12	0,08–0,15	0,12–0,20	0,14–0,25	0,16–0,28
			I	HP	KC7140										
		I	O	HP	KCU40	200	**300**	400	mm/r	0,04–0,06	0,05–0,08	0,06–0,10	0,09–0,15	0,11–0,18	0,13–0,25
			I	HP	KC7140										
	6	S	O	HP	KCU40	400	**450**	500	mm/r	0,07–0,12	0,10–0,16	0,12–0,20	0,16–0,28	0,18–0,32	0,20–0,34
			I	HP	KMF										
		U	O	HP	KCU40	250	**350**	450	mm/r	0,05–0,09	0,06–0,12	0,08–0,15	0,12–0,20	0,14–0,25	0,16–0,28
			I	HP	KMF										
		I	O	HP	KCU40	200	**300**	400	mm/r	0,04–0,06	0,05–0,08	0,06–0,10	0,09–0,15	0,11–0,18	0,13–0,25
			I	HP	KMF										

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Condition: S = Stable cutting conditions;
U = Unstable cutting conditions;
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Pocket seat: I = Inboard insert;
O = Outboard insert

Drill Fix™ DFSP™ • Metric

Metric															
Material Group		Condition	Pocket Seat	Geometry	Grade	Cutting Speed — vc Range — m/min			Recommended Feed Rate (fz) by Diameter						
						min	Starting Value	max	Ø	SPGX05 DFTX2 14,00–18,00mm	SPGX06 DFT03 18,00–21,99mm	SPGX07 DFT05 22,00–25,99mm	SPGX09 DFT05 26,00–32,99mm	SPGX12 DFT06/..07 33,00–43,99mm	SPGX15 DFT07/..09 44,00–55,00mm
S	1	S	O	HP	KCU40	60	**70**	75	mm/r	0,03–0,06	0,04–0,08	0,05–0,10	0,08–0,12	0,10–0,15	0,12–0,18
			I	MD	KC7140										
		U	O	HP	KCU40	40	**50**	60	mm/r	0,02–0,03	0,02–0,04	0,03–0,05	0,04–0,06	0,05–0,08	0,06–0,10
			I	MD	KC7140										
		I	O	HP	KCU40	25	**30**	40	mm/r	0,02–0,03	0,02–0,04	0,03–0,05	0,04–0,06	0,05–0,08	0,06–0,10
			I	MD	KC7140										
	2	S	O	HP	KCU40	50	**60**	70	mm/r	0,03–0,06	0,04–0,08	0,05–0,10	0,08–0,12	0,10–0,15	0,12–0,18
			I	MD	KC7140										
		U	O	HP	KCU40	30	**40**	50	mm/r	0,02–0,03	0,02–0,04	0,03–0,05	0,04–0,06	0,05–0,08	0,06–0,10
			I	MD	KC7140										
		I	O	HP	KCU40	25	**30**	40	mm/r	0,02–0,03	0,02–0,04	0,03–0,05	0,04–0,06	0,05–0,08	0,06–0,10
			I	MD	KC7140										
	3	S	O	LP	KCU40	70	**80**	90	mm/r	0,03–0,06	0,04–0,08	0,05–0,10	0,08–0,12	0,10–0,15	0,12–0,18
			I	DS	KC7140										
		U	O	LP	KCU40	50	**60**	70	mm/r	0,02–0,03	0,02–0,04	0,03–0,05	0,04–0,06	0,05–0,08	0,06–0,10
			I	DS	KC7140										
		I	O	HP	KCU40	30	**40**	50	mm/r	0,02–0,03	0,02–0,04	0,03–0,05	0,04–0,06	0,05–0,08	0,06–0,10
			I	MD	KC7140										
	4	S	O	LP	KCU40	70	**80**	90	mm/r	0,03–0,06	0,04–0,08	0,05–0,10	0,08–0,12	0,10–0,15	0,12–0,18
			I	DS	KC7140										
		U	O	LP	KCU40	50	**60**	70	mm/r	0,02–0,03	0,02–0,04	0,03–0,05	0,04–0,06	0,05–0,08	0,06–0,10
			I	DS	KC7140										
		I	O	HP	KCU40	30	**40**	50	mm/r	0,02–0,03	0,02–0,04	0,03–0,05	0,04–0,06	0,05–0,08	0,06–0,10
			I	MD	KC7140										

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Condition: S = Stable cutting conditions;
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O = Outboard insert

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Drill Fix™ DFT™

Primary Application

The Drill Fix DFT system is available in diameter range 24–82mm (.625–3.250") as a versatile and reliable tool solution with a large portfolio of lengths, insert geometries, and grades.

Balanced cutting forces, improved chip flute, and coolant-channel design enable high metal removal rates and long tool body life. The trigon-shaped DFT inserts are used for both inboard and outboard inserts and offer the highest centring capabilities. Each insert has three cutting edges.

Features and Benefits

Productivity and Profitability

- Achieve high hole accuracy with trigon-shaped inboard inserts that offer the highest centring capabilities.
- Use X-offset on turning machines to adjust the drill diameter and eliminate the need for specials in many applications, and on machining centres to reach tolerance optimisation.
- Same insert size is used in each pocket, reducing inventory costs.

Versatility

- Diameter range covering 24–82mm (.625–3.250").
- 2.5 x D and 4 x D L/D ratios are standard.
- Various shanks available as standard: WD and SSF.
- Trigon-shaped inserts feature three cutting edges.
- Large variety of DFT insert grades and geometries available.
- Use DFT drills in straight holes, inclined entries and exits, interrupted cuts, and rough or welded entry surfaces.
- Eccentric chuck available as standard.

Versatile and reliable tool solution with a large portfolio of lengths, insert geometries, and grades.



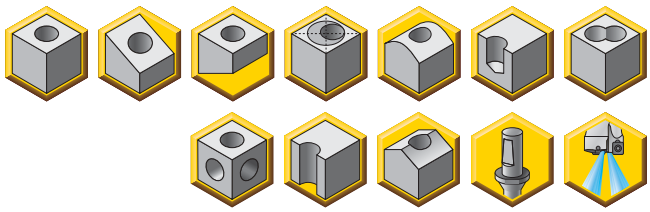
Reliability

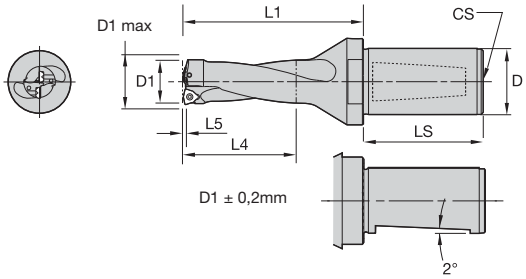
- Highest centring capabilities due to trigon-shaped insert.
- Same insert can be used as inboard or outboard insert — no risk of mixing up inner and outer inserts.
- Improved chip flute and coolant-channel design result in long tool body life and excellent chip evacuation.

Customisation

- Intermediate diameters available as semi-standards.
- Engineered solutions available.
- Multistep drills available upon request.
- Stacked material version.

- Drill shipped with insert screws and Torx wrench.
- See pages J85 and J87–J88 for inserts.







WN/WD Shank • 2,5 x D • Metric

D								
32	40	50	D1	D1 max	L1	L4 max	L5	gage insert
DFT250R2WD32M	DFT250R2WD40M	–	25,00	27,00	90,0	58,9	0,9	DFT05T3..
DFT260R2WD32M	DFT260R2WD40M	–	26,00	27,00	90,0	59,1	1,1	DFT05T3..
DFT270R2WD32M	DFT270R2WD40M	–	27,00	29,00	100,0	66,1	1,1	DFT05T3..
DFT280R2WD32M	DFT280R2WD40M	–	28,00	29,00	100,0	66,3	1,3	DFT05T3..
DFT290R2WD32M	DFT290R2WD40M	–	29,00	31,00	100,0	66,3	1,3	DFT05T3..
DFT300R2WD32M	DFT300R2WD40M	–	30,00	31,00	115,0	76,4	1,4	DFT05T3..
DFT310R2WD32M	DFT310R2WD40M	–	31,00	33,00	115,0	76,4	1,4	DFT05T3..
DFT320R2WD32M	DFT320R2WD40M	–	32,00	33,00	115,0	76,5	1,5	DFT05T3..
DFT330R2WD32M	DFT330R2WD40M	–	33,00	35,00	115,0	76,4	1,4	DFT06T3..
DFT340R2WD32M	DFT340R2WD40M	–	34,00	35,00	115,0	76,5	1,5	DFT06T3..
DFT350R2WD32M	DFT350R2WD40M	–	35,00	38,00	115,0	76,6	1,6	DFT06T3..
DFT360R2WD32M	DFT360R2WD40M	–	36,00	37,00	115,0	76,8	1,8	DFT06T3..
DFT370R2WD32M	DFT370R2WD40M	–	37,00	38,00	135,0	96,7	1,7	DFT06T3..
DFT380R2WD32M	DFT380R2WD40M	–	38,00	41,00	135,0	96,8	1,8	DFT06T3..
DFT390R2WD32M	DFT390R2WD40M	–	39,00	40,00	135,0	96,9	1,9	DFT06T3..
DFT400R2WD32M	DFT400R2WD40M	–	40,00	41,00	135,0	97,0	2,0	DFT06T3..
DFT410R2WD32M	DFT410R2WD40M	–	41,00	44,00	135,0	96,9	1,9	DFT0704..
DFT420R2WD32M	DFT420R2WD40M	–	42,00	43,00	135,0	96,9	2,0	DFT0704..
DFT430R2WD32M	DFT430R2WD40M	–	43,00	44,00	150,0	112,1	2,1	DFT0704..
DFT440R2WD32M	DFT440R2WD40M	–	44,00	47,00	150,0	112,1	2,1	DFT0704..
–	DFT450R2WD40M	DFT450R2WD50M	45,00	46,00	150,0	112,2	2,2	DFT0704..
–	DFT460R2WD40M	DFT460R2WD50M	46,00	47,00	150,0	112,0	2,3	DFT0704..
–	DFT470R2WD40M	DFT470R2WD50M *	47,00	50,00	150,0	111,5	2,4	DFT0704..
–	DFT480R2WD40M	DFT480R2WD50M	48,00	49,00	150,0	111,0	2,4	DFT0704..
–	DFT490R2WD40M	DFT490R2WD50M	49,00	50,00	165,0	117,2	2,2	DFT0905..
–	DFT500R2WD40M	DFT500R2WD50M	50,00	54,00	165,0	117,2	2,2	DFT0905..
–	DFT510R2WD40M	DFT510R2WD50M	51,00	52,00	165,0	117,4	2,5	DFT0905..
–	DFT520R2WD40M	DFT520R2WD50M	52,00	53,00	165,0	117,5	2,6	DFT0905..
–	DFT530R2WD40M	DFT530R2WD50M	53,00	54,00	165,0	117,6	2,6	DFT0905..
–	DFT540R2WD40M	DFT540R2WD50M	54,00	58,00	165,0	117,7	2,7	DFT0905..
–	–	DFT550R2WD50M	55,00	56,00	180,0	125,0	2,7	DFT0905..
–	–	DFT560R2WD50M	56,00	57,00	180,0	125,0	2,8	DFT0905..
–	–	DFT570R2WD50M	57,00	58,00	180,0	125,0	2,9	DFT0905..
–	–	DFT580R2WD50M	58,00	62,00	180,0	125,0	3,0	DFT0905..
–	–	DFT590R2WD50M	59,00	60,00	180,0	125,0	3,0	DFT0905..
–	–	DFT600R2WD50M	60,00	61,00	180,0	125,0	3,1	DFT0905..

(continued)

(WN/WD Shank • 2,5 x D • Metric — continued)

D								
32	40	50	D1	D1 max	L1	L4 max	L5	gage insert
–	–	**DFT610R2WD50M**	61,00	62,00	180,0	125,0	3,2	DFT0905..
–	–	**DFT620R2WD50M**	62,00	65,00	180,0	125,0	3,2	DFT0905..
–	–	**DFT630R2WD50M**	63,00	64,00	180,0	125,0	3,3	DFT0905..
–	–	**DFT640R2WD50M**	64,00	65,00	180,0	125,0	3,4	DFT0905..
–	–	**DFT650R2WD50M**	65,00	66,00	180,0	125,0	3,4	DFT0905..
–	–	**DFT660R2WD50M**	66,00	69,00	180,0	125,0	3,5	DFT0905..
–	–	**DFT670R2WD50M**	67,00	67,00	180,0	125,0	3,5	DFT0905..
–	–	**DFT680R2WD50M**	68,00	69,00	180,0	125,0	3,6	DFT0905..
–	–	**DFT690R2WD50M**	69,00	73,00	205,0	140,0	3,6	DFT1105..
–	–	**DFT700R2WD50M**	70,00	71,00	205,0	140,0	3,6	DFT1105..
–	–	**DFT710R2WD50M**	71,00	72,00	205,0	140,0	3,9	DFT1105..
–	–	**DFT720R2WD50M**	72,00	73,00	205,0	140,0	3,9	DFT1105..
–	–	**DFT730R2WD50M**	73,00	79,00	205,0	140,0	4,0	DFT1105..
–	–	**DFT740R2WD50M**	74,00	75,00	205,0	140,0	4,1	DFT1105..
–	–	**DFT750R2WD50M**	75,00	76,00	205,0	140,0	4,2	DFT1105..
–	–	**DFT760R2WD50M**	76,00	77,00	205,0	140,0	4,2	DFT1105..
–	–	**DFT770R2WD50M**	77,00	78,00	205,0	140,0	4,3	DFT1105..
–	–	**DFT780R2WD50M**	78,00	79,00	205,0	140,0	4,3	DFT1105..
–	–	**DFT790R2WD50M**	79,00	82,00	205,0	140,0	4,4	DFT1105..
–	–	**DFT800R2WD50M**	80,00	81,00	205,0	140,0	4,5	DFT1105..
–	–	**DFT810R2WD50M** *	81,00	82,00	205,0	140,0	4,5	DFT1105..
–	–	**DFT820R2WD50M**	82,00	83,00	205,0	140,0	4,5	DFT1105..

NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

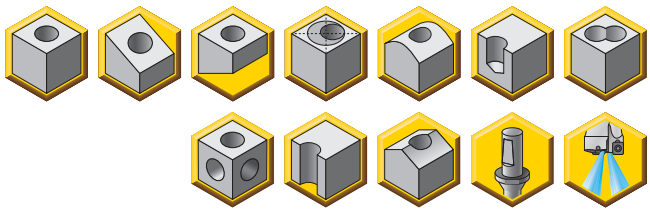
WARNING
During through-hole operations, a slug or disc is produced as the tool breaks through the workpiece. When the drill is stationary and the workpiece is rotating, this slug may be hurled from the chuck by centrifugal force. Provide adequate shielding to protect bystanders.

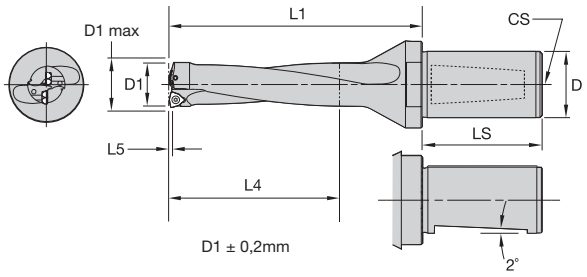



gage insert	insert screw	Torx wrench	Torx size
DFT05T3..	**191.924**	**170.024**	9
DFT06T3..	**191.848**	**170.025**	15
DFT0704..	**191.698**	**170.025**	15
DFT0905..	**191.726**	**170.026**	20
DFT1105..	**191.375**	**170.026**	20

D	LS	CS
32	58	R 1/4 BSP
40	68	R 1/4 BSP
50	68	R 1/4 BSP

- Drill shipped with insert screws and Torx wrench.
- See pages J85 and J87–J88 for inserts.







WN/WD Shank • 4 x D • Metric

D							
32	40	D1	D1 max	L1	L4 max	L5	gage insert
DFT250R4WD32M	**DFT250R4WD40M**	25,00	27,00	135,0	100,0	0,8	DFT05T3..
DFT260R4WD32M	**DFT260R4WD40M**	26,00	27,00	139,0	104,0	0,9	DFT05T3..
DFT270R4WD32M	**DFT270R4WD40M**	27,00	29,00	143,0	108,0	1,0	DFT05T3..
DFT280R4WD32M	**DFT280R4WD40M**	28,00	29,00	156,0	112,0	1,1	DFT05T3..
DFT290R4WD32M	**DFT290R4WD40M**	29,00	31,00	151,0	116,0	1,1	DFT05T3..
DFT300R4WD32M	**DFT300R4WD40M**	30,00	31,00	160,0	120,0	1,2	DFT05T3..
DFT310R4WD32M	**DFT310R4WD40M**	31,00	33,00	164,0	124,0	1,3	DFT05T3..
DFT320R4WD32M	**DFT320R4WD40M**	32,00	33,00	168,0	128,0	1,3	DFT05T3..
–	**DFT330R4WD40M**	33,00	35,00	177,0	132,0	1,1	DFT06T3..
–	**DFT340R4WD40M**	34,00	35,00	181,0	136,0	1,3	DFT06T3..
–	**DFT350R4WD40M**	35,00	38,00	185,0	140,0	1,3	DFT06T3..
–	**DFT360R4WD40M**	36,00	37,00	189,0	144,0	1,4	DFT06T3..
–	**DFT370R4WD40M**	37,00	38,00	198,0	148,0	1,5	DFT06T3..
–	**DFT380R4WD40M**	38,00	41,00	202,0	152,0	1,5	DFT06T3..
–	**DFT390R4WD40M**	39,00	40,00	206,0	156,0	1,6	DFT06T3..
–	**DFT400R4WD40M**	40,00	41,00	210,0	160,0	1,7	DFT06T3..
–	**DFT410R4WD40M**	41,00	44,00	214,0	164,0	1,6	DFT0704..
–	**DFT420R4WD40M**	42,00	43,00	223,0	168,0	1,7	DFT0704..
–	**DFT430R4WD40M**	43,00	44,00	227,0	172,0	1,7	DFT0704..
–	**DFT440R4WD40M**	44,00	47,00	231,0	176,0	1,8	DFT0704..
–	**DFT450R4WD40M**	45,00	46,00	240,0	180,0	1,9	DFT0704..
–	**DFT460R4WD40M**	46,00	47,00	244,0	184,0	1,9	DFT0704..
–	**DFT470R4WD40M**	47,00	50,00	248,0	188,0	2,0	DFT0704..
–	**DFT480R4WD40M**	48,00	49,00	252,0	192,0	2,0	DFT0704..

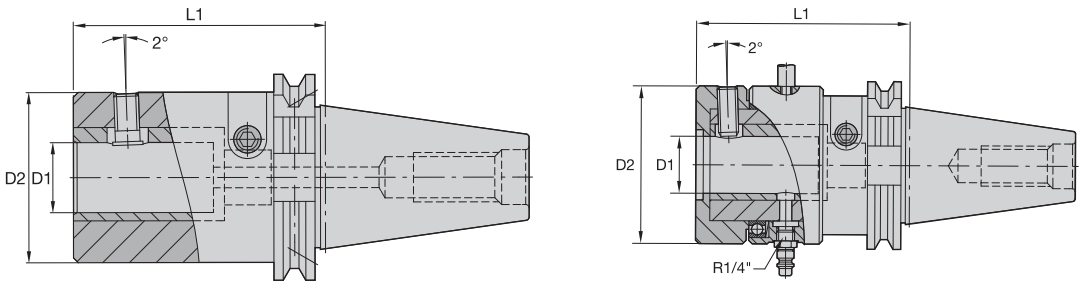
WARNING
During through-hole operations, a slug or disc is produced as the tool breaks through the workpiece. When the drill is stationary and the workpiece is rotating, this slug may be hurled from the chuck by centrifugal force. Provide adequate shielding to protect bystanders.





gage insert	insert screw	Torx wrench	Torx size
DFT05T3..	**191.924**	**170.024**	9
DFT06T3..	**191.848**	**170.025**	15
DFT0704..	**191.698**	**170.025**	15

D	LS	CS
32	58	R 1/4 BSP
40	68	R 1/4 BSP

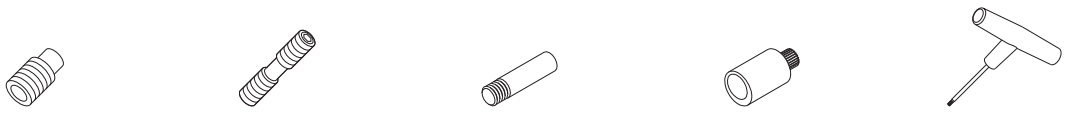


Drill Fix Chucks • Eccentric Adjustment Mechanism

				SK 40		SK 50				
catalogue number	D1	D2	L1	DIN 69871 A	MAS 403 BT	DIN 69871 A	MAS 403 BT	coolant ring	kg	lbs
BT40BEWD20096M	20,00	63.000	96.000	–	●	–	–	–	3.00	6.6
DV40BEWD20090M	20,00	63.000	96.000	●	–	–	–	–	3.00	6.6
DV50BEWD32108M	32,00	63.000	108.000	–	–	●	–	–	4.30	9.5
BT50BEWD32127M	32,00	63.000	108.000	–	–	–	●	–	4,3	9.5
DV40BEWD32108M	32,00	63.000	108.000	●	–	–	–	–	4.00	8.8
BT40BEWD32114M	32,00	63.000	114.000	–	●	–	–	–	3.40	7.5
BT40RMEWD32114M	32,00	90.000	114.000	–	●	–	–	●	4.00	8.8
DV50RMEWD32108M	32,00	90.000	108.000	–	–	●	–	●	6.90	15.2

NOTE: n_{max}: 4800 U/min
Pmax: 20 bar

With Coolant Ring



D1	clamping screw	adjusting screw	bumper bar	eccentric bushing	dial key
32	**192.941**	**570.850**	**169.974**	**536.088**	**170.236**

Without Coolant Ring



D1	clamping screw	adjusting screw	eccentric bushing	dial key
20	**193.203**	**570.850**	**536.090**	**170.236**
32	**193.204**	**570.850**	**536.091**	**170.236**

SAFETY NOTE: Use only the supplied plug-in nipple with nominal breakage point: R 6,35mm, catalogue number 191.469.
Intermediate sleeve with dial key included (for coolant ring version, use dial key, bumper bar, and plug-in nipple with predetermined breaking point).

Drill Fix™ DFT™ • Metric

Metric														
Material Group		Condition	Pocket Seat	Geometry	Grade	Cutting Speed — vc Range — m/min			Recommended Feed Rate (f) by Diameter					
						min	Starting Value	max	Ø	DFT03 16–24mm	DFT05 25–32mm	DFT06 32–40mm	DFT07 41–48mm	DFT09... 49–68mm	DFT11 69–82mm
P	0	S	O	DS	KCU40	280	**300**	320	mm/r	0,05–0,08	0,07–0,12	0,09–0,15	0,13–0,21	0,17–0,27	0,17–0,27
			I	DS	KCU40										
		U	O	DS	KCU40	200	**215**	230	mm/r	0,05–0,08	0,07–0,12	0,09–0,15	0,13–0,21	0,17–0,27	0,17–0,27
			I	DS	KCU40										
		I	O	DS	KCU40	130	**135**	150	mm/r	0,05–0,08	0,07–0,12	0,09–0,15	0,13–0,21	0,17–0,27	0,19–0,31
			I	DS	KCU40										
	1	S	O	MD	KCU25	310	**325**	360	mm/r	0,05–0,08	0,07–0,12	0,09–0,15	0,13–0,21	0,17–0,27	0,19–0,31
			I	MD	KC7140										
		U	O	MD	KCU25	200	**215**	230	mm/r	0,06–0,10	0,09–0,15	0,11–0,18	0,15–0,25	0,19–0,31	0,19–0,31
			I	MD	KC7140										
		I	O	MD	KCU40	130	**135**	150	mm/r	0,06–0,10	0,09–0,15	0,11–0,18	0,15–0,25	0,19–0,31	0,19–0,31
			I	MD	KC7140										
	2	S	O	HP	KCPK10	310	**325**	360	mm/r	0,06–0,10	0,09–0,15	0,11–0,18	0,15–0,25	0,19–0,31	0,19–0,31
			I	HP	KC7140										
		U	O	HP	KCU25	200	**215**	230	mm/r	0,06–0,10	0,09–0,15	0,11–0,18	0,15–0,25	0,19–0,31	0,19–0,31
			I	HP	KC7140										
		I	O	HP	KCU40	130	**135**	150	mm/r	0,06–0,10	0,09–0,15	0,11–0,18	0,15–0,25	0,19–0,31	0,19–0,31
			I	HP	KC7140										
	3	S	O	HP	KCPK10	260	**285**	320	mm/r	0,06–0,10	0,09–0,15	0,11–0,18	0,15–0,25	0,19–0,31	0,19–0,31
			I	HP	KC7140										
		U	O	HP	KCU25	180	**195**	220	mm/r	0,06–0,10	0,09–0,15	0,11–0,18	0,15–0,25	0,19–0,31	0,19–0,31
			I	HP	KC7140										
		I	O	HP	KCU40	110	**120**	140	mm/r	0,06–0,10	0,09–0,15	0,11–0,18	0,15–0,25	0,19–0,31	0,19–0,31
			I	HP	KC7140										
	4	S	O	HP	KCU25	220	**250**	300	mm/r	0,06–0,10	0,09–0,15	0,11–0,18	0,15–0,25	0,19–0,31	0,19–0,31
			I	HP	KC7140										
		U	O	HP	KCU40	150	**180**	220	mm/r	0,06–0,10	0,09–0,15	0,11–0,18	0,15–0,25	0,19–0,31	0,19–0,31
			I	HP	KC7140										
		I	O	HP	KC7140	90	**110**	140	mm/r	0,06–0,10	0,09–0,15	0,11–0,18	0,15–0,25	0,19–0,31	0,19–0,31
			I	HP	KC7140										
	5	S	O	HP	KCU25	180	**200**	220	mm/r	0,06–0,10	0,07–0,13	0,09–0,15	0,11–0,18	0,12–0,23	0,12–0,23
			I	HP	KC7140										
		U	O	HP	KCU40	120	**135**	150	mm/r	0,06–0,10	0,07–0,13	0,09–0,15	0,11–0,18	0,12–0,23	0,12–0,23
			I	HP	KC7140										
		I	O	HP	KC7140	70	**85**	100	mm/r	0,05–0,10	0,07–0,13	0,09–0,15	0,11–0,18	0,12–0,23	0,12–0,23
			I	HP	KC7140										
	6	S	O	HP	KCU25	180	**200**	220	mm/r	0,05–0,10	0,07–0,13	0,09–0,15	0,11–0,18	0,12–0,23	0,12–0,23
			I	HP	KC7140										
		U	O	HP	KCU40	120	**135**	150	mm/r	0,05–0,10	0,07–0,13	0,09–0,15	0,11–0,18	0,12–0,23	0,12–0,23
			I	HP	KC7140										
		I	O	HP	KC7140	70	**85**	100	mm/r	0,05–0,10	0,07–0,13	0,09–0,15	0,11–0,18	0,12–0,23	0,12–0,23
			I	HP	KC7140										
M	1	S	O	DS	KCU40	150	**190**	230	mm/r	0,05–0,08	0,05–0,10	0,06–0,13	0,08–0,14	0,09–0,17	0,09–0,17
			I	DS	KCU40										
		U	O	DS	KCU40	100	**130**	160	mm/r	0,05–0,08	0,05–0,10	0,06–0,13	0,08–0,14	0,09–0,17	0,09–0,17
			I	DS	KCU40										
		I	O	MD	KC7140	60	**80**	100	mm/r	0,05–0,08	0,05–0,10	0,06–0,13	0,08–0,14	0,09–0,17	0,09–0,17
			I	MD	KC7140										
	2	S	O	DS	KCU40	150	**180**	210	mm/r	0,05–0,08	0,05–0,10	0,06–0,13	0,08–0,14	0,09–0,17	0,09–0,17
			I	DS	KCU40										
		U	O	MD	KCU40	100	**130**	160	mm/r	0,05–0,08	0,05–0,10	0,06–0,13	0,08–0,14	0,09–0,17	0,09–0,17
			I	MD	KC7140										
		I	O	MD	KC7140	60	**80**	100	mm/r	0,05–0,08	0,05–0,10	0,06–0,13	0,08–0,14	0,09–0,17	0,09–0,17
			I	MD	KC7140										
	3	S	O	DS	KCU40	100	**130**	160	mm/r	0,05–0,08	0,05–0,10	0,06–0,13	0,08–0,14	0,09–0,17	0,09–0,17
			I	DS	KCU40										
		U	O	HP	KCU40	80	**110**	140	mm/r	0,05–0,08	0,05–0,10	0,06–0,13	0,08–0,14	0,09–0,17	0,09–0,17
			I	HP	KC7140										
		I	O	MD	KC7140	50	**70**	90	mm/r	0,05–0,08	0,05–0,10	0,06–0,13	0,08–0,14	0,09–0,17	0,09–0,17
			I	MD	KC7140										

Condition: S = Stable cutting conditions;
U = Unstable cutting conditions;
I = Interrupted cutting conditions

Pocket seat: I = Inboard insert;
O = Outboard insert

Drill Fix™ DFT™ • Metric

Metric															
Material Group		Condition	Pocket Seat	Geometry	Grade	Cutting Speed — vc Range — m/min			Recommended Feed Rate (f) by Diameter						
						min	Starting Value	max	Ø	DFT03 16–24mm	DFT05 25–32mm	DFT06 32–40mm	DFT07 41–48mm	DFT09... 49–68mm	DFT11 69–82mm
K	1	S	O	HP	KCPK10	200	**240**	300	mm/r	0,08–0,13	0,10–0,18	0,14–0,26	0,18–0,33	0,21–0,39	0,21–0,39
			I	HP	KCU40										
		U	O	HP	KCU25	120	**155**	200	mm/r	0,08–0,13	0,10–0,18	0,14–0,26	0,18–0,33	0,21–0,39	0,21–0,39
			I	HP	KCU40										
		I	O	HP	KCU40	80	**100**	125	mm/r	0,08–0,13	0,10–0,18	0,14–0,26	0,18–0,33	0,21–0,39	0,21–0,39
			I	HP	KC7140										
	2	S	O	HP	KCPK10	180	**220**	260	mm/r	0,08–0,13	0,10–0,18	0,14–0,26	0,18–0,33	0,21–0,39	0,21–0,39
			I	HP	KCU40										
		U	O	HP	KCU25	110	**140**	170	mm/r	0,08–0,13	0,10–0,18	0,14–0,26	0,18–0,33	0,21–0,39	0,21–0,39
			I	HP	KC7140										
		I	O	HP	KCU40	80	**100**	120	mm/r	0,08–0,13	0,10–0,18	0,14–0,26	0,18–0,33	0,21–0,39	0,21–0,39
			I	HP	KC7140										
	3	S	O	HP	KCPK10	180	**220**	260	mm/r	0,08–0,13	0,10–0,18	0,14–0,26	0,18–0,33	0,21–0,39	0,21–0,39
			I	HP	KCU40										
		U	O	HP	KCU25	110	**140**	170	mm/r	0,08–0,13	0,10–0,18	0,14–0,26	0,18–0,33	0,21–0,39	0,21–0,39
			I	HP	KC7140										
		I	O	HP	KCU40	80	**100**	120	mm/r	0,08–0,13	0,10–0,18	0,14–0,26	0,18–0,33	0,21–0,39	0,21–0,39
			I	HP	KC7140										
N	1	S	O	ST	KD1425	400	**600**	800	mm/r	0,05–0,07	0,07–0,09	0,10–0,14	0,12–0,16	0,14–0,18	0,14–0,18
			I	ST	KD1425										
		U	O	HP	KCU40	300	**400**	500	mm/r	0,05–0,07	0,07–0,09	0,10–0,14	0,12–0,16	0,14–0,18	0,14–0,18
			I	HP	KCU40										
		I	O	HP	KMF	200	**300**	400	mm/r	0,05–0,07	0,07–0,09	0,10–0,14	0,12–0,16	0,14–0,18	0,14–0,18
			I	HP	KMF										
	2	S	O	ST	KD1425	375	**550**	775	mm/r	0,05–0,07	0,07–0,09	0,10–0,14	0,12–0,16	0,14–0,18	0,14–0,18
			I	ST	KD1425										
		U	O	HP	KCU40	250	**350**	450	mm/r	0,05–0,07	0,07–0,09	0,10–0,14	0,12–0,16	0,14–0,18	0,14–0,18
			I	HP	KCU40										
		I	O	HP	KMF	175	**250**	325	mm/r	0,05–0,07	0,07–0,09	0,10–0,14	0,12–0,16	0,14–0,18	0,14–0,18
			I	HP	KMF										
	3	S	O	ST	KD1425	350	**500**	650	mm/r	0,05–0,07	0,07–0,09	0,10–0,14	0,12–0,16	0,14–0,18	0,14–0,18
			I	ST	KD1425										
		U	O	HP	KCU40	250	**350**	450	mm/r	0,05–0,07	0,07–0,09	0,10–0,14	0,12–0,16	0,14–0,18	0,14–0,18
			I	HP	KCU40										
		I	O	HP	KMF	150	**250**	350	mm/r	0,05–0,07	0,07–0,09	0,10–0,14	0,12–0,16	0,14–0,18	0,14–0,18
			I	HP	KMF										
	4	S	O	ST	KD1425	400	**600**	800	mm/r	0,05–0,07	0,07–0,09	0,10–0,14	0,12–0,16	0,14–0,18	0,14–0,18
			I	ST	KD1425										
		U	O	HP	KCU40	250	**350**	450	mm/r	0,05–0,07	0,07–0,09	0,10–0,14	0,12–0,16	0,14–0,18	0,14–0,18
			I	HP	KCU40										
		I	O	HP	KMF	200	**300**	400	mm/r	0,05–0,07	0,07–0,09	0,10–0,14	0,12–0,16	0,14–0,18	0,14–0,18
			I	HP	KMF										
	5	S	O	ST	KD1425	400	**600**	800	mm/r	0,05–0,07	0,07–0,09	0,10–0,14	0,12–0,16	0,14–0,18	0,14–0,18
			I	ST	KD1425										
		U	O	HP	KCU40	250	**350**	450	mm/r	0,05–0,07	0,07–0,09	0,10–0,14	0,12–0,16	0,14–0,18	0,14–0,18
			I	HP	KCU40										
		I	O	HP	KMF	200	**300**	400	mm/r	0,05–0,07	0,07–0,09	0,10–0,14	0,12–0,16	0,14–0,18	0,14–0,18
			I	HP	KMF										
	6	S	O	ST	KD1425	400	**600**	800	mm/r	0,05–0,07	0,07–0,09	0,10–0,14	0,12–0,16	0,14–0,18	0,14–0,18
			I	ST	KD1425										
		U	O	HP	KCU40	250	**350**	450	mm/r	0,05–0,07	0,07–0,09	0,10–0,14	0,12–0,16	0,14–0,18	0,14–0,18
			I	HP	KCU40										
		I	O	HP	KMF	200	**300**	400	mm/r	0,05–0,07	0,07–0,09	0,10–0,14	0,12–0,16	0,14–0,18	0,14–0,18
			I	HP	KMF										

Condition: S = Stable cutting conditions;
U = Unstable cutting conditions;
I = Interrupted cutting conditions

Pocket seat: I = Inboard insert;
O = Outboard insert

Drill Fix™ DFT™ • Metric

Metric														
Material Group		Condition	Pocket Seat	Geometry	Grade	Cutting Speed — vc Range — m/min			Recommended Feed Rate (f) by Diameter					
						min	Starting Value	max	Ø	DFT03 16–24mm	DFT05 25–32mm	DFT06 32–40mm	DFT07 41–48mm	DFT09... 49–68mm	DFT11 69–82mm
S	1	S	O	HP	KCU40	60	**70**	75	mm/r	0,03–0,05	0,04–0,06	0,05–0,08	0,06–0,1	0,08–0,13	0,08–0,13
			I	HP	KCU40										
		U	O	HP	KCU40	40	**50**	60	mm/r	0,03–0,05	0,04–0,06	0,05–0,08	0,06–0,1	0,08–0,13	0,08–0,13
			I	HP	KC7140										
		I	O	MD	KC7140	25	**30**	40	mm/r	0,03–0,05	0,04–0,06	0,05–0,08	0,06–0,1	0,08–0,13	0,08–0,13
			I	MD	KC7140										
	2	S	O	HP	KCU40	50	**60**	70	mm/r	0,05–0,07	0,05–0,07	0,05–0,08	0,06–0,1	0,07–0,12	0,07–0,12
			I	HP	KCU40										
		U	O	HP	KCU40	30	**40**	50	mm/r	0,04–0,06	0,05–0,08	0,06–0,10	0,06–0,1	0,09–0,15	0,09–0,15
			I	HP	KC7140										
		I	O	MD	KC7140	25	**30**	40	mm/r	0,05–0,07	0,05–0,07	0,05–0,08	0,06–0,1	0,07–0,12	0,07–0,12
			I	MD	KC7140										
	3	S	O	HP	KCU40	70	**80**	90	mm/r	0,03–0,05	0,04–0,06	0,05–0,08	0,06–0,1	0,08–0,13	0,08–0,13
			I	HP	KCU40										
		U	O	HP	KCU40	50	**60**	70	mm/r	0,03–0,05	0,04–0,06	0,05–0,08	0,06–0,1	0,08–0,13	0,08–0,13
			I	HP	KCU40										
		I	O	MD	KC7140	30	**40**	50	mm/r	0,03–0,05	0,04–0,06	0,05–0,08	0,06–0,1	0,08–0,13	0,08–0,13
			I	MD	KC7140										
	4	S	O	HP	KCU40	70	**80**	90	mm/r	0,05–0,07	0,05–0,07	0,05–0,08	0,06–0,1	0,07–0,12	0,07–0,12
			I	HP	KCU40										
		U	O	HP	KCU40	50	**60**	70	mm/r	0,04–0,06	0,05–0,08	0,06–0,10	0,06–0,1	0,09–0,15	0,09–0,15
			I	HP	KCU40										
		I	O	MD	KC7140	30	**40**	50	mm/r	0,05–0,07	0,05–0,07	0,05–0,08	0,06–0,1	0,07–0,12	0,07–0,12
			I	MD	KC7140										

Condition: S = Stable cutting conditions;
U = Unstable cutting conditions;
I = Interrupted cutting conditions

Pocket seat: I = Inboard insert;
O = Outboard insert

The Most Cost-Effective
Way to Drill a Hole...

Indexable Drilling with Drill Fix™ DFSP™





COST-EFFECTIVE INSERTS

Versatile squared outboard inserts have four economic cutting edges to achieve high metal removal rates and excellent chip evacuation.

ONE COMPREHENSIVE PLATFORM

Standard diameter range covering 14–55mm (.551–2.125") in 2 x D, 3 x D, 4 x D, and 5 x D.

WIDE RANGE OF MATERIALS

P M K N S

APPLICATION CAPABILITIES

Drilling into Solid	Drilling: Inclined Entry	Drilling: Inclined Exit	Drilling: X-Offset	Drilling: Convex
Drilling: Blind	Chain Drilling	Drilling: Cross Hole	Drilling: Half Cylinder	Drilling: Corner Drilling 45°

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HTS Series Indexable Deep-Hole Drilling System

Primary Application

HTS series indexable drills are designed for deep-hole drilling up to 10 x D in steel, stainless steel, ductile iron, cast iron, and non-ferrous materials. The two HTS systems — HTS and HTS-R — cover a diameter range of 40–270mm (1.575–10.629").



Features and Benefits

HTS Indexable Drill System

- Large diameter range from 45–270mm (1.750–10.629") with standard drill heads.
- Drill Fix™ DFT™ trigon inserts as outboard and inboard insert offer the best centring capabilities; square-outboard insert cartridges offer increased surface and hole quality.
- Various insert geometries and grades available as standard.
- Adjust drilling depth and diameter range with suitable extensions and reducers.
- Diameter adjustment by shortening outer cartridge.
- Customised drilling heads up to 540mm (21.259").



HTS-R Indexable Drill System

- Modular system uses drill heads equipped with DFR™ insert cartridges.
- Five drill heads cover the diameter range 40–55mm (1.575–2.165").
- Drill Fix™ DFR rectangular inboard and outboard inserts offer the highest feed rates at small diameters.
- Various insert geometries and grades available as standard.
- Adjust drilling depth and diameters by using extensions and reducers.
- Diameter adjustment by shortening outer cartridge.

HTS Indexable Drill System

The HTS indexable drill system is one of the most reliable deep-hole drilling systems available. Drilling up to 10 x D can be easily achieved in materials like steel, stainless steel, ductile iron, cast iron, and non-ferrous materials. Various drilling heads cover the diameter range 45–270mm (1.77–10.63").

HTS drill heads are equipped with pilot drills and cartridges using trigon-shaped Drill Fix™ DFT™ inserts. Use HTS extensions and reducers to achieve various diameters and depths of drilling.

For improved surface qualities and increased reliability, finishing HTS cartridges with a squared-outboard insert are available as standard.

Features and Benefits

Productivity

- Achieve high hole accuracy by using pilot drills and trigon-shaped inserts.
- Benefit from improved surface qualities using finishing cartridges with squared-outboard inserts.
- Adjust outer cartridge to desired cutting diameter, reducing inventory.
- Same insert size is used in each insert cartridge, reducing inventory costs.

Versatility

- Diameter range covering 45–270mm (1.77–10.63").
- L/D ratio up to 10 x D as standard.
- Inserts and pilot drills can be used with various heads and cartridges, covering various diameters.
- Large variety of DFT insert grades and geometries available.
- Finishing cartridge with squared-outboard insert offering four cutting edges for high process stability.
- Carbide pilot drills are available upon request.

Use HTS extensions and reducers to achieve various diameters and depths of drilling.

Customisation

- Wear pads can be added for increased stability.
- Fully engineered solutions available.
- Custom solutions covering diameter range up to 540mm (21.259") are possible.



HTS-R Indexable Drill System

HTS-R extends the HTS system by covering diameters between 40–55mm (1.575–2.165").

Up to 30% higher feed rates achievable with rectangular-shaped Drill Fix™ DFR™ inserts with the added benefit of improved chip control.

Features and Benefits

Productivity

- Benefit from better chip control and higher insert stability for longer tool body life.
- Same insert size is used in each insert cartridge.

Versatility

- Diameter range covering 40–55mm (1.575–2.165") with five drilling heads.
- Large variety of DFR insert grades and geometries available.
- Outer cartridges can be adjusted to the desired cutting diameter.
- Extensions and reducers are available as standard.
- Solid carbide and HSS pilot drills are available to match the cutting conditions of specific applications.

Benefit from better chip control and higher insert stability for longer tool body life.



Pilot drill should be installed and set to the proper length before installing the inner cartridge.



Install inner cartridge, then the outer insert.



Install inner insert into cartridge.

Customisation

- Wear pads can be added for increased stability.
- Fully engineered solutions available.



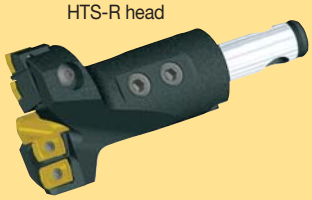
HTS-R


inner cartridge


pilot drill


outer cartridge

HTS-R head



HTS Ø 45–102mm


inner cartridge*

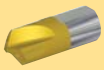

pilot drill


outer cartridge*

* for Ø 180–186mm:
2 inner and outer
cartridges are used

HTS Ø 102–170mm


inner cartridge


pilot drill


outer cartridge

HTS Ø 195–270mm


inner cartridge


pilot drill


outer cartridge

HTS with SPHX outboard insert


inner cartridge

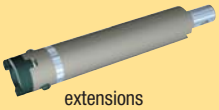

pilot drill

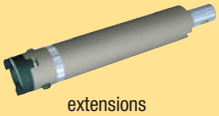

outer cartridge**

** for Ø 102–170mm & Ø 195–240mm:
the outer cartridge uses 3 inserts

HTS head




extensions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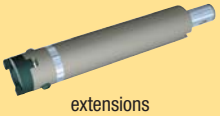
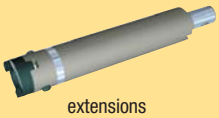

extensions


extensions


reducer


reducer

WARNING
- **DO NOT exceed 2 extensions or 1 extension plus reducer.**


DV


BT


CV with rotary ring


CV


HSK


KM™


HTS coolant coupling

HTS-R



inner cartridge



pilot drill



outer cartridge

HTS-R head



HTS Ø 45–102mm



inner cartridge*



pilot drill



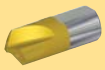
outer cartridge*

* for Ø 180–186mm:
2 inner and outer
cartridges are used

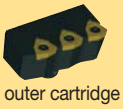
HTS Ø 102–170mm



inner cartridge



pilot drill



outer cartridge

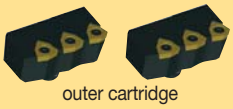
HTS Ø 195–270mm



inner cartridge



pilot drill

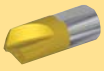


outer cartridge

HTS with SPHX outboard insert



inner cartridge



pilot drill

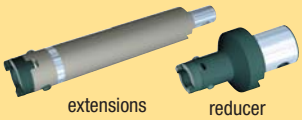


outer cartridge**

** for Ø 102–170mm & Ø 195–240mm:
the outer cartridge uses 3 inserts

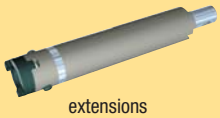
HTS head





extensions

reducer



extensions



reducer



basic shanks



DV



BT



BT with coolant ring



CV

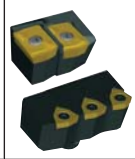
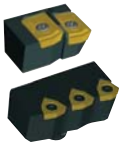


CV with coolant ring

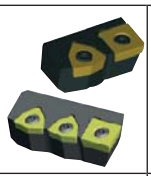
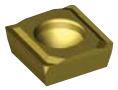


HSK

To assemble your HTS(-R) head, choose the desired drill diameter range from the left-hand column.
Next, follow the columns to the right, and select the appropriate component from each column to complete your HTS(-R) head.

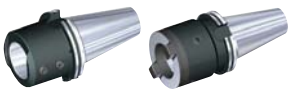
						HTS(-R) head with DFR™/DFT™ inserts								
						inner cartridge				outer cartridge				
	drilling range			L1										
	mm	in	HTS head	mm	in	cartridge	n	insert	n	cartridge	n	insert	n	pilot drill
HTS heads with DFR inserts	40–43	1.57–1.69	HTSR040R025M	60	2.36	HTSR10CI	1	DFR0302.	2	HTSR10CE	1	DFR0302.	2	B513S08.
	43–46	1.69–1.81	HTSR043R025M	70	2.76	HTSR11CI	1	DFR0302.	2	HTSR11CE	1	DFR0302.	2	B513S10.
	46–49	1.81–1.93	HTSR046R028M			HTSR12CI	1	DFR0403.	2	HTSR12CE	1	DFR0403.	2	B513S10.
	49–52	1.93–2.05	HTSR049R028M			HTSR13CI	1	DFR0403.	2	HTSR13CE	1	DFR0403..	2	B513S10.
	52–55	2.05–2.17	HTSR052R028M			HTSR14CI	1	DFR0403.	2	HTSR14CE	1	DFR0403..	2	B513S10.
HTS heads with DFT/SPHX inserts	45–50	1.77–1.97	3.76045R028V	50	1.97	3.77000R050V	1	DFT0303.	2	3.77000R051V	1	DFT0303.	2	B510S08.
	50–55	1.97–2.17	3.76050R028V			3.77000R052V	1	DFT0303.	2	3.77000R053V	1	DFT0303.	2	B510S08.
	55–58	2.17–2.28	3.76055R032V	60	2.36	3.77000R038V	1	DFT05T3.	2	3.77000R039V	1	DFT05T3.	2	B510S08.
	58–63	2.28–2.48	3.76058R032V			3.77000R023V	1	DFT05T3.	2	3.77000R024V	1	DFT05T3.	2	B510S10.
	63–68	2.48–2.68	3.76063R032V			3.77000R025V	1	DFT05T3.	2	3.77000R024V	1	DFT05T3.	2	B510S10.
	63–68	2.48–2.68	**3.76063R040V***	70	2.76	3.77000R025V	1	DFT05T3.	2	3.77000R024V	1	DFT05T3.	2	B510S10.
	68–73	2.68–2.87	3.76068R040V			3.77000R026V	1	DFT05T3.	2	3.77000R027V	1	DFT05T3.	2	B510S10.
	73–78	2.87–3.07	3.76073R040V			3.77000R026V	1	DFT05T3.	2	3.77000R027V	1	DFT05T3.	2	B510S15.
	78–84	3.07–3.31	3.76078R040V			3.77000R028V	1	DFT06T3.	2	3.77000R029V	1	DFT06T3.	2	B510S15.
	78–84	3.07–3.31	**3.76078R048V***	70	2.76	3.77000R028V	1	DFT06T3.	2	3.77000R029V	1	DFT06T3.	2	B510S15.
	84–90	3.31–3.54	3.76084R048V			3.77000R028V	1	DFT06T3.	2	3.77000R029V	1	DFT06T3.	2	B510S15.
	90–94°	3.54–3.70	3.76090R048V			–	–	–	–	–	–	–	–	–
	90–96	3.54–3.78	3.76090R048V			3.77000R030V	1	DFT06T3.	2	3.77000R031V	1	DFT06T3.	2	B510S15.
	96–100°	3.78–3.93	3.76096R048V			–	–	–	–	–	–	–	–	–
	96–102	3.78–4.02	3.76096R048V			3.77000R030V	1	DFT06T3.	2	3.77000R031V	1	DFT06T3.	2	B510S20.
	96–100°	3.78–3.93	**3.76096R058V***	80	3.15	–	–	–	–	–	–	–	–	–
	96–102	3.78–4.02	**3.76096R058V***			3.77000R030V	1	DFT06T3.	2	3.77000R031V	1	DFT06T3.	2	B510S20.
	102–108	4.02–4.25	3.76102R058V			3.77000R081V	1	DFT05T3.	3	3.77000R082V	1	DFT05T3.	3	B510S20.
	108–115	4.25–4.53	3.76108R058V			3.77000R083V	1	DFT06T3.	3	3.77000R084V	1	DFT06T3.	3	B510S20.
	115–122	4.53–4.80	3.76115R070V	90	3.54	3.77000R085V	1	DFT06T3.	3	3.77000R086V	1	DFT06T3.	3	B510S25.
	122–130	4.80–5.12	3.76122R070V			3.77000R079V	1	DFT06T3.	3	3.77000R080V	1	DFT06T3.	3	B510S25.
	130–140	5.12–5.51	3.76130R070V			3.77000R087V	1	DFT06T3.	3	3.77000R088V	1	DFT06T3.	3	B510S25.
	140–150	5.51–5.91	3.76140R080V	100	3.94	3.77000R077V	1	DFT0704.	3	3.77000R078V	1	DFT0704.	3	B510S25.
	150–158	5.91–6.22	3.76150R080V			3.77000R075V	1	DFT0704.	3	3.77000R076V	1	DFT0704.	3	B510S25.
	158–162	6.22–6.38	3.76158R080V			3.77000R073V	1	DFT0704.	3	3.77000R074V	1	DFT0704.	3	B510S25.
	162–170	6.38–6.70	3.76162R080V			3.77000R048V	1	DFT0704.	3	3.77000R049V	1	DFT0704.	3	B510S30.
	180–184°	7.08–7.24	3.76180R110	125	4.92	–	–	–	–	–	–	–	–	–
	180–186	7.08–7.32	3.76180R110			3.77000R030V	3	DFT06T3.	4	3.77000R031V	1	DFT06T3.	4	B510S30.
	195–201	7.68–7.91	3.76195R110			3.77000R081V	3	DFT05T3.	6	3.77000R082V	1	DFT05T3	6	B510S30.
	213–220	8.39–8.66	3.76213R125			3.77000R083V	3	DFT06T3.	6	3.77000R084V	1	DFT06T3.	6	B510S30.
	230–240	9.06–9.45	3.76230R160	150	5.91	3.77000R079V	2	DFT06T3.	6	3.77000R080V	2	DFT06T3.	6	B510S30.
	260–270	10.24–10.63	3.76260R160			3.77000R077V	2	DFT06T3.	6	3.77000R078V	2	DFT06T3.	6	B510S30.

° Decreased diameter range by using SPHX insert in exterior cartridge.
* Drill heads with reinforced body for short-chipping materials.
n = Required quantity.

	HTS head with DFT™ inserts and SPHX outboard insert												
	inner cartridge						outer cartridge						
													
	cartridge	n	cartridge	n	insert	n	cartridge	n	insert	n	insert	n	pilot drill
	–	–	–	–	–	–	–	–	–	–	–	–	–
	–	–	–	–	–	–	–	–	–	–	–	–	–
	–	–	–	–	–	–	–	–	–	–	–	–	–
	–	–	–	–	–	–	–	–	–	–	–	–	–
	–	–	–	–	–	–	–	–	–	–	–	–	–
	3.77000R250V	1	–	–	DFT0303.	2	3.77000R251V	1	DFT0303.	1	SPHX0703.	1	B510S08.
	3.77000R252V	1	–	–	DFT0303.	2	3.77000R253V	1	DFT0303.	1	SPHX0703.	1	B510S08.
	3.77000R038V	1	–	–	DFT05T3.	2	3.77000R239V	1	DFT05T3.	1	SPHX0903.	1	B510S08.
	3.77000R023V	1	–	–	DFT05T3.	2	3.77000R224V	1	DFT05T3.	1	SPHX0903.	1	B510S10.
	3.77000R025V	1	–	–	DFT05T3.	2	3.77000R224V	1	DFT05T3.	1	SPHX0903.	1	B510S10.
	3.77000R025V	1	–	–	DFT05T3.	2	3.77000R224V	1	DFT05T3.	1	SPHX0903.	1	B510S10.
	3.77000R026V	1	–	–	DFT05T3.	2	3.77000R227V	1	DFT05T3.	1	SPHX0903.	1	B510S10.
	3.77000R026V	1	–	–	DFT05T3.	2	3.77000R227V	1	DFT05T3.	1	SPHX0903.	1	B510S15.
	3.77000R028V	1	–	–	DFT06T3.	2	3.77000R229V	1	DFT06T3.	1	SPHX0903.	1	B510S15.
	3.77000R028V	1	–	–	DFT06T3.	2	3.77000R229V	1	DFT06T3.	1	SPHX0903.	1	B510S15.
	3.77000R228V	1	–	–	DFT06T3.	2	3.77000R229V	1	DFT06T3.	1	SPHX0903.	1	B510S15.
	3.77000R230V	1	–	–	DFT06T3.	2	3.77000R231V	1	DFT06T3.	1	SPHX0903.	1	B510S15.
	–	–	–	–	–	–	–	–	–	–	–	–	–
	3.77000R230V	1	–	–	DFT06T3.	2	3.77000R231V	1	DFT06T3.	1	SPHX0903.	1	B510S20.
	–	–	–	–	–	–	–	–	–	–	–	–	–
	3.77000R230V	1	–	–	DFT06T3.	2	3.77000R231V	1	DFT06T3.	1	SPHX0903.	1	B510S20.
	–	–	–	–	–	–	–	–	–	–	–	–	–
	3.77000R081V	1	–	–	DFT05T3.	3	3.77000R282V	1	DFT05T3.	2	SPHX0903.	1	B510S20.
	3.77000R083V	1	–	–	DFT06T3.	3	3.77000R284V	1	DFT06T3.	2	SPHX1204.	1	B510S20.
	3.77000R085V	1	–	–	DFT06T3.	3	3.77000R286V	1	DFT06T3.	2	SPHX1204.	1	B510S25.
	3.77000R079V	1	–	–	DFT06T3.	3	3.77000R280V	1	DFT06T3.	2	SPHX1204.	1	B510S25.
	3.77000R087V	1	–	–	DFT06T3.	3	3.77000R288V	1	DFT06T3.	2	SPHX1204.	1	B510S25.
	3.77000R077V	1	–	–	DFT0704.	3	3.77000R278V	1	DFT0704.	2	SPHX1505.	1	B510S25.
	3.77000R075V	1	–	–	DFT0704.	3	3.77000R276V	1	DFT0704.	2	SPHX1204.	1	B510S25.
	3.77000R073V	1	–	–	DFT0704.	3	3.77000R274V	1	DFT0704.	2	SPHX1204.	1	B510S25.
	3.77000R248V	1	–	–	DFT0704.	3	3.77000R249V	1	DFT0704.	2	SPHX1505.	1	B510S30.
	3.77000R230V	3	–	–	DFT06T3.	4	3.77000R231V	1	DFT06T3.	3	SPHX0903.	1	B510S30.
	–	–	–	–	–	–	–	–	–	–	–	–	–
	3.77000R081V	3	–	–	DFT05T3.	9	3.77000R282V	1	DFT05T3.	2	SPHX0903.	1	B510S30.
	3.77000R083V	3	–	–	DFT06T3.	9	3.77000R284V	1	DFT06T3.	2	SPHX1204.	1	B510S30.
	3.77000R079V	2	3.77000R080V	1	DFT06T3.	9	3.77000R280V	1	DFT06T3.	2	SPHX1204.	1	B510S30.
	–	–	–	–	–	–	–	–	–	–	–	–	B510S30

HTS Tool Assembly Combinations

- Select your appropriate drill diameter range.
- Choose the appropriate adaptor and shank size.
- Follow the columns to the right, and select the appropriate components from each column to complete your HTS(-R) tool.

	drilling range		shank		DV		BT		CV		HSK	
												
					assembly details		assembly details		assembly details		assembly details	
	mm	in		D1	40	50	40	50	40	50	50/63/100	
HTS heads with DFR™ inserts	40–43 43–46	1.57–1.69 1.69–1.81	WD/ WN	32	DV40BWD32075M **DV40RMWD32115M****	DV50BWD32060M **DV50RMWD32140M****	BT40BWD32070M	BT50BWD32080M	CV40BWD32M343 **CV40RMWD32M453****	CV50BWD32M343 **CV50RMWD32M453****	HSK50ASWN32110M HSK63ASWN32090M HSK100ASWN32100M	
				50	–	DV50BWD50075M **DV50RMWD50144M****	–	BT50BWD50085M **BT50RMWD50162M****	–	CV50BWD50M343 **CV50RMWD50M472****	–	
			SS(F)	1.50	–	–	–	–	CV40BSSF150575	CV50SS150400 (AD) CV50SS150600 (AD) CV50SS150800 (AD) CV50BSSF150450	–	
	46–49 49–52 52–55	1.81–1.93 1.93–2.05 2.05–2.17	WD/ WN	32	DV40BWD32075M **DV40RMWD32115M****	DV50BWD32060M **DV50RMWD32140M****	–	BT50BWD32080M	CV40BWD32M343 **CV40RMWD32M453****	CV50BWD32M343 **CV50RMWD32M453****	–	
				50	–	DV50BWD50075M **DV50RMWD50144M****	–	BT50BWD50085M **BT50RMWD50162M****	–	CV50BWD50M343 **CV50RMWD50M472****	–	
			SS(F)	2.00	–	–	–	–	–	CV50SS200562 (AD) CV50SS200762 (AD) CV50BSSF200550	–	
			HTS	50	–	5.36050–154050	–	BT50BHTS50080M	–	CV50BHTS50M314 **CV50RMHTS50M413****	–	
HTS heads with DFT™/SPHX inserts	45–50 50–55	1.77–1.97 1.97–2.17	WD/ WN	32	DV40BWD32075M **DV40RMWD32115M****	DV50BWD32060M **DV50RMWD32140M****	BT40BWD32070M	BT50BWD32080M	CV40BWD32M343 **CV40RMWD32M453****	CV50BWD32M343 **CV50RMWD32M453****	HSK50ASWN32110M HSK63ASWN32090M HSK100ASWN32100M	
				50	–	DV50BWD50075M **DV50RMWD50144M****	–	BT50BWD50085M **BT50RMWD50162M****	–	CV50BWD50M343 **CV50RMWD50M472****	HSK100ASWN50110M	
			SS(F)	2.00	–	–	–	–	–	CV50SS200562 (AD) CV50SS200762 (AD) CV50BSSF200550	–	
			HTS	50	–	5.36050–154050	–	BT50BHTS50080M	–	CV50BHTS50M314 **CV50RMHTS50M413****	–	
	55–58 58–63 63–68	2.17–2.28 2.28–2.48 2.48–2.68	WD/ WN	32	DV40BWD32075M **DV40RMWD32115M****	DV50BWD32060M **DV50RMWD32140M****	BT40BWD32070	BT50BWD32080M	CV40BWD32M343 **CV40RMWD32M453****	CV50BWD32M343 **CV50RMWD32M453****	HSK50ASWN32110M HSK63ASWN32090M HSK100ASWN32100M	
				50	–	DV50BWD50075M **DV50RMWD50144M****	–	BT50BWD50085M **BT50RMWD50162M****	–	CV50BWD50M343 **CV50RMWD50M472****	HSK100ASWN50110M	
			SS(F)	2.00	–	–	–	–	–	CV50SS200562 (AD) CV50SS200762 (AD) CV50BSSF200550	–	
			HTS	50	–	5.36050–154050	–	BT50BHTS50080M	–	CV50BHTS50M314 **CV50RMHTS50M413****	–	
	63–68* 68–73 73–78 78–84	2.48–2.68 2.68–2.87 2.87–3.07 3.07–3.31	WD/ WN	50	–	DV50BWD50075M **DV50RMWD50144M****	–	BT50BWD50085M **BT50RMWD50162M****	–	CV50BWD50M343 **CV50RMWD50M472****	HSK100ASWN50110M	
			SS(F)	2.00	–	–	–	–	–	V50SS200562 (AD) CV50SS200762 (AD) CV50BSSF200550	–	
			HTS	50	–	5.36050–154050	–	BT50BHTS50080M	–	CV50BHTS50M314 **CV50RMHTS50M413****	–	

* HTS drilling head with reinforced body for short-chipping materials.
** Adaptor with coolant ring.
The shown combinations are not complete. Ask your Kennametal representative to get the most reasonable solution for your application.
Please note that the assembled total length of the drilling tool is not necessarily the total achievable drilling depth.

	KM™	basic shank				reducer					extension			HTS head
														
	assembly details		L4		L4		L1		for use with coolant adaptor			L1		
	80	metric	mm	inch	in		mm	in	coolant adaptor	shell mill DV/BT		mm	in	
	–	5.34032–025115 5.34032–025200	110 195	–	–	–	–	–	–	–	5.34125R025150	160	6.30	HTSR040R025M HTSR043R025M
	–	5.34050–025300 5.34050–025450	270 420	–	–	–	–	–	–	–				
	–	–	–	SSF150HTS130239 SSF150HTS130664 SSF150HTS131114 SSF150HTS131764	.39 4.65 9.14 15.64	–	–	–	–	–				
	–	5.34032–028115 5.34032–028200	110 195	–	–	–	–	–	–	–	5.34128R028150	160	6.30	HTSR046R028M HTSR049R028M HTSR052R028M
	–	5.34050-028300 5.34050-028450	265 415	–	–	–	–	–	–	–				
	–	–	–	SSF200HTS130239 SSF200HTS130664 SSF200HTS131114 SSF200HTS131764	.39 4.65 9.14 15.64	–	–	–	–	–				
	KM80ATCHTS50085M KM80ATCHTS50100M	–	–	–	–	5.34280R028080	90	3.54	5.34350–090100	DV50SM60070M BT50SM60090M				
	–	5.34032–025115 5.34032–025200	110 195	–	–	–	–	–	–	–	5.34128R028150	160	6.30	3.76045R028V 3.76050R028V
	–	5.34050–028300 5.34050–028450	265 415	–	–	–	–	–	–	–				
	–	–	–	SSF200HTS130239 SSF200HTS130664 SSF200HTS131114 SSF200HTS131764	.39 4.65 9.14 15.64	–	–	–	–	–				
	KM80ATCHTS50085M KM80ATCHTS50100M	–	–	–	–	5.34280R028080	90	3.54	5.34350–090100	DV50SM60070M BT50SM60090M				
	–	5.34032–032125	120	–	–	–	–	–	–	–	5.34132R032100 5.34132R032200	110 210	4.33 8.27	3.76055R032V 3.76058R032V 3.76063R032V
	–	5.34050-032500 5.34050-032350 5.34050-032350	165 315 465	–	–	–	–	–	–	–				
	–	–	–	SSF200HTS160239 SSF200HTS160714 SSF200HTS161214 SSF200HTS161964	.39 5.14 10.14 17.64	–	–	–	–	–				
	KM80ATCHTS50085M KM80ATCHTS50100M	–	–	–	–	5.34280R032080	90	3.5	5.34350–090100	DV50SM60070M BT50SM60090M				
	–	5.34050–040148 5.34050–040300 5.34050–040450 5.34050–040600	140 267 417 567	–	–	–	–	–	–	–	5.34140R040200	212	8.35	3.76063R040V* 3.76068R040V 3.76073R040V 3.76078R040V
	–	–	–	SSF200HTS220297 SSF200HTS220922 SSF200HTS221572 SSF200HTS222572	.47 7.22 13.72 23.72	–	–	–	–	–				
	KM80ATCHTS50085M KM80ATCHTS50100M	–	–	–	–	5.34280R040080	90	3.62	5.34350–090100	DV50SM60070M BT50SM60090M				

(continued)

(HTS Tool Assembly Combinations — continued)

HTS Tool Assembly Combinations

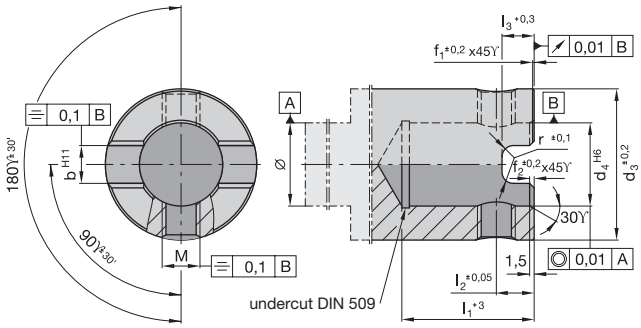
- Select your appropriate drill diameter range.
- Choose the appropriate adaptor and shank size.
- Follow the columns to the right, and select the appropriate components from each column to complete your HTS(-R) tool.

	drilling range		shank		DV assembly details		BT assembly details		CV assembly details		HSK assembly details	
	mm	in		D1	40	50	40	50	40	50	50/63/100	
HTS heads with DFT™/SPHX inserts	**78–84*** 84–90 90–96 96–102	3.07–3.31 3.31–3.54 3.54–3.70 3.78–4.02	WD/ WN	50	–	DV50BWD50075M **DV50RMWD50144M****	–	BT50BWD50085M **BT50RMWD50162M****	–	CV50BWD50M343 **CV50RMWD50M472****	HSK100ASWN50110M	
			SS(F)	2.00	–	–	–	–	–	CV50SS200562 (AD) CV50SS200762 (AD) CV50BSSF200550	–	
			HTS	50	–	5.36050–154050	–	BT50BHTS50080M	–	CV50BHTS50M314 **CV50RMHTS50M413****	–	
	96–102* 102–108 108–115	3.78–4.02 4.02–4.25 4.25–4.53	WD/ WN	50	–	DV50BWD50075M **DV50RMWD50144M****	–	BT50BWD50085M **BT50RMWD50162M****	–	CV50BWD50M343 **CV50RMWD50M472****	HSK100ASWN50110M	
			SS(F)	2.00	–	–	–	–	–	CV50SS200562 (AD) CV50SS200762 (AD) CV50BSSF200550	–	
			HTS	50	–	5.36050–154050	–	BT50BHTS50080M	–	CV50BHTS50M314 **CV50RMHTS50M413****	–	
	115–122 122–130 130–140	4.53–4.80 4.80–5.12 5.12–5.51	SS(F)	40	–	–	–	–	–	CV50SS250800	–	
			HTS	40	5.36050154040	–	BT50BHTS40080M	–	CV50BHTS40M314 **CV50RMHTS40M412****	–	HSK100AHTS40085M	
				50	–	5.36050–154050	–	BT50BHTS50080M	–	CV50BHTS50M314 **CV50RMHTS50M413****	HSK100AHTS50090M	
	140–150 150–158 158–162 162–170	5.51–5.91 5.91–6.22 6.22–6.38 6.38–6.70	HTS	50	–	5.36050–154050	–	BT50BHTS50080M	–	CV50BHTS50M314 **CV50RMHTS50M413****	HSK100AHTS50090M	
	180–186 195–201 213–220	7.08–7.32 7.68–7.91 8.39–8.66	customised solutions available upon request									
	230–240 260–270	9.06–9.45 10.24–10.63	customised solutions available upon request									

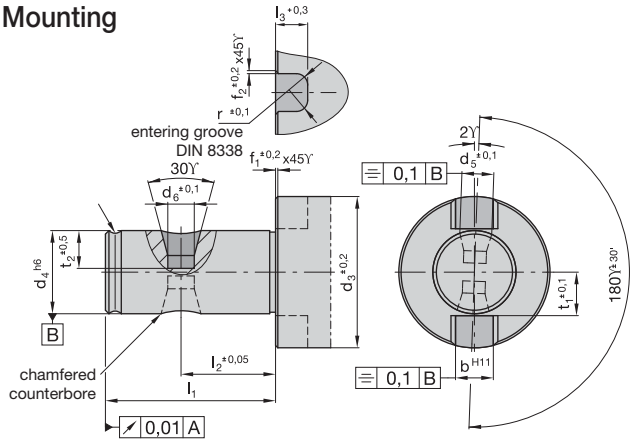
* HTS drilling head with reinforced body for short-chipping materials.
** Adaptor with coolant ring.
The shown combinations are not complete. Ask your Kennametal representative to get the most reasonable solution for your application.
Please note that the assembled total length of the drilling tool is not necessarily the total achievable drilling depth.

	KM™	basic shank				reducer					extension			HTS head
														
	assembly details		L4		L4		L1		for use with coolant adaptor			L1		
	80	metric	mm	inch	in		mm	in	coolant adaptor	shell mill DV/BT		mm	in	
	–	5.34050–048168 5.34050–048300 5.34050–048450 5.34050–048600	160 267 417 567	–	–	–	–	–	–	–	5.34140R048200	212	8.35	**3.76078R048V*** 3.76084R048V 3.76090R048V 3.76096R048V
	–	–	–	SSF200HTS270297 SSF200HTS271122 SSF200HTS271922 SSF200HTS273122	1.47 9.22 17.22 29.22	–	–	–	–	–				
	KM80ATCHTS50085M KM80ATCHTS50100M	–	–	–	–	5.34280R048080	92	3.62	5.34350–090100	DV50SM60070M BT50SM60090M				
	–	5.34050–058186 5.34050–058300 5.34050–058450 5.34050–058600	180 254 404 554	–	–	–	–	–	–	–	5.34158R058300	314	12.36	**3.76096R058V*** 3.76102R058V 3.76108R058V
	–	–	–	SSF200HTS160239 SSF200HTS160714 SSF200HTS161214 SSF200HTS161964	.39 5.14 10.14 17.64	–	–	–	–	–				
	KM80ATCHTS50085M KM80ATCHTS50100M	–	–	–	–	5.34280R058080	94	3.70	5.34350–090100	DV50SM60070M BT50SM60090M				
	–	–	–	SSF250HTS400355 SSF250HTS401055 SSF250HTS401555 SSF250HTS402555	1.63 8.21 13.21 23.21	–	–	–	–	–	–	–	–	3.76115R070V 3.76122R070V 3.76130R070V
	KM80ATCHTS40085M KM80ATCHTS40100M	–	–	–	–	5.34280R070150	164	6.45	5.34350–090100	DV50SM60070M BT50SM60090M	5.34170R070300 5.34170R070500	314 514	12.36 20.24	
	KM80ATCHTS50085M KM80ATCHTS50100M	–	–	–	–	–	–	–	–	–				
	KM80ATCHTS50085M KM80ATCHTS50100M	–	–	SSF300HTS500413 SSF300HTS501313 SSF300HTS502113 SSF300HTS503113	1.87 10.55 18.55 28.55	–	–	–	5.34350–090100	DV50SM60070M BT50SM60090M	5.34180R080204 5.34180R080300 5.34180R080500	220 316 516	8.66 12.44 20.32	3.76140R080V 3.76150R080V 3.76158R080V 3.76162R080V
customised solutions available upon request														3.76180R110 3.76195R110 3.76213R125
customised solutions available upon request														3.76230R160 3.76260R160

Adaptor



Mounting



Adaptor Dimensions

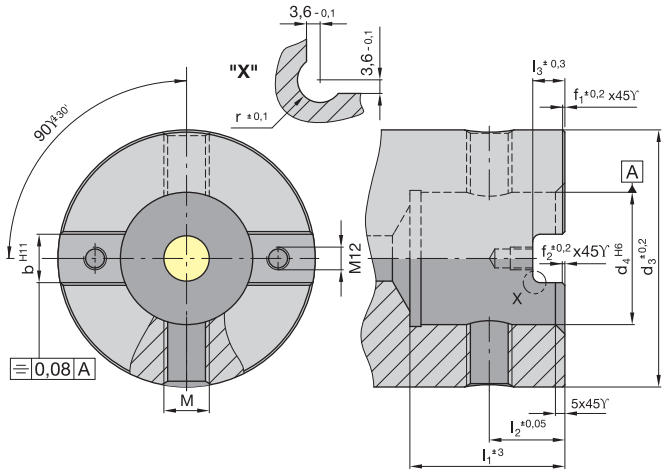


d3	d4	l1	l2	l3	M	b	r	f1	f2	drive ring	clamping screw	thread	MAn* Nm	sliding block	clamping screw M 12 x 25 for sliding block
25	13	28	12,4	7,0	M8 x 1,0	8,0	3	0,5	0,5	**193.371**	**193.372**	M8 x 1,0	10	–	–
28	13	28	12,4	7,0	M8 x 1,0	8,0	3	0,5	0,5	**192.419**	**193.372**	M8 x 1,0	10	–	–
32	16	32	14,4	7,5	M8 x 1,0	8,0	3	0,5	0,5	**192.420**	**192.156**	M8 x 1,0	10	–	–
40	22	35	13,4	8,5	M10 x 1,0	10,0	3	0,5	0,5	**192.421**	**192.157**	M10 x 1,0	16	–	–
48	27	40	15,4	9,0	M12 x 1,0	12,0	3	1,0	1,0	**192.422**	**191.727**	M12 x 1,0	16	–	–
58	32	38	15,4	10,0	M12 x 1,0	14,0	3	1,0	1,0	**192.423**	**191.727**	M12 x 1,0	20	–	–
70	40	43	16,4	10,0	M16 x 1,5	16,0	3	1,0	1,0	**192.424**	**191.728**	M16 x 1,5	34	–	–
80	50	46	20,4	12,5	M16 x 1,5	18,0	4	1,0	1,0	**192.425**	**191.728**	M16 x 1,5	34	–	–
90	50	46	20,4	12,5	M16 x 1,5	18,0	4	1,0	1,0	**192.426**	**191.729**	M16 x 1,5	34	–	–
110	60	46	20,4	12,5	M16 x 1,5	20,0	4	1,0	1,0	**192.427**	**191.729**	M16 x 1,5	34	–	–
125 1)	60	77	40,0	12,5	M24 x 2,0	25,5	4	1,0	1,0	–	**193.107**	M24 x 2,0	120	**191.019**	**125.225**
140 1)	70	82	40,0	12,5	M24 x 2,0	25,5	4	1,0	1,0	–	**193.107**	M24 x 2,0	120	**191.019**	**125.225**
160 1)	80	82	40,0	12,5	M24 x 2,0	25,5	4	1,0	1,0	–	**193.107**	M24 x 2,0	120	**191.019**	**125.225**

* MAn = Clamping torque of clamping screw in Nm.

Mounting Dimensions

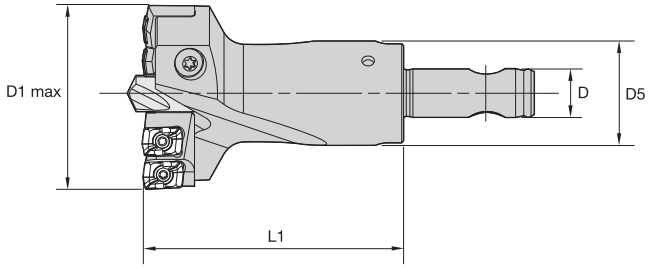
d3	d4	d5	d6	l1	l2	l3	t1	t2	b	r	f1	f2
25	13	8,50	6,5	35	22,0	7,00	6,7	6,50	8,0	3	0,5	0,5
28	13	8,50	6,5	35	22,0	7,00	7,0	6,50	8,0	3	0,5	0,5
32	16	8,30	6,5	40	24,0	7,50	8,5	7,50	8,0	3	0,5	0,5
40	22	10,50	7,0	45	25,0	8,50	11,5	10,00	10,0	3	0,5	0,5
48	27	12,75	9,0	50	27,0	9,00	14,0	12,00	12,0	3	1,0	1,0
58	32	11,50	9,0	50	29,0	10,00	16,5	7,25	14,0	3	1,0	1,0
70	40	15,25	12,2	55	30,0	10,50	20,5	10,00	16,0	3	1,0	1,0
80	50	15,25	12,2	60	36,0	12,50	25,5	12,50	18,0	4	1,0	1,0
90	50	16,50	12,2	60	36,0	12,50	25,5	12,50	18,0	4	1,0	1,0
110	60	14,50	12,2	60	36,0	13,65	30,5	10,00	20,0	4	1,0	1,0
125 1)	60	25,00	18,0	75	39,5	17,00	35,0	20,25	25,5	6	1,0	1,0
140 1)	70	25,00	18,0	80	39,5	17,00	42,0	20,25	25,5	6	1,0	1,0
160 1)	80	25,00	18,0	80	39,5	17,00	42,0	20,25	25,5	6	1,0	1,0



1) Adaptor for d3 = 125, 140, and 160

- Head shipped with clamping and adjusting screws.
- Order pilot drill and cartridges separately; see page J68 for pilot drill.





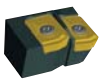


HTS Adjustable Heads with DFR™ Inserts









catalogue number	D1	D1 max	D5	D	L1	pilot drill HSS	pilot drill carbide	cartridge interior	n	cartridge exterior	n	gage insert	ni
HTSR040R025M	40	43	25	13A	60	B513S08..	B514S08..	**HTSR10CI**	1	**HTSR10CE**	1	DFR0302..	4
HTSR043R025M	43	46	25	13A	70	B513S10..	B514S10..	**HTSR11CI**	1	**HTSR11CE**	1	DFR0302..	4
HTSR046R028M	46	49	28	13B	70	B513S10..	B514S10..	**HTSR12CI**	1	**HTSR12CE**	1	DFR0403..	4
HTSR049R028M	49	52	28	13B	70	B513S10..	B514S10..	**HTSR13CI**	1	**HTSR13CE**	1	DFR0403..	4
HTSR052R028M	52	55	28	13B	70	B513S10..	B514S10..	**HTSR14CI**	1	**HTSR14CE**	1	DFR0403..	4

NOTE: n: number of cartridges required by head.
ni: number of inserts required by head.





D1 diameter		clamping screw	adjusting screw
mm	in		
40–42	1.57–1.68	**190.116**	**128.610**
43–52	1.69–2.05	**193.397**	**190.458**





HTS DFR Cartridges

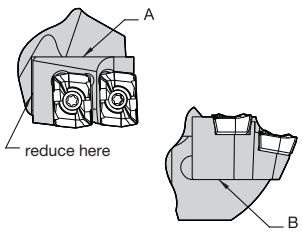




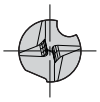


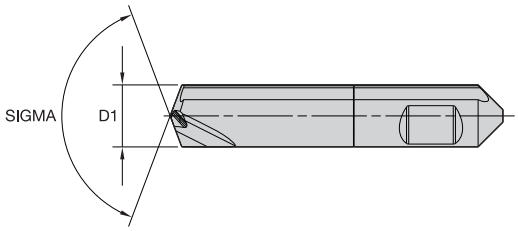
catalogue number	gage insert	Nm	ft. lbs.	insert screw	cartridge screw	washer
HTSR10CE	DFR0302..	5,0	3.69	**192.416**	**192.592**	**192.902**
HTSR10CI	DFR0302..	5,0	3.69	**192.416**	**192.592**	**192.902**
HTSR11CE	DFR0302..	5,0	3.69	**192.416**	**192.592**	**192.902**
HTSR11CI	DFR0302..	5,0	3.69	**192.416**	**192.592**	**192.902**
HTSR12CE	DFR0403..	5,0	3.69	**192.432**	**192.592**	**192.902**
HTSR12CI	DFR0403..	5,0	3.69	**192.432**	**192.592**	**192.902**
HTSR13CE	DFR0403..	5,0	3.69	**192.432**	**192.592**	**192.902**
HTSR13CI	DFR0403..	5,0	3.69	**192.432**	**192.592**	**192.902**
HTSR14CE	DFR0403..	5,0	3.69	**192.432**	**192.592**	**192.902**
HTSR14CI	DFR0403..	5,0	3.69	**192.432**	**192.592**	**192.902**

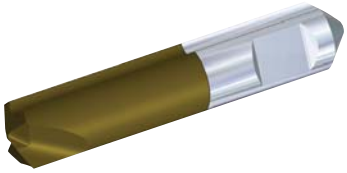
- Change drill diameter by shortening the outer cartridge.
- Shorten at 90° to the contact face A and the support face B.
- Shortening reduces the effective drill diameter by 2x the amount removed.



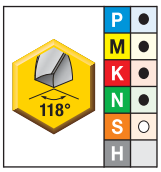
- Choose between HSS and solid carbide.

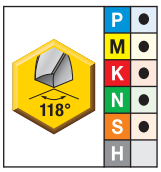


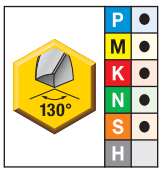




HTS DFR™ • Pilot Drills

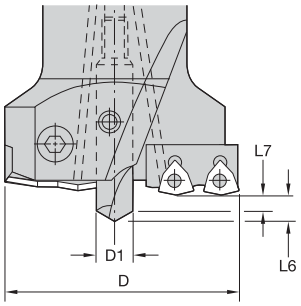






● first choice
○ alternate choice

high-speed steel uncoated	high-speed steel coated	solid carbide coated	
A30	AS3	KC7030	D1
B513S08000 A30	B513S08000 AS3	B514S08000 KC7030	8
B513S10000 A30	B513S10000 AS3	B514S10000 KC7030	10



HTS DFR • Pilot Drills

		high-speed steel				solid carbide			
D1		L6		L7		L6		L7	
mm	in	mm	in	mm	in	mm	in	mm	in
8,00	.315	4,14	.163	1,73	.068	3,61	.142	1,73	.068
10,00	.394	4,88	.192	1,88	.074	4,19	.165	1,88	.074

HTS DFR™ • Metric

Metric										
Material Group		Condition	Pocket Seat	Geometry	Grade	Cutting Speed — vc Range — m/min			Recommended Feed Rate (f) by Diameter		
						min	Starting Value	max	Ø	DFR03... 40,00–46,00mm	DFR04 46,00–55,00mm
P	1	S	O	MD	KCU25	79	**190**	229	mm/r	0,10–0,14	0,12–0,18
			I	MD	KCU25						
		U	O	MD	KCU40	71	**130**	171	mm/r	0,10–0,14	0,12–0,18
			I	MD	KCU40						
		I	O	MD	KC7140	44	**80**	106	mm/r	0,10–0,14	0,12–0,18
			I	MD	KC7140						
	2	S	O	GD	KCU25	75	**180**	217	mm/r	0,10–0,14	0,12–0,18
			I	GD	KCU25						
		U	O	GD	KCU40	71	**120**	271	mm/r	0,10–0,14	0,12–0,18
			I	GD	KCU40						
		I	O	GD	KC7140	44	**70**	106	mm/r	0,10–0,14	0,12–0,18
			I	GD	KC7140						
	3	S	O	GD	KCU25	60	**140**	169	mm/r	0,10–0,14	0,12–0,18
			I	GD	KCU25						
		U	O	GD	KCU40	50	**100**	121	mm/r	0,10–0,14	0,12–0,18
			I	GD	KCU40						
		I	O	GD	KC7140	30	**60**	72	mm/r	0,10–0,14	0,12–0,18
			I	GD	KC7140						
	4	S	O	GD	KCU25	79	**120**	229	mm/r	0,10–0,14	0,12–0,18
			I	GD	KCU25						
		U	O	GD	KCU40	71	**100**	171	mm/r	0,10–0,14	0,12–0,18
			I	GD	KCU40						
		I	O	GD	KC7140	44	**80**	106	mm/r	0,10–0,14	0,12–0,18
			I	GD	KC7140						
	5	S	O	GD	KCU40	62	**100**	190	mm/r	0,06–0,11	0,07–0,14
			I	GD	KCU40						
		U	O	GD	KC7140	47	**60**	114	mm/r	0,06–0,11	0,07–0,14
			I	GD	KC7140						
		I	O	GD	KC7140	31	**40**	76	mm/r	0,06–0,11	0,07–0,14
			I	GD	KC7140						
	6	S	O	GD	KCU40	59	**95**	180	mm/r	0,07–0,11	0,08–0,13
			I	GD	KCU40						
		U	O	GD	KC7140	45	**57**	108	mm/r	0,07–0,11	0,08–0,13
			I	GD	KC7140						
		I	O	GD	KC7140	30	**38**	72	mm/r	0,07–0,11	0,08–0,13
			I	GD	KC7140						
M	1	S	O	MD	KCU40	40	**110**	134	mm/r	0,07–0,11	0,12–0,18
			I	MD	KC7140						
		U	O	MD	KC7140	31	**70**	86	mm/r	0,07–0,11	0,12–0,18
			I	MD	KC7140						
		I	O	MD	KC7140	22	**50**	61	mm/r	0,07–0,11	0,12–0,18
			I	MD	KC7140						
	2	S	O	MD	KCU40	38	**99**	127	mm/r	0,07–0,11	0,12–0,18
			I	MD	KC7140						
		U	O	MD	KC7140	31	**63**	86	mm/r	0,07–0,11	0,12–0,18
			I	MD	KC7140						
		I	O	MD	KC7140	22	**45**	61	mm/r	0,07–0,11	0,12–0,18
			I	MD	KC7140						
	3	S	O	MD	KCU40	32	**88**	107	mm/r	0,07–0,11	0,12–0,18
			I	MD	KC7140						
		U	O	MD	KC7140	31	**56**	86	mm/r	0,07–0,11	0,12–0,18
			I	MD	KC7140						
		I	O	MD	KC7140	22	**40**	61	mm/r	0,07–0,11	0,12–0,18
			I	MD	KC7140						

Condition: S = Stable cutting conditions;
U = Unstable cutting conditions;
I = Interrupted cutting conditions

Pocket seat: I = Inboard insert;
O = Outboard insert

HTS DFR™ • Metric

Metric										
Material Group		Condition	Pocket Seat	Geometry	Grade	Cutting Speed — vc Range — m/min			Recommended Feed Rate (f) by Diameter		
						min	Starting Value	max	Ø	DFR03... 40,00–46,00mm	DFR04... 46,00–55,00mm
K	1	S	O	GD	KCPK10	79	**171**	229	mm/r	0,11–0,20	0,13–0,27
			I	GD	KCPK10						
		U	O	LD	KCU25	64	**117**	156	mm/r	0,11–0,20	0,13–0,27
			I	LD	KCU25						
		I	O	LD	KCU40	40	**72**	96	mm/r	0,11–0,20	0,13–0,27
			I	LD	KCU40						
	2	S	O	GD	KCPK10	75	**162**	217	mm/r	0,11–0,20	0,13–0,27
			I	GD	KCPK10						
		U	O	GD	KCU25	64	**111**	156	mm/r	0,11–0,20	0,13–0,27
			I	GD	KCU25						
		I	O	LD	KCU40	40	**68**	96	mm/r	0,11–0,20	0,13–0,27
			I	LD	KCU40						
	3	S	O	GD	KCPK10	68	**146**	195	mm/r	0,11–0,20	0,13–0,27
			I	GD	KCPK10						
		U	O	GD	KCU25	59	**100**	144	mm/r	0,11–0,20	0,13–0,27
			I	GD	KCU25						
		I	O	GD	KCU40	35	**62**	84	mm/r	0,11–0,20	0,13–0,27
			I	GD	KCU40						
N	1	S	O	ST	KD1425	128	**240**	358	mm/r	0,06–0,09	0,11–0,19
			I	ST	KD1425						
		U	O	LD	KCU40	102	**160**	239	mm/r	0,06–0,09	0,11–0,19
			I	LD	KCU40						
		I	O	LD	KCU40	67	**104**	155	mm/r	0,06–0,09	0,11–0,19
			I	LD	KCU40						
	2	S	O	ST	KD1425	119	**223**	333	mm/r	0,06–0,09	0,11–0,19
			I	ST	KD1425						
		U	O	LD	KCU40	102	**149**	239	mm/r	0,06–0,09	0,11–0,19
			I	LD	KCU40						
		I	O	LD	KCU40	67	**97**	155	mm/r	0,06–0,09	0,11–0,19
			I	LD	KCU40						
	3	S	O	ST	KD1425	110	**206**	308	mm/r	0,06–0,09	0,11–0,19
			I	ST	KD1425						
		U	O	LD	KCU40	102	**138**	239	mm/r	0,06–0,09	0,11–0,19
			I	LD	KCU40						
		I	O	LD	KCU40	67	**89**	155	mm/r	0,06–0,09	0,11–0,19
			I	LD	KCU40						
	4	S	O	ST	KD1425	119	**223**	333	mm/r	0,06–0,09	0,11–0,19
			I	ST	KD1425						
		U	O	LD	KCU40	102	**149**	239	mm/r	0,06–0,09	0,11–0,19
			I	LD	KCU40						
		I	O	LD	KCU40	67	**97**	155	mm/r	0,06–0,09	0,11–0,19
			I	LD	KCU40						
	5	S	O	ST	KD1425	92	**220**	262	mm/r	0,06–0,09	0,11–0,19
			I	ST	KD1425						
		U	O	LD	KCU40	72	**140**	167	mm/r	0,06–0,09	0,11–0,19
			I	LD	KCU40						
		I	O	LD	KCU40	46	**90**	107	mm/r	0,06–0,09	0,11–0,19
			I	LD	KCU40						

Condition: S = Stable cutting conditions;
U = Unstable cutting conditions;
I = Interrupted cutting conditions

Pocket seat: I = Inboard insert;
O = Outboard insert

Difficult Applications Made Easy

Use DS and LP geometries to avoid bird nesting and long, stringy chips in low-carbon steel applications.



- The new DS insert style can be used on Drill Fix™ DFT™, HTS, and KSEM PLUS™ tooling systems.
- LP-style inserts can be used on Drill Fix DFSP™ as outboard inserts.
- Use the new geometries in all applications where long chips are an issue.

See pages J4–J50 for Drill Fix indexable drills.

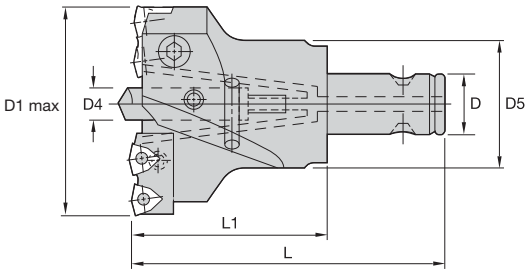
See pages H80–H82 and H84–H101, and H106 for KSEM PLUS A1 and B1 head systems.

Experience the advantages at your Authorised Kennametal Distributor or at **kennametal.com**.

KENNAMETAL®

kennametal.com

- Head shipped with clamping and adjusting screws.
- Order pilot drill separately; see page J76.
- Order cartridges separately; see pages J74.



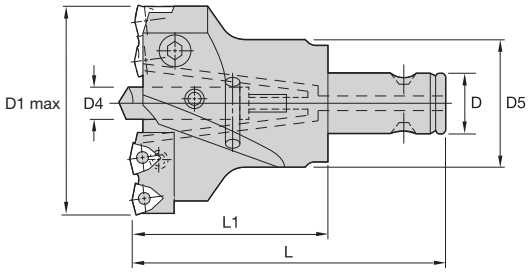


HTS Adjustable Heads • DFT™ inserts

catalogue number	D1	D1 max	D5	D	L	L1	kg	pilot drill	cartridge interior	n	cartridge exterior	n	gage insert	ni
3.76045R028V	45	50	28	13	85	50	0.3	B510S08.	3.77000R050V	1	3.77000R051V	1	DFT0303.	4
3.76050R028V	50	55	28	13	85	50	0.4	B510S08.	3.77000R052V	1	3.77000R053V	1	DFT0303.	4
3.76055R032V	55	58	33	16	100	60	0.4	B510S08.	3.77000R038V	1	3.77000R039V	1	DFT05T3.	4
3.76058R032V	58	63	33	16	100	60	0.4	B510S10.	3.77000R023V	1	3.77000R024V	1	DFT05T3.	4
3.76063R032V	63	68	33	16	100	60	0.4	B510S10.	3.77000R025V	1	3.77000R024V	1	DFT05T3.	4
3.76063R040V	63	68	41	22	115	70	0.5	B510S10.	3.77000R025V	1	3.77000R024V	1	DFT05T3.	4
3.76068R040V	68	73	41	22	115	70	0.8	B510S10.	3.77000R026V	1	3.77000R027V	1	DFT05T3.	4
3.76073R040V	73	78	41	22	115	70	0.8	B510S15.	3.77000R026V	1	3.77000R027V	1	DFT05T3.	4
3.76078R040V	78	84	41	22	115	70	0.8	B510S15.	3.77000R028V	1	3.77000R029V	1	DFT06T3.	4
3.76078R048V	78	84	49	27	120	70	0.9	B510S15.	3.77000R028V	1	3.77000R029V	1	DFT06T3.	4
3.76084R048V	84	90	49	27	120	70	1.0	B510S15.	3.77000R028V	1	3.77000R029V	1	DFT06T3.	4
3.76090R048V	90	96	49	27	120	70	1.0	B510S15.	3.77000R030V	1	3.77000R031V	1	DFT06T3.	4
3.76096R048V	96	102	49	27	120	70	1.1	B510S20.	3.77000R030V	1	3.77000R031V	1	DFT06T3.	4
3.76096R058V	96	102	59	32	130	80	1.2	B510S20.	3.77000R030V	1	3.77000R031V	1	DFT06T3.	4
3.76102R058V	102	108	59	32	130	80	1.7	B510S20.	3.77000R081V	1	3.77000R082V	1	DFT05T3.	6
3.76108R058V	108	115	59	32	130	80	1.8	B510S20.	3.77000R083V	1	3.77000R084V	1	DFT06T3.	6
3.76115R070V	115	122	71	40	145	90	2.9	B510S20.	3.77000R085V	1	3.77000R086V	1	DFT06T3.	6
3.76122R070V	122	130	71	40	145	90	2.9	B510S25.	3.77000R079V	1	3.77000R080V	1	DFT06T3.	6
3.76130R070V	130	140	71	40	145	90	3.0	B510S25.	3.77000R087V	1	3.77000R088V	1	DFT06T3.	6
3.76140R080V	140	150	81	50	160	100	4.3	B510S25.	3.77000R077V	1	3.77000R078V	1	DFT0704.	6
3.76150R080V	150	158	81	50	160	100	4.5	B510S25.	3.77000R075V	1	3.77000R076V	1	DFT0704.	6
3.76158R080V	158	162	81	50	160	100	4.5	B510S25.	3.77000R073V	1	3.77000R074V	1	DFT0704.	6
3.76162R080V	162	170	80	50	160	100	4.5	B510S30.	3.77000R048V	1	3.77000R049V	1	DFT0704.	6
3.76180R110	180	186	110	60	185	125	6.0	B510S30.	3.77000R030V	3	3.77000R031V	1	DFT06T3.	8
3.76195R110	195	201	110	60	185	125	6.5	B510S30.	3.77000R081V	3	3.77000R082V	1	DFT05T3.	12
3.76213R125	213	220	125	60	200	125	7.5	B510S30.	3.77000R083V	3	3.77000R084V	1	DFT06T3.	12
3.76230R160	230	240	160	80	230	150	8.5	B510S30.	3.77000R079V	2	3.77000R080V	2	DFT06T3.	12
3.76260R160 *	260	270	160	80	230	150	9.0	B510S30.	3.77000R077V	2	3.77000R078V	2	DFT06T3.	12

NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.
n: number of cartridges required by head.
ni: number of inserts required by head.

- Head shipped with clamping and adjusting screws.
- Order pilot drill separately; see page J76.
- Order cartridges separately; see pages J74–J75.





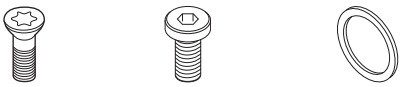
HTS Adjustable Heads • DFT™ and SPHX Inserts

catalogue number	D1	D1 max	pilot drill	cartridge interior	n	cartridge interior 2	n	insert	ni	cartridge exterior SPHX	n	gage insert	ni
3.76045R028V	45	50	B510S08.	**3.77000R250V**	1	–	–	DFT0303.	3	3.77000R251V	1	SPHX0703.	1
3.76050R028V	50	55	B510S08.	**3.77000R252V**	1	–	–	DFT0303.	3	3.77000R253V	1	SPHX0703.	1
3.76055R032V	55	58	B510S08.	**3.77000R038V**	1	–	–	DFT05T3.	3	3.77000R239V	1	SPHX0903.	1
3.76058R032V	58	63	B510S10.	**3.77000R023V**	1	–	–	DFT05T3.	3	3.77000R224V	1	SPHX0903.	1
3.76063R032V	63	68	B510S10.	**3.77000R025V**	1	–	–	DFT05T3.	3	3.77000R224V	1	SPHX0903.	1
3.76063R040V	63	68	B510S10.	**3.77000R025V**	1	–	–	DFT05T3.	3	3.77000R224V	1	SPHX0903.	1
3.76068R040V	68	73	B510S10.	**3.77000R026V**	1	–	–	DFT05T3.	3	3.77000R227V	1	SPHX0903.	1
3.76073R040V	73	78	B510S15.	**3.77000R026V**	1	–	–	DFT05T3.	3	3.77000R227V	1	SPHX0903.	1
3.76078R040V	78	84	B510S15.	**3.77000R028V**	1	–	–	DFT06T3.	3	3.77000R229V	1	SPHX0903.	1
3.76078R048V	78	84	B510S15.	**3.77000R028V**	1	–	–	DFT06T3.	3	3.77000R229V	1	SPHX0903.	1
3.76084R048V	84	90	B510S15.	**3.77000R228V**	1	–	–	DFT06T3.	3	3.77000R229V	1	SPHX0903.	1
3.76090R048V	90	96	B510S15.	**3.77000R230V**	1	–	–	DFT06T3.	3	3.77000R231V	1	SPHX0903.	1
3.76096R048V	96	102	B510S20.	**3.77000R230V**	1	–	–	DFT06T3.	3	3.77000R231V	1	SPHX0903.	1
3.76096R058V	96	102	B510S20.	**3.77000R230V**	1	–	–	DFT06T3.	3	3.77000R231V	1	SPHX0903.	1
3.76102R058V	102	108	B510S20.	**3.77000R081V**	1	–	–	DFT05T3.	5	3.77000R282V	1	SPHX0903.	1
3.76108R058V	108	115	B510S20.	**3.77000R083V**	1	–	–	DFT06T3.	5	3.77000R284V	1	SPHX1204.	1
3.76115R070V	115	122	B510S20.	**3.77000R085V**	1	–	–	DFT06T3.	5	3.77000R286V	1	SPHX1204.	1
3.76122R070V	122	130	B510S25.	**3.77000R079V**	1	–	–	DFT06T3.	5	3.77000R280V	1	SPHX1204.	1
3.76130R070V	130	140	B510S25.	**3.77000R087V**	1	–	–	DFT06T3.	5	3.77000R288V	1	SPHX1204.	1
3.76140R080V	140	150	B510S25.	**3.77000R077V**	1	–	–	DFT0704.	5	3.77000R278V	1	SPHX1505.	1
3.76150R080V	150	158	B510S25.	**3.77000R075V**	1	–	–	DFT0704.	5	3.77000R276V	1	SPHX1204.	1
3.76158R080V	158	162	B510S25.	**3.77000R073V**	1	–	–	DFT0704.	5	3.77000R274V	1	SPHX1204.	1
3.76162R080V	162	170	B510S30.	**3.77000R248V**	1	–	–	DFT0704.	5	3.77000R249V	1	SPHX1505.	1
3.76180R110	180	186	B510S30.	**3.77000R230V**	3	–	–	DFT06T3.	7	3.77000R231V	1	SPHX0903.	1
3.76195R110	195	201	B510S30.	**3.77000R081V**	3	–	–	DFT05T3.	11	3.77000R282V	1	SPHX0903.	1
3.76213R125	213	220	B510S30.	**3.77000R083V**	3	–	–	DFT06T3.	11	3.77000R284V	1	SPHX1204.	1
3.76230R160	230	240	B510S30.	**3.77000R079V**	2	**3.77000R080V**	1	DFT06T3.	11	3.77000R280V	1	SPHX1204.	1
3.76260R160 *	260	270	B510S30.	–	2	–	1	DFT06T3.	11	3.77000R078V	1	SPHX1204.	1

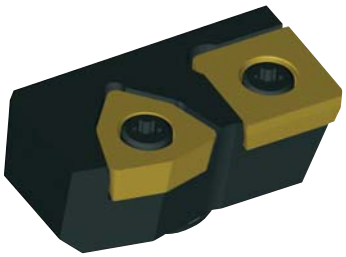
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.
n: number of cartridges required by head.
ni: number of inserts required by head.



HTS Interior and Exterior Cartridges • DFT™ Inserts



catalogue number	gage insert	number of inserts	insert screw	cartridge screw	fan washer	Nm	ft. lbs.
3.77000R023V	DFT05T3..	2	**191.924**	**192.593**	**192.903**	5,0	3.69
3.77000R024V	DFT05T3..	2	**191.924**	**192.593**	**192.903**	5,0	3.69
3.77000R025V	DFT05T3..	2	**191.924**	**192.593**	**192.903**	5,0	3.69
3.77000R026V	DFT05T3..	2	**191.924**	**192.593**	**192.903**	5,0	3.69
3.77000R027V	DFT05T3..	2	**191.924**	**192.593**	**192.903**	5,0	3.69
3.77000R028V	DFT06T3..	2	**191.848**	**129.612**	**192.111**	10,0	7.38
3.77000R029V	DFT06T3..	2	**191.848**	**129.612**	**192.111**	10,0	7.38
3.77000R030V	DFT06T3..	2	**191.848**	**129.616**	**192.111**	10,0	7.38
3.77000R031V	DFT06T3..	2	**191.848**	**129.616**	**192.111**	10,0	7.38
3.77000R038V	DFT05T3..	2	**191.924**	**192.593**	**192.903**	5,0	3.69
3.77000R039V	DFT05T3..	2	**191.924**	**192.593**	**192.903**	5,0	3.69
3.77000R048V	DFT0704..	3	**191.698**	**125.830**	**192.112**	35,0	25.81
3.77000R049V	DFT0704..	3	**191.698**	**125.830**	**192.112**	35,0	25.81
3.77000R050V	DFT0303..	2	**192.432**	**192.592**	**192.902**	5,0	3.69
3.77000R051V	DFT0303..	2	**192.432**	**192.592**	**192.902**	5,0	3.69
3.77000R052V	DFT0303..	2	**192.432**	**192.592**	**192.902**	5,0	3.69
3.77000R053V	DFT0303..	2	**192.432**	**192.592**	**192.902**	5,0	3.69
3.77000R073V	DFT0704..	3	**191.698**	**–**	**192.112**	35,0	25.81
3.77000R074V	DFT0704..	3	**191.698**	**–**	**192.112**	35,0	25.81
3.77000R075V	DFT0704..	3	**191.698**	**–**	**192.112**	35,0	25.81
3.77000R076V	DFT0704..	3	**191.698**	**–**	**192.112**	35,0	25.81
3.77000R077V	DFT0704..	3	**191.698**	**–**	**192.112**	35,0	25.81
3.77000R078V	DFT0704..	3	**191.698**	**–**	**192.112**	35,0	25.81
3.77000R079V	DFT06T3..	3	**191.848**	**125.820**	**192.112**	35,0	25.81
3.77000R080V	DFT06T3..	3	**191.848**	**125.820**	**192.112**	35,0	25.81
3.77000R081V	DFT05T3..	3	**191.924**	**125.820**	**192.112**	35,0	25.81
3.77000R082V	DFT05T3..	3	**191.924**	**125.820**	**192.112**	35,0	25.81
3.77000R083V	DFT06T3..	3	**191.848**	**125.820**	**192.112**	35,0	25.81
3.77000R084V	DFT06T3..	3	**191.848**	**125.820**	**192.112**	35,0	25.81
3.77000R085V	DFT06T3..	3	**191.848**	**–**	**192.112**	35,0	25.81
3.77000R086V	DFT06T3..	3	**191.848**	**125.820**	**192.112**	35,0	25.81
3.77000R087V	DFT06T3..	3	**191.848**	**125.820**	**192.112**	35,0	25.81
3.77000R088V	DFT06T3..	3	**191.848**	**125.820**	**192.112**	35,0	25.81



HTS Finishing Interior Cartridges • For Use with Exterior Cartridges Equipped with SPHX Inserts




catalogue number	gage insert	number of inserts	insert screw	washer	Nm	ft. lbs.
3.77000R228V	DFT06T3..	2	**191.848**	**192.111**	10,0	7.38
3.77000R230V	DFT06T3..	2	**191.848**	**192.111**	10,0	7.38
3.77000R248V	DFT0704..	3	**191.698**	**192.112**	35,0	25.81
3.77000R250V	DFT0303..	2	**192.432**	**192.902**	5,0	3.69
3.77000R252V	DFT0303..	2	**192.432**	**192.902**	5,0	3.69

NOTE: Modified interior cartridges for use with SPHX-equipped exterior cartridges only.

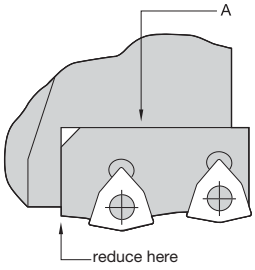
HTS Finishing Exterior Cartridges • SPHX Inserts

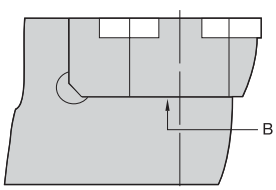


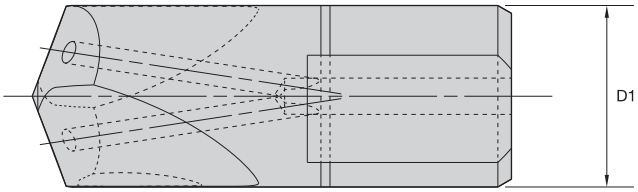


catalogue number	gage insert inside	number of inserts	gage insert outside	number of inserts	insert screw	screw	washer	Nm	ft. lbs.
3.77000R224V	DFT05T3..	2	SPHX0903..	1	**191.924**	**193.451**	**192.903**	5,0	3.69
3.77000R227V	DFT05T3..	2	SPHX0903..	1	**191.924**	**192.593**	**192.903**	5,0	3.69
3.77000R229V	DFT06T3..	2	SPHX0903..	1	**191.916**	**129.612**	**192.111**	10,0	7.38
3.77000R231V	DFT06T3..	2	SPHX0903..	1	**191.916**	**129.616**	**192.111**	10,0	7.38
3.77000R239V	DFT05T3..	2	SPHX0903..	1	**191.924**	**193.451**	**192.903**	5,0	3.69
3.77000R249V	DFT0704..	3	SPHX1505..	1	**191.698**	**125.830**	**192.112**	35,0	25.81
3.77000R251V	DFT0303..	2	SPHX0703..	1	**192.432**	**193.450**	**192.902**	5,0	3.69
3.77000R253V	DFT0303..	2	SPHX0703..	1	**192.432**	**193.450**	**192.902**	5,0	3.69
3.77000R274V	DFT0704..	3	SPHX1505..	1	**191.698**	**–**	**192.112**	35,0	25.81
3.77000R276V	DFT0704..	3	SPHX1505..	1	**191.698**	**–**	**192.112**	35,0	25.81
3.77000R278V	DFT0704..	3	SPHX1505..	1	**191.698**	**–**	**192.112**	35,0	25.81
3.77000R280V	DFT06T3..	3	SPHX1204..	1	**191.916**	**125.820**	**192.112**	35,0	25.81
3.77000R282V	DFT05T3..	3	SPHX0903..	1	**191.924**	**125.820**	**192.112**	35,0	25.81
3.77000R284V	DFT06T3..	3	SPHX1204..	1	**191.916**	**125.820**	**192.112**	35,0	25.81
3.77000R286V	DFT06T3..	3	SPHX1204..	1	**191.916**	**–**	**192.112**	35,0	25.81
3.77000R288V	DFT06T3..	3	SPHX1204..	1	**191.916**	**125.820**	**192.112**	35,0	25.81

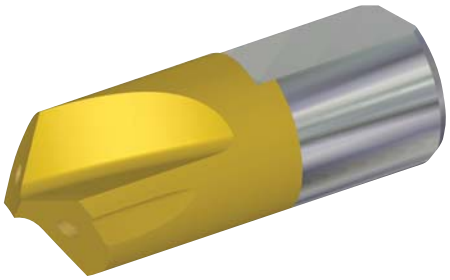
- Change drill diameter by shortening the outer cartridge.
- Shorten at 90° to the contact face A and the support face B.
- Shortening reduces the effective drill diameter by two times the amount removed.



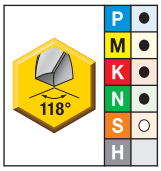


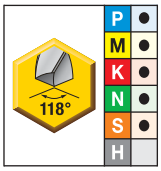


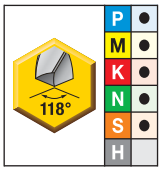
8–10mm sizes are without coolant.



HTS DFT™ • Pilot Drills

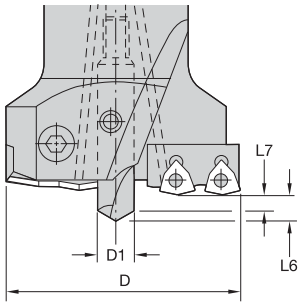






● first choice
○ alternate choice

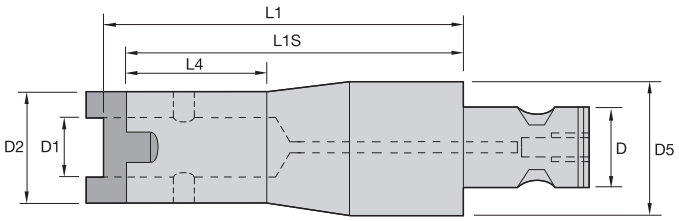
high-speed steel uncoated	high-speed steel coated	carbide drills	
A30	AS3	KC7315	D1
B510S08000 A30	B510S08000 AS3	B511S08000 KC7315	8,00
B510S10000 A30	B510S10000 AS3	B511S10000 KC7315	10,00
B510S15000 A30	B510S15000 AS3	B511S15000 KC7315	15,00
B510S20000 A30	B510S20000 AS3	B511S20000 KC7315	20,00
B510S25000 A30	B510S25000 AS3	B511S25000 KC7315	25,00
B510S30000 A30	B510S30000 AS3	B511S30000 KC7315	30,00

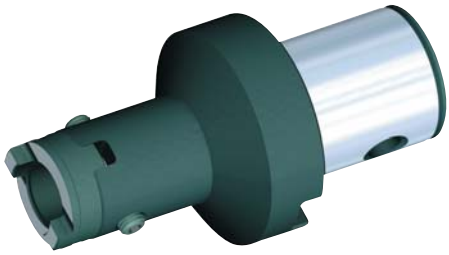


Pilot Drill Setting Lengths

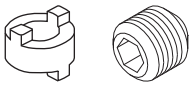
D1		2–4 x D				4–6 x D				>6 x D			
		L6		L7		L6		L7		L6		L7	
mm	in	mm	in	mm	in	mm	in	mm	in	mm	in	mm	in
8,00	.315	3,00	.118	0,80	.032	3,40	.134	1,20	.047	3,80	.150	1,60	.063
10,00	.394	4,00	.158	1,30	.051	4,30	.169	1,60	.063	4,60	.181	1,90	.075
15,00	.591	6,20	.244	2,10	.083	6,50	.256	2,40	.095	6,80	.268	2,70	.106
20,00	.787	8,10	.319	2,60	.102	8,40	.331	2,90	.114	8,70	.343	3,20	.126
25,00	.984	10.50	.413	3,50	.138	7,40	.429	3,90	.154	11,30	.445	4,30	.169
30,00	1181	12,30	.484	4,10	.158	12,80	.504	4,50	.177	13,20	.520	5,00	.197

- Reducers are shipped with drive ring and clamping screws.





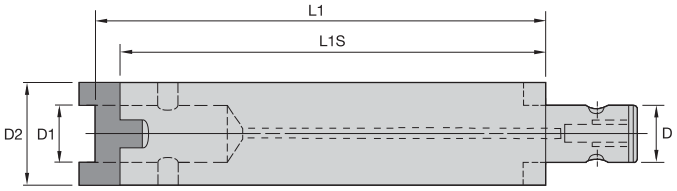
Reducers



catalogue number	D1 coupling size	D coupling size	D2	D5	L1	L1S	L4	drive ring	clamping screw	Nm	ft. lbs.
5.34280R028080	13B	50	27,6	80,0	90,0	80,0	50,0	**192.419**	**192.156**	10,2	7.5
5.34280R032080	16	50	31,6	80,0	90,0	80,0	55,0	**192.420**	**192.156**	10,2	7.5
5.34280R040080	22	50	39,6	80,0	92,0	80,0	57,0	**192.421**	**192.157**	16,3	12.0
5.34280R048080	27	50	47,6	80,0	92,0	80,0	57,0	**192.422**	**191.727**	20,3	15.0
5.34280R058080	32	50	57,6	80,0	93,9	80,0	58,9	**192.423**	**191.727**	20,3	15.0
5.34240R032100	16	22	31,6	40,0	110,0	100,0	55,0	**192.420**	**192.156**	10,2	7.5
5.34248R040100	22	27	39,6	48,0	112,0	100,0	57,0	**192.421**	**192.157**	16,3	12.0
5.34258R048100	27	32	47,6	58,0	112,0	100,0	57,0	**192.422**	**191.727**	20,3	15.0
5.34270R058100	32	40	57,6	70,0	113,9	100,0	58,9	**192.423**	**191.727**	20,3	15.0
5.34280R070150	40	50	69,6	80,0	163,9	150,0	68,9	**192.424**	**191.728**	33,9	25.0

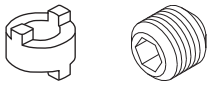
NOTE: Assemble components using recommended torque values.

- Extensions are shipped with drive ring and clamping screws.





Extensions

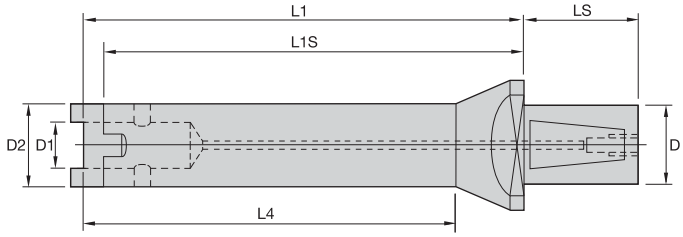


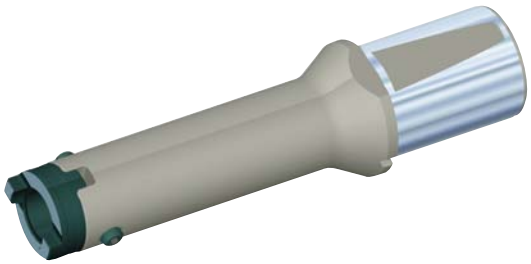
catalogue number	D1 coupling size	D coupling size	D2	L1	L1S	drive ring	clamping screw	Nm	ft. lbs.
5.34132R032100	16	16	32,0	110,0	100,0	**192.420**	**192.156**	10,2	7.5
5.34125R025150	13A	13A	25,0	160,0	150,0	**193.371**	**193.372**	10,2	7.5
5.34128R028150	13B	13B	28,0	160,0	150,0	**192.419**	**192.156**	10,2	7.5
5.34170R070186	40	40	70,0	200,0	186,0	**192.424**	**191.728**	33,9	25.0
5.34132R032200	16	16	32,0	210,0	200,0	**192.420**	**192.156**	10,2	7.5
5.34140R040200	22	22	40,0	212,0	200,0	**192.421**	**192.157**	16,3	12.0
5.34148R048200	27	27	48,0	212,0	200,0	**192.422**	**191.727**	20,3	15.0
5.34180R080204	50	50	80,0	220,0	204,0	**192.425**	**191.728**	33,9	25.0
5.34158R058300	32	32	58,0	314,0	300,0	**192.423**	**191.727**	33,9	25.0
5.34170R070300	40	40	70,0	314,0	300,0	**192.424**	**191.728**	33,9	25.0
5.34180R080300	50	50	80,0	316,0	300,0	**192.425**	**191.728**	33,9	25.0
5.34170R070500	40	40	70,0	514,0	500,0	**192.424**	**191.728**	33,9	25.0
5.34180R080500	50	50	80,0	516,0	500,0	**192.425**	**191.728**	33,9	25.0

NOTE: Assemble components using recommended torque values.

- Shanks are shipped with drive ring and clamping screws.







Basic Shank WN/WD • Metric

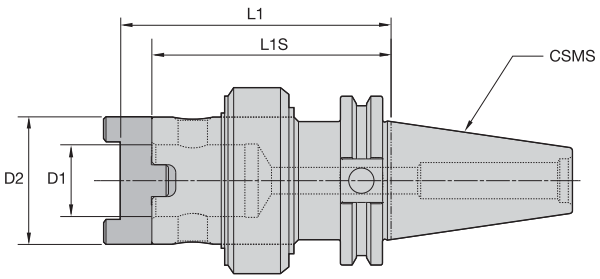



catalogue number	D1 coupling size	D	D2	L1	L1S	L4	LS	drive ring	clamping screw	Nm
5.34032-025115	13A	32,0	25,0	125,0	115,0	110,0	58,0	**193.371**	**193.372**	10,2
5.34032-028115	13B	32,0	28,0	125,0	115,0	110,0	58,0	**192.419**	**192.156**	10,2
5.34032-032125	16	32,0	32,0	135,0	125,0	120,0	58,0	**192.420**	**192.156**	10,2
5.34050-040148	22	50,0	40,0	160,0	148,0	140,0	68,0	**192.421**	**192.157**	16,3
5.34050-048168	27	50,0	48,0	175,0	168,0	160,0	68,0	**192.422**	**191.727**	20,3
5.34050-058186	32	50,0	58,0	200,0	186,0	180,0	68,0	**192.423**	**191.727**	20,3
5.34032-025200	13A	32,0	25,0	210,0	200,0	195,0	58,0	**193.371**	**193.372**	10,2
5.34032-028200	13B	32,0	28,0	210,0	200,0	195,0	58,0	**192.419**	**192.156**	10,2
5.34050-032200	16	50,0	32,0	210,0	200,0	165,0	68,0	**192.420**	**192.156**	10,2
5.34050-025300	13A	50,0	25,0	310,0	300,0	270,0	68,0	**193.371**	**193.372**	10,2
5.34050-028300	13B	50,0	28,0	310,0	300,0	265,0	68,0	**192.419**	**192.156**	10,2
5.34050-040300	22	50,0	40,0	312,0	300,0	267,0	68,0	**192.421**	**192.157**	10,2
5.34050-048300	27	50,0	48,0	312,0	300,0	267,0	68,0	**192.422**	**191.727**	16,3
5.34050-058300	32	50,0	58,0	314,0	300,0	254,0	68,0	**192.423**	**191.727**	20,3
5.34050-032350	16	50,0	32,0	360,0	350,0	315,0	68,0	**192.420**	**192.156**	10,2
5.34050-025450	13A	50,0	25,0	460,0	450,0	420,0	68,0	**193.371**	**193.372**	10,2
5.34050-028450	13B	50,0	28,0	460,0	450,0	415,0	68,0	**192.419**	**192.156**	10,2
5.34050-040450	22	50,0	40,0	462,0	450,0	417,0	68,0	**192.421**	**192.157**	10,2
5.34050-048450	27	50,0	48,0	462,0	450,0	417,0	68,0	**192.422**	**191.727**	16,3
5.34050-058450	32	50,0	58,0	464,0	450,0	404,0	68,0	**192.423**	**191.727**	20,3
5.34050-032500	16	50,0	32,0	510,0	500,0	465,0	68,0	**192.420**	**192.156**	10,2
5.34050-040600	22	50,0	40,0	612,0	600,0	567,0	68,0	**192.422**	**192.157**	10,2
5.34050-048600	27	50,0	48,0	612,0	600,0	567,0	68,0	**192.422**	**191.727**	16,3
5.34050-058600	32	50,0	58,0	614,0	600,0	554,0	68,0	**192.423**	**191.727**	20,3

NOTE: Assemble components using recommended torque values.

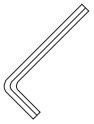
- Shanks are shipped with drive ring and clamping screws.







CV Taper Shank • Form AD • Rotary Coolant Ring

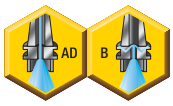



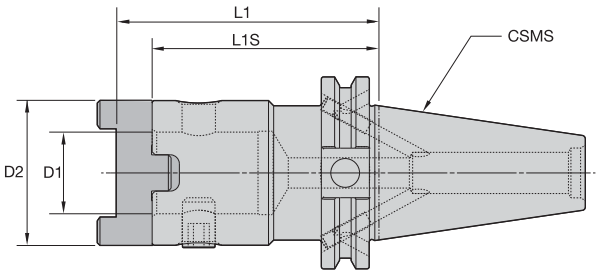


catalogue number	CSMS system size	D1 coupling size	clamping screw	hex wrench	drive ring	coolant ring	ft. lbs.
CV50RMHTS13M394	CV50	13B	**192.156**	**170.004**	**192.419**	**302.011**	7.5
CV50RMHTS16M394	CV50	16	**192.156**	**170.004**	**192.420**	**302.011**	7.5
CV50RMHTS22M394	CV50	22	**192.157**	**170.004**	**192.421**	**302.011**	12.0
CV50RMHTS27M394	CV50	27	**191.727**	**170.006**	**192.422**	**302.011**	15.0
CV50RMHTS32M394 *	CV50	32	**191.727**	**170.006**	**192.423**	**302.011**	15.0
CV50RMHTS40M413	CV50	40	**191.728**	**170.008**	**192.424**	**302.009**	26.0
CV50RMHTS50M413	CV50	50	**191.728**	**170.008**	**192.425**	**302.010**	26.0

NOTE: Assemble components using recommended torque values.
*Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

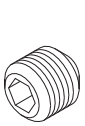
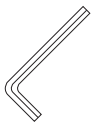
- Shanks are shipped with drive ring and clamping screws.







CV Taper Shank • Form B/AD Coolant

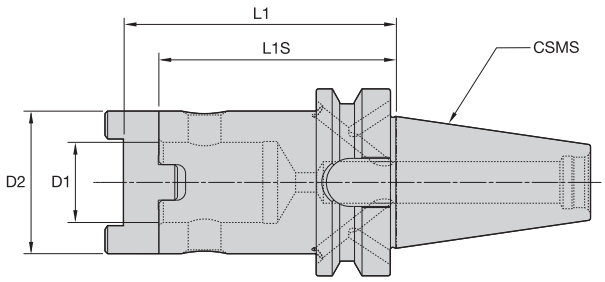




catalogue number	CSMS system size	D1 coupling size	clamping screw	hex wrench	drive ring	ft. lbs.
CV50BHTS13M295	CV50	13B	**192.156**	**170.004**	**192.419**	7.5
CV50BHTS16M295	CV50	16	**192.156**	**170.004**	**192.420**	7.5
CV50BHTS22M295	CV50	22	**192.157**	**170.004**	**192.421**	12.0
CV50BHTS27M295	CV50	27	**191.727**	**170.006**	**192.422**	15.0
CV50BHTS32M314	CV50	32	**191.727**	**170.006**	**192.423**	15.0
CV50BHTS40M314	CV50	40	**191.728**	**170.008**	**192.424**	26.0
CV50BHTS50M314	CV50	50	**191.728**	**170.008**	**192.425**	26.0

NOTE: Assemble components using recommended torque values.

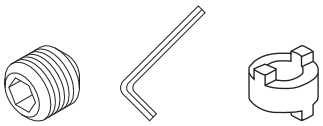
- Shanks are shipped with drive ring and clamping screw.







BT Taper Shank • Form B/AD Coolant

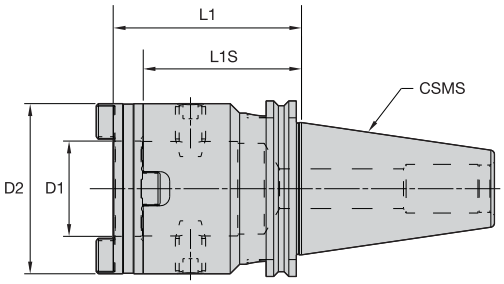


catalogue number	CSMS system size	D1 coupling size	D2	L1	L1S	clamping screw	hex wrench	drive ring	Nm	ft. lbs.
BT50BHTS22075M	BT50	22	40,0	87,0	75,0	**192.157**	**170.005**	**192.421**	16,0	12.0
BT50BHTS32080M	BT50	32	58,0	94,0	80,0	**MS1276**	**170.006**	**192.423**	20,0	15.0
BT50BHTS40080M	BT50	40	70,0	94,0	80,0	**191.728**	**170.008**	**192.424**	34,0	26.0
BT50BHTS50080M	BT50	50	80,0	96,0	80,0	**191.728**	**170.008**	**192.425**	34,0	26.0

NOTE: Assemble components using recommended torque values.

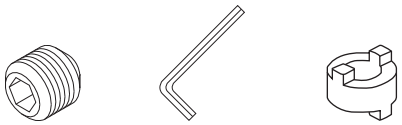
- Shanks are shipped with drive ring and clamping screw.





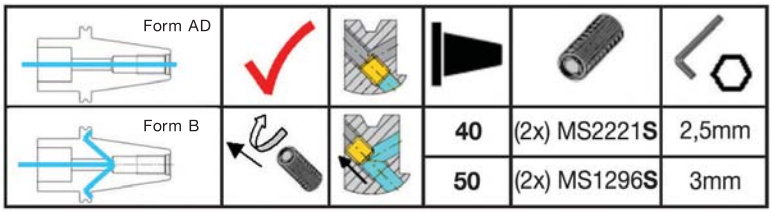


DV Taper Shank • Form B/AD Coolant

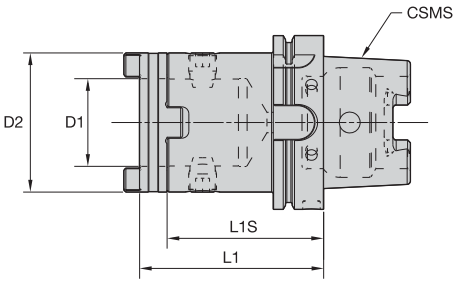


catalogue number	CSMS system size	D1 coupling size	D2	L1	L1S	clamping screw	hex wrench	drive ring
5.36050-154040	DV50	40	70,0	100,0	84,0	**191.728**	**170.008**	**192.424**
5.36050-154050	DV50	50	90,0	100,0	84,0	**191.729**	**170.008**	**192.426**

NOTE: Assemble components using recommended torque values.

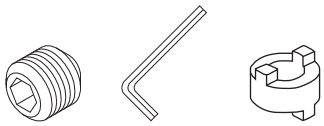


- Shanks are shipped with drive ring and clamping screw.





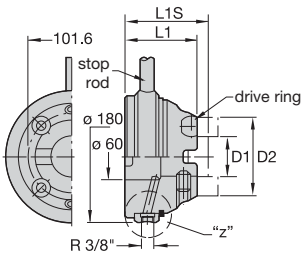
HSK100A Taper Shank

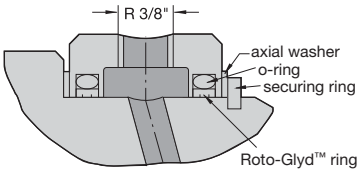


catalogue number	CSMS system size	D1 coupling size	D2	L1	L1S	clamping screw	hex wrench	drive ring	Nm	ft. lbs.
HSK100AHTS40085M	HSK100A	40	70,0	99,0	85,0	**191.728**	**170.008**	**192.424**	35,0	25.0
HSK100AHTS50090M	HSK100A	50	80,0	106,0	90,0	**191.728**	**170.008**	**192.425**	35,0	25.0

NOTE: Assemble components using recommended torque values.

- Shanks are shipped with drive ring and clamping screws.







Flanged Adaptor (Including Drive Ring)

catalogue number	D1
5.34350-090100	50,00

NOTE: Adaptor includes all items shown except the nipple. Nipple must be ordered separately.
If replacement becomes necessary, the nipple is manufactured with a predetermined breaking point for safety purposes.
Maximum RPM is 1500. Maximum pressure is 72 psi or 5 bar.

Spare Parts



drive ring	clamping screw	coolant ring	O-ring	securing ring	axial washer	ROTO-GLYD ring	stop bar	nipple
192.426	**191.729**	**302.014**	**192.731**	**192.126**	**192.158**	**192.730**	**460.716**	**192.759**

HTS DFT™ • Metric

Metric													
Material Group		Condition	Pocket Seat	Geometry	Grade	Cutting Speed — vc Range — m/min			Recommended Feed Rate (f) by Diameter				
						min	Starting Value	max	Ø	DFT03... 45,00–55,00mm	DFT05... 55,00–78,00mm	DFT06... 78,00–140,00mm	DFT07... 140,00–270,00mm
P	1	S	O	MD	KCU25	94	**190**	229	mm/r	0,06–0,10	0,08–0,12	0,10–0,14	0,13–0,19
			I	MD	KCU40								
		U	O	MD	KCU40	71	**130**	171	mm/r	0,06–0,10	0,08–0,12	0,10–0,14	0,13–0,19
			I	MD	KC7140								
		I	O	MD	KCU40	44	**80**	106	mm/r	0,06–0,10	0,08–0,12	0,10–0,14	0,13–0,19
			I	MD	KC7140								
	2	S	O	HP	KCU25	94	**180**	229	mm/r	0,10–0,14	0,12–0,18	0,12–0,18	0,12–0,20
			I	HP	KCU40								
		U	O	HP	KCU40	71	**120**	1714	mm/r	0,10–0,14	0,12–0,18	0,12–0,18	0,12–0,20
			I	HP	KC7140								
		I	O	HP	KCU40	44	**70**	106	mm/r	0,10–0,14	0,12–0,18	0,12–0,18	0,12–0,20
			I	HP	KC7140								
	3	S	O	HP	KCU25	70	**140**	169	mm/r	0,10–0,14	0,12–0,18	0,12–0,18	0,12–0,20
			I	HP	KCU40								
		U	O	HP	KCU40	50	**100**	121	mm/r	0,10–0,14	0,12–0,18	0,12–0,18	0,12–0,20
			I	HP	KC7140								
		I	O	HP	KCU40	30	**60**	72	mm/r	0,10–0,14	0,12–0,18	0,12–0,18	0,12–0,20
			I	HP	KC7140								
	4	S	O	HP	KCU25	94	**120**	229	mm/r	0,10–0,14	0,12–0,18	0,12–0,18	0,12–0,20
			I	HP	KCU40								
		U	O	HP	KCU40	71	**100**	171	mm/r	0,10–0,14	0,12–0,18	0,12–0,18	0,12–0,20
			I	HP	KC7140								
		I	O	HP	KCU40	44	**80**	106	mm/r	0,10–0,14	0,12–0,18	0,12–0,18	0,12–0,20
			I	HP	KC7140								
	5	S	O	HP	KCU25	78	**100**	190	mm/r	0,05–0,07	0,06–0,08	0,06–0,10	0,08–0,12
			I	HP	KCU40								
		U	O	HP	KCU40	47	**60**	114	mm/r	0,05–0,07	0,06–0,08	0,06–0,10	0,08–0,12
			I	HP	KC7140								
		I	O	HP	KCU40	31	**40**	76	mm/r	0,05–0,07	0,06–0,08	0,06–0,10	0,08–0,12
			I	HP	KC7140								
	6	S	O	HP	KCU25	74	**95**	180	mm/r	0,04–0,07	0,05–0,08	0,06–0,10	0,08–0,12
			I	HP	KCU40								
		U	O	HP	KCU40	45	**57**	108	mm/r	0,04–0,07	0,05–0,08	0,06–0,10	0,08–0,12
			I	HP	KC7140								
		I	O	HP	KCU40	30	**38**	72	mm/r	0,04–0,07	0,05–0,08	0,06–0,10	0,08–0,12
			I	HP	KC7140								
M	1	S	O	MD	KCU25	48	**110**	134	mm/r	0,07–0,11	0,12–0,18	0,14–0,20	0,16–0,22
			I	MD	KCU40								
		U	O	MD	KCU40	31	**70**	86	mm/r	0,07–0,11	0,12–0,18	0,14–0,20	0,16–0,22
			I	MD	KC7140								
		I	O	MD	KC7140	22	**50**	61	mm/r	0,07–0,11	0,12–0,18	0,14–0,20	0,16–0,22
			I	MD	KC7140								
	2	S	O	MD	KCU25	48	**99**	134	mm/r	0,07–0,11	0,12–0,18	0,14–0,20	0,16–0,22
			I	MD	KCU40								
		U	O	MD	KCU40	31	**63**	86	mm/r	0,07–0,11	0,12–0,18	0,14–0,20	0,16–0,22
			I	MD	KC7140								
		I	O	MD	KC7140	22	**45**	61	mm/r	0,07–0,11	0,12–0,18	0,14–0,20	0,16–0,22
			I	MD	KC7140								
	3	S	O	MD	KCU25	48	**88**	134	mm/r	0,07–0,11	0,12–0,18	0,14–0,20	0,16–0,22
			I	MD	KCU40								
		U	O	MD	KCU40	31	**56**	86	mm/r	0,07–0,11	0,12–0,18	0,14–0,20	0,16–0,22
			I	MD	KC7140								
		I	O	MD	KC7140	22	**40**	61	mm/r	0,07–0,11	0,12–0,18	0,14–0,20	0,16–0,22
			I	MD	KC7140								

Condition: S = Stable cutting conditions;
U = Unstable cutting conditions;
I = Interrupted cutting conditions

Pocket seat: I = Inboard insert;
O = Outboard insert

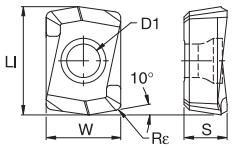
HTS DFT™ • Metric

Metric												
Material Group		Condition	Pocket Seat	Geometry	Grade	Cutting Speed — vc Range — m/min			Recommended Feed Rate (f) by Diameter			
						min	Starting Value	max	Ø	DFT03... 45,00–55,00mm	DFT05... 55,00–78,00mm	DFT06... 78,00–140,00mm	DFT07... 140,00–270,00mm
K	1	S	O	HP	KCPK10	94	**171**	229	mm/r	0,11–0,20	0,13–0,27	0,15–0,31	0,17–0,33
			I	HP	KCPK10								
		U	O	HP	KCU25	64	**117**	156	mm/r	0,11–0,20	0,13–0,27	0,15–0,31	0,17–0,33
			I	HP	KCU25								
		I	O	HP	KCU40	40	**72**	96	mm/r	0,11–0,20	0,13–0,27	0,15–0,31	0,17–0,33
			I	HP	KCU40								
	2	S	O	HP	KCPK10	94	**162**	229	mm/r	0,11–0,20	0,13–0,27	0,15–0,31	0,17–0,33
			I	HP	KCPK10								
		U	O	HP	KCU25	64	**111**	156	mm/r	0,11–0,20	0,13–0,27	0,15–0,31	0,17–0,33
			I	HP	KCU25								
		I	O	HP	KCU40	40	**68**	96	mm/r	0,11–0,20	0,13–0,27	0,15–0,31	0,17–0,33
			I	HP	KCU40								
	3	S	O	HP	KCPK10	90	**146**	217	mm/r	0,11–0,20	0,13–0,27	0,15–0,31	0,15–0,31
			I	HP	KCPK10								
		U	O	HP	KCU25	59	**100**	144	mm/r	0,11–0,20	0,13–0,27	0,15–0,31	0,15–0,31
			I	HP	KCU25								
		I	O	HP	KCU40	35	**62**	84	mm/r	0,11–0,20	0,13–0,27	0,15–0,31	0,15–0,31
			I	HP	KCU40								
N	1	S	O	ST	KD1425	154	**240**	358	mm/r	0,06–0,09	0,11–0,19	0,12–0,20	0,14–0,25
			I	ST	KD1425								
		U	O	HP	KC7140	102	**160**	239	mm/r	0,06–0,09	0,11–0,19	0,12–0,20	0,14–0,25
			I	HP	KC7140								
		I	O	HP	KC7140	67	**104**	155	mm/r	0,06–0,09	0,11–0,19	0,12–0,20	0,14–0,25
			I	HP	KC7140								
	2	S	O	ST	KD1425	154	**223**	358	mm/r	0,06–0,09	0,11–0,19	0,12–0,20	0,14–0,25
			I	ST	KD1425								
		U	O	HP	KCU40	102	**149**	239	mm/r	0,06–0,09	0,11–0,19	0,12–0,20	0,14–0,25
			I	HP	KCU40								
		I	O	HP	KCU40	67	**97**	155	mm/r	0,06–0,09	0,11–0,19	0,12–0,20	0,14–0,25
			I	HP	KCU40								
	3	S	O	ST	KD1425	154	**206**	358	mm/r	0,06–0,09	0,11–0,19	0,12–0,20	0,14–0,25
			I	ST	KD1425								
		U	O	HP	KCU40	102	**138**	239	mm/r	0,06–0,09	0,11–0,19	0,12–0,20	0,14–0,25
			I	HP	KCU40								
		I	O	HP	KCU40	67	**89**	155	mm/r	0,06–0,09	0,11–0,19	0,12–0,20	0,14–0,25
			I	HP	KCU40								
	4	S	O	ST	KD1425	154	**223**	358	mm/r	0,06–0,09	0,11–0,19	0,12–0,20	0,14–0,25
			I	ST	KD1425								
		U	O	LD	KC7140	102	**149**	239	mm/r	0,06–0,09	0,11–0,19	0,12–0,20	0,14–0,25
			I	LD	KC7140								
		I	O	LD	KC7140	67	**97**	155	mm/r	0,06–0,09	0,11–0,19	0,12–0,20	0,14–0,25
			I	LD	KC7140								
	5	S	O	ST	KD1425	112	**220**	262	mm/r	0,06–0,09	0,11–0,19	0,12–0,20	0,14–0,25
			I	ST	KD1425								
		U	O	HP	KCU40	72	**140**	167	mm/r	0,06–0,09	0,11–0,19	0,12–0,20	0,14–0,25
			I	HP	KCU40								
		I	O	HP	KCU40	46	**90**	107	mm/r	0,06–0,09	0,11–0,19	0,12–0,20	0,14–0,25
			I	HP	KCU40								
S	1	S	O	HP	KC7140	24	**40**	49	mm/r	0,04–0,07	0,05–0,08	0,07–0,10	0,07–0,10
			I	HP	KC7140								
		U	O	HP	KC7140	18	**30**	37	mm/r	0,04–0,07	0,05–0,08	0,07–0,10	0,07–0,10
			I	HP	KC7140								
		I	O	HP	KC7140	15	**25**	30	mm/r	0,04–0,07	0,05–0,08	0,07–0,10	0,07–0,10
			I	HP	KC7140								
	2	S	O	HP	KC7140	25	**35**	48	mm/r	0,04–0,07	0,05–0,08	0,07–0,10	0,07–0,10
			I	HP	KC7140								
		U	O	HP	KC7140	18	**25**	34	mm/r	0,04–0,07	0,05–0,08	0,07–0,10	0,07–0,10
			I	HP	KC7140								
		I	O	HP	KC7140	14	**20**	27	mm/r	0,04–0,07	0,05–0,08	0,07–0,10	0,07–0,10
			I	HP	KC7140								

Condition: S = Stable cutting conditions;
U = Unstable cutting conditions;
I = Interrupted cutting conditions

Pocket seat: I = Inboard insert;
O = Outboard insert





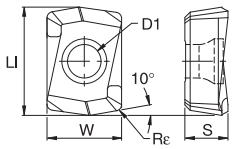
● first choice
○ alternate choice

P		●	●	●	●
M		○	○	○	○
K		●	●	○	○
N		○		○	○
S		○		●	●
H				○	○

DFR-GD

catalogue number	LI	W	D1	S	Rε	KCPK10	KCU25	KCU40	KC7140
DFR020204GD	7,12	4,90	2,30	2,79	0,40	●	●	●	●
DFR030204GD	8,71	6,00	2,50	2,88	0,40	●	●	●	●
DFR040304GD	10,76	7,38	2,85	3,79	0,40	●	●	●	●



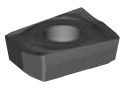


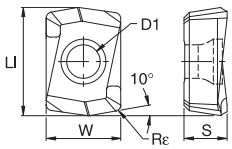
● first choice
○ alternate choice

P		●	●	●	●
M		○	●	●	●
K		○	○	○	○
N		○	○	○	○
S		○	●	●	●
H					

DFR-MD

catalogue number	LI	W	D1	S	Rε	KCU25	KCU40	KC7140
DFR020204MD	7,12	4,90	2,30	2,79	0,40	●	●	●
DFR030204MD	8,71	6,00	2,50	2,88	0,40	●	●	●
DFR040304D28MD	10,76	7,26	2,85	3,79	0,40	–	–	●
DFR040304MD	10,76	7,38	2,85	3,79	0,40	●	●	●





● first choice
○ alternate choice

P		○	●	○	●
M			○	●	●
K		●	●	●	○
N			○	●	○
S			○	●	○
H				○	

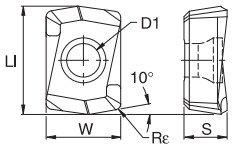
DFR-LD

catalogue number	LI	W	D1	S	Rε	KCPK10	KCU25	KCU40	KC7140
DFR020204LD	7,12	4,90	2,30	2,79	0,40	●	●	●	●
DFR030204LD	8,71	6,00	2,50	2,86	0,40	●	●	●	●
DFR040304LD	10,76	7,38	2,85	3,76	0,40	●	●	●	●

● first choice
○ alternate choice

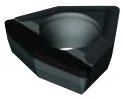
P		
M		
K		
N		●
S		
H		

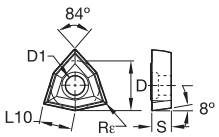




DFR • PCD • Single-Tipped

catalogue number	LI	W	D1	S	Rε	KD1425
DFR040304ST	10,50	7,40	2,85	3,18	0,40	●





DFT • PCD • Single-Tipped

catalogue number	L10	D	D1	S	Rε	KD1425
DFT05T308ST	5,19	8,00	3,40	3,75	0,80	●
DFT06T308ST	6,52	10,00	4,40	3,75	0,80	●
DFT070408ST	7,84	12,00	4,40	4,75	0,80	●
DFT090508ST	9,83	15,00	5,50	5,19	0,80	●
DFT110508ST	11,53	17,60	5,85	4,81	0,80	●

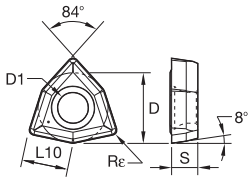
DFR™ • PCD • Metric

Metric										
Material Group		Condition	Pocket Seat	Geometry	Grade	Cutting Speed — vc Range — m/min			Recommended Feed Rate (fz) by Diameter	
						min	Starting Value	max	Ø	DFR04 20,50–24,00mm
N	1	S	O	ST	KD1425	396	**720**	841	mm/r	0,06–0,08
			I	ST	KD1425					
	2	S	O	ST	KD1425	369	**670**	782	mm/r	0,12–0,18
			I	ST	KD1425					
	3	S	O	ST	KD1425	341	**619**	723	mm/r	0,12–0,18
			I	ST	KD1425					
	4	S	O	ST	KD1425	475	**720**	841	mm/r	0,12–0,18
			I	ST	KD1425					
	5	S	O	ST	KD1425	480	**720**	864	mm/r	0,06–0,08
			I	ST	KD1425					

DFT™ • PCD • Metric

Metric														
Material Group		Condition	Pocket Seat	Geometry	Grade	Cutting Speed — vc Range — m/min			Recommended Feed Rate (f) by Diameter					
						min	Starting Value	max	Ø	DFT03 16–24,00mm	DFT05 25–32,00mm	DFT06 33–40,00mm	DFT07 41–48,00mm	DFT09 49–68,00mm	DFT11 69–82,00mm
N	1	S	O	ST/C	KD1425	480	**720**	864	mm/r	0,05–0,07	0,07–0,09	0,10–0,14	0,12–0,16	0,14–0,18	0,14–0,18
			I	ST/C	KD1425										
	2	S	O	ST/C	KD1425	447	**670**	804	mm/r	0,05–0,07	0,07–0,09	0,10–0,14	0,12–0,16	0,14–0,18	0,14–0,18
			I	ST/C	KD1425										
	3	S	O	ST/C	KD1425	413	**619**	743	mm/r	0,05–0,07	0,07–0,09	0,10–0,14	0,12–0,16	0,14–0,18	0,14–0,18
			I	ST/C	KD1425										
	4	S	O	ST/C	KD1425	447	**670**	804	mm/r	0,05–0,07	0,07–0,09	0,10–0,14	0,12–0,16	0,14–0,18	0,14–0,18
			I	ST/C	KD1425										
	5	S	O	ST/C	KD1425	480	**720**	864	mm/r	0,05–0,07	0,07–0,09	0,10–0,14	0,12–0,16	0,14–0,18	0,14–0,18
			I	ST/C	KD1425										





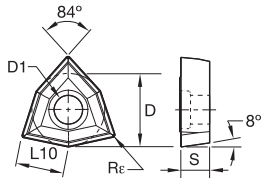
● first choice
○ alternate choice

P	●	●	●	●	
M	○	○	○	●	
K	●	●	●	○	
N	○		○	○	
S	○		●	○	
H			○		

DFT-GD

catalogue number	L10	D	D1	S	Rε	KCPK10	KCU25	KCU40	KC7140
DFT030204GD	3,97	6,00	2,25	2,45	0,40	●	●	●	–
DFT030304GD	3,97	6,00	2,65	2,95	0,40	●	●	●	●
DFT05T308GD	5,29	8,00	3,40	3,75	0,80	●	●	●	●
DFT06T308GD	6,62	10,00	4,40	3,75	0,80	●	●	●	●
DFT070408GD	7,94	12,00	4,40	4,75	0,80	●	●	●	●
DFT090508GD	9,92	15,00	5,50	5,25	0,85	●	●	●	●





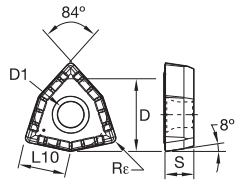
● first choice
○ alternate choice

P	●	●	●	●	
M	○	○	○	●	
K	●	●	●	○	
N	○		○	○	●
S	○		●	○	
H			○		

DFT-HP

catalogue number	L10	D	D1	S	Rε	KCPK10	KCU25	KCU40	KC7140	KMF
DFTX20204HP	3,31	5,00	2,25	2,45	0,40	–	●	●	●	–
DFT030204HP	3,97	6,00	2,25	2,45	0,40	●	●	●	●	●
DFT030304HP	3,97	6,00	2,65	2,95	0,40	●	●	●	●	●
DFT05T308HP	5,29	8,00	3,50	3,75	0,80	●	●	●	●	●
DFT06T308HP	6,62	10,00	4,40	3,75	0,80	●	●	●	●	●
DFT070408HP	7,94	12,00	4,40	4,75	0,80	●	●	●	●	●
DFT090508HP	9,92	15,00	5,50	5,25	0,85	●	●	●	●	●





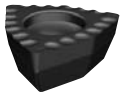
● first choice
○ alternate choice

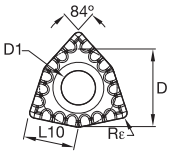
P	●	●	●	
M	○	○	●	
K	●	●	○	
N		○	○	
S		●	○	
H		○		

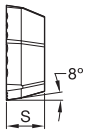
DFT-MD

catalogue number	L10	D	D1	S	Rε	KCU25	KCU40	KC7140
DFTX20204MD	3,31	5,00	2,25	2,45	0,40	●	●	●
DFT030204MD	3,97	6,00	2,25	2,45	0,40	●	●	●
DFT030304MD	3,97	6,00	2,65	2,95	0,40	●	●	●
DFT05T308MD	5,29	8,00	3,40	3,75	0,80	●	●	●
DFT06T308MD	6,62	10,00	4,40	3,75	0,80	●	●	●
DFT070408MD	7,94	12,00	4,40	4,75	0,80	●	●	●
DFT090508MD	9,92	15,00	5,50	5,25	0,80	●	●	●
DFT110508MD	11,64	17,60	5,85	4,88	0,80	–	–	●

- DS geometry for improved control of chip flow, chip breakage, and chip curling.
- These inserts support drilling in P0 and P1 steel, higher alloyed tool steels, and stainless steels where high feed rates cannot be used to provide short chips.







● first choice
○ alternate choice

P		●
M		○
K		
N		○
S		○
H		

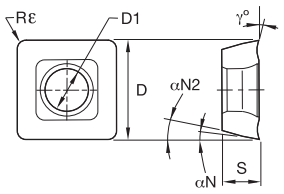
NEW!

Indexable Drills

DFT • DS

catalogue number	L10	D	D1	S	Rε	KCU40
DFTX20204DS	3,31	5,00	2,25	2,45	0,40	●
DFT030304DS	3,97	6,00	2,65	2,95	0,40	●
DFT05T308DS	5,29	8,00	3,40	3,75	0,80	●
DFT06T308DS	6,62	10,00	4,40	3,75	0,80	●
DFT070408DS	7,94	12,00	4,40	4,75	0,80	●
DFT090508DS	9,92	15,00	5,50	5,25	0,80	●





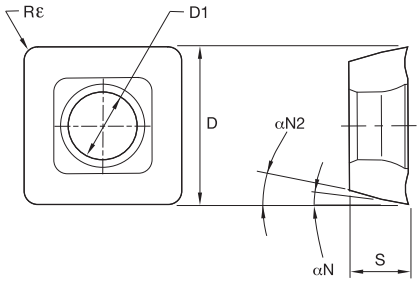
● first choice
○ alternate choice

P	●	●	●	●	
M		○	●	●	
K	●	●	●	○	
N		○	○	○	
S		○	●	○	
H					

SP..X..(R)HP

catalogue number	D	D1	S	Rε	γ°	αN	αN2	KCPK10	KCU25	KCU40	KC7140
SPGX050204HP	5,56	2,25	2,38	0,40	10	7	11	–	●	●	●
SPGX060304RHP	6,35	2,65	3,18	0,40	10	7	11	–	●	●	●
SPGX070304RHP	7,94	2,85	3,18	0,40	10	7	11	–	●	●	●
SPGX070308HP	7,94	2,85	3,18	0,80	10	7	11	●	●	●	–
SPPX09T308RHP	9,53	3,60	3,97	0,80	10	7	11	–	●	●	●
SPPX09T310HP	9,53	3,60	3,97	1,00	10	7	11	●	●	●	–
SPPX120408RHP	12,70	4,60	4,76	0,80	10	7	11	–	●	●	●
SPPX120412HP	12,70	4,60	4,76	1,20	10	7	11	●	●	●	–
SPPX15T508RHP	15,73	5,50	5,95	0,80	10	7	11	–	●	●	●
SPPX15T512HP	15,73	5,50	5,95	1,20	10	7	11	●	●	●	–

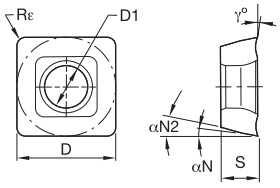




SP..X..MD

catalogue number	D	D1	S	Rε	γ°	αN	αN2	KCPK10	KCU25	KCU40	KC7140
SPGX050204MD	5,56	2,25	2,38	0,40	16	7	11	–	●	●	●
SPGX060304MD	6,35	2,65	3,18	0,40	20	7	11	●	●	●	●
SPGX070304MD	7,94	2,85	3,18	0,40	16	7	11	●	●	●	●
SPGX070308MD	7,94	2,85	3,18	0,80	16	7	11	●	●	●	–
SPPX09T308MD	9,53	3,60	3,97	0,80	16	7	11	–	●	●	●
SPPX09T310MD	9,53	3,60	3,97	1,00	16	7	11	●	●	●	–
SPPX120408MD	12,70	4,60	4,76	0,80	16	7	11	–	●	●	●
SPPX120412MD	12,70	4,60	4,76	1,20	16	7	11	●	●	●	–
SPPX15T508MD	15,73	5,50	5,95	0,80	16	7	11	–	●	●	●
SPPX15T512MD	15,73	5,50	5,95	1,20	16	7	11	●	●	●	–





● first choice
○ alternate choice

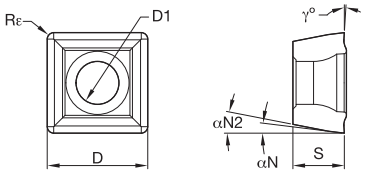
P	●	●	●
M		○	●
K	●	●	●
N		○	○
S		○	●
H			

SP..X..FP

catalogue number	D	D1	S	Rε	γ°	αN	αN2	KCPK10	KCU25	KCU40
SPGX060304FP	6,35	2,85	3,18	0,40	6	7	11	●	●	●
SPGX070304FP	7,94	2,85	3,18	0,40	6	7	11	●	●	●
SPGX070308FP	7,94	2,85	3,18	0,80	6	7	11	●	●	●
SPPX09T308FP	9,53	3,60	3,97	0,80	6	7	11	●	●	●
SPPX09T310FP	9,53	3,60	3,97	1,00	6	7	11	●	●	●
SPPX120408FP	12,70	4,60	4,76	0,80	6	7	11	●	●	●
SPPX120412FP	12,70	4,60	4,76	1,20	6	7	11	●	●	●
SPPX15T508FP	15,73	5,50	5,95	0,80	6	7	11	●	●	●
SPPX15T512FP	15,73	5,50	5,95	1,20	6	7	11	●	●	●

- LP geometry for improved control of chip flow, chip breakage, and chip curling.
- These inserts support drilling in P0 and P1 steel, higher alloyed tool steels, and stainless steels where high feed rates cannot be used to provide short chips.





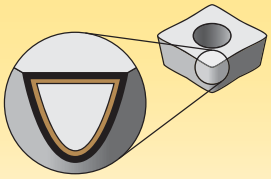
● first choice
○ alternate choice

P		●
M		○
K		
N		○
S		○
H		

NEW!

SP..X..LP

catalogue number	D	D1	S	Rε	γ°	αN	αN2	KCU40
SPGX050204LP	5,42	2,25	2,38	0,40	4	7	11	●
SPGX060304LP	6,35	2,65	3,18	0,40	4	7	11	●
SPPX070304LP	7,80	2,85	3,18	0,40	4	7	11	●
SPPX09T308LP	9,38	3,60	3,97	0,80	4	7	11	●
SPPX120408LP	12,56	4,60	4,76	0,80	4	7	11	●

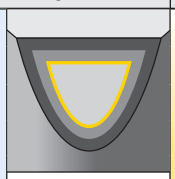
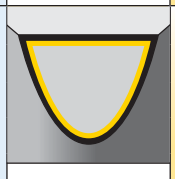


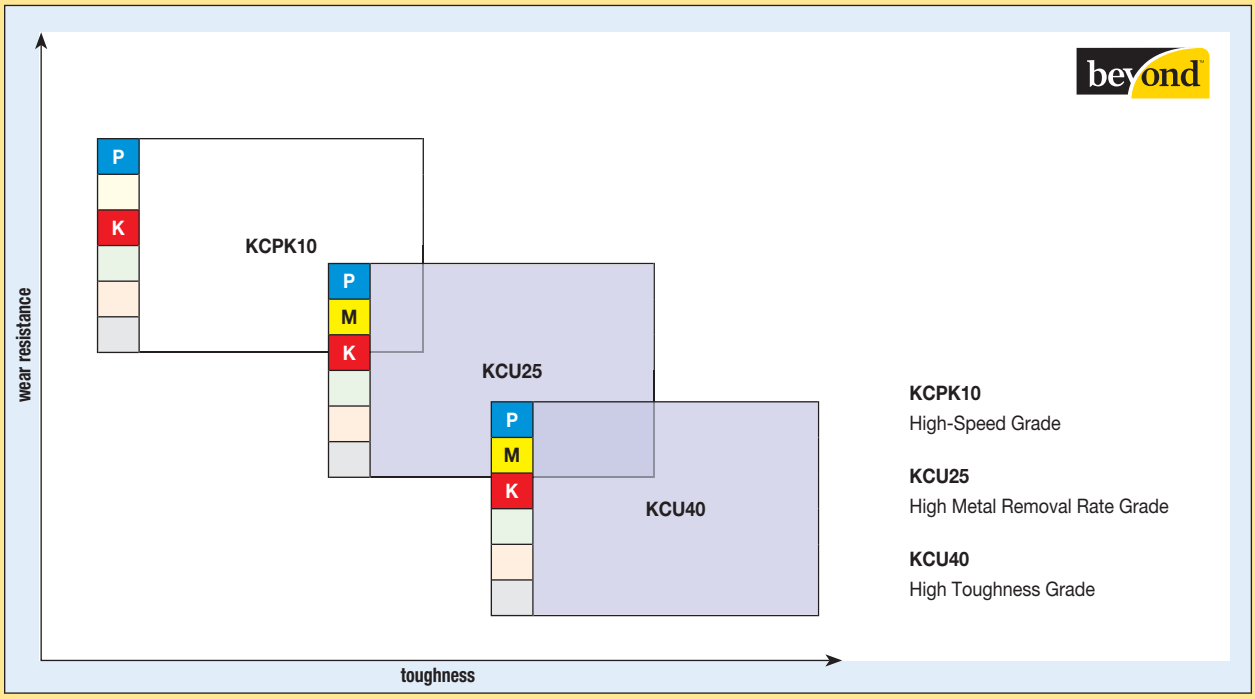
Coatings provide high-speed capability and are engineered for finishing to light roughing.

P	Steel
M	Stainless Steel
K	Cast Iron
N	Non-Ferrous
S	High-Temp Alloys
H	Hardened Materials

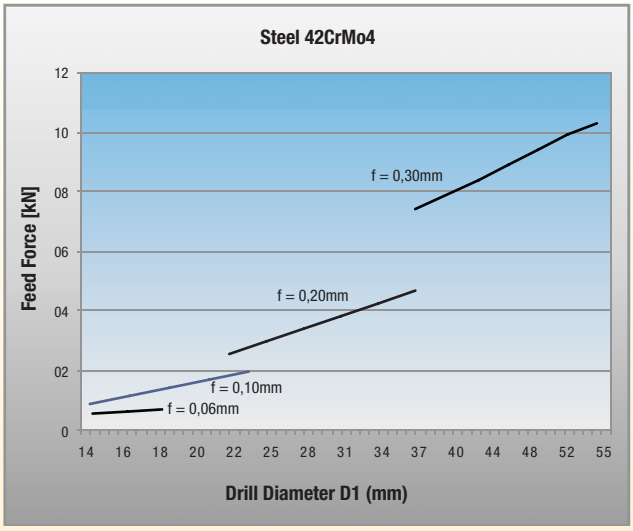
wear resistance ← → toughness

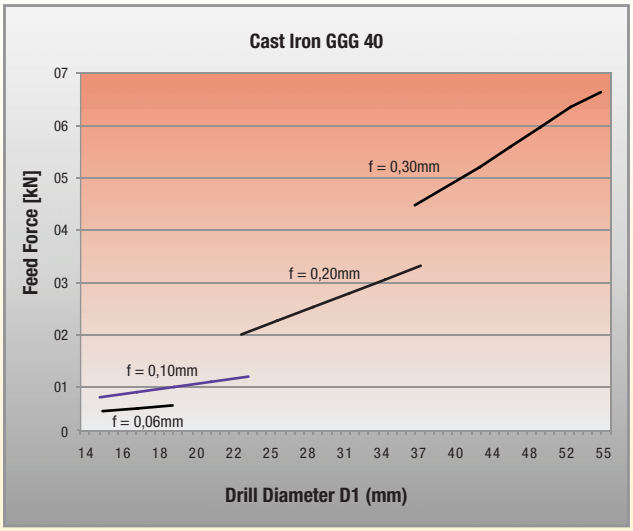
Grade

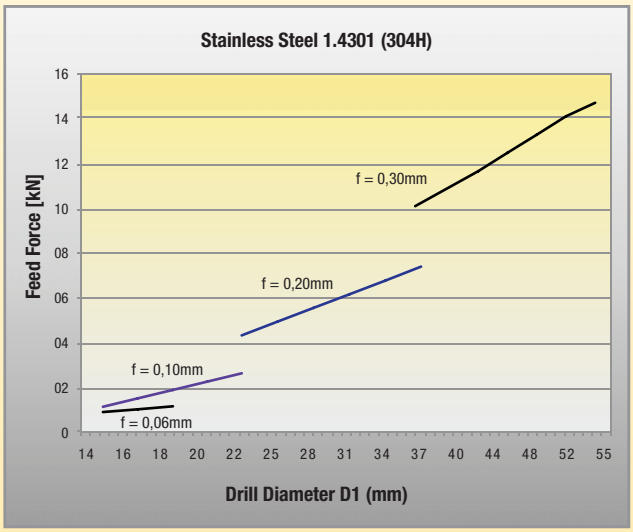
Coating	Grade Description	05	10	15	20	25	30	35	40	45
KCPK10  Al_2O_3 TiCN	**Composition:** With an advanced CVD TiCN-Al_2O_3 coating combined with a cobalt-enriched carbide substrate, this grade offers a balanced combination of deformation-resistance and edge toughness. **Application:** The KCPK10™ grade offers outstanding abrasion and crater wear resistance for high-speed machining of steels and cast irons. Use for very high cutting speeds with low to medium feed rates.	P	P	P	P					
		K	K	K	K					
KCU25  Al_2O_3 TiCN	**Composition:** This advanced CVD TiCN-Al_2O_3 coating, together with a newly engineered tough carbide substrate, ensures adequate deformation resistance along with excellent edge strength, and offers very good wear resistance over a wide range of machining conditions. **Application:** KCU25, as a high productivity grade with high speeds and feeds, is the first choice for productive process with very good reliability in steels, stainless steels, and cast irons.	P	P	P	P	P	P	P	P	P
		M	M	M	M	M	M	M	M	M
		K	K	K	K	K	K	K	K	K
KCU40  PVD TiN_TiAlN	**Composition:** With a multilayered PVD TiN-TiAlN coating and a tough substrate, this grade withstands interruptions and provides high wear resistance for long tool life. **Application:** The KCU40 grade is the first choice for high reliability in most materials. This grade should be used at medium speeds and high feeds due to sharper edges, and as a grade for high toughness applications. It covers steel, stainless steel, cast iron, and high-temp alloys under certain conditions.	P	P	P	P	P	P	P	P	P
		M	M	M	M	M	M	M	M	M
		K	K	K	K	K	K	K	K	K

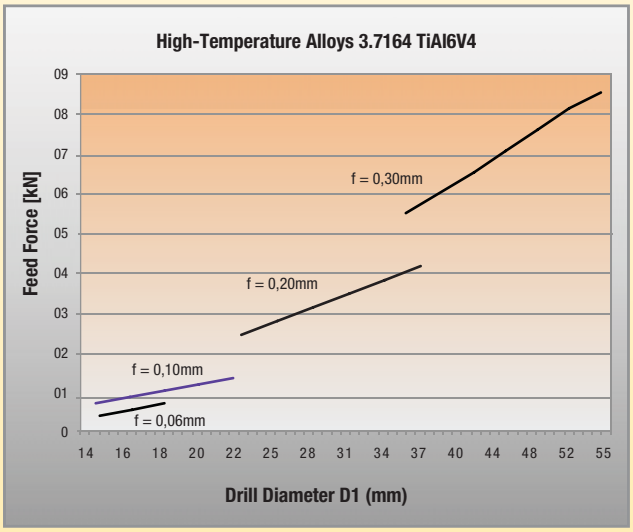


Feed Force Requirement

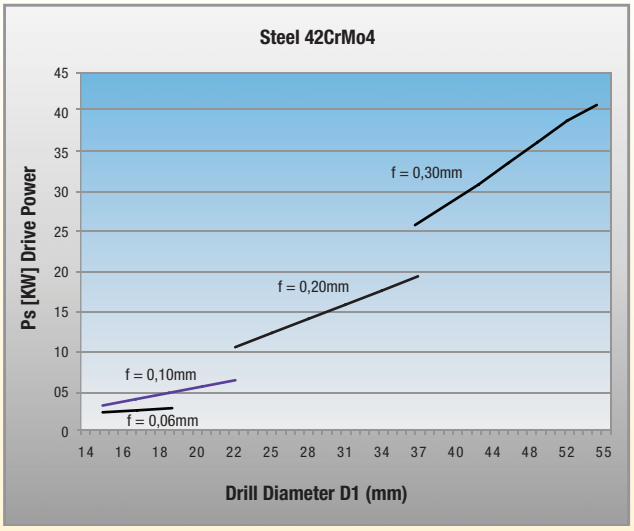


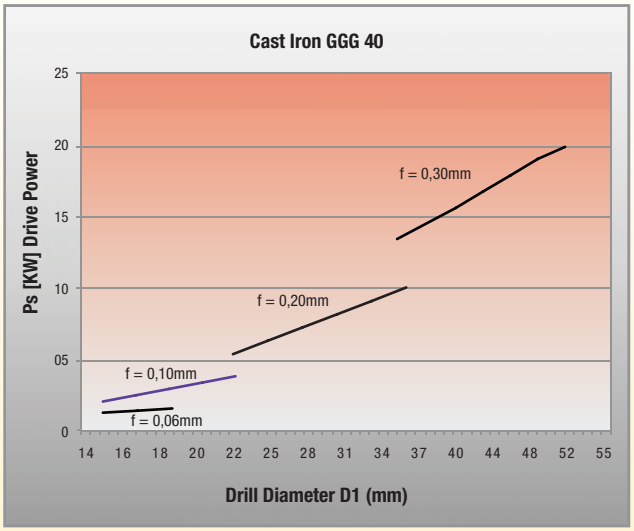


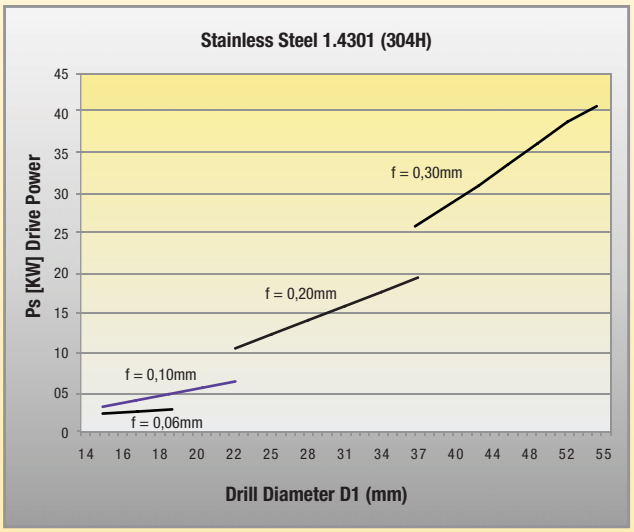


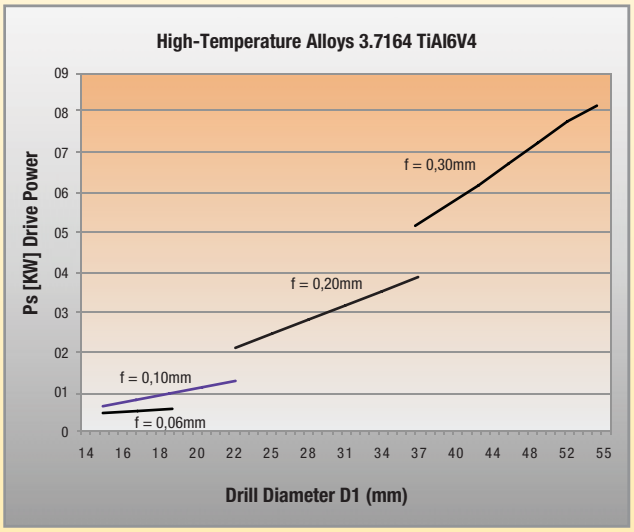


Power Recommendation

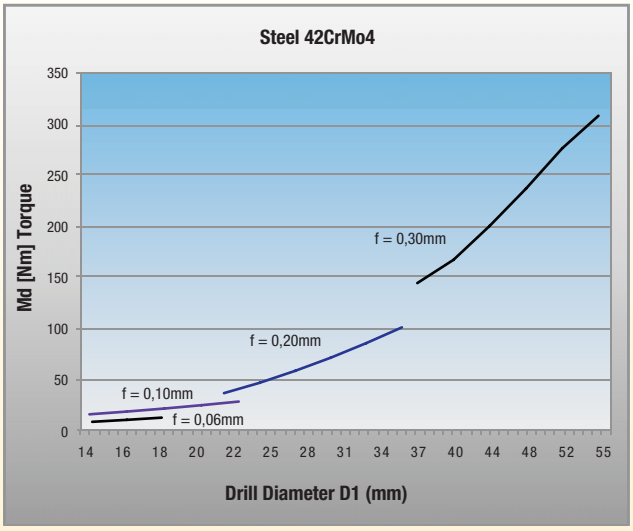


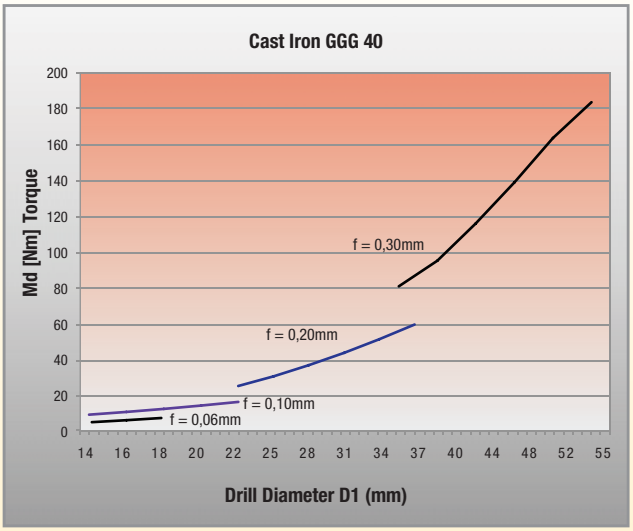


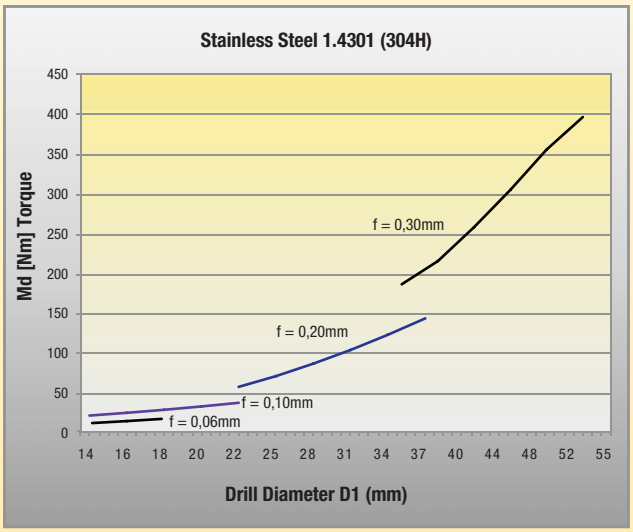


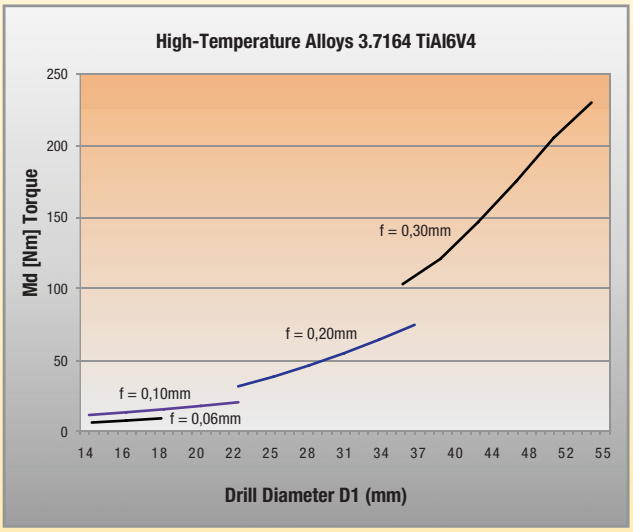


Torque Recommendation









NOVO KNOWS CAD/CAM

With the addition of NOVO™ applications to your team, your CAD/CAM capabilities become much more accurate, streamlined, and productive.

Before NOVO: The programmer would be in their CAD/CAM software, programming a part. Using the tedious method of finding a tool in a catalogue, and then manually inputting the tooling information from the catalogue into the CAD/CAM software.

The concern is that assumptions are made, and only partial tooling information is entered.

With NOVO: The powerful digital intelligence of NOVO applications not only help the programmer find the right tool for the metalcutting job, but also automatically integrates all the tooling data into a complete CAD/CAM solution. The integration of all the tooling data increases the viability of the part being programmed, and is delivered quickly — saving you time.

NOVO applications can ensure you have the right tools on your machines, in the right sequence. Resulting in flawless execution that accelerates every job, and maximises every shift. **kennametal.com/novo**



CTR™ Counterboring Tools

CTR counterboring tools are designed for high-production screw-head counterbores and similar counterboring operations. Tools can be adapted to almost all applications for optimum cutting performance and long tool life.

Extremely unequal insert positioning and flutes prevent chattering and generate less noise. A precise 90° bottom can be achieved with the S2 S inserts.

Features and Benefits

Productivity and Reliability

- S2 S inserts reduce additional drill operations to achieve a precise 90° bottom.
- Chatter-free operations for improved surface quality due to extremely unequal insert positioning and flutes.
- Achieve high metal removal rates to reduce machine time and manufacturing costs.

Versatility

- Counterboring tools can be used in steel, stainless steel, non-ferrous materials, cast irons, and heat-resistant alloy applications.
- Toolholders are double- or triple-fluted at a diameter range of 15–46mm (.591–1.811") with through-coolant capabilities.
- S2 S standard inserts are double-edged and available in various grades and geometries.

Achieve high metal removal rates to reduce machine time and manufacturing costs.

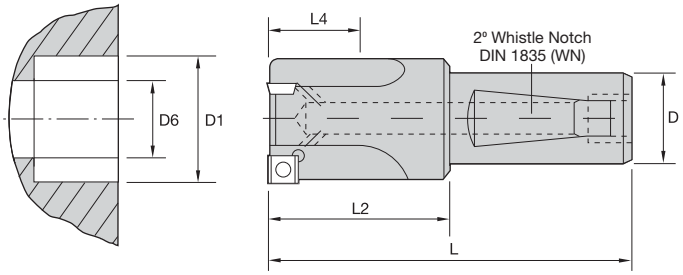


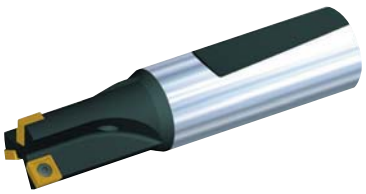
Customisation

- Length and diameter variations with and without adjustable cartridges available.
- Combination and multistep tooling based on drilling tools, like the Drill Fix™ system, with short distance and small diameter steps.
- Various radii and customised grades available upon request.

- Counterboring tool shipped with insert screws and Torx wrench.
- Order inserts separately; see pages J99–J101.







S2 S Whistle Notch WN Shank • Metric

catalogue number	D1	tol min D1	tol max D1	D	D6	L	L2	L4 max	gage insert	number of inserts
CBTF150R2WD20N2M	15,14	-0,120	0,120	20	6,0	81	31	8,5	SPHX060204R..	2
CBTF160R2WD20N2M	16,14	-0,120	0,120	20	7,0	81	31	8,5	SPHX060204R..	2
CBTF170R2WD20N2M	17,14	-0,120	0,120	20	8,0	86	36	13,5	SPHX060204R..	2
CBTF180R2WD20N2M	18,14	-0,120	0,120	20	8,4	86	36	13,5	SPHX070304R..	2
CBTF180R2WD20N3M	18,14	-0,120	0,120	20	8,4	86	36	13,5	SPHX060204R..	3
CBTF200R2WD20N2M	20,17	-0,120	0,120	20	8,5	86	36	16,0	SPHX070304R..	2
CBTF200R2WD20N3M	20,17	-0,120	0,120	20	8,5	86	36	16,0	SPHX060204R..	3
CBTF210R2WD20N2M	21,17	-0,120	0,120	20	8,5	86	36	16,0	SPHX070304R..	2
CBTF210R2WD20N3M	21,17	-0,120	0,120	20	10,5	86	36	11,0	SPHX060204R..	3
CBTF220R2WD20N2M	22,17	-0,120	0,120	20	10,4	86	36	16,0	SPHX070304R..	2
CBTF220R2WD20N3M	22,17	-0,120	0,120	20	10,5	86	36	16,0	SPHX060204R..	3
CBTF230R2WD20N2M	23,17	-0,120	0,120	20	10,5	91	41	21,0	SPHX090304R..	2
CBTF230R2WD20N3M	23,17	-0,120	0,120	20	10,5	91	41	16,0	SPHX070304R..	3
CBTF240R2WD20N2M	24,17	-0,120	0,120	20	10,5	91	41	18,5	SPHX090304R..	2
CBTF240R2WD20N3M	24,17	-0,120	0,120	20	10,5	91	41	16,0	SPHX070304R..	3
CBTF250R2WD20N2M	25,17	-0,120	0,120	20	12,0	96	46	23,5	SPHX090304R..	2
CBTF250R2WD20N3M	25,17	-0,120	0,120	20	10,5	96	46	21,0	SPHX070304R..	3
CBTF260R2WD20N2M	26,17	-0,120	0,120	20	13,0	96	46	23,5	SPHX090304R..	2
CBTF270R2WD20N3M	27,17	-0,120	0,120	20	10,5	96	46	21,0	SPHX090304R..	3
CBTF280R2WD20N3M	28,17	-0,120	0,120	20	15,0	101	51	23,5	SPHX090304R..	3
CBTF300R2WD20N3M	30,17	-0,120	0,120	20	15,0	101	51	23,0	SPHX090304R..	3
CBTF320R2WD20N3M	32,20	-0,120	0,120	20	17,0	101	51	23,0	SPHX090304R..	3
CBTF330R2WD20N3M	33,20	-0,120	0,120	20	17,0	101	51	25,5	SPHX090304R..	3
CBTF340R2WD32N3M	34,20	-0,120	0,120	32	18,0	111	51	25,5	SPHX090304R..	3
CBTF350R2WD32N3M	35,20	-0,120	0,120	32	19,0	111	51	25,5	SPHX090304R..	3
CBTF360R2WD32N3M	36,20	-0,120	0,120	32	19,0	116	56	27,5	SPHX090304R..	3
CBTF380R2WD32N3M	38,20	-0,120	0,120	32	22,0	121	61	30,0	SPHX120404R..	3
CBTF400R2WD32N3M	40,20	-0,120	0,120	32	21,0	121	61	30,5	SPHX120404R..	3
CBTF420R2WD32N3M	42,20	-0,120	0,120	32	22,0	126	66	33,5	SPHX120404R..	3
CBTF460R2WD32N3M	46,20	-0,120	0,120	32	25,0	126	66	33,5	SPHX120404R..	3

Spare Parts



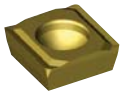


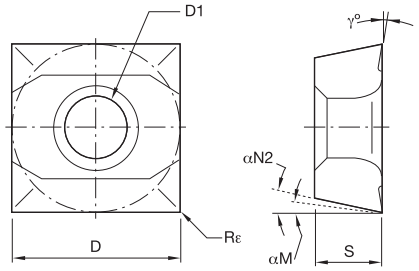
gage insert	insert screw	wrench	Torx size
SPHX060204R..	**192.432**	**170.028**	T8
SPHX070304R..	**192.432**	**170.028**	T8
SPHX090304R..	**191.924**	**170.024**	T9
SPHX120404R..	**191.916**	**170.025**	T15

- Double-sided insert style.

● first choice
○ alternate choice

		KCU25	KCU40	KC7215	KC7140
P		●	●	●	●
M		○	○	○	●
K		○	○	○	○
N					○
S					○
H					

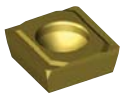


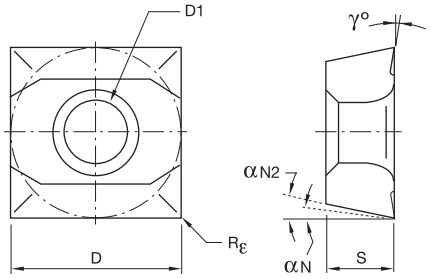


SPHX..R-20

catalogue number	D	D1	S	Rε	γ°	αN2	αN M	KCU25	KCU40	KC7215	KC7140
SPHX060202R20	6,35	2,85	2,38	0,20	12	11	7	–	–	●	–
SPHX060204R20	6,35	2,85	2,38	0,40	12	11	7	●	●	–	●
SPHX060206R20	6,35	2,85	2,38	0,60	12	11	7	–	–	●	–
SPHX060208R20	6,35	2,85	2,38	0,80	12	11	7	–	–	●	–
SPHX070302R20	7,94	2,85	3,18	0,20	12	11	7	–	–	●	–
SPHX070304R20	7,94	2,85	3,18	0,40	12	11	7	●	●	–	●
SPHX070306R20	7,94	2,85	3,18	0,60	12	11	7	–	–	●	–
SPHX070308R20	7,94	2,85	3,18	0,80	12	11	7	–	–	●	–
SPHX070310R20	7,94	2,85	3,18	1,00	12	11	7	–	–	●	–
SPHX070312R20	7,94	2,85	3,18	1,20	12	11	7	–	–	●	–
SPHX090304R20	9,53	3,50	3,18	0,40	12	11	7	●	●	●	●
SPHX090308R20	9,53	3,50	3,18	0,80	12	11	7	●	●	–	–
SPHX090310R20	9,53	3,50	3,18	1,00	12	11	7	–	–	●	–
SPHX090312R20	9,53	3,50	3,18	1,20	12	11	7	–	–	●	–
SPHX090316R20	9,53	3,50	3,18	1,60	12	11	7	–	–	●	–
SPHX120404R20	12,70	4,50	4,76	0,40	12	11	7	●	●	–	●
SPHX120408R20	12,70	4,50	4,76	0,80	12	11	7	●	●	–	–
SPHX120410R20	12,70	4,50	4,76	1,00	12	11	7	–	–	●	–
SPHX120412R20	12,70	4,50	4,76	1,20	12	11	7	–	–	●	–
SPHX120416R20	12,70	4,50	4,76	1,60	12	11	7	–	–	●	–
SPHX120420R20	12,70	4,50	4,76	2,00	12	11	7	–	–	●	–
SPHX150504R20	15,88	5,50	5,95	0,40	12	11	7	●	●	–	–
SPHX150508R20	15,88	5,50	5,95	0,80	12	11	7	●	●	–	–
SPHX150512R20	15,88	5,50	5,95	1,20	12	11	7	–	–	●	–
SPHX150516R20	15,88	5,50	5,95	1,60	12	11	7	–	–	●	–
SPHX150520R20	15,88	5,50	5,95	2,00	12	11	7	–	–	●	–

NOTE: SPHX...R-20: This geometry is first choice for steel applications.





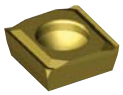
● first choice
○ alternate choice

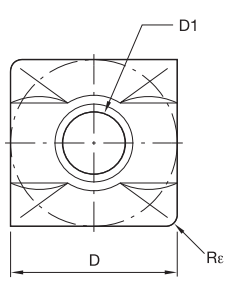
		KCPK10	KCU25	KCU40	KC7215	KM1
P		○	○	○	○	○
M				○	○	○
K		●	●	●	●	●
N						○
S				○	○	
H						

SPHX..R-21

catalogue number	D	D1	S	Rε	γ°	αN2	αN	KCPK10	KCU25	KCU40	KC7215	KM1
SPHX060202R21	6,35	2,85	2,38	0,20	4	11	7	–	–	–	●	–
SPHX060204R21	6,35	2,85	2,38	0,40	4	11	7	●	●	●	–	–
SPHX060204R-21	6,35	2,85	2,38	0,40	4	11	7	–	–	–	–	●
SPHX060206R21	6,35	2,85	2,38	0,60	4	11	7	–	–	–	●	–
SPHX060208R21	6,35	2,85	2,38	0,80	4	11	7	–	–	–	●	–
SPHX070304R21	7,94	2,85	3,18	0,40	4	11	7	●	●	●	–	–
SPHX070304R-21	7,94	2,85	3,18	0,40	4	11	7	–	–	–	–	●
SPHX070306R21	7,94	2,85	3,18	0,60	4	11	7	–	–	–	●	–
SPHX070308R21	7,94	2,85	3,18	0,80	4	11	7	●	–	●	–	–
SPHX070310R21	7,94	2,85	3,18	1,00	4	11	7	–	–	–	●	–
SPHX090304R21	9,53	3,50	3,18	0,40	4	11	7	●	●	●	–	–
SPHX090304R-21	9,53	3,50	3,18	0,40	4	11	7	–	–	–	–	●
SPHX090308R21	9,53	3,50	3,18	0,80	4	11	7	●	●	●	–	–
SPHX090310R21	9,53	3,50	3,18	1,00	4	11	7	–	–	–	●	–
SPHX090312R21	9,53	3,50	3,18	1,20	4	11	7	–	–	–	●	–
SPHX090316R21	9,53	3,50	3,18	1,60	4	11	7	–	–	–	●	–
SPHX120404R21	12,70	4,50	4,76	0,40	4	11	7	●	●	●	–	–
SPHX120404R-21	12,70	4,50	4,76	0,40	4	11	7	–	–	–	–	●
SPHX120408R21	12,70	4,50	4,76	0,80	4	11	7	–	–	–	●	–
SPHX120410R21	12,70	4,50	4,76	1,00	4	11	7	–	–	–	●	–
SPHX120412R21	12,70	4,50	4,76	1,20	4	11	7	–	–	–	●	–
SPHX120416R21	12,70	4,50	4,76	1,60	4	11	7	–	–	–	●	–
SPHX120420R21	12,70	4,50	4,76	2,00	4	11	7	–	–	–	●	–
SPHX150504R-21	15,88	5,50	5,95	0,40	4	11	7	–	–	–	–	●

NOTE: SPHX...R-21: This geometry is first choice for cast iron applications.





● first choice
○ alternate choice

P		
M		
K		○
N		●
S		
H		

SPHX..R-22

catalogue number	D	D1	S	Rε	γ°	αN2	αN M	KM1
SPHX060204R-22	6,35	2,85	2,38	0,40	25	11	–	●
SPHX070304R-22	7,94	2,85	3,18	0,40	25	11	–	●
SPHX090304R-22	9,53	3,50	3,18	0,40	25	11	–	●
SPHX120404R-22	12,70	4,50	4,76	0,40	25	11	–	●
SPHX150504R-22	15,88	5,50	5,95	0,40	25	11	7	●

NOTE: SPHX...R-22: This geometry is first choice for aluminium applications.



Hole Finishing

Introduction **K2–K5**

Tool Selection Guide K4–K5

RMS Solid Carbide Reaming **K6–K10**

RMR, RMB, and RMB-E Tipped Reaming **K12–K23**

RMR Disc Tipped Reaming K12, K15–K16, K22

RMB Cermet Tipped Reaming K13, K17–K18, K22

RMB-E Expansion Reaming K14, K19–K22

RHR, RHM, and RHM-E Modular Reaming **K24–K41**

RHR Disc Tipped Reaming K24, K27–K28, K36

RHM Cermet Tipped Reaming K25, K29–K32, K36

RHM-E Expansion Reaming K26, K33–K36

Modular Reaming Bodies K38–K41

SIF Steerable Toolholder **K42–K48**

RIR and RIQ Guided Reaming **K50–K67**

Romicron High-Performance Boring System **K68–K113**

ModBORE Boring Systems **K114–K145**

PCD Customised Tooling **K146–K150**

Application Examples **K152–K212**

Hole Finishing with Kennametal

Owning the entire process chain from raw materials to reconditioning makes Kennametal one of the few sources in the metalworking industry where you can get complete hole finishing tooling, from reaming and fine boring to motion tooling. Kennametal provides customised solutions that are the best fit for any application or machining challenge, without limitations from product portfolio or capacity.



PCD Tooling

- Extremely productive and tailored for satisfying your high-volume production needs.
- Several standard PCD grades, like KD1415™ and KD1425™, are available to provide the highest tool life and cutting data as well as unmatched surface and diameter tolerance quality.
- Platforms are available depending on your application and preference from steel to carbide based, adjustable pocket seats, fine-boring components like Romicron™ or FB cartridges, spindle couplings, or SIF™ steerable adaptors.



Multi-flute Reaming

- RMR™, RMB™, and RMB-E™ tipped reaming.
- RHR™, RHM™, and RHM-E™ modular reaming.
- Highly productive and easy to apply.
- Large, standard, off-the-shelf portfolio of solid carbide, cermet, carbide-tipped, and modular reaming tools, all ground to achieve H7 without any customisation.
- Complex specials with multiple steps, coupling, and length variations are available.
- Intermediate sizes, grades, and lead chamfers available with short delivery.

Motion Tooling

- Sophisticated tooling achieves most challenging tasks.
- Large, customised complex solution portfolio of:
  - — Linear feed-out heads.
  - — Eccentric actuating heads.
  - — Pivot heads.
  - — Cylinder boring tools.
  - — Line boring bars.
  - — Bottle boring tools.
  - — Valve seat and guide tools.
  - — Machining centre tools.
- Depending on your application and preference, tools are based on the positive-stop principle; use drawbars, like with engineered solution machines; or don't require machining centre modification.



Padded Reaming

- RIQ™ Quattro Cut™ and RIR™ reaming systems.
- Highest precision and surface quality achievable but still easy to apply.
- RIQ is the market-leading reaming technology that eliminates back taper adjustment, dramatically reduces setup time while still offering highest accuracy and surface quality, and offers four cutting edges with PCD, CBN, carbide, or cermet.
- RIR provides the most stable pocket seat and fail-safe clamping, from smallest to largest diameters.
- Combine the large, standard RIQ and RIR insert offering with your customised tool body.

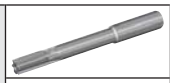


Fine Boring

- Romicron™ and ModBORE™ systems.
- Extremely flexible, with an extensive diameter and length range.
- Offers the latest grade technology using standard turning inserts.
- Romicron enables diameter modifications by hand directly at the machine without setup equipment or affecting lock screw accuracy.
- The ModBORE system offers a very large diameter range with each tool along, with roughing to finishing tooling, and can be easily and safely adapted to every KM™ spindle.



● first choice
○ alternate choice

			P	M	K	N	S	H	standard diameter range	standard diameter accuracy	custom solution diameter range	custom solution diameter accuracy	⊕	⌭
reaming tools		**RMS™** Solid *Carbide*	●	●	●	●	○		5–14mm	IT7	1,4–25,4mm	IT6 >10mm	10 µm	7 µm
		**RMR™** Disc Style *Carbide*	●	●	●	●	○		14–20mm	IT7	14–42mm	IT6	10 µm	7 µm
		**RMB™** Cermet Tipped *Cermet*	●		○	○			14–20mm	IT7	14–65mm	IT6	10 µm	7 µm
		**RMB-E™** Expandable Reamer *Carbide/Cermet*	●	●	●	●	○		14–42mm	IT6	14–42mm	IT5–IT6	10 µm	7 µm
		**RHR™** Modular Disc Style *Carbide*	●	●	●	●	○		14–42mm	IT7	14–42mm	IT6	10 µm	7 µm
		**RHM™** Modular Cermet Tipped *Cermet*	●		○	○			14–42mm	IT7	14–50mm	IT6	10 µm	7 µm
		**RHM-E™ (Expandable)** Modular Expandable Reamer *Carbide/Cermet*	●	●	●	●	○		14–42mm	IT6	14–42mm	IT5–IT6	10 µm	7 µm
		**RIR™** Reamer Insert Rectangular *Carbide*	●	●	●	●	●	○	–	–	6–300mm	IT5	10 µm	4 µm
		**Quattro Cut™ RIQ™** Reamer Insert Quattro Cut *Carbide/Cermet/PCD/CBN*	●	●	●	●	●	○	–	–	16–300mm	IT5	10 µm	4 µm
boring/fine-boring tools		**Romicron™ SVU BB** Fine Boring *Carbide/Cermet/PCD/CBN*	●	●	●	●	●	○	4–100mm	IT6	1,6–100mm	IT6	5 µm	5–10 µm
		**Romicron AVS00B–3B/SVS4B–6B** Fine Boring *Carbide/Cermet/PCD/CBN*	●	●	●	●	●	●	25–139mm	IT6	25–183mm	IT6	5 µm	5–10 µm
		**Romicron SVU65/92** Fine Boring *Carbide/Cermet/PCD/CBN*	●	●	●	●	●	○	71–213mm	IT6	10–326mm	IT6	5 µm	5–10 µm
		**Romicron SVS M** Fine Boring *Carbide/Cermet/PCD/CBN*	●	●	●	○	●	○	>40mm	IT6	40–1600mm	IT6	5 µm	5–10 µm
		**ModBORE™ RBHT** Roughing *Carbide/Cermet/PCD/CBN*	●	●	●	●	●		23,5–153mm	IT9	23,5–153mm	IT9	10 µm	>20 µm
		**ModBORE FBHO** Fine Boring *Carbide/Cermet/PCD/CBN*	●	●	●	●	●	○	9,75–88,1mm	IT7	3,0–88,1mm	IT7	5 µm	5–10 µm
		**ModBORE FBHM** Fine Boring *Carbide/Cermet/PCD/CBN*	●	●	●	●	●	○	9,75–320mm	IT7	3,0–320mm	IT7	5 µm	5–10 µm
		**ModBORE FBHS** Fine Boring *Carbide/Cermet/PCD/CBN*	●	●	●	●	●	○	23,5–153mm	IT7	23,5–153mm	IT7	5 µm	5–10 µm
		**ModBORE Bridge Tools** Roughing *Carbide/Cermet/PCD/CBN*	●	●	●	●	●		150–2205mm	IT9	150–2205mm	IT9	10 µm	>20 µm
		**ModBORE Bridge Tools** Fine Boring *Carbide/Cermet/PCD/CBN*	●	●	●	●	●		150–2205mm	IT7	150–2205mm	IT7	5 µm	>10 µm
		**Fine Boring Cartridges** Fine Boring *Carbide/Cermet/PCD/CBN*	●	○	●	●	○		>28mm	IT7	>28mm	IT7	5 µm	5–10 µm
PCD		**PCD** Round Tools *Steel Base*				●			–	–	10–100mm	IT6	10 µm	10 µm
		**PCD** Round Tools *Carbide Base*				●			–	–	5–25mm	IT6	5 µm	7 µm

⌭ Cylindricity
NOTE: Process- and application-dependent.
Highly dependent on the pre-machine hole accuracy.
Use of high-performance drilling/pre-machining tools mandatory to reach values.

⊕ Position
NOTE: Process- and application-dependent.
Highly dependent on the pre-machine hole accuracy.
Use of high-performance drilling/pre-machining tools mandatory to reach values.

achievable surface quality Ra						capability				cost/part	cycle time	required operator experience	page(s)
P	M	K	N	S	H								
0,5–1,0 µm	0,5–1,0 µm	0,5–1,5 µm	–	0,5–1,0 µm	–	●	●	●	●	moderate	low	low	K6–K10
0,2–0,6 µm	0,5–1,0 µm	0,5–1,0 µm	–	0,5–1,0 µm	–	●	●	●	●	low	low	low	K12, K15–K16, K22
0,2–0,6 µm	–	0,5–1,5 µm	0,1–0,6 µm	–	–	●	●	●	●	moderate	low	low	K13, K17–K18, K22
0,5–1,0 µm	0,5–1,0 µm	0,5–1,5 µm	–	0,5–1,0 µm	–	●	●	●	●	moderate	low	moderate	K14, K19–K22
0,2–0,6 µm	0,5–1,0 µm	0,5–1,0 µm	–	0,5–1,0 µm	–	●	●	●	●	moderate	low	low	K24, K27–K28, K36
0,2–0,6 µm	–	0,5–1,5 µm	0,1–0,6 µm	–	–	●	●	●	●	moderate	low	low	K25, K29–K32, K36
0,5–1,0 µm	0,5–1,0 µm	0,5–1,5 µm	–	0,5–1,0 µm	–	●	●	●	●	moderate	low	moderate	K26, K33–K36
0,2–0,6 µm	0,5–1,6 µm	0,5–1,8 µm	0,1–0,6 µm	<08 µm	<08 µm	●	●	●	●	low	moderate	high	K50–K54, K57–K61
0,2–0,6 µm	0,5–1,6 µm	0,5–1,8 µm	0,1–0,6 µm	<08 µm	<08 µm	●	●	●	●	low	moderate	moderate	K50–K52, K54–K61
0,8–2,0 µm	0,8–2,0 µm	0,8–2,0 µm	0,8–2,0 µm	0,8–2,0 µm	<1,2 µm	●	●	○	○	low	moderate	low	K72–K76
0,8–2,0 µm	0,8–2,0 µm	0,8–2,0 µm	0,8–2,0 µm	0,8–2,0 µm	<1,2 µm	●	●	●	●	low	moderate	low	K78–K82
0,8–2,0 µm	0,8–2,0 µm	0,8–2,0 µm	0,8–2,0 µm	0,8–2,0 µm	<1,2 µm	●	●	○	○	low	moderate	low	K84–K85
0,8–2,0 µm	0,8–2,0 µm	0,8–2,0 µm	0,8–2,0 µm	0,8–2,0 µm	<1,2 µm	●	●	●	●	low	moderate	low	please contact us
1,0–5,0 µm	1,0–5,0 µm	1,0–5,0 µm	1,0–2,0 µm	1,0–5,0 µm	–	●	●	●	●	low	low	low–moderate	K118–K122
0,8–2,0 µm	0,8–2,0 µm	0,8–2,0 µm	0,8–2,0 µm	0,8–2,0 µm	<1,2 µm	●	●	●	●	low	moderate	low–moderate	K124–K125
0,8–2,0 µm	0,8–2,0 µm	0,8–2,0 µm	0,8–2,0 µm	0,8–2,0 µm	<1,2 µm	●	●	●	●	low	moderate	low–moderate	K128–K132
0,8–2,0 µm	0,8–2,0 µm	0,8–2,0 µm	0,8–2,0 µm	0,8–2,0 µm	<1,2 µm	●	●	●	●	low	moderate	low–moderate	K133–K137
1,0–5,0 µm	1,0–5,0 µm	1,0–5,0 µm	1,0–2,0 µm	1,0–5,0 µm	–	●	●	●	●	low	low	low–moderate	K137–K141
0,8–2,0 µm	0,8–2,0 µm	0,8–2,0 µm	0,8–2,0 µm	0,8–2,0 µm	–	●	●	●	●	low	moderate	low–moderate	K137–K141
0,8–2,0 µm	0,8–2,0 µm	0,8–2,0 µm	0,8–2,0 µm	0,8–2,0 µm	–	●	●	○	○	low	moderate	low–moderate	K111–K113
–	–	–	0,1–0,8 µm	–	–	●	●	●	●	low	very low	moderate	K146–K150
–	–	–	0,1–0,8 µm	–	–	●	●	●	●	low	very low	moderate	K146–K150

Ra Surface roughness

NOTE: Surface roughness values are guidelines and depend on the application, coolant situation, machine, and cutting data applied.

RMS™ Multi-Flute Reaming Tools

RMS™ multi-flute reaming tools achieve the highest metal removal rates in 5–14mm (.197–.551") diameters. All standard reamers are ground to an ISO H7 tolerance class hole to address common applications. Specific coatings and lead configurations enable high-speed machining of steel, stainless steel, cast iron, and non-ferrous materials at accelerated speeds.



Primary Application

Use standard SIF™ steerable hydraulic chucks or SIF adaptors for easy compensation of radial runout and angular inaccuracies of the spindle to achieve the highest possible hole straightness and surface quality.

Features and Benefits

Higher Productivity and Profitability

- Longer tool life with increased hole and surface quality due to lapped ground leads.
- Highest metal removal rates at higher speeds and feeds due to reaming-specific grades and substrates.
- Improved straightness and cylindrical form compared to competitive tools, and reduced vibration due to unequal flutes.
- All RMS reamers have internal coolant capability.

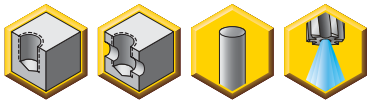
RMS™ multi-flute reaming tools achieve highest metal removal rates from 5–14mm (.197–.551").

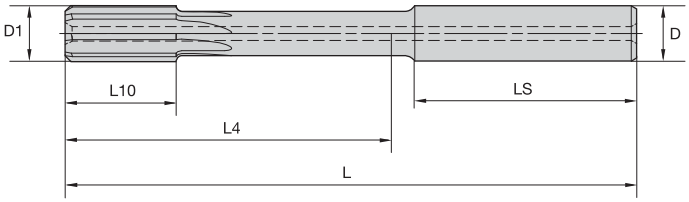


Customisation

- Diameters 1,40–14,15mm (.055–.557") available with and without internal coolant in 0,001mm (.00004") steps.
- Intermediate diameters of standard programme available as simple specials with short delivery time.
- Solid cermet reaming tools and tooling for heat-resistant materials are available on request.

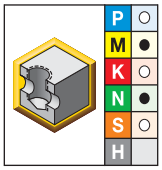
- For hole tolerance H7.
- Intermediate sizes ground to achieve IT7 hole tolerance class available.
- Starting with Ø 10mm in IT6 hole tolerance available.

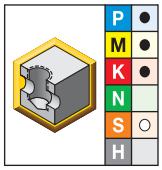






RMS • Blind Hole Solid Carbide Reamer with Internal Coolant





● first choice
○ alternate choice

K605	KC6305	D1	D	L	L4	L10	LS	Z
RMS05000H7SF	RMS05000H7SF	5,00	6,00	74,0	32,0	12,0	36,0	4
RMS05500H7SF *	RMS05500H7SF	5,50	6,00	74,0	32,0	12,0	36,0	4
RMS06000H7SF	RMS06000H7SF	6,00	6,00	74,0	32,0	12,0	36,0	4
RMS06500H7SF	RMS06500H7SF	6,50	8,00	91,0	49,0	16,0	36,0	4
RMS07000H7SF	RMS07000H7SF	7,00	8,00	91,0	49,0	16,0	36,0	4
RMS08000H7SF	RMS08000H7SF	8,00	8,00	91,0	49,0	16,0	36,0	6
RMS09000H7SF	RMS09000H7SF	9,00	10,00	103,0	57,0	20,0	40,0	6
RMS10000H7SF	RMS10000H7SF	10,00	10,00	103,0	57,0	20,0	40,0	6
RMS11000H7SF	RMS11000H7SF	11,00	12,00	118,0	67,0	24,0	45,0	6
RMS12000H7SF	RMS12000H7SF	12,00	12,00	118,0	67,0	24,0	45,0	6
RMS13000H7SF	RMS13000H7SF	13,00	14,00	132,0	81,0	28,0	45,0	6
RMS14000H7SF	RMS14000H7SF	14,00	14,00	132,0	81,0	28,0	45,0	6

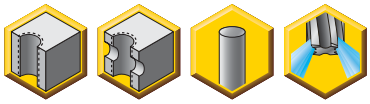
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

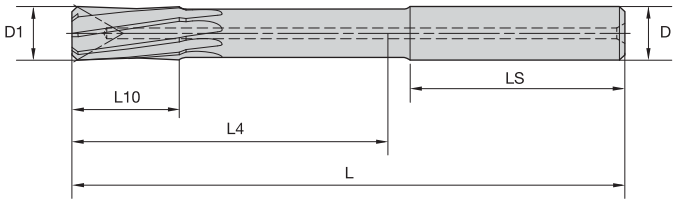
Dimensions for Engineered-Solution Reamers

D1 min	D1 max	D	L	L4	L10	LS	
mm	mm	mm	mm	mm	mm	mm	Z
14,000	15,999	16	147,4	92,4	7,5	49	6
16,000	17,999	20	159,4	102,4	7,5	51	6
18,000	20,000	20	173,4	116,4	7,5	51	6
20,001	22,499	20	202,4	145,4	7,5	51	6
22,500	24,999	20	212,4	155,4	7,5	51	6
25,000	27,499	25	232,4	169,4	7,5	57	8
27,500	29,999	25	242,4	179,4	7,5	57	8
30,000	32,499	25	272,4	209,4	7,5	57	8
32,500	34,999	32	272,4	205,4	7,5	61	8
35,000	37,499	32	272,4	205,4	7,5	61	8
37,500	39,999	32	272,4	205,4	7,5	61	8
40,000	42,500	32	272,4	205,4	7,5	61	8

NOTE: The above dimensions are used when ordering engineered-solution reamers on this page unless otherwise specified.

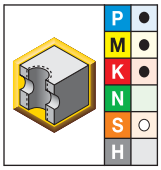
- For hole tolerance H7.
- Intermediate sizes ground to achieve IT7 hole tolerance class available.
- Starting with Ø 10mm in IT6 hole tolerance available.

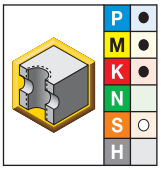






RMS • Through Hole Solid Carbide Reamer with Internal Coolant





● first choice
○ alternate choice

K605	KC6305	D1	D	L	L4	L10	LS	Z
RMS05000H7HF	RMS05000H7HF	5,00	6,00	74,0	32,0	12,0	36,0	4
RMS05500H7HF	RMS05500H7HF	5,50	6,00	74,0	32,0	12,0	36,0	4
RMS06000H7HF	RMS06000H7HF	6,00	6,00	74,0	32,0	12,0	36,0	4
RMS06500H7HF	RMS06500H7HF	6,50	8,00	91,0	49,0	16,0	36,0	4
RMS07000H7HF	RMS07000H7HF	7,00	8,00	91,0	49,0	16,0	36,0	4
RMS08000H7HF	RMS08000H7HF	8,00	8,00	91,0	49,0	16,0	36,0	6
RMS09000H7HF *	RMS09000H7HF	9,00	10,00	103,0	57,0	20,0	40,0	6
RMS10000H7HF	RMS10000H7HF	10,00	10,00	103,0	57,0	20,0	40,0	6
RMS11000H7HF	RMS11000H7HF	11,00	12,00	118,0	67,0	24,0	45,0	6
RMS12000H7HF	RMS12000H7HF	12,00	12,00	118,0	67,0	24,0	45,0	6
RMS13000H7HF	RMS13000H7HF	13,00	14,00	132,0	81,0	28,0	45,0	6
RMS14000H7HF	RMS14000H7HF	14,00	14,00	132,0	81,0	28,0	45,0	6

NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Dimensions for Engineered-Solution Reamers

D1 min	D1 max	D	L	L4	L10	LS	
mm	mm	mm	mm	mm	mm	mm	Z
14,000	15,999	16	147,4	92,4	7,5	49	6
16,000	17,999	20	159,4	102,4	7,5	51	6
18,000	20,000	20	173,4	116,4	7,5	51	6
20,001	22,499	20	202,4	145,4	7,5	51	6
22,500	24,999	20	212,4	155,4	7,5	51	6
25,000	27,499	25	232,4	169,4	7,5	57	8
27,500	29,999	25	242,4	179,4	7,5	57	8
30,000	32,499	25	272,4	209,4	7,5	57	8
32,500	34,999	32	272,4	205,4	7,5	61	8
35,000	37,499	32	272,4	205,4	7,5	61	8
37,500	39,999	32	272,4	205,4	7,5	61	8
40,000	42,500	32	272,4	205,4	7,5	61	8

NOTE: The above dimensions are used when ordering engineered-solution reamers on this page unless otherwise specified.

RMS™ • Metric

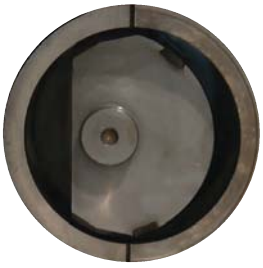
Material Group		straight flute			helical flute			Metric						
		K605			KC6305			Cutting Speed — vc						
		Range — m/min						Tool Diameter (mm)	Recommended Feed Rate per Tooth					
									4,16–7,15mm		7,16–9,59mm		9,60–14,00mm	
		min	Starting Value	max	min	Starting Value	max	Feed/ Tooth	min	max	min	max	min	max
P	1	40	**60**	70	90	**120**	155	mm/z	0,05	0,10	0,05	0,12	0,05	0,15
	2	40	**60**	70	90	**120**	155	mm/z	0,05	0,10	0,05	0,12	0,05	0,15
	3	35	**50**	60	75	**100**	130	mm/z	0,05	0,10	0,05	0,12	0,05	0,15
	4	25	**40**	45	60	**80**	105	mm/z	0,05	0,10	0,05	0,12	0,05	0,15
	5	15	**20**	25	30	**40**	55	mm/z	0,04	0,08	0,04	0,10	0,04	0,12
	6	15	**20**	25	30	**40**	55	mm/z	0,04	0,08	0,04	0,10	0,04	0,12
M	1	8	**10**	15	15	**20**	28	mm/z	0,04	0,08	0,04	0,09	0,04	0,10
	2	8	**10**	15	15	**20**	28	mm/z	0,04	0,08	0,04	0,09	0,04	0,10
	3	8	**10**	15	15	**20**	28	mm/z	0,04	0,08	0,04	0,09	0,04	0,10
K	1	35	**50**	60	75	**100**	130	mm/z	0,05	0,16	0,05	0,18	0,05	0,20
	2	25	**40**	50	60	**90**	110	mm/z	0,05	0,14	0,05	0,16	0,05	0,18
	3	20	**30**	45	60	**80**	105	mm/z	0,05	0,12	0,05	0,14	0,05	0,16
N	1	110	**150**	195	–	**–**	–	mm/z	0,06	0,16	0,06	0,18	0,06	0,20
	2	110	**150**	195	–	**–**	–	mm/z	0,06	0,16	0,06	0,18	0,06	0,20
	3	110	**150**	195	–	**–**	–	mm/z	0,06	0,16	0,06	0,18	0,06	0,20
	4	110	**150**	195	–	**–**	–	mm/z	0,06	0,16	0,06	0,18	0,06	0,20
	5	105	**140**	180	–	**–**	–	mm/z	0,06	0,16	0,06	0,18	0,06	0,20
S	1	8	**10**	15	15	**20**	28	mm/z	0,04	0,08	0,04	0,10	0,04	0,12
	2	8	**10**	15	15	**20**	28	mm/z	0,04	0,08	0,04	0,10	0,04	0,12
	3	15	**20**	30	20	**30**	40	mm/z	0,05	0,10	0,05	0,12	0,05	0,15
	4	15	**20**	30	20	**30**	40	mm/z	0,05	0,10	0,05	0,12	0,05	0,15

Revolution in **Crank Boring**

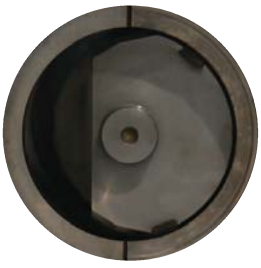


Our asymmetrical line boring bar (LBB) is an ideal solution for crank bore machining. It has the same advantages of a regular LBB, but can be used on machining centres. Setup is done outside of the machine on standard optical presetters. Asymmetrical LBBs feature RI8 inserts made from PCD or carbide, with eight cutting edges per insert for highly economical machining.





Feed in/out



Machining

Ask your Kennametal specialist about asymmetrical line boring.

Experience the advantages at your Authorised Kennametal Distributor or at **kennametal.com**.

KENNAMETAL®

kennametal.com

RMR™ Disc Reaming

Primary Application

In comparison to solid carbide reamers or single-tipped reamers, RMR disc reamers are the economic alternative without disadvantages to productivity or hole quality. Combine RMR disc reamers with the Kennametal SIF™ steerable holder for best results.



Features and Benefits

- Solid carbide disc at front instead of single-tipped carbide blanks.
- Unique coating specifically for reaming applications.
- High-speed and high-performance ready.
- Superior surface finish due to lapped ground leads.
- Improved hole straightness and roundness due to unequal flute spacing (less vibrations) and runout <3 microns.
- Helical and straight flutes for chip control in through and blind holes.
- Adjustment screw with straight-fluted RMR reamers to change internal coolant supply from axial to radial.

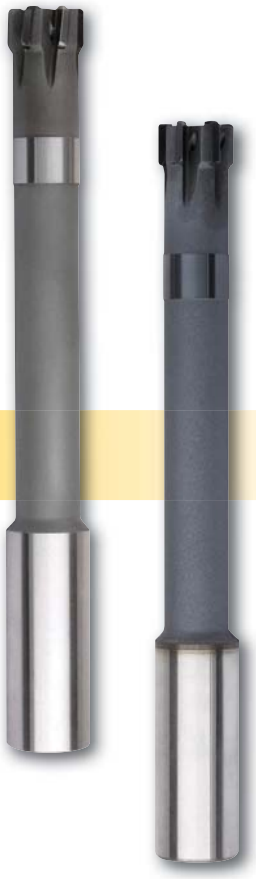
Customisation

- All diameters between 14–42,5mm (.5512–1.6732").
- Variation of leads and cylindrical margin for application-specific optimisation.

RMB™ Cermet Tipped Reamers

Primary Application

RMB™ multi-flute reamers are tipped with cermet blanks and are available in 14–20mm (.5512–.7874") diameters off-the-shelf and up to 50mm (1.968") as custom solutions. Cermet reamers provide excellent tool life and surface finishes in steel applications. Combine RMB reamers with the Kennametal SIF™ steerable holder for best results.



Features and Benefits

Higher productivity and profitability

- Longer tool life with increased hole and surface quality due to lapped ground leads.
- Cermet enables highest metal removal rates at higher speeds and feeds in steel.
- Improved straightness and cylindrical form compared to competitive tools and reduced vibration due to unequal flutes.
- Adjustment screw with straight-fluted RMB reamers to change internal coolant supply from axial to radial.

Customisation

- Diameters up to 50mm (1.968") available with and without internal coolant in 0,001mm (.00004") steps.
- Intermediate diameters from standard offering available as simple specials with short delivery time.
- RMB tooling for machining heat-resistant materials available on request.

RMB-E™ Expandable Reamers

Primary Application

The original idea behind an expansion reamer is to achieve more regrinds. The expansion mechanism is designed for this purpose only.

The Kennametal expandable reaming system is different. It offers a completely linear expansion rate of 2 microns per 30° turn, over an expansion rate of 48 microns. The micron adjustability of this system eliminates manufacturing tolerances and enables machining to the tightest tolerances, typically achieved only by using an uncoated tool or guide pad reaming. No presetting equipment is required.



Features and Benefits

Precision and Productivity

- Use with SIF™ steerable chucks for KST toolholders for easy compensation of radial runout and angular inaccuracies.
- Tools are preadjusted to hit IT6 tolerance.
- Expansion range of 48 microns.
- Completely linear expansion.
- 2 microns per 30° turn.

Increased Tool Life

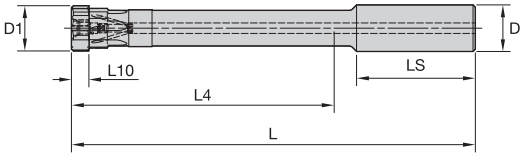
- Longer tool life at smaller tolerances.

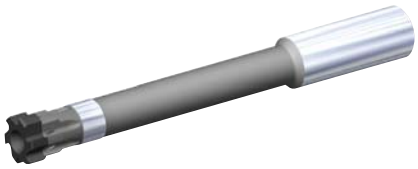
Customisation

- Diameters up to 42mm (1.65") available with helical and straight flutes in 0,001mm (.00004") increments.

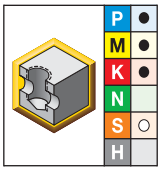
- For hole tolerance H7.
- Intermediate sizes ground to achieve IT6 or IT7 hole tolerance class available.
- Adjustment screw to change internal coolant supply from axial to radial.







RMR • Disc Style Reamer • Straight Fluted for Blind Holes with Internal Coolant



● first choice
○ alternate choice

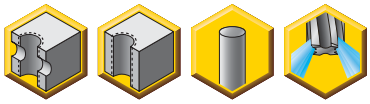
KCU05	D1	D	L	L4	L10	LS	Z
RMR14000H7SF	14,00	16,000	147,4	92,4	7,50	49,00	6
RMR15000H7SF	15,00	16,000	147,4	92,4	7,50	49,00	6
RMR16000H7SF	16,00	20,000	159,4	102,4	7,50	51,00	6
RMR17000H7SF	17,00	20,000	159,4	102,4	7,50	51,00	6
RMR18000H7SF	18,00	20,000	173,4	116,4	7,50	51,00	6
RMR19000H7SF	19,00	20,000	173,4	116,4	7,50	51,00	6
RMR20000H7SF	20,00	20,000	173,4	116,4	7,50	51,00	6

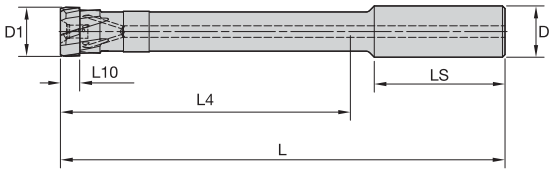
Dimensions for Engineered-Solution Reamers

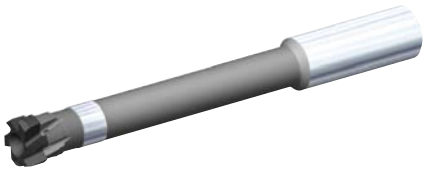
D1 min	D1 max	D	L	L4	L10	LS	
mm	mm	mm	mm	mm	mm	mm	Z
14,000	15,999	16	147,4	92,4	7,5	49	6
16,000	17,999	20	159,4	102,4	7,5	51	6
18,000	20,000	20	173,4	116,4	7,5	51	6
20,001	22,499	20	202,4	145,4	7,5	51	6
22,500	24,999	20	212,4	155,4	7,5	51	6
25,000	27,499	25	232,4	169,4	7,5	57	8
27,500	29,999	25	242,4	179,4	7,5	57	8
30,000	32,499	25	272,4	209,4	7,5	57	8
32,500	34,999	32	272,4	205,4	7,5	61	8
35,000	37,499	32	272,4	205,4	7,5	61	8
37,500	39,999	32	272,4	205,4	7,5	61	8
40,000	42,500	32	272,4	205,4	7,5	61	8

NOTE: The above dimensions are used when ordering engineered-solution reamers on this page unless otherwise specified.

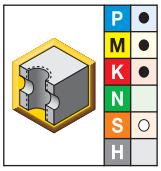
- For hole tolerance H7.
- Intermediate sizes ground to achieve IT6 or IT7 hole tolerance class available.







RMR • Disc Style Reamer • Helical Fluted for Through Holes with Internal Coolant



● first choice
○ alternate choice

KCU05	D1	D	L	L4	L10	LS	Z
RMR14000H7HF	14,00	16,00	147,4	92,4	7,5	49,00	6
RMR15000H7HF	15,00	16,00	147,4	92,4	7,5	49,00	6
RMR16000H7HF	16,00	20,00	159,4	102,4	7,5	51,00	6
RMR17000H7HF	17,00	20,00	159,4	102,4	7,5	51,00	6
RMR18000H7HF	18,00	20,00	173,4	116,4	7,5	51,00	6
RMR19000H7HF	19,00	20,00	173,4	116,4	7,5	51,00	6
RMR20000H7HF	20,00	20,00	173,4	116,4	7,5	51,00	6

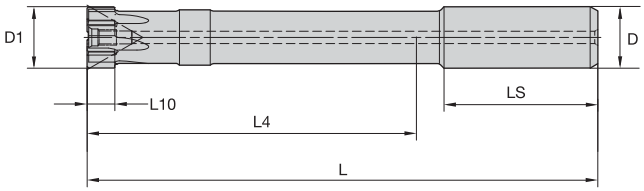
Dimensions for Engineered-Solution Reamers

D1 min	D1 max	D	L	L4	L10	LS	
mm	mm	mm	mm	mm	mm	mm	Z
14,000	15,999	16	147,4	92,4	7,5	49	6
16,000	17,999	20	159,4	102,4	7,5	51	6
18,000	20,000	20	173,4	116,4	7,5	51	6
20,001	22,499	20	202,4	145,4	7,5	51	6
22,500	24,999	20	212,4	155,4	7,5	51	6
25,000	27,499	25	232,4	169,4	7,5	57	8
27,500	29,999	25	242,4	179,4	7,5	57	8
30,000	32,499	25	272,4	209,4	7,5	57	8
32,500	34,999	32	272,4	205,4	7,5	61	8
35,000	37,499	32	272,4	205,4	7,5	61	8
37,500	39,999	32	272,4	205,4	7,5	61	8
40,000	42,500	32	272,4	205,4	7,5	61	8

NOTE: The above dimensions are used when ordering engineered-solution reamers on this page unless otherwise specified.

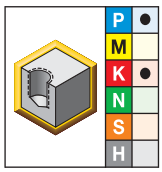
- For hole tolerance H7.
- Intermediate sizes ground to achieve IT6 or IT7 hole tolerance class available.
- Adjustment screw to change internal coolant supply from axial to radial.







RMB • Blind Hole Cermet-Tipped Reamer



● first choice
○ alternate choice

KT6215	D1	D	L	L4	L10	LS	Z
RMB14000H7SF *	14,00	16,00	145,0	76,0	8,0	49,0	6
RMB15000H7SF	15,00	16,00	145,0	76,0	8,0	49,0	6
RMB16000H7SF	16,00	20,00	157,0	86,0	8,0	51,0	6
RMB17000H7SF *	17,00	20,00	157,0	86,0	8,0	51,0	6
RMB18000H7SF *	18,00	20,00	171,0	100,0	8,0	51,0	6
RMB19000H7SF *	19,00	20,00	171,0	100,0	8,0	51,0	6
RMB20000H7SF *	20,00	20,00	200,0	129,0	8,0	51,0	6

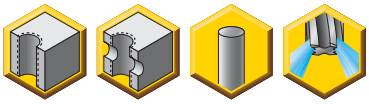
NOTE: Uncoated carbide grade K605™ and uncoated cermet grade KT325™ are available on request.
*Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

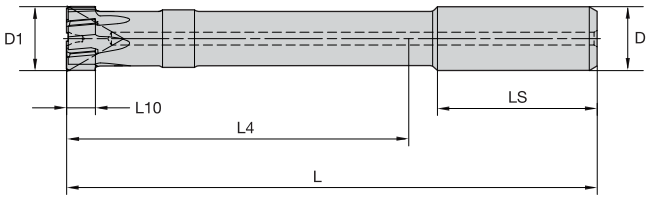
Dimensions for Engineered-Solution Reamers

D1 min	D1 max	D	L	L4	L10	LS	
mm	mm	mm	mm	mm	mm	mm	Z
14,000	15,999	16	145	76	8	49	6
16,000	17,999	20	157	86	8	51	6
18,000	19,999	20	171	100	8	51	6
20,000	21,999	20	200	129	8	51	6
22,000	25,999	20	210	139	10	51	6
26,000	29,999	25	240	163	10	57	8
30,000	32,000	25	270	193	12	57	8

NOTE: The above dimensions are used when ordering engineered-solution reamers on this page unless otherwise specified.

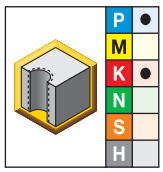
- For hole tolerance H7.
- Intermediate sizes ground to achieve IT6 or IT7 hole tolerance class available.
- Adjustment screw to change internal coolant supply from axial to radial.







RMB • Through Hole Cermet-Tipped Reamer



● first choice
○ alternate choice

KT6215	D1	D	L	L4	L10	LS	Z
RMB14000H7HF *	14,00	16,00	145,0	76,0	7,6	49,0	6
RMB15000H7HF *	15,00	16,00	145,0	76,0	7,6	49,0	6
RMB16000H7HF	16,00	20,00	157,0	86,0	7,6	51,0	6
RMB18000H7HF *	18,00	20,00	171,0	100,0	7,6	51,0	6
RMB19000H7HF *	19,00	20,00	171,0	100,0	7,6	51,0	6
RMB20000H7HF *	20,00	20,00	200,0	129,0	7,6	51,0	6

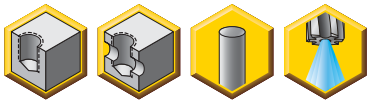
NOTE: Uncoated carbide grade K605™ is available on request.
*Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

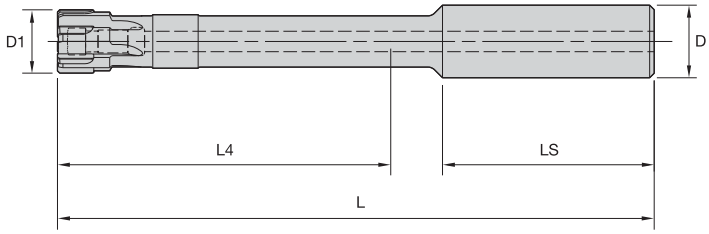
Dimensions for Engineered-Solution Reamers

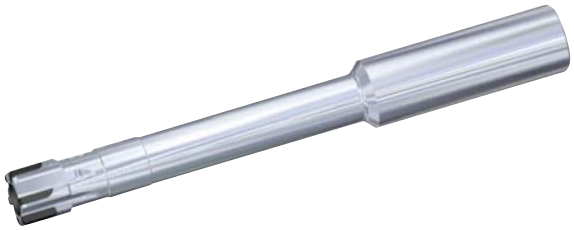
D1 min	D1 max	D	L	L4	L10	LS	
mm	mm	mm	mm	mm	mm	mm	Z
14,000	15,999	16	145	76	8	49	6
16,000	17,999	20	157	86	8	51	6
18,000	19,999	20	171	100	8	51	6
20,000	21,999	20	200	129	8	51	6
22,000	25,999	20	210	139	10	51	6
26,000	29,999	25	240	163	10	57	8
30,000	32,000	25	270	193	12	57	8

NOTE: The above dimensions are used when ordering engineered-solution reamers on this page unless otherwise specified.

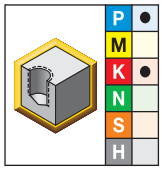
- For hole tolerance H6.
- Intermediate sizes available.
- Allen expansion screw.

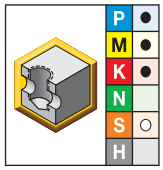






RMB-E • Blind Hole Expansion Reamer





● first choice
○ alternate choice

KC6005	KC6305	D1	D	L	L4	LS	Z
RMBE14000H6SF *	RMBE14000H6SF	14,00	16,00	131,5	72,5	49,0	6
RMBE15000H6SF *	RMBE15000H6SF *	15,00	16,00	136,5	77,5	49,0	6
RMBE16000H6SF *	RMBE16000H6SF *	16,00	20,00	143,5	82,5	54,4	6
RMBE17000H6SF *	RMBE17000H6SF *	17,00	20,00	148,5	87,5	51,0	6
RMBE18000H6SF *	RMBE18000H6SF *	18,00	20,00	153,5	92,5	51,0	6
RMBE19000H6SF *	RMBE19000H6SF	19,00	20,00	158,5	97,5	51,0	6
RMBE20000H6SF *	RMBE20000H6SF *	20,00	25,00	169,8	102,5	57,0	6

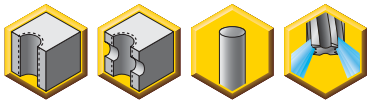
NOTE: Uncoated carbide grade K605™ and uncoated cermet grade KT325™ are available on request.
*Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

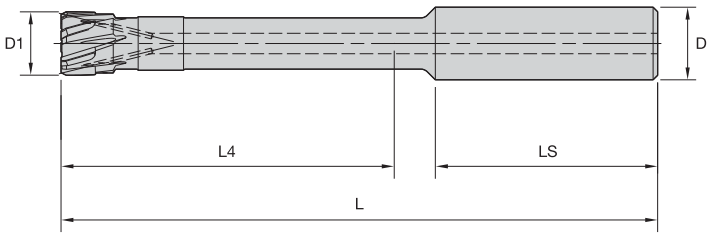
Dimensions for Engineered-Solution Reamers

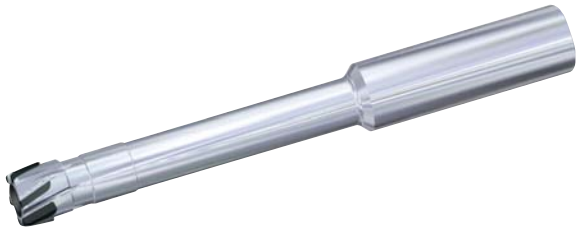
D1 min	D1 max	D	L	L4	LS	
mm	mm	mm	mm	mm	mm	Z
14,000	14,499	16	131,5	72,5	49	6
14,500	14,999	16	134,0	75,0	49	6
15,000	15,499	16	136,5	77,5	49	6
15,500	15,999	16	139,0	80,0	49	6
16,000	16,499	20	143,5	82,5	51	6
16,500	16,999	20	146,0	85,0	51	6
17,000	17,499	20	148,5	87,5	51	6
17,500	17,999	20	151,0	90,0	51	6
18,000	18,499	20	153,5	92,5	51	6
18,500	18,999	20	156,0	95,0	51	6
19,000	19,499	20	158,5	97,5	51	6
19,500	19,999	20	161,0	100,0	51	6
20,000	20,499	25	169,8	102,5	57	6

NOTE: The above dimensions are used when ordering engineered-solution reamers on this page unless otherwise specified.
Custom expandable reamers available starting from a diameter of 8mm.

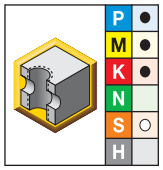
- For hole tolerance H6.
- Intermediate sizes available.
- Allen expansion screw.

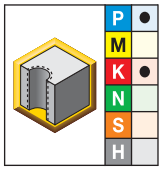






RMB-E • Through Hole Expansion Reamer





● first choice
○ alternate choice

KC6005	KC6305	D1	D	L	L4	LS	Z
RMBE14000H6HF	**RMBE14000H6HF** *	14,00	16,00	131,5	72,5	49,0	6
RMBE15000H6HF *	**RMBE15000H6HF**	15,00	16,00	136,5	77,5	49,0	6
RMBE16000H6HF *	**RMBE16000H6HF**	16,00	20,00	143,5	82,5	51,0	6
RMBE17000H6HF *	**RMBE17000H6HF** *	17,00	20,00	148,5	87,5	51,0	6
RMBE18000H6HF *	**RMBE18000H6HF**	18,00	20,00	153,5	92,5	51,0	6
RMBE19000H6HF *	**RMBE19000H6HF** *	19,00	20,00	158,5	97,5	51,0	6
RMBE20000H6HF *	**RMBE20000H6HF**	20,00	25,00	169,8	102,5	57,0	6

NOTE: Uncoated carbide grade K605™ is available on request.
*Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

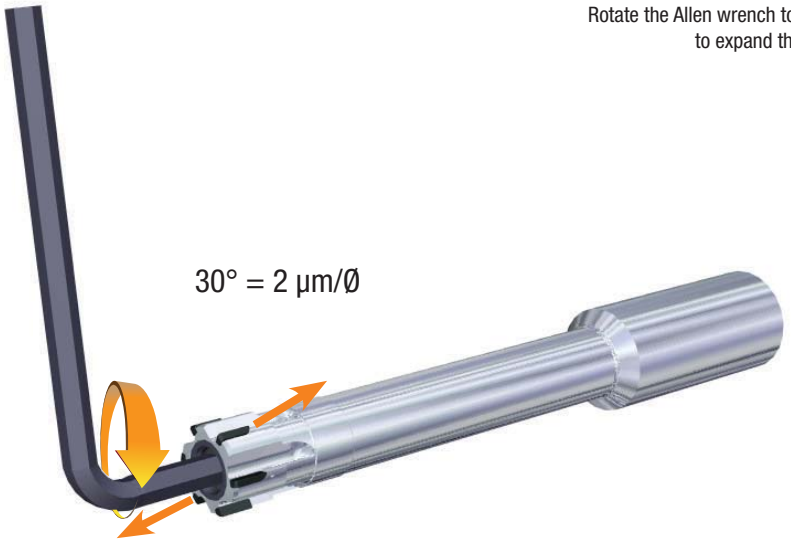
Dimensions for Engineered-Solution Reamers

D1 min	D1 max	D	L	L4	LS	
mm	mm	mm	mm	mm	mm	Z
14,000	14,499	16	131,5	72,5	49	6
14,500	14,999	16	134,0	75,0	49	6
15,000	15,499	16	136,5	77,5	49	6
15,500	15,999	16	139,0	80,0	49	6
16,000	16,499	20	143,5	82,5	51	6
16,500	16,999	20	146,0	85,0	51	6
17,000	17,499	20	148,5	87,5	51	6
17,500	17,999	20	151,0	90,0	51	6
18,000	18,499	20	153,5	92,5	51	6
18,500	18,999	20	156,0	95,0	51	6
19,000	19,499	20	158,5	97,5	51	6
19,500	19,999	20	161,0	100,0	51	6
20,000	20,499	25	169,8	102,5	57	6

NOTE: The above dimensions are used when ordering engineered-solution reamers on this page unless otherwise specified.
Custom expandable reamers available starting with a diameter of 8mm.

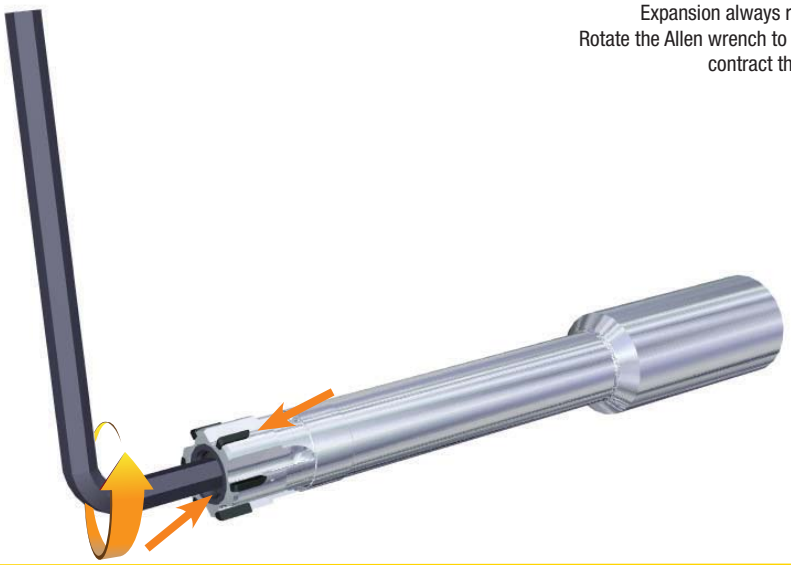
To Expand

Rotate the Allen wrench to the right to expand the reamer.



To Contract

Expansion always reversible:
Rotate the Allen wrench to the left to contract the reamer.



- 30° = 2 µm linear expansion.
- 720° = 2 revolutions; = 48µm maximum expansion.
- Hard stop after 720° expansion. You cannot over expand!
- The expansion occurs in the elastic material behaviour.
- You cannot reduce the diameter below D1.

RMR • Metric

Material Group		KCU05 Cutting Speed — vc Range — m/min min	Starting Value	max	Metric Recommended Feed Rate per Tooth Tool Diameter (mm) Feed/Tooth	14,00–19,99mm min	max	20,00–32,00mm min	max
P	1	90	**120**	155	mm/z	0,10	0,22	0,10	0,25
	2	90	**120**	155	mm/z	0,10	0,22	0,10	0,25
	3	75	**100**	130	mm/z	0,10	0,22	0,10	0,25
	4	50	**80**	105	mm/z	0,10	0,22	0,10	0,25
	5	30	**40**	60	mm/z	0,10	0,22	0,10	0,25
	6	30	**40**	60	mm/z	0,08	0,20	0,08	0,22
M	1	15	**20**	40	mm/z	0,08	0,18	0,08	0,20
	2	15	**20**	30	mm/z	0,08	0,18	0,08	0,20
	3	15	**20**	30	mm/z	0,08	0,18	0,08	0,20
K	1	80	**110**	130	mm/z	0,10	0,22	0,10	0,25
	2	65	**90**	110	mm/z	0,10	0,22	0,10	0,25
	3	50	**70**	90	mm/z	0,10	0,20	0,10	0,25
S	1	15	**20**	30	mm/z	0,10	0,18	0,10	0,20
	2	15	**20**	30	mm/z	0,10	0,18	0,10	0,20
	3	20	**30**	40	mm/z	0,10	0,20	0,10	0,20
	4	20	**30**	40	mm/z	0,10	0,20	0,10	0,20

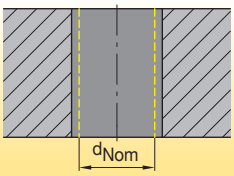
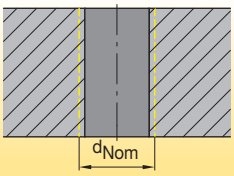
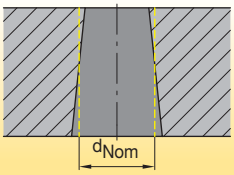
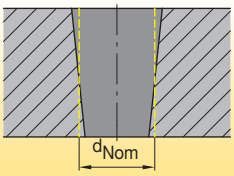
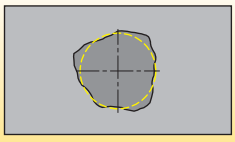
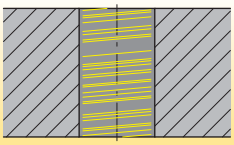
RMB™ and RMB-E™ • Metric

Material Group		RMB — Cermet Tipped straight flute KT6215 Cutting Speed — vc Range — m/min min	Starting Value	max	RMB — Cermet Tipped helical flute KT6215 min	Starting Value	max	RMB-E straight flute K605 min	Starting Value	max	RMB-E helical flute KC6305 min	Starting Value	max	Metric Recommended Feed Rate per Tooth Tool Diameter (mm) Feed/ Tooth	14,00–19,99mm min	max	20,00–32,00mm min	max
P	1	150	**180**	210	180	**210**	240	40	**60**	70	90	**120**	155	mm/z	0,10	0,22	0,10	0,25
	2	150	**180**	210	180	**210**	240	40	**60**	70	90	**120**	155	mm/z	0,10	0,22	0,10	0,25
	3	130	**160**	180	150	**180**	210	30	**40**	50	75	**100**	130	mm/z	0,10	0,22	0,10	0,25
	4	100	**130**	150	120	**150**	170	25	**40**	45	50	**80**	105	mm/z	0,10	0,22	0,10	0,25
	5	80	**100**	120	100	**130**	150	10	**20**	30	30	**40**	55	mm/z	0,08	0,20	0,08	0,22
	6	80	**100**	120	100	**130**	150	10	**20**	30	30	**40**	55	mm/z	0,08	0,20	0,08	0,22
M	1	–	**–**	–	–	**–**	–	8	**10**	15	15	**20**	28	mm/z	0,08	0,18	0,08	0,20
	2	–	**–**	–	–	**–**	–	8	**10**	15	15	**20**	28	mm/z	0,08	0,18	0,08	0,20
	3	–	**–**	–	–	**–**	–	8	**10**	15	15	**20**	28	mm/z	0,08	0,18	0,08	0,20
K	1	150	**180**	200	180	**210**	240	30	**50**	60	80	**110**	130	mm/z	0,10	0,22	0,10	0,25
	2	130	**160**	180	150	**180**	210	25	**40**	45	65	**90**	110	mm/z	0,10	0,22	0,10	0,25
	3	100	**130**	160	120	**150**	170	20	**30**	40	50	**70**	90	mm/z	0,10	0,20	0,10	0,22
N	1	–	**–**	–	–	**–**	–	110	**150**	195	–	**–**	–	mm/z	0,10	0,30	0,10	0,30
	2	–	**–**	–	–	**–**	–	110	**150**	195	–	**–**	–	mm/z	0,10	0,30	0,10	0,30
	3	–	**–**	–	–	**–**	–	110	**150**	195	–	**–**	–	mm/z	0,10	0,30	0,10	0,30
	4	–	**–**	–	–	**–**	–	110	**150**	195	–	**–**	–	mm/z	0,10	0,30	0,10	0,30
	5	–	**–**	–	–	**–**	–	105	**140**	180	–	**–**	–	mm/z	0,10	0,30	0,10	0,30
S	1	–	**–**	–	–	**–**	–	8	**10**	15	15	**20**	28	mm/z	0,10	0,18	0,10	0,20
	2	–	**–**	–	–	**–**	–	8	**10**	15	15	**20**	28	mm/z	0,10	0,18	0,10	0,20
	3	–	**–**	–	–	**–**	–	15	**20**	30	20	**30**	40	mm/z	0,10	0,20	0,10	0,20
	4	–	**–**	–	–	**–**	–	15	**20**	30	20	**30**	40	mm/z	0,10	0,20	0,10	0,20

Reaming Allowances for Multi-Blade Reaming

	reaming allowances in diameter mm		
mm	min	middle	max
1,40–4,80	0,08	0,12	0,20
4,81–9,59	0,10	0,15	0,25
9,60–15,00	0,15	0,20	0,30
15,00–20,00	0,15	0,25	0,35
20,00–50,00	0,20	0,30	0,40

Troubleshooting

Problem		Cause	Possible Remedy
Hole diameter too large.		• Reaming tool running out-of-centre. • Concentricity of pilot hole and ream machining unsatisfactory. • Built-up edge. • Unsuitable cooling lubricant. • Reaming tool diameter too large.	• Use equalising adaptor. • Re-align, use floating head. • Change cooling lubricant. • Change cutting speed. • Measure reamers and send for repairs.
Hole diameter too small.		• Reamer worn. • Unsuitable cooling lubricant. • Reaming allowance too small.	• Replace and refit tool. • Change cooling lubricant. • Increase reaming allowance.
Conical hole profile wider towards drill runout.		• Concentricity of pilot hole and reaming unsatisfactory. • Positioning accuracy of pilot hole to reaming.	• Re-align, use equalising adaptor. • Correct positioning accuracy.
Conical hole profile wider at drill entry point.		• Concentricity of pilot hole and reaming unsatisfactory. • Reaming tool skim cutting with ledger.	• Re-align, use floating head. • Securely clamp reaming tool axially.
Hole out-of-centre and/or showing chatter marks.		• Reaming tool running out-of-centre. • Slanted cutting surface/asymmetrical cutting. • Workpiece twisted.	• Use equalising adaptor. • Spot face as drilling preparation. • Take the direction of impact into account when clamping the workpiece.
Surface quality does not meet specification.		• Tool cutters worn. • Reaming tool running out-of-centre. • Incorrect technology data (cutting parameters). • Inadequate chip evacuation.	• Use equalising adaptor. • Re-align, use floating head. • Change cooling lubricant. • Change cutting speed. • Measure reamers and send for repairs.
Feed grooves.		• Built-up edge.	• Change cooling lubricant. • Change cutting speed.

RHR™ Disc Reaming

Primary Application

The RHR modular disc reaming system combines the productivity of disc reamers with the idea of interchangeable reaming heads. Only five coupling sizes cover the whole diameter range, a comfortable interchange mechanism, and no need for setting fixtures or repeat measurements makes this system very attractive. Combine RHR disc reamers with the Kennametal SIF™ steerable holder for the best results.



Features and Benefits

- Solid carbide disc at front instead of single-tipped carbide blanks.
- Unique coating specifically for reaming applications.
- Unique patented coupling system enables same runout accuracy as monoblock systems (<3 microns), eliminating repeat runout checking.
- Quick radial clamping change-outs, even in narrow situations.
- No fixture for clamping or dismounting necessary.
- Helical and straight flutes for chip control in through and blind holes.
- Bodies available with straight shank, HSK back end, and SIF connection.

Customisation

- All diameters between 14–42,5mm (.5512–1.6732").
- Variation of leads and cylindrical margin for application-specific optimisation.

RHM™ Modular Cermet-Tipped System

Primary Application

RHM modular reamers are tipped with cermet blanks and available in diameters from 14–42,5mm (.5512–1.6732") as standards, and up to 50mm (1.968") as custom solutions. Cermet reamers provide excellent tool life and surface finishes in steel applications. Combine RHM modular reamers with the Kennametal SIF™ steerable holder for best results.

Use SIF steerable hydraulic chucks or SIF adapters for easy compensation of radial runout and angular inaccuracies of the spindle to achieve the highest possible hole straightness and surface quality. Radial or axial tool bodies are available at diameter 20mm.



Features and Benefits

Taper-Face Contact with KST Coupling

- Symmetrical torque transmission near head.
- Higher feed rate than conventional reaming tools.
- Better surface quality and tool life due to less tendency to vibrate.
- No need for head to body orientation.

Customisation

- Diameters up to 50mm (1.968") available with and without internal coolant in 0,001mm (.00004") steps.
- Intermediate diameters from standard offering available with short delivery time.
- RHM tooling for machining heat-resistant materials, as well as different lengths and couplings or shanks, available on request.

Higher productivity and profitability

- Longer tool life with increased hole and surface quality due to lapped ground leads.
- Cermet enables highest metal removal rates at higher speeds and feeds in steel.
- Improved straightness and cylindrical form compared to competitive tools and reduced vibration tendency due to unequal flutes.

RHM-E™ Expandable Reamers

Primary Application

The original idea behind an expansion reamer is to achieve more regrinds. The expansion mechanism is designed for this purpose only.

The Kennametal expandable reaming system is different. Over an expansion range of 48 microns, it comes with a completely linear expansion rate of 2 microns per 30° turn. The micron-adjustability of this system eliminates manufacturing tolerances and thus allows for machining tightest tolerances, usually only achievable by using an uncoated tool or guide pad reaming. No pre-setting equipment is required.



Features and Benefits

Precision and Productivity

- Use with SIF™ steerable chucks for KST toolholders for easy compensation of radial runout and angular inaccuracies.
- Tools are preadjusted to hit IT6 tolerance.
- Expansion range of 48 microns.
- Completely linear expansion.
- 2 microns per 30° turn.

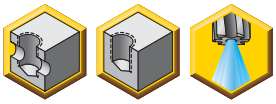
Increased Tool Life

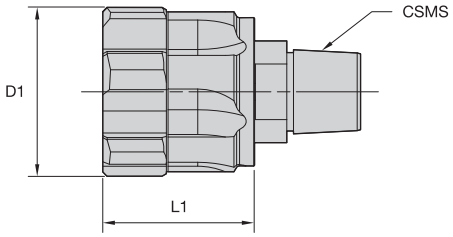
- Longer tool life at smaller tolerances.

Customisation

- Diameters up to 42mm (1.65") available with helical and straight flutes in 0,001mm (.00004") increments.

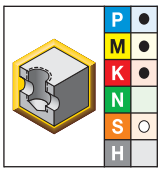
- For hole tolerance H7.
- Intermediate sizes ground to achieve IT6 or IT7 hole tolerance class available.
- Please order lock screw and retention knob separately.







RHR • Disc Style Reamer Head • Straight Fluted for Blind Holes with Internal Coolant

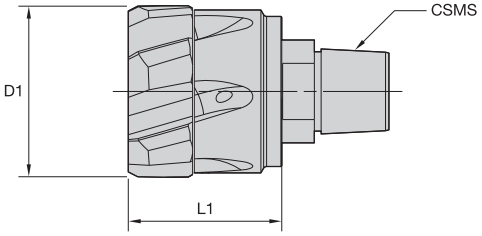


● first choice
○ alternate choice

KCU05	CSMS system size	D1	L1	Z
RHR14000KST115H7SF	KST115	14,00	17,90	6
RHR15000KST115H7SF	KST115	15,00	17,90	6
RHR16000KST135H7SF	KST135	16,00	17,90	6
RHR17000KST135H7SF	KST135	17,00	17,90	6
RHR18000KST155H7SF	KST155	18,00	17,90	6
RHR19000KST155H7SF	KST155	19,00	17,90	6
RHR20000KST175H7SF	KST175	20,00	17,90	6
RHR21000KST175H7SF	KST175	21,00	17,90	6
RHR22000KST175H7SF	KST175	22,00	17,90	6
RHR23000KST200H7SF	KST200	23,00	18,90	6
RHR24000KST200H7SF	KST200	24,00	18,90	6
RHR25000KST200H7SF	KST200	25,00	18,90	8
RHR26000KST200H7SF	KST200	26,00	18,90	8
RHR27000KST200H7SF	KST200	27,00	18,90	8
RHR28000KST250H7SF	KST250	28,00	18,90	8
RHR29000KST250H7SF	KST250	29,00	18,90	8
RHR30000KST250H7SF	KST250	30,00	18,90	8
RHR31000KST250H7SF	KST250	31,00	18,90	8
RHR32000KST250H7SF	KST250	32,00	18,90	8
RHR33000KST300H7SF	KST300	33,00	20,40	8
RHR34000KST300H7SF	KST300	34,00	20,40	8
RHR35000KST300H7SF	KST300	35,00	20,40	8
RHR36000KST300H7SF	KST300	36,00	20,40	8
RHR37000KST300H7SF	KST300	37,00	20,40	8
RHR38000KST350H7SF	KST350	38,00	20,40	8
RHR39000KST350H7SF	KST350	39,00	20,40	8
RHR40000KST350H7SF	KST350	40,00	20,40	8
RHR41000KST350H7SF	KST350	41,00	20,40	8
RHR42000KST350H7SF	KST350	42,00	20,40	8

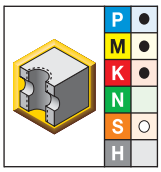
- For hole tolerance H7.
- Intermediate sizes ground to achieve IT6 or IT7 hole tolerance class available.
- Please order lock screw and retention knob separately.







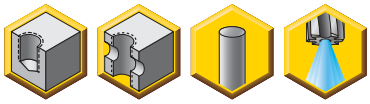
RHR • Disc Style Reamer Head • Helical Fluted for Through Holes with Internal Coolant

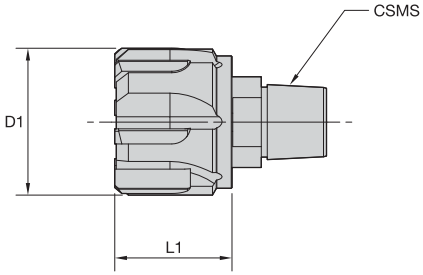


● first choice
○ alternate choice

KCU05	CSMS system size	D1	L1	Z
RHR14000KST115H7HF	KST115	14,00	17,90	6
RHR15000KST115H7HF	KST115	15,00	17,90	6
RHR16000KST135H7HF	KST135	16,00	17,90	6
RHR17000KST135H7HF	KST135	17,00	17,90	6
RHR18000KST155H7HF	KST155	18,00	17,90	6
RHR19000KST155H7HF	KST155	19,00	17,90	6
RHR20000KST175H7HF	KST175	20,00	17,90	6
RHR21000KST175H7HF	KST175	21,00	17,90	6
RHR22000KST175H7HF	KST175	22,00	17,90	6
RHR23000KST200H7HF	KST200	23,00	18,90	6
RHR24000KST200H7HF	KST200	24,00	18,90	6
RHR25000KST200H7HF	KST200	25,00	18,90	8
RHR26000KST200H7HF	KST200	26,00	18,90	8
RHR27000KST200H7HF	KST200	27,00	18,90	8
RHR28000KST250H7HF	KST250	28,00	18,90	8
RHR29000KST250H7HF	KST250	29,00	18,90	8
RHR30000KST250H7HF	KST250	30,00	18,90	8
RHR31000KST250H7HF	KST250	31,00	18,90	8
RHR32000KST250H7HF	KST250	32,00	18,90	8
RHR33000KST300H7HF	KST300	33,00	20,40	8
RHR34000KST300H7HF	KST300	34,00	20,40	8
RHR35000KST300H7HF	KST300	35,00	20,40	8
RHR36000KST300H7HF	KST300	36,00	20,40	8
RHR37000KST300H7HF	KST300	37,00	20,40	8
RHR38000KST350H7HF	KST350	38,00	20,40	8
RHR39000KST350H7HF	KST350	39,00	20,40	8
RHR40000KST350H7HF	KST350	40,00	20,40	8
RHR41000KST350H7HF	KST350	41,00	20,40	8
RHR42000KST350H7HF	KST350	42,00	20,40	8

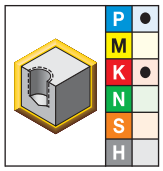
- For hole tolerance H7.
- Intermediate sizes ground to achieve IT6 or IT7 hole tolerance class available.
- Please order lock screw for axial use or retention knob separately.

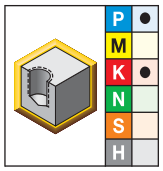






RHM • Blind Hole Cermet Tipped Reamer



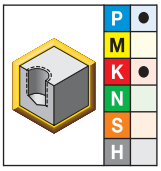


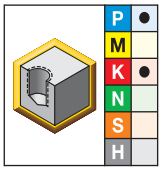
● first choice
○ alternate choice

KT325	KT6215	CSMS system size	D1	L1	Z
RHM14000KST115H7SF *	RHM14000KST115H7SF	KST115	14,00	13,50	6
RHM14288KST115H7SF *	RHM14288KST115H7SF	KST115	14,29	13,50	6
RHM15000KST115H7SF *	–	KST115	15,00	13,50	6
RHM15875KST115H7SF *	RHM15875KST115H7SF	KST115	15,88	13,50	6
RHM16000KST135H7SF *	RHM16000KST135H7SF	KST135	16,00	13,50	6
RHM17000KST135H7SF *	RHM17000KST135H7SF *	KST135	17,00	15,50	6
RHM17463KST135H7SF *	–	KST135	17,46	15,50	6
RHM18000KST155H7SF	RHM18000KST155H7SF	KST155	18,00	15,50	6
RHM19000KST155H7SF *	–	KST155	19,00	15,50	6
–	RHM19050KST155H7SF *	KST155	19,05	15,50	6
RHM20000KST175H7SF	RHM20000KST175H7SF	KST175	20,00	15,50	6
RHM20640KST175H7SF *	RHM20640KST175H7SF *	KST175	20,64	15,50	6
RHM21000KST175H7SF *	RHM21000KST175H7SF	KST175	21,00	15,50	6
–	RHM22000KST175H7SF *	KST175	22,00	15,50	6
RHM22230KST175H7SF *	RHM22230KST175H7SF *	KST175	22,23	15,50	6
RHM22500KST200H7SF *	RHM22500KST200H7SF *	KST200	22,50	16,50	6
RHM23000KST200H7SF *	RHM23000KST200H7SF *	KST200	23,00	16,50	6
RHM23810KST200H7SF *	RHM23810KST200H7SF *	KST200	23,81	16,50	6
RHM24000KST200H7SF *	RHM24000KST200H7SF *	KST200	24,00	16,50	6
RHM25000KST200H7SF *	RHM25000KST200H7SF	KST200	25,00	16,50	6
RHM25400KST200H7SF *	RHM25400KST200H7SF *	KST200	25,40	16,50	6
RHM26000KST200H7SF *	–	KST200	26,00	16,50	8
RHM26990KST200H7SF *	RHM26990KST200H7SF *	KST200	26,99	16,50	8
RHM27000KST200H7SF	RHM27000KST200H7SF *	KST200	27,00	16,50	8

(continued)

(RHM • Blind Hole Cermet Tipped Reamer — continued)



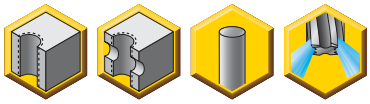


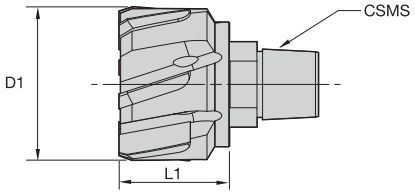
● first choice
○ alternate choice

KT325	KT6215	CSMS system size	D1	L1	Z
RHM27500KST250H7SF *	**RHM27500KST250H7SF** *	KST250	27,50	16,50	8
RHM28000KST250H7SF *	**RHM28000KST250H7SF**	KST250	28,00	16,50	8
RHM28580KST250H7SF *	**RHM28580KST250H7SF** *	KST250	28,58	16,50	8
RHM29000KST250H7SF	**RHM29000KST250H7SF** *	KST250	29,00	16,50	8
RHM30000KST250H7SF	**RHM30000KST250H7SF** *	KST250	30,00	16,50	8
RHM30160KST250H7SF *	–	KST250	30,16	16,50	8
RHM31000KST250H7SF *	**RHM31000KST250H7SF** *	KST250	31,00	16,50	8
RHM31750KST250H7SF *	**RHM31750KST250H7SF** *	KST250	31,75	16,50	8
RHM32000KST250H7SF *	–	KST250	32,00	16,50	8
RHM32500KST300H7SF *	**RHM32500KST300H7SF** *	KST300	32,50	18,00	8
RHM33000KST300H7SF *	**RHM33000KST300H7SF** *	KST300	33,00	18,00	8
RHM33340KST300H7SF *	**RHM33340KST300H7SF** *	KST300	33,34	18,00	8
RHM34000KST300H7SF *	–	KST300	34,00	18,00	8
RHM34930KST300H7SF *	**RHM34930KST300H7SF** *	KST300	34,93	18,00	8
RHM35000KST300H7SF *	**RHM35000KST300H7SF** *	KST300	35,00	18,00	8
RHM36000KST300H7SF *	**RHM36000KST300H7SF** *	KST300	36,00	18,00	8
RHM36510KST300H7SF *	**RHM36510KST300H7SF** *	KST300	36,51	18,00	8
RHM37000KST300H7SF *	–	KST300	37,00	18,00	8
RHM37500KST350H7SF *	**RHM37500KST350H7SF** *	KST350	37,50	18,00	8
RHM38000KST350H7SF *	**RHM38000KST350H7SF** *	KST350	38,00	18,00	8
RHM38100KST350H7SF *	**RHM38100KST350H7SF** *	KST350	38,10	18,00	8
RHM39000KST350H7SF *	**RHM39000KST350H7SF** *	KST350	39,00	18,00	8
RHM39690KST350H7SF *	**RHM39690KST350H7SF** *	KST350	39,69	18,00	8
–	**RHM40000KST350H7SF** *	KST350	40,00	18,00	8
RHM41000KST350H7SF *	**RHM41000KST350H7SF** *	KST350	41,00	18,00	8
RHM41280KST350H7SF *	**RHM41280KST350H7SF** *	KST350	41,28	18,00	8
RHM42000KST350H7SF	**RHM42000KST350H7SF** *	KST350	42,00	18,00	8

NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

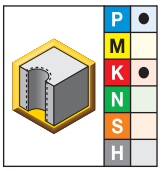
- For hole tolerance H7.
- Intermediate sizes ground to achieve IT6 or IT7 hole tolerance class available.
- Please order lock screw for axial use or retention knob separately.

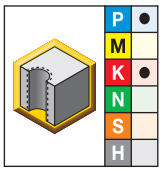






RHM • Through Hole Cermet Tipped Reamer



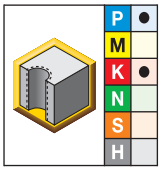


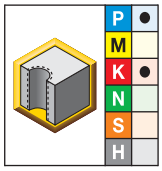
● first choice
○ alternate choice

KT325	KT6215	CSMS system size	D1	L1	Z
RHM14000KST115H7HF *	**RHM14000KST115H7HF**	KST115	14,00	13,50	6
RHM14288KST115H7HF *	**RHM14288KST115H7HF** *	KST115	14,29	13,50	6
RHM15875KST115H7HF *	–	KST115	15,88	13,50	6
RHM16000KST135H7HF	**RHM16000KST135H7HF**	KST135	16,00	13,50	6
RHM17000KST135H7HF *	**RHM17000KST135H7HF**	KST135	17,00	15,50	6
RHM17463KST135H7HF *	**RHM17463KST135H7HF** *	KST135	17,46	15,50	6
RHM18000KST155H7HF *	**RHM18000KST155H7HF**	KST155	18,00	15,50	6
RHM19000KST155H7HF *	**RHM19000KST155H7HF**	KST155	19,00	15,50	6
RHM19050KST155H7HF *	**RHM19050KST155H7HF**	KST155	19,05	15,50	6
RHM20000KST175H7HF	**RHM20000KST175H7HF**	KST175	20,00	15,50	6
RHM20640KST175H7HF *	**RHM20640KST175H7HF**	KST175	20,64	15,50	6
RHM21000KST175H7HF	**RHM21000KST175H7HF**	KST175	21,00	15,50	6
RHM22000KST175H7HF	**RHM22000KST175H7HF** *	KST175	22,00	15,50	6
RHM22230KST175H7HF *	**RHM22230KST175H7HF** *	KST175	22,23	15,50	6
RHM22500KST200H7HF *	**RHM22500KST200H7HF** *	KST200	22,50	16,50	6
RHM23000KST200H7HF *	**RHM23000KST200H7HF** *	KST200	23,00	16,50	6
RHM23810KST200H7HF *	**RHM23810KST200H7HF** *	KST200	23,81	16,50	6
RHM24000KST200H7HF	**RHM24000KST200H7HF** *	KST200	24,00	16,50	6
RHM25000KST200H7HF	**RHM25000KST200H7HF**	KST200	25,00	16,50	6
RHM25400KST200H7HF *	**RHM25400KST200H7HF**	KST200	25,40	16,50	6
RHM26000KST200H7HF *	–	KST200	26,00	16,50	8
RHM26990KST200H7HF *	**RHM26990KST200H7HF** *	KST200	26,99	16,50	8
RHM27000KST200H7HF *	**RHM27000KST200H7HF** *	KST200	27,00	16,50	8
RHM27500KST250H7HF *	**RHM27500KST250H7HF** *	KST250	27,50	16,50	8

(continued)

(RHM • Through Hole Cermet Tipped Reamer — continued)

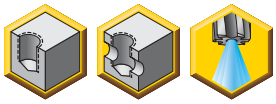


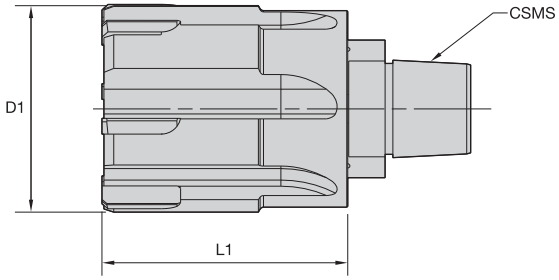


KT325	KT6215	CSMS system size	D1	L1	Z
RHM28000KST250H7HF	**RHM28000KST250H7HF**	KST250	28,00	16,50	8
RHM28580KST250H7HF *	–	KST250	28,58	16,50	8
RHM29000KST250H7HF *	**RHM29000KST250H7HF** *	KST250	29,00	16,50	8
RHM30000KST250H7HF	**RHM30000KST250H7HF**	KST250	30,00	16,50	8
RHM30160KST250H7HF *	**RHM30160KST250H7HF** *	KST250	30,16	16,50	8
RHM31000KST250H7HF *	**RHM31000KST250H7HF** *	KST250	31,00	16,50	8
RHM31750KST250H7HF *	**RHM31750KST250H7HF** *	KST250	31,75	16,50	8
RHM32000KST250H7HF *	**RHM32000KST250H7HF** *	KST250	32,00	16,50	8
RHM32500KST300H7HF *	**RHM32500KST300H7HF** *	KST300	32,50	18,00	8
RHM33000KST300H7HF *	**RHM33000KST300H7HF** *	KST300	33,00	18,00	8
RHM33340KST300H7HF *	**RHM33340KST300H7HF** *	KST300	33,34	18,00	8
–	**RHM34000KST300H7HF**	KST300	34,00	18,00	8
RHM34930KST300H7HF *	**RHM34930KST300H7HF** *	KST300	34,93	18,00	8
RHM35000KST300H7HF	**RHM35000KST300H7HF**	KST300	35,00	18,00	8
RHM36000KST300H7HF	–	KST300	36,00	18,00	8
RHM36510KST300H7HF *	**RHM36510KST300H7HF** *	KST300	36,51	18,00	8
RHM37000KST300H7HF *	**RHM37000KST300H7HF**	KST300	37,00	18,00	8
RHM37500KST350H7HF *	**RHM37500KST350H7HF** *	KST350	37,50	18,00	8
RHM38100KST350H7HF *	–	KST350	38,10	18,00	8
RHM39000KST350H7HF *	**RHM39000KST350H7HF** *	KST350	39,00	18,00	8
RHM39690KST350H7HF *	**RHM39690KST350H7HF** *	KST350	39,69	18,00	8
RHM40000KST350H7HF	**RHM40000KST350H7HF**	KST350	40,00	18,00	8
RHM41000KST350H7HF *	**RHM41000KST350H7HF** *	KST350	41,00	18,00	8
RHM41280KST350H7HF *	**RHM41280KST350H7HF** *	KST350	41,28	18,00	8
RHM42000KST350H7HF	**RHM42000KST350H7HF** *	KST350	42,00	18,00	8

NOTE: Uncoated carbide grade K605™ is available on request.
*Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

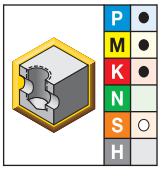
- For hole tolerance H6.
- Intermediate sizes available.
- Lock screw for axial use or retention knob comes with holder.
- Allen expansion screw.

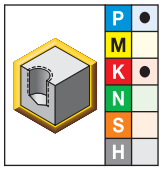






RHM-E • Blind Hole Expansion Reamer





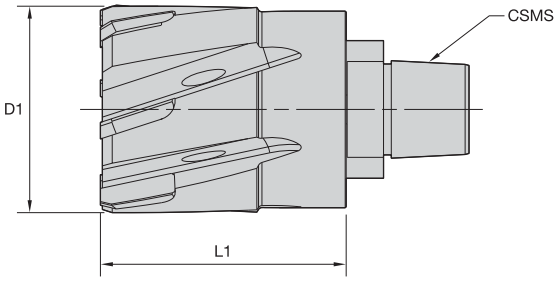
● first choice
○ alternate choice

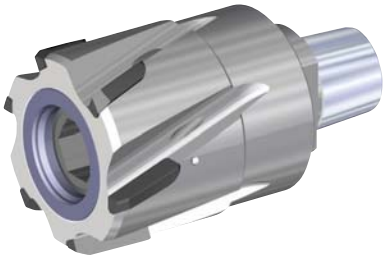
KC6005	KC6305	CSMS system size	D1	L1	Z
RHME14000KST115H6SF *	RHME14000KST115H6SF	KST115	14,00	25,00	6
RHME14288KST115H6SF *	RHME14288KST115H6SF *	KST115	14,29	25,00	6
RHME15000KST115H6SF *	RHME15000KST115H6SF	KST115	15,00	25,00	6
RHME16000KST135H6SF	RHME16000KST135H6SF	KST135	16,00	25,00	6
RHME17000KST135H6SF *	RHME17000KST135H6SF	KST135	17,00	25,00	6
RHME17463KST135H6SF *	RHME17463KST135H6SF *	KST135	17,46	25,00	6
RHME18000KST155H6SF *	RHME18000KST155H6SF *	KST155	18,00	25,00	6
RHME19000KST155H6SF *	RHME19000KST155H6SF *	KST155	19,00	25,00	6
RHME19050KST155H6SF *	RHME19050KST155H6SF *	KST155	19,05	25,00	6
RHME20000KST175H6SF *	RHME20000KST175H6SF	KST175	20,00	25,00	6
RHME21000KST175H6SF	RHME21000KST175H6SF *	KST175	21,00	25,00	6
RHME22000KST175H6SF *	RHME22000KST175H6SF *	KST175	22,00	25,00	6
RHME22225KST175H6SF *	RHME22225KST175H6SF	KST175	22,23	25,00	6
RHME23000KST200H6SF *	RHME23000KST200H6SF *	KST200	23,00	25,00	6
RHME23813KST200H6SF *	RHME23813KST200H6SF *	KST200	23,81	25,00	6
RHME24000KST200H6SF	RHME24000KST200H6SF *	KST200	24,00	25,00	6
RHME25000KST200H6SF	RHME25000KST200H6SF	KST200	25,00	30,00	6
RHME25400KST200H6SF *	RHME25400KST200H6SF *	KST200	25,40	30,00	6
RHME26000KST200H6SF *	RHME26000KST200H6SF *	KST200	26,00	30,00	8
RHME27000KST200H6SF *	RHME27000KST200H6SF	KST200	27,00	30,00	8
RHME28000KST250H6SF	RHME28000KST250H6SF	KST250	28,00	36,00	8
RHME30000KST250H6SF	RHME30000KST250H6SF	KST250	30,00	36,00	8
RHME31750KST250H6SF *	RHME31750KST250H6SF *	KST250	31,75	36,00	8
RHME32000KST250H6SF *	RHME32000KST250H6SF *	KST250	32,00	36,00	8
RHME34000KST300H6SF *	RHME34000KST300H6SF *	KST300	34,00	36,00	8
RHME36000KST300H6SF *	RHME36000KST300H6SF *	KST300	36,00	36,00	8
RHME38000KST350H6SF *	RHME38000KST350H6SF *	KST350	38,00	36,00	8
RHME40000KST350H6SF *	RHME40000KST350H6SF *	KST350	40,00	36,00	8
RHME42000KST350H6SF	RHME42000KST350H6SF *	KST350	42,00	36,00	8

NOTE: Uncoated carbide grade K605™ is available on request.
*Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

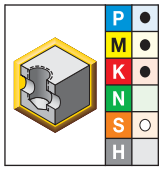
- For hole tolerance H6.
- Intermediate sizes available.
- Lock screw for axial use or retention knob comes with holder.
- Allen expansion screw.

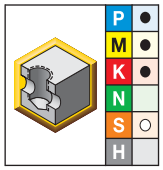






RHM-E • Through Hole Expansion Reamer





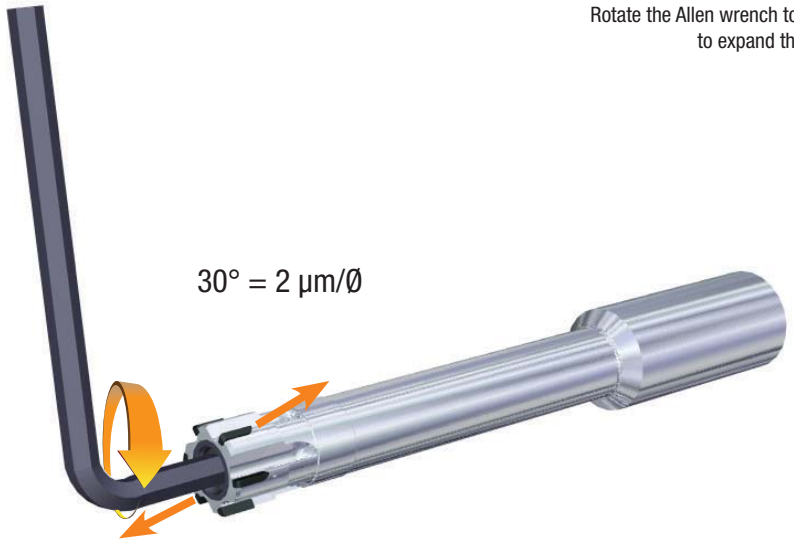
● first choice
○ alternate choice

KC6005	KC6305	CSMS system size	D1	L1	Z
RHME14000KST115H6HF *	RHME14000KST115H6HF *	KST115	14,00	25,00	6
RHME14288KST115H6HF *	RHME14288KST115H6HF *	KST115	14,29	25,00	6
RHME15000KST115H6HF *	RHME15000KST115H6HF *	KST115	15,00	25,00	6
RHME16000KST135H6HF	RHME16000KST135H6HF	KST135	16,00	25,00	6
RHME17000KST135H6HF	RHME17000KST135H6HF *	KST135	17,00	25,00	6
RHME17463KST135H6HF	RHME17463KST135H6HF *	KST135	17,46	25,00	6
RHME18000KST155H6HF *	RHME18000KST155H6HF	KST155	18,00	25,00	6
RHME19000KST155H6HF *	RHME19000KST155H6HF *	KST155	19,00	25,00	6
RHME19050KST155H6HF *	RHME19050KST155H6HF	KST155	19,05	25,00	6
RHME20000KST175H6HF	RHME20000KST175H6HF	KST175	20,00	25,00	6
RHME21000KST175H6HF *	RHME21000KST175H6HF *	KST175	21,00	25,00	6
RHME22000KST175H6HF	RHME22000KST175H6HF	KST175	22,00	25,00	6
RHME22225KST175H6HF *	RHME22225KST175H6HF	KST175	22,23	25,00	6
RHME23000KST200H6HF *	RHME23000KST200H6HF *	KST200	23,00	25,00	6
RHME23813KST200H6HF *	RHME23813KST200H6HF *	KST200	23,81	25,00	6
RHME24000KST200H6HF *	RHME24000KST200H6HF *	KST200	24,00	25,00	6
RHME25000KST200H6HF *	RHME25000KST200H6HF	KST200	25,00	30,00	6
RHME25400KST200H6HF	RHME25400KST200H6HF	KST200	25,40	30,00	6
RHME26000KST200H6HF *	RHME26000KST200H6HF	KST200	26,00	30,00	8
RHME27000KST200H6HF *	RHME27000KST200H6HF *	KST200	27,00	30,00	8
RHME28000KST250H6HF	RHME28000KST250H6HF	KST250	28,00	36,00	8
RHME30000KST250H6HF	RHME30000KST250H6HF	KST250	30,00	36,00	8
RHME31750KST250H6HF *	RHME31750KST250H6HF	KST250	31,75	36,00	8
RHME32000KST250H6HF *	RHME32000KST250H6HF *	KST250	32,00	36,00	8
RHME34000KST300H6HF *	RHME34000KST300H6HF *	KST300	34,00	36,00	8
RHME36000KST300H6HF *	RHME36000KST300H6HF *	KST300	36,00	36,00	8
RHME38000KST350H6HF *	RHME38000KST350H6HF *	KST350	38,00	36,00	8
RHME40000KST350H6HF *	–	KST350	39,99	36,00	8
–	RHME40000KST350H6HF *	KST350	40,00	36,00	8
RHME42000KST350H6HF *	RHME42000KST350H6HF *	KST350	42,00	36,00	8

NOTE: Uncoated carbide grade K605™ is available on request.
*Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

To Expand

Rotate the Allen wrench to the right to expand the reamer.



To Contract

Expansion always reversible: Rotate the Allen wrench to the left to contract the reamer.

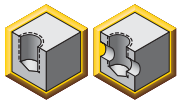
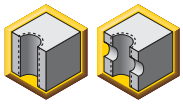


- 30° = 2 µm linear expansion.
- 720° = 2 revolutions; = 48µm maximum expansion.
- Hard stop after 720° expansion. You cannot over expand!
- The expansion occurs in the elastic material behaviour.
- You cannot reduce the diameter below D1.

RHR • Metric

Material Group		KCU05 Cutting Speed — vc Range — m/min			Metric Recommended Feed Rate per Tooth						
					Tool Diameter (mm)	14,00–19,99mm		20,00–32,00mm		32,50–42,00mm	
		min	Starting Value	max	Feed/Tooth	min	max	min	max	min	max
P	1	90	**120**	155	mm/z	0,10	0,20	0,10	0,22	0,10	0,25
	2	90	**120**	155	mm/z	0,10	0,20	0,10	0,22	0,10	0,25
	3	75	**100**	130	mm/z	0,10	0,20	0,10	0,22	0,10	0,25
	4	50	**80**	105	mm/z	0,10	0,20	0,10	0,22	0,10	0,25
	5	30	**40**	60	mm/z	0,08	0,18	0,08	0,20	0,08	0,22
	6	30	**40**	60	mm/z	0,08	0,18	0,08	0,20	0,08	0,22
M	1	15	**20**	40	mm/z	0,08	0,15	0,08	0,18	0,08	0,20
	2	15	**20**	30	mm/z	0,08	0,15	0,08	0,18	0,08	0,20
	3	15	**20**	30	mm/z	0,08	0,15	0,08	0,18	0,08	0,20
K	1	80	**110**	130	mm/z	0,10	0,20	0,10	0,22	0,10	0,25
	2	65	**90**	110	mm/z	0,10	0,20	0,10	0,22	0,10	0,25
	3	50	**70**	90	mm/z	0,10	0,18	0,10	0,20	0,10	0,22
S	1	15	**20**	30	mm/z	0,06	0,15	0,10	0,18	0,10	0,20
	2	15	**20**	30	mm/z	0,06	0,15	0,10	0,18	0,10	0,20
	3	20	**30**	40	mm/z	0,08	0,18	0,10	0,20	0,10	0,20
	4	20	**30**	40	mm/z	0,08	0,18	0,10	0,20	0,10	0,20

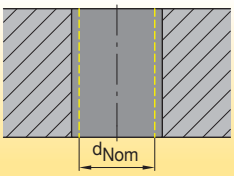
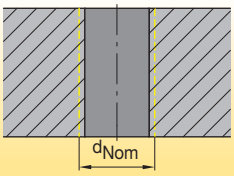
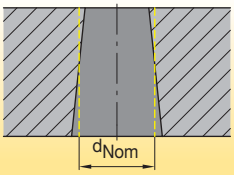
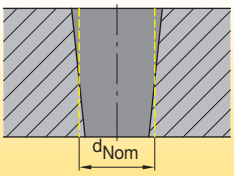
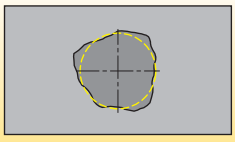
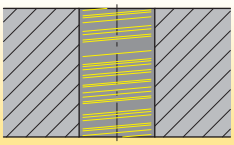
RHM™ and RHM-E™ • Metric

Material Group		Cermet Tipped						Carbide Tipped						Metric						
																				
		straight flute			helical flute			straight flute			helical flute									
		KT325			KT6215			K605			KC6305			Metric						
		Cutting Speed — vc												Recommended Feed Rate per Tooth						
		Range — m/min												Tool Diameter (mm)	14,00–19,99mm		20,00–32,00mm		32,50–42,00mm	
		min	Starting Value	max	min	Starting Value	max	min	Starting Value	max	min	Starting Value	max	Feed/ Tooth	min	max	min	max	min	max
P	1	150	**180**	210	180	**210**	240	40	**60**	70	90	**120**	155	mm/z	0,10	0,20	0,10	0,22	0,10	0,25
	2	150	**180**	210	180	**210**	240	40	**60**	70	90	**120**	155	mm/z	0,10	0,20	0,10	0,22	0,10	0,25
	3	130	**160**	180	150	**180**	210	30	**40**	50	75	**100**	130	mm/z	0,10	0,20	0,10	0,22	0,10	0,25
	4	100	**130**	150	120	**150**	170	25	**40**	45	50	**80**	105	mm/z	0,10	0,20	0,10	0,22	0,10	0,25
	5	80	**100**	120	100	**130**	150	10	**20**	30	30	**40**	55	mm/z	0,08	0,18	0,08	0,20	0,08	0,22
	6	80	**100**	120	100	**130**	150	10	**20**	30	30	**40**	55	mm/z	0,08	0,18	0,08	0,20	0,08	0,22
M	1	–	**–**	–	–	**–**	–	8	**10**	15	15	**20**	28	mm/z	0,08	0,15	0,08	0,18	0,08	0,20
	2	–	**–**	–	–	**–**	–	8	**10**	15	15	**20**	28	mm/z	0,08	0,15	0,08	0,18	0,08	0,20
	3	–	**–**	–	–	**–**	–	8	**10**	15	15	**20**	28	mm/z	0,08	0,15	0,08	0,18	0,08	0,20
K	1	150	**180**	200	180	**210**	240	30	**50**	60	80	**110**	130	mm/z	0,10	0,20	0,10	0,22	0,10	0,25
	2	130	**160**	180	150	**180**	210	25	**40**	45	65	**90**	110	mm/z	0,10	0,20	0,10	0,22	0,10	0,25
	3	100	**130**	160	120	**150**	170	20	**30**	40	50	**70**	90	mm/z	0,10	0,18	0,10	0,20	0,10	0,22
N	1	–	**–**	–	–	**–**	–	110	**150**	195	–	**–**	–	mm/z	0,10	0,30	0,10	0,30	0,10	0,30
	2	–	**–**	–	–	**–**	–	110	**150**	195	–	**–**	–	mm/z	0,10	0,30	0,10	0,30	0,10	0,30
	3	–	**–**	–	–	**–**	–	110	**150**	195	–	**–**	–	mm/z	0,10	0,30	0,10	0,30	0,10	0,30
	4	–	**–**	–	–	**–**	–	110	**150**	195	–	**–**	–	mm/z	0,10	0,30	0,10	0,30	0,10	0,30
	5	–	**–**	–	–	**–**	–	105	**140**	180	–	**–**	–	mm/z	0,10	0,30	0,10	0,30	0,10	0,30
S	1	–	**–**	–	–	**–**	–	8	**10**	15	15	**20**	28	mm/z	0,06	0,15	0,10	0,18	0,10	0,20
	2	–	**–**	–	–	**–**	–	8	**10**	15	15	**20**	28	mm/z	0,06	0,15	0,10	0,18	0,10	0,20
	3	–	**–**	–	–	**–**	–	15	**20**	30	20	**30**	40	mm/z	0,08	0,18	0,10	0,20	0,10	0,20
	4	–	**–**	–	–	**–**	–	15	**20**	30	20	**30**	40	mm/z	0,08	0,18	0,10	0,20	0,10	0,20

Reaming Allowances for Multi-Blade Reaming

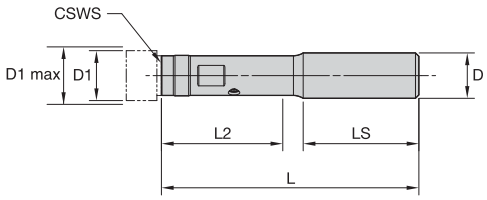
	reaming allowances in diameter mm		
mm	min	middle	max
1,40–4,80	0,08	0,12	0,20
4,81–9,59	0,10	0,15	0,25
9,60–15,00	0,15	0,20	0,30
15,00–20,00	0,15	0,25	0,35
20,00–50,00	0,20	0,30	0,40

Troubleshooting

Problem		Cause	Possible Remedy
Hole diameter too large.		• Reaming tool running out-of-centre. • Concentricity of pilot hole and ream machining unsatisfactory. • Built-up edge. • Unsuitable cooling lubricant. • Reaming tool diameter too large.	• Use equalising adaptor. • Re-align, use floating head. • Change cooling lubricant. • Change cutting speed. • Measure reamers and send for repairs.
Hole diameter too small.		• Reamer worn. • Unsuitable cooling lubricant. • Reaming allowance too small.	• Replace and refit tool. • Change cooling lubricant. • Increase reaming allowance.
Conical hole profile wider towards drill runout.		• Concentricity of pilot hole and reaming unsatisfactory. • Positioning accuracy of pilot hole to reaming.	• Re-align, use equalising adaptor. • Correct positioning accuracy.
Conical hole profile wider at drill entry point.		• Concentricity of pilot hole and reaming unsatisfactory. • Reaming tool skim cutting with ledger.	• Re-align, use floating head. • Securely clamp reaming tool axially.
Hole out-of-centre and/or showing chatter marks.		• Reaming tool running out-of-centre. • Slanted cutting surface/asymmetrical cutting. • Workpiece twisted.	• Use equalising adaptor. • Spot face as drilling preparation. • Take the direction of impact into account when clamping the workpiece.
Surface quality does not meet specification.		• Tool cutters worn. • Reaming tool running out-of-centre. • Incorrect technology data (cutting parameters). • Inadequate chip evacuation.	• Use equalising adaptor. • Re-align, use floating head. • Change cooling lubricant. • Change cutting speed. • Measure reamers and send for repairs.
Feed grooves.		• Built-up edge.	• Change cooling lubricant. • Change cutting speed.

- Tool body shipped with lock screw and wrench.
- Order reamer head separately.







Straight Shank • Axial Clamping • 3 x D

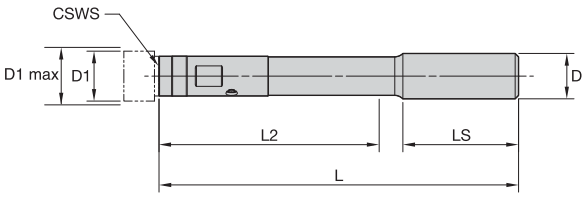




order number	catalogue number	CSWS system size	D1	D1 max	D	L	L2	LS	central lock screw	Torx wrench	Nm	ft. lbs.
4056174	**SS16KST115AR3M**	KST115	14,00	15,999	16,00	91,00	36,00	48,00	**KST115115AS**	**FT8**	3,0	2.2
4056175	**SS20KST135AR3M**	KST135	16,00	17,999	20,00	99,00	39,00	51,00	**KST135155AS**	**FT10**	4,0	3.0
4056176	**SS20KST155AR3M**	KST155	18,00	19,999	20,00	106,00	45,00	51,00	**KST135155AS**	**FT10**	4,0	3.0
3861185	**SS20KST175AR3M**	KST175	20,00	22,499	20,00	113,50	51,50	51,00	**KST175200AS**	**TT15**	5,0	3.7
3861186	**SS20KST200AR3M**	KST200	22,50	27,499	20,00	130,50	65,50	51,00	**KST175200AS**	**TT15**	5,0	3.7
3861187	**SS25KST250AR3M**	KST250	27,50	32,499	25,00	152,50	80,50	56,00	**KST250250AS**	**TT25**	9,0	6.7
3861188	**SS32KST300AR3M**	KST300	32,50	37,499	32,00	174,00	94,00	61,00	**KST300350AS**	**TT30**	13,0	9.7
3861189	**SS32KST350AR3M**	KST350	37,50	42,000	32,00	190,00	108,00	61,00	**KST300350AS**	**TT30**	13,0	9.7

- Tool body shipped with lock screw and wrench.
- Order reamer head separately.







Straight Shank • Axial Clamping • 5 x D

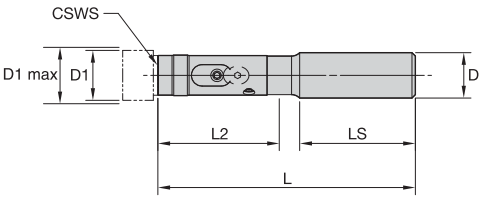




order number	catalogue number	CSWS system size	D1	D1 max	D	L	L2	LS	central lock screw	Torx wrench	Nm	ft. lbs.
4056177	**SS16KST115AR5M**	KST115	14,00	15,999	16,00	123,00	68,00	48,00	**KST115115AS**	**FT8**	3,0	2.2
4056178	**SS20KST135AR5M**	KST135	16,00	17,999	20,00	135,00	75,00	51,00	**KST135155AS**	**FT10**	4,0	3.0
4056179	**SS20KST155AR5M**	KST155	18,00	19,999	20,00	146,00	85,00	51,00	**KST135155AS**	**FT10**	4,0	3.0
3861190	**SS20KST175AR5M**	KST175	20,00	22,499	20,00	158,50	96,50	51,00	**KST175200AS**	**TT15**	5,0	3.7
3861191	**SS20KST200AR5M**	KST200	22,50	27,499	20,00	185,50	120,50	51,00	**KST175200AS**	**TT15**	5,0	3.7
3861192	**SS25KST250AR5M**	KST250	27,50	32,499	25,00	217,50	145,50	56,00	**KST250250AS**	**TT25**	9,0	6.7
3861193	**SS32KST300AR5M**	KST300	32,50	37,499	32,00	249,00	169,00	61,00	**KST300350AS**	**TT30**	13,0	9.7
3861194	**SS32KST350AR5M**	KST350	37,50	42,000	32,00	274,00	192,00	61,00	**KST300350AS**	**TT30**	13,0	9.7

- Tool body shipped with retention knob, clamp set, and wrench.
- Order reamer head separately.







Straight Shank • Radial Clamping • 3 x D

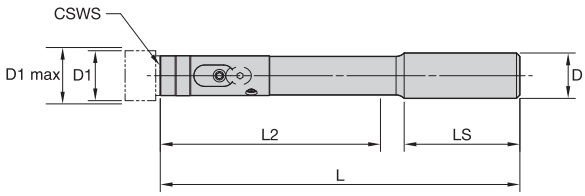




order number	catalogue number	CSWS system size	D1	D1 max	D	L	L2	LS	retention knob	clamp set	Torx wrench	Nm	ft. lbs.
3861195	**SS20KST175RR3M**	KST175	20,00	22,499	20,00	113,50	51,50	51,00	**KST175200RK**	**KST175CS**	**TT15**	5,0	3.7
3861196	**SS20KST200RR3M**	KST200	22,50	27,499	20,00	130,50	65,50	51,00	**KST175200RK**	**KST200CS**	**TT15**	5,0	3.7
3861197	**SS25KST250RR3M**	KST250	27,50	32,499	25,00	152,50	80,50	56,00	**KST250250RK**	**KST250CS**	**TT25**	9,0	6.7
3861198	**SS32KST300RR3M**	KST300	32,50	37,499	32,00	174,00	94,00	61,00	**KST300350RK**	**KST300CS**	**TT30**	13,0	9.7
3861199	**SS32KST350RR3M**	KST350	37,50	42,000	32,00	190,00	108,00	61,00	**KST300350RK**	**KST350CS**	**TT30**	13,0	9.7

- Tool body shipped with retention knob, clamp set, and wrench.
- Order reamer head separately.







Straight Shank • Radial Clamping • 5 x D

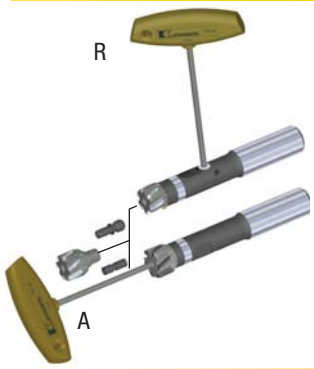




order number	catalogue number	CSWS system size	D1	D1 max	D	L	L2	LS	retention knob	clamp set	Torx wrench	Nm	ft. lbs.
3861200	**SS20KST175RR5M**	KST175	20,00	22,499	20,00	158,50	96,50	51,00	**KST175200RK**	**KST175CS**	**TT15**	5,0	3.7
3861201	**SS20KST200RR5M**	KST200	22,50	27,499	20,00	185,50	120,50	51,00	**KST175200RK**	**KST200CS**	**TT15**	5,0	3.7
3861202	**SS25KST250RR5M**	KST250	27,50	32,499	25,00	217,50	145,50	56,00	**KST250250RK**	**KST250CS**	**TT25**	9,0	6.7
3861203	**SS32KST300RR5M**	KST300	32,50	37,499	32,00	249,00	169,00	61,00	**KST300350RK**	**KST300CS**	**TT30**	13,0	9.7
3861204	**SS32KST350RR5M**	KST350	37,50	42,000	32,00	274,00	192,00	61,00	**KST300350RK**	**KST350CS**	**TT30**	13,0	9.7

Assemble

1



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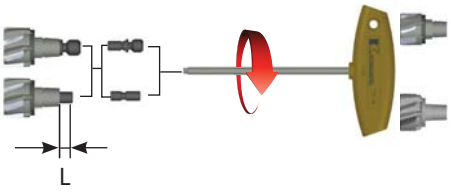
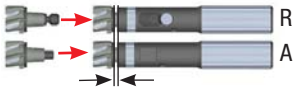
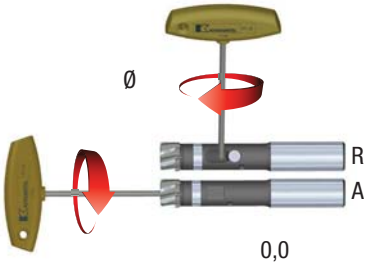


Ø (mm)		L (mm)
14,000	27,499	5–5,5
27,500	42,000	5,5–6

3



4

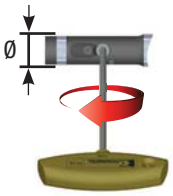


Ø (mm)			(Nm)
14,000	15,999	DT - 8	2
16,000	19,999	DT - 10	3
20,000	27,499	TT - 15	4
27,500	32,499	TT - 25	5
32,500	42,000	TT- 30	13

Disassemble 4 → 3 → 2 → 1

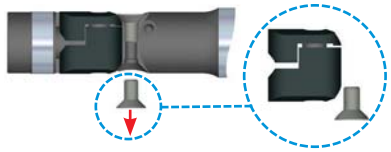
Disassemble

1



Ø (mm)	Ø (in)			(Nm)	(ft. lbs.)
17,5	0.686	KST175CS	2,5	2,5	1.9
20	0.784	KST200CS	2,5	2,5	1.9
25	0.980	KST250CS	3	5	3.7
30	1.176	KST300CS	4	9	6.7
35	1.373	KST350CS	4	9	9.7

2



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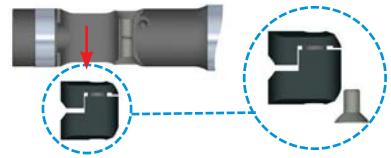
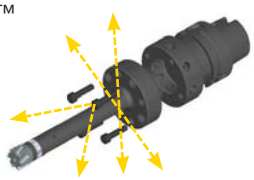
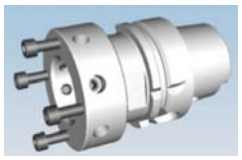


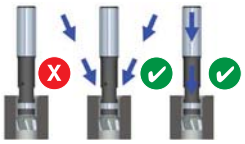
Assemble 3 → 2 → 1

SIF™



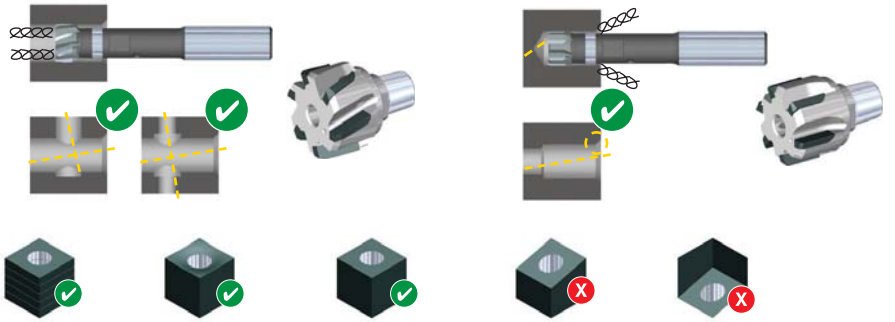


Coolant flow





Application



SIF™ Steerable Toolholder

Primary Application

SIF steerable toolholders should be used for easy compensation of radial runout and angular inaccuracies caused by the machine spindle or gravity. SIF tooling improves hole roundness for highest possible hole straightness and surface quality. Runout-optimised reaming tools provide higher process stability and longer tool life.

Use a separate SIF tooling package for each machine to ensure best configuration between reaming tool and spindle and HSK bushes. This enables faster tool change to avoid repeating adjustments.



Features and Benefits

Higher Productivity and Profitability

- Easy compensation of radial runout and angular inaccuracies increases process control and tool life.
- Less time-consuming adjustment due to eight radial screws.
- Increased rigidity by using a SIF back-end as a monoblock solution with the reamer.

Versatility

- Use standard DV, BT, CV, and HSK adaptors in combination with SIF hydraulic chucks for precise concentric clamping, highest accuracy, and flexible clamping using hydraulic chuck sleeves.
- HSK bushes with SIF coupling enable fast tool exchange and eliminate repeated runout adjustment, reducing adjustment and downtime.

SIF™ adaptation practically eliminates all spindle errors in terms of runout and angular misalignment.

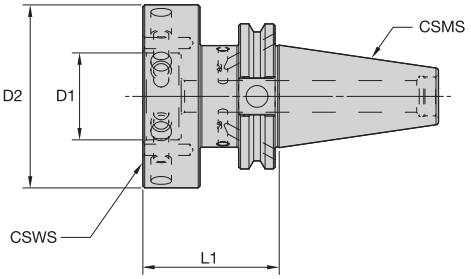


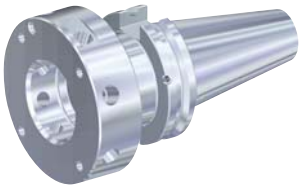
Customisation

- Different length versions and coupling size combinations are available.

- Through-the-toolholder coolant capability — form AD or form B.
- Suitable for SIF adaptors.

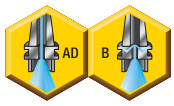






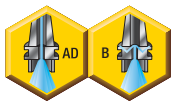
SIF-CV50 Form B/AD

order number	catalogue number	CSMS system size	CSWS system size	D2	D1	L1	dog-point set screw	hex wrench	hex wrench	socket-head cap screw	kg	lbs
3738506	**CV50BSIF70236**	CV50	SIF70	70	38	60	**121.808**	**170.004**	**170.005**	**125.625**	3,49	7.700
3738507	**CV50BSIF100236**	CV50	SIF100	100	58	60	**121.812**	**170.004**	**170.006**	**–**	4,14	9.140



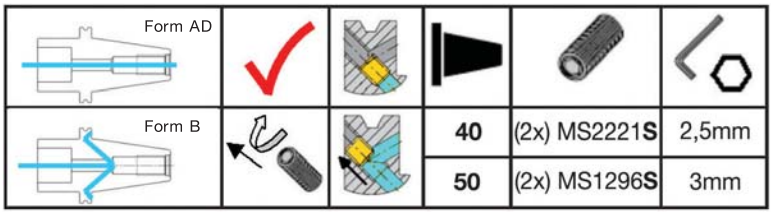
SIF-CV40 Form B/AD

order number	catalogue number	CSMS system size	CSWS system size	D2	D1	L1	dog-point set screw	hex wrench	hex wrench	socket-head cap screw	kg	lbs
3738505	**CV40BSIF80248**	CV40	SIF80	80	38	63	**121.812**	**170.004**	**170.005**	**125.625**	1,77	3.900



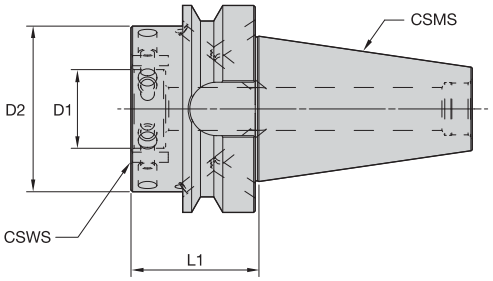
SIF-BT40 Form B/AD

order number	catalogue number	CSMS system size	CSWS system size	D2	D1	L1	dog-point set screw	hex wrench	hex wrench	socket-head cap screw	kg	lbs
3738492	**BT40BSIF80063M**	BT40	SIF80	80	38	63	**121.812**	**170.004**	**170.005**	**125.625**	1,86	4.110



- Through-the-toolholder coolant capability — form AD or form B.
- Suitable for SIF adaptors.

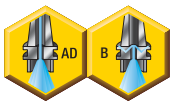






SIF-BT50 Form B/AD

order number	catalogue number	CSMS system size	CSWS system size	D2	D1	L1	dog-point set screw	hex wrench	hex wrench	socket-head cap screw	kg	lbs
3738503	**BT50BSIF70063M**	BT50	SIF70	70	38	63	**121.808**	**170.004**	**170.005**	**125.625**	4,08	9.000
3738504	**BT50BSIF100068M**	BT50	SIF100	100	58	68	**121.812**	**170.004**	**170.006**	**–**	4,94	10.890



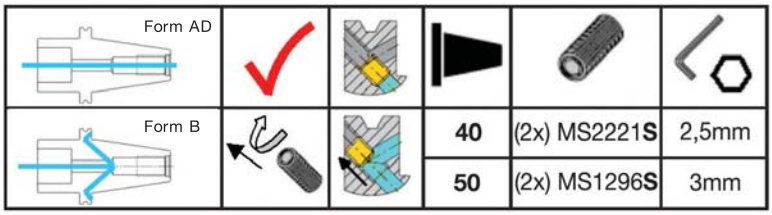
SIF-DV40 Form B/AD

order number	catalogue number	CSMS system size	CSWS system size	D2	D1	L1	dog-point set screw	hex wrench	hex wrench	socket-head cap screw	kg	lbs
3738488	**DV40BSIF80061M**	DV40	SIF80	80	38	61	**121.812**	**170.004**	**170.005**	**125.625**	1,83	4.020



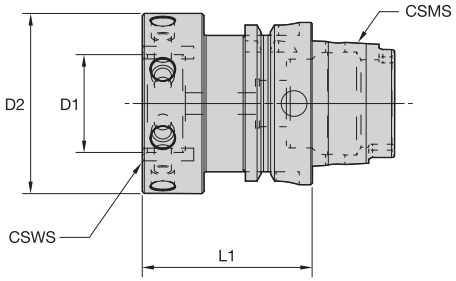
SIF-DV50 Form B/AD

order number	catalogue number	CSMS system size	CSWS system size	D2	D1	L1	dog-point set screw	hex wrench	hex wrench	socket-head cap screw	kg	lbs
3738490	**DV50BSIF70060M**	DV50	SIF70	70	38	60	**121.808**	**170.004**	**170.005**	**125.625**	3,60	7.930
3738491	**DV50BSIF100060M**	DV50	SIF100	100	58	60	**121.812**	**170.004**	**170.006**	**–**	4,30	9.480



- Through-the-toolholder coolant capability.
- Suitable for SIF adaptors.







SIF-HSK63 Form A

order number	catalogue number	CSMS system size	CSWS system size	D2	D1	L1	dog-point set screw	hex wrench	hex wrench	socket-head cap screw	kg	lbs
3738508	**HSK63ASIF70066M**	HSK63A	SIF70	70	38	66	**121.808**	**170.004**	**170.005**	**125.625**	1,44	3.180
3878347	**HSK63ASIF80063M**	HSK63A	SIF80	80	38	63	**121.812**	**170.004**	**170.005**	**125.625**	1,48	3.250

SIF-HSK80 Form A

order number	catalogue number	CSMS system size	CSWS system size	D2	D1	L1	dog-point set screw	hex wrench	hex wrench	socket-head cap screw	kg	lbs
3738510	**HSK80ASIF70066M**	HSK80A	SIF70	70	38	66	**121.808**	**170.004**	**170.005**	**125.625**	2,05	4.520

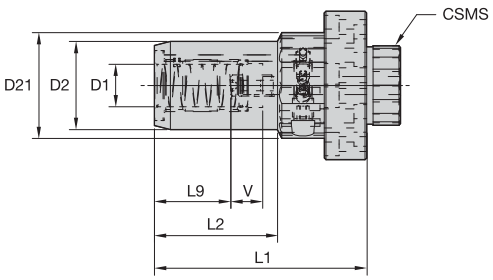
NOTE: HSK coolant unit and wrench are available and must be ordered separately.

SIF-HSK100 Form A

order number	catalogue number	CSMS system size	CSWS system size	D2	D1	L1	dog-point set screw	hex wrench	hex wrench	socket-head cap screw	kg	lbs
3738511	**HSK100ASIF70050M**	HSK100A	SIF70	70	38	50	**121.808**	**170.004**	**170.005**	**125.625**	2,43	5.360
3738512	**HSK100ASIF100070M**	HSK100A	SIF100	100	58	70	**121.812**	**170.004**	**170.006**	–	3,84	8.460

NOTE: HSK coolant unit and wrench are available and must be ordered separately.

- Runout < 0,003mm.
- External side actuation adjustment stop, giving 10mm axial adjustment.





HC HP Line • SIF70

order number	catalogue number	CSMS system size	D1	D2	D21	L1	L2	L9	V	hex wrench	T-handle hex wrench	kg	lbs
3667056	**SIF70HC12090M**	SIF70	12	32	44	90	45	36	10	**170.002**	**170.135**	1,13	2.49
3667057	**SIF70HC20100M**	SIF70	20	42	44	100	58	41	10	**170.003**	**170.135**	2,00	4.41

NOTE: HSK coolant unit and wrench are available and must be ordered separately.
IMPORTANT: Do not overtorque clamp screw. Use supplied wrench and tighten by hand until stop is felt.

HC HP Line • SIF80

order number	catalogue number	CSMS system size	D1	D2	D21	L1	L2	L9	V	hex wrench	T-handle hex wrench	kg	lbs
3667058	**SIF80HC12090M**	SIF80	12	32	50	90	45	36	10	**170.002**	**170.135**	9,00	19.84
3667059	**SIF80HC20100M**	SIF80	20	42	50	100	58	41	10	**170.003**	**170.135**	1,60	3.53
3667060	**SIF80HC25100M**	SIF80	25	50	54	100	51	47	10	**170.003**	**170.136**	1,83	4.03

NOTE: HSK coolant unit and wrench are available and must be ordered separately.
IMPORTANT: Do not overtorque clamp screw. Use supplied wrench and tighten by hand until stop is felt.

HC HP Line • SIF100

order number	catalogue number	CSMS system size	D1	D2	D21	L1	L2	L9	V	hex wrench	T-handle hex wrench	kg	lbs
3667061	**SIF100HC12090M**	SIF100	12	32	50	90	45	36	10	**170.002**	**170.135**	1,98	4.37
3667062	**SIF100HC20100M**	SIF100	20	42	50	100	58	41	10	**170.003**	**170.135**	2,19	4.84
3668023	**SIF100HC25100M**	SIF100	25	50	63	100	51	47	10	**170.004**	**170.136**	2,56	5.64

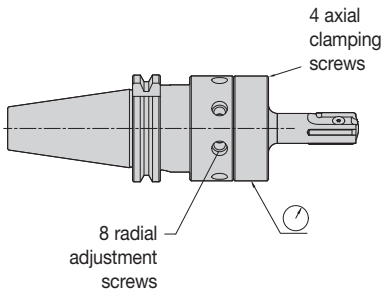
NOTE: HSK coolant unit and wrench are available and must be ordered separately.
IMPORTANT: Do not overtorque clamp screw. Use supplied wrench and tighten by hand until stop is felt.

SIF Tooling Setup

Step 1: Rough setup of runout at flange

1

- Set gage (TIR) at SIF flange.
- Tight axial clamping screws 6–8 Nm.
- Use radial adjustment screws to achieve 5 µm runout.

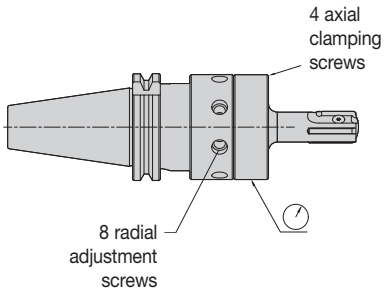




Step 2: Fine setup of runout at the flange

2

- Tight axial clamping screws crosswise:
  SIF70/80 18 Nm.
  SIF100 32 Nm.
- Use radial adjustment screws to achieve 2 µm runout.
- All radial adjustment screws to be clamped tight at 4 Nm.

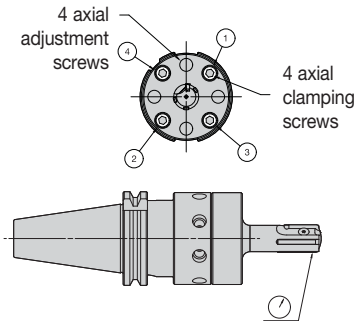




Step 3: Adjustment of runout at front

3

- Set gage (TIR) at control grind, cylindrical land, or guide pads.
- Use axial adjustment screws to achieve a maximum runout error of 2 µm.
- All axial adjustment screws to be clamped tight at 4 Nm.

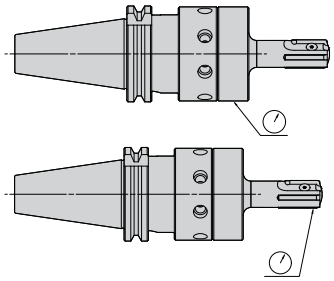




Step 4: Final runout check

4

- Check using gage (TIR) at flange; no deviation by theory.
- If needed, use radial adjustment screws to set runout below 2 µm.
- Any modification of radial setup demands an axial runout check and adjustment, if necessary.



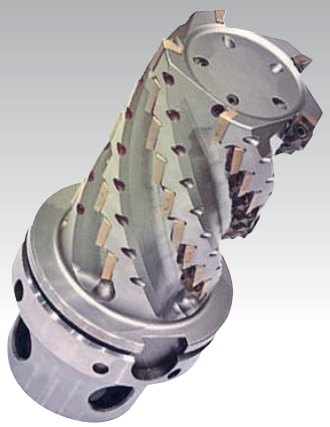


Engineered Solutions

You Won't Find These Solutions in a Catalogue

Kennametal engineered solutions pinpoint and address specific needs of customers, workpiece materials, or workpiece configurations. Solutions include standard products, custom designs, and old-fashioned process know-how that can only come from many decades of tooling expertise.

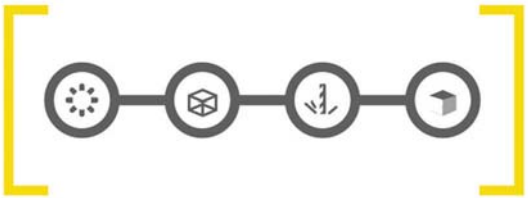
They are the result of coordinated global resources and are available anywhere in the world, no matter how small or large the project.



MANUFACTURING PROCESS

We Look at the Entire Production Process, Not Just Portions of It

From the machine tool to the last stop in production, we can optimise the manufacturing process throughout every step. The result is low implementation time and costs, and rapid return on investment.



RIQ™ (Quattro Cut™) and RIR™

Padded Reamers

Primary Application

Master the highest precision reaming with standard inserts in almost all materials with two unique systems:
RIR padded reamers for small-diameter applications and RIQ padded reamers for easy setup in large-diameters applications.

RIQ reamers are available starting at diameter 16mm (.630") with four cutting edges for lowest cost per hole. The proprietary pocket seat only requires setup of the diameter, which is a huge benefit in simplicity compared to systems that require the diameter and back taper to be adjusted simultaneously. RIR padded reamers are also proprietary and available starting at diameter 6mm (.236") with one cutting edge, and diameter 8mm (.315") with two edges.



Features and Benefits

Higher Productivity and Profitability

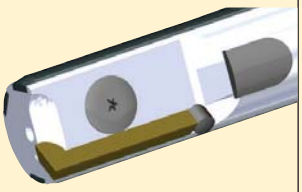
- Longer tool life with Kennametal grades.
- User friendly — RIQ padded reamers reduce setup time.
- Use four full edges even in PCD or PcBN styles of RIQ inserts.

Complete Insert Portfolio

- Large standard offering of lead geometries — E13, EDS, EDR, EGU, EGR, radius, and taper inserts.
- Large offering of grades — coated and uncoated carbide, cermet, PcBN, and PCD.

Customisation

- All RIQ tooling engineered to specific needs in diameters 16–245mm (.630–9.645") with internal coolant.
- All RIR tooling engineered to specific needs in diameters 6–245mm (.236–9.645") with internal coolant.
- RIR taper reamers available upon request.
- Multiflute and step reaming applications and special blade shapes available upon request.
- Measuring and adjustment equipment available as standard.

Application recommendation	RIR	RIQ
	Bore tolerances less than 10 µm (can be greater). Geometric tolerances down to 2 µm. Skilled workforce experience required. 	Bore tolerances less than 10 µm. Geometric tolerances down to 2 µm. Lower skilled workforce, easier adjustment. Multidiameter bores. 
Pocket seat	Flat with clamping groove in blade.	Serrated. Greater insert stability.
Cutting edges	2 (1 with PCD or CBN and 1 within diameter range 6–8mm [.236–.315"])	4 (SC, cermet, PCD, CBN)
Special blade forms	yes	yes
Multiple inserts on diameter	no	yes
Blade adjustment	Diameter and back taper.	Diameter only (back taper defined by serration).
Blade adjusting screws	2	1
Chamfer or valve seat machining	Yes, but adjustment required on position and angle.	Yes, only adjustment of position. Angle adjustment not required due to precision of serrated pocket seat.
General comments	For small diameters with high setup effort.	For larger diameters with low setup effort.

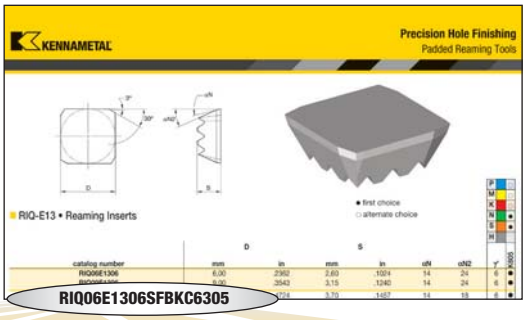

RIR™ Reamer


RIQ™ Reamer


RIQ™ Valve Seat Tool

How Do Catalogue Numbers Work?

Each character in our catalogue number signifies a specific trait of that product. Use the following key columns and corresponding images to easily identify which attributes apply.



RIQ	06	E13	06	S	FB	KC6305
Type	Size	Lead	Rake	Edge	Chipbreaker	Grade

RIR = Reamer Insert Rectangular

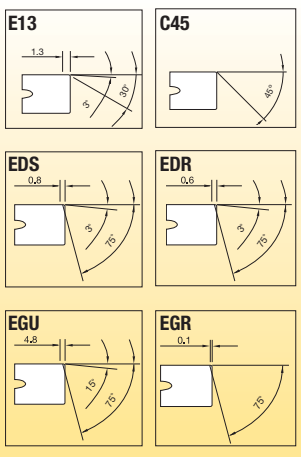
RIQ = Reamer Insert Quattro Cut™

Blade Size

Ø [mm]	RIQ	
16,0–24,99	**06**	6,0 x 6,0mm
Valve Seat	**B6**	6,0 x 6,0mm
Valve Seat	**B7**	6,5 x 6,5mm
Valve Seat	**07**	7,0 x 7,0mm
Valve Seat	**08**	8,0 x 8,0mm
>25	**09**	9,0 x 9,0mm
>25	**12**	12,0 x 12,0mm

Ø [mm]	RIR	
6,0–7,99	**A0**	10,5 x 2,50mm
8,0–10,99	**01**	15,0 x 2,80mm
11,0–13,99	**02**	18,0 x 4,00mm
14,0–17,99	**03**	20,0 x 4,76mm
18,0–45,99	**04**	27,0 x 5,56mm
>46	**05**	27,0 x 6,75mm
Taper Reamer	**T4**	45,0 x 5,56mm

Cutting Lead



Rake Angle

00



06



12



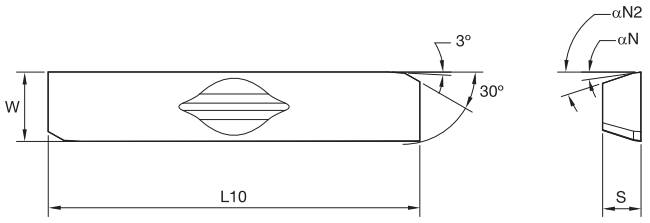
S  Chamfered and Rounded

R = Radius Blade
R02
R04
R05

FB = Finishing Blind Hole

FT = Finishing Through Hole

Grade	
Carbide	KC6005
Carbide	KC6105
Carbide	KC6305
Cermet	KT6225
Cermet	KT6315
PCD	KD1415
CBN	KB1610





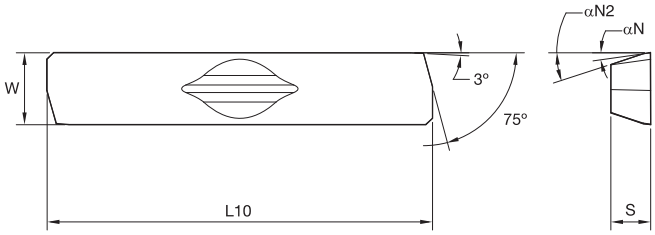
● first choice
○ alternate choice

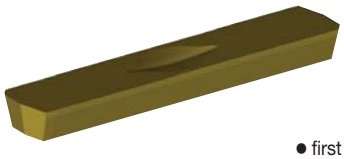
P	●	●	○
M	○	○	●
K	●	●	●
N	○	○	○
S			
H			

RIR-E13 • Reaming Inserts

ISO catalogue number	L10	S	W	αN°	αN2°	γ°	KC6005	KC6105	KC6305
RIR01E1306 *	15,00	1,53	2,80	8	18	6	–	●	–
RIR01E1312 *	15,00	1,53	2,80	8	18	12	–	●	–
RIR02E1312 *	18,00	1,93	4,00	8	18	12	–	●	●
RIR03E1312 *	20,00	2,33	4,76	8	18	12	–	–	●
RIR04E1312	27,00	3,13	5,56	8	18	12	●	–	–
RIR04E1312 *	27,00	3,13	5,56	8	18	12	–	●	–

NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.





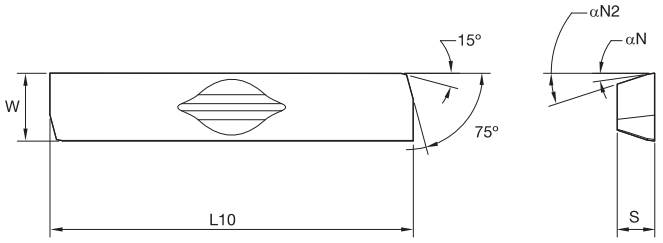
● first choice
○ alternate choice

P			
M			
K			
N			●
S			
H			

RIR-EDS • Reaming Inserts

ISO catalogue number	L10	S	W	αN°	αN2°	γ°	KD1415
RIR04EDS06 *	27,00	3,15	5,56	8	18	6	●

NOTE: All KD1415™ inserts are single tipped except full face at size RIR01.
*Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.





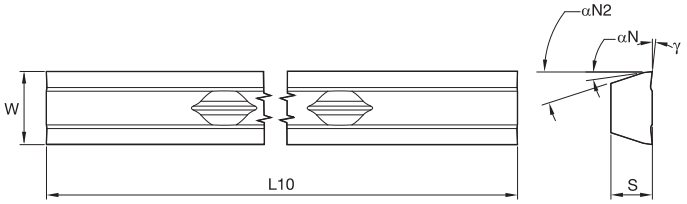
● first choice
○ alternate choice

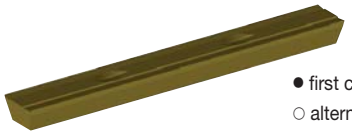
P			●
M			○
K			●
N			○
S			
H			

RIR-EGU • Reaming Inserts

ISO catalogue number	L10	S	W	αN°	αN2°	KC6105
RIR01EGU00	14,48	1,55	2,80	8	18	●
RIR05EGU00 *	27,00	3,15	6,75	8	18	●

NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.





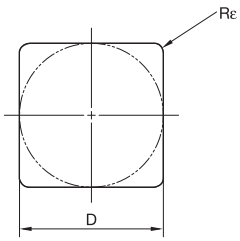
● first choice
○ alternate choice

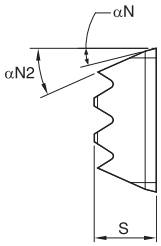
P		●
M		○
K		●
N		○
S		
H		

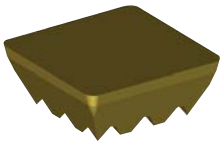
RIR-C45 • Reaming Inserts

ISO catalogue number	L10	S	W	αN°	αN2°	γ°	KC6005
RIRT4C4512	45,00	3,15	5,56	8	18	12	●

NOTE: For use with taper reamer bodies.







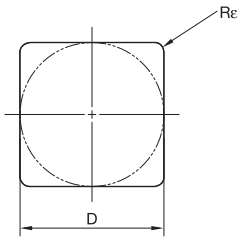
● first choice
○ alternate choice

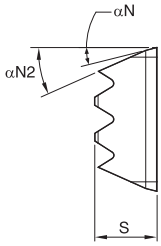
P		
M		
K		
N		●
S		
H		

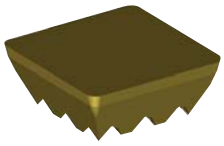
RIQ-R02 • Reaming Inserts

ISO catalogue number	D	S	Rε	αN°	αN2°	γ°	KD1415
RIQ06R0200 *	6,00	2,60	0,20	8	18	0	●

NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.





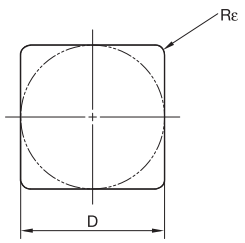


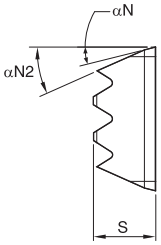
● first choice
○ alternate choice

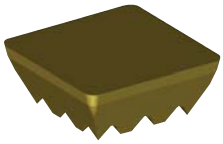
P			●
M			○
K		○	
N			
S			
H		●	

RIQ-R04 • Reaming Inserts

ISO catalogue number	D	S	Rε	αN°	αN2°	γ°	KB1610	KT6225
RIQ06R0400S	6,00	2,60	0,40	8	18	0	●	–
RIQ09R0400S	9,00	3,15	0,40	8	18	0	●	–





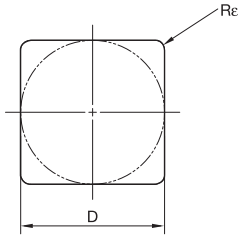


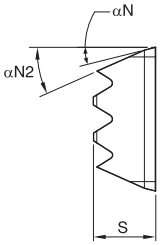
● first choice
○ alternate choice

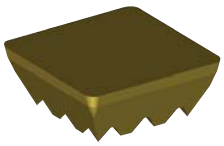
P		●
M		○
K	○	
N		
S		
H	●	

RIQ-R04-FB • Reaming Inserts • With Chipbreaker • For Blind Holes

ISO catalogue number	D	S	Rε	αN°	αN2°	γ°	KB1610	KT6225
RIQ06R0400FB	6,00	2,60	0,40	3	18	12	–	●
RIQ09R0400FB	9,00	3,15	0,40	3	18	12	–	●





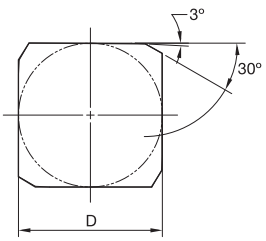


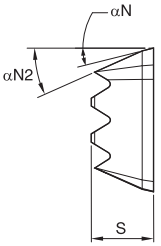
● first choice
○ alternate choice

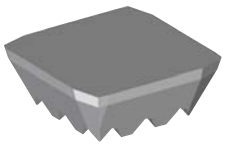
P		●
M		○
K		
N		
S		
H		

RIQ-R05 • Reaming Inserts • With Chipbreaker • For Through Holes

ISO catalogue number	D	S	Rε	αN°	αN2°	γ°	KT6315
RIQ06R0500FT	6,00	2,60	0,50	8	18	0	●
RIQ09R0506FT	9,00	3,15	0,50	14	24	6	●







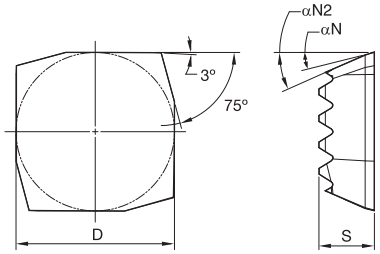
● first choice
○ alternate choice

P	●	●	○
M	○	○	●
K	●	●	●
N	○	○	○
S			
H			

RIQ-E13 • Reaming Inserts

ISO catalogue number	D	S	αN°	αN2°	γ°	KC6005	KC6105	KC6305
RIQ06E1300 *	6,00	2,60	8	18	0	●	●	●
RIQ06E1306 *	6,00	2,60	14	24	6	●	●	●
RIQ06E1312 *	6,00	2,60	20	30	12	●	●	●
RIQ09E1300 *	9,00	3,15	8	18	0	●	●	●
RIQ09E1306 *	9,00	3,15	14	24	6	●	●	●
RIQ09E1312 *	9,00	3,15	20	30	12	●	●	●

NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.





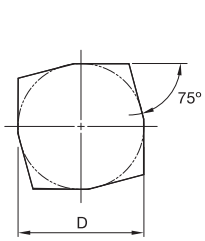
● first choice
○ alternate choice

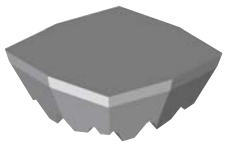
P		●	●	○	
M		○	○	●	
K		●	●	●	
N		○	○	○	●
S					
H					

RIQ-EDR • Reaming Inserts

ISO catalogue number	D	S	αN°	αN2°	γ°	KC6005	KC6105	KC6305	KD1415
RIQ06EDR00	6,00	2,60	8	18	0	●	–	●	–
RIQ06EDR00 *	6,00	2,60	8	18	0	–	●	–	–
RIQ06EDR06 *	6,00	2,60	14	24	6	●	–	–	–
RIQ06EDR06	6,00	2,60	14	24	6	–	●	●	●
RIQ06EDR12 *	6,00	2,60	20	30	12	●	●	●	–
RIQ09EDR00 *	9,00	3,15	8	18	0	●	●	●	–
RIQ09EDR06 *	9,00	3,15	14	24	6	●	●	●	●
RIQ09EDR12 *	9,00	3,15	20	30	12	●	●	●	–

NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

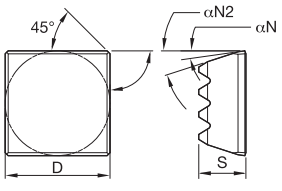


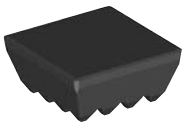


RIQ-EGR • Reaming Inserts

ISO catalogue number	D	S	αN°	αN2°	γ°	KC6005	KC6105	KC6305	KD1415
RIQ06EGR00	6,00	2,60	8	18	0	●	–	–	–
RIQ06EGR00 *	6,00	2,60	8	18	0	–	●	●	–
RIQ06EGR06	6,00	2,60	14	24	6	●	–	–	●
RIQ06EGR06 *	6,00	2,60	14	24	6	–	●	●	–
RIQ06EGR12 *	6,00	2,60	20	30	12	●	●	●	–
RIQ09EGR00	9,00	3,15	8	18	0	●	–	–	–
RIQ09EGR00 *	9,00	3,15	8	18	0	–	●	●	–
RIQ09EGR06 *	9,00	3,15	14	24	6	●	●	–	–
RIQ09EGR06	9,00	3,15	14	24	6	–	–	●	●
RIQ09EGR12 *	9,00	3,15	20	30	12	●	●	●	–

NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.





● first choice
○ alternate choice

P		
M		
K	●	●
N		
S		
H	●	●

RIQ-C45 • Valve Seat Finishing

ISO catalogue number	D	S	αN°	αN2°	KBHK10	KBHK15
RIQB6C4500S	6,00	2,60	8	18	●	●
RIQB7C4500S	6,50	2,60	8	18	●	●
RIQ07C4500S	7,00	3,15	8	18	●	●
RIQ08C4500S	8,00	3,15	8	18	●	●
RIQ09C4500S	9,00	3,15	8	18	●	●

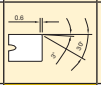
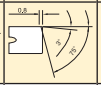
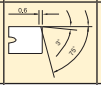
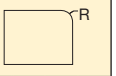
RIR™/RIQ™ • Metric

Material Group		Grade	Cutting Speed — vc Range — m/min				Hole Types	 1	 2	 3	 4	 5		
							Metric							
							Recommended Feed Rate per Tooth							
			min	Starting Value	max		E13	EDS	EDR	EGR	EGU	R0X	C45*
P	1	KC6005	30	**60**	100	mm/r	0,10–0,20	–	–	–	–	–	0,20–0,30
	2	KC6005	20	**50**	90	mm/r	0,10–0,20	–	–	–	–	–	0,20–0,30
	3	KC6005	20	**40**	80	mm/r	0,05–0,20	–	–	–	–	–	0,20–0,30
		KT6225	120	**180**	240	mm/r	–	–	–	–	–	0,15–0,20	–
		KT6315	120	**180**	240	mm/r	–	–	–	–	–	0,15–0,20	–
	4	KC6005	15	**30**	50	mm/r	0,05–0,20	–	–	–	–	–	0,20–0,30
		KC6105	15	**30**	50	mm/r	0,05–0,20	–	–	–	–	–	–
		KT6225	120	**180**	240	mm/r	–	–	–	–	–	0,15–0,20	–
		KT6315	120	**180**	240	mm/r	–	–	–	–	–	0,15–0,20	–
	5	KC6105	10	**25**	40	mm/r	0,05–0,20	–	–	–	–	–	–
	6	KC6105	10	**25**	40	mm/r	0,05–0,20	–	–	–	–	–	–
M	1	KC6305	10	**25**	40	mm/r	0,05–0,20	–	–	–	–	–	–
	2	KC6305	10	**25**	40	mm/r	0,05–0,20	–	–	–	–	–	–
	3	KC6305	10	**25**	40	mm/r	0,05–0,20	–	–	–	–	–	–
K	1	KC6005	20	**70**	100	mm/r	0,10–0,20	0,15–0,20	0,15–0,20	0,18–0,20	–	–	0,20–0,30
		K6105	20	**70**	100	mm/r	–	–	–	–	0,20	–	–
	2	KC6005	20	**60**	100	mm/r	0,10–0,20	0,15–0,20	0,15–0,20	0,18–0,20	–	–	0,20–0,30
		K6105	20	**60**	100	mm/r	–	–	–	–	0,20	–	–
	3	KC6005	20	**60**	100	mm/r	0,10–0,20	0,13–0,20	0,13–0,20	0,15–0,20	0,17–0,20	–	0,20–0,30
N	1	KD1415	100	**250**	600+	mm/r	–	0,10–0,20	0,10–0,20	0,10–0,20	–	–	–
	2	KD1415	100	**250**	600+	mm/r	–	0,10–0,20	0,10–0,20	0,10–0,20	–	–	–
	3	KD1415	100	**250**	600+	mm/r	–	0,10–0,20	0,10–0,20	0,10–0,20	–	–	–
	4	KD1415	100	**250**	600+	mm/r	–	0,10–0,20	0,10–0,20	0,10–0,20	–	–	–
S	1	–	–	–	–	mm/r	Recommendations available on request						
	2	–	–	–	–	mm/r							
	3	–	–	–	–	mm/r							
	4	–	–	–	–	mm/r							
H	1	KB1610	150	**180**	200	mm/r	–	–	–	–	–	0,05–0,10	–

*For taper reamers vc min 5 m/min, starting vc 10 m/min, max. vc 20 m/min

Overview of RIR and RIQ insert leads

Alternative insert lead that can be used

Tool designed for below listed lead	E06	E13	EDS	EGS	EKS	EGU	EGR	EDR	EKR	ESR	EUR	R02	R04	R06	R08
															
E06	●	–	–	–	–	–	–	–	–	–	–	●	–	–	–
E13	●	●	–	–	–	–	○	○	○	○	○	●	○	–	–
EDS	●	–	●	●	–	–	●	●	○	–	–	●	○	–	–
EGS	○	–	–	●	–	–	●	–	–	–	–	●	○	–	–
EKS	●	–	–	–	●	–	●	●	●	–	–	●	○	–	–
EGU	○	–	○	○	○	●	●	○	○	○	○	●	○	○	–
EGR	●	–	–	–	–	–	●	–	–	–	–	●	○	–	–
EDR	●	–	–	○	–	–	●	●	●	●	○	●	○	–	–
EKR	●	–	–	○	–	–	●	●	●	●	○	●	○	–	–
ESR	●	–	–	○	–	–	●	●	●	●	○	●	○	–	–
EUR	●	–	–	○	–	–	●	●	●	●	●	●	●	–	–
R02	–	–	–	–	–	–	○	–	–	–	–	●	–	–	–
R04	–	–	–	–	–	–	○	–	–	–	–	●	●	–	–
R06	●	–	–	–	–	–	●	●	●	●	●	●	●	●	–
R08	●	–	–	–	–	–	●	●	●	●	●	●	●	●	●

Insert Lead

Surface finish	●●●	●●●	●●	●	●●	●●	●	●●	●●	●●	●●	●●	●●	●●	●●
Postioning accuracy	–	–	●●	●●●	●●	●●	●●●	●●	●●	●●	●●	●	●	●	●

Legend

●	Alternative Inserts	Delivery condition of tool. Insert lead = tool lead.
●		90% compatible. Later support of guide pads at the bore entrance can happen, if leads are not identical.
○		Under certain circumstances compatible. Refer to a Kennametal expert for further support.
–		Do not use in this tool. Can lead to tool damage.

●●●	Surface/ Positioning	Excellent results
●●		Good results
●		Sufficient results
–		Not given

General advice: To mount an insert, where the lead is not identical to the tool lead, the rake angle and insert size have to be identical.

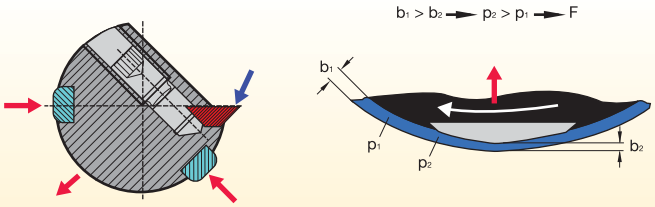
coolant selection		
	recommended	alternative
material type	mineral-oil-based emulsions	semi-synthetic
steel	6%	10%
nickel chrome steel	6%	12%
stainless steel	6%	12%
cast iron	6%	6%
aluminium	6%	12%
zinc alloys	6%	12%
copper	6%	12%
brass	6%	6%

pressure and flow rates					
cut diameter (mm)	cut diameter (in)	flow rate (L/min)	flow rate (gal/min)	pressure (bar)	pressure (psi)
6–12	.25–.468	15–20	55–75	>10	>150
12–16	.468–.625	20–40	75–150	>8	>120
16–20	.625–.781	30–50	115–190	>7	>100
20–32	.781–1.25	40–75	150–285	>5	>75
32–50	1.25–2.0	65–250	245–950	>4	>50
50–100	2.0–4.0	175–350	660–1325	>3	>40

Basic Principle

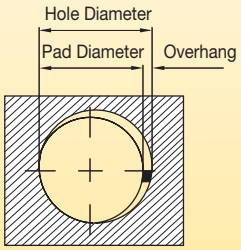
The Kennametal padded reaming tools follow two basic rules. The result, perfectly cylindrical bores with exceptional straightness and superior surface finishes combined with a bore diameter tolerance held to microns:

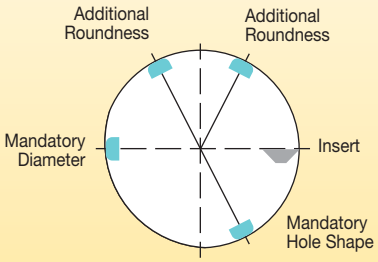
1. A SINGLE-POINT BORING TOOL SUPPORTED BY BEARING PADS, FLOATING ON A COOLANT FILM.
2. A TOOL MUST DEFLECT ONTO THE PADS, ON ENTERING THE HOLE, IN ORDER TO OBTAIN THE CORRECT SIZE.



Each padded reamer hosts a selection of guide pads that are positioned to resist the cutting forces created during machining. A minimum of two guide pads are necessary guiding the reamer in the predrilled hole.

The lubricant, in the form of coolant, gets between the pad and component surface, resulting in frictionless stability during cutting.





Guide pads are ground slightly smaller than the targeted diameter, this allows for blade/insert wear. Most common is a 10 µm overhang but can vary depending on the material to be cut.

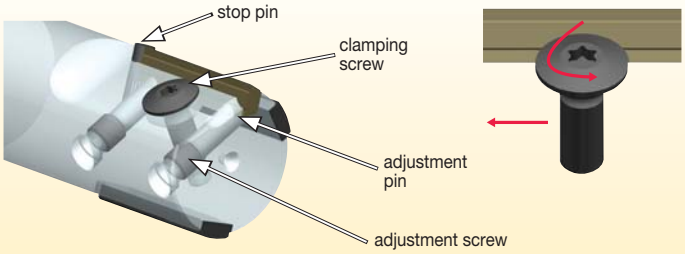
As padded reamers are specifically ground, relative to diameter and tolerance, guide pads are not flexible or adjustable. The pad below the insert ensures hole roundness while the pad opposite the insert defines the bore diameter. Each further pad improves the roundness, straightness, and bridges interruptions within the bore.

These carbide, cermet, PCD, and ceramic guide pads are selected and brazed or bonded to the body depending on coolant availability/type and abrasiveness of the material to be cut. Especially with high L/D ratio tooling (e.g., cam and crank boring bars), bonding of guide pads offers higher precision due to less thermal influence to the steel base body.

● first choice ○ alternate choice

material	P	M	K	N	S	H	MQL
carbide	●	○	●	●		○	○
cermet	●	○	●			○	●
PCD			○		●		●

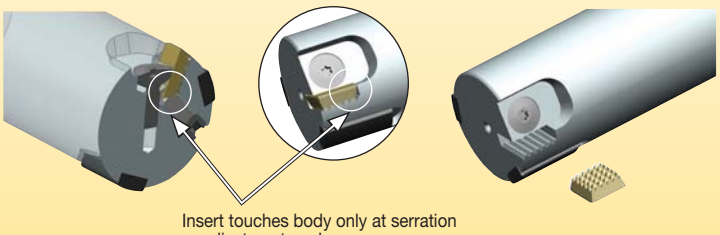
RIR Clamping



RIR reaming inserts are clamped by a single screw to avoid weakening of the pocket seat against common clamping wedges. This clamp screw has a left hand thread to move and securely hold the blade against the stop pin. The stop pin ensures correct advancement of cutting insert to guiding pad.

Like other types of padded reamers using rectangular reaming inserts, two adjustment screws and wedges are required to adjust diameter and back taper accurately. Therefore, RIR is the preferred solution for diameters below RIQ range.

RIQ Clamping



There is no need to adjust back taper as this is already predefined by the serrations. Only the overhang of the cutting edge, relative to the guide pads, needs to be adjusted.

The right-hand clamp screw locks the insert securely onto the high-precision serration. The three cutting edges that are not in use are completely protected by the body while not touching them. All four cutting edges of full-face CBN and PCD inserts can be completely used without the danger of accidently damaging one of them.

The special form of the clamp screw provides the highest clamping forces enabling less loss of diameter by bedding in effects than known on finger-clamp systems

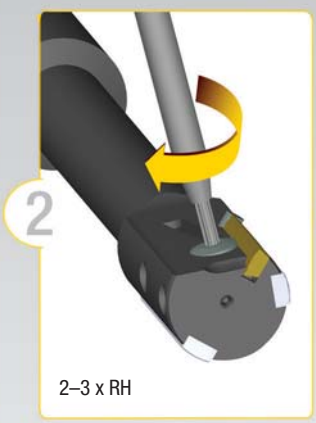
The proprietary adjustment wedge prevents any unpredictable rotation. This avoids errors during setup that cause tool damages.

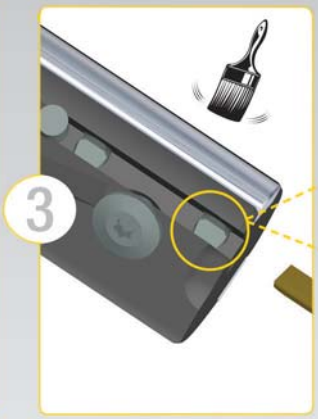
Adjustment Pin and Screw

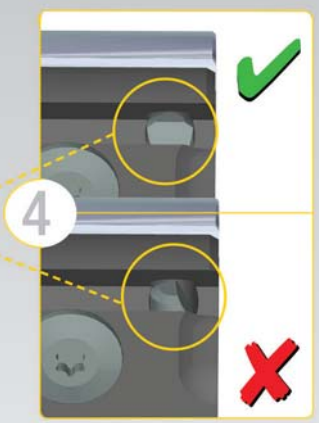


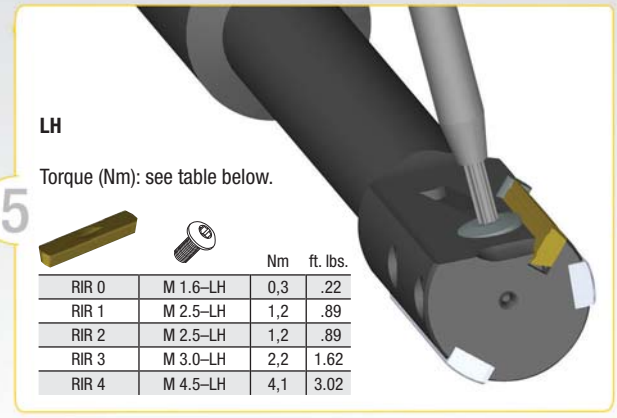
RIR Tooling Setup



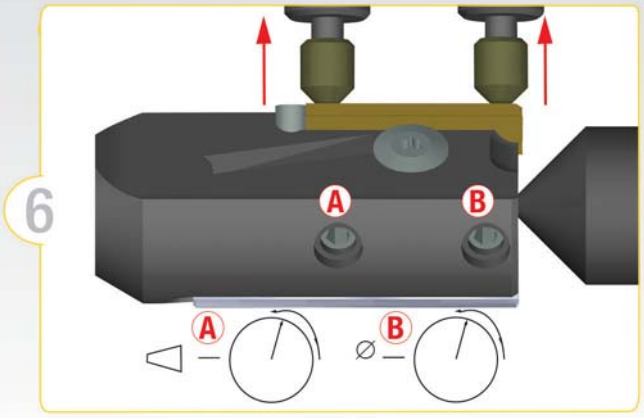






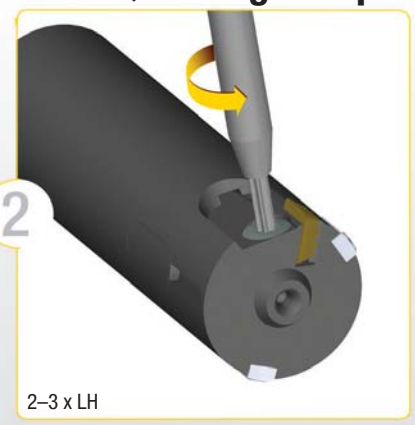


		Nm	ft. lbs.
RIR 0	M 1.6–LH	0,3	.22
RIR 1	M 2.5–LH	1,2	.89
RIR 2	M 2.5–LH	1,2	.89
RIR 3	M 3.0–LH	2,2	1.62
RIR 4	M 4.5–LH	4,1	3.02

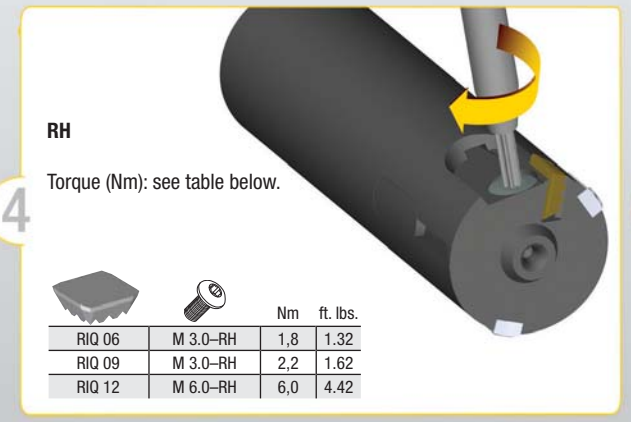


RIQ Tooling Setup

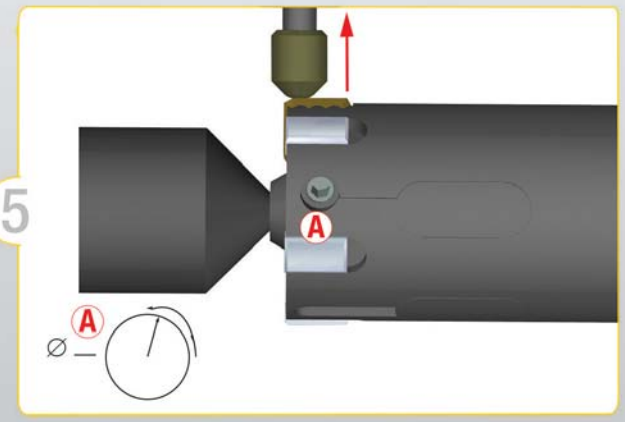






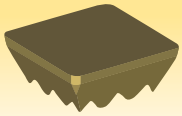


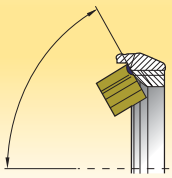
		Nm	ft. lbs.
RIQ 06	M 3.0–RH	1,8	1.32
RIQ 09	M 3.0–RH	2,2	1.62
RIQ 12	M 6.0–RH	6,0	4.42

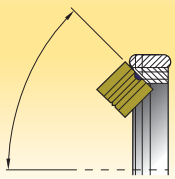


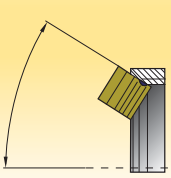
Valve Seat Tools • RIQ™ Quattro Cut™ Based Tooling

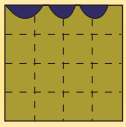
RIQ technology enables bypassing any angular adjustment of the insert and provides up to 12 cutting edges.











- Causing in three wear areas per edge.
- Resulting into 12 usable cutting edges per insert.

Valve Seat Tools • Machining Centre Solutions

RIQ valve seat tooling with integrated hydraulic chuck to clamp multiflute RMS™ or RIR™ guide pad reamer.

Machining Centre • Integrated Hydraulic Chuck

RMS Multiflute Reamer
for regular runout accuracy of valve seat to value guide demands



RIR Guide Pad Reamer
for highest requests regarding valve guide roundness and cylindricity



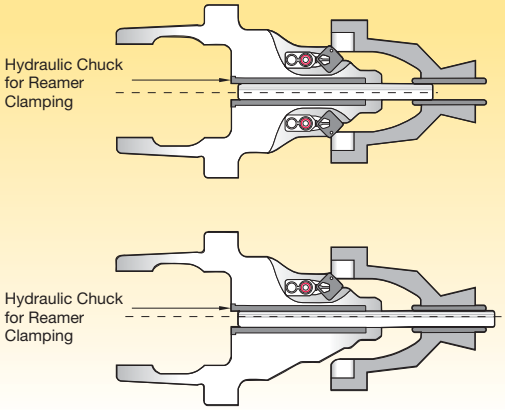
Machining Centre Process • All Angles Formed to Finish Specifications in TWO Passes

Process A (Preferred)
Tool 1 • Semi-Finish:
- Finish of secondary angles.
- Semi-finish of primary angles.
- Create pilot bore (short version of RMS or RIR reamer).

Tool 2 • Finish:
- Finish of primary angles.
- Finish of guide bore (long version of RMS or RIR reamer).

Process B (Alternate)
Tool 1 • Finish Valve Seat:
- Finish of primary and secondary angles.
- Create pilot bore (short version of RMS or RIR reamer).

Tool 2 • Finish Valve Guide:
- Finish of guide bore (long version of RMS or RIR reamer).





Valve Seat Tools • Transfer Line Solutions

RIQ valve seat tooling with carbide bushing guiding RMS or RIR reamer machining the valve guide on transfer lines.

Transfer Line • Integrated Carbide Bushing

Multiflute Reamer RMS
for regular runout accuracy of valve seat to value guide demands



RIR Guide Pad Reamer
for highest requests regarding valve guide roundness and cylindricity

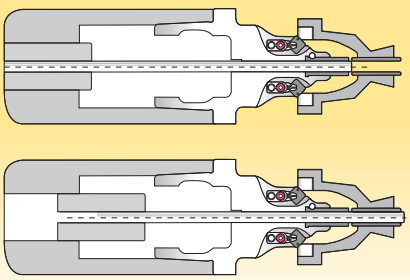


Transfer Line Process • All Angles Formed to Finish Specifications in TWO Passes/ONE Pass

Process A (Preferred)
Tool 1 • Semi-Finish:
- Semi-finish of secondary angles.
- Semi-finish of primary angles.

Tool 2 • Finish:
- Finish of primary angles.
- Finish of secondary angles.
- Finish of guide bore with feed out multiflute or guide pad reamer (squirt-through type).

Process B (Alternate)
Tool 1 • Semi-Finish and Finish Combined:
- Finish of primary and secondary seat angles.
- Finish of guide bore with feed out multiflute or guide pad reamer (squirt-through type).





Fine Boring Application Sheet

Feature tolerances, surface finishes, and geometric tolerances have to be content of the workpiece drawing

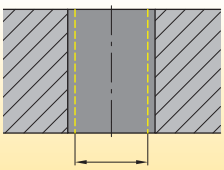
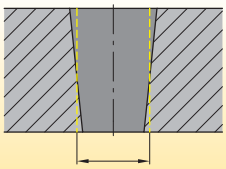
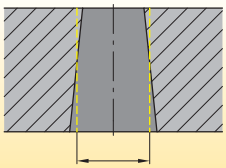
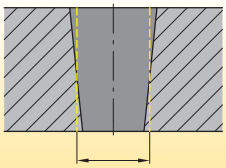
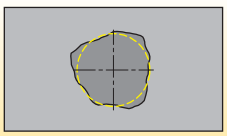
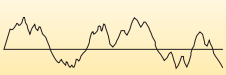
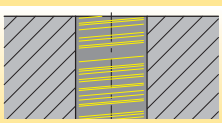
Q-Number:				**Date:**	
Customer:				**Sales eng.:**	
Location:				**Application eng.:**	
Contact person:				**Competitors:**	
General					
Status:	❒ Launch	❒ Running progress	❒ Process change		
Volume:	Holes/Year	**Similar tool:**			
Workpiece					
Operation name:					
Diameters/features to be machined	**1:**	**2:**	**3:**	**4:**	**5:**	**6:**
Tolerance target:	❒ Upper third ❒ Middle third (e.g., if CpK is needed) ❒ Lower third (e.g., if Go/NoGo Gage)		**Interrupted cut:** ❒ Yes ❒ No **Facing included:** ❒ Yes ❒ No **Max lead length:** _____		
CpK-value:	❒ Yes ❒ No		**Hole type:** ❒ Blind ❒ Through		
Workpiece material:			**Hardness/strength:**		(N/mm², HRC,...)
Premachining: (detailed description including stock amounts)					
Machine/Fixture/Hole Gaging					
Machine type:	❒ Machining centre ❒ Transfer line ❒ Lathe ❒ Special purpose machine				
Machine name:					
Tool:	❒ Rotating ❒ Stationary		**Spindle connection:**		(HSK80A, DV50, BT40,...)
Spindle orientation:	❒ Horizontal ❒ Vertical		**Number of spindles:**		(for same operation on same machine)
Workpiece clamping:	❒ Rigid ❒ Weak		**M/C spindle adjustment:**	❒ Radial runout ❒ Axial runout ❒ No	
Setting device available: (only for adjustable tools)	❒ Yes:		Description	❒ No	
Gauging method:	❒ Go/NoGo-gage ❒ Air or electronic gage ❒ Other				
Coolant type	❒ Soluble ❒ Semi-synthetic ❒ Synthetic ❒ MQL				
Coolant supply:	❒ Internal ❒ External ❒ None				
Coolant pressure:	bar		**Coolant concentration:**		%
			Coolant flow:		l/min
Additional Information: (e.g. interferences, weight or dimensional restrictions, customer reason for change, known issues,...)					

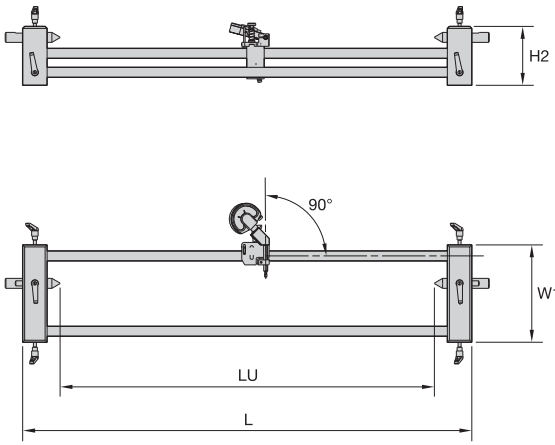
Quotation Processing Only with Workpiece Drawing and Filled Out Form

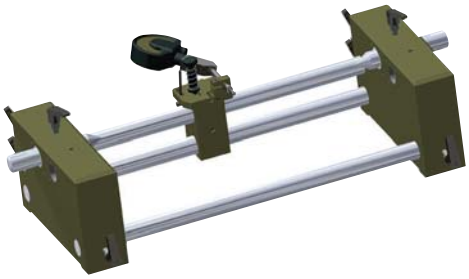
Reaming Allowances for Single Blade Reaming

	reaming allowance in diameter mm		
mm	min	middle	max
6,01–9,59	0,10	0,15	0,25
9,60–15,00	0,15	0,20	0,30
15,00–20,00	0,15	0,25	0,35
20,00–50,00	0,20	0,30	0,40

Causes of and Remedies for Reaming Problems

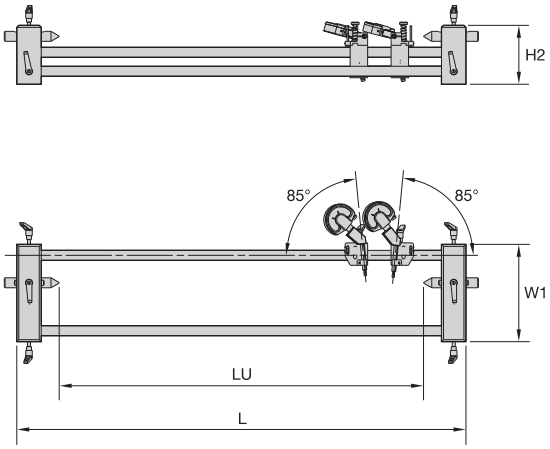
Problem		Cause	Possible Remedy
Drill diameter too large	 d_{Nom}	1. Reaming tool running out-of-centre. 2. Concentricity of pilot hole and ream machining unsatisfactory. 3. Built-up edge. 4. Unsuitable cooling lubricant. 5. Reaming tool Ø too large.	• Use SIF™ equalising adaptor. • Re-align, use floating head. • Change cooling lubricant. • Change cutting speed. • Measure reamers and send for repairs.
Drill diameter too small	 d_{Nom}	1. Reamer worn. 2. Unsuitable cooling lubricant. 3. Reaming allowance too small.	• Replace and refit tool. • Change cooling lubricant. • Increase reaming allowance.
Conical drill profile wider towards drill runout	 d_{Nom}	1. Concentricity of pilot hole and reaming unsatisfactory. 2. Positioning accuracy of pilot hole to reaming.	• Re-align, use SIF equalising adaptor. • Correct positioning accuracy.
Conical drill profile wider at drill entry point	 d_{Nom}	1. Concentricity of pilot hole and reaming unsatisfactory. 2. Reaming tool skim cutting with ledger.	• Re-align, use floating head. • Securely clamp reaming tool axially.
Hole out-of-centre and/or showing chatter marks		1. Reaming tool running out-of-centre. 2. Slanted cutting surface/asymmetrical cutting. 3. Workpiece twisted.	• Use SIF equalising adaptor. • Flatten surface before drilling or reaming. • Take the direction of impact into account when clamping the workpiece.
Surface quality does not meet specification		1. Tool cutters worn. 2. Reaming tool running out-of-centre. 3. Incorrect technology data (cutting parameters). 4. Inadequate chip evacuation.	• Replace and refit tool. • Use SIF equalising adaptor. • Change cutting parameters in machining range. • Optimise coolant supply; increase coolant pressure and volume.
Feed grooves		1. Built-up edge.	• Change cooling lubricant. • Change cutting speed.

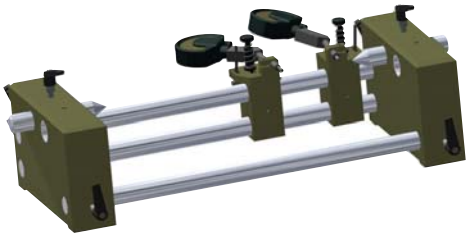




Setting Fixture • One Gage

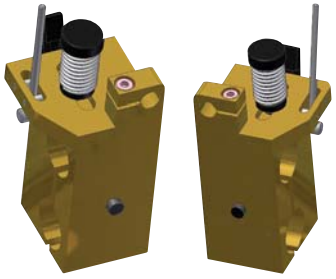
order number	catalogue number	H2	L	LU	W1
5025599	**SF300M1RS**	118	450	300	195
5025670	**SF750M1RS**	118	900	750	195





Setting Fixture • Two Gage

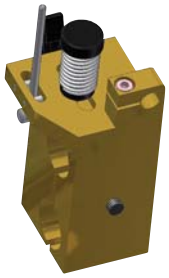
order number	catalogue number	H2	L	LU	W1
5025597	**SF300M1LA1RA**	118	450	300	195
5025598	**SF750M1LA1RA**	118	900	750	195



Left Hand Right Hand

Axial Slide • 90° with Angle Fine Adjustment

order number	catalogue number
5025672	SFSLLS
5025671	SFSLRS



SM Screw Sets for Slides

Axial Slides

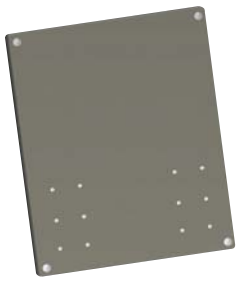
order number	catalogue number
5025683	SFSLSS



Left Hand Right Hand

Axial Slide • 85°

order number	catalogue number
5025674	SFSLLA
5025673	SFSLRA



Base Plate for Vertical Setup

order number	catalogue number
5025680	SFVB



SM Clamp Handle

Clamp Handle for End Blocks and Axial Slides

order number	catalogue number
5025682	SFEBCH



SM End Block

End Block Including Screws

order number	catalogue number
5025681	SFEBS



Contact Pins Set

order number	catalogue number
5025686	SFCPS



Support Bars (450mm and 900mm)

order number	catalogue number
5025684	SFSB450
5025685	SFSB900



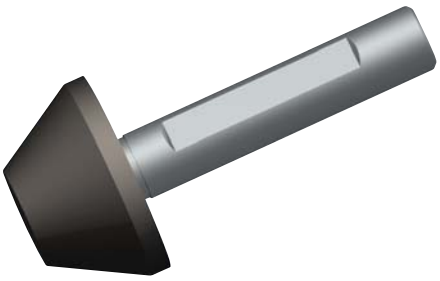
Gage Set

order number	catalogue number
5025675	SFMGS



Spring-Loaded Centre Ø 20mm

order number	catalogue number
5025679	SFCR20S



HSK Centre

order number	catalogue number
5025677	SFCRHSK3263
5025678	SFCRHSK63100



Standard Centre Ø 20mm

order number	catalogue number
5025676	SFCR20

Romicron™ Fine-Boring System

Primary Application

The Romicron tooling portfolio has a diameter range of 4–213mm (.1575–8.3858") and reduces setup time and scrap rates while increasing overall equipment efficiency. This premium fine-boring system can be used in most materials in metalcutting applications by applying the latest Kennametal standard ISO turning inserts. Its closed loop boring (CLB) provides a unique opportunity to automate insert wear compensation with minimal investment due to the precise 2 µm diameter adjustment per increment.

The Romicron system should be used where extremely close tolerances are critical to the overall process or where fast and easy diameter adjustments are needed.



Features and Benefits

Higher Productivity and Profitability

- Reduce scrap rates and setup time with backlash-free adjustment.
- Diameter adjustment can be done inside the machine, avoiding routine insert changes in the setup room.
- Avoid time-consuming control cuts or sister tooling.
- No training or experience needed for use, resulting in less stressful adjustments.

Versatility

- Retrofit existing machines to automated wear compensation using standard CLB pin. No electronic equipment needed, except hole measuring device.
- AVS00B-SVS6B prebalanced heads are preferred solution for diameter 25–139mm (.984–5.472").
- SVUBB1 tooling for high-speed applications 4–16,5mm (.157–.650").
- Broad diameter range of 6–100mm (.236–3.937") using SVUBB2 tooling.
- SVU65 and SVU92 for larger diameters of 71–213mm (2.79–8.386").

100% mechanical system with micron adjustment by hand or fully automated.



Ease of Adjustment

- No tools are needed so adjustment is done on the machine tool. Eliminates need to remove and return boring head to the presetting area, increasing productivity.
- SEE, FEEL, and HEAR the adjustment mechanism for fail-safe size control.

Customisation

- Engineered solutions available for multistep or high length-to-diameter tooling.
- Anti-chatter devices and various non-standard machine spindle coupling sizes available.



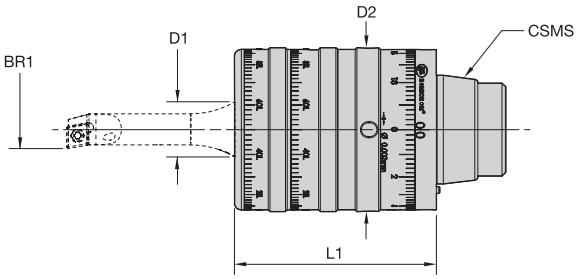
Boring range, coolant capacity, and maximum RPM features for all Romicron boring heads.

	head size	bore range
• 25,000 RPM max. • Balanceable. • 1,050 psi coolant capacity. • 1,050 psi/70 bar coolant capacity. • Movable zero reference.	**SVUBB1**	4mm – 16,5mm
• 10,000 RPM max. • Balanceable. • 1,050 psi coolant capacity. • 1,050 psi/70 bar coolant capacity. • Movable zero reference.	**SVUBB2**	6mm – 25,5mm
• 20,000 RPM. • Prebalanced. • 1740 psi/120 bar coolant capacity.	**AVS00B**	25mm – 32mm
• 20,000 RPM. • Prebalanced. • 1740 psi/120 bar coolant capacity.	**AVS0B**	31,5mm – 42,5mm
• 20,000 RPM. • Prebalanced. • 1740 psi/120 bar coolant capacity.	**AVS1B**	42mm – 53mm
• 20,000 RPM. • Prebalanced. • 1740 psi/120 bar coolant capacity.	**AVS2B**	52mm – 66mm
• 20,000 RPM. • Prebalanced. • 1740 psi/120 bar coolant capacity.	**AVS3B**	65mm – 79mm
• 4,500 RPM. • Prebalanced. • 300 psi/20 bar coolant capacity.	**SVS4B**	78mm – 98mm
• 4,500 RPM. • Prebalanced. • 300 psi/20 bar coolant capacity.	**SVS5B**	97mm – 117mm
• 3,500 RPM. • Prebalanced. • 300 psi/20 bar coolant capacity.	**SVS6B**	116mm – 139mm
• 6,000 RPM. • Balanceable. • 300 psi/20 bar coolant capacity. • Movable zero reference.	**SVU65**	71mm – 111mm
• 6,000 RPM. • Balanceable. • 300 psi/20 bar coolant capacity. • Movable zero reference.	**SVU92**	101mm – 213mm
• 6,000 RPM. • Balanceable. • 300 psi/20 bar coolant capacity. • Movable zero reference.	**SVU120**	139mm – 326mm

range mm	order number	catalogue number	content		
4,00–16,50	**4046076**	**SVUBB1KR32KIT**	KR32SVUBB1060M KRBB10FADRS102C KRBB10SCLDRS4060C KRBB10SCFPR06085C KRBB10SCFPR06110C KRBB10SCFPR06135C		
6,00–25,50	**4046077**	**SVUBB2KR32KITD025M**	KR32SVUBB2085M KRBB16SCLDRS4060A KRBB16SCFPR06085A KRBB16SCFPR06110A KRBB16SCFPR06135A KRBB16SCFPR06160A KRBB16SCFPR06190A KRBB16SCFPR06220A		
6,00–25,50	**4046078**	**SVUBB2KR50KITD025M**	KRBB16SCFPR06220A KR50SVUBB2075M KRBB16SCLDRS4060A KRBB16SCFPR06085A KRBB16SCFPR06110A KRBB16SCFPR06135A KRBB16SCFPR06160A KRBB16SCFPR06190A KRBB16SCFPR06220A		
6,00–100,00	**4052608**	**SVUBB2KR32KITD100M**	KR32SVUBB2085M KRBB16SCLDRS4060A KRBB16SCFPR06085A KRBB16SCFPR06110A KRBB16SCFPR06135A KRBB16SCFPR06160A KRBB16SCFPR06190A KRBB16SCFPR06220A	KRDEA046AM KRDE025010M KRDE033010M KRDEA051AM KRDE043010M KRDEA012AM KRDE065012M KRCW032A	
6,00–100,00	**4052609**	**SVUBB2KR50KITD100M**	KR50SVUBB2075M KRBB16SCLDRS4060A KRBB16SCFPR06085A KRBB16SCFPR06110A KRBB16SCFPR06135A KRBB16SCFPR06160A KRBB16SCFPR06190A KRBB16SCFPR06220A	KRDEA046AM KRDE025010M KRDE033010M KRDEA051AM KRDE043010M KRDEA012AM KRDE065012M KRCW032A	

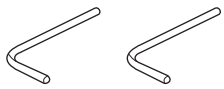
- For correct balance ring settings, see pages K96–K97.
- Order boring bar separately; see page K74.
- Order taper shank seperately; see page K86.







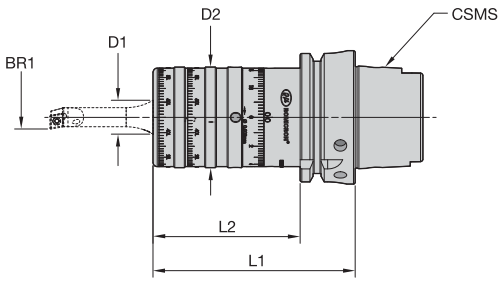
SVU BB1 • KR Back End with CLB Capability



order number	catalogue number	BR1 bore range	CSMS system size	D1	D2	L1	Torx wrench	hex wrench	kg	lbs
4054737	**KR32SVUBB1060MCLB**	4,000-16,500	KR32	10,0	46,5	58,6	**KT8**	**170.000**	0,94	2.07

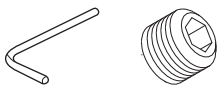
- For correct balance ring settings, see pages K96–K97.
- Order boring bar separately; see page K74.







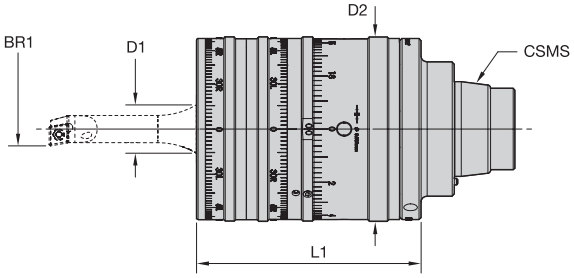
SVU BB1 • HSK Back End with CLB Capability



order number	catalogue number	BR1 bore range	CSMS system size	D1	D2	L1	L2	Torx wrench	radial adjusting screw	kg	lbs
4054734	**HSK63ASVUBB1095MCLB**	4,000-16,500	HSK63A	10,0	46,5	95,5	69,4	**KT15**	**191.282**	1,45	3.20

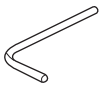
- For correct balance ring settings, see pages K98–K103.
- Order boring bar separately; see page K75.
- Order taper shank separately; see page K86.







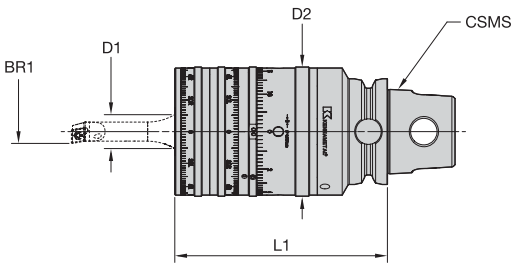
SVU BB2 • KR Back End with CLB Capability



order number	catalogue number	BR1 bore range	CSMS system size	D1	D2	L1	Torx wrench	kg	lbs
4054738	**KR32SVUBB2085MCLB**	6,000-25,500	KR32	16,0	60,0	85,0	**KT27**	1,81	3.99
4054739	**KR50SVUBB2075MCLB**	6,000-25,500	KR50	16,0	60,0	75,0	**KT27**	1,61	3.55

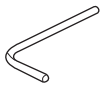
- For correct balance ring settings, see pages K98–K103.
- Order boring bar separately; see page K75.







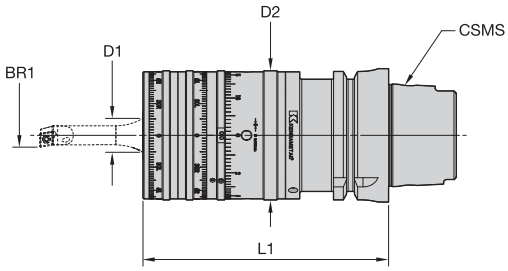
SVU BB2 • KM™ Back End with CLB Capability



order number	catalogue number	BR1 bore range	CSMS system size	D1	D2	L1	Torx wrench	kg	lbs
4054736	**KM50TSSVUBB2100MCLB**	6,000-25,500	KM50TS	16,0	60,0	100,0	**KT27**	1,91	4.21

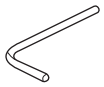
- For correct balance ring settings, see page K98–K103.
- Order boring bar separately; see page K75.





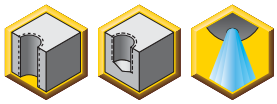


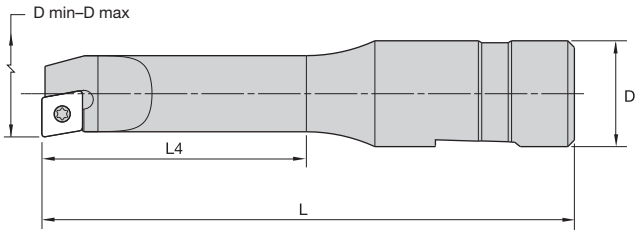
SVU BB2 • HSK Back End with CLB Capability



order number	catalogue number	BR1 bore range	CSMS system size	D1	D2	L1	Torx wrench	kg	lbs
4054735	HSK63ASVUBB2116MCLB	6,000-25,500	HSK63A	16,0	60,0	116,0	KT27	2,52	5.56
4054733	HSK100ASVUBB2124MCLB	6,000-25,500	HSK100A	16,0	60,0	124,4	KT27	4,21	9.28

- Order inserts separately.







SVU BB1 • Universal Boring Bars

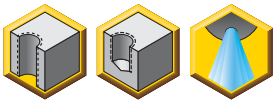


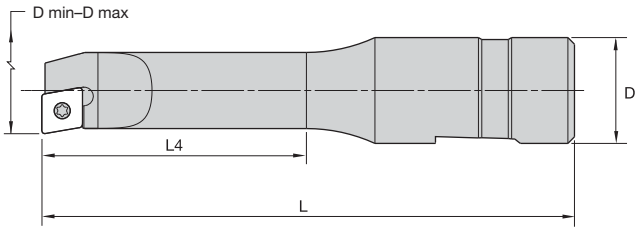


order number	catalogue number	D min	D max	D	L	L4	gage insert	insert screw	Torx wrench	kg	lbs
2202438	KRBB10FABDRS204C	4,00	7,00	10	57	14	–	–	–	0,05	.11
2202439	KRBB10SCLDR4060C	6,00	9,00	10	53	22	CD..S4T004	MS1454	FT5	0,05	.11
2202440	KRBB10SCFPR06085C	8,50	11,50	10	58	31	CP..060204	MS2005	FT7	0,08	.17
2202450	KRBB10SCFPR06110C	11,00	14,00	10	60	33	CP..060204	MS2005	FT7	0,08	.18
2202451	KRBB10SCFPR06135C	13,50	16,50	10	65	39	CP..060204	MS1153	FT7	0,09	.20

NOTE: Carbide shank and customised boring bars are available upon request to meet your specific requirements.
Please contact Kennametal for a design and quotation.

• Order inserts separately.





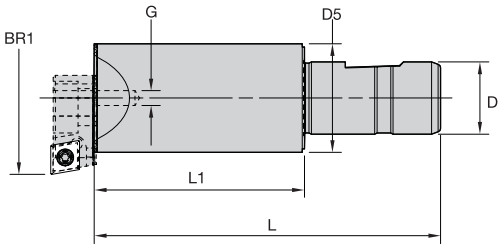


SVU BB2 • Universal Boring Bars

order number	catalogue number	D min	D max	D	L	L4	gage insert	insert screw	Torx wrench	kg	lbs
1522063	**KRBB16SCFPR06085A**	8,50	12,00	16	68	26	CP..060204	**MS1153**	**FT7**	0,06	.14
1522062	**KRBB16SCLDRS406A**	6,00	9,50	16	62	20	CD..S4T004	**MS1454**	**FT6**	0,06	.13
1522064	**KRBB16SCFPR0611A**	11,00	14,50	16	78	36	CP..060204	**MS1153**	**FT7**	0,08	.17
1522068	**KRBB16SCFPR06135A**	13,50	17,00	16	80	40	CP..060204	**MS1153**	**FT7**	0,09	.20
1522069	**KRBB16SCFPR0616A**	16,00	19,50	16	90	55	CP..060204	**MS1153**	**FT7**	0,11	.25
1522070	**KRBB16SCFPR0619A**	19,00	22,50	16	90	60	CP..060204	**MS1153**	**FT7**	0,12	.27
1522071	**KRBB16SCFPR0622A**	22,00	25,50	16	90	60	CP..060204	**MS1153**	**FT7**	0,15	.32

NOTE: Carbide shank and customised boring bars are available upon request to meet your specific requirements. Please contact Kennametal for a design and quotation.



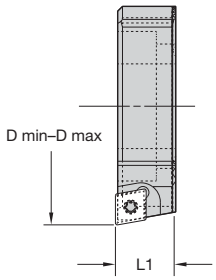


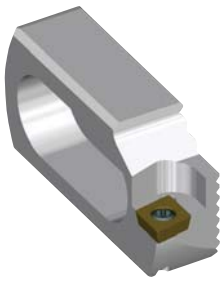


SVU BB2 • Universal Adaptors

order number	catalogue number	BR1 bore range	D	D5	G	L	L1	kg	lbs
2541200	**KRDEA046AM**	25,500-43,500	16	24,0	M4X0.70	76,4	46,4	0,2	.50
2541201	**KRDEA051AM**	43,000-65,000	16	25,0	M6X1.00	81,7	51,7	0,2	.52
2541202	**KRDEA012AM**	65,000-100,000	16	63,5	M8X1.25	42,5	12,5	0,2	.42

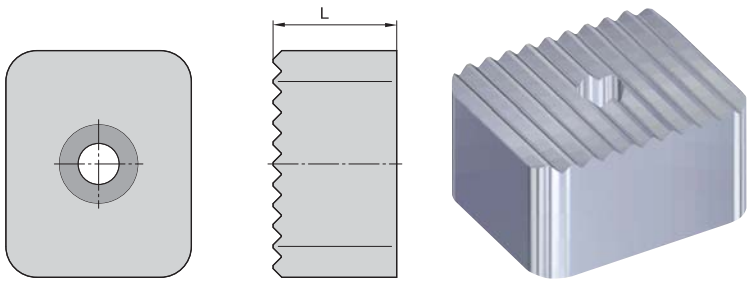
- Order inserts separately.





SVU BB2 • Universal Diameter Extenders

order number	catalogue number	D min	D max	L1	gage insert	insert screw	Torx wrench	kg	lbs
2541213	**KRDE025010M**	25,50	33,50	10,0	CP..0602../CP..215...	**MS1153**	**FT7**	0,02	.04
2541214	**KRDE033010M**	33,50	43,50	10,0	CP..0602../CP..215...	**MS1153**	**FT7**	0,02	.05
2541215	**KRDE043010M**	43,00	65,00	10,0	CP..0602../CP..215...	**MS1153**	**FT7**	0,03	.07
2541216	**KRDE065012M**	65,00	100,00	12,0	CP..0602../CP..215...	**MS1153**	**FT7**	0,05	.10



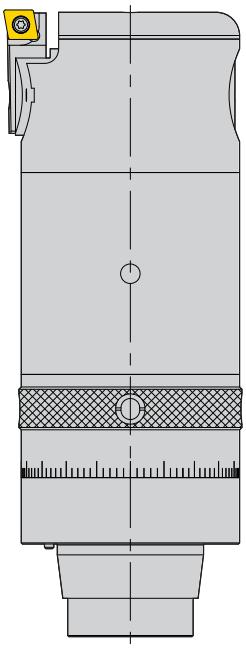
SVU BB2 • Counterweight

order number	catalogue number	L	kg	lbs
2541217	**KRCW032A**	12,0	0,04	.08

NOTE: Counterweight must be used with KRDEA012M adaptor and KRDEA065012M extender.

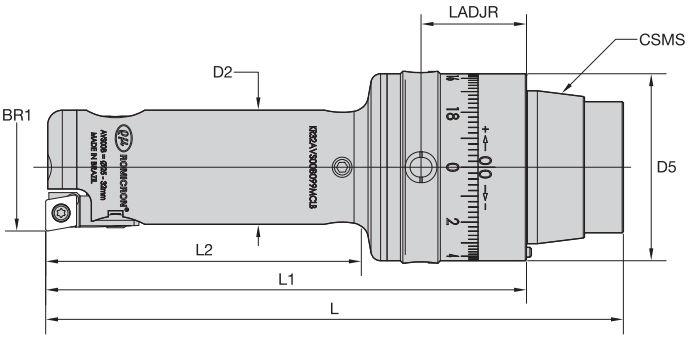
AVS and SVS Systems • Tooling Tree

cartridge range	cartridge size	bore range	head size
25–27,5mm	1Y	25–32mm	AVS00B
27,25–29,75mm	2Y		
29,5–32mm	3Y		
31,5–35,5mm	1X	31,5–42,5mm	AVS0B
35–39mm	2X		
38,5–42,5mm	3X		
42–46mm	1X	42–53mm	AVS1B
45,5–49,5mm	2X		
49–53mm	3X		
52–57mm	1W	52–66mm	AVS2B
56,5–61,5mm	2W		
61–66mm	3W		
65–70mm	1W	65–79mm	AVS3B
69,5–74,5mm	2W		
74–79mm	3W		



- Order cartridges separately.
- Order taper shank separately.





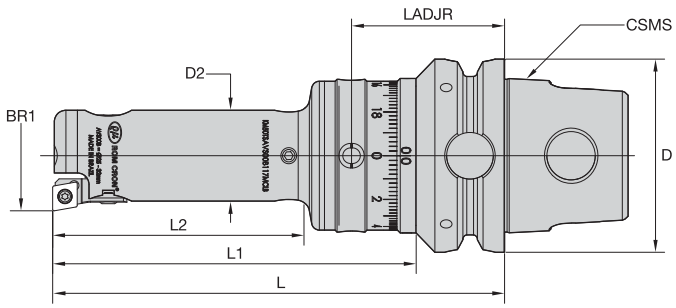


AVS • KR Back End with CLB Capability

order number	catalogue number	BR1 bore range	CSMS system size	D2	D5	L	L1	L2	LADJR	kg	lbs
5124812	**KR32AVS00B099MCLB**	25,000-32,000	KR32	23,5	39,5	119,0	99,0	64,0	21,7	0,6	1.20
5124814	**KR32AVS0B116MCLB**	31,500-42,500	KR32	30,0	39,5	136,0	116,0	85,0	21,7	0,8	1.81
5124816	**KR32AVS1B100MCLB**	42,000-53,000	KR32	38,5	39,5	120,0	100,0	100,0	21,7	1,0	2.13
5124818	**KR32AVS2B115MCLB**	52,000-66,000	KR32	47,0	48,0	135,0	115,0	115,0	29,2	1,5	3.27
5124820	**KR32AVS3B115MCLB**	65,000-79,000	KR32	47,0	48,0	135,0	115,0	115,0	29,2	1,5	3.36

- Order cartridges separately.





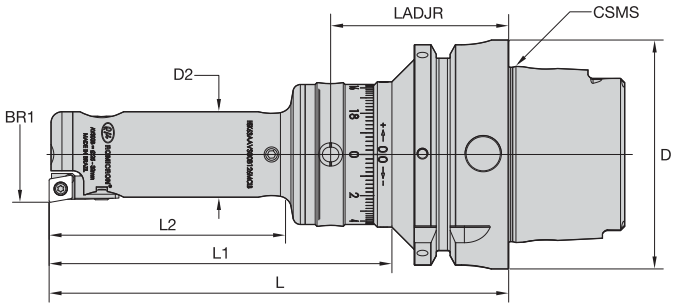


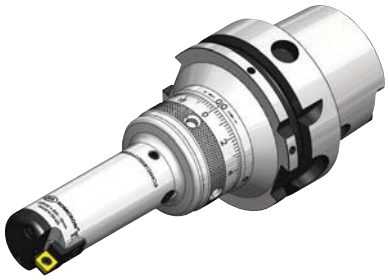
AVS • KM™ Back End with CLB Capability

order number	catalogue number	BR1 bore range	CSMS system size	D	D2	L	L1	L2	LADJR	kg	lbs
5124801	**KM40TSAVS00B111MCLB**	25.000-32.000	KM40TS	40,000	23,5	136,0	111,0	63,5	34,0	0,6	1.36
5124802	**KM40TSAVS0B128MCLB**	31.500-42.500	KM40TS	40,000	30,0	153,0	128,0	–	34,0	0,8	1.82
5124803	**KM40TSAVS1B112MCLB**	42.000-53.000	KM40TS	40,000	38,5	137,0	112,0	112,0	34,0	1,0	2.18
5124804	**KM40TSAVS2B127MCLB**	52.000-66.000	KM40TS	40,000	47,0	152,0	127,0	127,0	41,3	1,6	3.41
5124805	**KM50TSAVS00B117MCLB**	25.000-32.000	KM50TS	50,000	23,5	149,0	117,0	63,5	39,7	0,8	1.79
5124807	**KM50TSAVS0B134MCLB**	31.500-42.500	KM50TS	50,000	30,0	166,0	134,0	83,0	39,7	1,0	2.25
5124808	**KM50TSAVS1B118MCLB**	42.000-53.000	KM50TS	50,000	38,5	150,0	118,0	–	39,6	1,2	2.57
5124809	**KM50TSAVS2B128MCLB**	52.000-66.000	KM50TS	50,000	47,0	160,0	128,0	128,0	42,3	1,7	3.67
5124810	**KM50TSAVS3B128MCLB**	65.000-79.000	KM50TS	50,000	47,0	160,0	128,0	128,0	42,3	1,7	3.82
5124811	**KM63TSAVS3B130MCLB**	65.000-79.000	KM63TS	63,000	47,0	170,0	130,0	130,0	44,3	2,0	4.46

- Order cartridges separately.



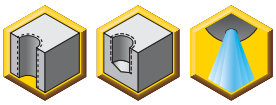


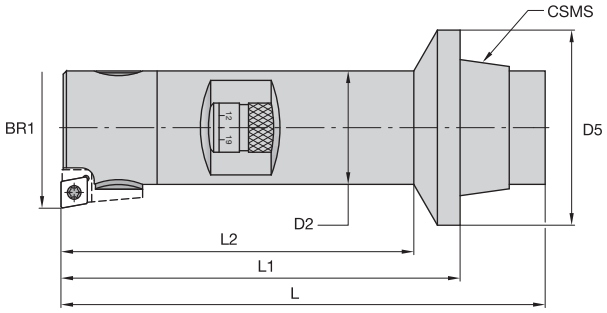


AVS • HSK Back End with CLB Capability

order number	catalogue number	BR1 bore range	CSMS system size	D	D2	L	L1	L2	LADJR	kg	lbs
5124576	**HSK63AAVS00B126MCLB**	25.000-32.000	HSK63A	63,000	23,5	158,0	126,0	63,5	49,0	1,2	2.71
5124577	**HSK63AAVS0B143MCLB**	31.500-42.500	HSK63A	63,000	30,0	175,0	143,0	83,0	49,0	1,4	3.17
5124578	**HSK63AAVS1B127MCLB**	42.000-53.000	HSK63A	63,000	38,5	159,0	127,0	95,0	49,0	1,6	3.53
5124579	**HSK63AAVS2B139MCLB**	52.000-66.000	HSK63A	63,000	47,0	171,0	139,0	109,0	53,5	2,2	4.73
5124800	**HSK63AAVS3B139MCLB**	65.000-79.000	HSK63A	63,000	47,0	171,0	139,0	109,0	53,5	2,2	4.85

- Order cartridges separately; see page K82.
- Order taper shank separately; see page K86.





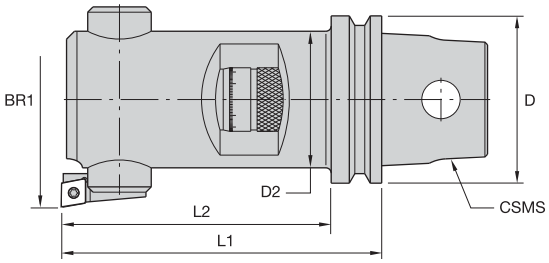


SVS • KR Back End

order number	catalogue number	BR1 bore range	CSMS system size	D2	L	L1	kg	lbs
1192281	**KR50SVS4B094M**	78,000-98,000	KR50	65,0	119,0	94,0	2,4	5.21
1279787	**KR50SVS5B094M**	97,000-117,000	KR50	65,0	119,0	94,0	3,0	6.49
1279793	**KR63SVS6B126M**	116,000-139,000	KR63	85,0	162,0	126,0	5,7	12.63

- Order cartridges separately; see page K82.



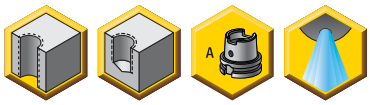


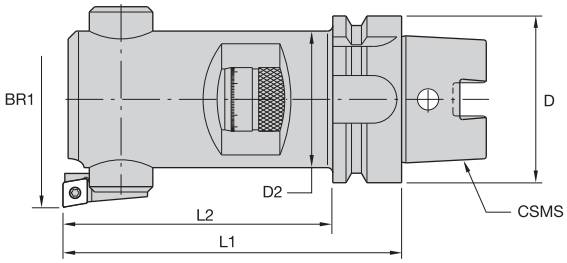


SVS • KM™ Back End

order number	catalogue number	BR1 bore range	CSMS system size	D	D2	L1	L2	kg	lbs
1763375	**KM50SVS4B125M**	78,000-98,000	KM50	50,000	65,0	125,0	110,0	2,2	4.90
1763378	**KM50SVS5B125M**	97,000-117,000	KM50	50,000	65,0	125,0	110,0	3,2	7.10
1763376	**KM63SVS4B110M**	78,000-98,000	KM63	63,000	65,0	110,0	92,0	2,4	5.30
1763379	**KM63SVS5B110M**	97,000-117,000	KM63	63,000	65,0	110,0	92,0	3,2	7.10
1763382	**KM80SVS6B150M**	116,000-139,000	KM80	80,000	85,0	150,0	128,0	7,8	17.20

- Order cartridges separately.





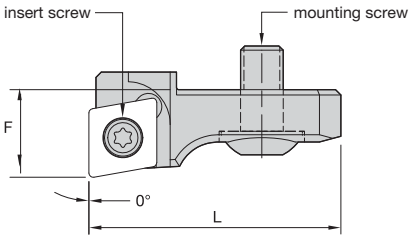


SVS • HSK Back End

order number	catalogue number	BR1 bore range	CSMS system size	D	D2	L1	L2	kg	lbs
1763116	**HSK63ASVS4B139M**	78,000-98,000	HSK63A	63,000	65,0	139,0	113,0	3,6	8.00
1763118	**HSK63ASVS5B139M**	97,000-117,000	HSK63A	63,000	65,0	139,0	113,0	5,9	13.00

- Order inserts separately.







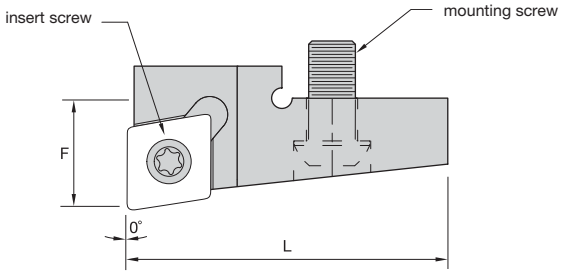
AVS • Cartridges SCF



order number	catalogue number	L	F	gage insert	reference head	cartridge size	mounting screw	Torx wrench	insert screw	Torx wrench	kg	lbs
5124822	**KRCSCFPR061Y**	19,20	4,76	CP..0602../CP..215...	AVS00B	1Y	**MS2006**	**FT8**	**MS2005**	**FT7**	0,00	.010
5124823	**KRCSCFPR062Y**	19,20	5,88	CP..0602../CP..215...	AVS00B	2Y	**MS2006**	**FT8**	**MS2005**	**FT7**	0,00	.010
5124824	**KRCSCFPR063Y**	19,20	7,01	CP..0602../CP..215...	AVS00B	3Y	**MS2006**	**FT8**	**MS2005**	**FT7**	0,00	.010
5124825	**KRCSCFPR061X**	23,75	6,46	CP..0602../CP..215...	AVS1B,AVS0B	1X	**MS-1896**	**FT15**	**MS1153**	**FT7**	0,01	.020
5124826	**KRCSCFPR062X**	23,60	8,21	CP..0602../CP..215...	AVS1B,AVS0B	2X	**MS-1896**	**FT15**	**MS1153**	**FT7**	0,01	.020
5124827	**KRCSCFPR063X**	23,60	9,96	CP..0602../CP..215...	AVS1B,AVS0B	3X	**MS-1896**	**FT15**	**MS1153**	**FT7**	0,01	.020
5124828	**KRCSCFPR061W**	26,60	6,45	CP..0602../CP..215...	AVS3B1,AVS2B1	1W	**MS-1896**	**FT15**	**MS1153**	**FT7**	0,01	.030
5124829	**KRCSCFPR062W**	26,75	8,70	CP..0602../CP..215...	AVS2B1,AVS3B1	2W	**MS-1896**	**FT15**	**MS1153**	**FT7**	0,01	.030
5124850	**KRCSCFPR063W**	26,60	10,95	CP..0602../CP..215...	AVS3B1,AVS2B1	3W	**MS-1896**	**FT15**	**MS1153**	**FT7**	0,01	.020

- Order inserts separately.



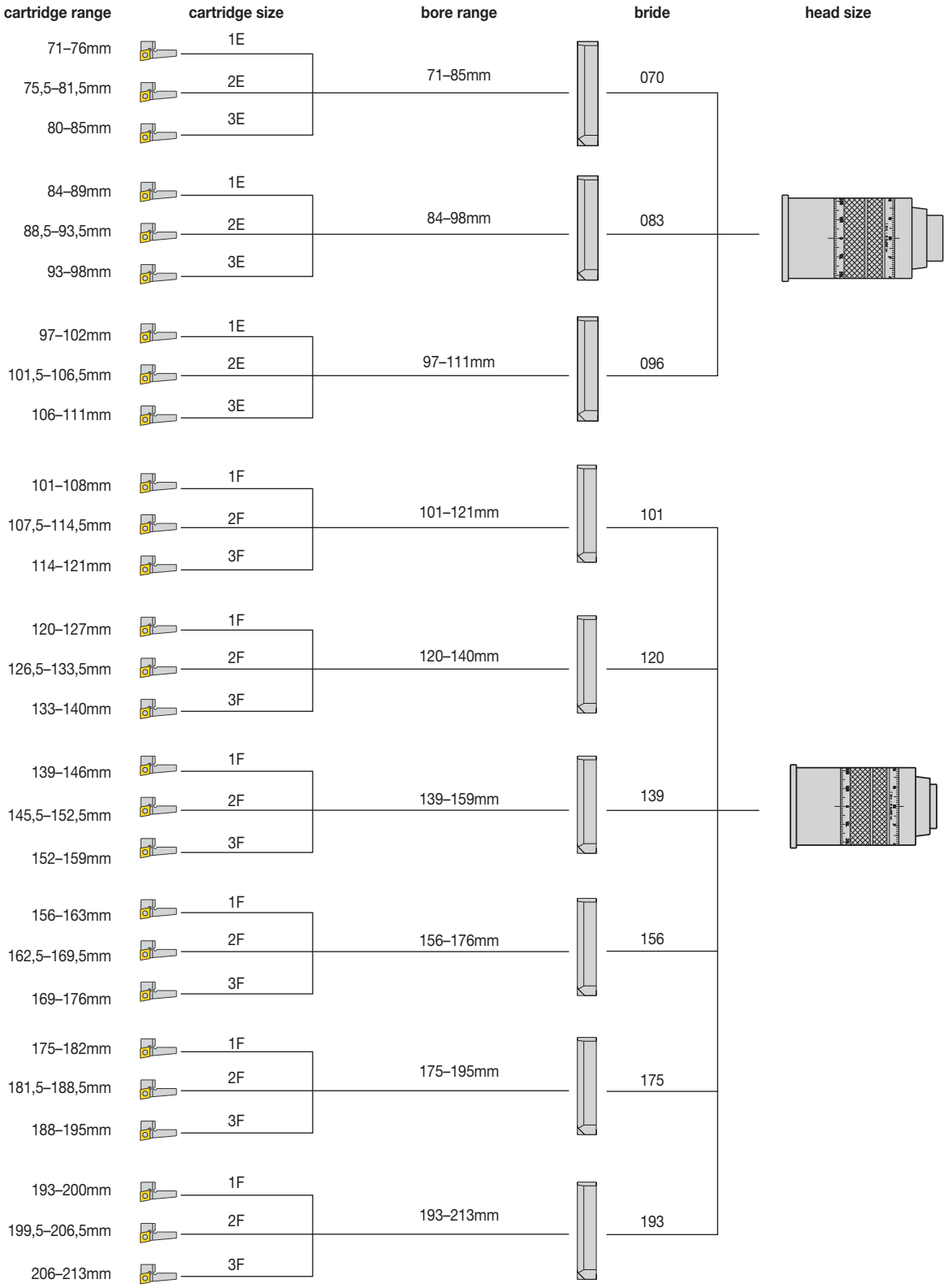




SVS • Cartridges SCF

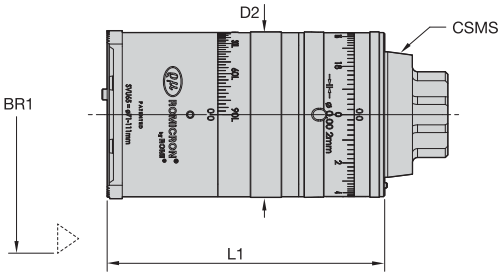
order number	catalogue number	L	F	gage insert	reference head	cartridge size	kg	lbs
1501356	**KRCSCFPR061L**	19,15	4,76	CP..0602../CP..215...	AVS00B	1L.	0,01	.02
1500650	**KRCSCFPR062L**	19,15	5,89	CP..0602../CP..215...	KRMSVS00M50049M,AVS00B	2L.	0,01	.02
1501357	**KRCSCFPR063L**	19,15	7,01	CP..0602../CP..215...	AVS00B	3L.	0,01	.03
1099162	**KRCSCFPR061A**	23,65	6,45	CP..0602../CP..215...	AVS0B,AVS1B,AVS1B	1A.	0,01	.02
1099163	**KRCSCFPR062A**	23,70	8,20	CP..0602../CP..215...	AVS0B,AVS1B,AVS1B	2A.	0,01	.02
1099164	**KRCSCFPR063A**	23,70	9,95	CP..0602../CP..215...	AVS0B,AVS1B,AVS1B	3A.	0,01	.03
1099166	**KRCSCFPR062B**	24,65	8,70	CP..0602../CP..215...	SVS3B,SVS2B	2B.	0,01	.03
1099167	**KRCSCFPR063B**	24,65	10,95	CP..0602../CP..215...	SVS3B,SVS2B	3B.	0,02	.04
1099165	**KRCSCFPR061B**	24,70	6,45	CP..0602../CP..215...	SVS3B,SVS2B	1B.	0,01	.02
1099168	**KRCSCFPR061C**	30,70	8,45	CP..0602../CP..215..	SVS5B,SVS4B	1C.	0,02	.05
1099169	**KRCSCFPR062C**	30,70	11,70	CP..0602../CP..215...	SVS5B,SVS4B	2C.	0,03	.06
1099170	**KRCSCFPR063C**	30,70	14,95	CP..0602../CP..215...	SVS5B,SVS4B	3C.	0,04	.08
1099171	**KRCSCFPR061D**	38,70	8,45	CP..0602../CP..215...	SVS8B,SVS7B,SVS6B	1D.	0,03	.07
1099172	**KRCSCFPR062D**	38,70	12,20	CP..0602../CP..215...	SVS8B,SVS7B,SVS6B	2D.	0,05	.10
1099173	**KRCSCFPR063D**	38,70	15,95	CP..0602../CP..215...	SVS8B,SVS7B,SVS6B	3D.	0,06	.13

SVU System • Tooling Tree



- For correct balance ring settings, see page K104–K105.
- Order diameter extenders, cartridges, and taper shanks separately.





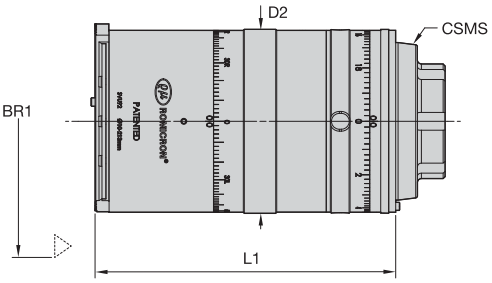


SVU65 • KR Boring Head with CLB Capability

order number	catalogue number	BR1 bore range	CSMS system size	D2	L1	Torx wrench	kg	lbs
1582600	**KR50SVU65110MCLB**	71,000-111,000	KR50	65,0	110,0	**KT27**	2,8	6.20

- For correct balance ring settings, see page K106–K110.
- Order diameter extenders, cartridges, and taper shanks separately.

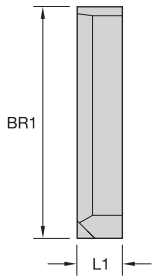






SVU92 • KR Boring Head with CLB Capability

order number	catalogue number	BR1 bore range	CSMS system size	D2	L1	Torx wrench	kg	lbs
4054740	**KR80SVU92152MCLB**	101,000-213,000	KR80	92,0	152,0	**KT27**	7,5	16.54



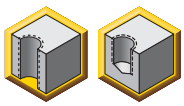


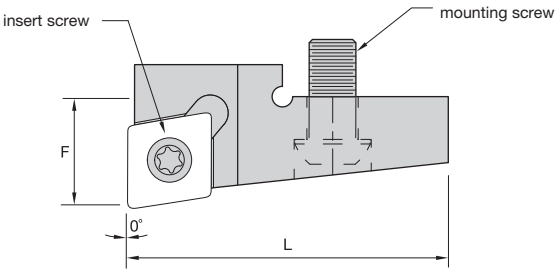


SVU • Diameter Extenders

order number	catalogue number	BR1 bore range	L1 assy	kg	lbs
1279736	**KRDE070019M**	70,000-85,000	19,2	0,2	.48
1279739	**KRDE083019M**	83,000-98,000	19,2	0,3	.62
1279740	**KRDE096019M**	96,000-111,000	19,2	0,3	.76
1279741	**KRDE101023M**	101,000-121,000	23,2	0,6	1.25
1279742	**KRDE120023M**	120,000-140,000	23,2	0,7	1.54
1279743	**KRDE139026M**	139,000-159,000	26,2	1,0	2.15
1279745	**KRDE156026M**	156,000-176,000	26,2	1,1	2.51
1279746	**KRDE175026M**	175,000-195,000	26,2	1,3	2.83
1279748	**KRDE193026M**	193,000-213,000	26,2	1,4	3.14

- Order inserts separately.



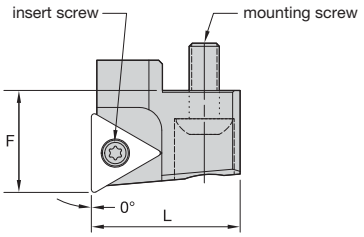




SVU • Cartridges SCF



order number	catalogue number	reference head	F	L	gage insert	insert screw	mounting screw	insert Torx wrench	Torx wrench	cartridge size	kg	lbs
1099174	**KRCSCFPR061E**	SVU65	6,75	19,70	CP..0602../CP..215...	**MS1375**	**MS1153**	**FT7**	**KT15**	1E.	0,01	.02
1099175	**KRCSCFPR062E**	SVU65	9,00	19,70	CP..0602../CP..215...	**MS1375**	**MS1153**	**FT7**	**KT15**	2E.	0,01	.02
1099176	**KRCSCFPR063E**	SVU65	11,25	19,70	CP..0602../CP..215...	**MS1375**	**MS1153**	**FT7**	**KT15**	3E.	0,01	.03
1099177	**KRCSCFPR061F**	SVU92	6,75	19,70	CP..0602../CP..215...	**MS1375**	**MS1153**	**FT7**	**KT15**	1F.	0,01	.02
1099178	**KRCSCFPR062F**	SVU92	10,00	19,70	CP..0602../CP..215...	**MS1375**	**MS1153**	**FT7**	**KT15**	2F.	0,01	.03
1099179	**KRCSCFPR063F**	SVU92	13,25	19,70	CP..0602../CP..215...	**MS1375**	**MS1153**	**FT7**	**KT15**	3F.	0,02	.03



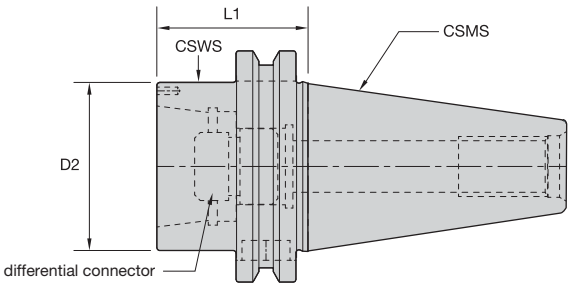


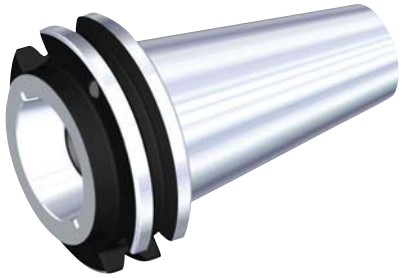
SVU92 • Cartridges STF 90° Lead Angle



order number	catalogue number	reference head	F	L	gage insert	insert screw	mounting screw	insert Torx wrench	Torx wrench	kg	lbs
1279732	**KRCSTFPR113F**	SVU92	13,25	19,70	TP..1102../TP..215...	**MS1375**	**MS1153**	**FT7**	**KT15**	0,02	.03

- Differential connector included.





CV to KR Adaptors AD/B



order number	catalogue number	CSMS system size	CSWS system size	D2	L1	differential connector	kg	lbs	reference head
3554366	**CV40BKR32157**	CV40	KR32	47	40	**KRDCKR32M**	1,08	2.40	AVS00B,0B,1B,2B,3B,SVUBB1,BB2
3554367	**CV40BKR50236**	CV40	KR50	65	60	**KRDCKR50M**	1,23	2.70	SVS4B,5B,SVU65,SVUBB2
3554368	**CV50BKR32157**	CV50	KR32	50	40	**KRDCKR32M**	3,25	7.20	AVS00B,0B,1B,2B,3B,SVUBB1,BB2
3554369	**CV50BKR50157**	CV50	KR50	65	40	**KRDCKR50M**	3,05	6.70	SVS4B,5B,SVU65,SVUBB2
3554370	**CV50BKR63236**	CV50	KR63	85	60	**KRDCKR63M**	3,50	7.70	SVS6B,7B,8B
3554371	**CV50BKR80275**	CV50	KR80	95	70	**KRDCKR80M**	4,28	9.40	SVU92,120

DV to KR DIN 69871 AD/B

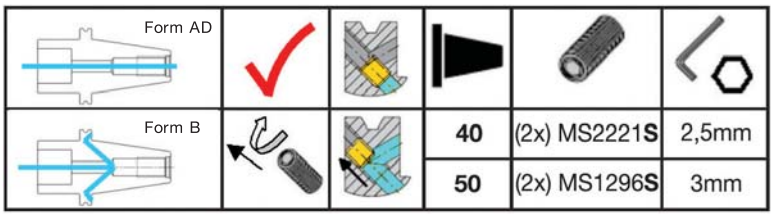


order number	catalogue number	CSMS system size	CSWS system size	D2	L1	differential connector	kg	lbs	reference head
1539005	**DV40BKR32041M**	DV40	KR32	44	41	**KRDCKR32M**	1,00	2.20	AVS00B,0B,1B,2B,3B,SVUBB1,BB2
1263816	**DV40BKR50060M**	DV40	KR50	65	60	**KRDCKR50M**	1,40	3.08	SVS4B,5B,SVU65,SVUBB2
1528328	**DV50BKR32041M**	DV50	KR32	50	41	**KRDCKR32M**	2,80	6.16	AVS00B,0B,1B,2B,3B,SVUBB1,BB2
1191970	**DV50BKR32040M**	DV50	KR32	50	40	**KRDCKR32M**	2,80	6.16	AVS0B, AVS2B, AVS3B
1191971	**DV50BKR50040M**	DV50	KR50	65	40	**KRDCKR50M**	2,80	6.16	SVS4B,5B,SVU65,SVUBB2
1264135	**DV50BKR63060M**	DV50	KR63	85	60	**KRDCKR63M**	3,30	7.26	SVS6B,7B,8B
1264136	**DV50BKR80070M**	DV50	KR80	95	70	**KRDCKR80M**	4,10	9.02	SVU92,120

BT to KR JIS B6339 Adaptors AD/B

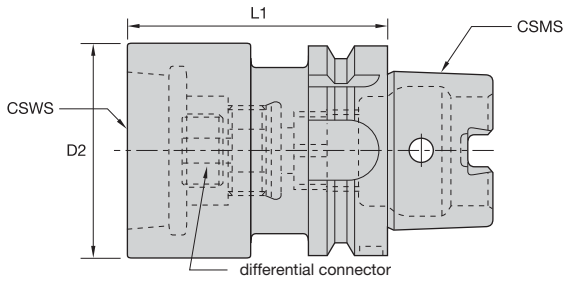


order number	catalogue number	CSMS system size	CSWS system size	D2	L1	differential connector	kg	lbs	reference head
3554372	**BT40BKR32030M**	BT40	KR32	50	30	**KRDCKR32M**	1,20	2.63	AVS00B,0B,1B,2B,3B,SVUBB1,BB2
3554373	**BT40BKR50050M**	BT40	KR50	63	50	**KRDCKR50M**	1,26	2.80	SVS4B,5B,SVU65,SVUBB2
3554374	**BT50BKR32040M**	BT50	KR32	50	40	**KRDCKR32M**	3,90	8.60	AVS00B,0B,1B,2B,3B,SVUBB1,BB2
3554375	**BT50BKR50040M**	BT50	KR50	65	40	**KRDCKR50M**	3,17	7.00	SVS4B,5B,SVU65,SVUBB2
3554376	**BT50BKR63060M**	BT50	KR63	85	60	**KRDCKR63M**	4,31	9.50	SVS6B,7B,8B
3554377	**BT50BKR80060M**	BT50	KR80	95	60	**KRDCKR80M**	4,53	9.98	SVU92,120



- Differential connector included.







ERICKSON

HSK Form A to KR Adaptors



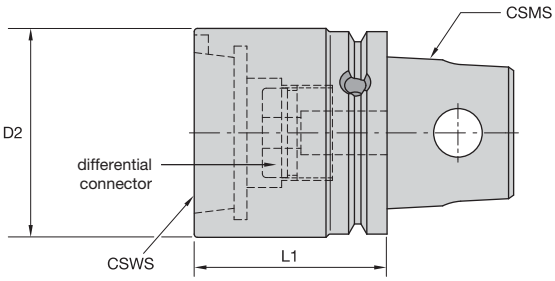
order number	catalogue number	CSMS system size	CSWS system size	D2	L1	differential connector	kg	lbs	reference head
1153403	**HSK63AKR32075M**	HSK63A	KR32	50	75	**KRDCKR32M**	1,20	2.64	AVS00B,0B,1B,2B,3B,SVUBB1,BB2
1153604	**HSK63AKR50080M**	HSK63A	KR50	65	80	**KRDCKR50M**	1,60	3.52	SVS4B,5B,SVU65,SVUBB2
1153606	**HSK100AKR32075M**	HSK100A	KR32	50	75	**KRDCKR32M**	2,56	5.64	AVS00B,0B,1B,2B,3B,SVUBB1,BB2
1107188	**HSK100AKR50085M**	HSK100A	KR50	65	85	**KRDCKR50M**	3,12	6.87	SVS4B,5B,SVU65,SVUBB2
1173988	**HSK100AKR63100M**	HSK100A	KR63	85	100	**KRDCKR63M**	4,26	9.40	SVS6B,7B,8B
1153612	**HSK100AKR80090M**	HSK100A	KR80	95	90	**KRDCKR80M**	4,36	9.62	SVU92,120

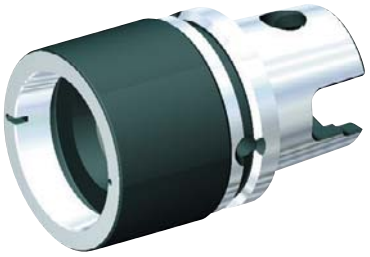
NOTE: Plug may need to be removed to access the differential screw drive through the HSK taper.

- Differential connector included.



KM QUICK CHANGE





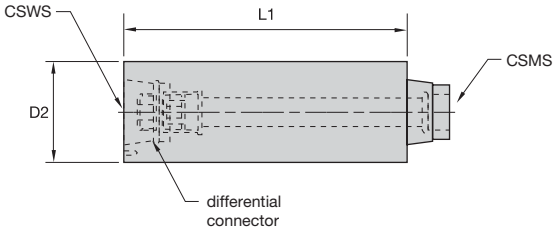
KM63XMZ to KR Adaptors



order number	catalogue number	CSMS system size	CSWS system size	D2	L1	differential connector	kg	lbs	reference head
1831590	**KM63XMZKR5060Y**	KM63XMZ	KR50	65	60	**KRDCKR50M**	1,37	3.02	SVS4B,5B,SVU65,SVUBB2

NOTE: Do not overtighten lock screw; use torque recommendations above.
Supplied with lock screw.
Lock screw wrench not included.

- Differential connector included.

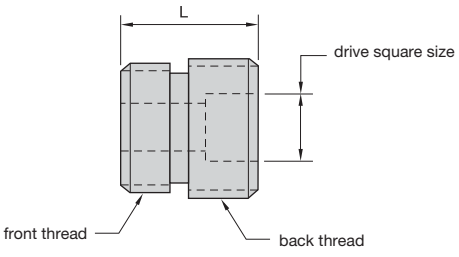




Length Extenders and Spare Differential Connectors



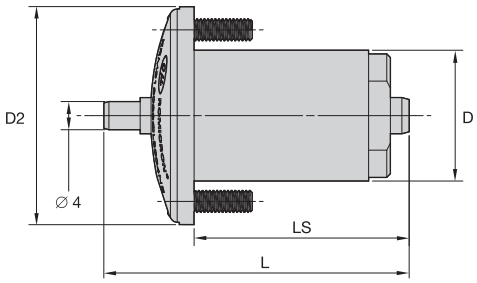
order number	catalogue number	CSWS system size	CSMS system size	D2	L1	differential connector	kg	lbs	reference head
1279772	**KR32KR32038050M**	KR32	KR32	38	50	**KRDCKR32M**	0,45	.99	AVS00B,1B
1192275	**KR32KR32038100M**	KR32	KR32	38	100	**KRDCKR32M**	0,82	1.81	AVS00B,1B
1279775	**KR32KR32047050M**	KR32	KR32	47	50	**KRDCKR32M**	0,69	1.52	AVS0B,2B,3B,SVUBB1
1192276	**KR32KR32047100M**	KR32	KR32	47	100	**KRDCKR32M**	1,28	2.82	AVS0B,2B,3B,SVUBB1
1279785	**KR50KR50065050M**	KR50	KR50	65	50	**KRDCKR50M**	1,16	2.56	SVS4B,5B,SVU65,SVUBB2
1192280	**KR50KR50065100M**	KR50	KR50	65	100	**KRDCKR50M**	2,25	4.96	SVS4B,5B,SVU65,SVUBB2
1279791	**KR63KR63085050M**	KR63	KR63	85	50	**KRDCKR63M**	2,00	4.41	SVS6B,7B,8B
1279792	**KR63KR63085100M**	KR63	KR63	85	100	**KRDCKR63M**	4,02	8.86	SVS6B,7B,8B
1279797	**KR80KR80095050M**	KR80	KR80	95	50	**KRDCKR80M**	2,50	5.51	SVU92,120
1279798	**KR80KR80095100M**	KR80	KR80	95	100	**KRDCKR80M**	5,00	11.02	SVU92,120





Spare Differential Connectors

order number	catalogue number	L	back thread	front thread	drive square size
1192295	**KRDCKR32M**	22	M20 X 2	M18 X 1	3/8 SQ
1192296	**KRDCKR50M**	22	M28 X 2	M26 X 1	3/8 SQ
1279733	**KRDCKR63M**	25	M36 X 2	M32 X 1	1/2 SQ
1279734	**KRDCKR80M**	28	M42 X 2	M38 X 1	1/2 SQ



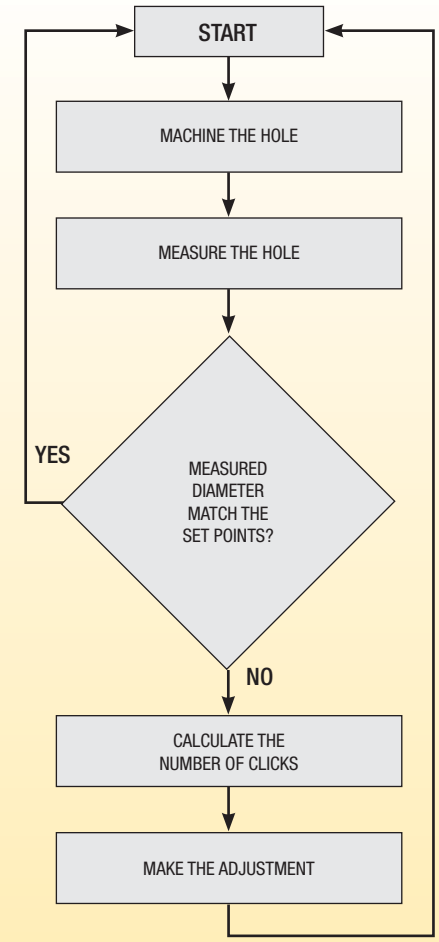


KRM • CLB Pin

order number	catalogue number	D	D2	LS	L	kg	lbs
4052592	**KRM018030CLB004NE**	18,0	30,0	29,6	42,0	0,1	.15

The Romicron Closed Loop Boring Process

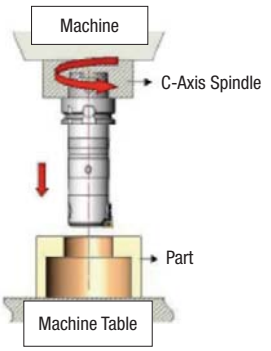
Closed Loop Boring (CLB) provides the unique possibility to automate the insert wear compensation with minimal investment due to the precise 2 µm adjustment in diameter of these tools per increment. Retrofit existing machines to automated wear compensation using the standard CLB pin without any electronic equipment needed besides a measuring device of holes produced.



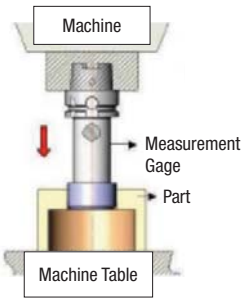
NOTE: This process is only possible with the Romicron system because it does not require tools to make the adjustment.

1. A precision system measures the holes after the machine process. The data is sent to the CNC.
2. The values are compared to the set points.
3. If the diameter is in the range of the specified set points, the machine goes to the next hole. Otherwise, the software calculates the necessary increment and automatically adjusts the Romicron using the CLB pin.

Step 1



Step 2



CNC Machine Command

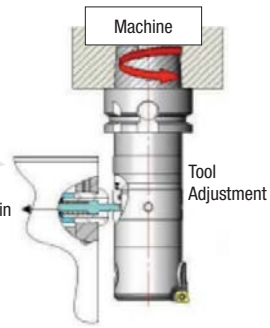


CNC calculates the correction and commands the tool.

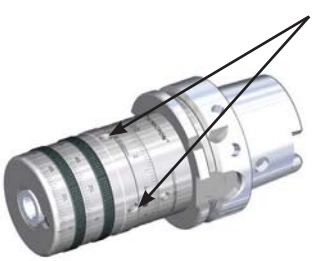
Step 3



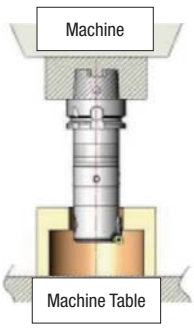
CLB retractable pin to lock the dial ring during diameter adjustment.



Step 4



Four CLB holes positioned at diameter dial ring.



Finishing Hole

Ready for **Takeoff**

Machining carbon-fibre reinforced polymers (CFRP) is a common challenge in the aerospace industry, and these solid carbide drills address the challenge head on. Our SPF drills feature a material-specific design and grade to machine CFRP composite materials by minimising delamination and increasing tool life. These drills feature a combination of point design, substrate, and coating for longer tool life and substantially less cutting force.

The new PCD-tipped PDC251_ drill provides outstanding wear resistance and tool life, and withstands the most abrasive CFRP materials with high-fibre content. Multiple regrinds are possible with these drills, making them extremely economical to use.

SPF DRILL
For composite exits



FULL PCD-TIP DRILL
For composite/metal stacks

Experience the advantages at your Authorised Kennametal Distributor or at **kennametal.com**.

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Romicron™ • Cutting Data

Material Group		Condition	Geometry				Cutting Speed — vc m/min			Feed Rate mm/r			
			-LF	-UF	-FP	-FW	min	Starting Value	max	-LF	-UF	-FP	-FW
P	1		KCP05			–	180	**435**	495	0,06–0,25	0,04–0,16	0,06–0,25	–
			–	–	KTP10	–	180	**435**	495	–	–	0,06–0,25	–
			KT315	–	–	KT315	180	**400**	495	0,06–0,25	–	–	0,08–0,30
			KCP10			–	180	**395**	465	0,06–0,25	0,04–0,16	0,06–0,25	–
			KC9110		–	–	180	**395**	495	0,06–0,25	0,04–0,16	–	–
			KCP25				140	**280**	360	0,06–0,10	0,04–0,08	0,06–0,12	0,08–0,16
			KC9125		–	–	140	**280**	360	0,06–0,10	0,04–0,08	–	–
	2		KCP05			–	180	**265**	400	0,06–0,25	0,04–0,16	0,06–0,25	–
			–	–	KTP10	–	180	**265**	400	–	–	0,06–0,25	–
			KT315	–	–	KT315	190	**270**	390	0,06–0,25	–	–	0,08–0,30
			KCP10			–	180	**240**	330	0,06–0,25	0,04–0,16	0,06–0,25	–
			KC9110		–	–	180	**240**	330	0,06–0,25	0,04–0,16	–	–
			KCP25				145	**195**	320	0,06–0,10	0,04–0,08	0,06–0,12	0,08–0,16
			KC9125		–	–	145	**195**	320	0,06–0,10	0,04–0,08	–	–
	3		KCP05			–	180	**205**	275	0,06–0,25	0,04–0,16	0,06–0,25	–
			–	–	KTP10	–	180	**205**	275	–	–	0,06–0,25	–
			KT315	–	–	KT315	180	**210**	275	0,06–0,25	–	–	0,08–0,30
			KCP10			–	160	**190**	250	0,06–0,25	0,04–0,16	0,06–0,25	–
			KC9110		–	–	155	**190**	240	0,06–0,25	0,04–0,16	–	–
			KCP25				135	**155**	225	0,06–0,10	0,04–0,08	0,06–0,12	0,08–0,16
			KC9125		–	–	135	**155**	225	0,06–0,10	0,04–0,08	–	–
	4		KCP05			–	90	**160**	220	0,06–0,25	0,04–0,16	0,06–0,25	–
			–	–	KTP10	–	90	**160**	220	–	–	0,06–0,25	–
			KT315	–	–	KT315	90	**180**	220	0,06–0,25	–	–	0,08–0,30
			KCP10			–	90	**145**	195	0,06–0,25	0,04–0,16	0,06–0,25	–
			KC9110		–	–	90	**145**	195	0,06–0,25	0,04–0,16	–	–
			KCP25				75	**105**	180	0,06–0,10	0,04–0,08	0,06–0,12	0,08–0,16
			KC9125		–	–	75	**105**	180	0,06–0,10	0,04–0,08	–	–
	5		KCP05			–	150	**240**	315	0,06–0,25	0,04–0,16	0,06–0,25	–
			–	–	KTP10	–	150	**240**	315	–	–	0,06–0,25	–
			KT315	–	–	KT315	150	**250**	315	0,06–0,25	–	–	0,08–0,30
			KCP10			–	150	**215**	300	0,06–0,25	0,04–0,16	0,06–0,25	–
			KC9110		–	–	150	**215**	300	0,06–0,25	0,04–0,16	–	–
			KCP25				120	**195**	255	0,06–0,10	0,04–0,08	0,06–0,12	0,08–0,16
			KC9125		–	–	120	**195**	255	0,06–0,10	0,04–0,08	–	–
	6		KCP05			–	140	**200**	300	0,06–0,25	0,04–0,16	0,06–0,25	–
			–	–	KTP10	–	140	**200**	300	–	–	0,06–0,25	–
			KT315	–	–	KT315	140	**200**	300	0,06–0,25	–	–	0,08–0,30
			KCP10			–	120	**180**	275	0,06–0,25	0,04–0,16	0,06–0,25	–
			KC9110		–	–	120	**180**	225	0,06–0,25	0,04–0,16	–	–
			KCP25				105	**150**	225	0,06–0,10	0,04–0,08	0,06–0,12	0,08–0,16
			KC9125		–	–	105	**150**	225	0,06–0,10	0,04–0,08	–	–

Material Group		Condition	Geometry				Cutting Speed — vc m/min			Feed Rate mm/r			
			-LF	-UF	-FP	-FW	min	Starting Value	max	-LF	-UF	-FP	-FW
M	1		–	–	KTP10	–	140	**230**	315	–	–	0,06–0,25	–
			KT315	–	–	KT315	140	**230**	315	0,06–0,25	–	–	0,08–0,30
			KC5010	–	–	KC5010	130	**215**	245	0,06–0,25	–	–	0,08–0,30
			KCM15	–	KCM15	–	105	**180**	240	0,06–0,12	–	0,06–0,12	–
			KC9225	–	–	KC9225	105	**180**	240	0,06–0,12	–	–	0,08–0,16
	2		–	–	KTP10	–	140	**215**	295	–	–	0,06–0,25	–
			KT315	–	–	KT315	140	**215**	295	0,06–0,25	–	–	0,08–0,30
			KC5010	–	–	KC5010	130	**200**	245	0,06–0,25	–	–	0,08–0,30
			KCM15	–	KCM15	–	105	**165**	250	0,06–0,12	–	0,06–0,12	–
			KC9225	–	–	KC9225	100	**160**	230	0,06–0,12	–	–	0,08–0,16
	3		–	–	KTP10	–	140	**200**	300	–	–	0,06–0,25	–
			KT315	–	–	KT315	140	**200**	300	0,06–0,25	–	–	0,08–0,30
			KC5010	–	–	KC5010	130	**185**	230	0,06–0,25	–	–	0,08–0,30
			KCM15	–	KCM15	–	115	**150**	255	0,06–0,12	–	0,06–0,12	–
			KC9225	–	–	KC9225	110	**150**	230	0,06–0,12	–	–	0,08–0,16

Romicron™ • Cutting Data

Material Group		Condition	Geometry				Cutting Speed — vc m/min			Feed Rate mm/r			
			-LF	-UF	-FP	-FW	min	Starting Value	max	-LF	-UF	-FP	-FW
K	1		KCK20	–	KCK20		200	**300**	540	0,06–0,25	–	0,06–0,25	0,08–0,30
			KT315	–	–	KT315	165	**275**	490	0,06–0,25	–	–	0,08–0,30
			KC9315	–	–	–	110	**275**	450	0,06–0,25	–	–	–
			KC9320	–	–	–	100	**240**	400	0,06–0,12	–	–	–
	2		KCK20	–	KCK20		150	**240**	420	0,06–0,25	–	0,06–0,25	0,08–0,30
			KT315	–	–	KT315	180	**275**	360	0,06–0,25	–	–	0,08–0,30
			KC5010		–	KC5010	100	**200**	265	0,06–0,25	0,04–0,16	–	0,08–0,30
			KC9315	–	–	–	145	**260**	360	0,06–0,25	–	–	–
			KC9320	–	–	–	140	**240**	330	0,06–0,12	–	–	–
	3		KCK20	–	KCK20		140	**210**	350	0,06–0,25	–	0,06–0,25	0,08–0,30
			KT315	–	–	KT315	180	**230**	320	0,06–0,25	–	–	0,08–0,30
			KC5010		–	KC5010	120	**150**	225	0,06–0,25	0,04–0,16	–	0,08–0,30
			KC9315	–	–	–	145	**215**	275	0,06–0,25	–	–	–
			KC9320	–	–	–	140	**210**	260	0,06–0,12	–	–	–

Material Group		Condition	Geometry				Cutting Speed — vc m/min			Feed Rate mm/r			
			-LF	-FWL20	–	–	min	Starting Value	max	-LF	-FWL20	–	–
N	1		KC5410		–	–	200	**550**	1000	0,10–0,40	0,20–0,50	–	–
			KC5410	–	–	–	200	**550**	1000	0,10–0,20	–	–	–
			–	–	KD1400	–	450	**765**	3000	–	–	0,06–0,15	–
	2		–	–	KD1425	–	375	**580**	1150	–	–	0,06–0,25	–
			–	–	KD1400	–	400	**650**	1250	–	–	0,06–0,15	–
	3		KC5410		–	–	125	**275**	525	0,10–0,40	0,20–0,50	–	–
			–	–	KD1425	–	250	**500**	875	–	–	0,06–0,25	–
			KC5410	–	–	–	125	**275**	525	0,10–0,20	–	–	–
			–	–	KD1400	–	375	**520**	1000	–	–	0,06–0,12	–
	5		KC5410	–	–	–	125	**200**	375	0,10–0,40	–	–	–
			KC5410	–	–	–	125	**200**	375	0,10–0,20	–	–	–

Material Group		Condition	Geometry				Cutting Speed — vc m/min			Feed Rate mm/r			
			-LF	-UF	-FP	-FW	min	Starting Value	max	-LF	-UF	-FP	-FW
S	1		–	–	KCU10	–	30	**55**	125	–	–	0,06–0,25	–
			K313	–	–	–	10	**30**	60	0,06–0,25	–	–	–
			KC5010		–	KC5010	30	**55**	120	0,06–0,25	0,04–0,16	–	0,08–0,30
			–	–	KCU10	–	30	**55**	125	–	–	0,06–0,25	–
			KC5010		–	KC5010	30	**55**	120	0,06–0,25	0,04–0,16	–	0,08–0,30
			–	–	KCU25	–	10	**40**	50	–	–	0,06–0,12	–
			KC5025	–	–	–	10	**40**	50	0,06–0,10	–	–	–
	2		–	–	KCU10	–	30	**35**	125	–	–	0,06–0,25	–
			K313	–	–	–	10	**35**	60	0,06–0,25	–	–	–
			KC5010		–	KC5010	30	**60**	120	0,06–0,25	0,04–0,16	–	0,08–0,30
			–	–	KCU10	–	30	**35**	125	–	–	0,06–0,25	–
			KC5010		–	KC5010	30	**60**	120	0,06–0,25	0,04–0,16	–	0,08–0,30
			–	–	KCU25	–	10	**30**	50	–	–	0,06–0,12	–
			KC5025	–	–	–	10	**30**	50	0,06–0,10	–	–	–
	3		–	–	KCU10	–	30	**70**	125	–	–	0,06–0,25	–
			K313	–	–	–	10	**40**	60	0,06–0,25	–	–	–
			KC5010		–	KC5010	30	**70**	120	0,06–0,25	0,04–0,16	–	0,08–0,30
			–	–	KCU10	–	30	**35**	125	–	–	0,06–0,25	–
			KC5010		–	KC5010	30	**70**	120	0,06–0,25	0,04–0,16	–	0,08–0,30
			–	–	KCU25	–	25	**40**	60	–	–	0,06–0,12	–
			KC5025	–	–	–	25	**40**	60	0,06-0,10	–	–	–
	4		–	–	KCU10	–	45	**70**	140	–	–	0,06–0,25	–
			K313	–	–	–	15	**45**	65	0,06–0,25	–	–	–
			KC5010		–	KC5010	45	**70**	140	0,06–0,25	0,04–0,16	–	0,08–0,30
			–	–	KCU10	–	45	**70**	140	–	–	0,06–0,25	–
			KC5010		–	KC5010	45	**70**	140	0,06–0,25	0,04–0,16	–	0,08–0,30
			–	–	KCU25	–	25	**55**	90	–	–	0,06–0,12	–
			KC5025	–	–	–	15	**55**	90	0,06–0,10	–	–	–

Romicron Assembly Instructions

The required parts for the adaptor assembly are identified on Figures 1 and 2. The SVS model is shown. The instructions are also valid to the SVU and SVUBB models.

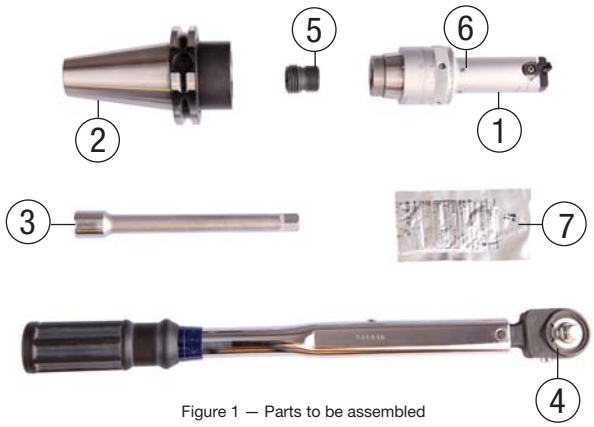


Figure 1 — Parts to be assembled

1	Boring head
2	Taper shank
3	Square extension (3/8" or 1/2")
4	Torque wrench
5	Differential connector
6	Positioning pin
7	Lubricant ASL-3G

WARNING:
Before starting the assembly procedure, ensure that all surfaces to be assembled together are free of dirt and completely clean.



Figure 2 — Assembled Tool

A



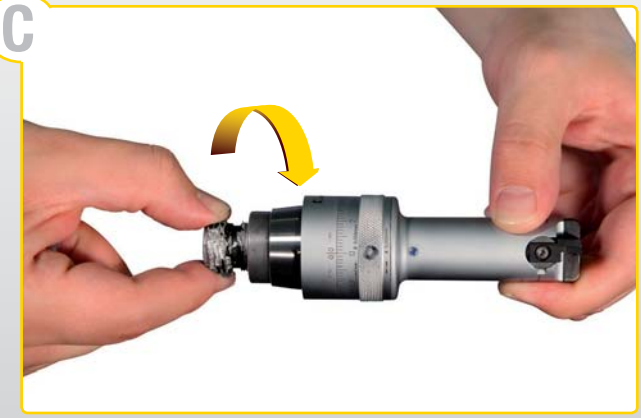
A. Remove the Differential Connector (5) from the Taper Shank (2).

B



B. Lubricate the thread on the Differential Connector (5) with Lubricant ASK-3G (7), supplied with the Taper Shank (2).

C



C. Screw the Differential Connector (5) into the rear thread on the Boring Head (1) until the end of the thread. At this time it is not necessary to tighten the Differential Connector (5). Remember that the Differential Connector (5) has two different screws, so there is no way to assemble the wrong side.

Romicron Assembly Instructions

D



D. Screw the front end of the Taper Shank (2) onto the Differential Connector (5), now located at the back on the Boring Head (1). Screw carefully until the Positioning Pin (6) gently touches the Taper (2) face. Stop!

F



F. Insert the square end of the Extension (3) through the Taper Shank (2) and into the Differential Connector (5). Keeping the Positioning Pin (6) and the positioning slot aligned, turn the Extensions (3) anti-clockwise until you see that two Romicron faces are meshing. Ensure that the Positioning Pin (6) is inserted into the slot on the Taper Shank (2).

E



E. Unscrew the Taper Shank (2) a little bit until the Positioning Pin (6) is aligned with the positioning slot mark in the Taper Shank (2) face.

G



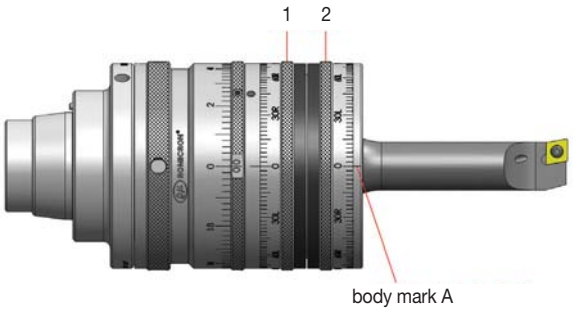
G. Tighten the Differential Connector (5) with the specified required torque, as shown on the table below. Use the Torque Wrench (4) to do this.

Tightening Torque Specifications

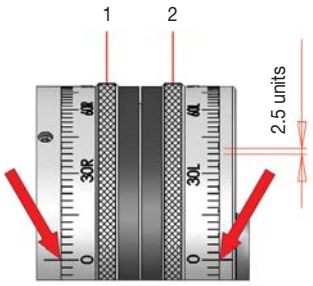
joint size	Torque Nm	drive square
KR32	30	3/8"
KR50	40	3/8"
KR63	55	1/2"
KR80	65	1/2"

Following these procedures will result in a rigid surface contact between the taper and the boring head face.

1. There are 2 balancing dials on the SVUBB system. Align ring 2 “zero” with the body mark A. Align “zero” mark of ring 1 with the “zero” mark of ring 2.



2. Look up your diameter in the table below and read the setting values for ring 1 and ring 2.



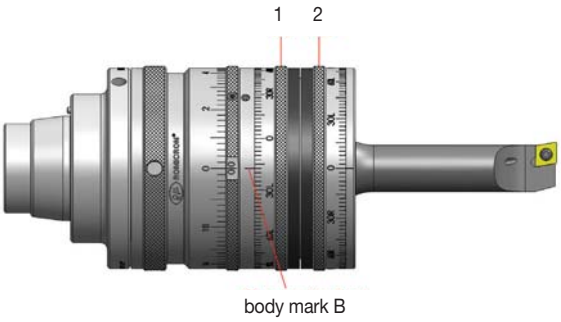
Balancing Table • SVU-BB1 Boring Head

KRBB10FABDRS204C 4–6,4mm					KRBB10SCLDR4060C 6–9mm					KRBB10SCFPR06085C 8,5–11,5mm				
diameter	ring 1		ring 2		diameter	ring 1		ring 2		diameter	ring 1		ring 2	
mm					mm					mm				
4	40	L	58	L	6	34	L	66	L	8,5	34	L	66	L
4,1	42	L	58	L	6,1	36	L	66	L	8,6	36	L	68	L
4,2	42	L	54	L	6,2	36	L	64	L	8,7	36	L	64	L
4,3	44	L	54	L	6,3	38	L	62	L	8,8	38	L	62	L
4,4	44	L	50	L	6,4	38	L	62	L	8,9	36	L	60	L
4,5	46	L	50	L	6,5	40	L	60	L	9	40	L	60	L
4,6	46	L	48	L	6,6	40	L	58	L	9,1	40	L	58	L
4,7	46	L	46	L	6,7	40	L	56	L	9,2	42	L	56	L
4,8	46	L	42	L	6,8	40	L	54	L	9,3	40	L	54	L
4,9	46	L	40	L	6,9	42	L	52	L	9,4	42	L	52	L
5	22	R	20	R	7	42	L	54	L	9,5	42	L	50	L
5,1	32	R	26	R	7,1	54	R	60	R	9,6	40	L	46	L
5,2	40	R	32	R	7,2	54	R	60	R	9,7	38	L	42	L
5,3	44	R	34	R	7,3	60	R	60	R	9,8	30	L	32	L
5,4	48	R	36	R	7,4	70	R	72	R	9,9	24	R	22	R
5,5	50	R	36	R	7,5	42	R	40	R	10	24	R	22	R
5,6	52	R	34	R	7,6	48	R	44	R	10,1	26	R	22	R
5,7	54	R	34	R	7,7	50	R	42	R	10,2	44	R	38	R
5,8	56	R	32	R	7,8	50	R	42	R	10,3	48	R	38	R
5,9	58	R	32	R	7,9	52	R	40	R	10,4	52	R	38	R
6	60	R	30	R	8	54	R	40	R	10,5	52	R	38	R
6,1	62	R	30	R	8,1	54	R	38	R	10,6	56	R	36	R
6,2	64	R	28	R	8,2	56	R	38	R	10,7	56	R	36	R
6,3	66	R	28	R	8,3	58	R	36	R	10,8	58	R	34	R
6,4	68	R	24	R	8,4	58	R	34	R	10,9	58	R	32	R
–	–	–	–	–	8,5	60	R	36	R	11	62	R	32	R
–	–	–	–	–	8,6	62	R	34	R	11,1	60	R	30	R
–	–	–	–	–	8,7	62	R	32	R	11,2	62	R	28	R
–	–	–	–	–	8,8	62	R	32	R	11,3	62	R	28	R
–	–	–	–	–	8,9	66	R	28	R	11,4	68	R	26	R
–	–	–	–	–	9	66	R	28	R	11,5	68	R	26	R

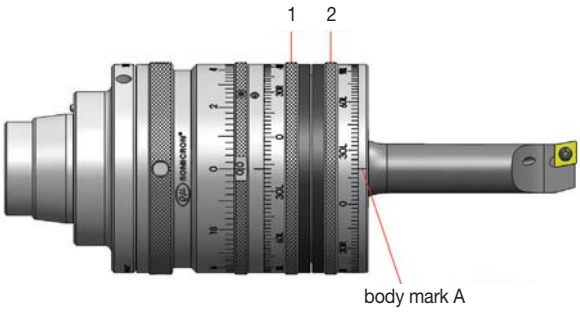
(continued)

(Balancing Table • SVU-BB1 Boring Head — continued)

3. Set ring 1 first, referencing to body mark B (one dial mark equals 2.5 units).

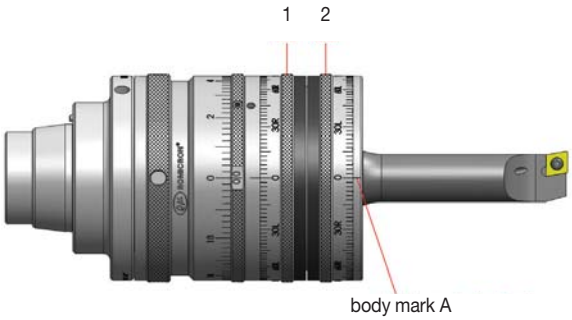


4. Set ring 2, referencing to body mark A (one dial mark equals 2.5 units).

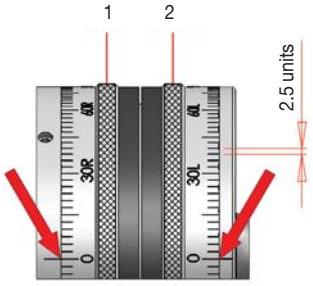


KRBB10SCFPR06110C 11–14mm					KRBB10SCFPR06135C 13,5–16,5mm				
diameter	ring 1		ring 2		diameter	ring 1		ring 2	
mm					mm				
11	32	L	66	L	13,5	34	L	62	L
11,1	34	L	64	L	13,6	36	L	60	L
11,2	34	L	62	L	13,7	38	L	58	L
11,3	36	L	60	L	13,8	38	L	56	L
11,4	36	L	58	L	13,9	40	L	56	L
11,5	38	L	58	L	14	42	L	44	L
11,6	38	L	56	L	14,1	42	L	52	L
11,7	40	L	54	L	14,2	44	L	50	L
11,8	40	L	52	L	14,3	42	L	46	L
11,9	40	L	52	L	14,4	34	L	36	L
12	38	L	46	L	14,5	18	L	20	L
12,1	34	L	42	L	14,6	10	R	6	R
12,2	26	L	30	L	14,7	18	R	10	R
12,3	24	R	22	R	14,8	40	R	30	R
12,4	28	L	26	L	14,9	44	R	32	R
12,5	44	L	38	R	15	48	R	34	R
12,6	44	R	36	R	15,1	48	R	32	R
12,7	50	R	40	R	15,2	50	R	30	R
12,8	50	R	38	R	15,3	52	R	30	R
12,9	52	R	36	R	15,4	56	R	32	R
13	52	R	36	R	15,5	54	R	28	R
13,1	54	R	34	R	15,6	58	R	28	R
13,2	54	R	32	R	15,7	60	R	26	R
13,3	56	R	32	R	15,8	64	R	26	R
13,4	56	R	30	R	15,9	64	R	26	R
13,5	60	R	28	R	16	66	R	24	R
13,6	60	R	28	R	16,1	66	R	22	R
13,7	62	R	26	R	16,2	70	R	20	R
13,8	64	R	26	R	16,3	74	R	18	R
13,9	68	R	24	R	16,4	76	R	16	R
14	68	R	24	R	16,5	78	R	14	R

1. There are 2 balancing dials on the SVUBB system. Align ring 2 “zero” with the body mark A. Align “zero” mark of ring 1 with the “zero” mark of ring 2.



2. Look up your diameter in the table below and read the setting values for ring 1 and ring 2.



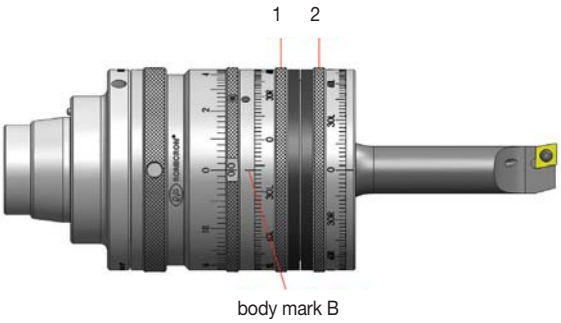
Balancing Table • SVU-BB2 Boring Head

KRBB16SCLDRS406A 6–9,5mm					KRBB16SCFPR06085A 8,5–12mm					KRBB16SCFPR0611A 11–14,5mm					KRBB16SCFPR06135A 13,5–17mm				
diameter	ring 1		ring 2		diameter	ring 1		ring 2		diameter	ring 1		ring 2		diameter	ring 1		ring 2	
mm					mm					mm					mm				
6	67.5	L	67.5	L	8,5	67.5	L	67.5	L	11	67.5	L	70	L	13,5	65	L	70	L
6,1	62.5	L	62.5	L	8,6	62.5	L	62.5	L	11,1	60	L	62.5	L	13,6	60	L	65	L
6,2	57.5	L	57.5	L	8,7	57.5	L	57.5	L	11,2	57.5	L	60	L	13,7	55	L	60	L
6,3	55	L	55	L	8,8	52.5	L	55	L	11,3	52.5	L	55	L	13,8	50	L	55	L
6,4	50	L	50	L	8,9	50	L	50	L	11,4	47.5	L	50	L	13,9	47.5	L	52.5	L
6,5	47.5	L	47.5	L	9	47.5	L	47.5	L	11,5	45	L	47.5	L	14	42.5	L	47.5	L
6,6	45	L	45	L	9,1	42.5	L	45	L	11,6	42.5	L	45	L	14,1	40	L	45	L
6,7	40	L	40	L	9,2	40	L	40	L	11,7	37.5	L	42.5	L	14,2	35	L	42.5	L
6,8	37.5	L	37.5	L	9,3	37.5	L	37.5	L	11,8	35	L	37.5	L	14,3	32.5	L	40	L
6,9	35	L	35	L	9,4	35	L	35	L	11,9	32.5	L	35	L	14,4	30	L	37.5	L
7	32.5	L	32.5	L	9,5	30	L	32.5	L	12	30	L	32.5	L	14,5	25	L	35	L
7,1	30	L	30	L	9,6	27.5	L	30	L	12,1	27.5	L	30	L	14,6	22.5	L	32.5	L
7,2	27.5	L	27.5	L	9,7	25	L	27.5	L	12,2	25	L	27.5	L	14,7	20	L	30	L
7,3	25	L	25	L	9,8	22.5	L	25	L	12,3	22.5	L	25	L	14,8	17.5	L	27.5	L
7,4	22.5	L	22.5	L	9,9	20	L	22.5	L	12,4	17.5	L	25	L	14,9	15	L	25	L
7,5	20	L	20	L	10	17.5	L	20	L	12,5	15	L	22.5	L	15	10	L	25	L
7,6	17.5	L	17.5	L	10,1	15	L	17.5	L	12,6	12.5	L	20	L	15,1	7.5	L	22.5	L
7,7	15	L	15	L	10,2	12.5	L	15	L	12,7	10	L	17.5	L	15,2	2.5	L	22.5	L
7,8	12.5	L	12.5	L	10,3	10	L	15	L	12,8	5	L	17.5	L	15,3	2.5	R	22.5	L
7,9	10	L	12.5	L	10,4	7.5	L	12.5	L	12,9	2.5	L	15	L	15,4	7.5	R	22.5	L
8	7.5	L	10	L	10,5	5	L	10	L	13	2.5	R	15	L	15,5	17.5	R	27.5	L
8,1	5	L	7.5	L	10,6	0	L	10	L	13,1	10	R	17.5	L	15,6	37.5	R	42.5	L
8,2	2.5	L	5	L	10,7	5	R	10	L	13,2	25	R	30	L	15,7	85	L	90	R
8,3	2.5	R	5	L	10,8	45	R	45	L	13,3	62.5	L	65	R	15,8	35	L	42.5	R
8,4	10	L	12.5	R	10,9	10	L	15	R	13,4	17.5	L	22.5	R	15,9	17.5	L	27.5	R
8,5	0	R	5	R	11	2.5	L	10	R	13,5	5	L	15	R	16	7.5	L	22.5	R
8,6	2.5	R	7.5	R	11,1	2.5	R	10	R	13,6	0	R	15	R	16,1	2.5	L	22.5	R
8,7	7.5	R	7.5	R	11,2	5	R	12.5	R	13,7	5	R	15	R	16,2	2.5	R	22.5	R
8,8	10	R	10	R	11,3	10	R	12.5	R	13,8	7.5	R	17.5	R	16,3	7.5	R	22.5	R
8,9	12.5	R	12.5	R	11,4	12.5	R	15	R	13,9	10	R	20	R	16,4	10	R	25	R
9	12.5	R	15	R	11,5	15	R	17.5	R	14	15	R	20	R	16,5	15	R	25	R
9,1	15	R	17.5	R	11,6	17.5	R	20	R	14,1	17.5	R	22.5	R	16,6	17.5	R	27.5	R
9,2	17.5	R	20	R	11,7	20	R	22.5	R	14,2	20	R	25	R	16,7	20	R	30	R
9,3	20	R	22.5	R	11,8	22.5	R	25	R	14,3	22.5	R	27.5	R	16,8	22.5	R	32.5	R
9,4	22.5	R	25	R	11,9	25	R	27.5	R	14,4	25	R	30	R	16,9	27.5	R	35	R
9,5	25	R	27.5	R	12	27.5	R	30	R	14,5	27.5	R	32.5	R	17	30	R	37.5	R

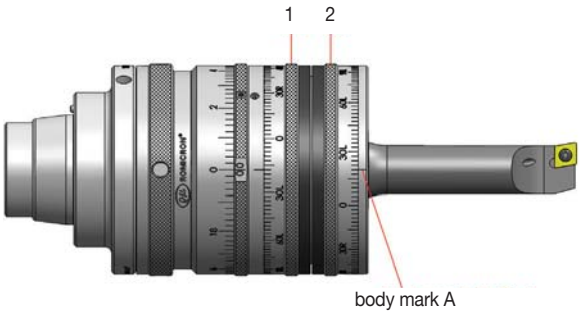
(continued)

(Balancing Table • SVU-BB2 Boring Head — continued)

3. Set ring 1 first, referencing to body mark B (one dial mark equals 2.5 units).



4. Set ring 2, referencing to body mark A (one dial mark equals 2.5 units).



KRBB16SCFPR0616A 16–19,5mm					KRBB16SCFPR0619A 19–22,5mm					KRBB16SCFPR0622A 22–25,5mm				
diameter					diameter					diameter				
mm	ring 1		ring 2		mm	ring 1		ring 2		mm	ring 1		ring 2	
16	65	L	72.5	L	19	60	L	75	L	22	57.5	L	80	L
16,1	57.5	L	65	L	19,1	55	L	70	L	22,1	50	L	72.5	L
16,2	52.5	L	62.5	L	19,2	50	L	65	L	22,2	45	L	70	L
16,3	47.5	L	57.5	L	19,3	45	L	60	L	22,3	37.5	L	65	L
16,4	42.5	L	52.5	L	19,4	40	L	57.5	L	22,4	32.5	L	62.5	L
16,5	40	L	50	L	19,5	35	L	52.5	L	22,5	27.5	L	60	L
16,6	35	L	47.5	L	19,6	30	L	50	L	22,6	22.5	L	57.5	L
16,7	32.5	L	45	L	19,7	27.5	L	47.5	L	22,7	20	L	55	L
16,8	27.5	L	42.5	L	19,8	22.5	L	45	L	22,8	15	L	52.5	L
16,9	25	L	40	L	19,9	20	L	42.5	L	22,9	10	L	52.5	L
17	20	L	37.5	L	20	15	L	42.5	L	23	5	L	50	L
17,1	17.5	L	35	L	20,1	10	L	40	L	23,1	0	R	50	L
17,2	12.5	L	32.5	L	20,2	5	L	40	L	23,2	7.5	R	52.5	L
17,3	10	L	30	L	20,3	0	L	40	L	23,3	12.5	R	52.5	L
17,4	5	L	30	L	20,4	5	R	40	L	23,4	20	R	55	L
17,5	0	L	30	L	20,5	10	R	40	L	23,5	30	R	60	L
17,6	5	R	30	L	20,6	17.5	R	42.5	L	23,6	40	R	65	L
17,7	12.5	R	32.5	L	20,7	27.5	R	47.5	L	23,7	52.5	R	75	L
17,8	22.5	R	37.5	L	20,8	40	R	57.5	L	23,8	67.5	R	90	L
17,9	35	R	47.5	L	20,9	57.5	R	72.5	L	23,9	77.5	L	97.5	R
18	60	R	67.5	L	21	80	R	92.5	L	24	60	L	82.5	R
18,1	75	L	82.5	R	21,1	65	L	77.5	R	24,1	47.5	L	72.5	R
18,2	45	L	55	R	21,2	45	L	60	R	24,2	35	L	62.5	R
18,3	25	L	40	R	21,3	30	L	50	R	24,3	25	L	57.5	R
18,4	15	L	32.5	R	21,4	20	L	45	R	24,4	17.5	L	55	R
18,5	7.5	L	30	R	21,5	12.5	L	40	R	24,5	10	L	52.5	R
18,6	2.5	L	30	R	21,6	5	L	40	R	24,6	5	L	50	R
18,7	2.5	R	30	R	21,7	0	L	40	R	24,7	2.5	R	50	R
18,8	7.5	R	30	R	21,8	5	R	40	R	24,8	7.5	R	50	R
18,9	12.5	R	32.5	R	21,9	10	R	40	R	24,9	12.5	R	52.5	R
19	15	R	35	R	22	12.5	R	42.5	R	25	17.5	R	52.5	R
19,1	20	R	35	R	22,1	17.5	R	42.5	R	25,1	20	R	55	R
19,2	22.5	R	37.5	R	22,2	22.5	R	45	R	25,2	25	R	57.5	R
19,3	27.5	R	40	R	22,3	25	R	47.5	R	25,3	30	R	60	R
19,4	30	R	42.5	R	22,4	30	R	50	R	25,4	35	R	62.5	R
19,5	35	R	45	R	22.5	35	R	52.5	R	25,5	40	R	67.5	R

(continued)

(Balancing Table • SVU-BB2 Boring Head — continued)

KRDEA046AM • KRDE025010M 25,5–33,5mm

diameter					diameter					diameter				
mm	ring 1		ring 2		mm	ring 1		ring 2		mm	ring 1		ring 2	
25,5	62.5	L	65	L	28,5	57.5	L	60	L	31,5	52.5	L	55	L
25,6	57.5	L	60	L	28,6	52.5	L	55	L	31,6	47.5	L	50	L
25,7	50	L	52.5	L	28,7	45	L	50	L	31,7	42.5	L	45	L
25,8	45	L	47.5	L	28,8	40	L	45	L	31,8	37.5	L	42.5	L
25,9	40	L	45	L	28,9	37.5	L	40	L	31,9	32.5	L	37.5	L
26,0	35	L	40	L	29,0	32.5	L	37.5	L	32,0	27.5	L	35	L
26,1	32.5	L	35	L	29,1	27.5	L	32.5	L	32,1	25	L	30	L
26,2	27.5	L	32.5	L	29,2	25	L	30	L	32,2	20	L	27.5	L
26,3	22.5	L	30	L	29,3	20	L	27.5	L	32,3	17.5	L	22.5	L
26,4	20	L	25	L	29,4	15	L	25	L	32,4	12.5	L	22.5	L
26,5	62.5	L	65	L	29,5	55	L	57.5	L	32,5	50	L	55	L
26,6	55	L	57.5	L	29,6	50	L	52.5	L	32,6	45	L	50	L
26,7	50	L	52.5	L	29,7	45	L	47.5	L	32,7	40	L	45	L
26,8	45	L	47.5	L	29,8	40	L	45	L	32,8	37.5	L	40	L
26,9	40	L	42.5	L	29,9	35	L	40	L	32,9	32.5	L	37.5	L
27,0	35	L	40	L	30,0	32.5	L	35	L	33,0	27.5	L	32.5	L
27,1	30	L	35	L	30,1	27.5	L	32.5	L	33,1	22.5	L	30	L
27,2	25	L	32.5	L	30,2	22.5	L	30	L	33,2	20	L	25	L
27,3	22.5	L	27.5	L	30,3	20	L	25	L	33,3	15	L	22.5	L
27,4	17.5	L	25	L	30,4	15	L	22.5	L	33,4	12.5	L	20	L
27,5	60	L	62.5	L	30,5	55	L	57.5	L	33,5	50	L	52.5	L
27,6	52.5	L	55	L	30,6	47.5	L	52.5	L	33,6	45	L	47.5	L
27,7	47.5	L	50	L	30,7	42.5	L	47.5	L	33,7	40	L	42.5	L
27,8	42.5	L	45	L	30,8	37.5	L	42.5	L	33,8	35	L	40	L
27,9	37.5	L	42.5	L	30,9	35	L	37.5	L	33,9	30	L	35	L
28,0	32.5	L	37.5	L	31,0	30	L	35	L	34,0	27.5	L	32.5	L
28,1	30	L	35	L	31,1	25	L	32.5	L	34,1	22.5	L	27.5	L
28,2	25	L	30	L	31,2	22.5	L	27.5	L	34,2	20	L	25	L
28,3	20	L	27.5	L	31,3	17.5	L	25	L	34,3	15	L	22.5	L
28,4	17.5	L	25	L	31,4	12.5	L	22.5	L	34,4	10	L	20	L

KRDEA046AM • KRDE033010M 33,5–44,4mm

diameter					diameter					diameter					diameter				
mm	ring 1		ring 2		mm	ring 1		ring 2		mm	ring 1		ring 2		mm	ring 1		ring 2	
33,5	55	L	57.5	L	36,5	47.5	L	52.5	L	39,5	42.5	L	47.5	L	42,5	37.5	L	40	L
33,6	50	L	52.5	L	36,6	42.5	L	47.5	L	39,6	37.5	L	42.5	L	42,6	32.5	L	37.5	L
33,7	45	L	47.5	L	36,7	37.5	L	42.5	L	39,7	32.5	L	37.5	L	42,7	27.5	L	35	L
33,8	40	L	42.5	L	36,8	35	L	37.5	L	39,8	27.5	L	35	L	42,8	25	L	30	L
33,9	35	L	40	L	36,9	30	L	35	L	39,9	25	L	30	L	42,9	20	L	27.5	L
34,0	30	L	35	L	37,0	25	L	32.5	L	40,0	20	L	27.5	L	43,0	15	L	25	L
34,1	25	L	32.5	L	37,1	22.5	L	27.5	L	40,1	15	L	25	L	43,1	10	L	22.5	L
34,2	22.5	L	27.5	L	37,2	17.5	L	25	L	40,2	10	L	22.5	L	43,2	5	L	20	L
34,3	17.5	L	25	L	37,3	12.5	L	22.5	L	40,3	7.5	L	20	L	43,3	0	L	17.5	L
34,4	12.5	L	22.5	L	37,4	7.5	L	20	L	40,4	2.5	L	17.5	L	43,4	7.5	R	20	L
34,5	52.5	L	57.5	L	37,5	47.5	L	50	L	40,5	40	L	45	L	43,5	35	L	40	L
34,6	47.5	L	50	L	37,6	42.5	L	45	L	40,6	35	L	40	L	43,6	30	L	35	L
34,7	42.5	L	47.5	L	37,7	37.5	L	40	L	40,7	30	L	37.5	L	43,7	25	L	32.5	L
34,8	37.5	L	42.5	L	37,8	32.5	L	37.5	L	40,8	27.5	L	32.5	L	43,8	22.5	L	27.5	L
34,9	32.5	L	37.5	L	37,9	27.5	L	35	L	40,9	22.5	L	30	L	43,9	17.5	L	25	L
35,0	27.5	L	35	L	38,0	25	L	30	L	41,0	17.5	L	27.5	L	44,0	15	L	22.5	L
35,1	25	L	30	L	38,1	20	L	27.5	L	41,1	15	L	22.5	L	44,1	10	L	20	L
35,2	20	L	27.5	L	38,2	15	L	25	L	41,2	10	L	20	L	44,2	5	L	17.5	L
35,3	15	L	25	L	38,3	10	L	22.5	L	41,3	5	L	20	L	44,3	2.5	R	17.5	L
35,4	10	L	22.5	L	38,4	5	L	20	L	41,4	0	R	17.5	L	44,4	12.5	R	22.5	L
35,5	50	L	55	L	38,5	45	L	47.5	L	41,5	37.5	L	42.5	L	–	–	–	–	–
35,6	45	L	50	L	38,6	40	L	42.5	L	41,6	35	L	37.5	L	–	–	–	–	–
35,7	40	L	45	L	38,7	35	L	40	L	41,7	30	L	35	L	–	–	–	–	–
35,8	35	L	40	L	38,8	30	L	35	L	41,8	25	L	32.5	L	–	–	–	–	–
35,9	30	L	37.5	L	38,9	25	L	32.5	L	41,9	22.5	L	27.5	L	–	–	–	–	–
36,0	27.5	L	32.5	L	39,0	22.5	L	27.5	L	42,0	17.5	L	25	L	–	–	–	–	–
36,1	22.5	L	30	L	39,1	17.5	L	25	L	42,1	12.5	L	22.5	L	–	–	–	–	–
36,2	17.5	L	27.5	L	39,2	15	L	22.5	L	42,2	7.5	L	20	L	–	–	–	–	–
36,3	15	L	22.5	L	39,3	10	L	20	L	42,3	2.5	L	17.5	L	–	–	–	–	–
36,4	10	L	20	L	39,4	5	L	17.5	L	42,4	5	R	20	L	–	–	–	–	–

(continued)

(Balancing Table • SVU-BB2 Boring Head — continued)

KRDEA051AM • KRDE043010M 43–65,9mm

diameter					diameter					diameter					diameter				
mm	ring 1		ring 2		mm	ring 1		ring 2		mm	ring 1		ring 2		mm	ring 1		ring 2	
43,0	55	L	65	L	46,0	42.5	L	55	L	49,0	32.5	L	47.5	L	52,0	25	L	40	L
43,1	47.5	L	57.5	L	46,1	37.5	L	50	L	49,1	27.5	L	42.5	L	52,1	20	L	37.5	L
43,2	40	L	52.5	L	46,2	30	L	45	L	49,2	22.5	L	40	L	52,2	12.5	L	35	L
43,3	35	L	47.5	L	46,3	25	L	42.5	L	49,3	17.5	L	35	L	52,3	7.5	L	32.5	L
43,4	30	L	42.5	L	46,4	20	L	37.5	L	49,4	12.5	L	32.5	L	52,4	0	L	32.5	L
43,5	22.5	L	40	L	46,5	15	L	35	L	49,5	5	L	32.5	L	52,5	7.5	R	32.5	L
43,6	17.5	L	37.5	L	46,6	7.5	L	32.5	L	49,6	2.5	R	32.5	L	52,6	20	R	37.5	L
43,7	12.5	L	32.5	L	46,7	2.5	L	30	L	49,7	12.5	R	35	L	52,7	42.5	R	52.5	L
43,8	5	L	32.5	L	46,8	7.5	R	32.5	L	49,8	27.5	R	42.5	L	52,8	85	L	92.5	R
43,9	2.5	R	32.5	L	46,9	17.5	R	35	L	49,9	60	R	70	L	52,9	40	L	52.5	R
44,0	50	L	60	L	47,0	40	L	52.5	L	50,0	30	L	45	L	53,0	22.5	L	37.5	L
44,1	42.5	L	55	L	47,1	35	L	47.5	L	50,1	25	L	40	L	53,1	17.5	L	35	L
44,2	37.5	L	50	L	47,2	27.5	L	42.5	L	50,2	20	L	37.5	L	53,2	10	L	32.5	L
44,3	32.5	L	45	L	47.3	22.5	L	40	L	50,3	12.5	L	35	L	53,3	2.5	L	32.5	L
44,4	25	L	42.5	L	47,4	17.5	L	35	L	50,4	7.5	L	32.5	L	53,4	5	R	32.5	L
44,5	20	L	37.5	L	47,5	12.5	L	32.5	L	50,5	0	L	32.5	L	53,5	15	R	35	L
44,6	15	L	35	L	47,6	5	L	32.5	L	50,6	7.5	R	32.5	L	53,6	30	R	45	L
44,7	10	L	32.5	L	47,7	2.5	R	32.5	L	50,7	20	R	37.5	L	53,7	62.5	R	72.5	L
44,8	2.5	L	30	L	47,8	12.5	R	35	L	50,8	40	R	52.5	L	53,8	57.5	L	67.5	R
44,9	7.5	R	32.5	L	47,9	27.5	R	42.5	L	50,9	87.5	R	95	L	53,9	27.5	L	42.5	R
45,0	47.5	L	57.5	L	48,0	37.5	L	50	L	51,0	27.5	L	42.5	L	54,0	20	L	37.5	L
45,1	40	L	52.5	L	48,1	30	L	45	L	51,1	22.5	L	40	L	54,1	12.5	L	35	L
45,2	35	L	47.5	L	48,2	25	L	40	L	51,2	17.5	L	35	L	54,2	7.5	L	32.5	L
45,3	30	L	42.5	L	48,3	20	L	37.5	L	51,3	10	L	35	L	54,3	0	L	32.5	L
45,4	22.5	L	40	L	48,4	15	L	35	L	51,4	5	L	32.5	L	54,4	7.5	R	32.5	L
45,5	17.5	L	35	L	48,5	7.5	L	32.5	L	51,5	2.5	R	30	L	54,5	20	R	37.5	L
45,6	12.5	L	32.5	L	48,6	0	L	32.5	L	51,6	12.5	R	32.5	L	54,6	45	R	55	L
45,7	5	L	32.5	L	48,7	7.5	R	32.5	L	51,7	30	R	45	L	54,7	82.5	L	90	R
45,8	2.5	R	32.5	L	48,8	20	R	37.5	L	51,8	60	R	70	L	54,8	40	L	52.5	R
45,9	12.5	R	35	L	48,9	40	R	52.5	L	51,9	60	L	70	R	54,9	20	L	37.5	R
55,0	17.5	L	35	L	58,0	7.5	L	32.5	L	61,0	5	R	32.5	L	64,0	25	R	40	L
55,1	10	L	32.5	L	58,1	0	R	30	L	61,1	15	R	35	L	64,1	55	R	65	L
55,2	2.5	L	32.5	L	58,2	10	R	32.5	L	61,2	35	R	47.5	L	64,2	67.5	L	77.5	R
55,3	5	R	32.5	L	58,3	22.5	R	40	L	61,3	75	R	82.5	L	64,3	32.5	L	45	R
55,4	15	R	35	L	58,4	47.5	R	57.5	L	61,4	50	L	60	R	64,4	15	L	35	R
55,5	32.5	R	45	L	58,5	75	L	82.5	R	61,5	25	L	40	R	64,5	5	L	32.5	R
55,6	65	R	75	L	58,6	35	L	47.5	R	61,6	10	L	32.5	R	64,6	2.5	R	32.5	R
55,7	55	L	65	R	58,7	17.5	L	37.5	R	61,7	0	L	30	R	64,7	10	R	32.5	R
55,8	27.5	L	42.5	R	58,8	5	L	32.5	R	61,8	5	R	32.5	R	64,8	15	R	35	R
55,9	12.5	L	35	R	58,9	2.5	R	32.5	R	61,9	12.5	R	35	R	64,9	22.5	R	37.5	R
56,0	12.5	L	35	L	59,0	2.5	L	32.5	L	62,0	10	R	32.5	L	65,0	37.5	R	50	L
56,1	7.5	L	32.5	L	59,1	5	R	32.5	L	62,1	25	R	40	L	65,1	80	R	87.5	L
56,2	0	R	32.5	L	59,2	15	R	35	L	62,2	52.5	R	62.5	L	65,2	47.5	L	57.5	R
56,3	10	R	32.5	L	59,3	35	R	47.5	L	62,3	70	L	77.5	R	65,3	22.5	L	40	R
56,4	22.5	R	40	L	59,4	72.5	R	80	L	62,4	35	L	47.5	R	65,4	7.5	L	32.5	R
56,5	47.5	R	57.5	L	59,5	52.5	L	62.5	R	62,5	15	L	35	R	65,5	0	L	32.5	R
56,6	80	L	87.5	R	59,6	25	L	40	R	62,6	5	L	32.5	R	65,6	7.5	R	32.5	R
56,7	37.5	L	50	R	59,7	10	L	32.5	R	62,7	2.5	R	32.5	R	65,7	12.5	R	35	R
56,8	17.5	L	35	R	59,8	2.5	L	32.5	R	62,8	10	R	32.5	R	65,8	17.5	R	37.5	R
56,9	7.5	L	32.5	R	59,9	5	R	32.5	R	62,9	15	R	35	R	65,9	25	R	40	R
57,0	10	L	32.5	L	60,0	0	R	30	L	63,0	17.5	R	37.5	L	–	–	–	–	–
57,1	2.5	L	32.5	L	60,1	10	R	32.5	L	63,1	37.5	R	50	L	–	–	–	–	–
57,2	5	R	32.5	L	60,2	25	R	40	L	63,2	77.5	R	85	L	–	–	–	–	–
57,3	15	R	35	L	60,3	50	R	60	L	63,3	47.5	L	57.5	R	–	–	–	–	–
57,4	32.5	R	45	L	60,4	72.5	L	80	R	63,4	22.5	L	40	R	–	–	–	–	–
57,5	67.5	R	77.5	L	60,5	35	L	47.5	R	63,5	10	L	32.5	R	–	–	–	–	–
57,6	52.5	L	62.5	R	60,6	15	L	35	R	63,6	0	L	30	R	–	–	–	–	–
57,7	25	L	40	R	60,7	5	L	32.5	R	63,7	7.5	R	32.5	R	–	–	–	–	–
57,8	10	L	32.5	R	60,8	2.5	R	32.5	R	63,8	12.5	R	35	R	–	–	–	–	–
57,9	2.5	L	32.5	R	60,9	10	R	32.5	R	63,9	17.5	R	37.5	R	–	–	–	–	–

(continued)

(Balancing Table • SVU-BB2 Boring Head — continued)

KRDEA012AM • KRDE065012M 65–82,9mm

diameter	ring 1		ring 2		diameter	ring 1		ring 2		diameter	ring 1		ring 2	
mm					mm					mm				
65,0	5	L	37.5	R	68,0	12.5	R	37.5	R	71,0	25	R	45	R
65,1	2.5	R	37.5	R	68,1	17.5	R	40	R	71,1	32.5	R	47.5	R
65,2	10	R	37.5	R	68,2	22.5	R	42.5	R	71,2	37.5	R	52.5	R
65,3	15	R	40	R	68,3	27.5	R	47.5	R	71,3	42.5	R	57.5	R
65,4	20	R	42.5	R	68,4	32.5	R	50	R	71,4	47.5	R	62.5	R
65,5	25	R	45	R	68,5	40	R	55	R	71,5	55	R	67.5	R
65,6	30	R	47.5	R	68,6	45	R	60	R	71,6	65	R	77.5	R
65,7	35	R	52.5	R	68,7	52.5	R	65	R	71,7	65	R	77.5	R
65,8	42.5	R	57.5	R	68,8	60	R	72.5	R	71,8	65	R	77.5	R
65,9	47.5	R	62.5	R	68,9	70	R	82.5	R	71,9	65	R	77.5	R
66,0	2.5	R	35	R	69,0	17.5	R	40	R	72,0	30	R	47.5	R
66,1	7.5	R	37.5	R	69,1	22.5	R	42.5	R	72,1	35	R	52.5	R
66,2	12.5	R	40	R	69,2	27.5	R	45	R	72,2	40	R	55	R
66,3	20	R	40	R	69,3	32.5	R	50	R	72,3	47.5	R	60	R
66,4	25	R	45	R	69,4	37.5	R	52.5	R	72,4	55	R	67.5	R
66,5	30	R	47.5	R	69,5	45	R	57.5	R	72,5	62.5	R	75	R
66,6	35	R	52.5	R	69,6	50	R	62.5	R	72,6	80	R	90	R
66,7	40	R	55	R	69,7	57.5	R	70	R	72,7	80	R	90	R
66,8	47.5	R	60	R	69,8	67.5	R	80	R	72,8	80	R	90	R
66,9	55	R	67.5	R	69,9	67.5	R	80	R	72,9	80	R	90	R
67,0	7.5	R	37.5	R	70,0	22.5	R	42.5	R	73,0	40	R	55	R
67,1	12.5	R	40	R	70,1	27.5	R	45	R	73,1	47.5	R	60	R
67,2	17.5	R	42.5	R	70,2	32.5	R	50	R	73,2	52.5	R	65	R
67,3	22.5	R	45	R	70,3	37.5	R	52.5	R	73,3	62.5	R	75	R
67,4	30	R	47.5	R	70,4	42.5	R	57.5	R	73,4	75	R	87.5	R
67,5	35	R	50	R	70,5	50	R	62.5	R	73,5	75	R	87.5	R
67,6	40	R	55	R	70,6	57.5	R	70	R	73,6	75	R	87.5	R
67,7	45	R	60	R	70,7	65	R	77.5	R	73,7	75	R	87.5	R
67,8	52.5	R	65	R	70,8	65	R	77.5	R	73,8	75	R	87.5	R
67,9	60	R	72.5	R	70,9	65	R	77.5	R	73,9	75	R	87.5	R
74,0	40	R	55	R	77,0	55	R	67.5	R	80,0	22.5	L	45	L
74,1	45	R	60	R	77,1	65	R	77.5	R	80,1	17.5	L	42.5	L
74,2	52.5	R	65	R	77,2	65	R	77.5	R	80,2	12.5	L	40	L
74,3	60	R	72.5	R	77,3	65	R	77.5	R	80,3	5	L	40	L
74,4	70	R	82.5	R	77,4	65	R	77.5	R	80,4	2.5	R	40	L
74,5	70	R	82.5	R	77,5	65	R	77.5	R	80,5	10	R	40	L
74,6	70	R	82.5	R	77,6	65	R	77.5	R	80,6	22.5	R	45	L
74,7	70	R	82.5	R	77,7	65	R	77.5	R	80,7	37.5	R	55	L
74,8	70	R	82.5	R	77,8	65	R	77.5	R	80,8	65	R	77.5	L
74,9	70	R	82.5	R	77,9	65	R	77.5	R	80,9	70	L	82.5	R
75,0	52.5	R	65	R	78,0	62.5	R	75	R	81,0	20	L	42.5	L
75,1	57.5	R	70	R	78,1	82.5	R	92.5	R	81,1	12.5	L	40	L
75,2	70	R	82.5	R	78,2	82.5	R	92.5	R	81,2	5	L	40	L
75,3	70	R	82.5	R	78,3	82.5	R	92.5	R	81,3	0	R	37.5	L
75,4	70	R	82.5	R	78,4	82.5	R	92.5	R	81,4	10	R	40	L
75,5	70	R	82.5	R	78,5	82.5	R	92.5	R	81,5	20	R	45	L
75,6	70	R	82.5	R	78,6	82.5	R	92.5	R	81,6	35	R	52.5	L
75,7	70	R	82.5	R	78,7	82.5	R	92.5	R	81,7	57.5	R	72.5	L
75,8	70	R	82.5	R	78,8	82.5	R	92.5	R	81,8	75	L	87.5	R
75,9	70	R	82.5	R	78,9	82.5	R	92.5	R	81,9	45	L	60	R
76,0	50	R	62.5	R	79,0	75	R	87.5	R	82,0	15	L	40	L
76,1	57.5	R	70	R	79,1	75	R	87.5	R	82,1	7.5	L	40	L
76,2	67.5	R	80	R	79,2	75	R	87.5	R	82,2	0	L	40	L
76,3	67.5	R	80	R	79,3	75	R	87.5	R	82,3	7.5	R	40	L
76,4	67.5	R	80	R	79,4	75	R	87.5	R	82,4	17.5	R	42.5	L
76,5	67.5	R	80	R	79,5	75	R	87.5	R	82,5	30	R	50	L
76,6	67.5	R	80	R	79,6	75	R	87.5	R	82,6	52.5	R	67.5	L
76,7	67.5	R	80	R	79,7	75	R	87.5	R	82,7	82.5	L	95	R
76,8	67.5	R	80	R	79,8	75	R	87.5	R	82,8	50	L	65	R
76,9	67.5	R	80	R	79,9	75	R	87.5	R	82,9	30	L	50	R

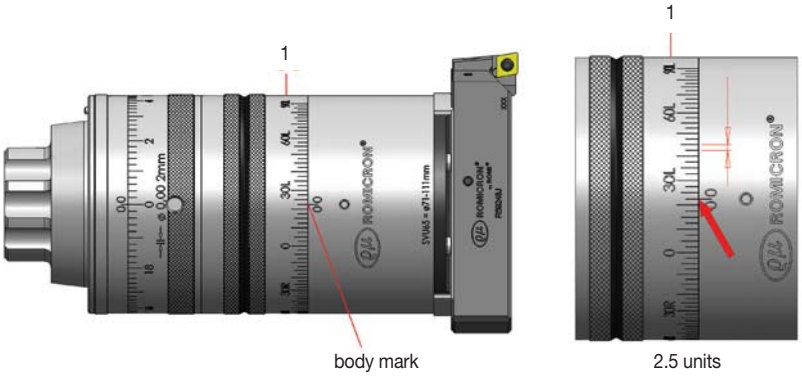
(continued)

(Balancing Table • SVU-BB2 Boring Head — continued)

KRDEA012AM • KRDE065012M 65–100mm

diameter	ring 1		ring 2		diameter	ring 1		ring 2		diameter	ring 1		ring 2	
mm					mm					mm				
83,0	10	L	40	L	86,0	10	R	40	L	89,0	42.5	R	57.5	L
83,1	2.5	L	37.5	L	86,1	20	R	45	L	89,1	72.5	R	85	L
83,2	5	R	40	L	86,2	35	R	52.5	L	89,2	62.5	L	75	R
83,3	15	R	42.5	L	86,3	57.5	R	72.5	L	89,3	37.5	L	55	R
83,4	27.5	R	47.5	L	86,4	75	L	87.5	R	89,4	22.5	L	45	R
83,5	47.5	R	62.5	L	86,5	45	L	60	R	89,5	10	L	40	R
83,6	77.5	R	90	L	86,6	27.5	L	47.5	R	89,6	0	L	37.5	R
83,7	55	L	70	R	86,7	15	L	42.5	R	89,7	5	R	40	R
83,8	32.5	L	50	R	86,8	5	L	40	R	89,8	12.5	R	40	R
83,9	17.5	L	42.5	R	86,9	2.5	R	40	R	89,9	17.5	R	42.5	R
84,0	5	L	37.5	L	87,0	17.5	R	42.5	L	90,0	65	R	77.5	L
84,1	2.5	R	37.5	L	87,1	30	R	50	L	90,1	70	L	82.5	R
84,2	12.5	R	40	L	87,2	52.5	R	67.5	L	90,2	40	L	57.5	R
84,3	25	R	47.5	L	87,3	82.5	L	95	R	90,3	22.5	L	45	R
84,4	42.5	R	57.5	L	87,4	50	L	65	R	90,4	12.5	L	40	R
84,5	72.5	R	85	L	87,5	30	L	50	R	90,5	2.5	L	37.5	R
84,6	62.5	L	75	R	87,6	17.5	L	42.5	R	90,6	5	R	37.5	R
84,7	37.5	L	55	R	87,7	7.5	L	40	R	90,7	10	R	40	R
84,8	22.5	L	45	R	87,8	2.5	R	37.5	R	90,8	17.5	R	42.5	R
84,9	10	L	40	R	87,9	7.5	R	40	R	90,9	22.5	R	45	R
85,0	2.5	R	40	L	88,0	27.5	R	47.5	L	91,0	75	L	87.5	R
85,1	10	R	40	L	88,1	47.5	R	62.5	L	91,1	47.5	L	62.5	R
85,2	22.5	R	45	L	88,2	77.5	R	90	L	91,2	27.5	L	47.5	R
85,3	37.5	R	55	L	88,3	55	L	70	R	91,3	15	L	42.5	R
85,4	65	R	77.5	L	88,4	35	L	52.5	R	91,4	5	L	40	R
85,5	70	L	82.5	R	88,5	17.5	L	42.5	R	91,5	2.5	R	40	R
85,6	40	L	57.5	R	88,6	7.5	L	40	R	91,6	10	R	40	R
85,7	22.5	L	45	R	88,7	0	R	40	R	91,7	15	R	42.5	R
85,8	12.5	L	40	R	88,8	7.5	R	40	R	91,8	22.5	R	45	R
85,9	2.5	L	37.5	R	88,9	12.5	R	42.5	R	91,9	27.5	R	47.5	R
92,0	50	L	65	R	95,0	12.5	L	40	R	98,0	7.5	R	40	R
92,1	30	L	50	R	95,1	2.5	L	37.5	R	98,1	12.5	R	42.5	R
92,2	17.5	L	42.5	R	95,2	5	R	37.5	R	98,2	20	R	42.5	R
92,3	7.5	L	40	R	95,3	10	R	40	R	98,3	25	R	47.5	R
92,4	2.5	R	37.5	R	95,4	17.5	R	42.5	R	98,4	30	R	50	R
92,5	7.5	R	40	R	95,5	22.5	R	45	R	98,5	37.5	R	55	R
92,6	15	R	40	R	95,6	27.5	R	47.5	R	98,6	42.5	R	60	R
92,7	20	R	45	R	95,7	35	R	52.5	R	98,7	50	R	65	R
92,8	25	R	47.5	R	95,8	40	R	57.5	R	98,8	57.5	R	72.5	R
92,9	32.5	R	50	R	95,9	47.5	R	62.5	R	98,9	70	R	82.5	R
93,0	35	L	52.5	R	96,0	5	L	40	R	99,0	12.5	R	40	R
93,1	17.5	L	42.5	R	96,1	2.5	R	40	R	99,1	17.5	R	42.5	R
93,2	7.5	L	40	R	96,2	10	R	40	R	99,2	25	R	45	R
93,3	0	R	37.5	R	96,3	15	R	42.5	R	99,3	30	R	50	R
93,4	7.5	R	40	R	96,4	22.5	R	45	R	99,4	35	R	52.5	R
93,5	12.5	R	42.5	R	96,5	27.5	R	47.5	R	99,5	42.5	R	57.5	R
93,6	20	R	42.5	R	96,6	32.5	R	52.5	R	99,6	47.5	R	62.5	R
93,7	25	R	47.5	R	96,7	40	R	55	R	99,7	55	R	70	R
93,8	30	R	50	R	96,8	45	R	60	R	99,8	67.5	R	80	R
93,9	37.5	R	55	R	96,9	52.5	R	67.5	R	99,9	67.5	R	80	R
94,0	22.5	L	45	R	97,0	2.5	R	37.5	R	100,0	17.5	R	42.5	R
94,1	10	L	40	R	97,1	7.5	R	40	R	100,1	22.5	R	45	R
94,2	2.5	L	40	R	97,2	15	R	40	R	100,2	27.5	R	47.5	R
94,3	5	R	40	R	97,3	20	R	45	R	100,3	35	R	52.5	R
94,4	12.5	R	40	R	97,4	25	R	47.5	R	100,4	40	R	57.5	R
94,5	17.5	R	42.5	R	97,5	32.5	R	50	R	100,5	47.5	R	62.5	R
94,6	25	R	45	R	97,6	37.5	R	55	R	100,6	55	R	70	R
94,7	30	R	50	R	97,7	45	R	60	R	100,7	65	R	77.5	R
94,8	35	R	52.5	R	97,8	50	R	65	R	100,8	65	R	77.5	R
94,9	42.5	R	57.5	R	97,9	60	R	72.5	R	100,9	65	R	77.5	R

Balancing Table • SVU-65 Boring Head



1. There is 1 balancing dial on the SVU system.
2. Look up your diameter in the table below and read the setting values for ring 1.
3. Set ring 1, referencing to the body mark (one dial mark equals 2.5 units).

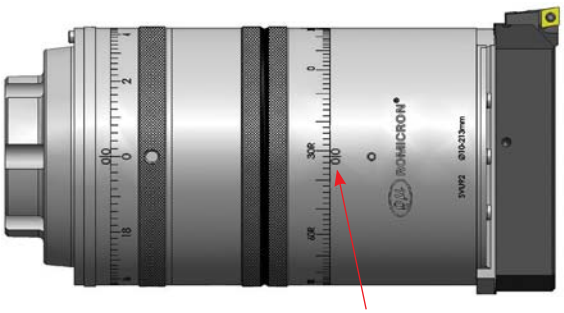
KRDE070019M									KRDE083019M					
KRCSCFPR061E 71–76mm			KRCSCFPR062E 75,5–81,5mm			KRCSCFPR063E 80–85mm			KRCSCFPR061E 84–89mm			KRCSCFPR062E 88,5–93,5mm		
diameter mm	balancing ring setting		diameter mm	balancing ring setting		diameter mm	balancing ring setting		diameter mm	balancing ring setting		diameter mm	balancing ring setting	
70,99	40	L	75,49	35	L	80,01	30	L	84,00	47.5	L	88,49	40	L
71,12	37.5	L	75,59	32.5	L	80,16	27.5	L	84,12	45	L	88,65	37.5	L
71,27	35	L	75,77	30	L	80,34	25	L	84,25	42.5	L	88,80	35	L
71,42	32.5	L	75,95	27.5	L	80,52	22.5	L	84,38	40	L	88,95	32.5	L
71,60	30	L	76,10	25	L	80,70	20	L	84,51	37.5	L	89,08	30	L
71,78	27.5	L	76,28	22.5	L	80,87	17.5	L	84,66	35	L	89,26	27.5	L
71,96	25	L	76,48	20	L	81,08	15	L	84,81	32.5	L	89,41	25	L
72,14	22.5	L	76,66	17.5	L	81,25	12.5	L	84,96	30	L	89,56	22.5	L
72,31	20	L	76,84	15	L	81,46	10	L	85,12	27.5	L	89,74	20	L
72,49	17.5	L	77,04	12.5	L	81,64	7.5	L	85,27	25	L	89,89	17.5	L
72,69	15	L	77,22	10	L	81,84	5	L	85,42	22.5	L	90,07	15	L
72,87	12.5	L	77,42	7.5	L	82,02	2.5	L	85,60	20	L	90,22	12.5	L
73,08	10	L	77,62	5	L	82,22	0	–	85,78	17.5	L	90,40	10	L
73,25	7.5	L	77,80	2.5	L	82,42	2.5	R	85,93	15	L	90,58	7.5	L
73,46	5	L	78,00	0	–	82,60	5	R	86,11	12.5	L	90,75	5	L
73,66	2.5	L	78,21	2.5	R	82,80	7.5	R	86,28	10	L	90,93	2.5	L
73,86	0	–	78,38	5	R	82,98	10	R	86,46	7.5	L	91,11	0	–
74,04	2.5	R	78,59	7.5	R	83,19	12.5	R	86,64	5	L	91,29	2.5	R
74,24	5	R	78,77	10	R	83,36	15	R	86,82	2.5	L	91,47	5	R
74,45	7.5	R	78,97	12.5	R	83,57	17.5	R	87,00	0	–	91,64	7.5	R
74,63	10	R	79,15	15	R	83,74	20	R	87,17	2.5	R	91,80	10	R
74,83	12.5	R	79,35	17.5	R	83,92	22.5	R	87,33	5	R	91,97	12.5	R
75,01	15	R	79,53	20	R	84,10	25	R	87,50	7.5	R	92,15	15	R
75,21	17.5	R	79,71	22.5	R	84,28	27.5	R	87,68	10	R	92,33	17.5	R
75,39	20	R	79,88	25	R	84,46	30	R	87,86	12.5	R	92,48	20	R
75,57	22.5	R	80,06	27.5	R	84,61	32.5	R	88,04	15	R	92,66	22.5	R
75,74	25	R	80,24	30	R	84,79	35	R	88,21	17.5	R	92,81	25	R
75,92	27.5	R	80,42	32.5	R	84,94	37.5	R	88,37	20	R	92,96	27.5	R
76,00	30	R	80,49	35	R	84,99	40	R	88,54	22.5	R	93,12	30	R
–	–	–	–	–	–	–	–	–	88,70	25	R	93,27	32.5	R
–	–	–	–	–	–	–	–	–	88,85	27.5	R	93,42	35	R
–	–	–	–	–	–	–	–	–	89,00	30	R	93,50	37.5	R

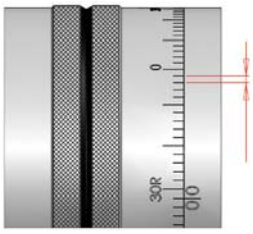
(continued)

(Balancing Table • SVU-65 Boring Head — continued)

KRDE083019M			KRDE096019M								
KRCSCFPR063E			KRCSCFPR061E			KRCSCFPR062E			KRCSCFPR063E		
93–98mm			97–102mm			101,5–106,5mm			106–111mm		
diameter mm	balancing ring setting		diameter mm	balancing ring setting		diameter mm	balancing ring setting		diameter mm	balancing ring setting	
92,99	35	L	97,00	55	L	101,50	45	L	105,99	37.5	L
93,14	32.5	L	97,05	52.5	L	101,60	42.5	L	106,17	35	L
93,29	30	L	97,16	50	L	101,73	40	L	106,32	32.5	L
93,45	27.5	L	97,28	47.5	L	101,85	37.5	L	106,45	30	L
93,60	25	L	97,38	45	L	101,98	35	L	106,58	27.5	L
93,78	22.5	L	97,51	42.5	L	102,13	32.5	L	106,73	25	L
93,93	20	L	97,61	40	L	102,26	30	L	106,88	22.5	L
94,11	17.5	L	97,74	37.5	L	102,41	27.5	L	107,04	20	L
94,26	15	L	97,87	35	L	102,54	25	L	107,19	17.5	L
94,44	12.5	L	98,02	32.5	L	102,69	22.5	L	107,34	15	L
94,62	10	L	98,15	30	L	102,84	20	L	107,49	12.5	L
94,79	7.5	L	98,30	27.5	L	103,00	17.5	L	107,65	10	L
94,95	5	L	98,45	25	L	103,15	15	L	107,82	7.5	L
95,12	2.5	L	98,58	22.5	L	103,30	12.5	L	107,98	5	L
95,30	0	–	98,73	20	L	103,48	10	L	108,13	2.5	L
95,48	2.5	R	98,88	17.5	L	103,63	7.5	L	108,31	0	–
95,66	5	R	99,06	15	L	103,78	5	L	108,46	2.5	R
95,83	7.5	R	99,21	12.5	L	103,96	2.5	L	108,61	5	R
96,01	10	R	99,36	10	L	104,11	0	–	108,79	7.5	R
96,19	12.5	R	99,52	7.5	L	104,27	2.5	R	108,94	10	R
96,34	15	R	99,70	5	L	104,44	5	R	109,09	12.5	R
96,52	17.5	R	99,85	2.5	L	104,60	7.5	R	109,25	15	R
96,67	20	R	100,03	0	–	104,75	10	R	109,40	17.5	R
96,85	22.5	R	100,18	2.5	R	104,90	12.5	R	109,55	20	R
97,00	25	R	100,33	5	R	105,08	15	R	109,70	22.5	R
97,16	27.5	R	100,51	7.5	R	105,23	17.5	R	109,86	25	R
97,31	30	R	100,66	10	R	105,38	20	R	110,01	27.5	R
97,46	32.5	R	100,81	12.5	R	105,54	22.5	R	110,13	30	R
97,61	35	R	100,97	15	R	105,69	25	R	110,29	32.5	R
97,76	37.5	R	101,14	17.5	R	105,82	27.5	R	110,41	35	R
97,89	40	R	101,30	20	R	105,97	30	R	110,54	37.5	R
97,99	42.5	R	101,45	22.5	R	106,10	32.5	R	110,67	40	R
–	–	–	101,57	25	R	106,25	35	R	110,79	42.5	R
–	–	–	101,73	27.5	R	106,38	37.5	R	110,90	45	R
–	–	–	104,39	30	R	106,43	40	R	111,00	47.5	R
–	–	–	102,01	32.5	R	106,53	42.5	R	–	–	–

Balancing Table • SVU-92 Boring Head





1. There is 1 balancing dial on the SVU system.
2. Look up your diameter in the table below and read the setting values for ring 1.
3. Set ring 1, referencing to the body mark (one dial mark equals 2.5 units)

KRDE101023M									KRDE120023M					
KRCSCFPR061F 101–108mm			KRCSCFPR062F 107,5–114,5mm			KRCSCFPR063F 114–121mm			KRCSCFPR061F 120–127mm			KRCSCFPR062F 126,5–133,5mm		
diameter mm	balancing ring setting		diameter mm	balancing ring setting		diameter mm	balancing ring setting		diameter mm	balancing ring setting		diameter mm	balancing ring setting	
100,99	36	L	107,49	34	L	114,00	30	L	119,99	40	L	126,49	36	L
101,19	34	L	107,62	32	L	114,22	28	L	120,19	38	L	126,72	34	L
101,40	32	L	107,80	30	L	114,40	26	L	120,35	36	L	126,90	32	L
101,57	30	L	108,00	28	L	114,60	24	L	120,52	34	L	127,08	30	L
101,78	28	L	108,20	26	L	114,81	22	L	120,70	32	L	127,25	28	L
101,98	26	L	108,41	24	L	115,01	20	L	120,88	30	L	127,43	26	L
102,18	24	L	108,61	22	L	115,24	18	L	121,06	28	L	127,61	24	L
102,39	22	L	108,81	20	L	115,44	16	L	121,23	26	L	127,81	22	L
102,59	20	L	109,02	18	L	115,67	14	L	121,41	24	L	127,99	20	L
102,79	18	L	109,25	16	L	115,87	12	L	121,62	22	L	128,19	18	L
103,02	16	L	109,45	14	L	116,10	10	L	121,79	20	L	128,40	16	L
103,23	14	L	109,68	12	L	116,31	8	L	122,00	18	L	128,57	14	L
103,45	12	L	109,88	10	L	116,54	6	L	122,20	16	L	128,78	12	L
103,66	10	L	110,11	8	L	116,76	4	L	122,38	14	L	128,98	10	L
103,89	8	L	110,34	6	L	116,97	2	L	122,58	12	L	129,18	8	L
104,11	6	L	110,57	4	L	117,20	0	–	122,78	10	L	129,39	6	L
104,32	4	L	110,77	2	L	117,42	2	R	122,99	8	L	129,59	4	L
104,55	2	L	111,00	0	–	117,65	4	R	123,19	6	L	129,79	2	L
104,78	0	–	111,23	2	R	117,86	6	R	123,39	4	L	130,00	0	–
105,00	2	R	111,46	4	R	118,08	8	R	123,60	2	L	130,20	2	R
105,23	4	R	111,66	6	R	118,31	10	R	123,80	0	–	130,40	4	R
105,44	6	R	111,89	8	R	118,52	12	R	124,00	2	R	130,61	6	R
105,66	8	R	112,12	10	R	118,75	14	R	124,21	4	R	130,81	8	R
105,89	10	R	107,19	12	R	118,95	16	R	124,41	6	R	131,01	10	R
106,10	12	R	112,55	14	R	119,18	18	R	124,61	8	R	131,22	12	R
106,32	14	R	112,75	16	R	119,38	20	R	124,82	10	R	131,42	14	R
106,53	16	R	112,98	18	R	119,58	22	R	125,02	12	R	131,62	16	R
106,76	18	R	113,18	20	R	119,79	24	R	125,22	14	R	131,80	18	R
106,96	20	R	113,39	22	R	119,99	26	R	125,43	16	R	132,00	20	R
107,16	22	R	113,59	24	R	120,19	28	R	125,63	18	R	132,18	22	R
107,37	24	R	113,79	26	R	120,37	30	R	125,81	20	R	132,38	24	R
107,57	26	R	114,00	28	R	120,57	32	R	126,01	22	R	132,56	26	R
107,77	28	R	114,20	30	R	120,75	34	R	126,19	24	R	132,74	28	R
107,98	30	R	114,38	32	R	120,93	36	R	126,37	26	R	132,92	30	R
108,00	32	R	114,50	34	R	121,01	38	R	126,57	28	R	133,10	32	R
–	–	–	–	–	–	–	–	–	126,75	30	R	133,27	34	R
–	–	–	–	–	–	–	–	–	126,92	32	R	133,45	36	R
–	–	–	–	–	–	–	–	–	127,00	34	R	133,50	38	R

(continued)

(Balancing Table • SVU-92 Boring Head — continued)

KRDE120023M			KRDE139026M								
KRCSCFPR063F			KRCSCFPR061F			KRCSCFPR062F			KRCSCFPR063F		
133–140mm			139–146mm			145,5–152,5mm			152–159mm		
diameter mm	balancing ring setting		diameter mm	balancing ring setting		diameter mm	balancing ring setting		diameter mm	balancing ring setting	
132,99	34	L	138,99	50	L	145,49	44	L	151,99	40	L
133,10	32	L	139,09	48	L	145,67	42	L	152,12	38	L
133,27	30	L	139,22	46	L	145,80	40	L	152,27	36	L
133,45	28	L	139,34	44	L	145,95	38	L	152,40	34	L
133,63	26	L	139,47	42	L	146,08	36	L	152,55	32	L
133,81	24	L	139,60	40	L	146,23	34	L	152,70	30	L
133,99	22	L	139,73	38	L	146,35	32	L	152,86	28	L
134,19	20	L	139,88	36	L	146,51	30	L	153,01	26	L
134,37	18	L	140,00	34	L	146,66	28	L	153,16	24	L
134,57	16	L	140,16	32	L	146,81	26	L	153,31	22	L
134,77	14	L	140,31	30	L	146,99	24	L	153,49	20	L
134,98	12	L	140,46	28	L	147,14	22	L	153,64	18	L
135,18	10	L	140,61	26	L	147,29	20	L	153,82	16	L
135,36	8	L	140,77	24	L	147,47	18	L	153,97	14	L
135,56	6	L	140,92	22	L	147,62	16	L	154,15	12	L
135,76	4	L	141,10	20	L	147,80	14	L	154,33	10	L
135,97	2	L	141,25	18	L	147,96	12	L	154,48	8	L
136,17	0	–	141,43	16	L	148,13	10	L	154,66	6	L
136,37	2	R	141,58	14	L	148,31	8	L	154,84	4	L
136,58	4	R	141,76	12	L	148,49	6	L	155,02	2	L
162,18	6	R	141,94	10	L	148,64	4	L	155,19	0	–
136,98	8	R	142,11	8	L	148,82	2	L	155,35	2	R
137,19	10	R	142,27	6	L	149,00	0	–	155,52	4	R
137,39	12	R	142,44	4	L	149,17	2	R	155,70	6	R
137,59	14	R	142,62	2	L	149,35	4	R	155,88	8	R
137,80	16	R	142,80	0	–	149,53	6	R	156,03	10	R
137,97	18	R	142,98	2	R	149,68	8	R	156,21	12	R
138,18	20	R	143,15	4	R	149,86	10	R	156,39	14	R
138,38	22	R	143,31	6	R	150,04	12	R	156,54	16	R
138,56	24	R	143,48	8	R	150,19	14	R	156,72	18	R
138,73	26	R	143,66	10	R	150,37	16	R	156,87	20	R
138,91	28	R	143,84	12	R	150,55	18	R	157,05	22	R
139,09	30	R	143,99	14	R	150,70	20	R	157,20	24	R
139,27	32	R	144,17	16	R	150,85	22	R	157,35	26	R
139,45	34	R	144,32	18	R	151,03	24	R	157,51	28	R
139,60	36	R	144,50	20	R	151,18	26	R	157,66	30	R
139,78	38	R	144,65	22	R	151,33	28	R	157,81	32	R
139,93	40	R	144,83	24	R	151,49	30	R	157,96	34	R
140,00	42	R	144,98	26	R	151,64	32	R	158,09	36	R
–	–	–	145,14	28	R	151,79	34	R	158,24	38	R
–	–	–	145,29	30	R	151,92	36	R	158,37	40	R
–	–	–	145,44	32	R	152,07	38	R	158,50	42	R
–	–	–	145,57	34	R	152,20	40	R	158,62	44	R
–	–	–	145,72	36	R	152,32	42	R	158,75	46	R
–	–	–	145,87	38	R	152,45	44	R	158,88	48	R
–	–	–	145,97	40	R	152,50	46	R	158,98	50	R
–	–	–	146,00	42	R	–	–	–	159,00	52	R

(continued)

(Balancing Table • SVU-92 Boring Head — continued)

KRDE156026M

KRCSCFPR061F 156–163mm			KRCSCFPR062F 162,5–169,5mm			KRCSCFPR063F 169–176mm		
diameter mm	balancing ring setting		diameter mm	balancing ring setting		diameter mm	balancing ring setting	
156,01	56	L	162,51	50	L	169,01	44	L
156,11	54	L	162,61	48	L	169,11	42	L
156,21	52	L	162,71	46	L	169,24	40	L
156,31	50	L	162,81	44	L	169,37	38	L
156,41	48	L	162,94	42	L	169,49	36	L
156,51	46	L	163,07	40	L	169,62	34	L
156,62	44	L	163,20	38	L	169,75	32	L
156,74	42	L	163,32	36	L	169,90	30	L
156,87	40	L	163,45	34	L	170,03	28	L
157,00	38	L	163,58	32	L	170,18	26	L
157,12	36	L	163,70	30	L	170,33	24	L
157,25	34	L	163,86	28	L	170,46	22	L
157,38	32	L	164,01	26	L	170,61	20	L
157,53	30	L	164,13	24	L	170,76	18	L
157,66	28	L	164,29	22	L	170,92	16	L
157,81	26	L	164,44	20	L	171,07	14	L
157,94	24	L	164,59	18	L	171,22	12	L
158,09	22	L	164,74	16	L	171,37	10	L
158,24	20	L	164,90	14	L	171,55	8	L
158,39	18	L	165,05	12	L	171,70	6	L
158,55	16	L	165,20	10	L	171,86	4	L
158,70	14	L	165,35	8	L	172,01	2	L
158,85	12	L	165,53	6	L	172,19	0	–
159,00	10	L	165,68	4	L	172,34	2	R
159,18	8	L	165,84	2	L	172,49	4	R
159,33	6	L	165,99	0	–	172,64	6	R
159,49	4	L	166,17	2	R	172,82	8	R
159,64	2	L	166,32	4	R	172,97	10	R
159,82	0	–	166,47	6	R	173,13	12	R
159,97	2	R	166,62	8	R	173,28	14	R
160,12	4	R	166,80	10	R	173,43	16	R
160,27	6	R	166,95	12	R	173,58	18	R
160,45	8	R	167,11	14	R	173,74	20	R
160,60	10	R	167,26	16	R	173,89	22	R
160,76	12	R	167,41	18	R	174,04	24	R
160,91	14	R	167,56	20	R	174,17	26	R
161,06	16	R	167,72	22	R	174,32	28	R
161,21	18	R	167,87	24	R	174,45	30	R
161,37	20	R	168,00	26	R	174,60	32	R
161,52	22	R	168,15	28	R	174,73	34	R
161,67	24	R	168,28	30	R	174,85	36	R
161,82	26	R	168,43	32	R	174,98	38	R
161,95	28	R	168,55	34	R	175,11	40	R
162,10	30	R	168,68	36	R	175,23	42	R
162,23	32	R	168,81	38	R	175,34	44	R
162,36	34	R	168,94	40	R	175,46	46	R
162,51	36	R	169,06	42	R	175,56	48	R
162,64	38	R	169,16	44	R	175,67	50	R
162,74	40	R	169,29	46	R	175,77	52	R
162,86	42	R	169,39	48	R	175,87	54	R
162,99	44	R	169,49	50	R	175,95	56	R
162,99	46	R	169,49	52	R	176,00	58	R

(continued)

(Balancing Table • SVU-92 Boring Head — continued)

KRDE175026M

KRCSCFPR061F 175–182mm			KRCSCFPR062F 181,5–188,5mm			KRCSCFPR063F 188–195mm		
diameter mm	balancing ring setting		diameter mm	balancing ring setting		diameter mm	balancing ring setting	
175,01	64	L	181,51	56	L	188,0108	48	L
175,06	62	L	181,56	54	L	188,1124	46	L
175,13	60	L	181,64	52	L	188,214	44	L
175,21	58	L	181,74	50	L	188,3156	42	L
175,29	56	L	181,84	48	L	188,4426	40	L
175,36	54	L	181,94	46	L	188,5442	38	L
175,46	52	L	182,04	44	L	188,6712	36	L
175,56	50	L	182,14	42	L	188,7982	34	L
175,64	48	L	182,27	40	L	188,8998	32	L
175,74	46	L	182,37	38	L	189,0268	30	L
175,87	44	L	182,50	36	L	189,1792	28	L
175,97	42	L	182,63	34	L	189,3062	26	L
176,07	40	L	182,75	32	L	189,4332	24	L
176,20	38	L	182,88	30	L	189,5602	22	L
176,30	36	L	183,01	28	L	189,7126	20	L
176,43	34	L	183,13	26	L	189,8396	18	L
176,56	32	L	183,26	24	L	189,992	16	L
176,68	30	L	183,41	22	L	190,1444	14	L
176,81	28	L	183,54	20	L	190,2714	12	L
176,96	26	L	183,69	18	L	190,4238	10	L
177,09	24	L	183,82	16	L	114,3762	8	L
177,22	22	L	183,97	14	L	190,7286	6	L
177,37	20	L	184,12	12	L	190,8556	4	L
177,50	18	L	184,25	10	L	191,008	2	L
177,65	16	L	184,40	8	L	191,1604	0	–
177,80	14	L	184,56	6	L	191,3128	2	R
177,93	12	L	184,71	4	L	191,4652	4	R
178,08	10	L	184,86	2	L	191,6176	6	R
178,23	8	L	184,99	0	–	191,7446	8	R
178,38	6	L	185,14	2	R	191,897	10	R
178,54	4	L	185,29	4	R	192,0494	12	R
178,66	2	L	185,45	6	R	192,2018	14	R
178,82	0	–	185,60	8	R	192,3288	16	R
178,97	2	R	185,75	10	R	192,4812	18	R
179,12	4	R	185,88	12	R	192,6082	20	R
179,27	6	R	186,03	14	R	192,7606	22	R
179,43	8	R	186,18	16	R	192,8876	24	R
179,55	10	R	186,31	18	R	193,04	26	R
179,71	12	R	186,46	20	R	193,167	28	R
179,86	14	R	186,59	22	R	193,294	30	R
180,01	16	R	186,74	24	R	193,421	32	R
180,14	18	R	186,87	26	R	193,548	34	R
180,29	20	R	186,99	28	R	193,675	36	R
180,42	22	R	187,12	30	R	193,7766	38	R
180,57	24	R	187,25	32	R	193,9036	40	R
180,70	26	R	187,38	34	R	194,0052	42	R
180,82	28	R	187,50	36	R	194,1068	44	R
180,95	30	R	187,63	38	R	194,2338	46	R
181,08	32	R	187,73	40	R	194,3354	48	R
181,20	34	R	187,86	42	R	194,4116	50	R
181,33	36	R	187,96	44	R	194,5132	52	R
181,46	38	R	188,06	46	R	194,6148	54	R
181,56	40	R	188,16	48	R	194,691	56	R
181,69	42	R	188,26	50	R	194,7672	58	R
181,79	44	R	188,37	52	R	194,8434	60	R
181,89	46	R	188,44	54	R	194,9196	62	R
181,99	48	R	188,49	56	R	194,9958	64	R
181,99	50	R	–	–	–	194,9958	66	R

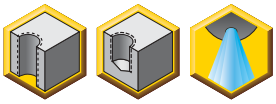
(continued)

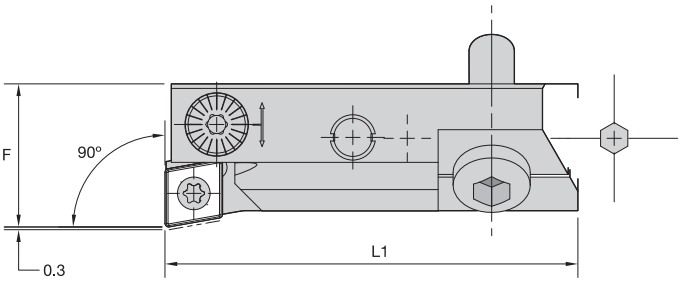
(Balancing Table • SVU-92 Boring Head — continued)

KRDE193026M

KRCSCFPR061F 193–200mm			KRCSCFPR062F 199,5–206,5mm			KRCSCFPR063F 206–213mm		
diameter mm	balancing ring setting		diameter mm	balancing ring setting		diameter mm	balancing ring setting	
192,99	64	L	199,49	54	L	205,994	46	L
193,07	62	L	199,62	52	L	206,1464	44	L
193,14	60	L	199,72	50	L	206,248	42	L
193,22	58	L	199,80	48	L	206,375	40	L
193,29	56	L	199,90	46	L	206,4766	38	L
193,37	54	L	200,03	44	L	206,6036	36	L
193,47	52	L	200,13	42	L	206,7306	34	L
193,57	50	L	200,23	40	L	206,8576	32	L
193,65	48	L	200,36	38	L	206,9846	30	L
193,75	46	L	200,48	36	L	207,1116	28	L
193,88	44	L	200,61	34	L	207,2386	26	L
193,98	42	L	200,71	32	L	207,391	24	L
194,08	40	L	200,86	30	L	207,518	22	L
194,21	38	L	200,99	28	L	207,6704	20	L
194,34	36	L	201,12	26	L	207,7974	18	L
194,46	34	L	201,24	24	L	207,9498	16	L
194,59	32	L	201,40	22	L	208,1022	14	L
194,72	30	L	201,52	20	L	208,2292	12	L
194,84	28	L	201,68	18	L	208,3816	10	L
194,97	26	L	201,80	16	L	208,534	8	L
195,10	24	L	201,96	14	L	208,6864	6	L
195,25	22	L	202,11	12	L	208,8388	4	L
195,38	20	L	202,26	10	L	208,9912	2	L
195,53	18	L	202,41	8	L	209,1182	0	–
195,68	16	L	202,54	6	L	209,2706	2	R
195,81	14	L	202,69	4	L	209,423	4	R
195,96	12	L	202,84	2	L	209,5754	6	R
196,11	10	L	203,00	0	–	209,7278	8	R
196,27	8	L	203,15	2	R	209,8802	10	R
196,42	6	L	203,30	4	R	210,0326	12	R
196,57	4	L	203,45	6	R	210,1596	14	R
196,70	2	L	203,61	8	R	210,312	16	R
196,85	0	–	203,76	10	R	210,4644	18	R
197,00	2	R	203,89	12	R	210,5914	20	R
197,15	4	R	204,04	14	R	210,7438	22	R
197,31	6	R	204,19	16	R	210,8708	24	R
197,46	8	R	204,32	18	R	210,9978	26	R
197,61	10	R	204,47	20	R	211,1502	28	R
197,76	12	R	204,60	22	R	211,2772	30	R
197,89	14	R	204,75	24	R	211,4042	32	R
198,04	16	R	204,88	26	R	211,5312	34	R
198,20	18	R	205,03	28	R	211,6582	36	R
198,32	20	R	205,16	30	R	211,7598	38	R
198,48	22	R	205,28	32	R	84,8868	40	R
198,60	24	R	205,41	34	R	211,9884	42	R
198,76	26	R	205,54	36	R	212,1154	44	R
198,88	28	R	205,64	38	R	212,217	46	R
199,01	30	R	205,77	40	R	212,3186	48	R
199,14	32	R	205,87	42	R	212,4202	50	R
199,26	34	R	205,99	44	R	212,4964	52	R
199,39	36	R	206,10	46	R	212,598	54	R
199,52	38	R	206,20	48	R	212,6742	56	R
199,62	40	R	206,30	50	R	212,7758	58	R
199,75	42	R	206,38	52	R	212,852	60	R
199,85	44	R	206,48	54	R	212,9028	62	R
199,95	46	R	206,50	56	R	212,979	64	R
200,00	48	R	–	–	–	213,0044	66	R

- All cartridges have internal coolant supply directed to the cutting edge.
- 0,01mm diameter adjustment respective 2 µm with vernier scale within a range of 0,3mm.
- Radial adjustment without influence on axial position.
- Axial adjustment range of 1mm.
- Smallest diameters can be machined starting from 28,0mm.







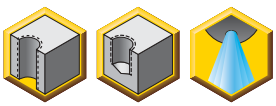
90° Lead • Micro-Adjustable Cartridge • C-Style

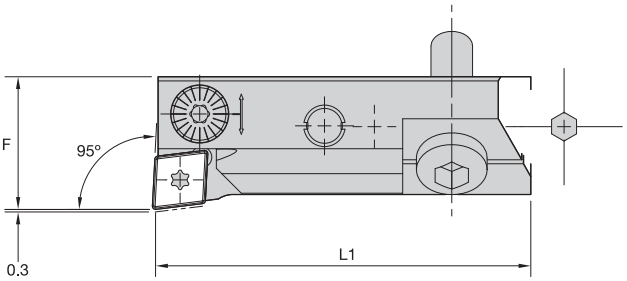


order number	catalogue number	F	L1	gage insert	insert screw	set screw
right hand						
3784474	**FBSCFCR09CA06F**	16,15	45,50	CCMT060204	**12148068700**	**12147629800**
left hand						
3784475	**FBSCFCL09CA06F**	16,15	45,50	CCMT060204	**12148068700**	**12147629800**

NOTE: For use with custom solution fine-boring and countersinking tools.

- All cartridges have internal coolant supply directed to the cutting edge.
- 0,01mm diameter adjustment respective 2 µm with vernier scale within a range of 0,3mm.
- Radial adjustment without influence on axial position.
- Axial adjustment range of 1mm.
- Smallest diameters can be machined starting from 28,0mm.







95° Lead • Micro-Adjustable Cartridge • C-Style

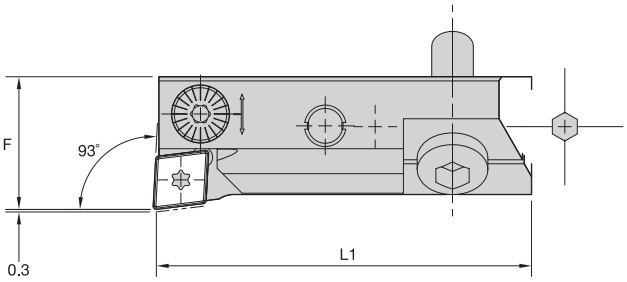


order number	catalogue number	F	L1	gage insert	insert screw	set screw
right hand						
3784476	**FBSCLCR09CA06F**	16,15	45,50	CCMT060204	**12148068700**	**12147629800**
left hand						
3784477	**FBSCLCL09CA06F**	16,15	45,50	CCMT060204	**12148068700**	**12147629800**

NOTE: For use with custom solution fine-boring and countersinking tools.

- All cartridges have internal coolant supply directed to the cutting edge.
- 0,01mm diameter adjustment respective 2 µm with vernier scale within a range of 0,3mm.
- Radial adjustment without influence on axial position.
- Axial adjustment range of 1mm.
- Smallest diameters can be machined starting from 28,0mm.





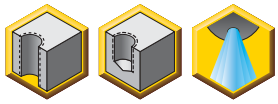


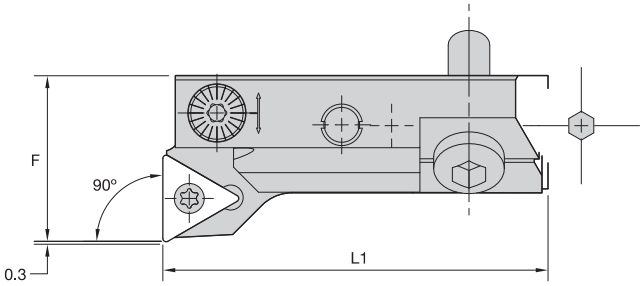
93° Lead • Micro-Adjustable Cartridge • C-Style

order number	catalogue number	F	L1	gage insert	 insert screw	 set screw
right hand						
2907289	**FBSCUCR09CA06F**	16,15	45,50	CCMT060204	**12148068700**	**12147629800**

NOTE: For use with custom solution fine-boring and countersinking tools.

- All cartridges have internal coolant supply directed to the cutting edge.
- 0,01mm diameter adjustment respective 2 µm with vernier scale within a range of 0,3mm.
- Radial adjustment without influence on axial position.
- Axial adjustment range of 1mm.
- Smallest diameters can be machined starting from 28,0mm.







90° Lead • Micro-Adjustable Cartridge • T-Style

order number	catalogue number	F	L1	gage insert	insert screw	set screw
right hand						
2907291	**FBSTFCR09CA11F**	20,15	45,50	TCMT110204	**12148068700**	**12147629800**

NOTE: For use with custom solution fine-boring and countersinking tools.

ModBORE™

One system includes highly flexible roughing and fine-boring heads to large bridge tooling with optimum amount of tooling components.

Primary Application

This premium boring line enables roughing to fine-boring operations using one system with a large diameter range from 9,75–2,205mm (.384–86.8"). The ModBORE system can be used in most workpiece materials in metalcutting applications along with the latest Kennametal standard ISO turning inserts.

Features and Benefits

Complete System

- Twin blade heads for roughing to semi-finishing operations starting from diameter 23,5mm (.925").
- Fine-boring heads for finishing in diameters 9,75–2,205mm (.384–86.8").
- Bridge tooling for large diameters up to 2,205mm (86.8") standard with both roughing and fine-finishing heads.
- Through-coolant capability in all styles.

Resolution

- Fine adjustable roughing heads.
- 0,01mm (.0004") diameter adjustment respective 2 µm (.00008") with easy-to-read large vernier scale with fine-boring heads.

Highest versatility possible on the shop floor with the ModBORE™ roughing and fine boring systems.



Product Variety

- KM™ shanks for use in all spindles with compatible adaptors.
- HSK shanks for use without adaptors.
- Inch shanks are most economical to use with compatible adaptors.



Customisation

- Engineered solutions available.
- Anti-chatter devices available.
- Cartridges can be designed into standard boring heads for added versatility.

ModBORE™ Fine-Boring System

Based on KM™, HSK, and inch SSF couplings, match all spindle specifications direct or indirect via adaptors. The ModBORE fine-boring system uses standard ISO/ANSI turning inserts for maximum performance and flexibility.

RBHT • Twin Cutters for Rough and Semi-Finish Boring

- Diameters 23,5–153mm (.925–6.024").
- KM, HSK, and inch straight shank back end versions available.
- Preloaded serration and ground support face for stable connection, minimal vibration, and maximum accuracy, with easy diameter adjustment.
- Large selection of blades sets:
  — Staggered — efficient machining of large depths of cut.
  — 70° — for challenging applications requiring stable corner radii and full use of inserts.
  — 90° — most precise machining results.
- Generous clearance and through coolant enable free chip flow and improved tool life.
- All toolholders accept positive standard inserts. Toolholders in diameter 65,5mm (2.58") and greater for negative standard inserts.



FBHM • Offset Boring Bar and Cartridge Heads for Fine Finishing

- Diameters 9,75–320mm (.384–12.59").
- KM-TS™, HSK, CV, DV, and BT steep taper back end styles available.
- Precision-ground micrometric screw enables fine adjustment of 2 µm (.00008"). Large TiN-coated dial is easy to adjust and read.
- Standard steel and carbide boring bars adjust in length for maximum stability.
- Aluminium diameter extender with insert cartridges and counterweight used for diameters starting at 86mm (3.38") for maximum flexibility.
- Through coolant at the cutting edge improves tool life, surface finish, and chip evacuation.



FBHO • Offset Boring Bar Heads for Fine Finishing



- Diameters 9,75–88,1mm (.384–3.46").
- KM™, HSK, and inch straight shank back end styles available.
- Precision-ground micrometric screw enables fine adjustment of 2 µm (.00008") via easy-to-read vernier scale.
- Standard steel and carbide boring bars can be adjusted in length for maximum stability.
- Through coolant at the cutting edge improves tool life, surface finish, and chip evacuation.

FBHS • Cartridge Boring Heads for Fine Finishing



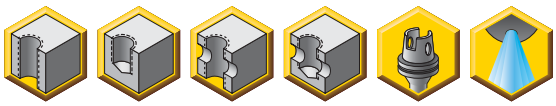
- Diameters 23,5–153mm (.925–6.024").
- KM, HSK, and inch straight shank back end styles available.
- Precision-ground micrometric screw enables fine adjustment of 2 µm (.00008") via easy-to-read vernier scale.
- Large selection of insert holders:
  — 95° — for use with wiper turning inserts.
  — 90° regular diameter — for efficient machining in large depths of cut.
  — 90° oversized diameter — for enhanced boring head diameter capabilities.
- Generous clearance and through coolant at the cutting edge improve tool life, surface finish, and chip evacuation.

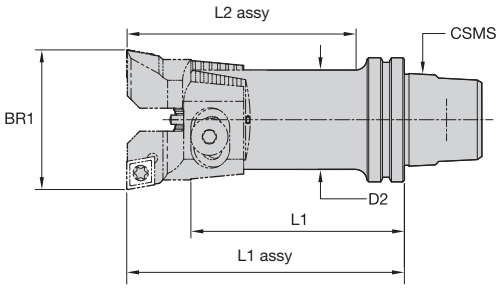
BT • Bridge Tools for Rough and Finish Boring

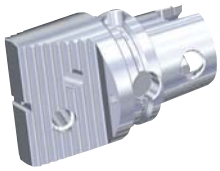


- Diameters 150–2,205mm (5.91–86.81").
- Sophisticated ground serration and T-style bolt clamping provide high cutting forces, and prevent diameter changes when heads are clamped.
- Only 10 bridge consoles are needed for diameters up to 655mm (25.7").
- KM, HSK, and some steep taper adaptors with ground serration available as standard. Through coolant at the cutting edge improves tool life and surface finish.
- Diameters 650–2,205mm (25.5–86.81") covered by three aluminium-based consoles and two sets of steel slides for mounting rough and finish boring heads.
- 90° roughing head sets ensure precise height alignment, and negative standard inserts enable high metal removal rates.
- Counterweight for better balancing and fine-boring head with precision-ground micrometric screw for adjustments of 2 µm (.00008").

- Order blade sets separately; see pages K120–K122.





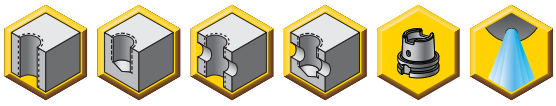


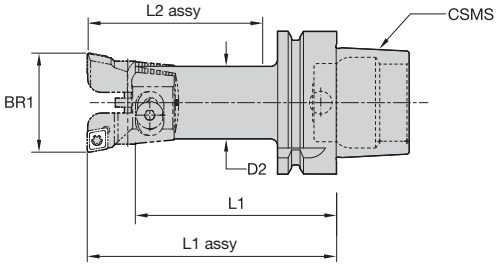
KM™ QUICK CHANGE

RBHT • KM™ Rough-Boring Twin Cutters

order number	catalogue number	BR1 bore range	CSMS system size	D2	L1	L1 assy	L2 assy	blade screw	washer	pin
3586519	KM32RBHT24	23.500-30.500	KM32	20,0	75,4	90,0	76,0	840.142.200	841.142.200	841.342.200
3586520	KM32RBHT30	29.500-40.000	KM32	25,0	83,8	100,0	86,0	840.142.250	841.142.250	841.342.200
3586521	KM40RBHT40	39.500-50.500	KM40	32,0	68,8	90,0	74,0	840.142.320	841.142.320	841.342.200
3586522	KM50RBHT50	49.500-66.500	KM50	42,0	62,2	90,0	70,0	840.142.420	841.142.200	841.342.420
3586543	KM50RBHT66	65.500-87.500	KM50	55,0	63,0	100,0	100,0	840.142.550	841.142.550	841.342.420
3586544	KM50RBHT87	86.500-115.500	KM50	72,0	70,5	120,0	120,0	840.142.720	841.142.720	841.342.420
3586545	KM63UTRBHT87	86.500-115.500	KM63UT	72,0	70,5	120,0	120,0	840.142.720	841.142.720	841.342.420
3586546	KM63UTRBHT115	114.500-153.000	KM63UT	94,0	83,2	150,0	150,0	840.142.940	841.142.940	841.342.420

- Order blade sets separately; see pages K120–K122.





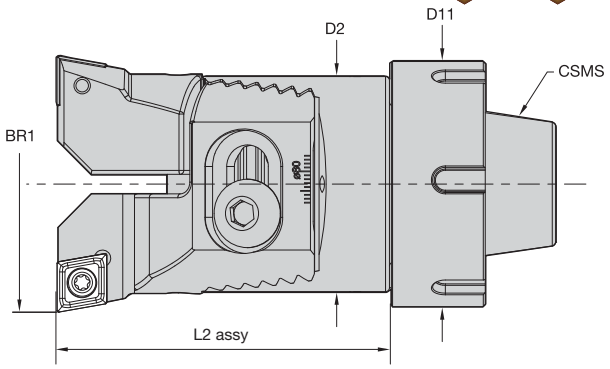


RBHT • HSK Rough-Boring Twin Cutters

order number	catalogue number	BR1 bore range	CSMS system size	D2	L1	L1 assy	L2 assy	blade screw	washer	pin
3586547	HSK63RBHT24	23.500-30.500	HSK63A	20,0	75,4	90,0	64,1	840.142.200	841.142.200	841.342.200
3586548	HSK63RBHT30	29.500-40.000	HSK63A	25,0	88,8	105,0	79,1	840.142.250	841.142.250	841.342.200
3586549	HSK63RBHT40	39.500-50.500	HSK63A	32,0	92,2	110,0	84,1	840.142.320	841.142.320	841.342.200
3586550	HSK63RBHT50	49.500-66.500	HSK63A	42,0	92,2	120,0	94,1	840.142.420	841.142.420	841.342.200
3586551	HSK63RBHT66	65.500-87.500	HSK63A	55,0	95,5	125,0	125,0	840.142.550	841.142.720	841.342.420
3586563	HSK63RBHT87	86.500-115.500	HSK63A	72,0	95,5	145,0	145,0	840.142.720	841.142.720	841.342.420

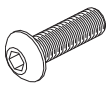
- Order blade sets separately; see pages K120–K122.







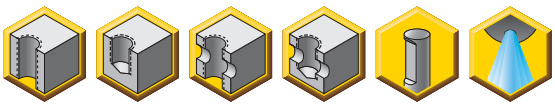
RBHT • ER Rough-Boring Twin Cutters

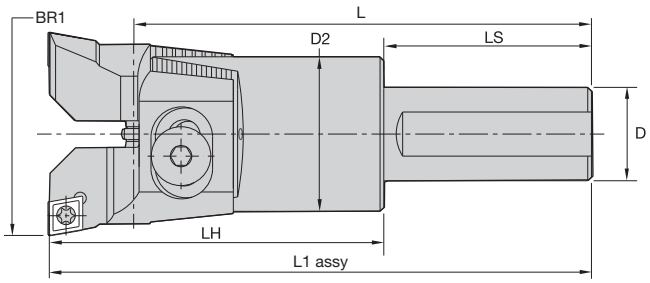




order number	catalogue number	BR1 bore range	CSMS system size	D11	D2	L2 assy	blade screw	washer	pin
5544148	**ER25RBHT40**	39,500-50,500	ER25	39,0	32,0	65,5	**840.142.320**	**841.142.320**	**841.342.200**
5544190	**ER32RBHT50**	49,500-66,500	ER32	49,5	42,0	75,5	**840.142.420**	**841.142.200**	**841.342.420**
5544192	**ER40RBHT66**	65,500-87,500	ER40	62,7	55,0	85,5	**840.142.550**	**841.142.550**	**841.342.420**

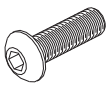
- Order blade sets separately; see pages K120–K122.







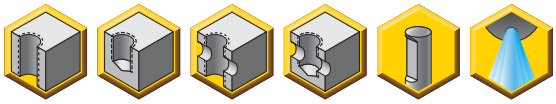
RBHT • Steel Straight Shank Rough Boring Twin Cutters

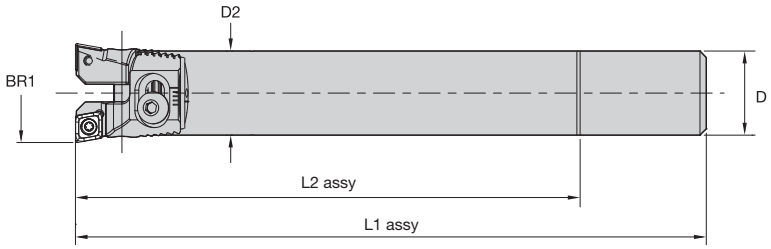


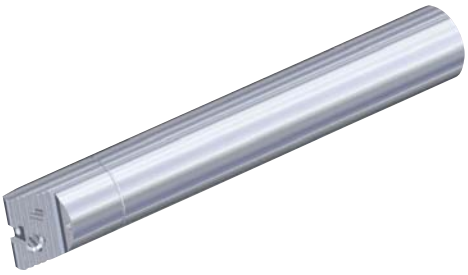


order number	catalogue number	BR1 bore range	D	D2	L	LH	L1 assy	LS	blade screw	washer	pin
3586564	**SF075RBHT24**	23,500-30,500	19,1	20,0	135,4	27,8	150,0	107,6	**840.142.200**	**841.142.200**	**841.342.200**
3586565	**SF100RBHT30**	29,500-40,000	25,4	25,0	153,8	30,6	170,0	123,2	**840.142.250**	**841.142.250**	**841.342.200**
3586566	**SF125RBHT40**	39,500-50,500	31,8	32,0	168,8	31,3	190,0	137,5	**840.142.320**	**841.142.320**	**841.342.200**
3586567	**SF100RBHT50**	49,500-66,500	25,4	42,0	118,1	62,2	145,9	55,9	**840.142.420**	**841.142.420**	**841.342.420**
3586569	**SF125RBHT66**	65,500-87,500	31,8	55,0	123,7	63,0	160,7	60,7	**840.142.550**	**841.142.720**	**841.342.420**
3586570	**SF150RBHT87**	86,500-115,500	38,1	72,0	142,1	70,5	191,6	71,6	**840.142.720**	**841.142.720**	**841.342.420**
3586571	**SF200RBHT115**	114,500-153,000	50,8	94,0	169,1	82,6	235,9	86,5	**840.142.940**	**841.142.940**	**841.342.420**

- Order blade sets separately; see pages K120–K122.

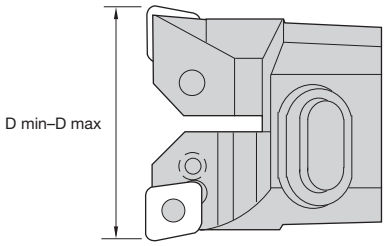


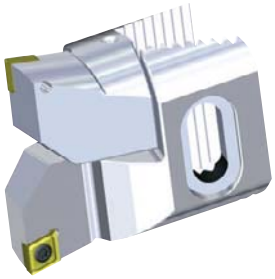




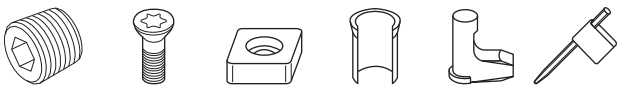
RBHT • Straight Shank Rough-Boring Twin Cutters • Metric

order number	catalogue number	BR1 bore range	D	D2	L1 assy	L2 assy	blade screw	washer	pin
5544143	**SS20RBHT24**	23,500-30,500	20,0	20,0	150,0	120,0	**840.142.200**	**841.142.200**	**841.342.200**
5544145	**SS25RBHT30**	29,500-40,000	25,0	25,0	170,0	140,0	**840.142.250**	**841.142.250**	**841.342.200**

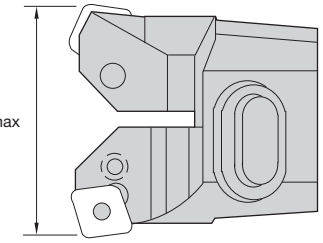


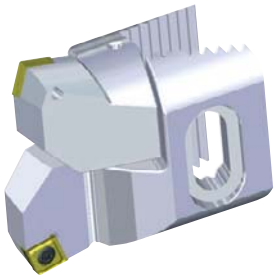


90° Lead Blade Sets



order number	catalogue number	D min	D max	gage insert	adjusting screw	insert screw	shim	shim pin	toggle lever	Torx wrench	Torx size
3556346	**MB24RBHT06F**	23,50	30,50	CC..0602../CC..215..	**848.200.407**	**843.006.000**	–	–	–	**FT7**	T7
3556347	**MB30RBHT06F**	29,50	40,10	CC..0602../CC..215..	**848.250.409**	**843.006.000**	–	–	–	**FT7**	T7
3556348	**MB40RBHT09F**	39,50	50,50	CC..09T3../CC..325..	**848.320.413**	**843.009.000**	–	–	–	**FT15**	T15
3556349	**MB50RBHT09F**	49,50	66,50	CC..09T3../CC..325..	**848.420.614**	**843.009.000**	–	–	–	**FT15**	T15
3556350	**MB66RBHT12F**	65,50	87,50	CC..1204../CC..43..	**848.550.620**	**843.012.000**	–	–	–	**FT20**	T20
3556352	**MB66RBHT12LF**	65,50	87,50	CN..1204../CN..43..	**847.012.000**	–	**845.012.000**	**844.012.000**	**846.012.000**	–	–
3556393	**MB87RBHT12F**	86,50	115,50	CC..1204../CC..43..	**848.720.000**	**843.012.000**	–	–	–	**FT20**	T20
3556394	**MB87RBHT16LF**	86,50	115,50	CN..1606../CN..54..	**847.016.000**	–	**845.016.000**	**844.016.000**	**846.016.000**	–	–
3556395	**MB115RBHT12F**	114,50	153,00	CC..1204../CC..43..	**848.940.640**	**843.012.000**	–	–	–	**FT20**	T20
3556396	**MB115RBHT16LF**	114,50	153,00	CN..1606../CN..54..	**847.016.000**	–	**845.016.000**	**844.016.000**	**846.016.000**	–	–

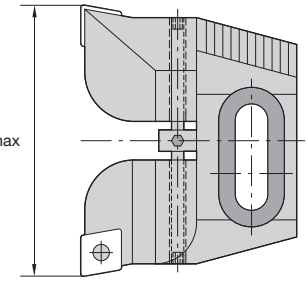


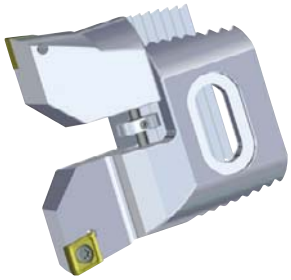


70° Lead Blade Sets



order number	catalogue number	D min	D max	gage insert	adjusting screw	insert screw	shim	shim pin	toggle lever	Torx wrench	Torx size	hex size
3556397	MB24RBHT06K	23,50	30,50	CC..0602../CC..215..	848.200.407	843.006.000	–	–	–	FT7	T7	–
3556398	MB30RBHT06K	29,50	40,10	CC..0602../CC..215..	848.250.409	843.006.000	–	–	–	FT7	T7	–
3556399	MB40RBHT09K	39,50	50,50	CC..09T3../CC..325..	848.320.413	843.009.000	–	–	–	FT15	T15	–
3556400	MB50RBHT09K	49,50	66,50	CC..09T3../CC..325..	848.420.614	843.009.000	–	–	–	FT15	T15	–
3556401	MB66RBHT12K	65,50	87,50	CC..1204../CC..43..	848.550.620	843.012.000	–	–	–	FT20	T20	–
3556402	MB66RBHT12LK	65,50	87,50	CN..1204../CN..43..	847.012.000	–	845.012.000	844.012.000	846.012.000	–	–	3 mm
3556403	MB87RBHT12K	86,50	115,50	CC..1204../CC..43..	848.720.000	843.012.000	–	–	–	FT20	T20	–
3556404	MB87RBHT16LK	86,50	115,50	CN..1606../CN..54..	847.016.000	–	845.016.000	844.016.000	846.016.000	–	–	3 mm
3556405	MB115RBHT16LK	114,50	153,00	CN..1606../CN..54..	847.016.000	–	845.016.000	844.016.000	846.016.000	–	–	3 mm

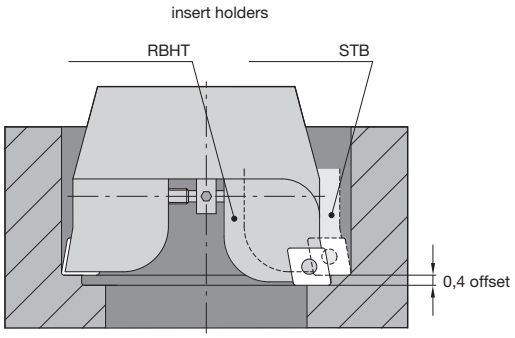


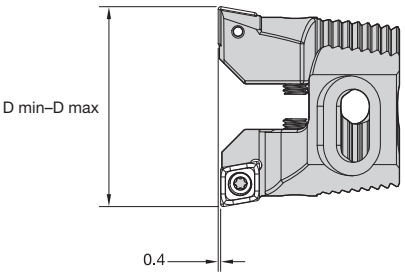


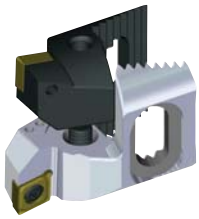
90° Lead Simultaneous Adjusting Blade Sets



order number	catalogue number	D min	D max	gage insert	adjusting screw	insert screw	simultaneous adj spindle	shim	shim pin	toggle lever
2652965	SYB24RBHT06F	23,50	30,50	CC..0602../CC..215..	848.200.407	843.006.000	848.200.005	–	–	–
2652967	SYB30RBHT06F	29,50	40,10	CC..0602../CC..215..	848.250.409	843.006.000	848.250.005	–	–	–
2652968	SYB40RBHT09F	39,50	50,50	CC..09T3../CC..325..	848.320.413	843.009.000	848.320.005	–	–	–
2652969	SYB50RBHT09F	49,50	66,50	CC..09T3../CC..325..	848.420.614	843.009.000	848.420.005	–	–	–
2652970	SYB66RBHT12F	65,50	87,50	CC..1204../CC..43..	–	843.012.000	848.550.005	–	–	–
2652971	SYB66RBHT12LF	65,50	87,50	CN..1204../CN..43..	–	848.550.620	848.550.005	845.012.000	844.012.000	846.012.000
2652972	SYB87RBHT12F	86,50	115,50	CC..1204../CC..43..	–	843.012.000	848.720.005	–	–	–
2652983	SYB87RBHT16LF	86,50	115,50	CNMG543	847.016.000	–	848.720.005	845.016.000	844.016.000	846.016.000
2652984	SYB115RBHT16LF	114,50	153,00	CNMG543	847.016.000	–	848.720.005	845.016.000	844.016.000	846.016.000







90° Lead Split Depth of Cut Blades

order number	catalogue number	D min	D max	gage insert	adjusting screw	insert screw	shim	shim pin	toggle lever
4063996	**SDB24RBHT06F**	23,50	30,50	CC..0602../CC..215..	**848.200.407**	**843.006.000**	**–**	**–**	**–**
4063997	**SDB30RBHT06F**	29,50	40,10	CC..0602../CC..215..	**848.250.409**	**843.006.000**	**–**	**–**	**–**
4063998	**SDB40RBHT09F**	39,50	50,50	CC..09T3../CC..325..	**848.320.413**	**843.009.000**	**–**	**–**	**–**
4063999	**SDB50RBHT09F**	49,50	66,50	CC..09T3../CC..325..	**848.420.614**	**843.009.000**	**–**	**–**	**–**
4064000	**SDB66RBHT12F**	65,50	87,50	CC..1204../CC..43..	**848.550.620**	**843.012.000**	**–**	**–**	**–**
4064001	**SDB66RBHT12LF**	65,50	87,50	CN..1204../CN..43..	**847.012.000**	**–**	**845.012.000**	**844.012.000**	**846.012.000**
4064002	**SDB87RBHT12F**	86,50	115,50	CC..1204../CC..43..	**848.720.000**	**843.012.000**	**–**	**–**	**–**
4064203	**SDB87RBHT16LF**	86,50	115,50	CN..1606../CN..54..	**847.016.000**	**–**	**845.016.000**	**844.016.000**	**846.016.000**
4064204	**SDB115RBHT16LF**	114,50	153,00	CN..1606../CN..54..	**847.016.000**	**–**	**845.016.000**	**844.016.000**	**846.016.000**
4064205	**SDB115RBHT12F**	114,50	153,00	CC..1204../CC..43..	**848.940.640**	**843.012.000**	**–**	**–**	**–**

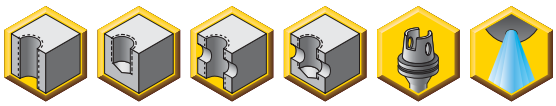
FBHM • Fine-Boring Kits

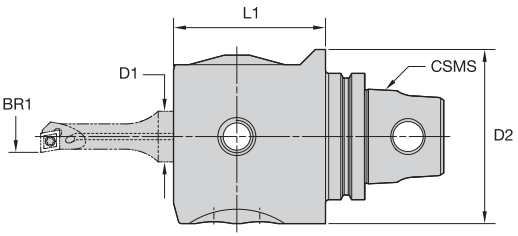
order number	catalogue number	range	contents	
4057101	**KM50TSFBHMKIT164M**	9,75–164,0	KM50TSFBHM1677 AFB09075SCFCR06 AFB13085SCFCR06 AFB17100SCFCR06 AFB21110SCFCR09 AFB24115SCFCR09	AFM29115 AFM47115 EBM8015086 AFM29SCFPR06 AFM47SCFPR09
4057098	**HSK63FBHMKIT164M**	9,75–164,0	HSK63FBHM1696 AFB09075SCFCR06 AFB13085SCFCR06 AFB17100SCFCR06 AFB21110SCFCR09 AFB24115SCFCR09	AFM29115 AFM47115 EBM8015086 AFM29SCFPR06 AFM47SCFPR09
4057099	**DV40FBHMKIT164M**	9,75–164,0	DV40FBHM1691 AFB09075SCFCR06 AFB13085SCFCR06 AFB17100SCFCR06 AFB21110SCFCR09 AFB24115SCFCR09	AFM29115 AFM47115 EBM8015086 AFM29SCFPR06 AFM47SCFPR09
4057100	**BT40FBHMKIT164M**	9,75–164,0	BT40FBHM1691 AFB09075SCFCR06 AFB13085SCFCR06 AFB17100SCFCR06 AFB21110SCFCR09 AFB24115SCFCR09	AFM29115 AFM47115 EBM8015086 AFM29SCFPR06 AFM47SCFPR09
4167882	**CV40FBHMKIT645**	9,75–164,0	CV40FBHM1691 AFB09075SCFCR06 AFB13085SCFCR06 AFB17100SCFCR06 AFB21110SCFCR09 AFB24115SCFCR09	AFM29115 AFM47115 EBM8015086 AFM29SCFPR06 AFM47SCFPR09

NOTE: Counterweight 886038045 is not part of the kits and needs to be ordered separately.



- Order boring bars separately for required diameter; see pages K130–K131.
- 0,01mm diameter adjustment respective 2 µm with vernier scale.





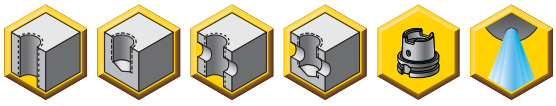


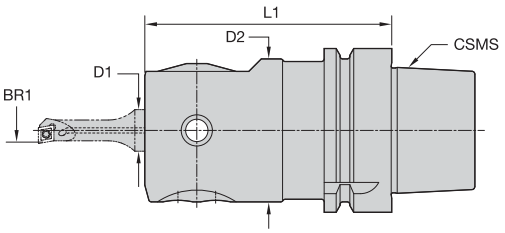
KM™ QUICK CHANGE

FBHO • KM™ Offset Boring Head

order number	catalogue number	BR1 bore range	CSMS system size	D1	D2	L1	ModBORE FBHO parts package
1131111	**KM40FBHO1660**	9.750-53.100	KM40	16	55,0	60,0	**PKG7001**
1132036	**KM50FBHO1670**	9.750-53.100	KM50	16	55,0	70,0	**PKG7001**

- Order boring bars separately for required diameter; see pages K130–K131.
- 0,01mm diameter adjustment respective 2 µm with vernier scale.



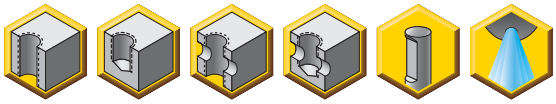


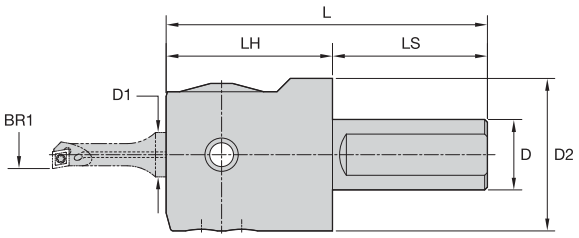


FBHO • HSK Boring Head

order number	catalogue number	BR1 bore range	CSMS system size	D1	D2	L1	ModBORE FBHO parts package
2651037	**HSK63FBHO1695**	9.750-53.100	HSK63A	16	55,0	95,0	**PKG7001**

- Order boring bars separately for required diameter; see pages K130–K131.

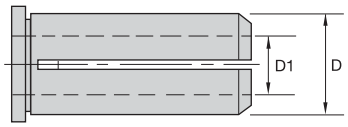






FBHO • Straight Shank Boring Head

order number	catalogue number	BR1 bore range	D	D1	D2	L	LH	LS
3077141	**SF100FBHO1660**	3.000-88.100	25	16	55,0	115,9	60,0	55,9
3077140	**SF150FBHO1660**	3.000-88.100	38	16	55,0	131,6	60,0	71,6

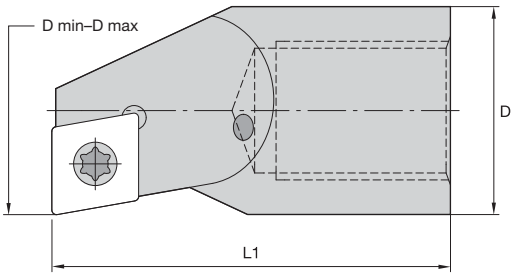




RS Series Sleeves • Metric I.D.

order number	catalogue number	D	D1
2651042	**RS1605**	16	5
1125092	**RS1606**	16	6
1133914	**RS1608**	16	8
1135642	**RS1610**	16	10
1135662	**RS1612**	16	12

- Match boring head diameter to carbide bar diameter.
- Order inserts separately.

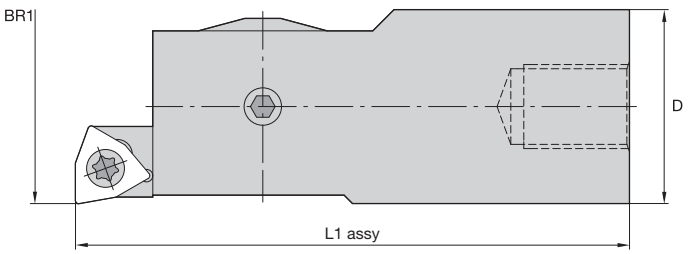




Fixed Pocket Boring Head

order number	catalogue number	D min	D max	D	L1	gage insert	insert screw	Torx size
2651168	**HFB1023SCFPR06**	10,75	16,10	10	23	CC..0602../CC..215..	**PKG0011**	T7
2651169	**HFB1223SCFPR06**	12,75	18,10	12	23	CC..0602../CC..215..	**PKG0011**	T7
2651170	**HFB1627SCFPR06**	16,75	22,10	16	27	CC..0602../CC..215..	**PKG0011**	T7
2651171	**HFB2127SCFPR06**	21,75	27,10	16	27	CC..0602../CC..215..	**PKG0011**	T7
2651172	**HFB2427SCFPR06**	24,75	30,10	16	27	CC..0602../CC..215..	**PKG0011**	T7
2651173	**HFB2727SCFPR06**	27,75	33,10	16	27	CC..0602../CC..215..	**PKG0011**	T7
2651174	**HFB3127SCFPR06**	31,75	37,10	16	27	CC..0602../CC..215..	**PKG0011**	T7
2651175	**HFB3427SCFPR06**	34,75	40,10	16	27	CC..0602../CC..215..	**PKG0011**	T7

- Match boring head diameter to carbide bar diameter.
- Order insert cartridge separately.





Fine Adjustable Screw On Boring Head for Carbide Bars

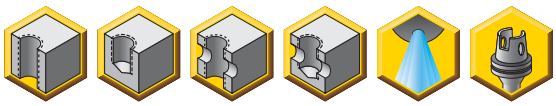
order number	catalogue number	BR1 bore range	L1 assy	D	cartridge mounting screw
2651176	**HFB14FBHS1440**	14.700-17.100	40,0	14	**PKG1402**
2651177	**HFB16FBHS1640**	16.700-20.100	40,0	16	**PKG1602**
2651178	**HFB19FBHS1840**	19.700-24.100	40,0	18	**PKG1802**

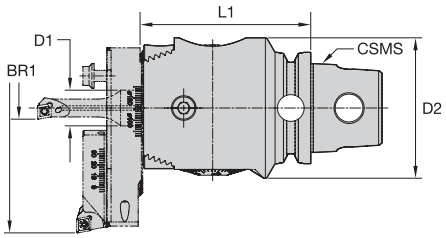
FBHM Fine-Boring Kits

order number	catalogue number	range	contents	
4057101	**KM50TSFBHMKIT164M**	9,75-164,0	KM50TSFBHM1677 AFB09075SCFCR06 AFB13085SCFCR06 AFB17100SCFCR06 AFB21110SCFCR09 AFB24115SCFCR09	AFM29115 AFM47115 EBM8015086 AFM29SCFPR06 AFM47SCFPR09
4057098	**HSK63FBHMKIT164M**	9,75-164,0	HSK63FBHM1696 AFB09075SCFCR06 AFB13085SCFCR06 AFB17100SCFCR06 AFB21110SCFCR09 AFB24115SCFCR09	AFM29115 AFM47115 EBM8015086 AFM29SCFPR06 AFM47SCFPR09
4057099	**DV40FBHMKIT164M**	9,75-164,0	DV40FBHM1691 AFB09075SCFCR06 AFB13085SCFCR06 AFB17100SCFCR06 AFB21110SCFCR09 AFB24115SCFCR09	AFM29115 AFM47115 EBM8015086 AFM29SCFPR06 AFM47SCFPR09
4057100	**BT40FBHMKIT164M**	9,75-164,0	BT40FBHM1691 AFB09075SCFCR06 AFB13085SCFCR06 AFB17100SCFCR06 AFB21110SCFCR09 AFB24115SCFCR09	AFM29115 AFM47115 EBM8015086 AFM29SCFPR06 AFM47SCFPR09
4167882	**CV40FBHMKIT645**	9,75-164,0	CV40FBHM1691 AFB09075SCFCR06 AFB13085SCFCR06 AFB17100SCFCR06 AFB21110SCFCR09 AFB24115SCFCR09	AFM29115 AFM47115 EBM8015086 AFM29SCFPR06 AFM47SCFPR09



- Order boring bars, diameter extension bridge, and cartridges separately.
- 0,01mm diameter adjustment respective 2 µm with vernier scale.



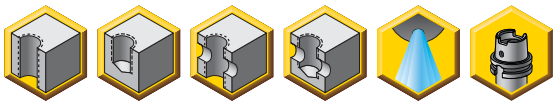


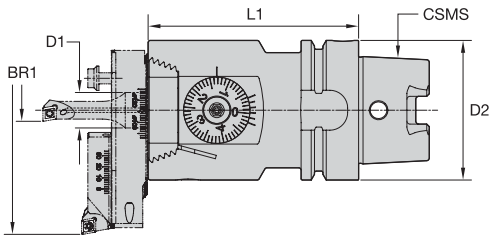


FBHM • KM™ Boring Head

order number	catalogue number	BR1 bore range	CSMS system size	D1	D2	L1	ModBORE FBHS parts package	kg	lbs
4057060	**KM50TSFBHM1677**	9,750-164,000	KM50TS	16,0	63,0	76,6	**PKG-8001**	1,5	3.31

- Order boring bars, diameter extension bridge, and cartridges separately.
- 0,01mm diameter adjustment respective 2 µm with vernier scale.



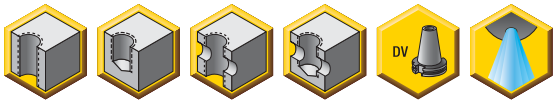


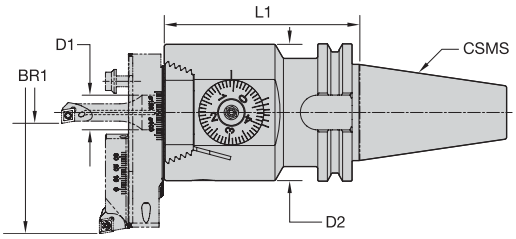


FBHM • HSK Boring Head

order number	catalogue number	BR1 bore range	CSMS system size	D1	D2	L1	ModBORE FBHS parts package	kg	lbs
4057057	**HSK63FBHM1696**	9,750-164,000	HSK63A	16,0	63,0	95,0	**PKG-8001**	2,0	4.30

- Order boring bars, diameter extension bridge, and cartridges separately.
- 0,01mm diameter adjustment respective 2 µm with vernier scale.



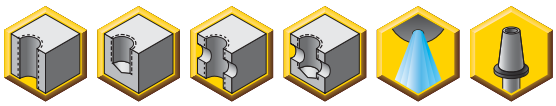


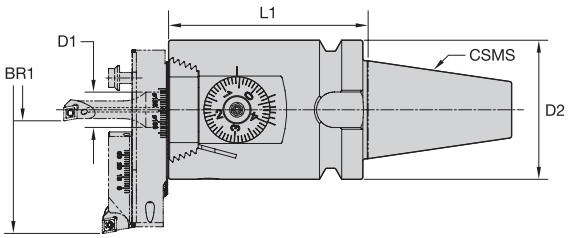


FBHM • DV40 Boring Head

order number	catalogue number	BR1 bore range	CSMS system size	D1	D2	L1	ModBORE FBHS parts package	kg	lbs
4057058	**DV40FBHM1691**	9,750-154,000	DV40	16,0	63,0	90,0	**PKG-8001**	2,1	4.64

- Order boring bars, diameter extension bridge, and cartridges separately.
- 0,01mm diameter adjustment respective 2 µm with vernier scale.



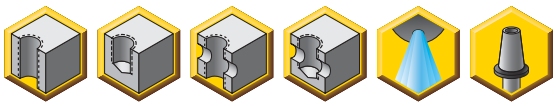


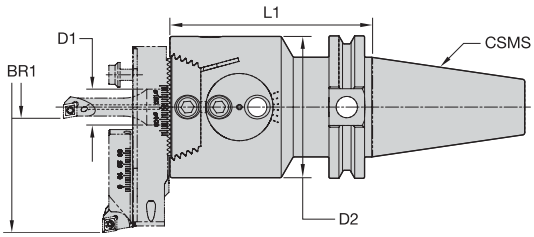


FBHM • BT40 Boring Head

order number	catalogue number	BR1 bore range	CSMS system size	D1	D2	L1	ModBORE FBHS parts package	kg	lbs
4057059	**BT40FBHM1691**	9,750-164,000	BT40	16,0	63,0	90,0	**PKG-8001**	2,2	4.94

- Order boring bars, diameter extension bridge, and cartridges separately.
- 0,01mm diameter adjustment respective 2 µm with vernier scale.



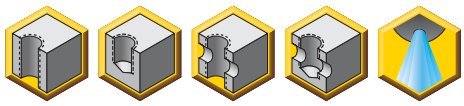


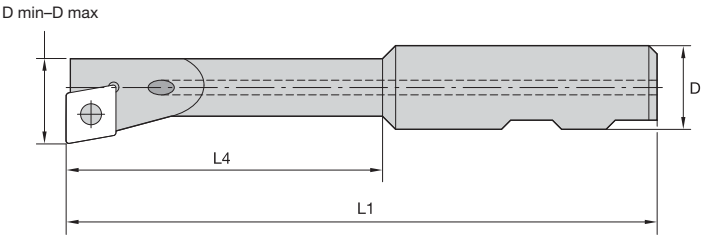


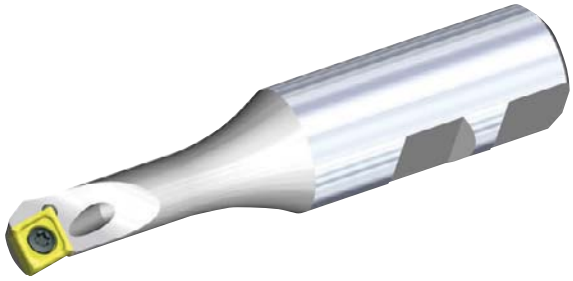
FBHM • CV40 Boring Head

order number	catalogue number	BR1 bore range	CSMS system size	D1	D2	L1	ModBORE FBHS parts package	kg	lbs
4167881	**CV40FBHM1691**	9,750-164,000	CV40	16,0	63,0	91,2	**PKG-8001**	2,1	4.52

- Order inserts separately.



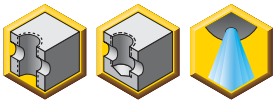


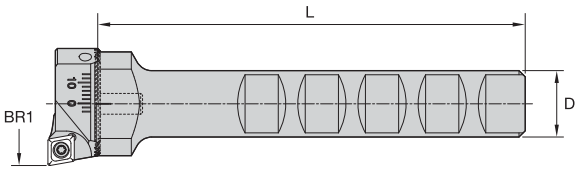


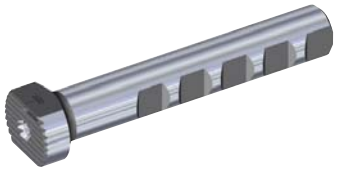
FBHO/FBHM • Universal Boring Bars

order number	catalogue number	D min	D max	D	L1	L4	gage insert	insert screw	Torx size
1125110	**AFB09075SCFCR06**	9,75	14,75	16	75,0	30,0	CC..0602../CC..215..	**PKG2025**	T7
1133883	**AFB13085SCFCR06**	13,75	18,75	16	85,0	40,0	CC..0602../CC..215..	**PKG2025**	T7
1133894	**AFB17100SCFCR06**	17,75	22,75	16	100,0	55,0	CC..0602../CC..215..	**PKG2025**	T7
1137835	**AFB21110SCFCR09**	21,75	26,75	16	110,0	60,0	CC..09T3../CC..325..	**PKG3242**	T15
1128324	**AFB24115SCFCR09**	24,75	29,75	16	115,0	65,0	CC..09T3../CC..325..	**PKG3242**	T15
1126838	**AFB27115SCFCR09**	27,75	32,75	16	115,0	70,0	CC..09T3../CC..325..	**PKG3242**	T15
1120731	**AFB31115SCFCR09**	31,75	36,75	16	115,0	70,0	CC..09T3../CC..325..	**PKG3242**	T15
1127271	**AFB34115SCFCR09**	34,75	39,75	16	115,0	70,0	CC..09T3../CC..325..	**PKG3242**	T15
2651038	**AFB38115SCFPR09**	38,75	44,10	16	115,0	85,0	CC..09T3../CC..325..	**PKG3242**	T15
2651039	**AFB42115SCFPR09**	42,75	48,10	16	115,0	85,0	CC..09T3../CC..325..	**PKG3242**	T15
2651040	**AFB47115SCFPR09**	47,75	53,10	16	115,0	85,0	CC..09T3../CC..325..	**PKG3242**	T15

- Order AFM insert cartridge separately.



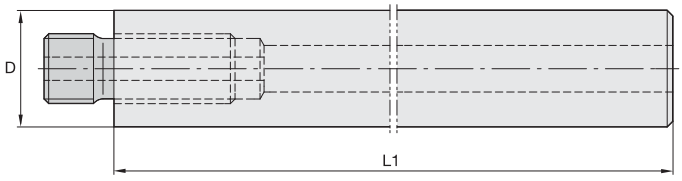




FBHO/FBHM • AFM Boring Bars

order number	catalogue number	BR1 bore range	D	D2	L
4057061	**AFM29115**	29.750-48.100	16,0	25,0	103,000
4057062	**AFM47115**	47.750-88.100	16,0	44,0	101,580



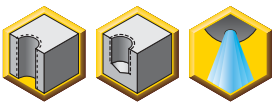


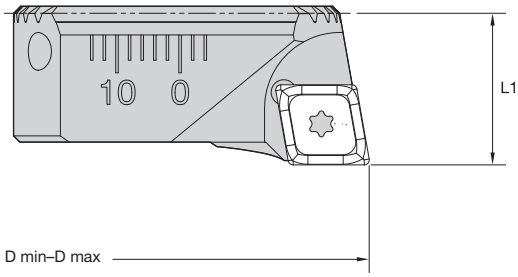


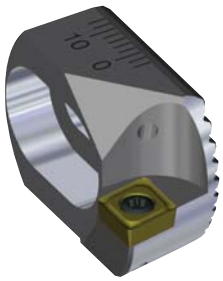
Carbide Shanks for Screw-On Boring Heads

order number	catalogue number	D	L1
2651163	**CFB10082**	10	82
2651164	**CFB12096**	12	96
2651165	**CFB14110**	14	110
2651166	**CFB16120**	16	120
2651167	**CFB18140**	18	140

- For use with AFM boring bars.
- Order inserts separately.



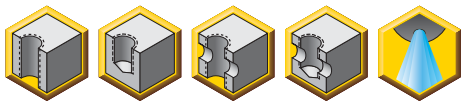


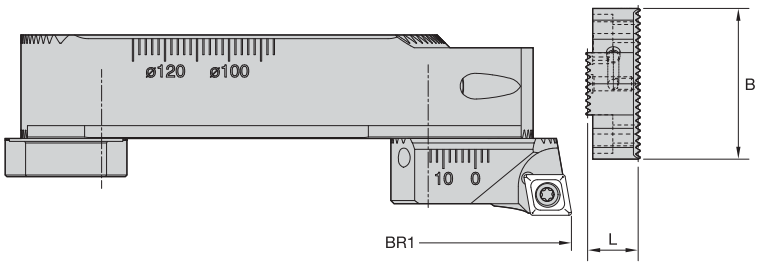


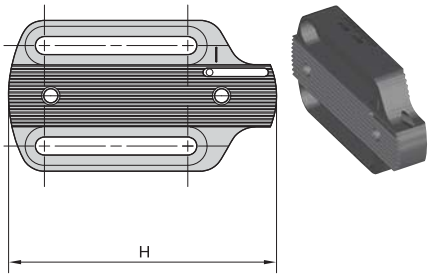
AFM • Insert Cartridges

order number	catalogue number	D min	D max	L1	gage insert	ModBORE parts package	insert screw ID drive size
4057093	**AFM29SCFPR06**	29,75	48,10	12,0	CC..0602../CC..2151..	**PKG2025**	T7
4057094	**AFM47SCFPR09**	47,75	88,10	14,0	CC..09T3../CC..3252..	**PKG3242**	T15

- For use with FBHM insert holders and FBHM counterweight.
- Order AFM47SCFPR09 insert cartridge separately to achieve diameter range.





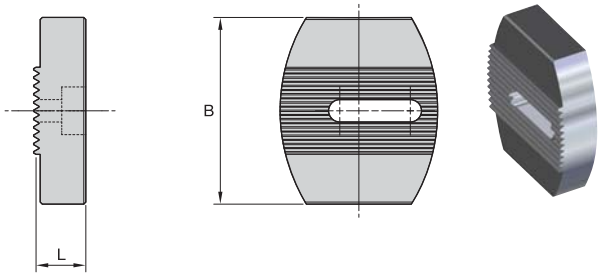


FBHM • Extension Bridge

order number	catalogue number	BR1 bore range	B	H	L
4057095	**EBM8015086**	86.000-164.000	45,0	80,0	15,0
4168063	**EBM1580160162**	162.000-320.000	45,0	158,0	16,2

- For use with FBHM extension bridge.

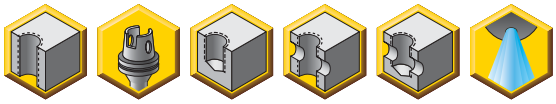


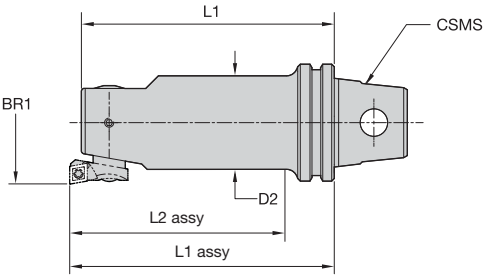


FBHM • Counterweight

order number	catalogue number	B	L
4057096	**886038045**	45	12

- 0,01mm diameter adjustment respective 2 µm with vernier scale.
- Internal coolant directed to indexable insert.
- Order insert cartridges separately for required bore range; see page K136.



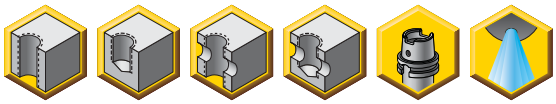


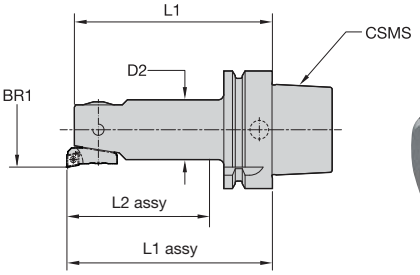


FBHS • KM™ Fine-Boring Single Cutters

order number	catalogue number	BR1 bore range	CSMS system size	D2	L1	L1 assy	L2 assy	cartridge mounting screw	lock screw
3586572	**KM32FBHS24**	23,900-37,100	KM32	20,0	86,0	90,0	76,1	**880.252.200**	**881.252.200**
3586573	**KM32FBHS31**	30,900-47,100	KM32	25,0	96,0	100,0	86,1	**880.252.250**	**881.252.250**
3586574	**KM40FBHS40**	39,900-59,100	KM40	32,0	86,0	90,0	74,0	**880.252.320**	**881.252.320**
3586575	**KM50FBHS51**	50,900-81,100	KM50	42,0	86,0	90,0	70,0	**880.252.420**	**881.252.420**
3586576	**KM50FBHS67**	66,900-105,100	KM50	55,0	96,0	100,0	100,0	**880.252.550**	**881.252.550**
3586577	**KM50FBHS87**	86,900-134,100	KM50	72,0	116,0	120,0	120,0	**880.252.550**	**881.252.720**
3586578	**KM63UTFBHS87**	86,900-134,100	KM63UT	72,0	116,0	120,0	120,0	**880.252.550**	**881.252.720**
3586579	**KM63UTFBHS116**	115,900-191,100	KM63UT	94,0	146,0	150,0	150,0	**880.252.550**	**881.252.940**

- 0,01mm diameter adjustment respective 2 µm with vernier scale.
- Internal coolant directed to indexable insert.
- Order insert cartridges separately for required bore range; see page K136.



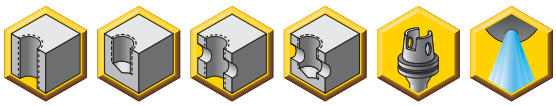


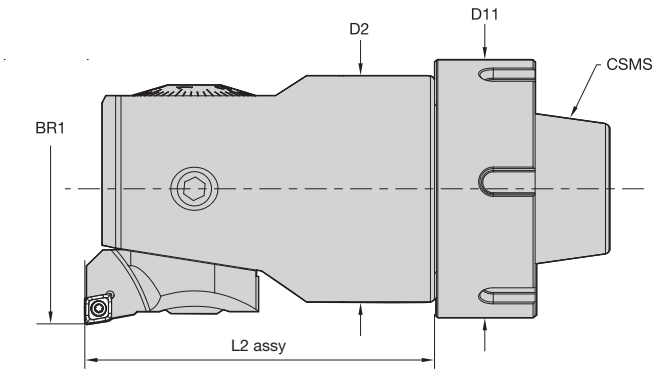


FBHS • HSK Fine-Boring Single Cutters

order number	catalogue number	BR1 bore range	CSMS system size	D2	L1	L1 assy	L2 assy	cartridge mounting screw	lock screw
3586580	**HSK63FBHS24**	23,900-37,100	HSK63A	20,0	86,0	90,0	61,1	**880.252.200**	**881.252.200**
3586581	**HSK63FBHS31**	30,900-47,100	HSK63A	25,0	101,0	105,0	76,1	**880.252.250**	**881.252.250**
3586582	**HSK63FBHS40**	39,900-59,100	HSK63A	32,0	106,0	110,0	81,1	**880.252.320**	**881.252.320**
3586583	**HSK63FBHS51**	50,900-81,100	HSK63A	42,0	116,0	120,0	91,1	**880.252.420**	**881.252.420**
3586584	**HSK63FBHS67**	66,900-105,100	HSK63A	55,0	121,0	125,0	99,1	**880.252.550**	**881.252.550**
3586585	**HSK63FBHS87**	86,900-134,100	HSK63A	72,0	141,0	145,0	145,0	**880.252.550**	**881.252.720**

- 0,01mm diameter adjustment respective 2 µm with vernier scale.
- Internal coolant directed to indexable insert.
- Order insert cartridges separately for required bore range; see page K136.



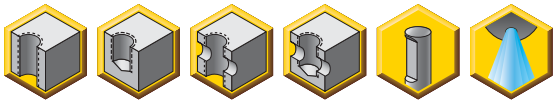


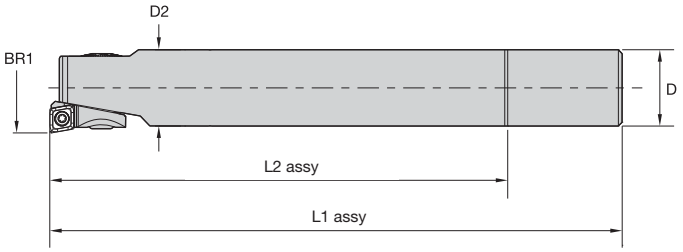


FBHS • ER Fine-Boring Single Cutters

order number	catalogue number	BR1 bore range	CSMS system size	D11	D2	L2 assy	 cartridge mounting screw	 lock screw
5544149	**ER25FBHS40**	39,900-59,100	ER25	39,0	32,0	65,5	**880.252.320**	**881.252.320**
5544191	**ER32FBHS51**	50,900-81,100	ER32	49,5	42,0	75,5	**880.252.420**	**881.252.420**
5544193	**ER40FBHS67**	66,900-105,100	ER40	62,7	55,0	85,5	**880.252.550**	**881.252.550**

- 0,01mm diameter adjustment respective 2 µm with vernier scale.
- Internal coolant directed to indexable insert.
- Order insert cartridges separately for required bore range; see page K136.



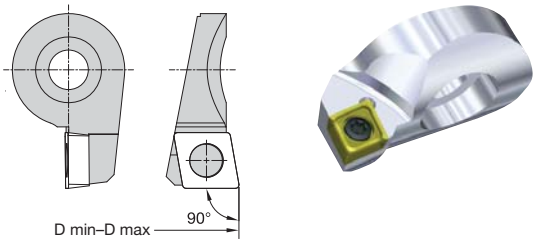




FBHS • Straight Shank Fine-Boring Single Cutters • Metric

order number	catalogue number	BR1 bore range	D	D2	L1 assy	L2 assy	 cartridge mounting screw	 lock screw
5544144	**SS20FBHS24**	23,900-37,100	20,0	20,0	150,0	120,0	**880.252.200**	**881.252.200**
5544146	**SS25FBHS31**	30,900-47,100	25,0	25,0	170,0	140,0	**880.252.250**	**881.252.250**

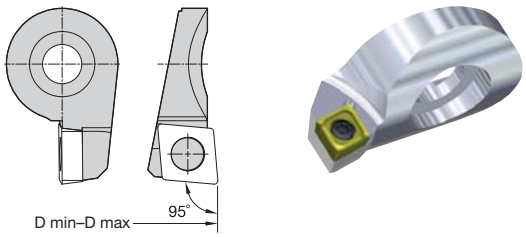
- Order inserts separately.



90° Lead • Insert Holders for FBHS Fine-Boring Heads

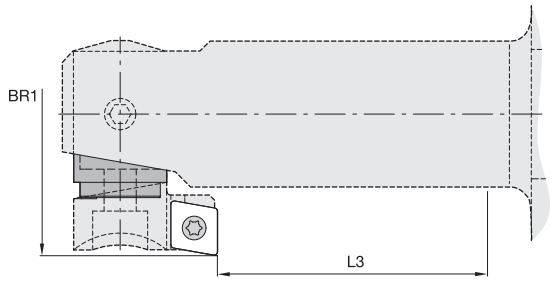
order number	catalogue number	D min	D max	gage insert	Torx size	insert screw
1137487	**R24FBHS06**	23,9	31,1	CC..0602../CC..215..	T7	**843.006.000**
2649548	**R30FBHS06**	29,9	37,1	CC..0602../CC..215..	T7	**843.006.000**
1133669	**R31FBHS06**	30,9	40,1	CC..0602../CC..215..	T7	**843.006.000**
2649549	**R38FBHS06**	37,9	47,1	CC..0602../CC..215..	T7	**843.006.000**
1135369	**R40FBHS06**	39,9	51,1	CC.0602../CC..215..	T7	**843.006.000**
2649550	**R48FBHS06**	47,9	59,1	CC..0602../CC..215..	T7	**843.006.000**
1137479	**R51FBHS06**	50,9	67,1	CC..0602../CC..215..	T7	**843.006.000**
2649551	**R65FBHS06**	64,9	81,1	CC..0602../CC..215..	T7	**843.006.000**
1834274	**R67FBHS06**	66,9	153,1	CC..0602../CC..215..	T7	**843.006.000**
1137505	**R67FBHS09**	66,9	153,1	CC..09T3../CC..325..	T15	**843.009.000**
2649552	**R85FBHS06**	84,9	171,1	CC..0602../CC..215..	T7	**843.006.000**
2649553	**R85FBHS09**	84,9	171,1	CC..09T3../CC..325..	T15	**843.009.000**
2649554	**R125FBHS09**	153,9	191,1	CC..09T3../CC..325..	T15	**843.009.000**

- Order inserts separately.



95° Lead • Insert Holders for FBHS

order number	catalogue number	D min	D max	gage insert	insert screw ID drive size	insert screw
2649555	**R24FBHS06LF**	23,9	31,1	CC..0602../CC..215..	T7	**843.006.000**
2649556	**R31FBHS06LF**	30,9	40,1	CC..0602../CC..215..	T7	**843.006.000**
2649557	**R40FBHS06LF**	39,9	51,1	CC..0602../CC..215..	T7	**843.006.000**
2649558	**R51FBHS06LF**	50,9	67,1	CC..0602../CC..215..	T7	**843.006.000**
2649559	**R67FBHS09LF**	66,9	153,1	CC..09T3../CC..325..	T15	**843.009.000**



Reversal Adaptors

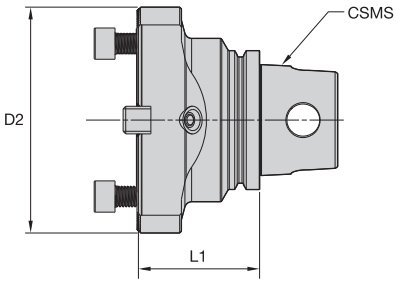
reversal adaptor	use with cartridges				L3	
catalogue number	90° lead	90° lead	95° lead	fine boring head series	mm	inch
R37FBHSRB	**R24FBHS06**	**–**	**R24FBHS06LF**	**..FBHS24**	13,0	0.512
R40FBHSRB	**R30FBHS06**	**–**	**–**	**..FBHS24**	13,0	0.512
R44FBHSRB	**R31FBHS06**	**–**	**R31FBHS06LF**	**..FBHS31**	17,6	0.693
R51FBHSRB	**R38FBHS06**	**–**	**–**	**..FBHS31**	17,6	0.693
R53FBHSRB	**R40FBHS06**	**–**	**R40FBHS06LF**	**..FBHS40**	31,3	1.232
R60FBHSRB	**R48FBHS06**	**–**	**–**	**..FBHS40**	31,3	1.232
R64FBHSRB	**R51FBHS06**	**–**	**R51FBHS06LF**	**..FBHS51**	49,2	1.937
R75FBHSRB	**R65FBHS06**	**–**	**–**	**..FBHS51**	49,2	1.937
R87FBHSRB	**R67FBHS06**	**R67FBHS09**	**R67FBHS09LF**	**..FBHS-67**	62,0	2.441

NOTE: Use the chart above to match the insert holder to the reversal adaptor.

ModBORE™ Bridge Boring Systems

- Extension bridge required.
- Order extension bridge separately; see pages K139–K140.
- Match adaptor and extension bridge series.





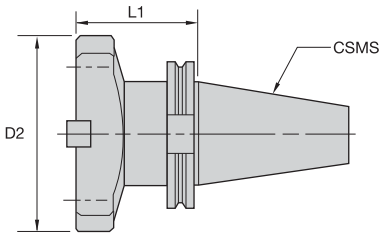


KM™ Bridge Tool Adaptors

order number	catalogue number	CSMS system size	extension bridge series	D2	L1	spare parts package	socket-head cap screw
1135802	**KM63BT13065**	KM63	A	130,0	65,0	**PKG1565**	**MS1085PKG**
1197315	**KM80BT13070**	KM80	B,A	130,0	70,0	**PKG1565**	**MS1085PKG**

- Extension bridge required.
- Order extension bridge separately; see pages K139–K140.
- Order coolant cartridge set separately.
- Match adaptor and extension bridge series.







CV Bridge Tool Adaptors

order number	catalogue number	CSMS system size	extension bridge series	D2	L1	spare parts package	socket-head cap screw
1122185	**CV50BT13069**	CV50	A,B,C	130,0	69,1	**PKG1565**	**MS1085PKG**



BT Bridge Tool Adaptors

order number	catalogue number	CSMS system size	extension bridge series	D2	L1	spare parts package	socket-head cap screw
1121711	**BT50BT13088**	BT50	A,B,C	130,0	88,0	**PKG1565**	**MS1085PKG**

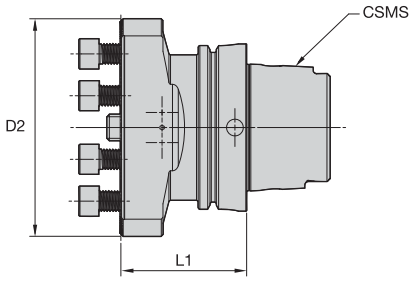


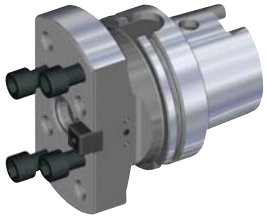
DV Bridge Tool Adaptors

order number	catalogue number	CSMS system size	extension bridge series	D2	L1	spare parts package	socket-head cap screw
1263825	**DV40BT13069**	DV40	A	130,0	69,1	**PKG1565**	**MS1085PKG**
1133581	**DV50BT13069**	DV50	A,B,C	130,0	69,1	**PKG1565**	**MS1085PKG**

- Extension bridge required.
- Order extension bridge separately; see pages K139–K140.
- Match adaptor and extension bridge series.







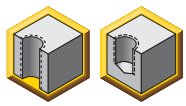
HSK Bridge Tool Adaptors

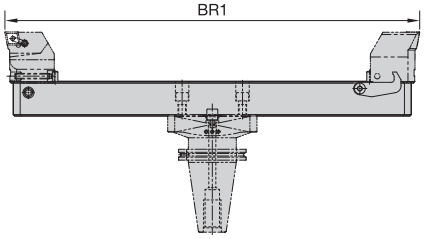


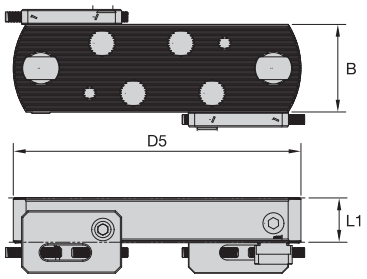
order number	catalogue number	CSMS system size	extension bridge series	D2	L1	spare parts package	socket-head cap screw
4062112	**HSK100BT13075**	HSK100A	A,B,C	130,0	75,0	**PKG1565**	**MS1085PKG**

NOTE: Tool adaptors combined with small-scale extension bridges cover boring range 150–655mm.
Tool adaptors combined with large-scale extension bridge and bridge slides cover boring range from 650–2205mm.

- Match extension bridge series to adaptor.







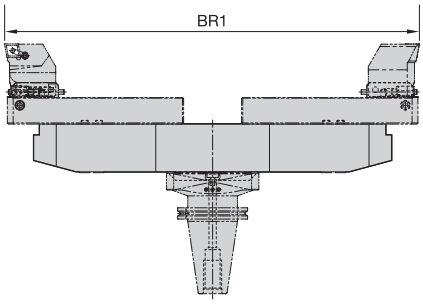


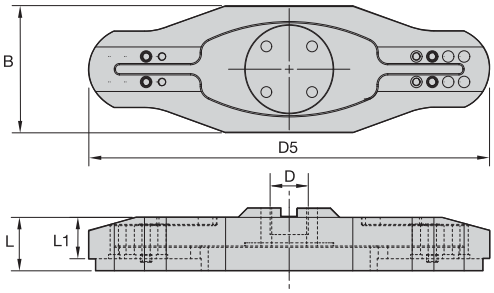
Small-Scale Extension Bridges

order number	catalogue number	BR1 bore range	max RPM	extension bridge series	B	D5	L1	spare parts package	hex size	kg	lbs
1133280	**EB13030150**	150.000-205.000	1250	A	70,0	130,0	30,0	**PKG156502**	8 mm	1,95	4.30
1125085	**EB18030200**	200.000-255.000	1000	A	70,0	180,0	30,0	**PKG156502**	8 mm	2,77	6.10
1132857	**EB23035250**	250.000-305.000	850	B	70,0	230,0	35,0	**PKG156502**	8 mm	4,00	8.80
1126830	**EB28035300**	300.000-355.000	700	B	70,0	280,0	35,0	**PKG156502**	8 mm	5,14	11.30
1121703	**EB33040350**	350.000-405.000	600	B	70,0	330,0	40,0	**PKG156502**	8 mm	6,86	15.10
1140602	**EB38040400**	400.000-455.000	530	C	70,0	380,0	40,0	**PKG156502**	8 mm	7,95	17.50
1121036	**EB43040450**	450.000-505.000	480	C	70,0	430,0	40,0	**PKG156502**	8 mm	9,23	20.30
1270619	**EB48040500**	500.000-550.000	440	C	70,0	480,0	40,0	**PKG156502**	8 mm	10,23	22.50
1270620	**EB53050550**	550.000-605.000	400	C	70,0	530,0	50,0	**PKG156502**	8 mm	13,91	30.60
1270621	**EB58050600**	600.000-655.000	370	C	70,0	580,0	50,0	**PKG156502**	8 mm	15,32	33.70

- For use with shell mill adaptors or direct connection to the machine spindle.
- Order bridge slides separately.









Large Scale Extension Bridge

order number	catalogue number	BR1 bore range	D	D5	B	L	L1	kg	lbs
4057204	**EB630128650**	650.000-1105.000	60,0	630,0	200,0	99,0	84,0	17,20	37.84
4057205	**EB10801281100**	1100.000-1655.000	60,0	1080,0	200,0	99,0	84,0	28,10	61.82
4057206	**EB16301281650**	1650.000-2205.000	60,0	1630,0	200,0	99,0	84,0	43,00	94.60

max RPM

BR1 bore range (mm)	BR1 bore range inch	maximum RPM
650–705	25.59–27.76	300
700–755	27.56–29.72	285
750–805	29.53–31.69	270
800–855	31.50–33.66	255
850–905	33.46–35.63	240
900–955	35.43–37.60	225
950–1005	37.40–39.57	210
1000–1055	39.37–41.54	195
1050–1105	41.34–43.50	180

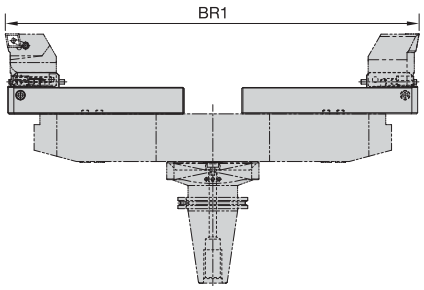
max RPM

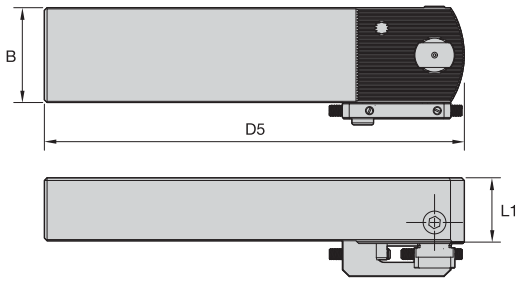
BR1 bore range (mm)	BR1 bore range inch	maximum RPM
1100–1155	43.31–45.47	170
1150–1205	45.28–47.44	163
1200–1255	47.24–49.41	156
1250–1305	49.21–51.38	149
1300–1355	51.18–53.35	142
1350–1405	53.15–55.31	135
1400–1455	55.12–57.28	128
1450–1505	57.09–59.25	121
1500–1555	59.06–61.22	114
1550–1605	61.02–63.19	107
1600–1655	62.99–65.16	100

max RPM

BR1 bore range (mm)	BR1 bore range inch	maximum RPM
1650–1705	64.96–67.13	95
1700–1755	66.93–69.09	90
1750–1805	68.90–71.06	85
1800–1855	70.87–73.03	80
1850–1905	72.83–75.00	75
1900–1955	74.80–76.97	70
1950–2005	76.77–78.94	65
2000–2055	78.74–80.91	60
2050–2105	80.71–82.87	55
2100–2155	82.68–84.84	50
2150–2205	84.65–86.81	45

- For use with large-scale bridge extensions.
- Delivered as a set of two.



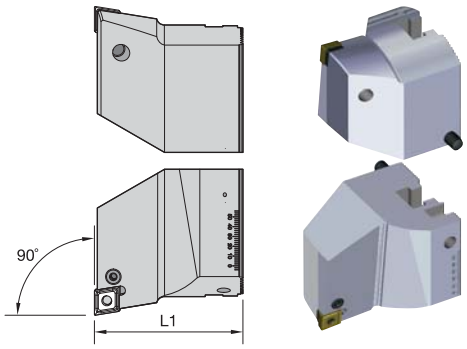




Bridge Slides

order number	catalogue number	BR1 bore range	B	D5	L1	spare parts package	kg	lbs
4057207	**EBSLD1105**	650.000-1105.000	70,0	310,0	48,0	**PKG156502**	7,00	15.40
4057208	**EBSLD2205**	1100.000-2205.000	70,0	360,0	48,0	**PKG156502**	7,90	17.38

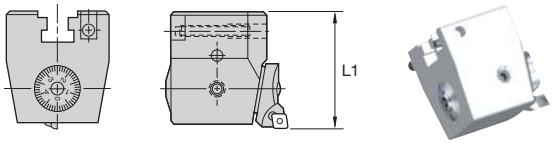
- Packaged as a matched set of two to enable twin cutting operations.



90° Lead • Bridge Tool Rough-Boring Head

order number	catalogue number	L1	gage insert	spare parts package	insert screw ID drive size	kg	lbs
1624878	**EBURF1975PKG**	75,0	CN..1906../CN..64..	**PKG7994**	4 mm	1,64	3.60

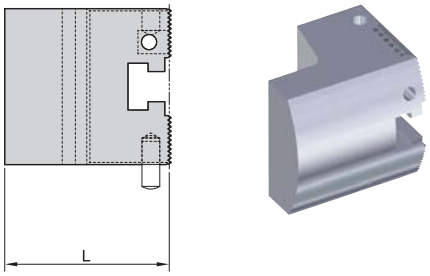
- Insert holder included.
- 0,01mm diameter adjustment respective 2 µm with vernier scale.
- Use with counterweight for balance.



90° Lead • Bridge Tool Fine-Boring Head

order number	catalogue number	L1	cartridge	spare parts package	wrench size-adjusting screw	kg	lbs
1135375	**EBUFF0975**	75,0	R67-FBHS-09	**PKG0002**	5 mm	2,14	4.70

- Use to balance the extension bridge when using an EBUFF fine-boring head.



Bridge Tool Counterweight

order number	catalogue number	L	kg	lbs
4062443	**EBUCW0074**	74,0	2,10	4.63

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Material Group		Condition	Geometry			Cutting Speed — vc m/min			Feed Rate mm/r		
			-MP	-MN	-MF	min	Starting Value	max	-MP	-MN	-MF
P	1		–	KCP05	–	180	**435**	495	–	0,16–0,63	–
			KCP10			180	**395**	360	0,10–0,40	0,16–0,63	0,10–0,40
			–	KC9110		180	**395**	360	–	0,16–0,63	0,10–0,40
			KCP25			125	**275**	360	0,10–0,20	0,16–0,31	0,10–0,20
			–	KC9125		155	**280**	360	–	0,16–0,31	0,10–0,20
	2		–	KCP05	–	180	**265**	400	–	0,16–0,63	–
			KCP10			180	**240**	470	0,10–0,40	0,16–0,63	0,10–0,40
			–	KC9110		180	**250**	340	–	0,16–0,63	0,10–0,40
			KCP25			125	**195**	280	0,10–0,20	0,16–0,31	0,10–0,20
			–	KC9125		140	**200**	295	–	0,16–0,31	0,10–0,20
	3		–	KCP05	–	180	**205**	275	–	0,16–0,63	–
			KCP10			160	**190**	350	0,10–0,40	0,16–0,63	0,10–0,40
			–	KC9110		155	**190**	235	–	0,16–0,63	0,10–0,40
			KCP25			135	**155**	225	0,10–0,20	0,16–0,31	0,10–0,20
			–	KC9125		135	**155**	225	–	0,16–0,31	0,10–0,20
	4		–	KCP05	–	90	**160**	220	–	0,16–0,63	–
			KCP10			90	**145**	235	0,10–0,40	0,16–0,63	0,10–0,40
			–	KC9110		90	**145**	195	–	0,16–0,63	0,10–0,40
			KCP25			75	**105**	180	0,10–0,20	0,16–0,31	0,10–0,20
			–	KC9125		75	**110**	175	–	0,16–0,31	0,10–0,20
	5		–	KCP05	–	150	**240**	315	–	0,16–0,63	–
			KCP10			150	**215**	300	0,10–0,40	0,16–0,63	0,10–0,40
			–	KC9110		150	**215**	300	–	0,16–0,63	0,10–0,40
			KCP25			120	**195**	260	0,10–0,20	0,16–0,31	0,10–0,20
			–	KC9125		120	**195**	260	–	0,16–0,31	0,10–0,20
	6		–	KCP05	–	140	**200**	300	–	0,16–0,63	–
			KCP10			110	**180**	270	0,10–0,40	0,16–0,63	0,10–0,40
			–	KC9110		120	**180**	225	–	0,16–0,63	0,10–0,40
			KCP25			105	**150**	225	0,10–0,20	0,16–0,31	0,10–0,20
			–	KC9125		105	**150**	225	–	0,16–0,31	0,10–0,20

ModBORE • Roughing • Metric

Material Group		Condition	Geometry			Cutting Speed — vc m/min			Feed Rate mm/r		
			-MP	-MF	–	min	Starting Value	max	-MP	-MF	–
M	1		KCM15		–	100	**180**	240	0,10–0,40	0,08–0,30	–
			KC5010	–	–	130	**215**	250	0,10–0,40	–	–
			KC9225		–	175	**185**	250	0,10–0,40	0,08–0,30	–
			KCM25		–	90	**150**	200	0,10–0,20	0,08–0,15	–
			KC9240		–	90	**120**	135	0,10–0,20	0,08–0,15	–
	2		KCM15		–	110	**165**	250	0,10–0,40	0,08–0,30	–
			KC5010	–	–	125	**200**	250	0,10–0,40	–	–
			KC9225		–	110	**170**	230	0,10–0,40	0,08–0,30	–
			KCM25		–	90	**150**	225	0,10–0,20	0,08–0,15	–
			KC9240		–	80	**105**	135	0,10–0,20	0,08–0,15	–
	3		KCM15		–	110	**150**	250	0,10–0,40	0,08–0,30	–
			KC5010	–	–	110	**150**	230	0,10–0,40	–	–
			KC9225		–	110	**150**	230	0,10–0,40	0,08–0,30	–
			KCM25		–	90	**120**	200	0,10–0,20	0,08–0,15	–
			KC9240		–	80	**90**	135	0,10–0,20	0,08–0,15	–

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Material Group		Condition	Geometry			Cutting Speed — vc m/min			Feed Rate mm/r		
			-MP	-MW	–	min	Starting Value	max	-MP	-MW	–
K	1		KCK20		–	220	**300**	540	0,10–0,40	0,16–1,00	–
			–	KT315	–	160	**275**	490	–	0,16–1,00	–
			KCK20		–	220	**275**	350	0,10–0,40	0,16–1,00	–
			–	KC9315	–	150	**275**	350	–	0,16–1,00	–
			KCK20		–	140	**210**	340	0,10–0,20	0,16–0,45	–
			–	KC9325	–	70	**210**	340	–	0,16–0,45	–
	2		KCK20		–	220	**275**	350	0,10–0,40	0,16–1,00	–
			–	KT315	–	180	**275**	360	–	0,16–1,00	–
			KCK20		–	220	**275**	350	0,10–0,40	0,16–1,00	–
			–	KC9315	–	130	**260**	340	–	0,16–1,00	–
			KCK20		–	220	**275**	350	0,10–0,20	0,16–0,45	–
	3		KCK20		–	110	**150**	230	0,10–0,40	0,16–1,00	–
			–	KT315	–	170	**230**	360	–	0,16–1,00	–
			KCK20		–	110	**150**	230	0,10–0,40	0,16–1,00	–
			–	KC9315	–	130	**215**	350	–	0,16–1,00	–
			KCK20		–	110	**150**	230	0,10–0,20	0,16–0,45	–

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Material Group		Condition	Geometry			Cutting Speed — vc m/min			Feed Rate mm/r		
			-HP	–	–	min	Starting Value	max	-HP	–	–
N	1		KC5410	–	–	200	**550**	1000	0,16–0,63	–	–
			–	KD1400	–	450	**765**	2500	–	0,25–0,63	–
			KC5410	–	–	200	**550**	1000	0,16–0,31	–	–
	2		–	KD1425	–	300	**520**	900	–	0,25–0,63	–
			–	KD1425	–	300	**520**	900	–	0,25–0,40	–
	3		KC5410	–	–	100	**275**	500	0,16–0,63	–	–
			K313	–	–	120	**260**	490	0,16–0,63	–	–
			KC5410	–	–	100	**275**	500	0,16–0,31	–	–
	5		KC5410	–	–	100	**200**	350	0,16–0,63	–	–
			KC5410	–	–	100	**200**	350	0,16–0,31	–	–

ModBORE • Roughing • Metric

Material Group		Condition	Geometry			Cutting Speed — vc m/min			Feed Rate mm/r		
			-MP	-FP	-UP	min	Starting Value	max	-MP	-FP	-UP
S	1		KCU10		–	30	**55**	115	0,10-0,40	0,06-0,25	–
			KC5010			30	**55**	115	0,10–0,40	0,06–0,25	0,16–0,50
			KCU25		–	10	**40**	55	0,10-0,20	0,06-0,12	–
			KC9240	–	KC9240	10	**40**	60	0,10–0,20	–	0,16–0,27
	2		KCU10		–	30	**60**	120	0,10-0,40	0,06-0,25	–
			KC5010			30	**60**	115	0,10–0,40	0,06–0,25	0,16–0,50
			KCU25		–	10	**30**	55	0,10-0,20	0,06-0,12	–
			KC9240	–	KC9240	10	**30**	55	0,10–0,20	–	0,16–0,27
	3		KCU10		–	30	**70**	115	0,10-0,40	0,06-0,25	–
			KC5010			30	**70**	115	0,10–0,40	0,06–0,25	0,16–0,50
			KCU25		–	20	**40**	55	0,10-0,20	0,06-0,12	–
			KC9240	–	KC9240	20	**40**	60	0,10–0,20	–	0,16–0,27
	4		KCU10		–	45	**70**	140	0,10-0,40	0,06-0,25	–
			KC5010			45	**70**	170	0,10–0,40	0,06–0,25	0,16–0,50
			KCU25		–	20	**55**	90	0,10-0,20	0,06-0,12	–
			KC9240	–	KC9240	15	**55**	90	0,10–0,20	–	0,16–0,27

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Material Group		Condition	Geometry				Cutting Speed — vc m/min			Feed Rate mm/r			
			-LF	-UF	-FP	-FW	min	Starting Value	max	-LF	-UF	-FP	-FW
P	1		KCP05			–	180	**435**	495	0,06–0,25	0,04–0,16	0,06–0,25	–
			–	–	KTP10	–	180	**435**	495	–	–	0,06–0,25	–
			KT315	–	–	KT315	180	**400**	495	0,06–0,25	–	–	0,08–0,30
			KCP10			–	180	**395**	465	0,06–0,25	0,04–0,16	0,06–0,25	–
			KC9110		–	–	180	**395**	495	0,06–0,25	0,04–0,16	–	–
			KCP25				140	**280**	360	0,06–0,10	0,04–0,08	0,06–0,12	0,08–0,16
			KC9125		–	–	140	**280**	360	0,06–0,10	0,04–0,08	–	–
	2		KCP05			–	180	**265**	400	0,06–0,25	0,04–0,16	0,06–0,25	–
			–	–	KTP10	–	180	**265**	400	–	–	0,06–0,25	–
			KT315	–	–	KT315	190	**270**	390	0,06–0,25	–	–	0,08–0,30
			KCP10			–	180	**240**	330	0,06–0,25	0,04–0,16	0,06–0,25	–
			KC9110		–	–	180	**240**	330	0,06–0,25	0,04–0,16	–	–
			KCP25				145	**195**	320	0,06–0,10	0,04–0,08	0,06–0,12	0,08–0,16
			KC9125		–	–	145	**195**	320	0,06–0,10	0,04–0,08	–	–
	3		KCP05			–	180	**205**	275	0,06–0,25	0,04–0,16	0,06–0,25	–
			–	–	KTP10	–	180	**205**	275	–	–	0,06–0,25	–
			KT315	–	–	KT315	180	**210**	275	0,06–0,25	–	–	0,08–0,30
			KCP10			–	160	**190**	250	0,06–0,25	0,04–0,16	0,06–0,25	–
			KC9110		–	–	155	**190**	240	0,06–0,25	0,04–0,16	–	–
			KCP25				135	**155**	225	0,06–0,10	0,04–0,08	0,06–0,12	0,08–0,16
			KC9125		–	–	135	**155**	225	0,06–0,10	0,04–0,08	–	–
	4		KCP05			–	90	**160**	220	0,06–0,25	0,04–0,16	0,06–0,25	–
			–	–	KTP10	–	90	**160**	220	–	–	0,06–0,25	–
			KT315	–	–	KT315	90	**180**	220	0,06–0,25	–	–	0,08–0,30
			KCP10			–	90	**145**	195	0,06–0,25	0,04–0,16	0,06–0,25	–
			KC9110		–	–	90	**145**	195	0,06–0,25	0,04–0,16	–	–
			KCP25				75	**105**	180	0,06–0,10	0,04–0,08	0,06–0,12	0,08–0,16
			KC9125		–	–	75	**105**	180	0,06–0,10	0,04–0,08	–	–
	5		KCP05			–	150	**240**	315	0,06–0,25	0,04–0,16	0,06–0,25	–
			–	–	KTP10	–	150	**240**	315	–	–	0,06–0,25	–
			KT315	–	–	KT315	150	**250**	315	0,06–0,25	–	–	0,08–0,30
			KCP10			–	150	**215**	300	0,06–0,25	0,04–0,16	0,06–0,25	–
			KC9110		–	–	150	**215**	300	0,06–0,25	0,04–0,16	–	–
			KCP25				120	**195**	255	0,06–0,10	0,04–0,08	0,06–0,12	0,08–0,16
			KC9125		–	–	120	**195**	255	0,06–0,10	0,04–0,08	–	–
	6		KCP05			–	140	**200**	300	0,06–0,25	0,04–0,16	0,06–0,25	–
			–	–	KTP10	–	140	**200**	300	–	–	0,06–0,25	–
			KT315	–	–	KT315	140	**200**	300	0,06–0,25	–	–	0,08–0,30
			KCP10			–	120	**180**	275	0,06–0,25	0,04–0,16	0,06–0,25	–
			KC9110		–	–	120	**180**	225	0,06–0,25	0,04–0,16	–	–
			KCP25				105	**150**	225	0,06–0,10	0,04–0,08	0,06–0,12	0,08–0,16
			KC9125		–	–	105	**150**	225	0,06–0,10	0,04–0,08	–	–

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Material Group		Condition	Geometry				Cutting Speed — vc m/min			Feed Rate mm/r			
			-LF	-UF	-FP	-FW	min	Starting Value	max	-LF	-UF	-FP	-FW
M	1		–	–	KTP10	–	140	**230**	315	–	–	0,06–0,25	–
			KT315	–	–	KT315	140	**230**	315	0,06–0,25	–	–	0,08–0,30
			KC5010	–	–	KC5010	130	**215**	245	0,06–0,25	–	–	0,08–0,30
			KCM15	–	KCM15	–	105	**180**	240	0,06–0,12	–	0,06–0,12	–
			KC9225	–	–	KC9225	105	**180**	240	0,06–0,12	–	–	0,08–0,16
	2		–	–	KTP10	–	140	**215**	295	–	–	0,06–0,25	–
			KT315	–	–	KT315	140	**215**	295	0,06–0,25	–	–	0,08–0,30
			KC5010	–	–	KC5010	130	**200**	245	0,06–0,25	–	–	0,08–0,30
			KCM15	–	KCM15	–	105	**165**	250	0,06–0,12	–	0,06–0,12	–
			KC9225	–	–	KC9225	100	**160**	230	0,06–0,12	–	–	0,08–0,16
	3		–	–	KTP10	–	140	**200**	300	–	–	0,06–0,25	–
			KT315	–	–	KT315	140	**200**	300	0,06–0,25	–	–	0,08–0,30
			KC5010	–	–	KC5010	130	**185**	230	0,06–0,25	–	–	0,08–0,30
			KCM15	–	KCM15	–	115	**150**	255	0,06–0,12	–	0,06–0,12	–
			KC9225	–	–	KC9225	110	**150**	230	0,06–0,12	–	–	0,08–0,16

ModBORE™ • Finishing • Metric

Material Group		Condition	Geometry				Cutting Speed – vc m/min			Feed Rate mm/r			
			-LF	-UF	-FP	-FW	min	Starting Value	max	-LF	-UF	-FP	-FW
K	1		KCK20	–	KCK20		200	**300**	540	0,06–0,25	–	0,06–0,25	0,08–0,30
			KT315	–	–	KT315	165	**275**	490	0,06–0,25	–	–	0,08–0,30
			KC9315	–	–	–	110	**275**	450	0,06–0,25	–	–	–
			KC9320	–	–	–	100	**240**	400	0,06–0,12	–	–	–
	2		KCK20	–	KCK20		150	**240**	420	0,06–0,25	–	0,06–0,25	0,08–0,30
			KT315	–	–	KT315	180	**275**	360	0,06–0,25	–	–	0,08–0,30
			KC5010		–	KC5010	100	**200**	265	0,06–0,25	0,04–0,16	–	0,08–0,30
			KC9315	–	–	–	145	**260**	360	0,06–0,25	–	–	–
			KC9320	–	–	–	140	**240**	330	0,06–0,12	–	–	–
	3		KCK20	–	KCK20		140	**210**	350	0,06–0,25	–	0,06–0,25	0,08–0,30
			KT315	–	–	KT315	180	**230**	320	0,06–0,25	–	–	0,08–0,30
			KC5010		–	KC5010	120	**150**	225	0,06–0,25	0,04–0,16	–	0,08–0,30
			KC9315	–	–	–	145	**215**	275	0,06–0,25	–	–	–
			KC9320	–	–	–	140	**210**	260	0,06–0,12	–	–	–

ModBORE • Finishing • Metric

Material Group		Condition	Geometry				Cutting Speed – vc m/min			Feed Rate mm/r			
			-LF	–	–	–	min	Starting Value	max	-LF	–	–	–
N	1		KC5410	–	–	–	200	**550**	1000	0,10–0,40	–	–	–
			KC5410	–	–	–	200	**550**	1000	0,10–0,20	–	–	–
			–	KD1400	–	–	450	**765**	3000	–	0,06–0,15	–	–
	2		–	KD1425	–	–	375	**580**	1150	–	0,06–0,25	–	–
			–	KD1400	–	–	400	**650**	1250	–	0,06–0,15	–	–
	3		KC5410	–	–	–	125	**275**	525	0,10–0,40	–	–	–
			–	KD1425	–	–	250	**500**	875	–	0,06–0,25	–	–
			KC5410	–	–	–	125	**275**	525	0,10–0,20	–	–	–
			–	KD1400	–	–	375	**520**	1000	–	0,06–0,12	–	–
	5		KC5410	–	–	–	125	**200**	375	0,10–0,40	–	–	–
			KC5410	–	–	–	125	**200**	375	0,10–0,20	–	–	–

ModBORE • Finishing • Metric

Material Group		Condition	Geometry				Cutting Speed – vc m/min			Feed Rate mm/r			
			-LF	-UF	-FP	-FW	min	Starting Value	max	-LF	-UF	-FP	-FW
S	1		–	–	KCU10	–	30	**55**	125	–	–	0,06–0,25	–
			K313	–	–	–	10	**30**	60	0,06–0,25	–	–	–
			KC5010		–	KC5010	30	**55**	120	0,06–0,25	0,04–0,16	–	0,08–0,30
			–	–	KCU10	–	30	**55**	125	–	–	0,06–0,25	–
			KC5010		–	KC5010	30	**55**	120	0,06–0,25	0,04–0,16	–	0,08–0,30
			–	–	KCU25	–	10	**40**	50	–	–	0,06–0,12	–
			KC5025	–	–	–	10	**40**	50	0,06–0,10	–	–	–
	2		–	–	KCU10	–	30	**35**	125	–	–	0,06–0,25	–
			K313	–	–	–	10	**35**	60	0,06–0,25	–	–	–
			KC5010		–	KC5010	30	**60**	120	0,06–0,25	0,04–0,16	–	0,08–0,30
			–	–	KCU10	–	30	**35**	125	–	–	0,06–0,25	–
			KC5010		–	KC5010	30	**60**	120	0,06–0,25	0,04–0,16	–	0,08–0,30
			–	–	KCU25	–	10	**30**	50	–	–	0,06–0,12	–
			KC5025	–	–	–	10	**30**	50	0,06–0,10	–	–	–
	3		–	–	KCU10	–	30	**70**	125	–	–	0,06–0,25	–
			K313	–	–	–	10	**40**	60	0,06–0,25	–	–	–
			KC5010		–	KC5010	30	**70**	120	0,06–0,25	0,04–0,16	–	0,08–0,30
			–	–	KCU10	–	30	**35**	125	–	–	0,06–0,25	–
			KC5010		–	KC5010	30	**70**	120	0,06–0,25	0,04–0,16	–	0,08–0,30
			–	–	KCU25	–	25	**40**	60	–	–	0,06–0,12	–
			KC5025	–	–	–	25	**40**	60	0,06–0,10	–	–	–
	4		–	–	KCU10	–	45	**70**	140	–	–	0,06–0,25	–
			K313	–	–	–	15	**45**	65	0,06–0,25	–	–	–
			KC5010		–	KC5010	45	**70**	140	0,06–0,25	0,04–0,16	–	0,08–0,30
			–	–	KCU10	–	45	**70**	140	–	–	0,06–0,25	–
			KC5010		–	KC5010	45	**70**	140	0,06–0,25	0,04–0,16	–	0,08–0,30
			–	–	KCU25	–	25	**55**	90	–	–	0,06–0,12	–
			KC5025	–	–	–	15	**55**	90	0,06–0,10	–	–	–

PCD Customised Tooling

PCD tooling offers the highest productivity and accuracy, reduced tooling costs due to long tool life, and secure process control due to close tolerances. All of this increases overall quality and reduces scrap rates and inspection costs.

Primary Application

Use Kennametal PCD tooling for machining aluminium and aluminium alloys, magnesium, copper, brass, bronze, plastics (GFRP, CFRP), MMC (Metal Matrix Composite), graphite, tungsten carbide green-stages, and ceramic. Choose from various PCD products for drilling, counterboring, and reaming. Steel- and solid carbide-based tool body designs are available for direct spindle coupling with or without adjustable PCD pocket seats or with steerable SIF™ backend.



Features and Benefits

Higher Productivity and Profitability

- Highest chip removal rates and fewer tool changes using multistep tooling.
- Extremely long tool life while maintaining very tight tolerances.
- Reduced built-up edge and bur formation, improved hole shape with multistep tooling, and better surface finish of the workpiece.

Choose Kennametal as your trusted partner for PCD applications and benefit from our years of experience and global presence.

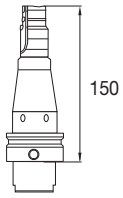


Product Platform Versatility

- All PCD drilling, counterboring, and reaming tools are designed to specific needs for diameter, shape, radii, and steps.
- Various PCD grades are available to match specific material.
- Multistep drilling, profiling, countersinking, and reaming platforms available.
- Coolant channel for optimised chip evacuation in regular and MQL styles.
- Steel-based tool body designs for direct spindle coupling or adjustable pocket seat for highest accuracy even in larger sizes.
- Carbide-based tool bodies enable highest accuracy and tool life in high L/D ratio applications.
- SIF™ steerable interface optimises runout and enables highest accuracy and tool life.
- All PCD tooling prebalanced by design. Further precision balancing available on request.

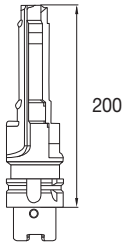
PCD Tooling Basic Design Overview

Kennametal offers you certain PCD design platforms to optimally fulfill your machining task.
These basic designs are independent, whether you are drilling, countersinking, profiling, reaming, or milling.
All tooling designs are capable of internal coolant, MQL coolant, and are balanced by design.

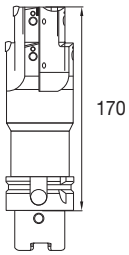


PCD ..ST —
Steel body

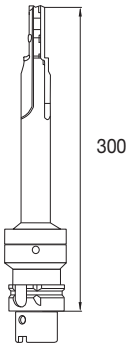
PCD ..SC —
Solid carbide body



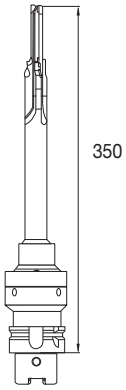
PCD ..STM —
Steel body monoblock



PCD ..STMJ —
Steel body monoblock
Ø adjustable



PCD ..STA —
Steel body with steerable SIF™ backend



PCD ..SCA —
Solid carbide shank and steerable SIF backend

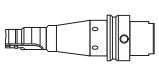
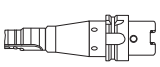
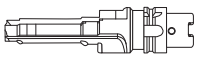
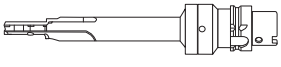
PCDRSC02CCE

PCD	R	SC	02	CC	E
	Technology	Type	Teeth	Point Geometry	Coolant
HF = Helix Flute	**D** = Drilling	**SC** = Solid carbide body	**02**	**RL** = Reaming lead	**E** = Emulsion
SF = Straight Flute	**R** = Reaming	**ST** = Steel body	**03**	**CC** = Centre cut	**M** = MQL
	C = Countersinking	**STM** = Steel monoblock	**04**	**CT** = Drill point	**A** = Air
	E = End milling	**STMJ** = Steel monoblock adjustable	**...**	**CTE** = Drill point	**D** = Dry
	F = Face milling	**STA** = Steel steerable	**12**	**SW** = Drill point	
	P = Profile milling	**SCA** = Carbide steerable	**...**	**MT** = Drill point	
	M = Multioperation tool		**22***		

*Exception for **Type** Reamer **22** = **2** teeth + **2** additional land = **4** guiding lands.

Runout of the Spindle

Depending on spindle runout and/or higher L/D ratios

runout ≤ 0,005mm		runout ≥ 0,006mm	
	**PCD-ST** **PCD-SC**		**PCD-ST or PCD-SC with hydraulic chuck and SIF shank**
	**PCD-STM**		**PCD-STA with SIF** **PCD-SCA with SIF**

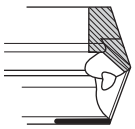
PCD Drill-Point Design Overview

CT
- PCD corner tipped.
- Carbide-based body design.
- Diameter >4,2mm.



Use for general application at moderate cutting speeds up to 12 x D drilling depth.

CTE
- PCD corner tipped, E point.
- Carbide-based body design.
- Diameter >4,2mm.



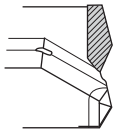
Use at precasted holes at moderate cutting speeds up to 12 x D drilling depth.

SW
- Full-face sandwich PCD.
- Carbide-based body design.
- Diameter >5mm.



Use at high cutting speeds and abrasive materials up to 5 x D drilling depth.

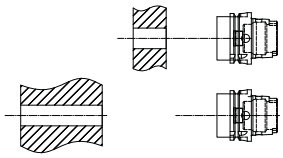
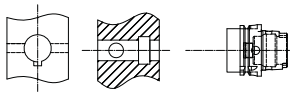
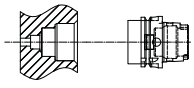
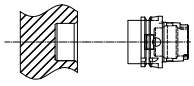
MT
- PCD corner tipped.
- Steel- and carbide-based body design.
- Diameter >12mm.



Use for drilling casted surfaces up to 3 x D drilling depth.

Cutting Edge and Margin Land Requirements

Determine correlations between spindle to edge overhang, amount of cutting, and margin lands for guidance and increased precision.

		number of cutting edges				
						
		2 flutes	2 flutes	3 flutes	4 flutes	6 flutes
application/shape of bore	overhang	2 lands	2 lands	3 lands	4 lands	6 lands
	short	●	●	●	●	●
	long	○	●	◑	●	●
	short	◑	●	◑	●	●
	long	○	●	○	○	○
	short	◑	●	◑	○	○
	long	○	●	◑	○	○
	short	●	●	●	◑	○
	long	○	●	◑	◑	○

● First Choice ◑ Suitable with Limitations ○ Not Recommended

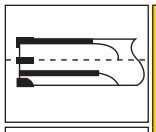
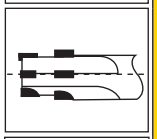
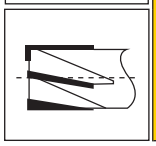
Cutting Grade, Tooling Design

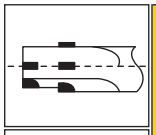
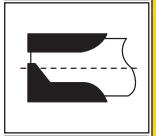
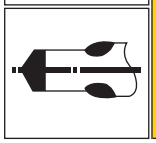
Select cutting data and tooling design based on stability and surface quality demands.

material	coolant	drilling	counterboring	reaming	milling	grade
Al <7%	MQL, emulsion	vc = 350–600 m/min	vc = 650–900 m/min	vc = 400–900 m/min	vc = 1.500–5.000 m/min	KD1415
		fz = 0,004–0,016 IPR	fz = 0,004–0,031 IPR	fz = 0,004–0,016 IPR	fz = 0,004–0,010 IPR	
Al <12%	MQL, emulsion	vc = 200–800 m/min	vc = 650–900 m/min	vc = 400–600 m/min	vc = 1.500–4.000 m/min	KD1415
		fz = 0,004–0,016 IPR	fz = 0,004–0,010 IPR	fz = 0,004–0,010 IPR	fz = 0,004–0,010 IPR	
Al >12%	emulsion	vc = 100–700 m/min	vc = 650–900 m/min	vc = 400–600 m/min	vc = 1.500–3000 m/min	KD1415
		fz = 0,004–0,012 IPR	fz = 0,004–0,010 IPR	fz = 0,004–0,010 IPR	fz = 0,004–0,010 IPR	
mg alloys	emulsion	vc = 350–1.000 m/min	vc = 650–900 m/min	vc = 400–600 m/min	vc = 1.500–6.000 m/min	KD1415
		fz = 0,004–0,016 IPR	fz = 0,004–0,010 IPR	fz = 0,004–0,010 IPR	fz = 0,004–0,010 IPR	
CFRP, GFRP	dry, air	vc = 350–1.800 m/min	vc = 650–900 m/min	vc = 60–200 m/min	vc = 1.500–4.000 m/min	KD1425
		fz = 0,004–0,010 IPR	fz = 0,004–0,010 IPR	fz = 0,004–0,010 IPR	fz = 0,004–0,010 IPR	

Quick-Ship Delivery • Tooling Ranges

Please contact us if this special service is available in your region.

		PCD tool		flutes[1]	chip flute length[2]	cutting diameter	max steps	through coolant	step difference
	non-centre cutting		reamer, corner tipped	2–6	max 5 x D	–	2	axial and radial	max 50%
			countersinker, corner tipped	2–4	max 5 x D	Ø 6–32	3		max 40%
			milling tool, corner tipped	1–6	max 5 x D	–	2		max 50%

		PCD tool		flutes[1]	chip flute length[2]	cutting diameter	max steps	through coolant	step difference
	centre cutting		drilling tool, corner tipped	2	max 20 x D	Ø 5–32	3	axial and radial	max 50%
			countersinker, centre cut	2–4	max 10 x D				
			drilling tool, centre cut	2	max 12 x D	Ø 5–12			

NOTE: 310mm max overall
[1]Depending on the diameter [2]Based on the max diameter

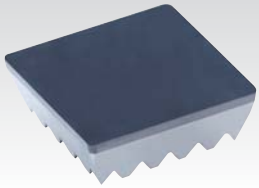
Valve Seat and **Guide Experts**





RMS™-BASED SOLID CARBIDE REAMER

- Best stiffness and accuracy.



CBN-BASED RIQ™ INSERT

- Cross-serration technology for pre-defined guide chamfer angles.
- Same type of insert for all angles.
- 12 effective cutting edges.



OPTIMISED HYDRO CHUCK

- Maximum flexural strength.
- Lowest runout error between seat and guide.



Experience the advantages at your Authorised Kennametal Distributor or at **kennametal.com**.

KENNAMETAL®

kennametal.com

Cylinder Head



RIQ™ QUATTRO CUT™ VALVE SEAT & GUIDE PARENT BORE

CHALLENGE

- Valve seat and guide parent bore machining combined.
- Tolerance range 8 µm.
- Cast iron.
- Machining centre with internal coolant.

SOLUTION

- RIQ padded reamer with integrated hydraulic chuck.
- RIQ Full face CBN KB1630™ insert.
- RMS™ reamer for guide parent bore.

CUTTING DATA

• vc 425 m/min	f 0,10 mm/rev	valve seat.
• vc 130 m/min	f 0,60 mm/rev	valve guide.

RESULT

- **Four usable cutting edges per CBN insert.**
- **CBN RIQ insert with 28,000 bore tool life.**
- **1,400 bores with regrindable RMS reamer.**

BENEFIT

- **Cost savings due to four-edged full face CBN insert.**
- **No insert back taper adjustment needed.**
- **Same RPM at both stages saving time on spindle acceleration and deceleration.**



Cylinder Head







Polished flutes
for improved
chip evacuation

PCD SEAT & GUIDE PARENT BORE PCDRSC04RLE

CHALLENGE

- Valve seat and guide parent bore machining combined.
- Tolerance range H7.
- Aluminium.
- Machining centre with internal coolant.

SOLUTION

- PCD-tipped, steel-based tool (valve seat) with shrink in PCD tip, carbide based reamer (valve guide) with less than 4 µm total runout.

CUTTING DATA

• vc 344 m/min	f 0,60 mm/rev	valve seat.
• vc 985 m/min	f 0,60 mm/rev	valve guide.

RESULT

- **Tool life of 456,000 bores.**

BENEFIT

- **Productivity increases as same RPM applied to both seat and guide stages.**
- **Lowest possible runout resulting in higher tool life.**

Cylinder Head





RIQ serration defines valve seat angle

RIQ™ QUATTRO CUT™ VALVE SEAT & GUIDE MACHINING

CHALLENGE

- Valve guide machining combined with primary and secondary seat angles.
- Sinter metal.
- Concentricity of seat to guide less than 50 µm.
- Machining centre with internal coolant.

SOLUTION

- RIQ valve seat tooling with integrated hydraulic chuck.
- RIQ K68™ carbide inserts and solid carbide RMS™ multi-flute reamer.
- Alternative solution with KST coupling for higher stiffness.
- RIQ CBN inserts for valve seat machining available in KBHK10 and KBHK15.

CUTTING DATA

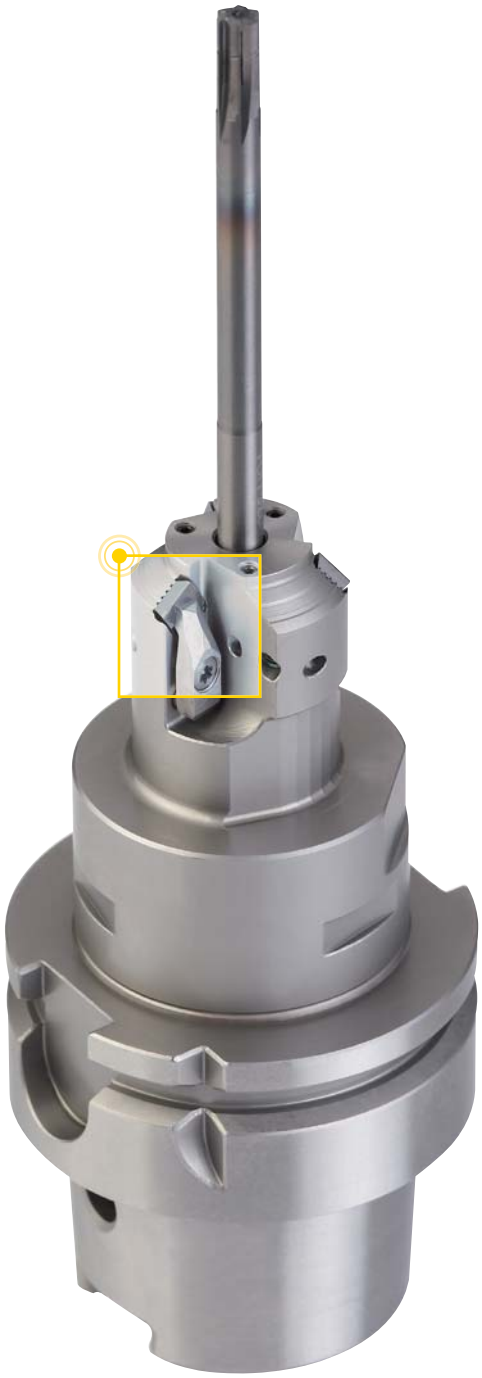
• vc 80 m/min	f 0,10 mm/rev	valve seat.
• vc 80 m/min	f 0,32 mm/rev	valve guide.

RESULT

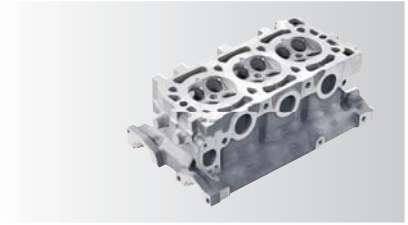
- **Tool life of 12,000 valve seats per insert.**

BENEFIT

- **Twelve usable cutting edges per carbide insert.**
- **Due to high precision RIQ pocket seat there is less setup effort as no angular adjustment of the insert is needed.**
- **Able to adapt RIR™ padded reamer machining the valve guide.**



Cylinder Head







Polished flutes for improved chip evacuation





Chipformer in carbide body

PCD STEP REAMING

CHALLENGE

- Valve lifter bore Ø 12mm.
- Tolerance range 18 µm G7.
- Aluminium AlSi7Mg.
- Machining centre with internal coolant.

SOLUTION

- PCD-tipped, carbide-based reamer and counter sinker with internal coolant.
- Four effective cutting and chamfering teeth.
- KD1415™.

CUTTING DATA

- vc 400 m/min (1.312 SFM).
- f 0,10 mm/rev (.004 IPR).

RESULT

- **Tool life of 125,000 holes.**
- **Surface finish better than Rz 1.5 µm.**

BENEFIT

- **Secure process and very good concentricity.**

PCD STEP REAMING

CHALLENGE

- Injector bore Ø 7,75–19,5mm.
- Tolerance range 5 µm.
- Aluminium G-AlSi7Mg.
- Machining centre with internal coolant.

SOLUTION

- PCD-tipped, carbide based tool with PCD guide pads at Ø 19,5mm and internal coolant.
- Two effective cutting and chamfering teeth.
- KD1415™.

CUTTING DATA

- vc 220 m/min (722 SFM).
- f 0,35 mm/rev (.014 IPR).

RESULT

- **Tool life of 400,000 bores.**
- **Surface finish better than Rz 3 µm.**

BENEFIT

- **Secure process due to chipformer in carbide body improving chip formation.**

Cylinder Head





Self-aligning
padded reamer

RIQ™ QUATTRO CUT™ PADDED REAMING

CHALLENGE

- Oil seal bore finishing Ø 56,4mm.
- Tolerance range 30 µm H7.
- Aluminium.
- Cambore to oil seal bore self alignment.
- Transfer line with internal coolant.

SOLUTION

- RIQ padded reamer with two PCD KD1415™ full-face inserts floating on finish machined cam bore.
- Self-aligning reamer body to ensure cam bore to oil seal bore concentricity.

CUTTING DATA

- vc 326 m/min (1.070 SFM).
- f 0,32 mm/rev (.004 IPR).

RESULT

- **Tool life of 80,000 cylinder heads.**

BENEFIT

- **No insert back taper adjustment needed.**
- **Cost savings due to four-edged full face PCD RIQ insert.**



Cylinder Head







Semi-finish and finish stage combined

RIQ™ QUATTRO CUT™ PADDED REAMING

CHALLENGE

- Cam bore finishing Ø 25mm.
- Tolerance range 21 µm H7.
- Aluminium.
- Deflection less than 20 µm over total length.
- Machining centre with internal coolant.

SOLUTION

- RIQ padded reamer with two PCD KD1415™ full-face inserts for semi-finishing and two PCD KD1415 full-face inserts for finishing.

CUTTING DATA

- vc 334 m/min (1.096 SFM).
- f 0,16 mm/rev (.006 IPR).

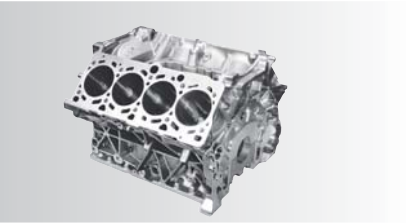
RESULT

- **Tool life of 160,000 cylinder heads.**
- **Surface finish Ra 0.3 µm.**

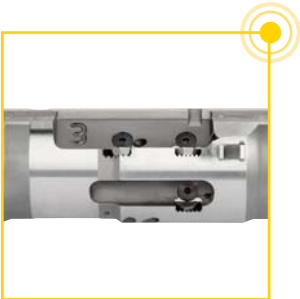
BENEFIT

- **No insert back taper adjustment is needed.**
- **Cost savings due to four-edged full face PCD RIQ insert.**
- **Setup time reduction from 8 hours with competitive tooling to less than 1/2 hour with RIQ.**

Cylinder Block







ASYMMETRICAL LINE BORING BAR

CHALLENGE

- Oil seal bore finishing Ø 56,4mm.
- Tolerance range 30 µm H7.
- Aluminium.
- Cambore to oil seal bore self alignment.
- Transfer line with internal coolant.

SOLUTION

- Patented asymmetrical LBB, which supports the before finished last journal of the crank bore.
- RI8 inserts with 8 cutting edges per inserts in PCD or carbide.
- Hybrid body made of heavy-metal and steel.

CUTTING DATA

- vc 326 m/min (1.070 SFM).
- f 0,32 mm/rev (.004 IPR).

RESULT

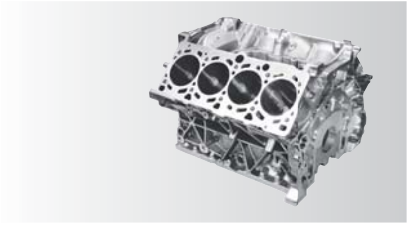
- **Roundness measured: 0.005mm.**
- **Concentricity measured: 0.005mm.**

BENEFIT

- **All advantages of a line boring bar, but applicable on MC.**
- **No disadvantage of typical line boring bars.**
- **Setup possible outside the machine on standard optical presetter.**



Cylinder Block







CLB screw for automatic wear compensation

MOTION TOOLING

CHALLENGE

- Cylinder bore Ø 75mm.
- Cast iron GG25.
- Semi-finish and finish operation combined in one tool with coolant pressure activated finish stage.
- Machining centre with internal coolant.

SOLUTION

- Motion tool with feed-out cartridges.
- Two-channel coolant system with coolant supply for inserts and feed-out cartridges.
- Solid CBN inserts with eight cutting edges; KB1340™.

CUTTING DATA

• vc 600 m/min	f 0,05 mm/rev	semi-finish.
• vc 600 m/min	f 0,11 mm/rev	finish.

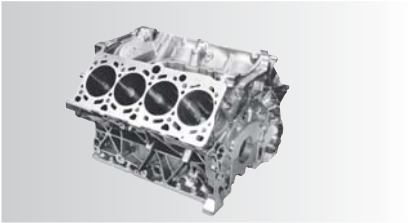
RESULT

- **Tool life of 2,000 bores per tooling setup.**
- **Cylindricity better than 8 µm.**

BENEFIT

- **Higher productivity as roughing at forward and finishing at backward movement — with coolant feed-out.**
- **Finish diameter adjustable with CLB process.**
- **Improved cylindricity in more than two separate operations.**

Cylinder Block





Bayonet quick-change system

ROMICRON™ FINE BORING

CHALLENGE

- Cylinder bore Ø 78,933mm.
- Cast iron GG25.
- Reduce setup and adjustment effort with roughing and finishing at various cylinder blocks.
- Engineered solutions vertical mill with internal coolant.

SOLUTION

- Romicron engineered solutions tool with quick-change interface and drawbar actuated finish cartridge.
- SNGN090308T00520 KY1615 roughing insert.
- CPMT09T308LF KT315™ finishing insert.

CUTTING DATA

• vc 580 m/min	f 0,26 mm/rev	roughing.
• vc 580 m/min	f 0,19 mm/rev	finishing.

RESULT

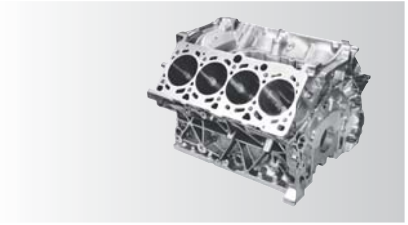
- **Tool life of 100 components per setup.**
- **Cylindricity 13 µm.**
- **Surface finish Ra 1.5 µm.**

BENEFIT

- **Bore tolerance easily and consistently achieved due to 1 µm per click in radius adjustment.**
- **Weight reduction from 11 kg to 1.8 kg.**
- **Setup time reduction from 1.5 hours to 15 minutes.**
- **Secure process resulting in higher cpk value.**



Cylinder Block







Semi-finish and finish stage combined

FINE BORING

CHALLENGE

- Crank bore finishing Ø 37mm.
- Tolerance range 5 µm.
- Cast iron.
- Maintain tolerance for minimum of 50 bores.
- Machining centre with internal coolant.

SOLUTION

- Line boring bar with tool bits adjusted by differential screw for more sensitivity.
- Dynamically balanced by design with axial holes ensuring highest stiffness of tool.

CUTTING DATA

• vc 160 m/min	f 0,12 mm/rev	semi-finish.
• vc 160 m/min	f 0,08 mm/rev	finish.

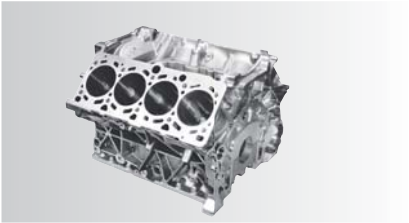
RESULT

- **Customer proprietary information.**

BENEFIT

- **Use of standard C-style inserts in LF reduce tooling costs in KCK15.**
- **Reduction of cycle time.**
- **Easy and fine adjustments ensure a stable process.**

Cylinder Block





RIQ chamfering, plunging, and reaming insert

RIQ™ QUATTRO CUT™ PADDED REAMING

CHALLENGE

- Balancing shaft bore Ø 31–39mm.
- Cast iron.
- Reaming of three diameters, machining of three chamfers, and one facing operation in one tool.
- Minimum quantity lubrication MQL.

SOLUTION

- RIQ padded reamer with one effective cutting edge combining chamfering, countersinking, and reaming stage in one tool, using two reaming RIQ and one special RIQ insert.

CUTTING DATA

- vc 100 m/min (328 SFM).
- f 0,14 mm/rev (.006 IPR).

RESULT

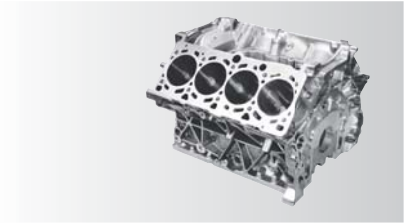
- **Tool life of 8,000 bores per insert.**
- **Surface finish Rz 10 µm.**

BENEFIT

- **No insert back taper adjustment needed.**
- **Highest angular precision without any adjustment with RIQ at chamfering stage.**



Cylinder Block





RHM™ MODULAR REAMING

CHALLENGE

- Position bore Ø 20mm.
- Tolerance range 21 µm N7.
- Cast iron GG26Cr.
- Replace padded double-edged reamer.
- Machining centre with internal coolant.

SOLUTION

- Special RHM head with six cutting edges.
- Engineered solution KC6105 TiN coated carbide grade.

CUTTING DATA

- vc 63 m/min (207 SFM).
- f 0,84 mm/rev (.033 IPR).

RESULT

- **Tool life of 336m.**

BENEFIT

- **8x higher productivity due to higher feed rate.**
- **Tool life increased by 240% when compared to previous solution.**

Conrod





ROMICRON™ FINE BORING

CHALLENGE

- Pin bore Ø 58,033mm.
- Brass.
- Combine finishing of crank and pin bore into one tool to increase productivity.
- Machining centre with internal coolant.

SOLUTION

- Romicron engineered-solution tool with two Romicron mechanisms in one tool body.
- KC5010™.

CUTTING DATA

- vc 450 m/min (1.476 SFM).
- f 0,10 mm/rev (.004 IPR).

RESULT

- **Tool life of 350 pin bores per insert.**
- **Surface finish better than Ra 1.0 µm.**
- **Cylindricity 5 µm.**

BENEFIT

- **Combination tool increases productivity.**
- **Bore tolerance range of 26 µm easily and consistently achieved due to 1 µm per click in radius adjustment.**

ROMICRON FINE BORING

CHALLENGE

- Crank bore Ø 93,777mm.
- Steel C70.
- Combine finishing of crank and pin bore into one tool to increase productivity.
- Machining centre with internal coolant.

SOLUTION

- Romicron engineered solution tool with two Romicron mechanisms in one tool body.
- KT315™.

CUTTING DATA

- vc 400 m/min (1.312 SFM).
- f 0,10 mm/rev (.004 IPR).

RESULT

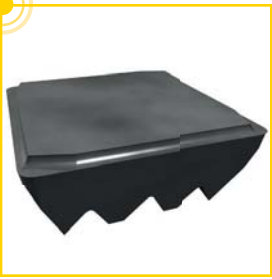
- **Tool life of 260 crank bores per insert.**
- **Surface finish better than Ra 1.0 µm.**
- **Cylindricity 5 µm.**

BENEFIT

- **Combination tool increases productivity.**
- **Bore tolerance range of 26 µm easily and consistently achieved due to 1 µm per click in radius adjustment.**

Conrod





RIQ cermet insert with chipformer geometry

RIQ™ QUATTRO CUT™ PADDED REAMING



CHALLENGE

- Pin bore Ø 19mm.
- Tolerance range 33 µm H8.
- Steel C70.
- Entry/exit inclined and chip control improvement.
- Transfer line with MQL internal coolant.

SOLUTION

- RIQ padded reamer with two axial staggered RIQ inserts in microfinishing setup.
- Coated cermet RIQ inserts with four edges and special chip former.

CUTTING DATA

- vc 200 m/min (328 SFM).
- f 0,20 mm/rev (.006 IPR).

RESULT

- **Tool life of more than 5,000 components per insert.**
- **Surface finish Rz 12–14 µm.**
- **Cylindricity 5 µm.**

BENEFIT

- **No insert back taper adjustment needed.**
- **High productivity increase due to higher feed rate when compared to previous fine boring tools.**
- **Very short chips improve chip evacuation.**
- **Secure process as surface requirement of Rz 8 µm to Rz 16 µm are achieved.**

Conrod



ROMICRON™ FINE BORING

CHALLENGE

- Pin bore Ø 16,77mm.
- Crank bore Ø 20,77mm.
- Steel C70.
- Combines roughing, semi-finishing, and finishing operation into one tool.

SOLUTION

- Romicron standard head HSK63ASVUBB2116M with engineered-solution boring bar.
- CPMT060204LF KC5010™.

CUTTING DATA

• vc 120 m/min	f 0,10 mm/rev	roughing.
• vc 120 m/min	f 0,05 mm/rev	finishing.

RESULT

- **Tool life of 2,500 components per insert edge.**
- **Surface finish Ra 0.5 µm.**
- **Cylindricity 3 µm.**

BENEFIT

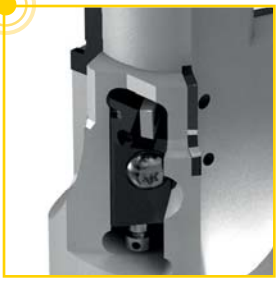
- **Productivity increase due to combination tool.**
- **Bore tolerance range of 20 µm easily and consistently achieved due to 1 µm per click in radius adjustment.**



Steering Column







Adjustable cartridge
with PCD insert

PCD COUNTERSINKING

CHALLENGE

- Bore Ø 26,2; 37,6; and 44mm.
- Tolerance range 21 µm N7.
- Aluminium G-AlSi9Cu3.
- Varying depth of cut ca. 1,5mm.
- Machining centre with internal coolant.

SOLUTION

- PCD-tipped, steel-based tool with internal coolant.
- Three effective cutting teeth; KD1415™.
- Standard cartridge SCFCR08CA06 achieves required surface finish range.

CUTTING DATA

- vc 1,640 SFM (500 m/min).
- f .012 IPR (0,30 mm/rev).

RESULT

- **Surface finish Ra 1.6–2.3 µm.**

BENEFIT

- **Secure process.**

Steering Column



PCD COUNTERSINKING

CHALLENGE

- Bore Ø 17,07; 39,1; and 50,9mm.
- Tolerance range 21 µm N7.
- Aluminium G-AlSi10Mg.
- Varying depth of cut ca. 2,5mm.
- Machining centre with internal coolant.

SOLUTION

- PCD-tipped, steel-based tool with SIF™ steerable interface and internal coolant.
- Three effective cutting and chamfering teeth.
- KD1415™.

CUTTING DATA

- vc 600 m/min (1,969 SFM).
- f 0,30 mm/rev (.012 IPR).

RESULT

- **Tool life of 2,000 metres.**

BENEFIT

- **Productivity increased due to higher cutting data.**



Gear Housing





PCD STEP REAMING

CHALLENGE

- Bearing bore Ø 13,5 and 18mm.
- Tolerance range 18 µm H7.
- Aluminium G-AlSi10Mg.
- Varying depth of cut ca. 0,5mm.
- Machining centre with internal coolant.

SOLUTION

- PCD-tipped, carbide-based tool with SIF™ steerable interface with internal coolant.
- Four effective cutting teeth.
- KD1415™.

CUTTING DATA

- vc 230 m/min (755 SFM).
- f 0,25 mm/rev (.010 IPR).

RESULT

- **Surface finish Ra 0.2 µm.**

BENEFIT

- **Secure process.**

Gear Housing





Adjustable PCD pocket seat

PCD COUNTERSINKING

CHALLENGE

- Bearing bore Ø 40, 62, 85mm.
- Tolerance range 25 µm S7.
- Aluminium AlSi9Cu3.
- Machine three different diameters with one tool.
- Machining centre with internal coolant.

SOLUTION

- PCD-tipped, steel-based tool with adjustable pocket seats, SIF™ steerable interface, and internal coolant.
- Four effective cutting and chamfering teeth; KD1415™.

CUTTING DATA

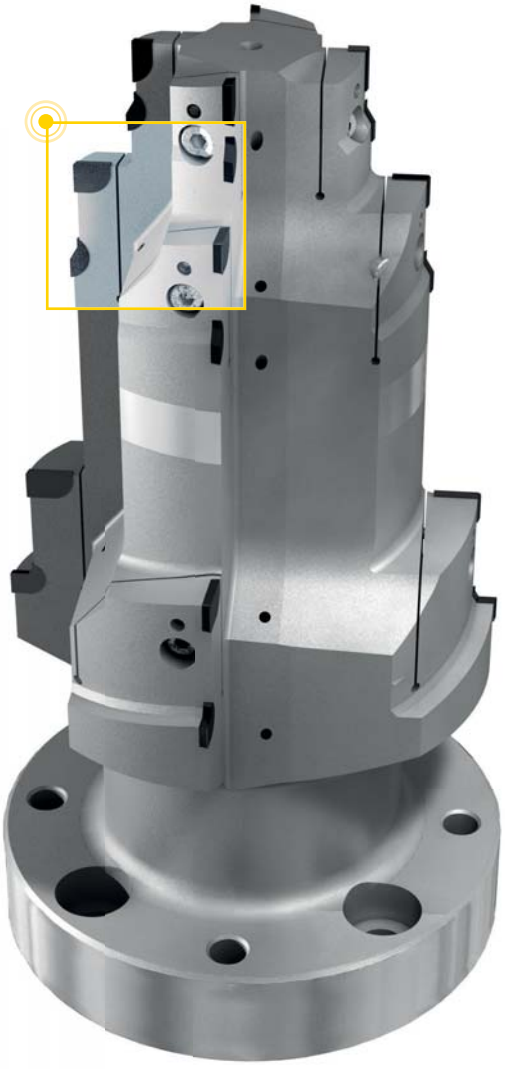
- vc 630–1,340 m/min n = 5,010 RPM.
- f 0,32 mm/rev (.013 IPR).

RESULT

- **Tool life of 500 workpieces.**

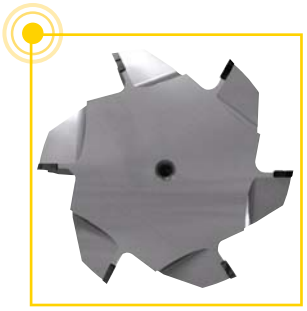
BENEFIT

- **Secure process with only 1.2 seconds cutting time per operation.**
- **Higher productivity due to combining three operations into one tool.**
- **Very stable process without chip control issues.**



Gear Housing





Highly uneven spacing

PCD STEP REAMING

CHALLENGE

- Bearing bore Ø 130mm.
- Tolerance range 25 µm S6.
- Aluminium AlSi8Cu3.
- Varying depth of cut ca. 0,5–5mm.
- Machining centre with internal coolant.



SOLUTION

- PCD-tipped, steel-based tool with HSK interface and internal coolant.
- Six effective cutting and chamfering teeth in positive cutting position; KD1415™.

CUTTING DATA

- vc 350 m/min (1,148 SFM).
- f 0,60 mm/rev (.024 IPR).

RESULT

- **Tool life increase versus previous solution.**
- **Surface finish Ra 0.2 µm.**

BENEFIT

- **Secure process.**

Gear Housing



PCD REAMING

CHALLENGE

- Bearing bore Ø 35mm.
- Tolerance range 21 µm H7.
- Aluminium G-AlSi10Mg.
- Pre-drilled hole with 0,5mm depth of cut.
- Machining centre HSK63A with internal coolant.

SOLUTION

- PCD-tipped, steel-based tool with SIF™ steerable interface and internal coolant.
- Three effective cutting and chamfering teeth.
- KD1415™.

CUTTING DATA

- vc 235 m/min (771 SFM).
- f 0,30 mm/rev (.012 IPR).

RESULT

- **Tool life of 100,000 holes.**
- **Surface finish Ra 0.2 µm.**

BENEFIT

- **Secure process despite high L/D ratio.**
- **Very good surface quality.**



Gear Housing





PCD REAMING

CHALLENGE

- Index bore Ø 11,5mm.
- Tolerance range 18 µm H7.
- Aluminium G-AlSi10Mg.
- Varying depth of cut ca. 3mm.
- Machining centre HSK63A with internal coolant.

SOLUTION

- PCD-tipped, carbide based tool with shrink in HSK63A adaptor with internal coolant.
- Two effective cutting and chamfering teeth.
- KD1415™.

CUTTING DATA

- vc 1,005 m/min (3,297 SFM).
- f 0,16 mm/rev (.024 IPR).

RESULT

- **Tool life of 200,000 holes.**
- **Surface finish Ra 0.2 µm.**

BENEFIT

- **Secure process and very good surface quality.**
- **Very short overhang length resulting in very good stability.**

Gear Housing





PCD REAMING

CHALLENGE

- Bearing bore Ø 80mm.
- Tolerance range 30 µm H7.
- Aluminium G-AlSi10Mg.
- Pre-drilled hole with 0,5mm depth of cut.
- Machining centre HSK63A with internal coolant.

SOLUTION

- PCD-tipped, steel-based tool with SIF™ steerable interface and internal coolant.
- Four effective cutting and chamfering teeth.
- KD1415™.

CUTTING DATA

- vc 400 m/min (1,312 SFM).
- f 0,32 mm/rev (.013 IPR).

RESULT

- **Tool life of more than 30,000 components.**
- **Surface finish Ra 0.2 µm.**

BENEFIT

- **Secure process and very good surface quality.**

Gear Housing





PCD REAMING

CHALLENGE

- Bearing bore Ø 28 and 90mm.
- Tolerance range 21 and 35 µm H7.
- Aluminium G-AlSi10Mg.
- Pre-drilled hole with 0,5mm depth of cut.
- Machining centre HSK63A with internal coolant.

SOLUTION

- PCD-tipped, steel-based tool with two individual adjustable SIF™ steerable interfaces and internal coolant.
- Four effective cutting teeth.
- KD1415™.

CUTTING DATA

- vc 1,312 SFM (400 m/min).
- f .013 IPR (0,32 mm/rev).

RESULT

- **Tool life of more than 95,000 holes.**
- **Surface finish Ra 0.2 µm.**

BENEFIT

- **Secure process and very good surface quality.**

Gear Housing



PCD STEP REAMING

CHALLENGE

- Bearing bore Ø 80 and 120mm.
- Tolerance range 30 and 35 µm H7.
- Aluminium G-AlSi7Mg.
- Pre-drilled hole with 0,5mm depth of cut.
- Machining centre HSK63A with internal coolant.

SOLUTION

- PCD-tipped, steel-based tool with HSK63A interface and internal coolant.
- Four effective cutting teeth.
- KD1415™.



CUTTING DATA

- vc 800 m/min (2,625 SFM).
- f 0,32 mm/rev (.013 IPR).

RESULT

- **Tool life of more than 400 minutes.**
- **Surface finish Ra 0.2 µm.**

BENEFIT

- **Secure process and very good surface quality.**
- **Tool life increase versus previous solution.**

Gear Housing





PCD COUNTERSINKING

CHALLENGE

- Bearing bore Ø 81,25 and 90,3mm.
- Tolerance range 30 and 35 µm H7.
- Aluminium G-AlSi7Mg.
- Pre drilled hole with 0,5mm depth of cut.
- Machining centre HSK63A with internal coolant.

SOLUTION

- PCD-tipped, steel-based tool with SIF™ steerable interface and internal coolant.
- Three effective cutting and chamfering teeth.
- KD1415™.

CUTTING DATA

- vc 400 m/min (1,312 SFM).
- f 0,30 mm/rev (.012 IPR).

RESULT

- **Tool life of 10,000 components.**
- **Surface finish Ra 0.2 µm.**

BENEFIT

- **Secure process and very good surface quality.**

Gear Housing



PCD STEP REAMING

CHALLENGE

- Bearing bore 17,984 and 66,037mm.
- Tolerance range 8 and 20 µm.
- Aluminium GD-AlSi7.
- Pre-drilled hole with 0,5mm depth of cut.
- Machining centre HSK63A with internal coolant.

SOLUTION

- PCD-tipped, steel-based tool with SIF™ steerable interface and internal coolant.
- Three effective cutting teeth.
- KD1415™.

CUTTING DATA

• vc 315 m/min	f 0,24 mm/rev	Ø 17,984mm.
• vc 1.156 m/min	f 0,15 mm/rev	Ø 66,037mm.

RESULT

- **Tool life of 35,000 components.**
- **Surface finish Ra 0.2 µm.**

BENEFIT

- **Secure process and very good surface quality.**
- **Achieves high concentricity and straightness.**



Gear Housing







PCD PROFILE MILLING

CHALLENGE

- Retraining grooves Ø 60,4 and 90,7mm.
- Tolerance range 60 µm.
- Aluminium G-AlSi10Mg.
- Pre-drilled hole with 0,5mm depth of cut.
- Machining centre HSK63A with internal coolant.

SOLUTION

- PCD-tipped, steel-based tool with HSK63A interface and internal coolant.
- Four effective cutting teeth.
- KD1415™.

CUTTING DATA

- vc 1,500 m/min (4,921 SFM).
- f 0,06 mm/rev (.002 IPR).

RESULT

- **Tool life of 50,000 parts.**
- **Surface finish better than Ra 0.4 µm.**

BENEFIT

- **Secure process.**
- **Combining two operations in one tool increases productivity.**
- **High accuracy in the distance between the two machined grooves.**

PCD PROFILE MILLING

CHALLENGE

- Retraining grooves Ø 60,4 and 90,7mm.
- Tolerance range 60 µm.
- Aluminium G-AlSi10Mg.
- Pre-drilled hole with 0,5mm depth of cut.
- Machining centre HSK63A with internal coolant.

SOLUTION

- PCD-tipped, steel-based tool with HSK63A interface and internal coolant.
- Four effective cutting teeth.
- KD1415.

CUTTING DATA

- vc 1,500 m/min (4,921 SFM).
- f 0,06 mm/rev (.002 IPR).

RESULT

- **Tool life of 50,000 parts.**
- **Surface finish better than Ra 0.4 µm.**

BENEFIT

- **Secure process.**
- **Combining two operations in one tool increases productivity.**
- **High accuracy in the distance between the two machined grooves.**

Differential Housing



REAMING AND BACK BORING

CHALLENGE

- Bearing seat finishing of gearbox.
- Material: G-AlSi9Cu3.
- Machine: M/C.
- IC 40 bar, 20 l/min.
- Ae = 0,25mm.

SOLUTION

- PCD reaming/back boring combination tool.
- 2 step reapers with 6 PCD teeth.
- Back boring with Romicron™ and PCD insert.

CUTTING DATA

- Speed: 350 m/min.
- Feed per tooth: 0,12mm.
- 1500 rev/min and 1080 mm/min.

RESULT

- **Roughness of Rz < 16 µm.**
- **One tool-chance saved.**

BENEFIT

- **Finish of 3 diameters with one tool.**
- **Perfect balanced tool, considering extreme asymmetrical shape.**
- **Easy adjustment with Romicron.**



Differential Housing





DIFFERENTIAL HOUSING–FINISH BORING

CHALLENGE

- Bearing seat finishing of gearbox.
- Material: GGG40.
- Machine: M/C.
- Diameter: 60H6.
- Surface Finish: Ra 1.6.

SOLUTION

- Fine boring tool Romicron™ AVS.
- Cartridge for SPHX inserts.
- SPHX-inserts KC7215 with 2 cutting edges.
- Special back taper grind for similar surface finishes to wiper inserts.

CUTTING DATA

- vc = 180 m/min
- fz = 0.05mm

RESULT

- **All geometric and dimensional tolerances including surface finish achieved.**
- **Very robust process.**
- **Tool life with standard SPHX insert 4000 pieces (within this tool life, 3 diameter adjustments with the “Romicron-Click-Mechanism” were required).**

BENEFIT

- **Excellent surface finish similar to wiper inserts.**
- **Huge portfolio of SPHX-inserts for all kind of workpiece materials.**
- **Romicron-Click-Mechanism.**
- **No need for wrench or gage for the diameter adjustment.**

Differential Housing





Adjustable pocket seat

DIFFERENTIAL HOUSING–FINISH BORING

CHALLENGE

- Bore Ø 40 and 55mm.
- Tolerance range 30 µm R7.
- Aluminium GD-AlSi10Mg.
- Fine boring two diameters with one tool.
- Machining centre with internal coolant.

SOLUTION

- PCD steel-based fine boring tool with four effective cutting edges, adjustable pocket seats at Ø 55mm, SIF™ steerable interface, and internal coolant.
- CCMT060202 KM™ — one uncoated carbide.

CUTTING DATA

- vc 340 and 520 m/min — n = 3,000 RPM.
- f 0,60 mm/rev — (.024 IPR).

RESULT

- **Tool life of more than 15,000 components per insert.**
- **Surface finish Rz 10–12 µm.**
- **Cylindricity better than 20 µm.**

BENEFIT

- **All requirements regarding perpendicularity, roundness, and surface quality between Rz 8 µm and Rz 16 µm continuously achieved.**
- **Higher productivity due to combining three operations in one tool.**



Water Pump Housing





PCD COUNTERSINKING

CHALLENGE

- Bore positions of Ø 21 and 24mm.
- Tolerance range 13 and 33 µm.
- Aluminium AlSi9Cu3.
- Pre drilled hole with 0,5mm depth of cut.
- Machining centre HSK63A with internal coolant.

SOLUTION

- PCD-tipped, steel-based tool with adjustable pocket seats; SIF™ steerable interface and internal coolant.
- Four effective cutting teeth; KD1415™.

CUTTING DATA

- vc 1,969 SFM (600 m/min).
- f .005 IPR (0,12 mm/rev).

RESULT

- **Tool life of 80,000 components.**
- **Surface finish Rz 0.8 µm with Ø 21mm and Rz 12 µm with Ø 24mm.**

BENEFIT

- **All requirements regarding perpendicularity, roundness, and surface quality between Rz 8 µm and Rz 15 µm at Ø 24mm are continuously achieved.**

Water Pump Housing



PCD MULTI-OPERATION TOOL

CHALLENGE

- Position bore Ø 7,9mm.
- Tolerance range 22 µm H8.
- Aluminium AlSi9Cu3.
- Combine drilling, back chamfering, and facing.
- Machining centre BT40 with internal coolant.

SOLUTION

- Solid carbide, PCD-tipped, steel-based tool with back chamfering capability and internal coolant.
- Two effective cutting teeth.
- KD1415™.

CUTTING DATA

- vc 350 m/min (1,148 SFM).
- f 0,20 mm/rev (.008 IPR).

RESULT

- **Tool life of 50,000 components.**
- **Surface finish Rz 0.8 µm.**

BENEFIT

- **Higher productivity due to combining three operations in one tool.**



Water Pump Housing





PCD STEP REAMING

CHALLENGE

- Bearing bores Ø 10,14–18,45mm.
- Tolerance range 3–10 µm.
- Aluminium GD-AlSi9Cu3.
- Pre-casted hole with 0,3mm depth of cut.
- Machining centre HSK32A with internal coolant.

SOLUTION

- PCD-tipped, steel-based tool with adjustable pocket seats; SIF™ steerable interface and internal coolant.
- Four effective cutting teeth.
- KD1415™.

CUTTING DATA

- vc 89–162 m/min n = 2800 RPM.
- f 0,4 mm/rev (.015 IPR).

RESULT

- **Tool life of 40,000 components.**
- **Surface finish Rz 0.8 µm.**

BENEFIT

- **The quality criterion with an exact alignment of rightness, concentricity, and a high value of surface quality was reached.**

Water Pump Housing





PCD END MILLING

CHALLENGE

- Face milling of connection face Ø 32mm.
- Aluminium AlSi10Mg.
- Casted face with 2,5mm depth of cut.
- Machining centre HSK63A with internal coolant.

SOLUTION

- PCD-tipped, steel-based end mill with HSK63A interface and internal coolant.
- Five effective cutting teeth.
- KD1415™.

CUTTING DATA

- vc 1,005 m/min (3,294 SFM).
- f 0,06 mm/rev (.002 IPR).

RESULT

- **Tool life of 3,000 min.**
- **Surface finish Ra 0.3 µm.**

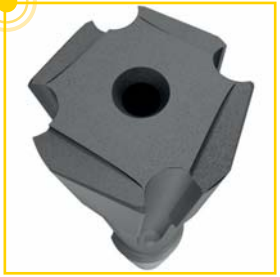
BENEFIT

- **Very low bur formation.**

Planetary Gear Carrier







Chip control geometry

RMS™ MULTI-FLUTE REAMING

CHALLENGE

- Bearing bores Ø 8,8mm.
- Tolerance range 9 µm M6.
- Steel 42CrMo4 and 31CrMoV9.
- Increase tool life with long chipping material.
- Machining centre with internal coolant.

SOLUTION

- RMS engineered-solution reamer with four effective cutting edges, internal coolant hole, and coolant channels at shank.
- KC6305™ TiAlN coated carbide.

CUTTING DATA

- vc 70 m/min (230 SFM).
- f 0,30 mm/rev (.012 IPR).

RESULT

- **Tool life of 300 components.**
- **Surface finish Rz 1.0–2.0 µm.**

BENEFIT

- **All requirements regarding perpendicularity, roundness, and surface quality below Rz 4 µm are continuously achieved.**

Planetary Gear Carrier



ROMICRON™ FINE BORING

CHALLENGE

- Bearing bores Ø 35 and 36,5mm.
- Tolerance range 20 µm.
- Steel 20MnCr5.
- Replace padded step reamer.
- Machining centre with internal coolant.

SOLUTION

- Romicron™ standard AVS heads.
- CCMT06020411 KT315™ cermet insert.

CUTTING DATA

- vc 290 m/min (230 SFM).
- f 0,10 mm/rev (.012 IPR).

RESULT

- **Surface finish better than Ra 1.0 µm.**
- **Cylindricity better than 5 µm.**

BENEFIT

- **More than 25% reduction in machining time.**
- **Removing setup of padded reamer outside of the machine results in increased uptime.**
- **Bore tolerance range of 20 µm easily and consistently achieved due to 1 µm per click in radius adjustment.**



Padded reaming pin machining







RIQ™ QUATTRO CUT™ PADDED REAMING

CHALLENGE

- Bearing pin machining Ø 45mm.
- Tolerance range 16 µm k6.
- Ductile cast iron GGG40.
- Surface quality of Rmax 10 µm to achieve.
- Special dimensional accuracy requirement.

SOLUTION

- RIQ padded reamer with SIF™ steerable tooling interface and special gashing for external coolant supply.
- Balanced-by-design and fine balanced.

CUTTING DATA

- vc 105 m/min (344 SFM).
- f 0,06 mm/rev (.002 IPR).

RESULT

- **Surface finish better than Rz 2.5 µm.**
- **Roundness 3 µm.**
- **Cylindricity 6 µm.**

BENEFIT

- **No insert back taper adjustment needed.**
- **Faster setup and less scrap.**

Brake Caliper



BRAKE CALIPER–ROUGHING/FINISHING MAIN BORE

CHALLENGE

- Component: Brake caliber
- Material: GGG55
- Operation: Cylinder hole
- Coolant: Yes
- Machine: Machine centre
- Objective: Surface finish and roundness

SOLUTION

- HSK100A special tool with radial adjustments and guide pad.
- Fix-Perfect™ insert.
- Internal coolant.
- Decreasing vibration by means of heavy metal shank.

CUTTING DATA

- vc = 107 m/min
- vf = 300 mm/min
- FPT = 0,13mm

RESULT

- **Tool life: 2.238 parts.**
- **Roundness 0,01mm.**
- **H8 — Tolerance kept, and even smaller would be feasible if requested.**

BENEFIT

- **From cast to finish hole in one go, i.e., with one single "One-Shot-Tool".**
- **4 effective teeth.**
- **4 edges per insert.**
- **Very fine, consistent adjustment mechanism.**



Brake Caliper





RMS™ MULTIFLUTE REAMING

CHALLENGE

- Pin hole Ø 12mm.
- Tolerance range 30 µm.
- Cast iron.
- Machining centre HSK63A with internal coolant.

SOLUTION

- UpSharp engineered-solution solid carbide reamer with six cutting edges.
- TICN coated carbide.

CUTTING DATA

- vc 75 m/min (246 SFM).
- f 0,8 mm/rev (.031 IPR).

RESULT

- **Tool life of 5,000 holes.**
- **Surface finish Ra 1.0 µm.**

BENEFIT

- **Productivity increase.**
- **Longer tool life than competition.**
- **Ease of use due to shrink technology.**

Brake Caliper



RIQ™ QUATTRO CUT™ PADDED REAMING

CHALLENGE

- Main bore Ø 54,02mm.
- Tolerance range 40 µm.
- Cast iron GGG.
- Reduce setup time and cost per part.

SOLUTION

- RIQ padded reamer with customer specific shank.
- Coated carbide RIQ insert with four edges.
- KC6305™.

CUTTING DATA

- vc 80 m/min (262 SFM).
- f 0,40 mm/rev (.016 IPR).

RESULT

- **Tool life of 16,000 bores per insert.**
- **Surface finish better than Ra 1.6 µm.**

BENEFIT

- **No insert back taper adjustment needed.**
- **High cost savings due to more than 100% increase in tool life.**



Brake Caliper





PCD REAMING

CHALLENGE

- Main bore Ø 42mm.
- Tolerance range 8 µm.
- Aluminium.
- Varying depth of cut between 1–2mm.
- Machining centre with internal coolant.

SOLUTION

- PCD-tipped, steel-based tool with HSK63A interface and internal coolant.
- Four effective cutting teeth.
- KD1415™.

CUTTING DATA

- vc 500 m/min (1,640 SFM).
- f 1 mm/rev (.039 IPR).

RESULT

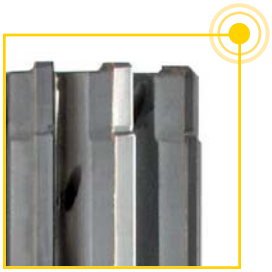
- **Tool life of 400,000–600,000 bores.**
- **Surface finish better than Ra 1.6 µm.**

BENEFIT

- **Secure process and high tool life.**
- **Productivity increase compared to previous solution.**

Brake Caliper





Producing two different diameters

RMB™ MULTI-FLUTE REAMING

CHALLENGE

- Location holes Ø 39 and 40mm.
- Tolerance range 39 µm H8.
- Cast iron GGG60.
- Produces both diameters with one tool.
- Machining centre with internal coolant.



SOLUTION

- RMB engineered-solution carbide tipped reamer with 10 teeth and internal coolant supply.
- KC6305™ TiAlN coated carbide.

CUTTING DATA

- vc 70 m/min (230 SFM).
- f 3,30 mm/rev (.130 IPR).

RESULT

- **Tool life of 5,000 holes.**
- **Surface finish Rz 20 µm better than required Rz 25 µm.**

BENEFIT

- **Very stable and highly productive process as multiple operations are combined at very high cutting data.**

Brake Master Cylinder





RIQ™ QUATTRO CUT™ PADDED REAMING

CHALLENGE

- Piston bore Ø 25,431mm.
- Tolerance range 10 µm.
- Ductile cast iron.
- Replace honing process with reaming.
- Machining centre with internal coolant.

SOLUTION

- RIQ padded reamer in angular micro-finishing setup with semi- and fine-finishing insert.
- RIQ full face PCD KD1415™ as finishing insert.

CUTTING DATA

- vc 120 m/min (394 SFM).
- f 0,20 mm/rev (.008 IPR).

RESULT

- **Tool life of 1,600 bores per insert.**
- **Surface finish better than Ra 0.4 µm.**
- **Cylindricity 6 µm.**

BENEFIT

- **No insert back taper adjustment needed.**
- **Higher productivity due to combining two operations in one tool.**

Steering Knuckle



ROMICRON™ FINE BORING

CHALLENGE

- Main bearing bore Ø 82mm.
- Replace setup of padded reamer and cover various diameters with one tool.
- Machining centre with internal coolant.

SOLUTION

- Romicron™ engineered solution. HSK80ASVSB156M SVS4B head.
- CPMT 060204 FW KCK20™.

CUTTING DATA

- vc 400 m/min (1,312 SFM).
- f 0,20 mm/rev (.008 IPR).

RESULT

- **Tool life of 1,000 components.**
- **Surface finish 1.2 µm.**
- **Cylindricity better than 6 µm.**

BENEFIT

- **Reduce setup time and cost reduction when standard inserts are used.**
- **Bore tolerance range of 30 µm easily and consistently achieved due to 1 µm per click in radius adjustment.**



Suspension Sub-frame





REAMING PIVOT BEARING

CHALLENGE

- Location hole Ø 18,5–23,0mm.
- Tolerance range 0,1°.
- Steel.
- Improvement in roundness and angularity.
- Transfer line with internal coolant.

SOLUTION

- RIR taper reamer with HSK interface.
- R904S00771 KC6005™ with two edges.

CUTTING DATA

- vc 400 m/min (1,312 SFM).
- f 0,20 mm/rev (.008 IPR).

RESULT

- **Tool life of 800 bores per insert.**
- **Surface finish Ra 1.6 µm.**

BENEFIT

- **Predictable performance and cost savings because inserts can be reconditioned.**
- **Easy to set with three clock padded reamer setting fixtures.**
- **Roundness improvement over competitive solid carbide multi-flute reamer.**

Mounting Lever



PCD COUNTERSINKING

CHALLENGE

- Reaming pre-casted hole Ø 20mm.
- Tolerance range 21 µm H7.
- Aluminium AlSi9Cu3.
- 220mm overhang due to workpiece fixture.
- Machining centre with internal coolant.

SOLUTION

- PCD-tipped, steel-based tool with HSK63A interface and internal coolant.
- Four effective cutting teeth.
- KD1415™.

CUTTING DATA

- vc 125 m/min (410 SFM).
- f 0,70 mm/rev (.003 IPR).

RESULT

- **Tool life of 60,000 components.**
- **Surface finish Ra 0.2 µm.**

BENEFIT

- **Secure process and less scrap than previous competitive solution.**
- **No adjustment effort due to solid solution.**



Turbocharger





RMS™ MULTI-FLUTE REAMING

CHALLENGE

- Mounting holes Ø 12mm.
- Tolerance range 18 µm H7.
- Ductile cast iron.
- Machining centre with internal coolant

SOLUTION

- RMS standard reamer with six effective cutting edges and internal coolant.
- KC6305™ TiAlN coated carbide.

CUTTING DATA

- vc 66 SFM (20 m/min).
- f .012 IPR (0,30 mm/rev).

RESULT

- **Tool life of 1,000 components.**
- **Surface finish better than Rz 10 µm.**

BENEFIT

- **Productivity and tool life increase compared to previous solution.**

Compressor



ROMICRON™ FINE BORING

CHALLENGE

- Piston bore Ø 23,5mm.
- Tolerance range 18 µm.
- Aluminium 12% Si.
- Machining centre BT40 with external coolant.

SOLUTION

- Standard SVUBB2 head with KR coupling.
- Standard steel boring bar.
- CPGW060204FST KD1400™.

CUTTING DATA

- vc 367 m/min (1,204 SFM).
- f 0,07 mm/rev (.003 IPR).

RESULT

- **Surface finish Ra 0.6 µm.**
- **Roundness better than 5 µm.**

BENEFIT

- **2x the productivity compared to the current solution.**
- **80% less adjustment time needed.**
- **Bore tolerance range of 18 µm easily and consistently achieved due to 1 µm per click in radius adjustment.**



Compressor







Polished flutes improving chip evacuation

PCD COUNTERSINKING

CHALLENGE

- Bearing hole Ø 12–31mm.
- Tolerance range 50 µm.
- Aluminium G-AlSi12.
- Machining centre HSK40 with internal coolant.

SOLUTION

- PCD-tipped, carbide-based tool with four guiding lands, flat-bottom drilling point, and internal coolant.
- Two effective cutting and chamfering teeth; KD1415™.

CUTTING DATA

- vc 440 m/min (1,444 SFM).
- f 0,20 mm/rev (.008 IPR).

RESULT

- **Surface finish Rz 1–2 µm.**
- **Roundness better than 5 µm.**

BENEFIT

- **Productivity increases due to combining different tools in one.**
- **Tool life increase versus previous solution.**

Compressor





KST pre-loaded taper face contact interface

RHM™ MODULAR REAMING

CHALLENGE

- Piston bore Ø 23,5mm.
- Tolerance range 10 µm.
- Cast iron GGG60.
- Machining centre HSK63 with internal coolant.

SOLUTION

- RHM modular reamer with six cutting edges.
- KT325™ uncoated cermet.
- Standard lead geometry.
- SIF™ steerable tooling.

CUTTING DATA

- vc 125 m/min (410 SFM).
- f 0,75 mm/rev (.030 IPR).

RESULT

- **Surface finish better than Rz 4 µm.**

BENEFIT

- **Higher productivity than single-edged padded reamer.**



Hydraulic Valve Block





RIR™ PADDED REAMING

CHALLENGE

- Spool bore Ø 18,5mm.
- Tolerance range 10 µm.
- Cast iron.
- Up to 4mm varying depth of cut.
- Machining centre with internal coolant.

SOLUTION

- RIR padded reamer with up to 100mm long cermet guide pads.
- Engineered solution RIR insert with modified chipformer.

CUTTING DATA

- vc 70 m/min (230 SFM).
- f 0,125 mm/rev (.005 IPR).

RESULT

- **Tool life of 400 min per double-edged insert.**
- **Roundness and straightness within 10 µm.**

BENEFIT

- **Very stable process control and predictable performance.**

Hydraulic Valve Block





RMS™ MULTI-FLUTE REAMING

CHALLENGE

- Rinse slider bore Ø 9,534mm.
- Tolerance range 6 µm.
- Ductile cast iron 0.7060.
- Three interrupted cuts at a reaming depth of 100mm.
- Special dimensional accuracy requirement.

SOLUTION

- RMS solid carbide reamer engineered solution.
- Special back taper configuration and support margins lands.
- KC6305™ TiAlN coated carbide.

CUTTING DATA

- vc 150 m/min (492 SFM).
- f 0,72 mm/rev (.028 IPR).

RESULT

- **Tool life of 500 pieces.**

BENEFIT

- **Speed and feed rates are almost 30x faster, resulting in higher productivity.**
- **Less scrap due to consistent accuracy.**

Hydraulic Valve Block





PCD COUNTERSINKING

CHALLENGE

- Thread core hole Ø 24mm.
- Tolerance range 21 µm F7.
- Aluminium AlSi9Cu3.
- Pre-drilled hole.
- Machining centre DV40 with internal coolant.

SOLUTION

- PCD-tipped, carbide-based tool with internal coolant.
- Two effective cutting and chamfering teeth.
- KD1415™.

CUTTING DATA

- vc 360–750 m/min — n = 7,500 RPM.
- f 0,20 mm/rev — (.008 IPR).

RESULT

- **Tool life of 100,000 holes.**
- **Surface finish Ra 0.1 µm.**

BENEFIT

- **Productivity increase due to combining two operations into one.**
- **Carbide base increases tool life and accuracy.**

ABS Valve Block



PCD COUNTERSINKING

CHALLENGE

- Bearing bores Ø 20,99 and 24,275mm.
- Tolerance range 20 µm.
- Aluminium AlSi1.
- Pre-casted hole with 0,15mm depth of cut.
- Machining centre HSK63A with internal coolant.

SOLUTION

- PCD-tipped, steel-based tool with SIF™ steerable interface and internal coolant.
- Two effective cutting and chamfering teeth.
- KD1415™.

CUTTING DATA

- vc 300 m/min (984 SFM).
- f 0,35 mm/rev (.014 IPR).

RESULT

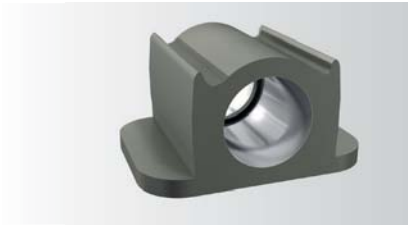
- **Surface finish Ra 0.4–0.6 µm.**

BENEFIT

- **Very stable process control and predictable performance.**
- **Very favourable chip creation.**



Bearing Seat







KST pre-loaded taper face contact interface

RHM™ MODULAR REAMING

CHALLENGE

- Reaming Ø 35mm.
- Tolerance range 20 µm.
- Carbon steel, annealed, long-chipping.
- Blind hole limiting chip evacuation.
- Machining centre with internal coolant.

SOLUTION

- RHM modular reamer with eight cutting edges.
- KT325™ uncoated cermet.
- Standard lead geometry.
- Short engineered-solution axial clamping tool body.

CUTTING DATA

- vc 120 m/min (394 SFM).
- f 1,18 mm/rev (.046 IPR).

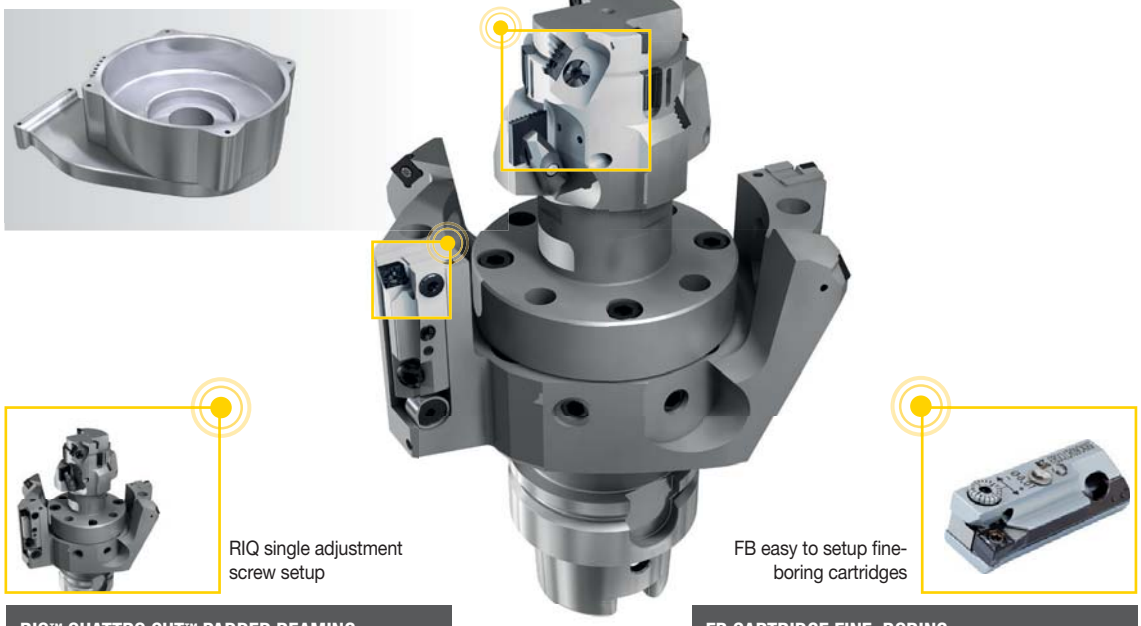
RESULT

- **Tool life of 145,000 holes.**
- **Surface finish better than Rz 6.3 µm.**

BENEFIT

- **Predictable tool life as only 2 µm diameter deviation after 10,000 holes.**

Bearing Seat



RIQ single adjustment screw setup

FB easy to setup fine-boring cartridges

RIQ™ QUATTRO CUT™ PADDED REAMING

CHALLENGE

- Reaming Ø 47mm.
- Tolerance range 19 µm N6.
- Aluminium AlSi9Cu3.
- Machine four different diameters, two spot faces, and four different chamfers with one tool.

SOLUTION

- RIQ padded reamer with full-face PCD KD1415™ insert having four cutting edges.
- SIF™ steerable interface between reaming and fine boring section.

CUTTING DATA

- vc 236 m/min (774 SFM).
- f 0,08 mm/rev (.003 IPR).

RESULT

- **Surface finish better than Rz 16 µm.**

BENEFIT

- **No insert back taper adjustment needed.**
- **Less operations increase productivity.**
- **Higher accuracy than multiple operations.**
- **Full-face PCD inserts reduce cost per hole.**

FB CARTRIDGE FINE–BORING

CHALLENGE

- Reaming Ø 144mm.
- Tolerance range 40 µm H7.
- Aluminium AlSi9Cu3.
- Machine two different diameters.

SOLUTION

- Standard FB fine-boring cartridges with almost backlash-free fine adjustment.
- CCGW060204 KD1415™.

CUTTING DATA

- vc 723 m/min (2,372 SFM).
- f 0,08 mm/rev (.003 IPR).

RESULT

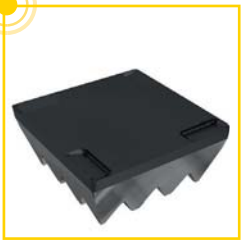
- **Surface finish better than Rz 16 µm.**

BENEFIT

- **Radial adjustment does not influence axial adjustment of inserts resulting in faster setup.**
- **Productivity increase with less operations.**
- **More accurate than previous solution.**

Pump Housing





Full-face PCD insert with chipformer geometry



RIQ™ QUATTRO CUT™ PADDED REAMING

CHALLENGE

- Piston bore Ø 18,5mm.
- Tolerance range 21 µm H7.
- Aluminium.
- Heavy interrupted cut and surface finish Rz 6.3.
- Machining centre with internal coolant.

SOLUTION

- RIQ padded reamer with helical chip flute and helical solid carbide guide pad.
- Full-face KD1415™ insert having four cutting edges.
- Positive wiper insert geometry.

CUTTING DATA

- vc 230 m/min (755 SFM).
- f 0,15 mm/rev (.006 IPR).

RESULT

- **No chip evacuation issues.**
- **No bur, marks, or scratches at entrance or exit of interruptions.**

BENEFIT

- **No insert back taper adjustment needed.**
- **Half cycle time compared to previous competitive tooling.**

Valve Housing



ROMICRON™ FINE BORING

CHALLENGE

- Various bore Ø 170–480mm.
- Tolerance range 75 µm.
- Cast iron GG25.
- Automated wear compensation at interrupted cut.
- Machining centre HSK100 with internal coolant.



SOLUTION

- Semi-standard SVU120 CLB head with engineered-solution diameter extender and automatic wear compensation with CLB.
- CPGW09T308S01015C KB1630™.

CUTTING DATA

- vc 800 m/min (2,625 SFM).
- f 0,12 mm/rev (.005 IPR).

RESULT

- **Tool life of 1,200 minutes per insert.**
- **Surface finish better than Rz 16 µm.**

BENEFIT

- **More than 30% reduction in manufacturing lead time.**
- **Third shift and weekend without operators.**
- **1 µm per click in radius adjustment executed by machine.**

Wind Energy Housing







1 µm per click in
radius adjustment

ROMICRON™ FINE BORING

CHALLENGE

- Flange Ø 1260–1400mm.
- Tolerance range 125 µm H7.
- Cast iron GGG40.
- One base bridge for multiple diameters.
- Machining centre without coolant.

SOLUTION

- Romicron standard modular MF40 element with engineered-solution aluminium bridge.
- CPGT060204/08HP KC5410™.

CUTTING DATA

- vc 200 m/min (650 SFM).
- f 0,12 mm/rev (.005 IPR).

RESULT

- **Tool life of 73 min.**

BENEFIT

- **Investment saving as only one base bridge needed.**
- **Use of standard off-the-shelf Romicron tool.**
- **Ease of use due to Romicron.**

Synchronous Joint





Balanced-by-design

ROMICRON™ FINE BORING

CHALLENGE

- Pin machining Ø 13mm.
- Tolerance range 6 µm.
- Steel 42CrMo4 (4140).
- Machining centre with internal coolant.

SOLUTION

- Romicron standard HSK63ASVUBB1095MCLB head with engineered solution pin boring bar.
- TCMT110202FP KTP10™.

CUTTING DATA

- vc 160 m/min (525 SFM).
- f 0,1 mm/rev (.004 IPR).

RESULT

- **Tool life of 300-450 components per insert.**
- **Surface finish Ra 0.3 µm.**
- **Cpk value ≥1,33.**

BENEFIT

- **Use of standard off-the-shelf Romicron tooling.**
- **Bore tolerance of 6 µm consistently achieved due to 1 µm per click in radius adjustment.**



Wind Energy

ModBORE™

For the **Big Jobs!**

The ModBore system includes tooling ranges from highly flexible roughing and fine-boring heads to large bridge tooling, with an optimum amount of tooling components. This premium boring line enables roughing to fine-boring operations using one system with a large diameter range from 9,75–2,205mm (.384–86.8"). ModBORE can be used in most workpiece materials in metalcutting applications with the latest Kennametal standard ISO turning inserts.



Experience the advantages at your Authorised Kennametal Distributor or at **kennametal.com**.

KENNAMETAL®

kennametal.com



Tapping

Taps Introduction L2–L15

Spiral-Point/Left-Hand Spiral-Flute Taps M2–M18

Spiral-Flute Taps M20–M50

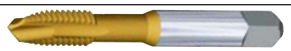
Straight-Flute Taps M52–M68

Forming Taps M70–M75

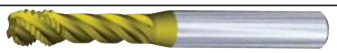
Pipe Taps M76–M79

Solid Carbide Thread Mills M80–M97

Technical Information M98–M132

Spiral-Point and Left-Hand Spiral-Flute Taps	series	grade/ coating	shank/dimension	● first choice ○ alternate choice P	M	K	N	S	H	
	**T320**	KC7542	6535 HA	●		○				
	**T320**	KC7542	6535 HA	●		○				
	**T321**	KC7542	6535 HA	●		○				
	**T620**	KP6525 KM6515	DIN 371, 374, 376	●	●	○	○			
	**T621**	KP6525 KM6515	DIN 371, 374, 376	●	●	○	○			
	**T620**	KP6525	DIN 376	●		●				
	**T620**	KP6525	XL	●		●				
	**T620**	KP6525	DIN 371, 376	●	○	○				
	**T621**	KP6525	DIN 371, 376	●	○	○				
	**T670**	KSN38	DIN 371, 376				●			
	**T600**	KSP21	DIN 371, 374, 376	●				○		
	**T820**	KSP32 KSP39	DIN 371, 374, 376	●	○	●	○			
	**T820**	KSP39	DIN 371, 376	○	○	○				
	**T820**	KSU31 KSU30	JIS	●	○	○	○			

	size range min-max	hole		chamfer		helix angle	coolant		page(s)	recommended cutting parameters
		through	blind	type	form		flood	through		
	3/8–1/2"	●		plug	D	L15°	●		M4	M98
	M6–M16	●		plug	D	L15°	●		M4	M98
	M10–M16	●		plug	D	L15°		●	M5	M98
	M3–M20	●		plug	D	L15°	●		M6	M98
	M5–M18	●		plug	D	L15°		●	M7	M98
	M24–M42	●		plug	D	L15°	●		M8	M98
	M24–M42	●		plug	D	L15°		●	M9	M98
	#6–1/2"	●		plug	D	L15°	●		M10	M98
	1/4–1/2"	●		plug	D	L15°		●	M11	M98
	M3–M16	●		plug	B	0°	●		M12	M98
	M3–M20	●		plug	B	0°	●		M13	M98
	M2–M36	●		plug	B	0°	●		M14–M15	M99
	#4–1"	●		plug	B	0°	●		M16–M17	M99
	M3–M20	●		plug	B	0°	●		M18	M99

Spiral-Flute Taps	series	grade/coating	shank/dimension	● first choice ○ alternate choice P	M	K	N	S	H
	**T331**	KC7542	6535 HA	●		○			
	**T331**	KC7542	6535 HA	●		○			
	**T630**	KP6525, KM6515	DIN 371, 374, 376	●	●	○	○		
	**T631**	KP6525, KM6515	DIN 371, 374, 376	●	●	○	○		
	**T632**	KP6525	DIN 371, 374, 376	●		○			
	**T633**	KP6525	DIN 371, 374, 376	●		○			
	**T630**	KP6525	DIN 376	●		●			
	**T631**	KP6525	DIN 376	●		●			
	**T630**	KP6525	XL	●		●			
	**T631**	KP6525	XL	●		●			
	**T650**	KP6525	DIN 376	●		●			
	**T651**	KP6525	DIN 376	●		●			
	**T650**	KP6525	XL	●		●			
	**T651**	KP6525	XL	●		●			
	**T630**	KP6525	DIN 371, 376	●	○	○			
	**T631**	KP6525	DIN 371, 376	●	○	○			
	**T680**	KSN38	DIN 371, 376				●		
	**T604**	KSH26	DIN 371, 374, 376	●				○	
	**T830**	KSP32, KSP39	DIN 371, 374, 376	●	○	●	○		
	**T832**	KSP32, KSP39	DIN 371, 374, 376	●	○	●	○		
	**T838**	KSU31, KSP39	DIN 371, 374, 376	●	○	○	○		
	**T839**	KSU31, KSP39	DIN 371, 376	●	○	○	○		
	**T830**	KSP39	DIN 371, 376	○	○	○			
	**T838**	KSU31, KSP39	DIN 371, 374, 376	●	○	○	○		
	**T830**	KSU31, KSU30	JIS	●	○	○	○		

	size range min-max	hole		chamfer		helix angle	coolant		page(s)	recommended cutting parameters
		through	blind	type	form		flood	through		
										
	1/4–1/2"		●	semi-bottoming	C	45°		●	M22	M98
	M6–M16		●	semi-bottoming	C	45°		●	M23	M98
	M3–M20		●	semi-bottoming	C	45°	●		M24	M98
	M5–M18		●	semi-bottoming	C	45°		●	M25	M98
	M5–M16		●	bottoming	E	45°	●		M26	M98
	M5–M16		●	bottoming	E	45°		●	M27	M98
	M24–M42		●	semi-bottoming	C	45°	●		M28	M98
	M24–M42		●	semi-bottoming	C	45°		●	M29	M98
	M24–M42		●	semi-bottoming	C	45°	●		M30	M98
	M24–M42		●	semi-bottoming	C	45°		●	M31	M98
	M24–M42		●	semi-bottoming	C	15°	●		M32	M98
	M24–M42		●	semi-bottoming	C	15°		●	M33	M98
	M24–M42		●	semi-bottoming	C	15°	●		M34	M98
	M24–M42		●	semi-bottoming	C	15°		●	M35	M98
	#6–1/2"		●	semi-bottoming	C	45°	●		M36	M98
	1/4–1/2"		●	semi-bottoming	C	45°		●	M37	M98
	M3–M20		●	semi-bottoming	C	45°	●		M38	M98
	M3–M20		●	semi-bottoming	C	42°	●		M39	M98
	M2–M36		●	semi-bottoming	C	45°	●		M40–M41	M99
	M3–M20		●	bottoming	E	45°	●		M42	M99
	M2–M52		●	semi-bottoming	C	45°	●		M43–M44	M99
	M3–M20		●	bottoming	E	45°	●		M45	M99
	#4–1"		●	semi-bottoming	C	45°	●		M46, M49	M99
	#6–2"		●	semi-bottoming	C	45°	●		M47–M48	M99
	M3–M20		●	semi-bottoming	C	45°	●		M50	M99

Straight-Flute Taps	series	grade/coating	shank/dimension	● first choice ○ alternate choice P	M	K	N	S	H
	**T340**	KCK17	6535 HA	○		●			
	**T340**	KCK17	6535 HA	○		●			
	**T351**	KCK17	6535 HA	○		●			
	**T351**	KCK17	6535 HA	○		●			
	**T351**	KCK17	DIN 371, 374, 376	○		●			
	**T353**	KCK17	DIN 371, 376	○		●			
	**T471**	KCN14	6535 HA				●		
	**T471**	KCN14	DIN 371				●		
	**T410**	KCU36	DIN 371, 374, 376						●
	**T640**	KP6525	DIN 371, 376			●	●		
	**T641**	KP6525	DIN 371, 376			●	●		
	**T642**	KP6525	DIN 371, 374, 376			●	●		
	**T643**	KP6525	DIN 371, 374, 376			●	●		
	**T640**	KP6525	DIN 371, 376			●	●		
	**T641**	KP6525	DIN 371, 376			●	●		

*Through coolant 1/4", M6 and larger.

	size range min-max	hole		chamfer		helix angle	coolant		page(s)	recommended cutting parameters
		through	blind	type	form		flood	through		
										
	#6–9/16"	●		plug	D	0°	●		M54	M98
	M4–M20	●		plug	D	0°	●		M55	M98
	#6*–3/4"		●	bottoming	E	0°		●	M56	M98
	M4*–M16		●	bottoming	E	0°		●	M57	M98
	M6–M14		●	bottoming	E	0°		●	M58	M98
	M4*–M14		●	semi-bottoming	C	0°		●	M59	M98
	M6–M14		●	bottoming	E	0°		●	M60	M98
	M6–M10		●	bottoming	E	0°		●	M61	M98
	M3–M16		●	semi-bottoming	C	0°	●		M62	M98
	M4–M22	●	●	semi-bottoming	C	0°	●		M63	M98
	M5–M20		●	semi-bottoming	C	0°		●	M64	M98
	M5–M16	●	●	bottoming	E	0°	●		M65	M98
	M5–M16		●	bottoming	E	0°		●	M66	M98
	#6–1/2"	●	●	semi-bottoming	C	0°	●		M67	M98
	1/4–1/2"		●	semi-bottoming	C	0°		●	M68	M98

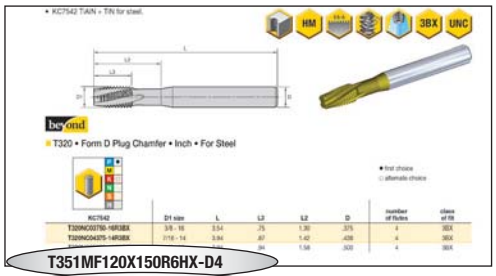
Forming Taps	series	grade/coating	shank/dimension	● first choice ○ alternate choice P	M	K	N	S	H	
	**T491**	KCN14	6535 HA				●			
	**T491**	KCN14	DIN 2174				●			
	**T622**	KSP21, KSN28	DIN 2174	●			●			
	**T623**	KSP21, KSN28	DIN 2174	●			●			

Pipe Taps	series	grade/coating	shank/dimension	● first choice ○ alternate choice P	M	K	N	S	H	
	**T877**	KSU31, KSP39	DIN 5156	●	○	○	○			
	**T857**	KSU31, KSP39	DIN 5156	●	○	○	○			
	**T848**	KSU30	DIN 5156	○		○				

	size range min-max	hole		chamfer		helix angle	coolant		page(s)	recommended cutting parameters
		through	blind	type	form		flood	through		
	M5–M12		●	bottoming	E	–		●	M72	M98
	M6–M10		●	bottoming	E	–		●	M73	M98
	M3–M16	●	●	semi-bottoming	C	–	●		M74	M98
	M5–M16		●	semi-bottoming	C	–		●	M75	M98

	size range min-max	hole		chamfer		helix angle	coolant		page(s)	recommended cutting parameters
		through	blind	type	form		flood	through		
	1/8–1"	●		plug	B	0°	●		M78	M99
	1/8–1"		●	semi-bottoming	C	42°	●		M78	M99
	1/16–1"	●	●	semi-bottoming	C	0°	●		M79	M99

Solid Carbide Tap Identification System



Metric	T351	MF	120	X	150	R	6HX	-D4
Inch	T320	NC	05000	–	13	R	3BX	
	Tap Design	Type of Thread	Nominal Diameter of Thread		Pitch	Cutting Direction	Tolerance Class	Taps Dimension
			mm or inch (depending on type)		mm or TPI (depending on type)			

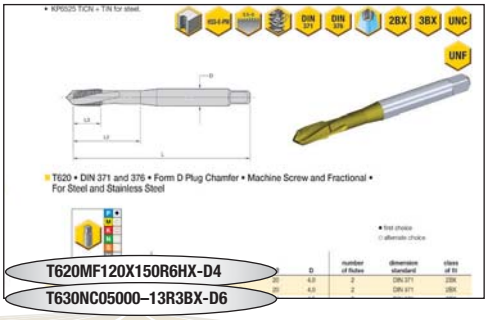
M = Metric coarse-pitch thread (ISO form)
MF = Metric fine-pitch thread (ISO form)
NC = Unified coarse series thread
NF = Unified fine series thread

D1 = DIN 371
D4 = DIN 374
D6 = DIN 376
D74 = DIN 2174
blank = 6535 HA

Tap design

T320 = Steel, through holes, LH spiral flute, solid
T321 = Steel, through holes, LH spiral flute, through coolant
T331 = Steel, blind holes, RH spiral flute, through coolant
T340 = Cast iron and cast aluminium, through holes, straight flute, solid
T351 = Cast iron and cast aluminium, blind holes, straight flute, through coolant
T353 = Cast iron and cast aluminium, blind holes, straight flute, through coolant
T410 = Hard steel 55–63 HRC, through and blind holes, straight flute, solid
T471 = Aluminium, blind holes, straight flute, through coolant
T491 = Aluminium, blind holes, forming tap, through coolant

HSS-E-PM Tap Identification System



Metric	**T620**	**MF**	**120**	**X**	**150**	**R**	**6HX**	**-D4**
Inch	**T630**	**NC**	**05000**	**–**	**13**	**R**	**3BX**	**-D6**
	Tap Design	Type of Thread	Nominal Diameter of Thread		Pitch	Cutting Direction	Tolerance Class	Taps Dimension
			mm or inch (depending on type)		mm or TPI (depending on type)			

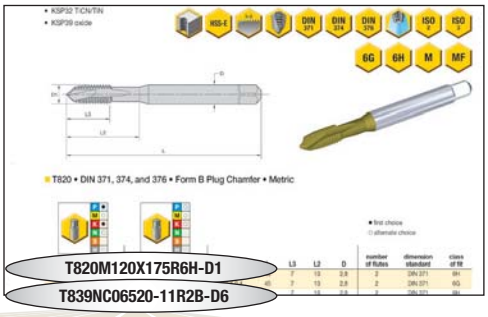
M = Metric coarse-pitch thread (ISO form)
MF = Metric fine-pitch thread (ISO form)
NC = Unified coarse series thread
NF = Unified fine series thread

Tap design

T600 = Steel 32–44 HRC, through holes, spiral point, solid
T604 = Steel 32–44 HRC, blind holes, 3 x D, RH 42° spiral flute, solid
T620 = Steel and stainless steel, through holes, LH spiral flute, solid
T621 = Steel and stainless steel, through holes, LH spiral flute, through coolant
T622 = Steel and aluminium, blind and through holes, forming tap, solid
T623 = Steel and aluminium, blind holes, forming tap, through coolant
T630 = Steel and stainless steel, blind holes, RH spiral flute, solid
T631 = Steel and stainless steel, blind holes, RH spiral flute, through coolant
T632 = Steel and stainless steel, blind holes, RH spiral flute, solid
T633 = Steel and stainless steel, blind holes, RH spiral flute, through coolant
T640 = Cast iron and cast aluminium, through and blind holes, straight flute, solid
T641 = Cast iron and cast aluminium, blind holes, straight flute, through coolant
T642 = Cast iron and cast aluminium, blind holes, straight flute, solid
T643 = Cast iron and cast aluminium, blind holes, straight flute, through coolant
T650 = Steel and cast iron, blind holes, RH spiral flute, large sizes, solid
T651 = Steel and cast iron, blind holes, RH spiral flute, large sizes, through coolant
T670 = Aluminium, through holes, spiral point, solid
T680 = Aluminium, blind holes, RH spiral flute, solid

D1 = DIN 371
D4 = DIN 374
D6 = DIN 376
D74 = DIN 2174
XL = DIN extra length

GOtap HSS-E Tap Identification System



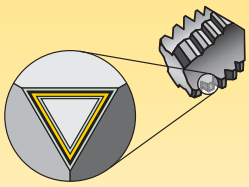
Metric	**T820**	**M**	**120**	**X**	**175**	**R**	**6H**	**-D1**
Inch	**T839**	**NC**	**06520**	**–**	**11**	**R**	**2B**	**-D6**
	Tap Design	Type of Thread	Nominal Diameter of Thread		Pitch	Cutting Direction	Tolerance Class	Taps Dimension
			mm or inch (depending on type)		mm or TPI (depending on type)			

M = Metric coarse-pitch thread (ISO form)
MF = Metric fine-pitch thread (ISO form)
NC = Unified coarse series thread
NF = Unified fine series thread
NPT = American standard taper pipe thread
NPTF = Dryseal American standard taper pipe thread
G = DIN EN ISO 228

D1 = DIN 371
D4 = DIN 374
D6 = DIN 376
D56 = DIN 5156
J = JIS

Tap design

T820 = Steel, stainless steel, ductile iron, and cast aluminium, through holes, spiral point, solid
T830 = Steel, stainless steel, ductile iron, and cast aluminium, blind holes, spiral flute, semi-bottoming, solid
T832 = Steel, stainless steel, ductile iron, and cast aluminium, blind holes, spiral flute, bottoming, solid
T838 = Steel, stainless steel, ductile iron, and cast aluminium, blind holes, spiral flute, TC, semi-bottoming, solid
T839 = Steel, stainless steel, ductile iron, and cast aluminium, blind holes, spiral flute, TC, bottoming, solid
T848 = Steel, stainless steel, ductile iron, and cast aluminium, straight flute, NPT, NPTF, solid
T857 = Steel, stainless steel, ductile iron, and cast aluminium, spiral flute, G, solid
T877 = Steel, stainless steel, ductile iron, and cast aluminium, spiral point, G, solid



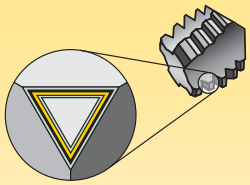
Coatings are designed for optimised tapping performance in specific materials.

P	Steel
M	Stainless Steel
K	Cast Iron
N	Non-Ferrous
S	High-Temp Alloys
H	Hardened Materials

Grade

wear resistance ⟷ toughness

Coating	Grade Description		05	10	15	20	25	30	35	40	45
KC7542	Coated carbide, PVD-multilayer coating with TiAlN and TiN over a high-strength carbide substrate specifically designed for tap application. Use in steel up to 32 HRC and cast iron at 4x faster speeds than HSS-E-PM taps.	P	■	■	■						
		K	■	■	■						
KCK17	Multilayer PVD AlCrN-coated fine-grain carbide. Newly-developed unique coating. Extraordinary wear resistance when tapping cast iron. High-temperature hardness enables long life at up to 4x faster speed than HSS-E-PM taps.	K	■	■	■						
KCN14	Coated carbide, PVD-two-layer coating over fine-grain carbide. Coating consists of low-friction CrC/C over wear-resistant TiN. CrC/C resists galling of non-ferrous materials to the tap. Provides superior performance for tapping cast aluminium and other non-ferrous materials.	N	■	■	■						
KCU36	Coated carbide. PVD — two-layer coating with heat-resistant TiAlN base layer and low-friction MoS_2 top layer over carbide substrate. Use in hardened steel 55–63 HRC.	H				■	■	■			
KSP21	Coated HSS-E-PM. PVD — powder metal HSS-E substrate with TiN coating. Use for tapping steel 32–44 HRC and for forming threads in steel 32 HRC.	P						■	■	■	
KSH26	Coated HSS-E-PM. PVD — powder metal HSS-E substrate coated with TiN base layer and low-friction MoS_2 top layer. Use in deep blind steel holes 32–44 HRC.	P						■	■	■	



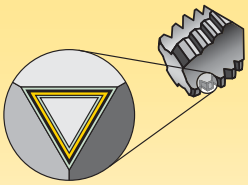
Coatings are designed for optimised tapping performance in specific materials.

P	Steel
M	Stainless Steel
K	Cast Iron
N	Non-Ferrous
S	High-Temp Alloys
H	Hardened Materials

Grade

wear resistance ← → toughness

Coating	Grade Description		05	10	15	20	25	30	35	40	45
KSN25	Coated HSS-E-PM. PVD — powder metal HSS-E substrate with two-layer coating: TiN base layer and DLC top layer that resists galling of non-ferrous materials to the tap. Use for tapping titanium. Not recommended for steel.	S									
KSN28	Coated HSS-E-PM. PVD — powder metal HSS-E substrate with DLC coating. Use for form tapping aluminium. Not recommended for steel.	N									
KSN38	Coated HSS-E. PVD — lower vanadium HSS-E substrate with DLC coating. Use for tapping non-ferrous materials with low cutting temperatures like wrought aluminium. Not recommended for steel.	N									
KP6525	Coated HSS-E-PM. PVD — heat- and wear-resistant high vanadium — cobalt powder metal HSS substrate coated with wear-resistant TiCN base layer and low-friction TiN top layer. Use in steel, cast iron, and cast aluminium with silicon.	P K									
KM6515	Coated HSS-E-PM. PVD — heat- and wear-resistant high vanadium — cobalt powder metal HSS substrate. Coating consists of low-friction CrC/C over wear-resistant TiN base layer. Use for tapping stainless steel and non-ferrous materials.	M N									
KSP32	High-vanadium HSS-E substrate coated with wear resistant TiCN base layer and low-friction TiN top layer. Use in multiple applications, including steel, stainless steel, ductile cast iron, and cast aluminium. KSP32 is abrasion resistant.	P M K N									

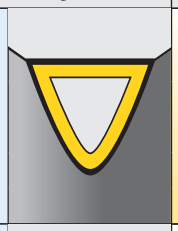
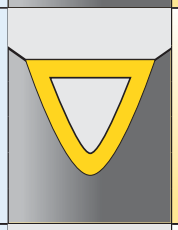
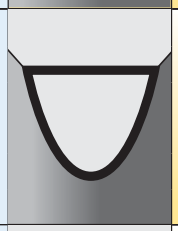
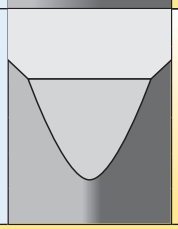


Coatings are designed for optimised tapping performance in specific materials.

P	Steel
M	Stainless Steel
K	Cast Iron
N	Non-Ferrous
S	High-Temp Alloys
H	Hardened Materials

wear resistance ← → toughness

Grade

Coating		Grade Description		05	10	15	20	25	30	35	40	45
KSMN34		High-vanadium HSS-E substrate with a coating consists of low-friction CrC/C over wear-resistant TiN base layer. Use for tapping stainless steel and non-ferrous materials.										
			M									
			N									
KSU31		Coated HSS-E substrate with TiN PVD layer. Use in multiple applications, including steel, stainless steel, ductile cast iron, and cast aluminium.	P									
			M									
			K									
			N									
KSP39		HSS-E substrate with black oxide surface treatment. Use in a variety of materials, including steel, stainless steel, and ductile iron. Not recommended for non-ferrous materials.	P									
			M									
			K									
KSU30		Uncoated HSS-E grade with bright surface. Use in easy to machine, general-purpose applications.	P									
			M									
			K									
			N									



Tapping Portfolio

Spiral-Point/Left-Hand Spiral-Flute Taps M2–M18

Beyond High-Performance Solid Carbide Taps M4–M5

High-Performance HSS-E-PM Taps M6–M13

Multipurpose GOtap M14–M18

Spiral-Flute Taps M20–M50

Beyond High-Performance Solid Carbide Taps M22–M23

High-Performance HSS-E-PM Taps M24–M39

Multipurpose GOtap M40–M50

Straight-Flute Taps M52–M68

Beyond High-Performance Solid Carbide Taps M54–M62

High-Performance HSS-E-PM Taps M63–M68

Forming Taps M70–M75

Beyond High-Performance Solid Carbide Taps M72–M73

High-Performance HSS-E-PM Taps M74–M75

Pipe Taps M76–M79

Multipurpose GOtap M78–M79

Solid Carbide Thread Mills M80–M97

Taps and Thread Milling Application and Technical Information M98–M132

Spiral-Point and Left-Hand Spiral-Flute Taps



High-Performance Taps for Through-Hole Applications

- Steel and steel alloys.
- Stainless steel.
- Cast iron.
- Nickel- and cobalt-based alloys.
- Titanium and titanium alloys.
- Aluminium.
- Hard steel.

High-Performance Beyond™ Solid Carbide Taps

- Left-hand spiral flute for optimal chip evacuation ahead of the tap.
- Runs up to 4x faster and 4x longer than conventional high-speed steel (HSS) taps.
- Ideal for long production runs where fewer tool changes result in greater productivity.
- For use on CNC machines with synchronous or rigid controls and precision toolholders.

High-Performance Beyond™ HSS-E-PM Taps

- Left-hand spiral flute for optimal chip evacuation ahead of the tap.
- Higher strength and wider range of applications versus solid carbide taps.
- Higher tapping speed capability and longer tool life than conventional HSS-E taps.
- Can be used on either conventional or synchronous tapping machines.

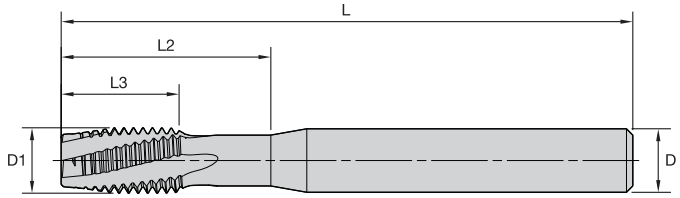
Multipurpose HSS-E GOtap™ Taps

- Optimised spiral-point geometry for efficient chip evacuation in through-hole applications.
- Manufactured with high vanadium HSS-E material for exceptional wear characteristics and longer tool life.
- Advanced PVD coatings to reduce tapping torque, resulting in high-quality thread finish and longer tool life.
- For use in both synchronous and non-synchronous machines, including rigid, synchronous, and tension/compression tap holders.



• KC7542 TiAlN + TiN for steel.

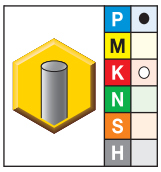






beyond

T320 • Form D Plug Chamfer • Inch • Solid Carbide • For Steel



● first choice
○ alternate choice

KC7542	D1 size	L	L3	L2	D	number of flutes	class of fit
T320NC03750-16R3BX	3/8 - 16	3.54	.75	1.30	.375	4	3BX
T320NC04375-14R3BX	7/16 - 14	3.94	.87	1.42	.438	4	3BX
T320NC05000-13R3BX	1/2 - 13	3.94	.94	1.58	.500	4	3BX

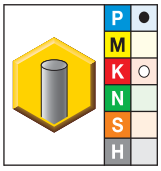
Shank Tolerance

D	tolerance h6
.250–.375	+0, -.0004
.438–.625	+0, -.0004



beyond

T320 • Form D Plug Chamfer • Metric • Solid Carbide • For Steel



● first choice
○ alternate choice

KC7542	D1 size	L	L3	L2	D	number of flutes	class of fit
T320M060X100R6HX	M6 X 1	70	12	23	6,0	3	6HX
T320M080X125R6HX	M8 X 1,25	80	15	28	8,0	3	6HX
T320M100X150R6HX	M10 X 1,5	90	18	33	10,0	4	6HX
T320M120X175R6HX	M12 X 1,75	100	21	40	12,0	4	6HX
T320MF140X150R6HX *	M14 X 1,5	110	24	47	12,0	4	6HX
T320M160X200R6HX	M16 X 2	110	24	53	14,0	4	6HX

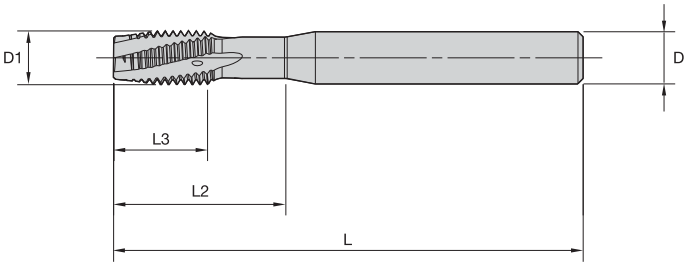
NOTE: Proprietary technology.
*Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

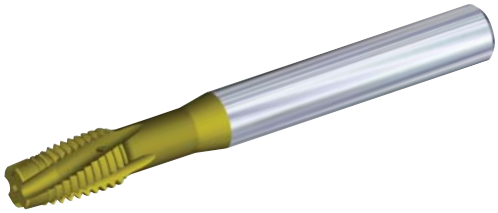
Shank Tolerance

D	tolerance h6
6	+0, -0,008
8–10	+0, -0,009
12–16	+0, -0,011

• KC7542 TiAlN + TiN for steel.

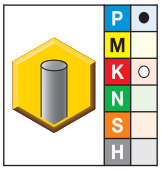






beyond

T321 • Form D Plug Chamfer • Through Coolant • Metric • Solid Carbide • For Steel



● first choice
○ alternate choice

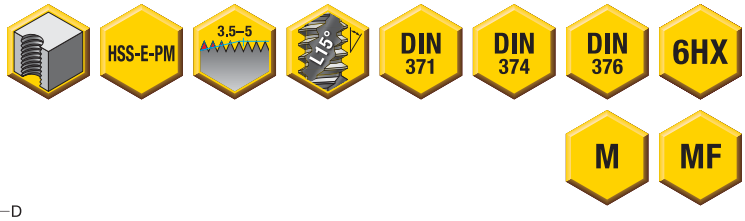
KC7542	D1 size	L	L3	L2	D	number of flutes	class of fit
T321M100X150R6HX	M10 X 1,5	90	18	33	10,0	4	6HX
T321MF120X150R6HX	M12 X 1,5	100	21	40	12,0	4	6HX
T321M120X175R6HX	M12 X 1,75	100	21	40	12,0	4	6HX
T321MF140X150R6HX	M14 X 1,5	110	24	47	12,0	4	6HX
T321M140X200R6HX	M14 X 2	110	24	47	12,0	4	6HX
T321M160X200R6HX *	M16 X 2	110	24	53	14,0	4	6HX

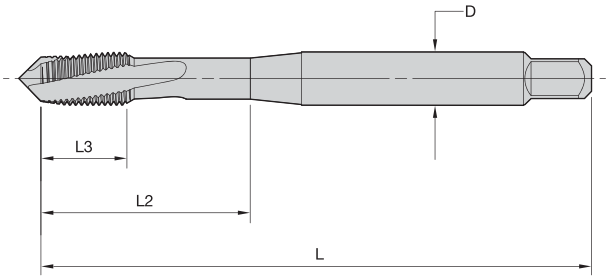
NOTE: Proprietary technology.
*Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

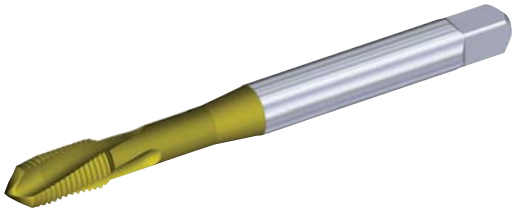
Shank Tolerance

D	tolerance h6
6	+0, -0,008
8–10	+0, -0,009
12–16	+0, -0,011

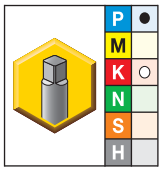
- KM6515 TiN + CrC/C for tapping stainless steel.
- KP6525 TiCN + TiN for tapping steel.

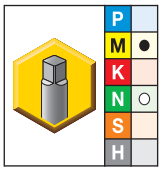






T620 • DIN 371, 374, and 376 • Form D Plug Chamfer • Metric • For Steel and Stainless Steel





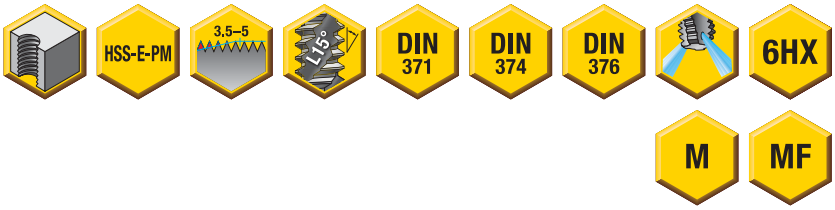
● first choice
○ alternate choice

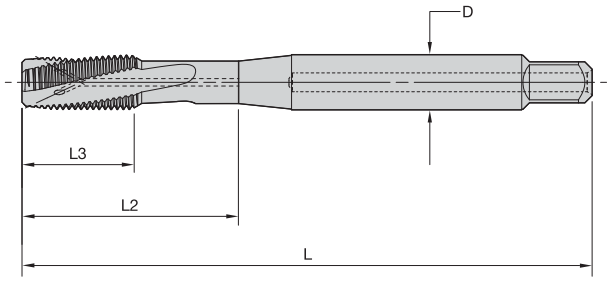
KP6525	KM6515	D1 size	L	L3	L2	D	number of flutes	dimension standard	class of fit
T620M030X050R6HX-D1	T620M030X050R6HX-D1	M3 X 0,5	56	8	18	3,5	2	DIN 371	6HX
T620M040X070R6HX-D1	T620M040X070R6HX-D1	M4 X 0,7	63	10	21	4,5	2	DIN 371	6HX
T620M050X080R6HX-D1	T620M050X080R6HX-D1	M5 X 0,8	70	10	25	6,0	2	DIN 371	6HX
T620M060X100R6HX-D1	T620M060X100R6HX-D1	M6 X 1	80	10	30	6,0	3	DIN 371	6HX
T620MF080X100R6HX-D4	T620MF080X100R6HX-D4	M8 X 1	90	13	35	6,0	3	DIN 374	6HX
T620M080X125R6HX-D1	T620M080X125R6HX-D1	M8 X 1,25	90	13	35	8,0	3	DIN 371	6HX
T620MF100X100R6HX-D4	T620MF100X100R6HX-D4	M10 X 1	90	10	35	7,0	3	DIN 374	6HX
T620MF100X125R6HX-D4	—	M10 X 1,25	100	15	39	7,0	3	DIN 374	6HX
T620M100X150R6HX-D1	T620M100X150R6HX-D1	M10 X 1,5	100	15	39	10,0	3	DIN 371	6HX
T620MF120X150R6HX-D4	T620MF120X150R6HX-D4	M12 X 1,5	100	15	39	9,0	3	DIN 374	6HX
T620M120X175R6HX-D6	T620M120X175R6HX-D6	M12 X 1,75	110	18	44	9,0	3	DIN 376	6HX
T620MF140X150R6HX-D4	T620MF140X150R6HX-D4	M14 X 1,5	100	15	47	11,0	4	DIN 374	6HX
T620M140X200R6HX-D6	T620M140X200R6HX-D6	M14 X 2	110	20	52	11,0	4	DIN 376	6HX
T620MF160X150R6HX-D4	T620MF160X150R6HX-D4	M16 X 1,5	100	15	46	12,0	4	DIN 374	6HX
T620M160X200R6HX-D6	T620M160X200R6HX-D6	M16 X 2	110	20	51	12,0	4	DIN 376	6HX
T620MF180X150R6HX-D4	T620MF180X150R6HX-D4	M18 X 1,5	110	15	50	14,0	4	DIN 374	6HX
T620M200X250R6HX-D6	T620M200X250R6HX-D6	M20 X 2,5	140	25	64	16,0	4	DIN 376	6HX

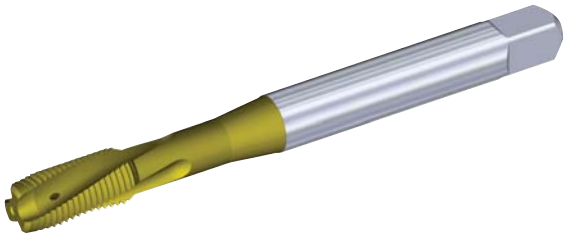
Shank Tolerance

D	tolerance h6
12–18	+0, -0,011
20–30	+0, -0,013
32–36	+0, -0,016

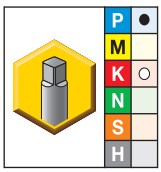
- KM6515 TiN + CrC/C for stainless steel.
- KP6525 TiCN + TiN for steel.

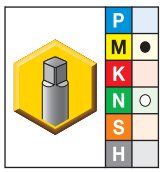






T621 • DIN 371, 374, and 376 • Form D Plug Chamfer • Through Coolant • Metric • For Steel and Stainless Steel





● first choice
○ alternate choice

KP6525	KM6515	D1 size	L	L3	L2	D	number of flutes	dimension standard	class of fit
T621M050X080R6HX-D1	T621M050X080R6HX-D1	M5 X 0,8	70	10	25	6,0	2	DIN 371	6HX
T621M060X100R6HX-D1	T621M060X100R6HX-D1	M6 X 1	80	10	30	6,0	3	DIN 371	6HX
T621MF080X100R6HX-D4 *	T621MF080X100R6HX-D4 *	M8 X 1	90	13	35	6,0	3	DIN 374	6HX
T621M080X125R6HX-D1	T621M080X125R6HX-D1	M8 X 1,25	90	13	35	8,0	3	DIN 371	6HX
T621MF100X100R6HX-D4	T621MF100X100R6HX-D4	M10 X 1	90	10	35	7,0	3	DIN 374	6HX
T621MF100X125R6HX-D4	T621MF100X125R6HX-D4	M10 X 1,25	100	15	39	7,0	3	DIN 374	6HX
T621M100X150R6HX-D1	T621M100X150R6HX-D1	M10 X 1,5	100	15	39	10,0	3	DIN 371	6HX
T621MF120X125R6HX-D4	—	M12 X 1,25	100	15	39	9,0	3	DIN 374	6HX
T621MF120X150R6HX-D4	T621MF120X150R6HX-D4	M12 X 1,5	100	15	39	9,0	3	DIN 374	6HX
T621M120X175R6HX-D6	T621M120X175R6HX-D6	M12 X 1,75	110	18	44	9,0	3	DIN 376	6HX
T621MF140X125R6HX-D4	—	M14 X 1,25	100	15	47	11,0	4	DIN 374	6HX
T621MF140X150R6HX-D4	T621MF140X150R6HX-D4	M14 X 1,5	100	15	47	11,0	4	DIN 374	6HX
T621M140X200R6HX-D6	T621M140X200R6HX-D6	M14 X 2	110	20	52	11,0	4	DIN 376	6HX
T621MF160X150R6HX-D4	T621MF160X150R6HX-D4	M16 X 1,5	100	15	46	12,0	4	DIN 374	6HX
T621M160X200R6HX-D6	T621M160X200R6HX-D6	M16 X 2	110	20	51	12,0	4	DIN 376	6HX
T621MF180X150R6HX-D4	T621MF180X150R6HX-D4	M18 X 1,5	110	15	50	14,0	4	DIN 374	6HX
T621M180X250R6HX-D6	T621M180X250R6HX-D6	M18 X 2,5	125	25	58	14,0	4	DIN 376	6HX

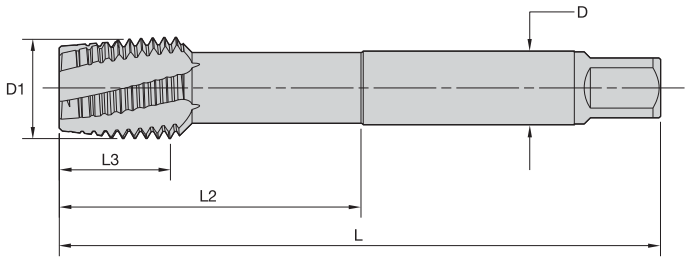
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

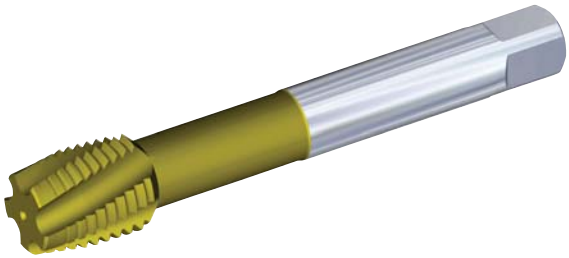
Shank Tolerance

D	tolerance h6
6	+0, -0,008
8–10	+0, -0,009
12–16	+0, -0,011

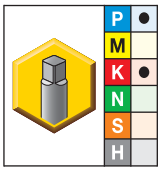
- KP6525 TiCN + TiN for tapping steel and cast iron.







T620 • DIN 376 • Form D Plug Chamfer • Large Sizes • Metric • For Steel and Cast Iron



● first choice
○ alternate choice

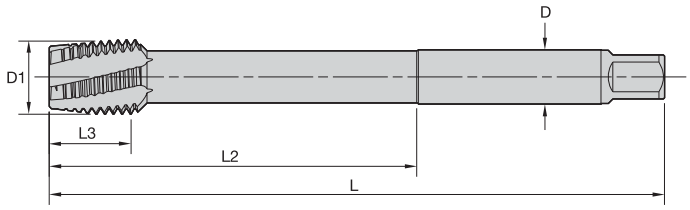
KP6525	D1 size	L	L3	L2	D	number of flutes	dimension standard	class of fit
T620M240X300R6HX-D6	M24 X 3	160	30	77	18,0	5	DIN 376	6HX
T620M300X350R6HX-D6	M30 X 3,5	180	35	91	22,0	5	DIN 376	6HX
T620M330X350R6HX-D6	M33 X 3,5	180	35	100	25,0	5	DIN 376	6HX
T620M360X400R6HX-D6	M36 X 4	200	40	110	28,0	6	DIN 376	6HX
T620M420X450R6HX-D6	M42 X 4,5	200	45	120	32,0	6	DIN 376	6HX

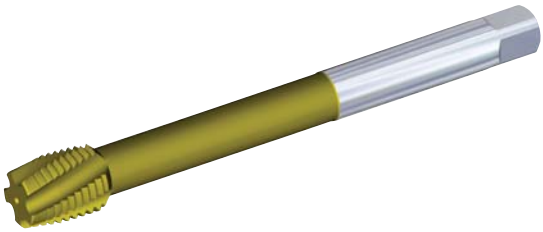
Shank Tolerance

D	tolerance h6
12–18	+0, -0,011
20–30	+0, -0,013
32–36	+0, -0,016

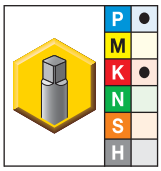
- KP6525 TiCN + TiN for tapping steel and cast iron.







T620 • Extra Long • Form D Plug Chamfer • Larger Sizes • Metric • For Steel and Cast Iron



● first choice
○ alternate choice

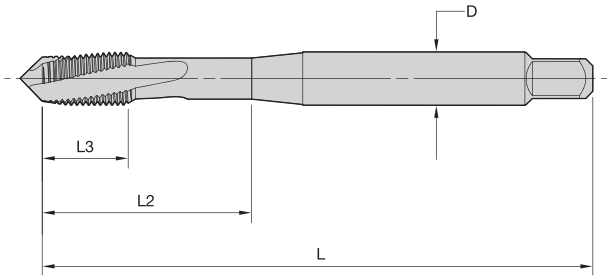
KP6525	D1 size	L	L3	L2	D	number of flutes	class of fit
T620M240X300R6H-XL	M24 X 3	200	30	120	18,0	5	6HX
T620M300X350R6H-XL	M30 X 3,5	250	35	150	22,0	5	6HX
T620M330X350R6H-XL	M33 X 3,5	250	35	150	25,0	5	6HX
T620M360X400R6H-XL	M36 X 4	250	40	150	28,0	6	6HX
T620M420X450R6H-XL	M42 X 4,5	300	45	180	32,0	6	6HX

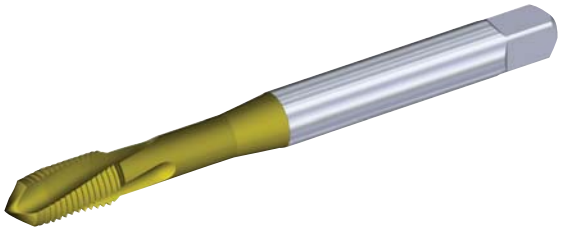
Shank Tolerance

D	tolerance h6
12–18	+0, -0,011
20–30	+0, -0,013
32–36	+0, -0,016

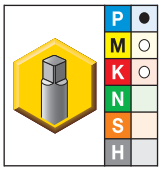
- KP6525 TiCN + TiN for steel.







T620 • DIN 371 and 376 • Form D Plug Chamfer • Machine Screw and Fractional • For Steel and Stainless Steel



● first choice
○ alternate choice

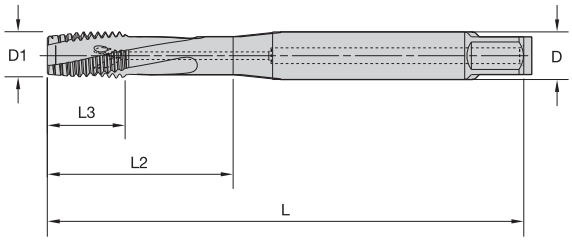
KP6525	D1 size	L	L3	L2	D	number of flutes	dimension standard	class of fit
T620NC#06-32R2BX-D1	6 - 32	56	9	20	4,0	2	DIN 371	2BX
T620NF#06-40R2BX-D1	6 - 40	56	9	20	4,0	2	DIN 371	2BX
T620NC#08-32R2BX-D1	8 - 32	63	10	21	4,5	2	DIN 371	2BX
T620NC#10-24R2BX-D1	10 - 24	70	10	25	6,0	3	DIN 371	2BX
T620NF#10-32R2BX-D1	10 - 32	70	10	25	6,0	3	DIN 371	2BX
T620NC02500-20R3BX-D1	1/4 - 20	80	13	30	7,0	3	DIN 371	3BX
T620NF02500-28R3BX-D1	1/4 - 28	80	13	30	7,0	3	DIN 371	3BX
T620NC03125-18R3BX-D1	5/16 - 18	90	13	35	8,0	3	DIN 371	3BX
T620NF03125-24R3BX-D1	5/16 - 24	90	13	35	8,0	3	DIN 371	3BX
T620NC04375-14R3BX-D6	7/16 - 14	100	15	41	8,0	3	DIN 376	3BX
T620NF04375-20R3BX-D6	7/16 - 20	100	15	41	8,0	3	DIN 376	3BX
T620NC03750-16R3BX-D1	3/8 - 16	100	16	39	10,0	3	DIN 371	3BX
T620NF03750-24R3BX-D1	3/8 - 24	100	16	39	10,0	3	DIN 371	3BX
T620NC05000-13R3BX-D6	1/2 - 13	110	20	47	9,0	3	DIN 376	3BX
T620NF05000-20R3BX-D6	1/2 - 20	110	20	47	9,0	3	DIN 376	3BX

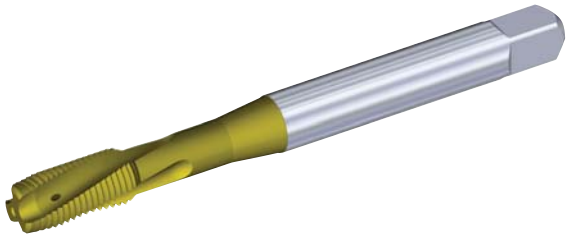
Shank Tolerance

D fractional	tolerance h6
>3–6	+0, -0,008
>6–10	+0, -0,009
<10–18	+0, -0,011

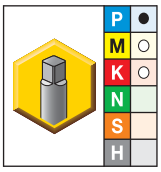
- KP6525 TiCN + TiN for steel.







T621 • DIN 371 and 376 • Form D Plug Chamfer • Through Coolant • Fractional • For Steel and Stainless Steel



● first choice
○ alternate choice

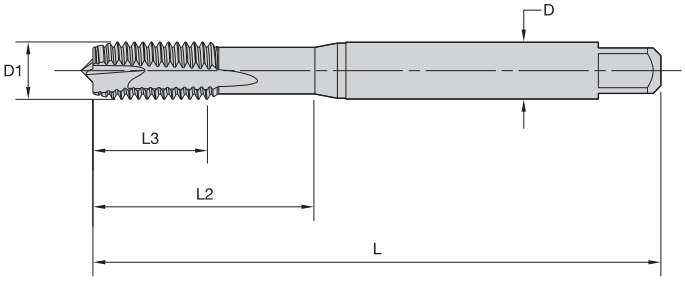
KP6525	D1 size	L	L3	L2	D	number of flutes	dimension standard	class of fit
T621NC02500-20R3BX-D1	1/4 - 20	80	13	30	7,0	3	DIN 371	3BX
T621NF02500-28R3BX-D1	1/4 - 28	80	13	30	7,0	3	DIN 371	3BX
T621NC03125-18R3BX-D1	5/16 - 18	90	13	35	8,0	3	DIN 371	3BX
T621NF03125-24R3BX-D1	5/16 - 24	90	13	35	8,0	3	DIN 371	3BX
T621NC03750-16R3BX-D1	3/8 - 16	100	16	39	10,0	3	DIN 371	3BX
T621NF03750-24R3BX-D1	3/8 - 24	100	16	39	10,0	3	DIN 371	3BX
T621NC04375-14R3BX-D6	7/16 - 14	100	15	41	8,0	3	DIN 376	3BX
T621NF04375-20R3BX-D6	7/16 - 20	100	15	41	8,0	3	DIN 376	3BX
T621NC05000-13R3BX-D6	1/2 - 13	110	20	47	9,0	3	DIN 376	3BX
T621NF05000-20R3BX-D6	1/2 - 20	110	20	47	9,0	3	DIN 376	3BX

Shank Tolerance

D fractional	tolerance h6
>3–6	+0, -0,008
>6–10	+0, -0,009
<10–18	+0, -0,011

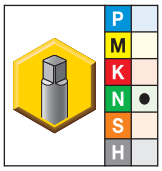
- KSN38 DLC for tapping aluminium.







T670 • DIN 371 and 376 • Form B Plug Chamfer • Metric • For Aluminium



● first choice
○ alternate choice

KSN38	D1 size	L	L3	L2	D	number of flutes	dimension standard	class of fit
T670M030X050R6H-D1	M3 X 0,5	56	11	18	3,5	2	DIN 371	6H
T670M040X070R6H-D1	M4 X 0,7	63	13	21	4,5	2	DIN 371	6H
T670M050X080R6H-D1	M5 X 0,8	70	15	25	6,0	2	DIN 371	6H
T670M060X100R6H-D1	M6 X 1	80	17	30	6,0	2	DIN 371	6H
T670M080X125R6H-D1 *	M8 X 1,25	90	20	35	8,0	2	DIN 371	6H
T670M100X150R6H-D1	M10 X 1,5	100	22	39	10,0	2	DIN 371	6H
T670M120X175R6H-D6	M12 X 1,75	110	24	—	9,0	3	DIN 376	6H
T670M160X200R6H-D6	M16 X 2	110	27	—	12,0	3	DIN 376	6H

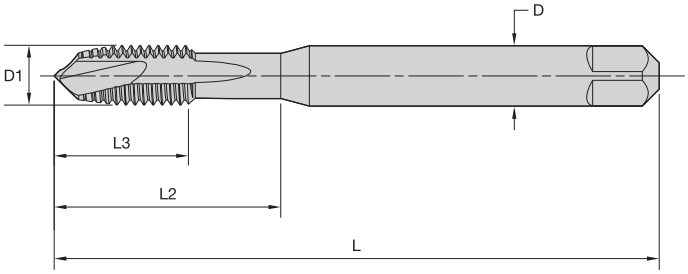
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

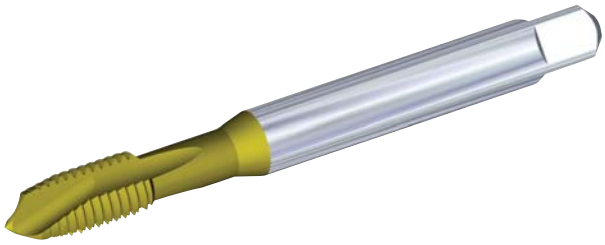
Shank Tolerance

D	tolerance h9
1–3	+0, -0,025
3,5–6	+0, -0,030
7–10	+0, -0,036
11–18	+0, -0,043

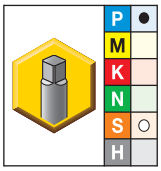
- KSP21 TiN for tapping steel 32–44 HRC.







T600 • DIN 371, 374, and 376 • Form B Plug Chamfer • Metric • For Hard Steel



● first choice
○ alternate choice

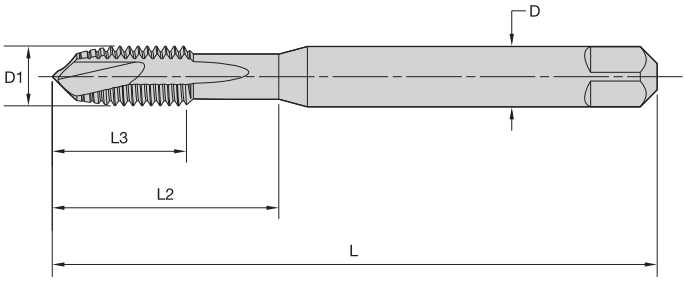
KSP21	D1 size	L	L3	L2	D	number of flutes	dimension standard	class of fit
T600M030X050R6HX-D1	M3 X 0,5	56	11	18	3,5	2	DIN 371	6HX
T600M040X070R6HX-D1	M4 X 0,7	63	13	21	4,5	2	DIN 371	6HX
T600M050X080R6HX-D1	M5 X 0,8	70	15	25	6,0	2	DIN 371	6HX
T600M060X100R6HX-D1	M6 X 1	80	17	30	6,0	3	DIN 371	6HX
T600MF080X100R6HX-D4	M8 X 1	90	17	–	6,0	3	DIN 374	6HX
T600M080X125R6HX-D1	M8 X 1,25	90	20	35	8,0	3	DIN 371	6HX
T600MF100X100R6HX-D4	M10 X 1	90	18	–	7,0	3	DIN 374	6HX
T600MF100X125R6HX-D4	M10 X 1,25	100	22	–	7,0	3	DIN 374	6HX
T600M100X150R6HX-D1	M10 X 1,5	100	22	39	10,0	3	DIN 371	6HX
T600MF120X125R6HX-D4	M12 X 1,25	100	22	–	9,0	3	DIN 374	6HX
T600MF120X150R6HX-D4	M12 X 1,5	100	22	–	9,0	3	DIN 374	6HX
T600M120X175R6HX-D6	M12 X 1,75	110	24	–	9,0	3	DIN 376	6HX
T600MF140X150R6HX-D4	M14 X 1,5	100	22	–	11,0	3	DIN 374	6HX
T600M140X200R6HX-D6	M14 X 2	110	26	–	11,0	3	DIN 376	6HX
T600MF160X150R6HX-D4	M16 X 1,5	100	22	–	12,0	4	DIN 374	6HX
T600M160X200R6HX-D6	M16 X 2	110	27	–	12,0	4	DIN 376	6HX
T600M180X250R6HX-D6	M18 X 2	125	30	–	14,0	4	DIN 376	6HX
T600M200X250R6HX-D6	M20 X 2,5	140	32	–	16,0	4	DIN 376	6HX

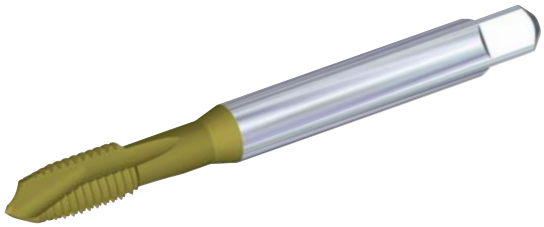
Shank Tolerance

D	tolerance h9
1–3	+0, -0,025
3,5–6	+0, -0,030
7–10	+0, -0,036
11–18	+0, -0,043

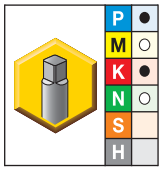
- KSP32 TiCN/TiN
- KSP39 oxide

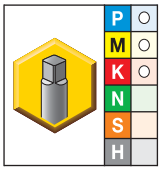






T820 • DIN 371, 374, and 376 • Form B Plug Chamfer • Metric



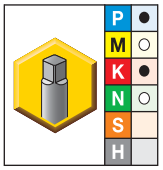


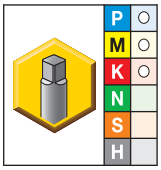
● first choice
○ alternate choice

KSP32	KSP39	D1 size	L	L3	L2	D	number of flutes	dimension standard	class of fit
T820M020X040R6H-D1	T820M020X040R6H-D1	M2 X 0,4	45	7	13	2,8	2	DIN 371	6H
–	T820M020X040R6G-D1	M2 X 0,4	45	7	13	2,8	2	DIN 371	6G
–	T820M025X045R6H-D1	M2,5 X 0,45	50	7	15	2,8	2	DIN 371	6H
–	T820M025X045R6G-D1	M2,5 X 0,45	50	7	15	2,8	2	DIN 371	6G
T820M030X050R6H-D1	T820M030X050R6H-D1	M3 X 0,5	56	8	18	3,5	2	DIN 371	6H
–	T820M030X050R6G-D1	M3 X 0,5	56	8	18	3,5	2	DIN 371	6G
–	T820M035X060R6H-D1	M3,5 X 0,6	56	9	20	4,0	2	DIN 371	6H
–	T820MF040X050R6H-D4	M4 X 0,5	63	10	21	2,8	2	DIN 374	6H
T820M040X070R6H-D1	T820M040X070R6H-D1	M4 X 0,7	63	11	21	4,5	2	DIN 371	6H
–	T820M040X070R6G-D1	M4 X 0,7	63	11	21	4,5	2	DIN 371	6G
–	T820MF050X050R6H-D4	M5 X 0,5	70	12	25	3,5	2	DIN 374	6H
T820M050X080R6H-D1	T820M050X080R6H-D1	M5 X 0,8	70	12	25	6,0	2	DIN 371	6H
–	T820M050X080R6G-D1	M5 X 0,8	70	12	25	6,0	2	DIN 371	6G
–	T820MF060X050R6H-D4	M6 X 0,5	80	12	30	4,5	3	DIN 374	6H
–	T820MF060X075R6H-D4	M6 X 0,75	80	12	30	4,5	3	DIN 374	6H
–	T820M060X100R6H-D6	M6 X 1	80	12	30	4,5	3	DIN 376	6H
T820M060X100R6H-D1	T820M060X100R6H-D1	M6 X 1	80	12	30	6,0	3	DIN 371	6H
–	T820M060X100R6G-D1	M6 X 1	80	12	30	6,0	3	DIN 371	6G
T820M070X100R6H-D1	T820M070X100R6H-D1	M7 X 1	80	12	30	7,0	3	DIN 371	6H
–	T820M070X100R6G-D1	M7 X 1	80	12	30	7,0	3	DIN 371	6G
–	T820MF080X100R6H-D4	M8 X 1	90	15	35	6,0	3	DIN 374	6H
–	T820M080X125R6H-D6	M8 X 1,25	90	15	35	6,0	3	DIN 376	6H
T820M080X125R6H-D1	T820M080X125R6H-D1	M8 X 1,25	90	15	35	8,0	3	DIN 371	6H
–	T820M080X125R6G-D1	M8 X 1,25	90	15	35	8,0	3	DIN 371	6G
–	T820MF100X100R6H-D4	M10 X 1	90	15	35	7,0	3	DIN 374	6H
–	T820MF100X125R6H-D4	M10 X 1,25	100	18	39	7,0	3	DIN 374	6H
–	T820M100X150R6H-D6	M10 X 1,5	100	18	39	7,0	3	DIN 376	6H
T820M100X150R6H-D1	T820M100X150R6H-D1	M10 X 1,5	100	18	39	10,0	3	DIN 371	6H
–	T820M100X150R6G-D1	M10 X 1,5	100	18	39	10,0	3	DIN 371	6G
–	T820MF120X100R6H-D4	M12 X 1	100	21	39	9,0	3	DIN 374	6H
–	T820MF120X125R6H-D4	M12 X 1,25	100	21	39	9,0	3	DIN 374	6H
–	T820MF120X150R6H-D4	M12 X 1,5	100	21	39	9,0	3	DIN 374	6H

(continued)

(T820 • DIN 371, 374, and 376 • Form B Plug Chamfer • Metric — continued)





● first choice
○ alternate choice

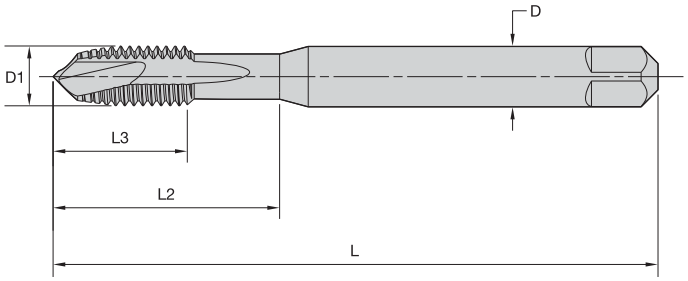
KSP32	KSP39	D1 size	L	L3	L2	D	number of flutes	dimension standard	class of fit
T820M120X175R6H-D6	**T820M120X175R6H-D6**	M12 X 1,75	110	21	44	9,0	3	DIN 376	6H
—	**T820M120X175R6G-D6**	M12 X 1,75	110	21	44	9,0	3	DIN 376	6G
—	**T820MF140X100R6H-D4**	M14 X 1	100	21	47	11,0	3	DIN 374	6H
—	**T820MF140X125R6H-D4**	M14 X 1,25	100	21	47	11,0	3	DIN 374	6H
—	**T820MF140X150R6H-D4**	M14 X 1,5	100	21	47	11,0	3	DIN 374	6H
T820M140X200R6H-D6	**T820M140X200R6H-D6**	M14 X 2	110	24	52	11,0	3	DIN 376	6H
—	**T820M140X200R6G-D6**	M14 X 2	110	24	52	11,0	3	DIN 376	6G
—	**T820MF160X100R6H-D4**	M16 X 1	100	21	46	12,0	3	DIN 374	6H
—	**T820MF160X150R6H-D4**	M16 X 1,5	100	21	46	12,0	3	DIN 374	6H
T820M160X200R6H-D6	**T820M160X200R6H-D6**	M16 X 2	110	24	51	12,0	3	DIN 376	6H
—	**T820M160X200R6G-D6**	M16 X 2	110	24	51	12,0	3	DIN 376	6G
—	**T820MF180X150R6H-D4**	M18 X 1,5	110	21	50	14,0	3	DIN 374	6H
—	**T820MF180X200R6H-D4**	M18 X 2	125	30	58	14,0	3	DIN 374	6H
T820M180X250R6H-D6	**T820M180X250R6H-D6**	M18 X 2,5	125	30	58	14,0	3	DIN 376	6H
—	**T820MF200X150R6H-D4**	M20 X 1,5	125	24	56	16,0	3	DIN 374	6H
—	**T820MF200X200R6H-D4**	M20 X 2	140	30	64	16,0	3	DIN 374	6H
T820M200X250R6H-D6	**T820M200X250R6H-D6**	M20 X 2,5	140	30	64	16,0	3	DIN 376	6H
—	**T820MF220X150R6H-D4**	M22 X 1,5	125	24	62	18,0	3	DIN 374	6H
—	**T820MF220X200R6H-D4**	M22 X 2	140	30	70	18,0	3	DIN 374	6H
—	**T820M220X250R6H-D6**	M22 X 2,5	140	30	70	18,0	3	DIN 376	6H
—	**T820MF240X150R6H-D4**	M24 X 1,5	140	28	67	18,0	3	DIN 374	6H
—	**T820M240X300R6H-D6**	M24 X 3	160	36	77	18,0	3	DIN 376	6H
—	**T820M270X300R6H-D6**	M27 X 3	160	36	82	20,0	4	DIN 376	6H
—	**T820M300X350R6H-D6**	M30 X 3,5	180	42	91	22,0	4	DIN 376	6H
—	**T820M330X350R6H-D6**	M33 X 3,5	180	42	100	25,0	4	DIN 376	6H
—	**T820M360X400R6H-D6**	M36 X 4	200	48	110	28,0	4	DIN 376	6H

Shank Tolerance

D mm	tolerance h9
1–3	+0, -0,025
>3–6	+0, -0,030
>6–10	+0, -0,036
>10–18	+0, -0,043
>18–30	+0, -0,052

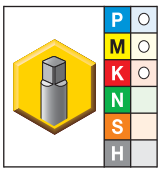
• KSP39 oxide







T820 • DIN 371 and 376 • Form B Plug Chamfer • UNC/UNF



● first choice
○ alternate choice

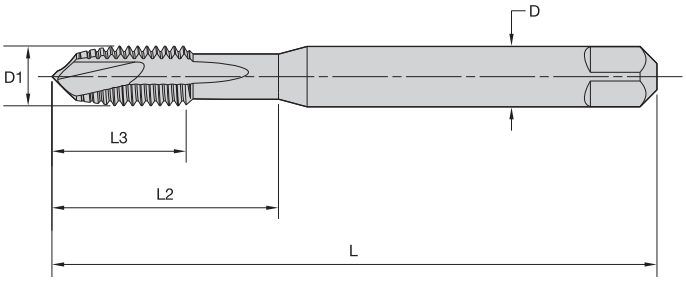
KSP39	metric dimensions D1 size	L	L3	L2	D	number of flutes	dimension standard	class of fit
T820NC#04-40R2B-D1	4 - 40	56	8	18	3,5	2	DIN 371	2B
T820NC#05-40R2B-D1	5 - 40	56	9	20	4,0	2	DIN 371	2B
T820NC#06-32R2B-D1	6 - 32	56	9	20	4,0	2	DIN 371	2B
T820NF#06-40R2B-D1	6 - 40	56	9	20	4,0	2	DIN 371	2B
T820NC#08-32R2B-D1	8 - 32	63	11	21	4,5	2	DIN 371	2B
T820NC#10-24R2B-D1	10 - 24	70	12	25	6,0	2	DIN 371	2B
T820NF#10-32R2B-D1	10 - 32	70	12	25	6,0	2	DIN 371	2B
T820NC02500-20R2B-D1	1/4 - 20	80	15	30	7,0	3	DIN 371	2B
T820NF02500-28R2B-D1	1/4 - 28	80	15	30	7,0	3	DIN 371	2B
T820NC03125-18R2B-D1	5/16 - 18	90	15	35	8,0	3	DIN 371	2B
T820NF03125-24R2B-D1	5/16 - 24	90	15	35	8,0	3	DIN 371	2B
T820NC03750-16R2B-D1	3/8 - 16	100	19	39	10,0	3	DIN 371	2B
T820NF03750-24R2B-D1	3/8 - 24	100	19	39	10,0	3	DIN 371	2B
T820NC04375-14R2B-D6	7/16 - 14	100	18	41	8,0	3	DIN 376	2B
T820NF04375-20R2B-D6	7/16 - 20	100	18	41	8,0	3	DIN 376	2B
T820NC05000-13R2B-D6	1/2 - 13	110	23	47	9,0	3	DIN 376	2B
T820NF05000-20R2B-D6	1/2 - 20	110	23	47	9,0	3	DIN 376	2B
T820NC05625-12R2B-D6	9/16 - 12	110	25	53	11,0	3	DIN 376	2B
T820NF05625-18R2B-D6	9/16 - 18	110	25	53	11,0	3	DIN 376	2B
T820NC06250-11R2B-D6	5/8 - 11	110	24	51	12,0	3	DIN 376	2B
T820NF06250-18R2B-D6	5/8 - 18	110	24	51	12,0	3	DIN 376	2B
T820NC07500-10R2B-D6	3/4 - 10	140	30	64	16,0	3	DIN 376	2B
T820NF07500-16R2B-D6	3/4 - 16	140	30	64	16,0	3	DIN 376	2B
T820NC08750-9R2B-D6	7/8 - 9	140	34	71	18,0	3	DIN 376	2B
T820NF08750-14R2B-D6	7/8 - 14	140	34	71	18,0	3	DIN 376	2B
T820NC10000-8R2B-D6	1 - 8	160	38	81	18,0	3	DIN 376	2B
T820NF10000-12R2B-D6	1 - 12	160	38	81	18,0	3	DIN 376	2B

Shank Tolerance

D mm	tolerance h9
1–3	+0, -0,025
>3–6	+0, -0,030
>6–10	+0, -0,036
>10–18	+0, -0,043
>18–30	+0, -0,052

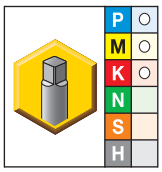
• KSP39 oxide







T820 • DIN 371 and 376 • Form B Plug Chamfer • UNJC/UNJF



● first choice
○ alternate choice

KSP39	metric dimensions D1 size	L	L3	L2	D	number of flutes	dimension standard	class of fit
T820NC#04-40R3B-D1	4 - 40	56	8	18	3,5	2	DIN 371	3B
T820NC#06-32R3B-D1	6 - 32	56	9	20	4,0	2	DIN 371	3B
T820NC#08-32R3B-D1	8 - 32	63	11	21	4,5	2	DIN 371	3B
T820NF#10-32R3B-D1	10 - 32	70	12	25	6,0	2	DIN 371	3B
T820NF02500-28R3B-D1	1/4 - 28	80	15	30	7,0	3	DIN 371	3B
T820NF03125-24R3B-D1	5/16 - 24	90	15	35	8,0	3	DIN 371	3B
T820NF03750-24R3B-D1	3/8 - 24	100	19	39	10,0	3	DIN 371	3B
T820NF04375-20R3B-D6	7/16 - 20	100	18	41	8,0	3	DIN 376	3B
T820NF05000-20R3B-D6	1/2 - 20	110	23	47	9,0	3	DIN 376	3B

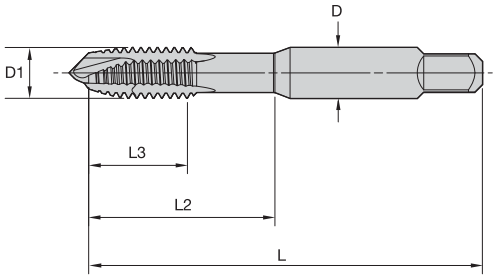
NOTE: Internal UNJC/UNJF threads may be produced with ground thread UNC/UNF taps.

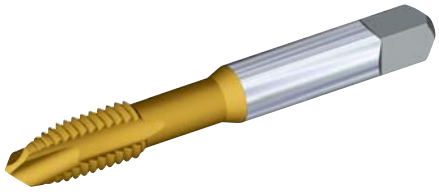
Shank Tolerance

D mm	tolerance h9
1–3	+0, -0,025
>3–6	+0, -0,030
>6–10	+0, -0,036
>10–18	+0, -0,043
>18–30	+0, -0,052

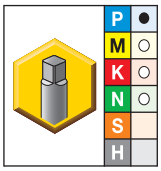
- KSU31 TiN
- KSU30 bright

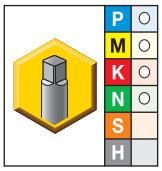






T820 • Form B Plug Chamfer • Metric • JIS





● first choice
○ alternate choice

KSU31	KSU30	D1 size	L	L3	L2	D	number of flutes	dimension standard	tap class
T820M030X050R6H-J	T820M030X050R6H-J	M3 X 0,5	46	11	19	4,0	2	JIS	ISO 2
T820M040X070R6H-J	T820M040X070R6H-J	M4 X 0,7	52	13	21	5,0	2	JIS	ISO 2
T820M050X080R6H-J	T820M050X080R6H-J	M5 X 0,8	60	16	24	5,5	2	JIS	ISO 2
T820M060X100R6H-J	T820M060X100R6H-J	M6 X 1	62	19	29	6,0	3	JIS	ISO 2
T820M080X125R6H-J	T820M080X125R6H-J	M8 X 1,25	70	22	37	6,2	3	JIS	ISO 2
T820M100X150R6H-J	T820M100X150R6H-J	M10 X 1,5	75	24	41	7,0	3	JIS	ISO 2
–	T820MF120X125R6H-J	M12 X 1,25	82	29	48	8,5	3	JIS	ISO 2
–	T820MF120X150R6H-J	M12 X 1,5	82	29	48	8,5	3	JIS	ISO 2
–	T820M120X175R6H-J	M12 X 1,75	82	29	48	8,5	3	JIS	ISO 2
–	T820MF140X150R6H-J	M14 X 1,5	88	30	48	10,5	3	JIS	ISO 2
–	T820M140X200R6H-J	M14 X 2	88	30	48	10,5	3	JIS	ISO 2
–	T820MF160X150R6H-J	M16 X 1,5	95	32	52	12,5	3	JIS	ISO 2
–	T820M160X200R6H-J	M16 X 2	95	32	52	12,5	3	JIS	ISO 2
–	T820M180X250R6H-J	M18 X 2,5	100	37	55	14,0	3	JIS	ISO 2
–	T820M200X250R6H-J	M20 X 2,5	105	37	60	15,0	3	JIS	ISO 2

Shank Tolerance

D mm	tolerance h9
1–3	+0, -0,025
>3–6	+0, -0,030
>6–10	+0, -0,036
>10–18	+0, -0,043
>18–30	+0, -0,052

NOVO KNOWS SEARCH

Searching for a tool has been enhanced by Advise and Select functions from NOVO™ applications — saving you time and money.

ADVISE

Uses a rules-based approach to provide cutting tool recommendations:

- Define Machining Feature (face milling, slotting, blind hole, etc.)
- Apply Constraint Requirements (geometric, material, tolerance, etc.)
- Set Machining Sequence (single or multi-step operations, rough then finish, etc.)
- Receive Ranked Results

SELECT

A method of selecting cutting tools from a tree structure via a hierarchy or parametric search:

- If you know which product you are looking for, a quick search can be performed by just the catalogue number or product description.
- Smart filters significantly reduce the amount of potential tooling solutions.
- After the tool is selected, NOVO also provides cutting and adaptive item options that fit with your solution.

NOVO applications can ensure you have the right tools on your machines, in the right sequence. Resulting in flawless execution that accelerates every job, and maximises every shift. **kennametal.com/novo**

Spiral-Flute Taps



High-Performance Taps for Blind-Hole Applications

- Steel and steel alloys.
- Stainless steel.
- Cast iron.
- Nickel- and cobalt-based alloys.
- Titanium and titanium alloys.
- Aluminium.
- Hard steel.

High-Performance Beyond™ Solid Carbide Taps

- Right-hand spiral flute with through coolant for efficient chip evacuation at high spindle speeds.
- Runs up to 4x faster and 4x longer than conventional high-speed steel (HSS) taps.
- Ideal for long production runs where fewer tool changes result in greater productivity.
- For use on CNC machines with synchronous or rigid controls and precision toolholders.

High-Performance Beyond™ HSS-E-PM Taps

- Right-hand spiral flutes with the flute form and helix angle optimised for material-specific applications.
- Higher strength and wider range of applications versus solid carbide taps.
- Higher tapping speed capability and longer tool life than conventional HSS-E taps.
- Can be used on either conventional or synchronous tapping machines with rigid or synchronous tap holders.

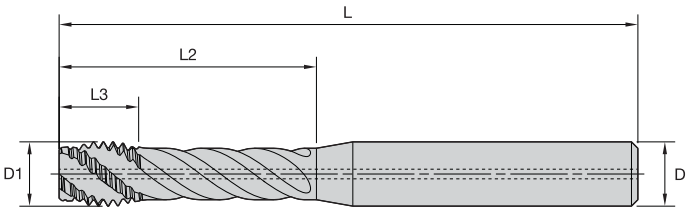


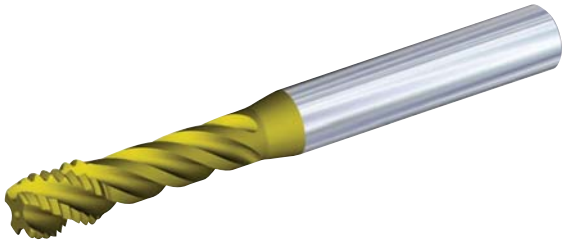
Multipurpose HSS-E GOtap™ Taps

- Advanced spiral-flute geometry designed for free cutting action and efficient chip evacuation in blind holes.
- Manufactured with high vanadium HSS-E material for exceptional wear characteristics and longer tool life.
- Advanced PVD coatings to reduce tapping torque, resulting in high-quality thread finish and longer tool life.
- For use in both synchronous and non-synchronous machines, including rigid, synchronous, and tension/compression tap holders.

- KC7542 TiAlN + TiN for steel.

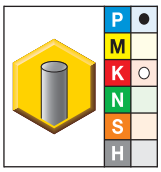






beyond

T331 • Form C Semi-Bottoming Chamfer • Through Coolant • Inch • Solid Carbide • For Steel



● first choice
○ alternate choice

KC7542	D1 size	L	L3	L2	D	number of flutes	class of fit
T331NC2500-20R3BX	1/4 - 20	2.76	.39	.94	.250	3	3BX
T331NF2500-28R3BX	1/4 - 28	2.76	.39	.94	.250	3	3BX
T331NC3125-18R3BX	5/16 - 18	3.15	.47	1.26	.313	3	3BX
T331NC3750-16R3BX	3/8 - 16	3.54	.51	1.57	.375	4	3BX
T331NC4375-14R3BX	7/16 - 14	3.94	.59	1.73	.438	4	3BX
T331NC5000-13R3BX *	1/2 - 13	3.94	.63	1.89	.500	4	3BX

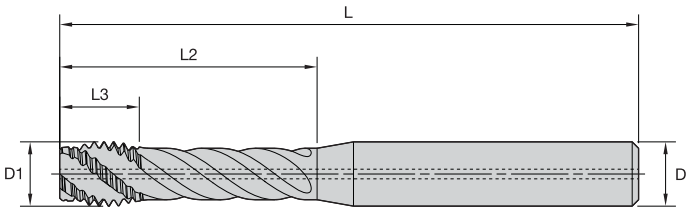
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

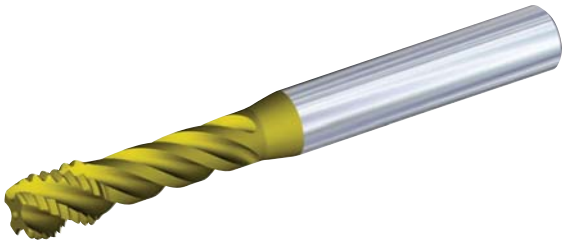
Shank Tolerance

D	tolerance h6
.250–.375	+0, -.0004
.438–.625	+0, -.0004

• KC7542 TiAlN + TiN for steel.

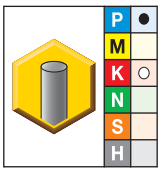






beyond

T331 • Form C Semi-Bottoming Chamfer • Through Coolant • Metric • Solid Carbide • For Steel



● first choice
○ alternate choice

KC7542	D1 size	L	L3	L2	D	number of flutes	class of fit
T331M060X100R6HX	M6 X 1	70	8	24	6,0	3	6HX
T331M080X125R6HX	M8 X 1,25	80	10	32	8,0	3	6HX
T331M100X150R6HX	M10 X 1,5	90	12	40	10,0	4	6HX
T331MF120X150R6HX	M12 X 1,5	100	14	48	12,0	4	6HX
T331M120X175R6HX	M12 X 1,75	100	14	48	12,0	4	6HX
T331MF140X150R6HX	M14 X 1,5	110	16	56	12,0	4	6HX
T331M140X200R6HX	M14 X 2	110	16	56	12,0	4	6HX
T331M160X200R6HX	M16 X 2	110	16	64	14,0	4	6HX

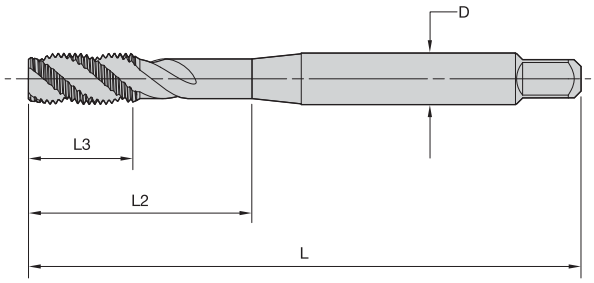
NOTE: Proprietary technology.

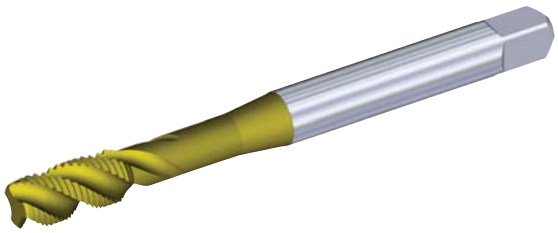
Shank Tolerance

D	tolerance h6
6	+0, -0,008
8–10	+0, -0,009
12–16	+0, -0,011

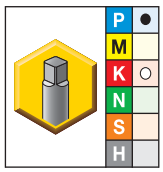
- KM6515 TiN + CrC/C for stainless steel.
- KP6525 TiCN + TiN for steel.

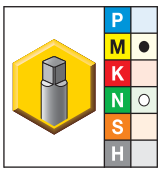






T630 • DIN 371, 374, and 376 • Form C Semi-Bottoming Chamfer • Metric • For Steel and Stainless Steel • Rigid and Synchronous Holders





● first choice
○ alternate choice

KP6525	KM6515	D1 size	L	L3	L2	D	number of flutes	dimension standard	class of fit
T630M030X050R6HX-D1	T630M030X050R6HX-D1	M3 X 0,5	56	8	18	3,5	3	DIN 371	6HX
T630M040X070R6HX-D1	T630M040X070R6HX-D1	M4 X 0,7	63	10	21	4,5	3	DIN 371	6HX
T630M050X080R6HX-D1	T630M050X080R6HX-D1	M5 X 0,8	70	10	25	6,0	3	DIN 371	6HX
T630M060X100R6HX-D1	T630M060X100R6HX-D1	M6 X 1	80	10	30	6,0	3	DIN 371	6HX
T630MF080X100R6HX-D4	T630MF080X100R6HX-D4	M8 X 1	90	13	35	6,0	3	DIN 374	6HX
T630M080X125R6HX-D1	T630M080X125R6HX-D1	M8 X 1,25	90	13	35	8,0	3	DIN 371	6HX
T630MF100X100R6HX-D4	T630MF100X100R6HX-D4	M10 X 1	90	10	35	7,0	3	DIN 374	6HX
T630MF100X125R6HX-D4	T630MF100X125R6HX-D4	M10 X 1,25	100	15	39	7,0	3	DIN 374	6HX
T630M100X150R6HX-D1	T630M100X150R6HX-D1	M10 X 1,5	100	15	39	10,0	3	DIN 371	6HX
T630MF120X150R6HX-D4	T630MF120X150R6HX-D4	M12 X 1,5	100	15	39	9,0	4	DIN 374	6HX
T630M120X175R6HX-D6	T630M120X175R6HX-D6	M12 X 1,75	110	18	44	9,0	4	DIN 376	6HX
T630MF140X150R6HX-D4	T630MF140X150R6HX-D4	M14 X 1,5	100	15	47	11,0	4	DIN 374	6HX
T630M140X200R6HX-D6	T630M140X200R6HX-D6	M14 X 2	110	20	52	11,0	4	DIN 376	6HX
T630MF160X150R6HX-D4	T630MF160X150R6HX-D4	M16 X 1,5	100	15	46	12,0	4	DIN 374	6HX
T630M160X200R6HX-D6	T630M160X200R6HX-D6	M16 X 2	110	20	51	12,0	4	DIN 376	6HX
T630MF180X150R6HX-D4	T630MF180X150R6HX-D4	M18 X 1,5	110	15	50	14,0	4	DIN 374	6HX
T630M180X250R6HX-D6	T630M180X250R6HX-D6	M18 X 2,5	125	25	58	14,0	4	DIN 376	6HX

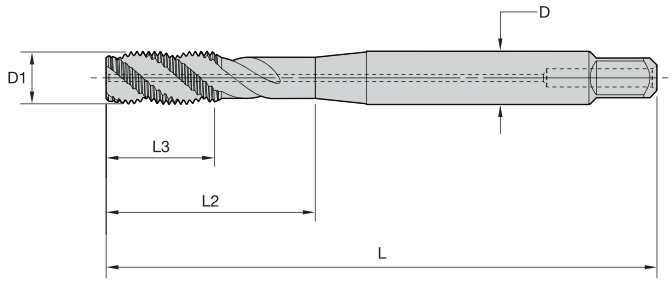
NOTE: Suggested for use in rigid and synchronous holders.

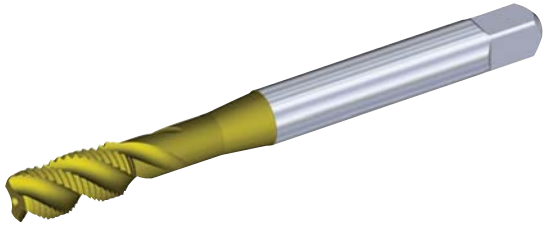
Shank Tolerance

D	tolerance h6
6	+0, -0,008
8–10	+0, -0,009
12–16	+0, -0,011

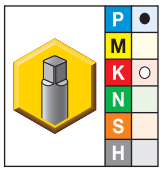
- KM6515 TiN + CrC/C for stainless steel.
- KP6525 TiCN + TiN for steel.

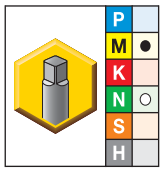






T631 • DIN 371, 374, and 376 • Form C Semi-Bottoming Chamfer • Through Coolant • Metric • For Steel and Stainless Steel • Rigid and Synchronous Holders





● first choice
○ alternate choice

KP6525	KM6515	D1 size	L	L3	L2	D	number of flutes	dimension standard	class of fit
T631M050X080R6HX-D1	T631M050X080R6HX-D1	M5 X 0,8	70	10	25	6,0	3	DIN 371	6HX
T631M060X100R6HX-D1	T631M060X100R6HX-D1	M6 X 1	80	10	30	6,0	3	DIN 371	6HX
T631MF080X100R6HX-D4	T631MF080X100R6HX-D4	M8 X 1	90	13	35	6,0	3	DIN 374	6HX
T631M080X125R6HX-D1	T631M080X125R6HX-D1	M8 X 1,25	90	13	35	8,0	3	DIN 371	6HX
T631MF100X100R6HX-D4	T631MF100X100R6HX-D4	M10 X 1	90	10	35	7,0	3	DIN 374	6HX
T631MF100X125R6HX-D4	T631MF100X125R6HX-D4	M10 X 1,25	100	15	39	7,0	3	DIN 374	6HX
T631M100X150R6HX-D1	T631M100X150R6HX-D1	M10 X 1,5	100	15	39	10,0	3	DIN 371	6HX
T631MF120X125R6HX-D4	T631MF120X125R6HX-D4	M12 X 1,25	100	15	39	9,0	4	DIN 374	6HX
T631MF120X150R6HX-D4	T631MF120X150R6HX-D4	M12 X 1,5	100	15	39	9,0	4	DIN 374	6HX
T631M120X175R6HX-D6	T631M120X175R6HX-D6	M12 X 1,75	110	18	44	9,0	4	DIN 376	6HX
T631MF140X125R6HX-D4	T631MF140X125R6HX-D4	M14 X 1,25	100	15	47	11,0	4	DIN 374	6HX
T631MF140X150R6HX-D4	T631MF140X150R6HX-D4	M14 X 1,5	100	15	47	11,0	4	DIN 374	6HX
T631M140X200R6HX-D6	T631M140X200R6HX-D6	M14 X 2	110	20	52	11,0	4	DIN 376	6HX
T631MF160X150R6HX-D4	T631MF160X150R6HX-D4	M16 X 1,5	100	15	46	12,0	4	DIN 374	6HX
T631M160X200R6HX-D6	T631M160X200R6HX-D6	M16 X 2	110	20	51	12,0	4	DIN 376	6HX
T631MF180X150R6HX-D4	T631MF180X150R6HX-D4	M18 X 1,5	110	15	50	14,0	4	DIN 374	6HX
T631M180X250R6HX-D6	T631M180X250R6HX-D6	M18 X 2,5	125	25	58	14,0	4	DIN 376	6HX

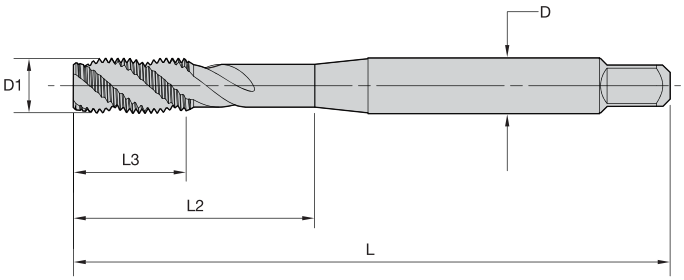
NOTE: Suggested for use in rigid and synchronous holders.

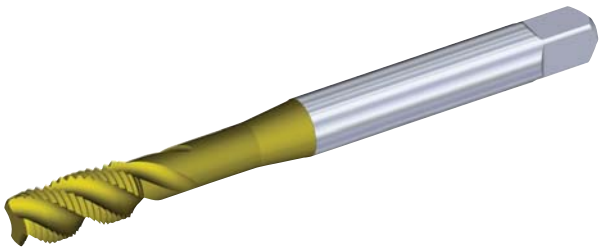
Shank Tolerance

D	tolerance h6
6	+0, -0,008
8–10	+0, -0,009
12–16	+0, -0,011

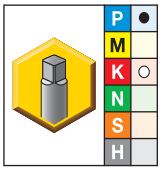
- KP6525 TiCN + TiN for tapping steel.







T632 • DIN 371, 374, and 376 • Form E Bottoming Chamfer • Metric • For Steel • Rigid and Synchronous Holders



● first choice
○ alternate choice

KP6525	D1 size	L	L3	L2	D	number of flutes	dimension standard	class of fit
T632M050X080R6HX-D1	M5 X 0,8	70	10	25	6,0	3	DIN 371	6HX
T632M060X100R6HX-D1	M6 X 1	80	10	30	6,0	3	DIN 371	6HX
T632M080X125R6HX-D1	M8 X 1,25	90	13	35	8,0	3	DIN 371	6HX
T632M100X150R6HX-D1	M10 X 1,5	100	15	39	10,0	3	DIN 371	6HX
T632MF120X150R6HX-D4	M12 X 1,5	100	15	39	9,0	4	DIN 374	6HX
T632M120X175R6HX-D6	M12 X 1,75	110	18	44	9,0	4	DIN 376	6HX
T632MF140X150R6HX-D4	M14 X 1,5	100	15	47	11,0	4	DIN 374	6HX
T632M140X200R6HX-D6	M14 X 2	110	20	52	11,0	4	DIN 376	6HX
T632MF160X150R6HX-D4	M16 X 1,5	100	15	46	12,0	4	DIN 374	6HX

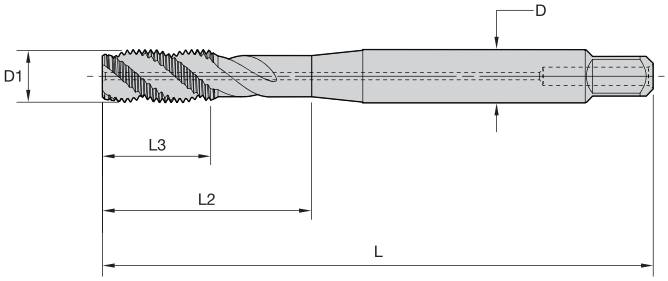
NOTE: Suggested for use in rigid and synchronous holders.

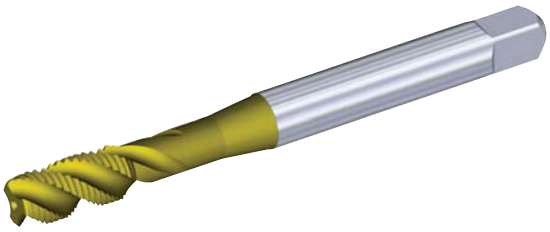
Shank Tolerance

D	tolerance h6
6	+0, -0,008
8–10	+0, -0,009
12–16	+0, -0,011

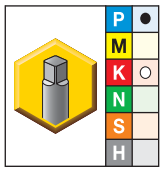
• KP6525 TiCN + TiN for tapping steel.







T633 • DIN 371, 374, and 376 • Form E Bottoming Chamfer • Through Coolant • Metric • For Steel • Rigid and Synchronous Holders



● first choice
○ alternate choice

KP6525	D1 size	L	L3	L2	D	number of flutes	dimension standard	class of fit
T633M050X080R6HX-D1	M5 X 0,8	70	10	25	6,0	3	DIN 371	6HX
T633M060X100R6HX-D1	M6 X 1	80	10	30	6,0	3	DIN 371	6HX
T633M080X125R6HX-D1	M8 X 1,25	90	13	35	8,0	3	DIN 371	6HX
T633M100X150R6HX-D1	M10 X 1,5	100	15	39	10,0	3	DIN 371	6HX
T633MF120X150R6HX-D4	M12 X 1,5	100	15	39	9,0	4	DIN 374	6HX
T633M120X175R6HX-D6	M12 X 1,75	110	18	44	9,0	4	DIN 376	6HX
T633MF140X150R6HX-D4	M14 X 1,5	100	15	47	11,0	4	DIN 374	6HX
T633M140X200R6HX-D6	M14 X 2	110	20	52	11,0	4	DIN 376	6HX
T633MF160X150R6HX-D4	M16 X 1,5	100	15	46	12,0	4	DIN 374	6HX

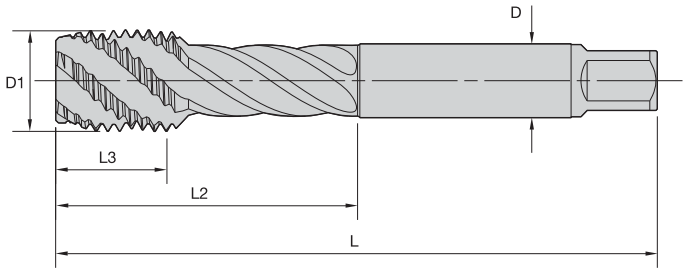
NOTE: Suggested for use in rigid and synchronous holders.

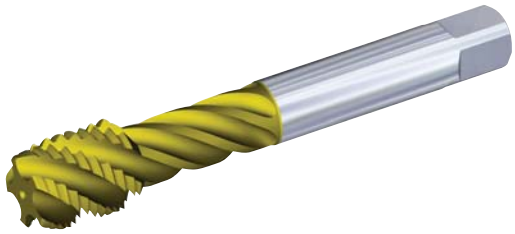
Shank Tolerance

D	tolerance h6
6	+0, -0,008
8–10	+0, -0,009
12–16	+0, -0,011

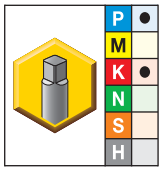
- KP6525 TiCN + TiN for tapping steel and cast iron.







T630 • DIN 376 • Form C Semi-Bottoming Chamfer • Larger Sizes • Metric • For Steel and Cast Iron • Rigid and Synchronous Holders



● first choice
○ alternate choice

KP6525	D1 size	L	L3	L2	D	number of flutes	dimension standard	class of fit
T630M240X300R6HX-D6	M24 X 3	160	30	77	18,0	5	DIN 376	6HX
T630M300X350R6HX-D6	M30 X 3,5	180	35	91	22,0	5	DIN 376	6HX
T630M330X350R6HX-D6	M33 X 3,5	180	35	100	25,0	5	DIN 376	6HX
T630M360X400R6HX-D6	M36 X 4	200	40	110	28,0	5	DIN 376	6HX
T630M420X450R6HX-D6	M42 X 4,5	200	45	120	32,0	5	DIN 376	6HX

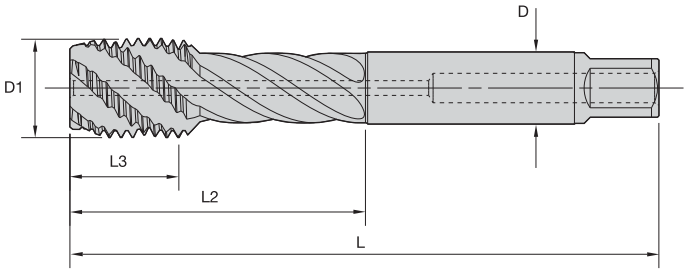
NOTE: Suggested for use in rigid and synchronous holders.

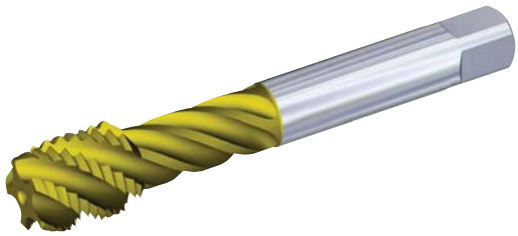
Shank Tolerance

D	tolerance h6
12–18	+0, -0,011
20–30	+0, -0,013
32–36	+0, -0,016

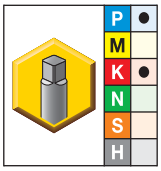
- KP6525 TiCN + TiN for tapping steel and cast iron.







T631 • DIN 376 • Form C Semi-Bottoming Chamfer • Through Coolant • Larger Sizes • Metric • For Steel and Cast Iron • Rigid and Synchronous Holders



● first choice
○ alternate choice

KP6525	D1 size	L	L3	L2	D	number of flutes	dimension standard	class of fit
T631M240X300R6HX-D6	M24 X 3	160	30	77	18,0	5	DIN 376	6HX
T631M300X350R6HX-D6	M30 X 3,5	180	35	91	22,0	5	DIN 376	6HX
T631M330X350R6HX-D6	M33 X 3,5	180	35	100	25,0	5	DIN 376	6HX
T631M360X400R6HX-D6	M36 X 4	200	40	110	28,0	5	DIN 376	6HX
T631M420X450R6HX-D6	M42 X 4,5	200	45	120	32,0	5	DIN 376	6HX

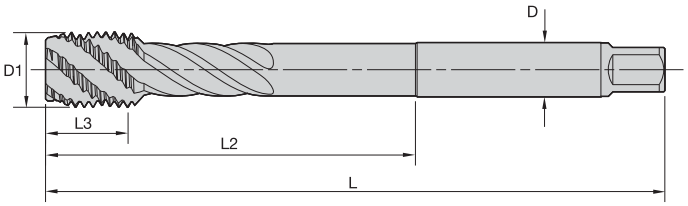
NOTE: Suggested for use in rigid and synchronous holders.

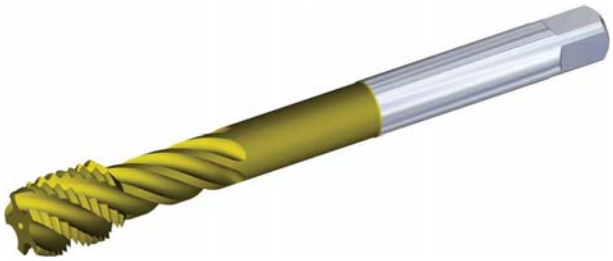
Shank Tolerance

D	tolerance h6
12–18	+0, -0,011
20–30	+0, -0,013
32–36	+0, -0,016

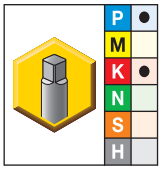
- KP6525 TiCN + TiN for tapping steel and cast iron.







T630 • Extra Long • Form C Semi-Bottoming Chamfer • Larger Sizes • Metric • For Steel and Cast Iron • Rigid and Synchronous Holders



● first choice
○ alternate choice

KP6525	D1 size	L	L3	L2	D	number of flutes	class of fit
T630M240X300R6HX-XL	M24 X 3	200	30	120	18,0	5	6HX
T630M300X350R6HX-XL	M30 X 3,5	250	35	150	22,0	5	6HX
T630M330X350R6HX-XL	M33 X 3,5	250	35	150	25,0	5	6HX
T630M360X400R6HX-XL	M36 X 4	250	40	150	28,0	5	6HX
T630M420X450R6HX-XL	M42 X 4,5	300	45	180	32,0	5	6HX

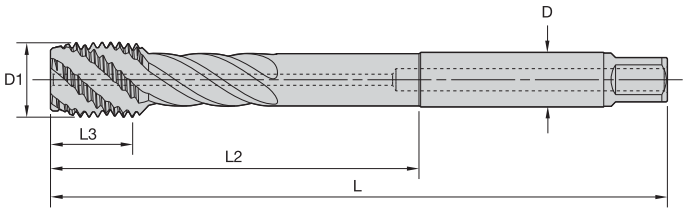
NOTE: Suggested for use in rigid and synchronous holders.

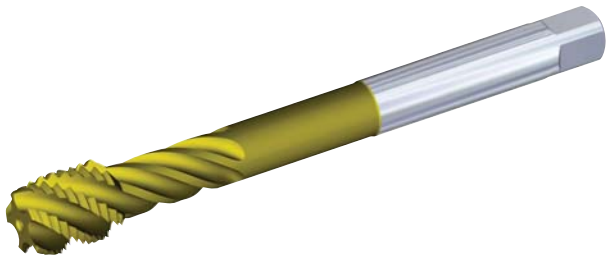
Shank Tolerance

D	tolerance h6
12–18	+0, -0,011
20–30	+0, -0,013
32–36	+0, -0,016

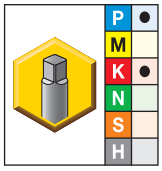
- KP6525 TiCN + TiN for tapping steel and cast iron.







T631 • Extra Long • Form C Semi-Bottoming Chamfer • Through Coolant • Larger Sizes • Metric • For Steel and Cast Iron • Rigid and Synchronous Holders



● first choice
○ alternate choice

KP6525	D1 size	L	L3	L2	D	number of flutes	class of fit
T631M240X300R6HX-XL	M24 X 3	200	30	120	18,0	5	6HX
T631M300X350R6HX-XL	M30 X 3,5	250	35	150	22,0	5	6HX
T631M330X350R6HX-XL	M33 X 3,5	250	35	150	25,0	5	6HX
T631M360X400R6HX-XL	M36 X 4	250	40	150	28,0	5	6HX
T631M420X450R6HX-XL	M42 X 4,5	300	45	180	32,0	5	6HX

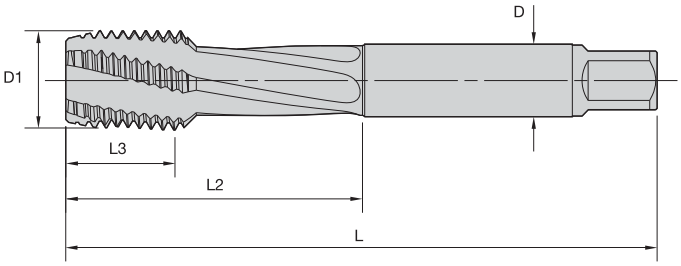
NOTE: Suggested for use in rigid and synchronous holders.

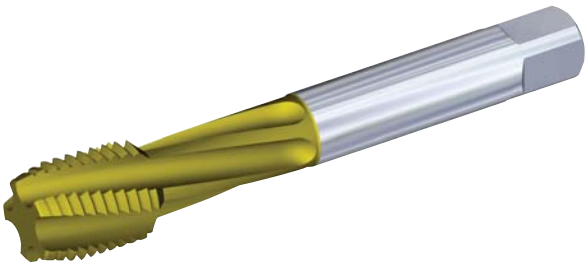
Shank Tolerance

D	tolerance h6
12–18	+0, -0,011
20–30	+0, -0,013
32–36	+0, -0,016

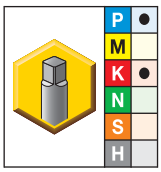
- KP6525 TiCN + TiN for tapping steel and cast iron.







T650 • DIN 376 • Form C Semi-Bottoming Chamfer • Larger Sizes • Metric • For Steel and Cast Iron



● first choice
○ alternate choice

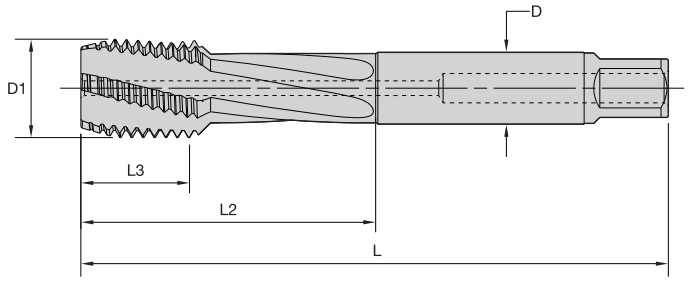
KP6525	D1 size	L	L3	L2	D	number of flutes	dimension standard	class of fit
T650M240X300R6HX-D6	M24 X 3	160	30	77	18,0	4	DIN 376	6HX
T650M300X350R6HX-D6	M30 X 3,5	180	35	91	22,0	5	DIN 376	6HX
T650M330X350R6HX-D6	M33 X 3,5	180	35	100	25,0	5	DIN 376	6HX
T650M360X400R6HX-D6	M36 X 4	200	40	110	28,0	5	DIN 376	6HX
T650M420X450R6HX-D6	M42 X 4,5	200	45	120	32,0	6	DIN 376	6HX

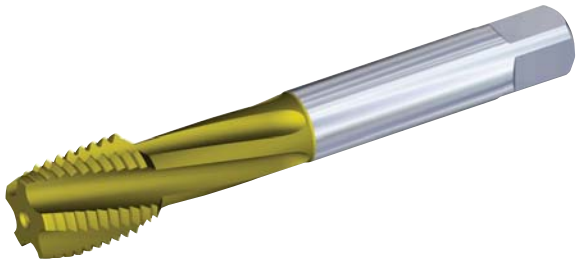
Shank Tolerance

D	tolerance h6
12–18	+0, -0,011
20–30	+0, -0,013
32–36	+0, -0,016

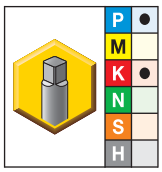
- KP6525 TiCN + TiN for tapping steel and cast iron.







T651 • DIN 376 • Form C Semi-Bottoming Chamfer • Through Coolant • Larger Sizes • Metric • For Steel and Cast Iron



● first choice
○ alternate choice

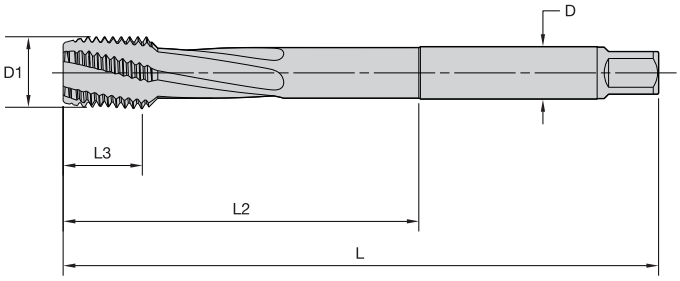
KP6525	D1 size	L	L3	L2	D	number of flutes	dimension standard	class of fit
T651M240X300R6HX-D6	M24 X 3	160	30	77	18,0	4	DIN 376	6HX
T651M300X350R6HX-D6	M30 X 3,5	180	35	91	22,0	5	DIN 376	6HX
T651M330X350R6HX-D6	M33 X 3,5	180	35	100	25,0	5	DIN 376	6HX
T651M360X400R6HX-D6	M36 X 4	200	40	110	28,0	5	DIN 376	6HX
T651M420X450R6HX-D6	M42 X 4,5	200	45	120	32,0	6	DIN 376	6HX

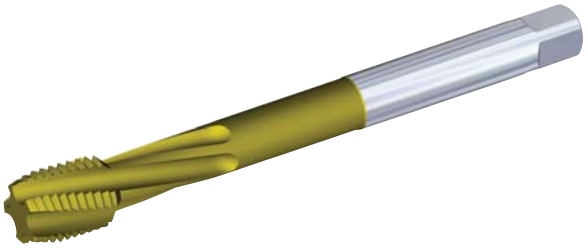
Shank Tolerance

D	tolerance h6
12–18	+0, -0,011
20–30	+0, -0,013
32–36	+0, -0,016

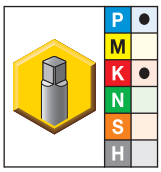
- KP6525 TiCN + TiN for tapping steel and cast iron.







T650 • Extra Long • Form C Semi-Bottoming Chamfer • Larger Sizes • Metric • For Steel and Cast Iron



● first choice
○ alternate choice

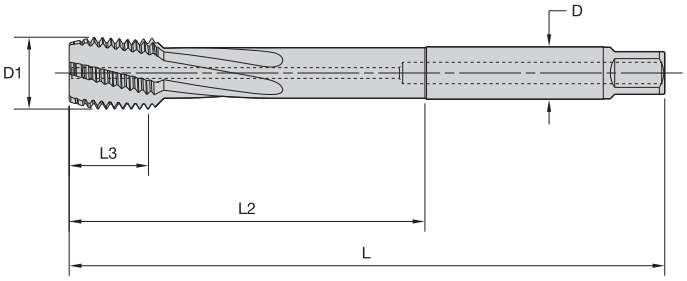
KP6525	D1 size	L	L3	L2	D	number of flutes	class of fit
T650M240X300R6HX-XL	M24 X 3	200	30	120	18,0	4	6HX
T650M300X350R6HX-XL	M30 X 3,5	250	35	150	22,0	5	6HX
T650M330X350R6HX-XL	M33 X 3,5	250	35	150	25,0	5	6HX
T650M360X400R6HX-XL	M36 X 4	250	40	150	28,0	5	6HX
T650M420X450R6HX-XL	M42 X 4,5	300	45	180	32,0	6	6HX

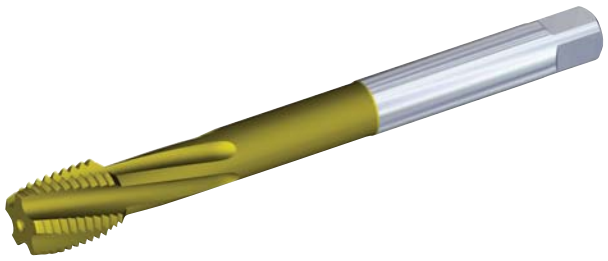
Shank Tolerance

D	tolerance h6
12–18	+0, -0,011
20–30	+0, -0,013
32–36	+0, -0,016

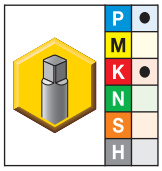
- KP6525 TiCN + TiN for tapping steel and cast iron.







T651 • Extra Long • Form C Semi-Bottoming Chamfer • Through Coolant • Larger Sizes • Metric • For Steel and Cast Iron



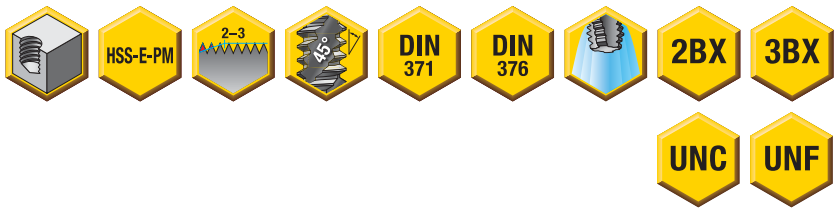
● first choice
○ alternate choice

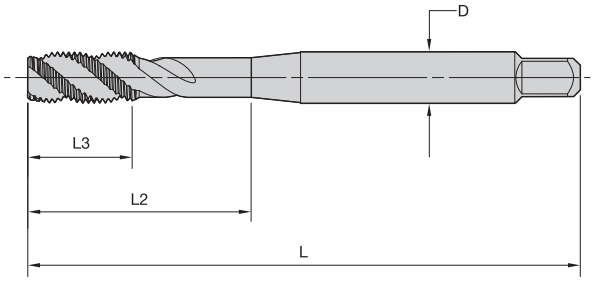
KP6525	D1 size	L	L3	L2	D	number of flutes	class of fit
T651M240X300R6HX-XL	M24 X 3	200	30	120	18,0	4	6HX
T651M300X350R6HX-XL	M30 X 3,5	250	35	150	22,0	5	6HX
T651M330X350R6HX-XL	M33 X 3,5	250	35	150	25,0	5	6HX
T651M360X400R6HX-XL	M36 X 4	250	40	150	28,0	5	6HX
T651M420X450R6HX-XL	M42 X 4,5	300	45	180	32,0	6	6HX

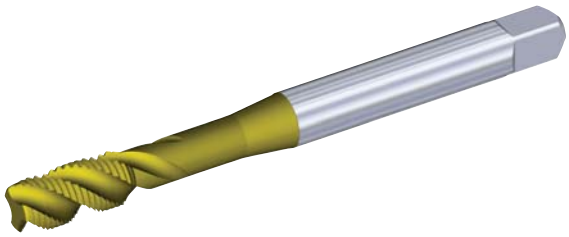
Shank Tolerance

D	tolerance h6
12–18	+0, -0,011
20–30	+0, -0,013
32–36	+0, -0,016

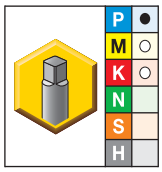
- KP6525 TiCN + TiN for steel.







T630 • DIN 371 and 376 • Form C Semi-Bottoming Chamfer • Machine Screw and Fractional • For Steel • Rigid and Synchronous Holders



● first choice
○ alternate choice

KP6525	D1 size	L	L3	L2	D	number of flutes	dimension standard	class of fit
T630NC#06-32R2BX-D1	6 - 32	56	9	20	4,0	3	DIN 371	2BX
T630NF#06-40R2BX-D1	6 - 40	56	9	20	4,0	3	DIN 371	2BX
T630NC#08-32R2BX-D1	8 - 32	63	10	21	4,5	3	DIN 371	2BX
T630NC#10-24R2BX-D1	10 - 24	70	10	25	6,0	3	DIN 371	2BX
T630NF#10-32R2BX-D1	10 - 32	70	10	25	6,0	3	DIN 371	2BX
T630NC02500-20R3BX-D1	1/4 - 20	80	13	30	7,0	3	DIN 371	3BX
T630NF02500-28R3BX-D1	1/4 - 28	80	13	30	7,0	3	DIN 371	3BX
T630NC03125-18R3BX-D1	5/16 - 18	90	13	35	8,0	3	DIN 371	3BX
T630NF03125-24R3BX-D1	5/16 - 24	90	13	35	8,0	3	DIN 371	3BX
T630NC03750-16R3BX-D1	3/8 - 16	100	16	39	10,0	3	DIN 371	3BX
T630NF03750-24R3BX-D1	3/8 - 24	100	16	39	10,0	3	DIN 371	3BX
T630NC04375-14R3BX-D6	7/16 - 14	100	15	41	8,0	4	DIN 376	3BX
T630NF04375-20R3BX-D6	7/16 - 20	100	15	41	8,0	4	DIN 376	3BX
T630NC05000-13R3BX-D6	1/2 - 13	110	20	47	9,0	4	DIN 376	3BX
T630NF05000-20R3BX-D6	1/2 - 20	110	20	47	9,0	4	DIN 376	3BX

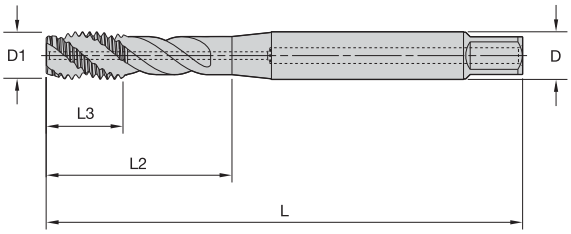
NOTE: Suggested for use in rigid and synchronous holders.

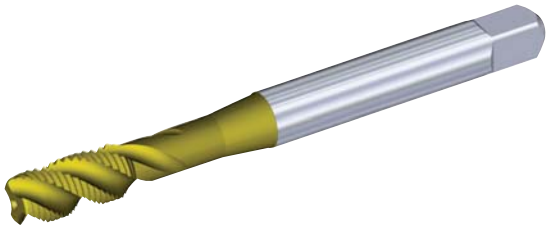
Shank Tolerance

D fractional	tolerance h6
>3–6	+0, -0,008
>6–10	+0, -0,009
<10–18	+0, -0,011

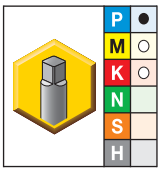
• KP6525 TiCN + TiN for steel.







T631 • DIN 371 and 376 • Form C Semi-Bottoming Chamfer • Through Coolant • Fractional • For Steel • Rigid and Synchronous Holders



● first choice
○ alternate choice

KP6525	D1 size	L	L3	L2	D	number of flutes	dimension standard	class of fit
T631NC02500-20R3BX-D1	1/4 - 20	80	13	30	7,0	3	DIN 371	3BX
T631NF02500-28R3BX-D1	1/4 - 28	80	13	30	7,0	3	DIN 371	3BX
T631NC03125-18R3BX-D1	5/16 - 18	90	13	35	8,0	3	DIN 371	3BX
T631NF03125-24R3BX-D1	5/16 - 24	90	13	35	8,0	3	DIN 371	3BX
T631NC03750-16R3BX-D1	3/8 - 16	100	16	39	10,0	3	DIN 371	3BX
T631NF03750-24R3BX-D1	3/8 - 24	100	16	39	10,0	3	DIN 371	3BX
T631NC04375-14R3BX-D6	7/16 - 14	100	15	41	8,0	4	DIN 376	3BX
T631NF04375-20R3BX-D6	7/16 - 20	100	15	41	8,0	4	DIN 376	3BX
T631NC05000-13R3BX-D6	1/2 - 13	110	20	47	9,0	4	DIN 376	3BX
T631NF05000-20R3BX-D6	1/2 - 20	110	20	47	9,0	4	DIN 376	3BX

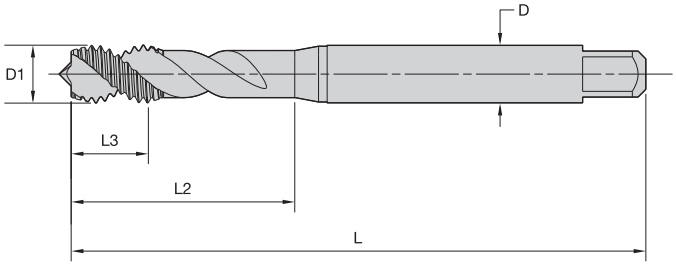
NOTE: Suggested for use in rigid and synchronous holders.

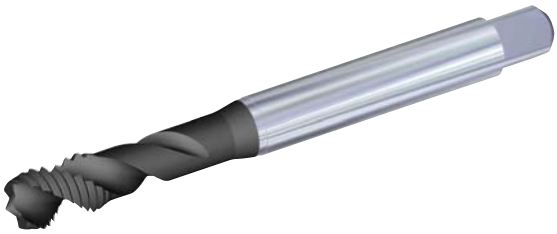
Shank Tolerance

D fractional	tolerance h6
>3–6	+0, -0,008
>6–10	+0, -0,009
<10–18	+0, -0,011

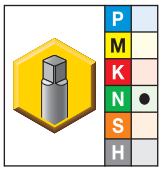
- KSN38 DLC for tapping aluminium.







T680 • DIN 371 and 376 • Form C Semi-Bottoming Chamfer • Metric • For Aluminium



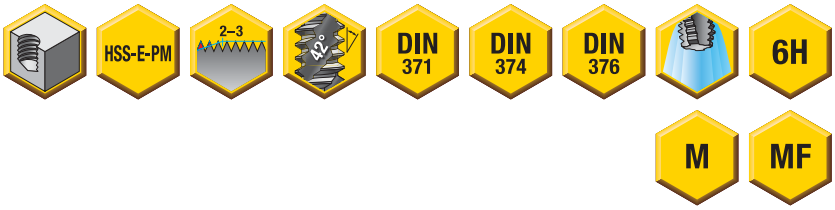
● first choice
○ alternate choice

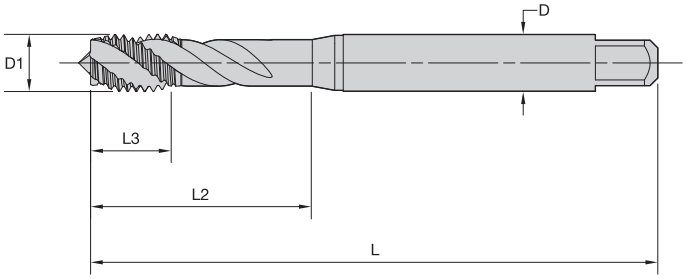
KSN38	D1 size	L	L3	L2	D	number of flutes	dimension standard	class of fit
T680M030X050R6H-D1	M3 X 0,5	56	6	18	3,5	2	DIN 371	6H
T680M040X070R6H-D1	M4 X 0,7	63	7	21	4,5	2	DIN 371	6H
T680M050X080R6H-D1	M5 X 0,8	70	8	25	6,0	2	DIN 371	6H
T680M060X100R6H-D1	M6 X 1	80	10	30	6,0	2	DIN 371	6H
T680M080X125R6H-D1	M8 X 1,25	90	14	35	8,0	2	DIN 371	6H
T680M100X150R6H-D1	M10 X 1,5	100	16	39	10,0	2	DIN 371	6H
T680M120X175R6H-D6	M12 X 1,75	110	18	–	9,0	3	DIN 376	6H
T680M160X200R6H-D6	M16 X 2	110	22	–	12,0	3	DIN 376	6H
T680M200X250R6H-D6	M20 X 2,5	140	25	–	16,0	3	DIN 376	6H

Shank Tolerance

D	tolerance h9
1–3	+0, -0,025
3,5–6	+0, -0,030
7–10	+0, -0,036
11–18	+0, -0,043

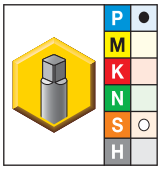
- KSH26 TiAlN/MoS_2 for tapping steel 32–44 HRC (3 x D).







T604 • DIN 371, 374, and 376 • Form C Semi-Bottoming Chamfer • Metric • For Hard Steel



● first choice
○ alternate choice

KSH26	D1 size	L	L3	L2	D	number of flutes	dimension standard	class of fit
T604M030X050R6H-D1	M3 X 0,5	56	6	18	3,5	3	DIN 371	6H
T604M040X070R6H-D1	M4 X 0,7	63	7	21	4,5	3	DIN 371	6H
T604M050X080R6H-D1	M5 X 0,8	70	8	25	6,0	3	DIN 371	6H
T604M060X100R6H-D1	M6 X 1	80	10	30	6,0	3	DIN 371	6H
T604MF080X100R6H-D4	M8 X 1	90	10	–	6,0	3	DIN 374	6H
T604M080X125R6H-D1	M8 X 1,25	90	14	35	8,0	3	DIN 371	6H
T604MF100X100R6H-D4	M10 X 1	90	10	–	7,0	3	DIN 374	6H
T604MF100X125R6H-D4	M10 X 1,25	100	16	–	7,0	3	DIN 374	6H
T604M100X150R6H-D1	M10 X 1,5	100	16	39	10,0	3	DIN 371	6H
T604MF120X125R6H-D4	M12 X 1,25	100	15	–	9,0	4	DIN 374	6H
T604MF120X150R6H-D4	M12 X 1,5	100	15	–	9,0	4	DIN 374	6H
T604M120X175R6H-D6	M12 X 1,75	110	18	–	9,0	4	DIN 376	6H
T604MF140X150R6H-D4	M14 X 1,5	100	15	–	11,0	4	DIN 374	6H
T604M140X200R6H-D6	M14 X 2	110	20	–	11,0	4	DIN 376	6H
T604MF160X150R6H-D4 *	M16 X 1,5	100	15	–	12,0	4	DIN 374	6H
T604M160X200R6H-D6	M16 X 2	110	22	–	12,0	4	DIN 376	6H
T604M180X250R6H-D6	M18 X 2,5	125	25	–	14,0	4	DIN 376	6H
T604M200X250R6H-D6	M20 X 2,5	140	25	–	16,0	4	DIN 376	6H

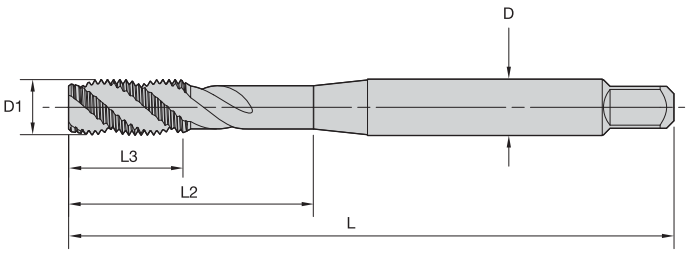
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

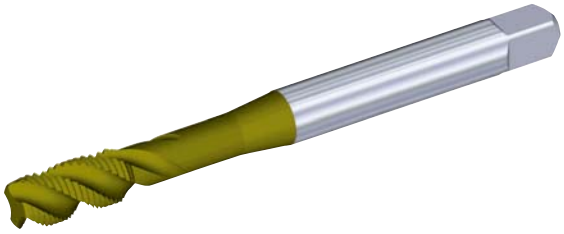
Shank Tolerance

D	tolerance h9
1–3	+0, -0,025
3,5–6	+0, -0,030
7–10	+0, -0,036
11–18	+0, -0,043

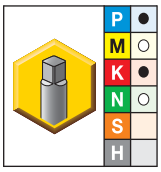
- KSP32 TiCN/TiN
- KSP39 oxide

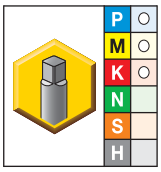






T830 • DIN 371, 374, and 376 • Form C Semi-Bottoming Chamfer • Metric • Rigid and Synchronous Holders



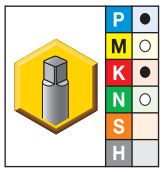


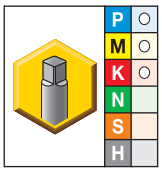
● first choice
○ alternate choice

KSP32	KSP39	D1 size	L	L3	L2	D	number of flutes	dimension standard	class of fit
–	T830M020X040R6H-D1	M2 X 0,4	45	7	13	2,8	2	DIN 371	6H
–	T830M020X040R6G-D1	M2 X 0,4	45	7	13	2,8	2	DIN 371	6G
–	T830M025X045R6H-D1	M2,5 X 0,45	50	7	15	2,8	2	DIN 371	6H
–	T830M025X045R6G-D1	M2,5 X 0,45	50	7	15	2,8	2	DIN 371	6G
T830M030X050R6H-D1	T830M030X050R6H-D1	M3 X 0,5	56	8	18	3,5	2	DIN 371	6H
–	T830M030X050R6G-D1	M3 X 0,5	56	8	18	3,5	2	DIN 371	6G
–	T830M035X060R6H-D1	M3,5 X 0,6	56	9	20	4,0	2	DIN 371	6H
T830M040X070R6H-D1	T830M040X070R6H-D1	M4 X 0,7	63	11	21	4,5	3	DIN 371	6H
–	T830M040X070R6G-D1	M4 X 0,7	63	11	21	4,5	3	DIN 371	6G
T830M050X080R6H-D1	T830M050X080R6H-D1	M5 X 0,8	70	12	25	6,0	3	DIN 371	6H
–	T830M050X080R6G-D1	M5 X 0,8	70	12	25	6,0	3	DIN 371	6G
–	T830M060X100R6H-D6	M6 X 1	80	12	30	4,5	3	DIN 376	6H
T830M060X100R6H-D1	T830M060X100R6H-D1	M6 X 1	80	12	30	6,0	3	DIN 371	6H
–	T830M060X100R6G-D1	M6 X 1	80	12	30	6,0	3	DIN 371	6G
–	T830M070X100R6H-D1	M7 X 1	80	12	30	7,0	3	DIN 371	6H
T830MF080X100R6H-D4	T830MF080X100R6H-D4	M8 X 1	90	15	35	6,0	3	DIN 374	6H
–	T830M080X125R6H-D6	M8 X 1,25	90	15	35	6,0	3	DIN 376	6H
T830M080X125R6H-D1	T830M080X125R6H-D1	M8 X 1,25	90	15	35	8,0	3	DIN 371	6H
–	T830M080X125R6G-D1	M8 X 1,25	90	15	35	8,0	3	DIN 371	6G
T830MF100X125R6H-D4	T830MF100X125R6H-D4	M10 X 1,25	100	18	39	7,0	3	DIN 374	6H
–	T830M100X150R6H-D6	M10 X 1,5	100	18	39	7,0	3	DIN 376	6H
T830M100X150R6H-D1	–	M10 X 1,5	100	18	39	10,0	3	DIN 371	6G
–	T830M100X150R6H-D1	M10 X 1,5	100	18	39	10,0	3	DIN 371	6H
–	T830M100X150R6G-D1	M10 X 1,5	100	18	39	10,0	3	DIN 371	6G
–	T830MF120X125R6H-D4	M12 X 1,25	100	21	39	9,0	3	DIN 374	6H
T830MF120X150R6H-D4	T830MF120X150R6H-D4	M12 X 1,5	100	21	39	9,0	3	DIN 374	6H
T830M120X175R6H-D6	T830M120X175R6H-D6	M12 X 1,75	110	21	44	9,0	3	DIN 376	6H
–	T830M120X175R6G-D6	M12 X 1,75	110	21	44	9,0	3	DIN 376	6G

(continued)

(T830 • DIN 371, 374, and 376 • Form C Semi-Bottoming Chamfer • Metric • Rigid and Synchronous Holders — continued)





● first choice
○ alternate choice

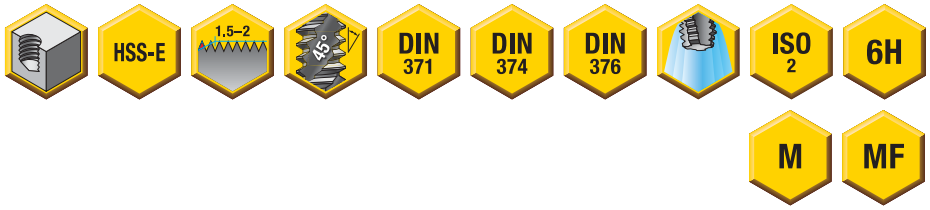
KSP32	KSP39	D1 size	L	L3	L2	D	number of flutes	dimension standard	class of fit
T830MF140X150R6H-D4	**T830MF140X150R6H-D4**	M14 X 1,5	100	21	47	11,0	3	DIN 374	6H
T830M140X200R6H-D6	**T830M140X200R6H-D6**	M14 X 2	110	24	52	11,0	3	DIN 376	6H
–	**T830M140X200R6G-D6**	M14 X 2	110	24	52	11,0	3	DIN 376	6G
–	**T830MF160X150R6H-D4**	M16 X 1,5	100	21	46	12,0	3	DIN 374	6H
–	**T830M160X200R6H-D6**	M16 X 2	110	24	51	12,0	3	DIN 376	6H
–	**T830M160X200R6G-D6**	M16 X 2	110	24	51	12,0	3	DIN 376	6G
–	**T830MF180X150R6H-D4**	M18 X 1,5	110	21	50	14,0	4	DIN 374	6H
–	**T830M180X250R6H-D6**	M18 X 2,5	125	30	58	14,0	4	DIN 376	6H
–	**T830M200X250R6H-D6**	M20 X 2,5	140	30	64	16,0	4	DIN 376	6H
–	**T830M220X250R6H-D6**	M22 X 2,5	140	30	70	18,0	4	DIN 376	6H
–	**T830M240X300R6H-D6**	M24 X 3	160	36	77	18,0	4	DIN 376	6H
–	**T830M270X300R6H-D6**	M27 X 3	160	36	82	20,0	4	DIN 376	6H
–	**T830M300X350R6H-D6**	M30 X 3,5	180	42	91	22,0	4	DIN 376	6H
–	**T830M330X350R6H-D6**	M33 X 3,5	180	42	100	25,0	4	DIN 376	6H
–	**T830M360X400R6H-D6**	M36 X 4	200	48	110	28,0	5	DIN 376	6H

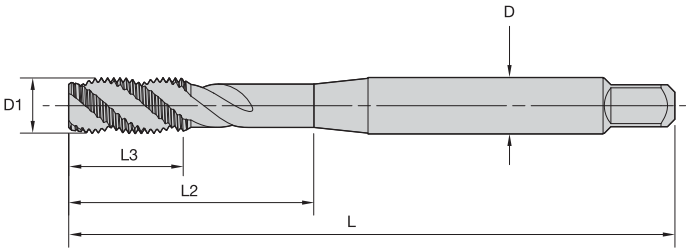
NOTE: Suggested for use in rigid and synchronous holders.

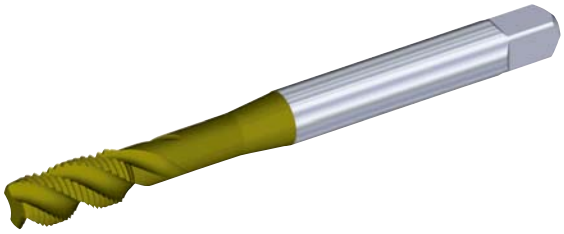
Shank Tolerance

D mm	tolerance h9
1–3	+0, -0,025
>3–6	+0, -0,030
>6–10	+0, -0,036
>10–18	+0, -0,043
>18–30	+0, -0,052

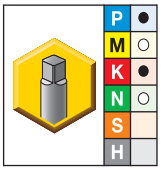
- KSP32 TiCN/TiN
- KSP39 oxide

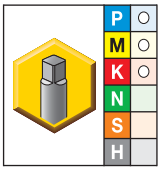






T832 • DIN 371, 374, and 376 • Form E Bottoming Chamfer • Metric • Rigid and Synchronous Holders





● first choice
○ alternate choice

KSP32	KSP39	D1 size	L	L3	L2	D	number of flutes	dimension standard	class of fit
T832M030X050R6H-D1	T832M030X050R6H-D1	M3 X 0,5	56	8	18	3,5	2	DIN 371	6H
T832M040X070R6H-D1	T832M040X070R6H-D1	M4 X 0,7	63	11	21	4,5	3	DIN 371	6H
T832M050X080R6H-D1	T832M050X080R6H-D1	M5 X 0,8	70	12	25	6,0	3	DIN 371	6H
T832M060X100R6H-D1	T832M060X100R6H-D1	M6 X 1	80	12	30	6,0	3	DIN 371	6H
T832MF080X100R6H-D4	T832MF080X100R6H-D4	M8 X 1	90	15	35	6,0	3	DIN 374	6H
T832M080X125R6H-D1	T832M080X125R6H-D1	M8 X 1,25	90	15	35	8,0	3	DIN 371	6H
T832MF100X125R6H-D4	T832MF100X125R6H-D4	M10 X 1,25	100	18	39	7,0	3	DIN 374	6H
T832M100X150R6H-D1	T832M100X150R6H-D1	M10 X 1,5	100	18	39	10,0	3	DIN 371	6H
T832MF120X150R6H-D4	T832MF120X150R6H-D4	M12 X 1,5	100	21	39	9,0	3	DIN 374	6H
T832M120X175R6H-D6	T832M120X175R6H-D6	M12 X 1,75	110	21	44	9,0	3	DIN 376	6H
T832MF140X150R6H-D4	T832MF140X150R6H-D4	M14 X 1,5	100	21	47	11,0	3	DIN 374	6H
T832M140X200R6H-D6	T832M140X200R6H-D6	M14 X 2	110	24	52	11,0	3	DIN 376	6H
—	T832M160X200R6H-D6	M16 X 2	110	24	51	12,0	3	DIN 376	6H
T832M180X250R6H-D6	T832M180X250R6H-D6	M18 X 2,5	125	30	58	14,0	4	DIN 376	6H
T832M200X250R6H-D6	T832M200X250R6H-D6	M20 X 2,5	140	30	64	16,0	4	DIN 376	6H

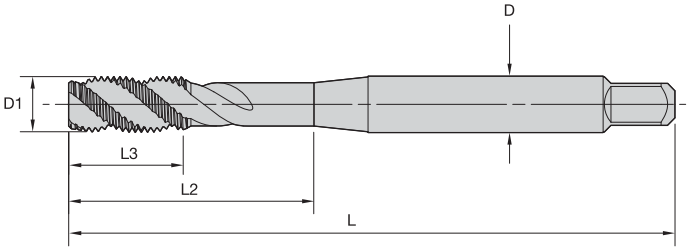
NOTE: Suggested for use in rigid and synchronous holders.

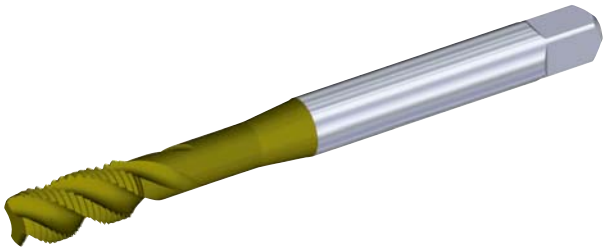
Shank Tolerance

D mm	tolerance h9
1–3	+0, -0,025
>3–6	+0, -0,030
>6–10	+0, -0,036
>10–18	+0, -0,043
>18–30	+0, -0,052

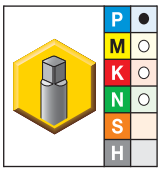
- KSU31 TiN
- KSP39 oxide

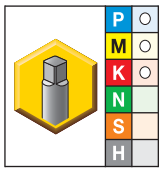






T838 • DIN 371, 374, and 376 • Form C Semi-Bottoming Chamfer • Metric • Tension/Compression Holders



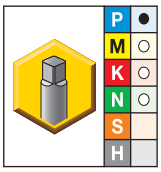


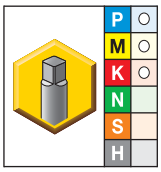
● first choice
○ alternate choice

KSU31	KSP39	D1 size	L	L3	L2	D	number of flutes	dimension standard	class of fit
T838M020X040R6H-D1	T838M020X040R6H-D1	M2 X 0,4	45	7	13	2,8	3	DIN 371	6H
T838M030X050R6H-D1	T838M030X050R6H-D1	M3 X 0,5	56	5	19	3,5	3	DIN 371	6H
T838M040X070R6H-D1	T838M040X070R6H-D1	M4 X 0,7	63	7	21	4,5	3	DIN 371	6H
T838M050X080R6H-D1	T838M050X080R6H-D1	M5 X 0,8	70	8	26	6,0	3	DIN 371	6H
T838M050X080R6H-D6	T838M050X080R6H-D6	M5 X 0,8	70	8	27	3,5	3	DIN 376	6H
T838MF060X075R6H-D4	T838MF060X075R6H-D4	M6 X 0,75	80	10	34	4,5	3	DIN 374	6H
T838M060X100R6H-D1	T838M060X100R6H-D1	M6 X 1	80	10	30	6,0	3	DIN 371	6H
T838M060X100R6H-D6	T838M060X100R6H-D6	M6 X 1	80	10	34	4,5	3	DIN 376	6H
T838MF080X075R6H-D4	T838MF080X075R6H-D4	M8 X 0,75	90	13	37	6,0	3	DIN 374	6H
T838MF080X100R6H-D4	T838MF080X100R6H-D4	M8 X 1	90	13	37	6,0	3	DIN 374	6H
T838M080X125R6H-D1	T838M080X125R6H-D1	M8 X 1,25	90	13	37	8,0	3	DIN 371	6H
T838M080X125R6H-D6	T838M080X125R6H-D6	M8 X 1,25	90	13	37	6,0	3	DIN 376	6H
T838MF100X075R6H-D4	T838MF100X075R6H-D4	M10 X 0,75	90	15	40	7,0	3	DIN 374	6H
T838MF100X100R6H-D4	T838MF100X100R6H-D4	M10 X 1	90	15	40	7,0	3	DIN 374	6H
T838MF100X125R6H-D4	T838MF100X125R6H-D4	M10 X 1,25	100	15	44	7,0	3	DIN 374	6H
T838M100X150R6H-D1	T838M100X150R6H-D1	M10 X 1,5	100	15	41	10,0	3	DIN 371	6H
T838M100X150R6H-D6	T838M100X150R6H-D6	M10 X 1,5	100	15	44	7,0	3	DIN 376	6H
T838MF120X100R6H-D4	T838MF120X100R6H-D4	M12 X 1	100	13	50	9,0	3	DIN 374	6H
T838MF120X125R6H-D4	T838MF120X125R6H-D4	M12 X 1,25	100	13	50	9,0	3	DIN 374	6H
T838MF120X150R6H-D4	T838MF120X150R6H-D4	M12 X 1,5	100	13	50	9,0	3	DIN 374	6H
T838M120X175R6H-D6	T838M120X175R6H-D6	M12 X 1,75	110	18	55	9,0	3	DIN 376	6H
T838MF140X100R6H-D4	T838MF140X100R6H-D4	M14 X 1	100	15	41	11,0	4	DIN 374	6H
T838MF140X125R6H-D4	T838MF140X125R6H-D4	M14 X 1,25	100	15	41	11,0	4	DIN 374	6H
T838MF140X150R6H-D4	T838MF140X150R6H-D4	M14 X 1,5	100	15	41	11,0	4	DIN 374	6H
T838M140X200R6H-D6	T838M140X200R6H-D6	M14 X 2	110	20	50	11,0	3	DIN 376	6H
T838MF160X150R6H-D4	T838MF160X150R6H-D4	M16 X 1,5	100	15	45	12,0	4	DIN 374	6H
T838M160X200R6H-D6	T838M160X200R6H-D6	M16 X 2	110	20	55	12,0	4	DIN 376	6H
T838MF180X150R6H-D4	T838MF180X150R6H-D4	M18 X 1,5	110	17	55	14,0	4	DIN 374	6H
T838MF180X200R6H-D4	T838MF180X200R6H-D4	M18 X 2	125	25	61	14,0	4	DIN 374	6H
T838M180X250R6H-D6	T838M180X250R6H-D6	M18 X 2,5	125	25	61	14,0	4	DIN 376	6H
T838MF200X150R6H-D4	T838MF200X150R6H-D4	M20 X 1,5	125	17	56	16,0	4	DIN 374	6H
T838MF200X200R6H-D4	T838MF200X200R6H-D4	M20 X 2	140	25	65	16,0	4	DIN 374	6H

(continued)

(T838 • DIN 371, 374, and 376 • Form C Semi-Bottoming Chamfer • Metric • Tension/Compression Holders — continued)





● first choice
○ alternate choice

KSU31	KSP39	D1 size	L	L3	L2	D	number of flutes	dimension standard	class of fit
T838M200X250R6H-D6	**T838M200X250R6H-D6**	M20 X 2,5	140	25	65	16,0	4	DIN 376	6H
T838MF220X150R6H-D4	**T838MF220X150R6H-D4**	M22 X 1,5	125	18	61	18,0	4	DIN 374	6H
T838MF220X200R6H-D4	**T838MF220X200R6H-D4**	M22 X 2	140	25	66	18,0	4	DIN 374	6H
T838M220X250R6H-D6	**T838M220X250R6H-D6**	M22 X 2,5	140	25	66	18,0	4	DIN 376	6H
T838MF240X150R6H-D4	**T838MF240X150R6H-D4**	M24 X 1,5	140	20	67	18,0	4	DIN 374	6H
T838MF240X200R6H-D4	**T838MF240X200R6H-D4**	M24 X 2	140	20	67	18,0	4	DIN 374	6H
T838M240X300R6H-D6	**T838M240X300R6H-D6**	M24 X 3	160	30	77	18,0	4	DIN 376	6H
T838MF270X150R6H-D4	**T838MF270X150R6H-D4**	M27 X 1,5	140	20	65	20,0	4	DIN 374	6H
T838M270X300R6H-D6	**T838M270X300R6H-D6**	M27 X 3	160	33	85	20,0	4	DIN 376	6H
T838MF300X150R6H-D4	**T838MF300X150R6H-D4**	M30 X 1,5	150	22	68	20,0	4	DIN 374	6H
T838MF300X200R6H-D4	**T838MF300X200R6H-D4**	M30 X 2	150	22	68	22,0	4	DIN 374	6H
T838M300X350R6H-D6	**T838M300X350R6H-D6**	M30 X 3,5	180	35	87	22,0	4	DIN 376	6H
T838M330X350R6H-D6	**T838M330X350R6H-D6**	M33 X 3,5	180	35	92	25,0	4	DIN 376	6H
T838M360X400R6H-D6	**T838M360X400R6H-D6**	M36 X 4	200	40	110	28,0	4	DIN 376	6H
T838M390X400R6H-D6	**T838M390X400R6H-D6**	M39 X 4	200	40	105	32,0	4	DIN 376	6H
T838M420X450R6H-D6	**T838M420X450R6H-D6**	M42 X 4,5	200	40	105	32,0	5	DIN 376	6H
T838M450X450R6H-D6	**T838M450X450R6H-D6**	M45 X 5	220	50	110	36,0	5	DIN 376	6H
T838M480X500R6H-D6	**T838M480X500R6H-D6**	M48 X 5	250	50	145	36,0	5	DIN 376	6H
T838M520X500R6H-D6	**T838M520X500R6H-D6**	M52 X 5	250	50	135	40,0	5	DIN 376	6H

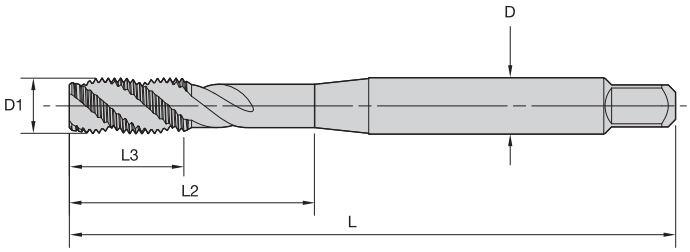
NOTE: Suitable for tension/compression holders.

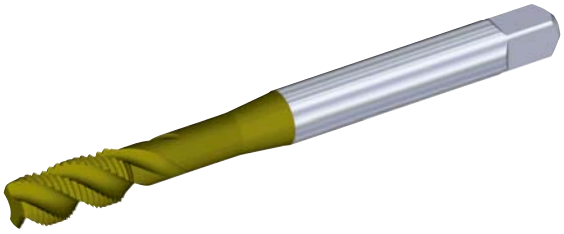
Shank Tolerance

D mm	tolerance h9
1–3	+0, -0,025
>3–6	+0, -0,030
>6–10	+0, -0,036
>10–18	+0, -0,043
>18–30	+0, -0,052

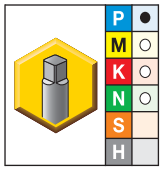
- KSU31 TiN
- KSP39 oxide

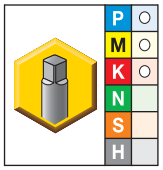






T839 • DIN 371 and 376 • Form E Bottoming Chamfer • Metric • Tension/Compression Holders





● first choice
○ alternate choice

KSU31	KSP39	D1 size	L	L3	L2	D	number of flutes	dimension standard	class of fit
T839M030X050R6H-D1	**T839M030X050R6H-D1**	M3 X 0,5	56	5	19	3,5	3	DIN 371	6H
T839M040X070R6H-D1	**T839M040X070R6H-D1**	M4 X 0,7	63	7	21	4,5	3	DIN 371	6H
T839M050X080R6H-D1	**T839M050X080R6H-D1**	M5 X 0,8	70	8	26	6,0	3	DIN 371	6H
T839M060X100R6H-D1	**T839M060X100R6H-D1**	M6 X 1	80	10	30	6,0	3	DIN 371	6H
T839M080X125R6H-D1	**T839M080X125R6H-D1**	M8 X 1,25	90	13	37	8,0	3	DIN 371	6H
T839M100X150R6H-D1	**T839M100X150R6H-D1**	M10 X 1,5	100	15	42	10,0	3	DIN 371	6H
T839M120X175R6H-D6	**T839M120X175R6H-D6**	M12 X 1,75	110	18	55	9,0	3	DIN 376	6H
T839M140X200R6H-D6	**T839M140X200R6H-D6**	M14 X 2	110	20	50	11,0	3	DIN 376	6H
T839M160X200R6H-D6	**T839M160X200R6H-D6**	M16 X 2	110	20	55	12,0	4	DIN 376	6H
T839M180X250R6H-D6	**T839M180X250R6H-D6**	M18 X 2,5	125	25	61	14,0	4	DIN 376	6H
T839M200X250R6H-D6	**T839M200X250R6H-D6**	M20 X 2,5	140	25	65	16,0	4	DIN 376	6H

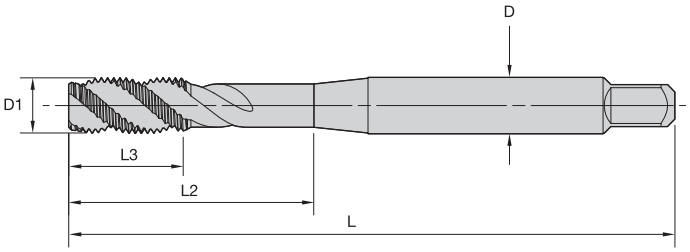
NOTE: Suitable for tension/compression holders.

Shank Tolerance

D mm	tolerance h9
1–3	+0, -0,025
>3–6	+0, -0,030
>6–10	+0, -0,036
>10–18	+0, -0,043
>18–30	+0, -0,052

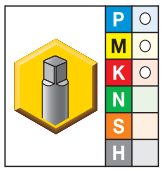
• KSP39 oxide







T830 • DIN 371 and 376 • Form C Semi-Bottoming Chamfer • UNC/UNF • Rigid and Synchronous Holders



● first choice
○ alternate choice

KSP39	metric dimensions D1 size	L	L3	L2	D	number of flutes	dimension standard	class of fit
T830NC#04-40R2B-D1	4 - 40	56	8	18	3,5	2	DIN 371	2B
T830NC#05-40R2B-D1	5 - 40	56	9	20	4,0	2	DIN 371	2B
T830NC#06-32R2B-D1	6 - 32	56	9	20	4,0	2	DIN 371	2B
T830NF#06-40R2B-D1	6 - 40	56	9	20	4,0	2	DIN 371	2B
T830NC#08-32R2B-D1	8 - 32	63	11	21	4,5	3	DIN 371	2B
T830NC#10-24R2B-D1	10 - 24	70	12	25	6,0	3	DIN 371	2B
T830NF#10-32R2B-D1	10 - 32	70	12	25	6,0	3	DIN 371	2B
T830NC02500-20R2B-D1	1/4 - 20	80	15	30	7,0	3	DIN 371	2B
T830NF02500-28R2B-D1	1/4 - 28	80	15	30	7,0	3	DIN 371	2B
T830NC03125-18R2B-D1	5/16 - 18	90	15	35	8,0	3	DIN 371	2B
T830NF03125-24R2B-D1	5/16 - 24	90	15	35	8,0	3	DIN 371	2B
T830NC03750-16R2B-D1	3/8 - 16	100	19	39	10,0	3	DIN 371	2B
T830NF03750-24R2B-D1	3/8 - 24	100	19	39	10,0	3	DIN 371	2B
T830NC04375-14R2B-D6	7/16 - 14	100	18	41	8,0	3	DIN 376	2B
T830NF04375-20R2B-D6	7/16 - 20	100	18	41	8,0	3	DIN 376	2B
T830NC05000-13R2B-D6	1/2 - 13	110	23	47	9,0	3	DIN 376	2B
T830NF05000-20R2B-D6	1/2 - 20	110	23	47	9,0	3	DIN 376	2B
T830NC05625-12R2B-D6	9/16 - 12	110	25	53	11,0	3	DIN 376	2B
T830NF05625-18R2B-D6	9/16 - 18	110	25	53	11,0	3	DIN 376	2B
T830NC06250-11R2B-D6	5/8 - 11	110	24	51	12,0	3	DIN 376	2B
T830NF06250-18R2B-D6	5/8 - 18	110	24	51	12,0	3	DIN 376	2B
T830NC07500-10R2B-D6	3/4 - 10	140	30	64	16,0	4	DIN 376	2B
T830NF07500-16R2B-D6	3/4 - 16	140	30	64	16,0	4	DIN 376	2B
T830NF08750-9R2B-D6	7/8 - 9	140	34	71	18,0	4	DIN 376	2B
T830NF08750-14R2B-D6	7/8 - 14	140	34	71	18,0	4	DIN 376	2B
T830NC10000-8R2B-D6	1 - 8	160	38	81	18,0	4	DIN 376	2B
T830NF10000-12R2B-D6	1 - 12	160	38	81	18,0	4	DIN 376	2B

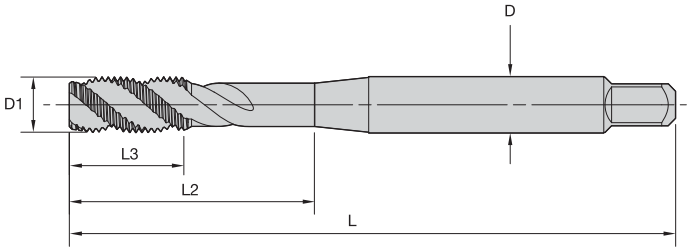
NOTE: Suggested for use in rigid and synchronous holders.

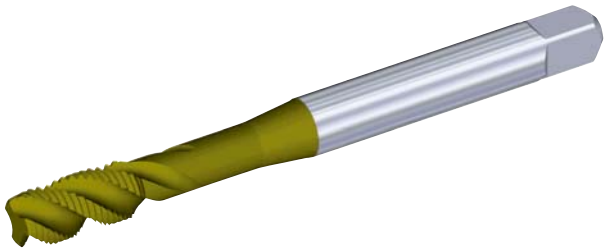
Shank Tolerance

D mm	tolerance h9
1–3	+0, -0,025
>3–6	+0, -0,030
>6–10	+0, -0,036
>10–18	+0, -0,043
>18–30	+0, -0,052

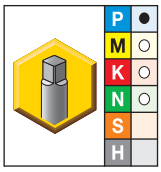
- KSU31 TiN
- KSP39 oxide

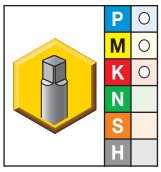






T838 • DIN 371, 374, and 376 • Form C Semi-Bottoming Chamfer • UNC/UNF • Tension/Compression Holders



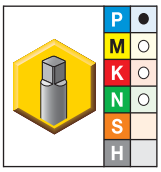


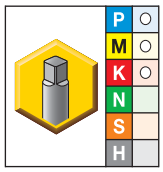
● first choice
○ alternate choice

KSU31	KSP39	D1 size	L	L3	L2	D	number of flutes	dimension standard	class of fit
T838NC#06-32R2B-D1	T838NC#06-32R2B-D1	6 - 32	56	7	21	4,0	3	DIN 371	2B
T838NF#06-40R2B-D1	T838NF#06-40R2B-D1	6 - 40	56	7	21	4,0	3	DIN 371	2B
T838NC#08-32R2B-D1	T838NC#08-32R2B-D1	8 - 32	63	7	21	4,5	3	DIN 371	2B
T838NF#08-36R2B-D1	T838NF#08-36R2B-D1	8 - 36	63	7	21	4,5	3	DIN 371	2B
T838NC#10-24R2B-D1	T838NC#10-24R2B-D1	10 - 24	70	8	25	6,0	3	DIN 371	2B
T838NF#10-32R2B-D1	T838NF#10-32R2B-D1	10 - 32	70	8	25	6,0	3	DIN 371	2B
T838NC#12-24R2B-D1	T838NC#12-24R2B-D1	12 - 24	80	10	30	6,0	3	DIN 371	2B
T838NF#12-28R2B-D1	T838NF#12-28R2B-D1	12 - 28	80	10	30	6,0	3	DIN 371	2B
T838NC02500-20R2B-D1	T838NC02500-20R2B-D1	1/4 - 20	80	10	29	7,0	3	DIN 371	2B
T838NC02500-20R2B-D6	T838NC02500-20R2B-D6	1/4 - 20	80	10	36	4,5	3	DIN 376	2B
T838NF02500-28R2B-D1	T838NF02500-28R2B-D1	1/4 - 28	80	10	29	7,0	3	DIN 371	2B
T838NF02500-28R2B-D4	T838NF02500-28R2B-D4	1/4 - 28	80	10	36	4,5	3	DIN 374	2B
T838NC03125-18R2B-D1	T838NC03125-18R2B-D1	5/16 - 18	90	13	37	8,0	3	DIN 371	2B
T838NC03125-18R2B-D6	T838NC03125-18R2B-D6	5/16 - 18	90	13	37	6,0	3	DIN 376	2B
T838NF03125-24R2B-D4	T838NF03125-24R2B-D4	5/16 - 24	90	13	37	6,0	3	DIN 374	2B
T838NC03750-16R2B-D1	T838NC03750-16R2B-D1	3/8 - 16	100	15	42	10,0	3	DIN 371	2B
T838NC03750-16R2B-D6	T838NC03750-16R2B-D6	3/8 - 16	100	15	45	7,0	3	DIN 376	2B
T838NF03750-24R2B-D4	T838NF03750-24R2B-D4	3/8 - 24	90	15	40	7,0	3	DIN 374	2B
T838NC04375-14R2B-D6	T838NC04375-14R2B-D6	7/16 - 14	100	15	47	8,0	3	DIN 376	2B
T838NF04375-20R2B-D4	T838NF04375-20R2B-D4	7/16 - 20	100	15	47	8,0	3	DIN 374	2B
T838NC05000-13R2B-D6	T838NC05000-13R2B-D6	1/2 - 13	110	18	50	9,0	3	DIN 376	2B
T838NF05000-20R2B-D4	T838NF05000-20R2B-D4	1/2 - 20	100	13	44	9,0	3	DIN 374	2B
T838NC05625-12R2B-D6	T838NC05625-12R2B-D6	9/16 - 12	110	20	55	11,0	4	DIN 376	2B
T838NF05625-18R2B-D4	T838NF05625-18R2B-D4	9/16 - 18	100	15	44	11,0	4	DIN 374	2B
T838NC06250-11R2B-D6	T838NC06250-11R2B-D6	5/8 - 11	110	20	55	12,0	4	DIN 376	2B
T838NF06250-18R2B-D4	T838NF06250-18R2B-D4	5/8 - 18	100	15	45	12,0	4	DIN 374	2B
T838NC07500-10R2B-D6	T838NC07500-10R2B-D6	3/4 - 10	125	25	65	14,0	4	DIN 376	2B
T838NF07500-16R2B-D4	T838NF07500-16R2B-D4	3/4 - 16	110	17	55	14,0	4	DIN 374	2B
T838NC08750-9R2B-D6	T838NC08750-9R2B-D6	7/8 - 9	140	25	68	18,0	4	DIN 376	2B
T838NF08750-14R2B-D4	T838NF08750-14R2B-D4	7/8 - 14	125	18	57	18,0	4	DIN 374	2B
T838NC10000-8R2B-D6	T838NC10000-8R2B-D6	1 - 8	160	30	89	18,0	4	DIN 376	2B
T838NF10000-12R2B-D4	T838NF10000-12R2B-D4	1 - 12	140	22	63	18,0	4	DIN 374	2B

(continued)

(T838 • DIN 371, 374, and 376 • Form C Semi-Bottoming Chamfer • UNC/UNF • Tension/Compression Holders — continued)





● first choice
○ alternate choice

KSU31	KSP39	D1 size	L	L3	L2	D	number of flutes	dimension standard	class of fit
T838NC11250-7R2B-D6	**T838NC11250-7R2B-D6**	1 1/8 - 7	180	35	90	22,0	4	DIN 376	2B
T838NF11250-12R2B-D4	**T838NF11250-12R2B-D4**	1 1/8 - 12	150	22	70	22,0	4	DIN 374	2B
T838NC12500-7R2B-D6	**T838NC12500-7R2B-D6**	1 1/4 - 7	180	35	95	22,0	4	DIN 376	2B
T838NF12500-12R2B-D4	**T838NF12500-12R2B-D4**	1 1/4 - 12	150	22	67	22,0	5	DIN 374	2B
T838NC13750-6R2B-D6	**T838NC13750-6R2B-D6**	1 3/8 - 6	200	40	100	28,0	4	DIN 376	2B
T838NF13750-12R2B-D4	**T838NF13750-12R2B-D4**	1 3/8 - 12	170	24	80	28,0	5	DIN 374	2B
T838NC15000-6R2B-D6	**T838NC15000-6R2B-D6**	1 1/2 - 6	200	40	100	28,0	4	DIN 376	2B
T838NF15000-12R2B-D4	**T838NF15000-12R2B-D4**	1 1/2 - 12	170	24	72	28,0	6	DIN 374	2B
T838NC17500-5R2B-D6	**T838NC17500-5R2B-D6**	1 3/4 - 5	220	50	108	36,0	5	DIN 376	2B
T838NC20000-4,5R2B-D6	**T838NC20000-4,5R2B-D6**	2 - 4 1/2	250	55	140	40,0	5	DIN 376	2B

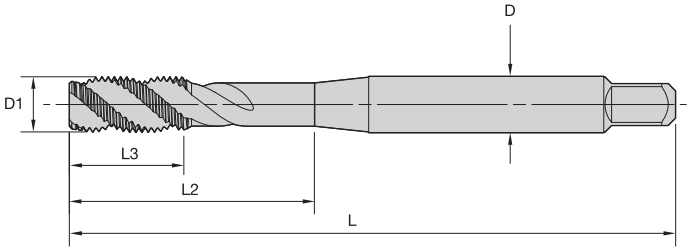
NOTE: Suitable for tension/compression holders.

Shank Tolerance

D mm	tolerance h9
1–3	+0, -0,025
>3–6	+0, -0,030
>6–10	+0, -0,036
>10–18	+0, -0,043
>18–30	+0, -0,052

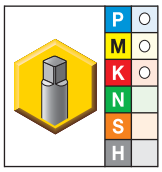
• KSP39 oxide







T830 • DIN 371 and 376 • Form C Semi-Bottoming Chamfer • UNJC/UNJF • Rigid and Synchronous Holders



● first choice
○ alternate choice

KSP39	metric dimensions D1 size	L	L3	L2	D	number of flutes	dimension standard	class of fit
T830NC#04-40R3B-D1	4 - 40	56	8	18	3,5	2	DIN 371	3B
T830NC#06-32R3B-D1	6 - 32	56	9	20	4,0	2	DIN 371	3B
T830NC#08-32R3B-D1	8 - 32	63	11	21	4,5	3	DIN 371	3B
T830NF#10-32R3B-D1	10 - 32	70	12	25	6,0	3	DIN 371	3B
T830NF02500-28R3B-D1	1/4 - 28	80	15	30	7,0	3	DIN 371	3B
T830NF03125-24R3B-D1	5/16 - 24	90	15	35	8,0	3	DIN 371	3B
T830NF03750-24R3B-D1	3/8 - 24	100	19	39	10,0	3	DIN 371	3B
T830NF04375-20R3B-D6	7/16 - 20	100	18	41	8,0	3	DIN 376	3B
T830NF05000-20R3B-D6	1/2 - 20	110	23	47	9,0	3	DIN 376	3B

NOTE: Internal UNJC/UNJF threads may be produced with ground thread UNC/UNF taps.

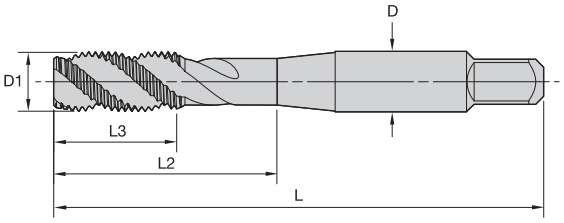
NOTE: Suggested for use in rigid and synchronous holders.

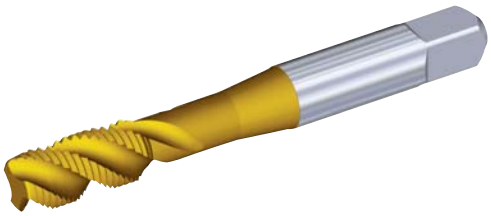
Shank Tolerance

D mm	tolerance h9
1–3	+0, -0,025
>3–6	+0, -0,030
>6–10	+0, -0,036
>10–18	+0, -0,043
>18–30	+0, -0,052

- KSU31 TiN
- KSU30 bright

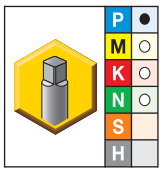


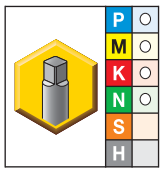




T830 • Form C Semi-Bottoming Chamfer • Metric • JIS • Rigid and Synchronous Holders

Tapping





● first choice
○ alternate choice

KSU31	KSU30	metric dimensions D1 size	L	L3	L2	D	number of flutes	dimension standard	tap class
T830M030X050R6H-J	**T830M030X050R6H-J**	M3 X 0,5	46	11	19	4,0	2	JIS	ISO 2
T830M040X070R6H-J	**T830M040X070R6H-J**	M4 X 0,7	52	13	21	5,0	3	JIS	ISO 2
T830M050X080R6H-J	**T830M050X080R6H-J**	M5 X 0,8	60	16	24	5,5	3	JIS	ISO 2
T830M060X100R6H-J	**T830M060X100R6H-J**	M6 X 1	62	19	29	6,0	3	JIS	ISO 2
T830M080X125R6H-J	**T830M080X125R6H-J**	M8 X 1,25	70	22	37	6,2	3	JIS	ISO 2
T830M100X150R6H-J	**T830M100X150R6H-J**	M10 X 1,5	75	24	41	7,0	3	JIS	ISO 2
–	**T830MF120X125R6H-J**	M12 X 1,25	82	29	48	8,5	3	JIS	ISO 2
–	**T830MF120X150R6H-J**	M12 X 1,5	82	29	48	8,5	3	JIS	ISO 2
–	**T830M120X175R6H-J**	M12 X 1,75	82	29	48	8,5	3	JIS	ISO 2
–	**T830MF140X150R6H-J**	M14 X 1,5	88	30	48	10,5	3	JIS	ISO 2
–	**T830M140X200R6H-J**	M14 X 2	88	30	48	10,5	3	JIS	ISO 2
–	**T830MF160X150R6H-J**	M16 X 1,5	95	32	52	12,5	3	JIS	ISO 2
–	**T830M160X200R6H-J**	M16 X 2	95	32	52	12,5	3	JIS	ISO 2
–	**T830M180X250R6H-J**	M18 X 2,5	100	37	55	14,0	4	JIS	ISO 2
–	**T830M200X250R6H-J**	M20 X 2,5	105	37	60	15,0	4	JIS	ISO 2

NOTE: Suggested for use in rigid and synchronous holders.

Shank Tolerance

D mm	tolerance h9
1–3	+0, -0,025
>3–6	+0, -0,030
>6–10	+0, -0,036
>10–18	+0, -0,043
>18–30	+0, -0,052

Mobile App

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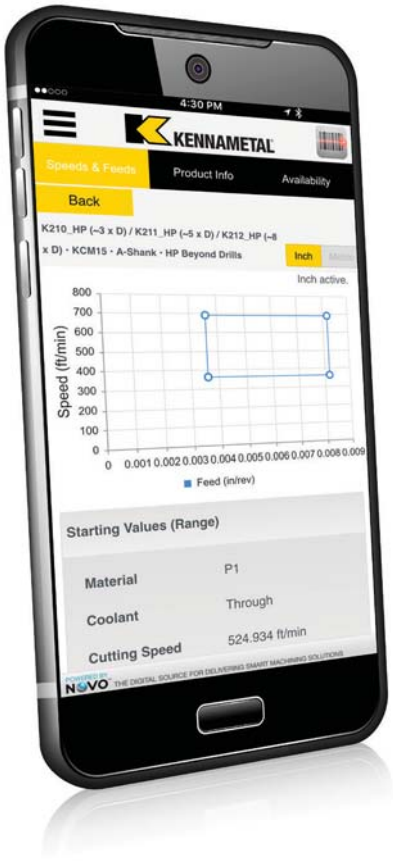

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Straight-Flute Taps



High-Performance Taps for Through-Hole and Blind-Hole Applications

- Cast iron.
- Cast aluminium.

High-Performance Beyond™ Solid Carbide Taps

- Straight-flute design for through- and blind-hole tapping in cast iron, cast aluminium, and hard steels.
- Runs up to 4x faster and 4x longer than conventional high-speed steel (HSS) taps.
- Ideal for long production runs where fewer tool changes result in greater productivity.
- For use on CNC machines with synchronous or rigid controls and precision toolholders.

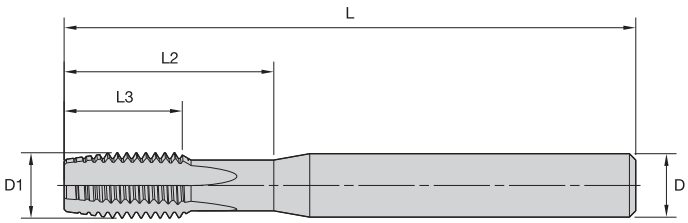
High-Performance Beyond™ HSS-E-PM Taps

- Straight-flute design for through- and blind-hole tapping in cast iron and cast aluminium.
- Higher strength and wider range of applications versus solid carbide taps.
- Higher tapping speed capability and longer tool life than conventional HSS-E taps.
- Can be used on either conventional or synchronous tapping machines with rigid or synchronous tap holders.



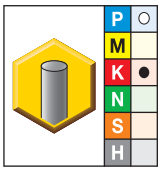
- KCK17 AlCrTiN for cast iron.







T340 • Form D Plug • Inch • Solid Carbide • For Cast Iron



● first choice
○ alternate choice

KCK17	D1 size	L	L3	L2	D	number of flutes	class of fit
T340NC#6-32R3BX	6 - 32	2.36	.28	.55	.2500	3	3BX
T340NC#8-32R3BX *	8 - 32	2.36	.28	.63	.2500	3	3BX
T340NC#10-24R3BX	10 - 24	2.36	.35	.79	.2500	3	3BX
T340NF#10-32R3BX	10 - 32	2.36	.35	.79	.2500	3	3BX
T340NC02500-20R3BX	1/4 - 20	2.76	.59	.94	.2500	4	3BX
T340NC03125-18R3BX	5/16 - 18	3.15	.67	1.26	.3125	4	3BX
T340NC03750-16R3BX	3/8 - 16	3.54	.75	1.57	.3750	4	3BX
T340NF03750-24R3BX	3/8 - 24	3.54	.75	1.57	.3750	4	3BX
T340NC05000-13R3BX	1/2 - 13	3.94	.94	1.89	.5000	4	3BX
T340NF05000-20R3BX	1/2 - 20	3.94	.94	1.89	.5000	4	3BX
T340NF05625-18R3BX	9/16 - 18	4.33	1.02	2.21	.5000	4	3BX

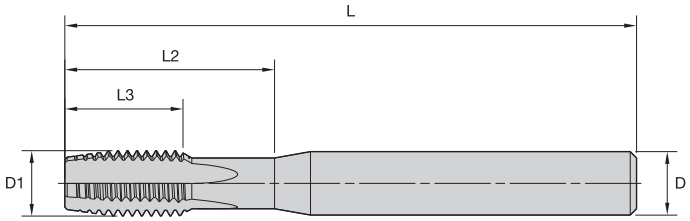
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Shank Tolerance

D	tolerance h6
.250–.375	+0, -.0004
.438–.625	+0, -.0004

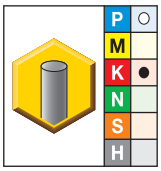
• KCK17 AlCrTiN for cast iron.







T340 • Form D Plug • Metric • Solid Carbide • For Cast Iron



● first choice
○ alternate choice

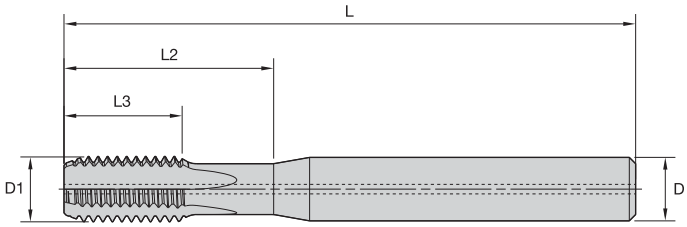
KCK17	D1 size	L	L3	L2	D	number of flutes	class of fit
T340M040X070R6HX	M4 X 0,7	60	6	16	6,0	3	6HX
T340M050X080R6HX	M5 X 0,8	60	7	20	6,0	3	6HX
T340M060X100R6HX	M6 X 1	70	12	24	6,0	4	6HX
T340M080X125R6HX	M8 X 1,25	80	15	32	8,0	4	6HX
T340MF100X100R6HX	M10 X 1	90	18	40	10,0	4	6HX
T340M100X150R6HX	M10 X 1,5	90	18	40	10,0	4	6HX
T340MF120X150R6HX	M12 X 1,5	100	21	48	12,0	4	6HX
T340M120X175R6HX	M12 X 1,75	100	21	48	12,0	4	6HX
T340MF140X150R6HX	M14 X 1,5	110	24	56	12,0	4	6HX
T340M140X200R6HX	M14 X 2	110	24	56	12,0	4	6HX
T340M160X200R6HX	M16 X 2	110	24	64	14,0	4	6HX
T340M200X250R6HX	M20 X 2,5	140	30	80	18,0	5	6HX

Shank Tolerance

D	tolerance h6
6	+0, -0,008
8–10	+0, -0,009
12–16	+0, -0,011

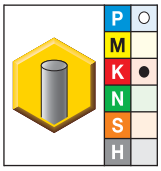
- KCK17 AlCrTiN for cast iron.







T351 • Form E Bottoming Chamfer • Through Coolant 1/4" and Larger • Inch • Solid Carbide • For Cast Iron



● first choice
○ alternate choice

KCK17	D1 size	L	L3	L2	D	number of flutes	class of fit
T351NC#6-32R3BX *	6 - 32	2.36	.28	.55	.2500	3	3BX
T351NC#8-32R3BX	8 - 32	2.36	.28	.63	.2500	3	3BX
T351NF#10-32R3BX *	10 - 32	2.36	.35	.79	.2500	3	3BX
T351NC02500-20R3BX	1/4 - 20	2.76	.59	.95	.2500	4	3BX
T351NC03125-18R3BX	5/16 - 18	3.15	.67	1.26	.3125	4	3BX
T351NC03750-16R3BX	3/8 - 16	3.54	.75	1.57	.3750	4	3BX
T351NC04375-14R3BX	7/16 - 14	3.94	.87	1.73	.4375	4	3BX
T351NC05000-13R3BX	1/2 - 13	3.94	.94	1.89	.5000	4	3BX
T351NC06250-11R3BX	5/8 - 11	4.33	1.10	2.52	.5625	5	3BX
T351NC07500-10R3BX	3/4 - 10	4.92	1.22	3.01	.6250	5	3BX

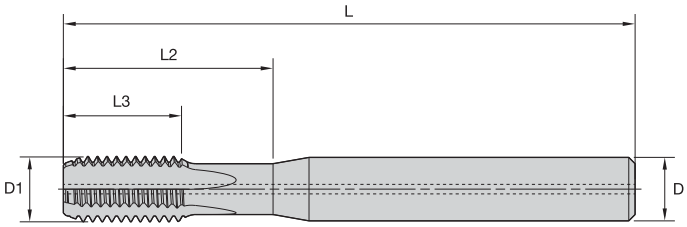
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Shank Tolerance

D	tolerance h6
.250–.375	+0, -.0004
.438–.625	+0, -.0004

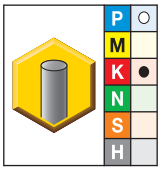
• KCK17 AlCrTiN for cast iron.







T351 • Form E Bottoming Chamfer • Through Coolant M6 and Larger • Metric • Solid Carbide • For Cast Iron



● first choice
○ alternate choice

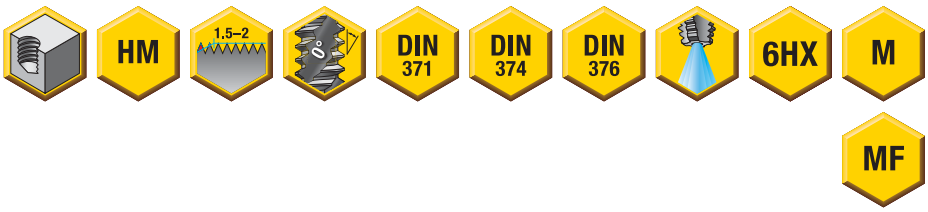
KCK17	D1 size	L	L3	L2	D	number of flutes	class of fit
T351M040X070R6HX *	M4 X 0,7	60	6	16	6,0	3	6HX
T351M050X080R6HX	M5 X 0,8	60	7	20	6,0	3	6HX
T351M060X100R6HX	M6 X 1	70	12	24	6,0	4	6HX
T351M080X125R6HX	M8 X 1,25	80	15	32	8,0	4	6HX
T351MF100X100R6HX	M10 X 1	90	18	40	10,0	4	6HX
T351M100X150R6HX	M10 X 1,5	90	18	40	10,0	4	6HX
T351MF120X150R6HX	M12 X 1,5	100	21	48	12,0	4	6HX
T351M120X175R6HX	M12 X 1,75	100	21	48	12,0	4	6HX
T351MF140X150R6HX	M14 X 1,5	110	24	56	12,0	4	6HX
T351M140X200R6HX	M14 X 2	110	24	56	12,0	4	6HX
T351M160X200R6HX	M16 X 2	110	24	64	14,0	4	6HX

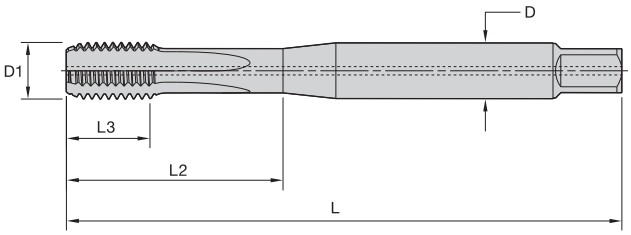
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Shank Tolerance

D	tolerance h6
6	+0, -0,008
8–10	+0, -0,009
12–16	+0, -0,011

• KCK17 AlCrTiN for cast iron.

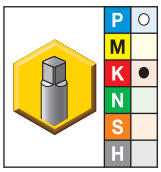






beyond

T351 • DIN 371, 374, and 376 • Form E Bottoming Chamfer • Through Coolant • Metric • Solid Carbide • For Cast Iron



● first choice
○ alternate choice

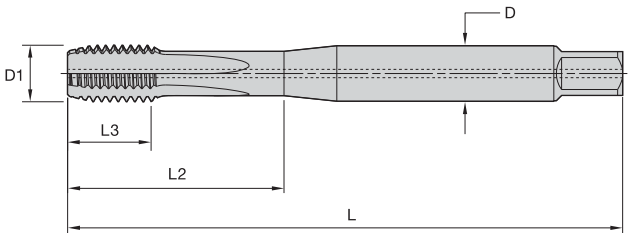
KCK17	D1 size	L	L3	L2	D	number of flutes	dimension standard	class of fit
T351M060X100R6HX-D1	M6 X 1	80	10	30	6,0	4	DIN 371	6HX
T351M070X100R6HX-D1	M7 X 1	80	10	30	7,0	4	DIN 371	6HX
T351M080X125R6HX-D1	M8 X 1,25	90	13	35	8,0	4	DIN 371	6HX
T351M090X125R6HX-D1	M9 X 1,25	90	13	35	9,0	4	DIN 371	6HX
T351MF100X100R6HX-D4	M10 X 1	90	10	35	7,0	4	DIN 374	6HX
T351MF100X125R6HX-D4	M10 X 1,25	100	15	39	7,0	4	DIN 374	6HX
T351M100X150R6HX-D1	M10 X 1,5	100	15	39	10,0	4	DIN 371	6HX
T351MF120X125R6HX-D4	M12 X 1,25	100	15	39	9,0	4	DIN 374	6HX
T351MF120X150R6HX-D4	M12 X 1,50	100	15	39	9,0	4	DIN 374	6HX
T351M120X175R6HX-D6	M12 X 1,75	110	18	44	9,0	4	DIN 376	6HX
T351MF140X125R6HX-D4	M14 X 1,25	100	15	47	11,0	4	DIN 374	6HX
T351MF140X150R6HX-D4	M14 X 1,5	100	15	47	11,0	4	DIN 374	6HX
T351M140X2006RHX-D6	M14 X 2	110	20	52	11,0	4	DIN 376	6HX

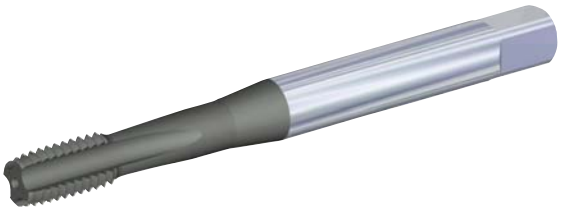
Shank Tolerance

D	tolerance h6
3–6	+0, -0,008
>6–10	+0, -0,009
>10–18	+0, -0,011
>18–30	+0, -0,013
>30–50	+0, -0,016

- KCK17 AlCrTiN for cast iron.

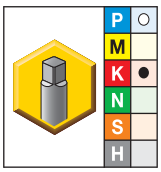






beyond

T353 • DIN 371 and 376 • Form C Semi-Bottoming Chamfer • Through Coolant M6 and Larger • Metric • Solid Carbide • For Cast Iron



● first choice
○ alternate choice

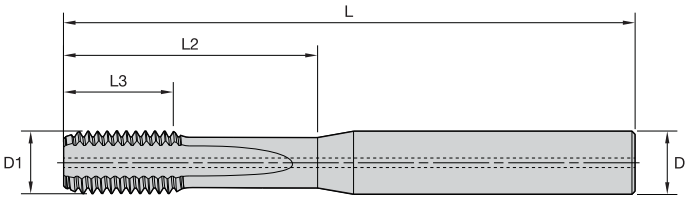
KCK17	D1 size	L	L3	L2	D	number of flutes	dimension standard	class of fit
T353M040X070R6HX-D1	M4 X 0,7	63	10	21	4,5	3	DIN 371	6HX
T353M050X080R6HX-D1	M5 X 0,8	70	10	25	6,0	3	DIN 371	6HX
T353M060X100R6HX-D1	M6 X 1	80	10	30	6,0	4	DIN 371	6HX
T353M080X125R6HX-D1	M8 X 1,25	90	13	35	8,0	4	DIN 371	6HX
T353M100X150R6HX-D1	M10 X 1,5	100	15	39	10,0	4	DIN 371	6HX
T353M120X175R6HX-D6	M12 X 1,75	110	18	44	9,0	4	DIN 376	6HX
T353M140X200R6HX-D6	M14 X 2	110	20	52	11,0	4	DIN 376	6HX

Shank Tolerance

D	tolerance h6
3–6	+0, -0,008
>6–10	+0, -0,009
>10–18	+0, -0,011
>18–30	+0, -0,013
>30–50	+0, -0,016

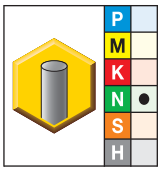
• KCN14 TiN + CrC/C for aluminium.







T471 • Form E Bottoming Chamfer • Through Coolant • Metric • Solid Carbide • For Aluminium



● first choice
○ alternate choice

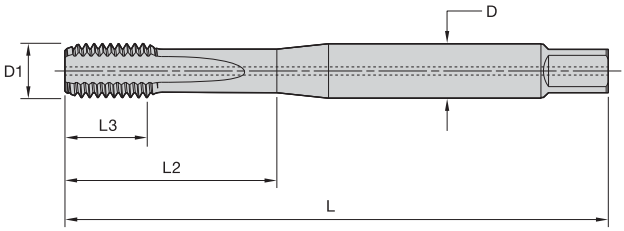
KCN14	D1 size	L	L3	L2	D	number of flutes	class of fit
T471M060X100R6HX	M6 X 1	70	12	24	6,0	3	6HX
T471M080X125R6HX	M8 X 1,25	80	15	32	8,0	3	6HX
T471M100X150R6HX	M10 X 1,5	90	18	40	10,0	3	6HX
T471M120X175R6HX	M12 X 1,75	100	21	48	12,0	3	6HX
T471M140X200R6HX	M14 X 2	110	24	56	12,0	4	6HX

Shank Tolerance

D	tolerance h6
6	+0, -0,008
8–10	+0, -0,009
12–16	+0, -0,011

• KCN14 TiN + CrC/C for aluminium.

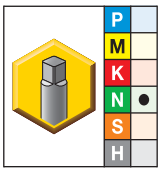






beyond

T471 • DIN 371 • Form E Bottoming Chamfer • Through Coolant • Metric • Solid Carbide • For Aluminium



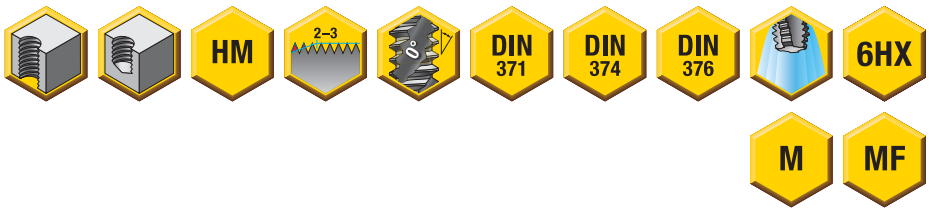
● first choice
○ alternate choice

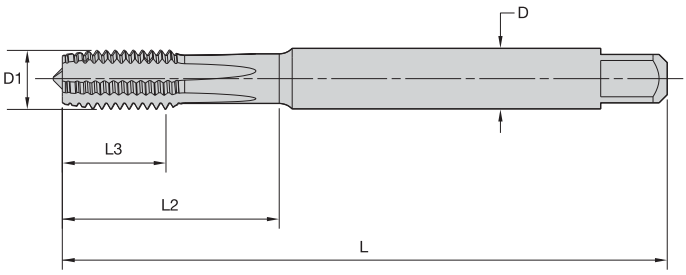
KCN14	D1 size	L	L3	L2	D	number of flutes	dimension standard	class of fit
T471M060X100R6HX-D1	M6 X 1	80	10	30	6,0	3	DIN 371	6HX
T471M080X125R6HX-D1	M8 X 1,25	90	10	35	8,0	3	DIN 371	6HX
T471M100X150R6HX-D1	M10 X 1,5	100	15	39	10,0	3	DIN 371	6HX

Shank Tolerance

D	tolerance h6
3–6	+0, -0,008
>6–10	+0, -0,009
>10–18	+0, -0,011
>18–30	+0, -0,013
>30–50	+0, -0,016

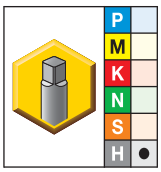
- KCU36 TiAlN/MoS_2 for tapping steel 55–63 HRC.







T410 • DIN 371, 374, and 376 • Form C Semi-Bottoming Chamfer • Metric • Solid Carbide • For Hard Steel



● first choice
○ alternate choice

KCU36	D1 size	L	L3	L2	D	number of flutes	dimension standard	class of fit
T410M030X050R6HX-D1	M3 X 0,5	63	6	18	4,5	4	DIN 371	6HX
T410M040X070R6HX-D1	M4 X 0,7	63	8	20	4,5	4	DIN 371	6HX
T410M050X080R6HX-D1	M5 X 0,8	70	10	26	6,0	4	DIN 371	6HX
T410M060X100R6HX-D1	M6 X 1	80	12	28	6,0	4	DIN 371	6HX
T410MF080X100R6HX-D4 *	M8 X 1	90	15	35	8,0	5	DIN 374	6HX
T410M080X125R6HX-D1	M8 X 1,25	90	15	35	8,0	5	DIN 371	6HX
T410MF100X100R6HX-D4 *	M10 X 1	100	18	38	10,0	5	DIN 374	6HX
T410M100X150R6HX-D1	M10 X 1,5	100	18	38	10,0	5	DIN 371	6HX
T410MF120X150R6HX-D4	M12 X 1,5	110	21	41	12,0	5	DIN 374	6HX
T410M120X175R6HX-D6	M12 X 1,75	110	21	41	12,0	5	DIN 376	6HX
T410MF140X150R6HX-D4	M14 X 1,5	110	24	44	14,0	5	DIN 374	6HX
T410M140X200R6HX-D6	M14 X 2	110	24	44	14,0	6	DIN 376	6HX
T410MF160X150R6HX-D4	M16 X 1,5	110	24	44	16,0	5	DIN 374	6HX

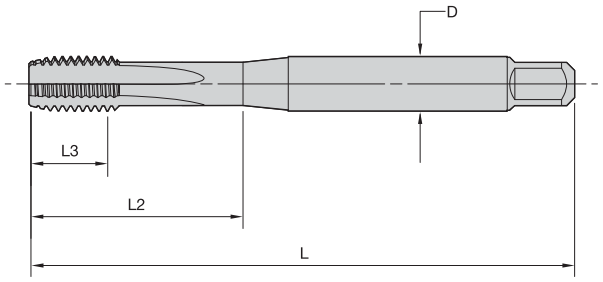
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

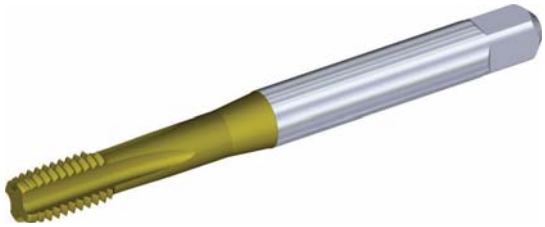
Shank Tolerance

D	tolerance h9
1–3	+0, -0,025
3,5–6	+0, -0,030
7–10	+0, -0,036
11–18	+0, -0,043

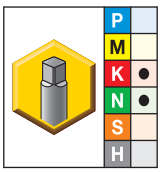
- KP6525 TiCN + TiN for cast iron and cast aluminium.







T640 • DIN 371 and 376 • Form C Semi-Bottoming Chamfer • Metric • For Cast Iron and Cast Aluminium



● first choice
○ alternate choice

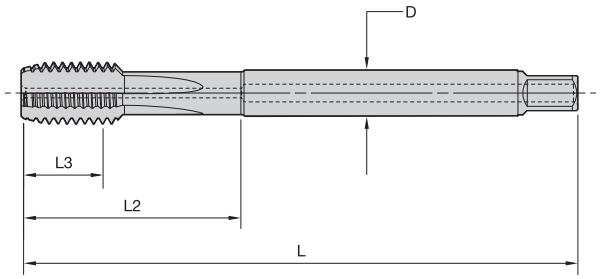
KP6525	D1 size	L	L3	L2	D	number of flutes	dimension standard	class of fit
T640M040X070R6HX-D1	M4 X 0,7	63	10	21	4,5	3	DIN 371	6HX
T640M050X080R6HX-D1	M5 X 0,8	70	10	25	6,0	3	DIN 371	6HX
T640M060X100R6HX-D1	M6 X 1	80	10	30	6,0	4	DIN 371	6HX
T640M080X125R6HX-D1	M8 X 1,25	90	13	35	8,0	4	DIN 371	6HX
T640M100X150R6HX-D1	M10 X 1,5	100	15	39	10,0	4	DIN 371	6HX
T640M120X175R6HX-D6	M12 X 1,75	110	18	44	9,0	4	DIN 376	6HX
T640M140X200R6HX-D6	M14 X 2	110	20	52	11,0	4	DIN 376	6HX
T640M160X200R6HX-D6	M16 X 2	110	20	51	12,0	4	DIN 376	6HX
T640M180X250R6HX-D6	M18 X 2,5	125	25	58	14,0	4	DIN 376	6HX
T640M200X250R6HX-D6	M20 X 2,5	140	25	64	16,0	4	DIN 376	6HX
T640M220X250R6HX-D6	M22 X 2,5	140	25	70	18,0	4	DIN 376	6HX

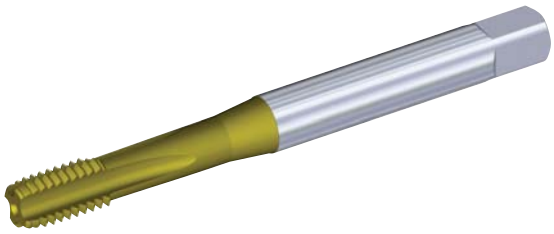
Shank Tolerance

D	tolerance h6
6	+0, -0,008
8–10	+0, -0,009
12–16	+0, -0,011

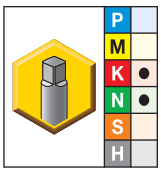
- KP6525 TiCN + TiN for cast iron and cast aluminium.







T641 • DIN 371 and 376 • Form C Semi-Bottoming Chamfer • Through Coolant • Metric • For Cast Iron and Cast Aluminium



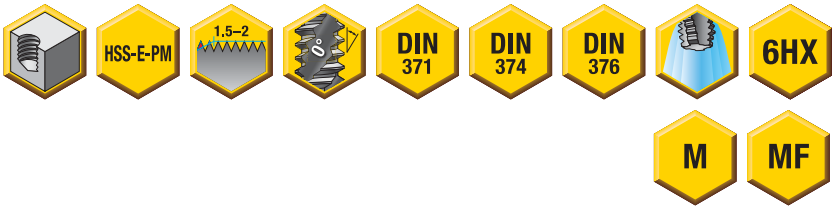
● first choice
○ alternate choice

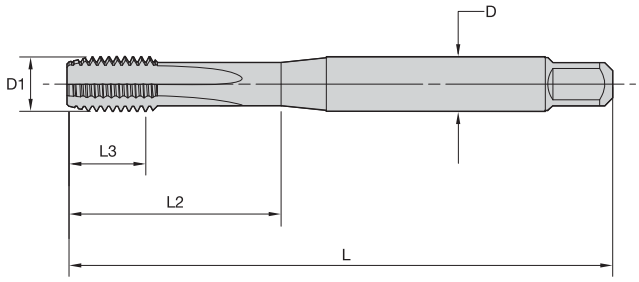
KP6525	D1 size	L	L3	L2	D	number of flutes	dimension standard	class of fit
T641M050X080R6HX-D1	M5 X 0,8	70	10	25	6,0	3	DIN 371	6HX
T641M060X100R6HX-D1	M6 X 1	80	10	30	6,0	4	DIN 371	6HX
T641M080X125R6HX-D1	M8 X 1,25	90	13	35	8,0	4	DIN 371	6HX
T641M100X150R6HX-D1	M10 X 1,5	100	15	39	10,0	4	DIN 371	6HX
T641M120X175R6HX-D6	M12 X 1,75	110	18	44	9,0	4	DIN 376	6HX
T641M140X200R6HX-D6	M14 X 2	110	20	52	11,0	4	DIN 376	6HX
T641M160X200R6HX-D6	M16 X 2	110	20	51	12,0	4	DIN 376	6HX
T641M180X250R6HX-D6	M18 X 2,5	125	25	58	14,0	4	DIN 376	6HX
T641M200X250R6HX-D6	M20 X 2,5	140	25	64	16,0	4	DIN 376	6HX

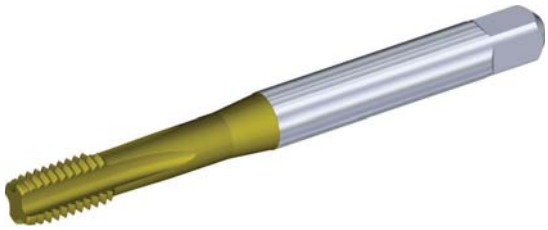
Shank Tolerance

D	tolerance h6
6	+0, -0,008
8–10	+0, -0,009
12–16	+0, -0,011

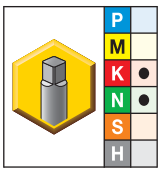
- KP6525 TiCN + TiN for cast iron and cast silicon aluminium.







T642 • DIN 371, 374, and 376 • Form E Bottoming Chamfer • Metric • For Cast Iron and Cast Silicon Aluminium



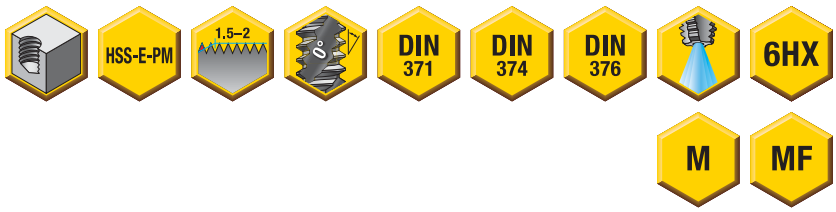
● first choice
○ alternate choice

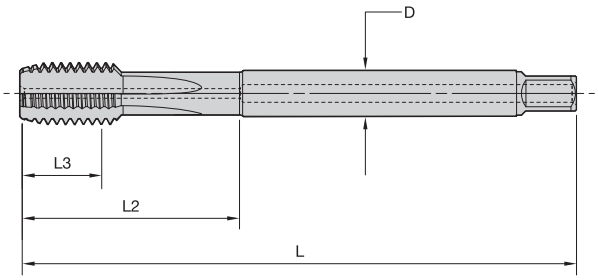
KP6525	D1 size	L	L3	L2	D	number of flutes	dimension standard	class of fit
T642M050X080R6HX-D1	M5 X 0,8	70	10	25	6,0	3	DIN 371	6HX
T642M060X100R6HX-D1	M6 X 1	80	10	30	6,0	4	DIN 371	6HX
T642M080X125R6HX-D1	M8 X 1,25	90	13	35	8,0	4	DIN 371	6HX
T642M100X150R6HX-D1	M10 X 1,5	100	15	39	10,0	4	DIN 371	6HX
T642MF120X150R6HX-D4	M12 X 1,5	100	15	39	9,0	4	DIN 374	6HX
T642M120X175R6HX-D6	M12 X 1,75	110	18	44	9,0	4	DIN 376	6HX
T642MF140X150R6HX-D4	M14 X 1,5	100	15	47	11,0	4	DIN 374	6HX
T642M140X200R6HX-D6	M14 X 2	110	20	52	11,0	4	DIN 376	6HX
T642MF160X150R6HX-D4	M16 X 1,5	100	15	46	12,0	4	DIN 374	6HX

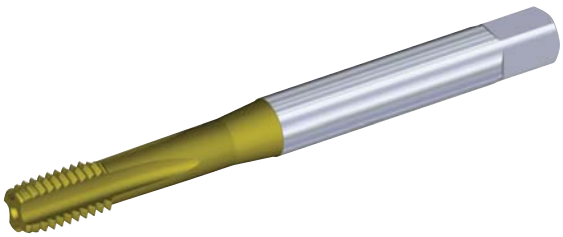
Shank Tolerance

D	tolerance h6
6	+0, -0,008
8–10	+0, -0,009
12–16	+0, -0,011

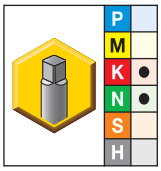
- KP6525 TiCN + TiN for tapping cast iron and cast silicon aluminium.







T643 • DIN 371, 374, and 376 • Form E Bottoming Chamfer • Through Coolant • Metric • For Cast Iron and Cast Silicon Aluminium



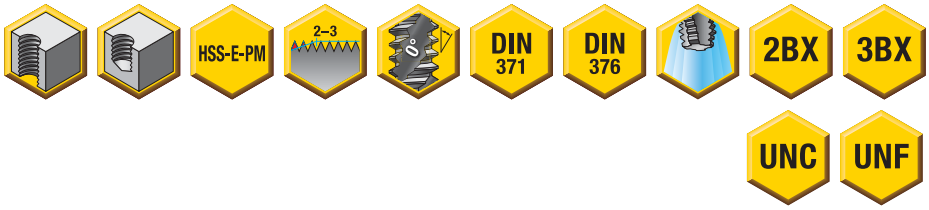
● first choice
○ alternate choice

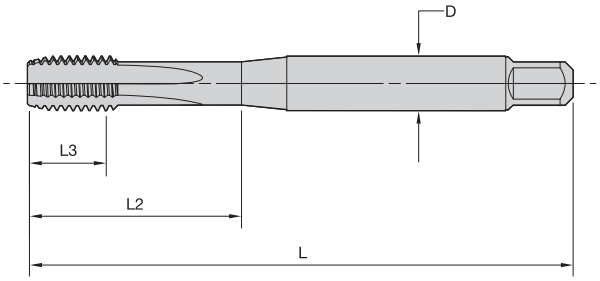
KP6525	D1 size	L	L3	L2	D	number of flutes	dimension standard	class of fit
T643M050X080R6HX-D1	M5 X 0,8	70	10	25	6,0	3	DIN 371	6HX
T643M060X100R6HX-D1	M6 X 1	80	10	30	6,0	4	DIN 371	6HX
T643M080X125R6HX-D1	M8 X 1,25	90	13	35	8,0	4	DIN 371	6HX
T643M100X150R6HX-D1	M10 X 1,5	100	15	39	10,0	4	DIN 371	6HX
T643MF120X150R6HX-D4	M12 X 1,5	100	15	39	9,0	4	DIN 374	6HX
T643M120X175R6HX-D6	M12 X 1,75	110	18	44	9,0	4	DIN 376	6HX
T643MF140X150R6HX-D4	M14 X 1,5	100	15	47	11,0	4	DIN 374	6HX
T643M140X200R6HX-D6	M14 X 2	110	20	52	11,0	4	DIN 376	6HX
T643MF160X150R6HX-D4	M16 X 1,5	100	15	46	12,0	4	DIN 374	6HX

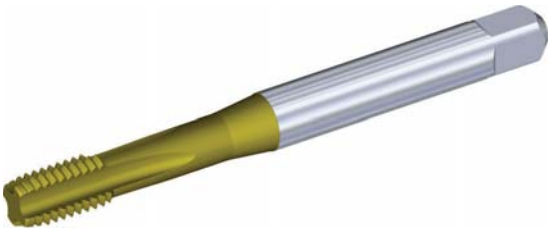
Shank Tolerance

D	tolerance h6
6	+0, -0,008
8–10	+0, -0,009
12–16	+0, -0,011

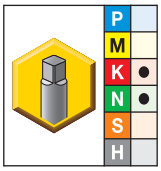
- KP6525 TiCN + TiN for cast iron and cast aluminium.







T640 • DIN 371 and 376 • Form C Semi-Bottoming Chamfer • Machine Screw and Fractional • For Cast Iron and Cast Aluminium



● first choice
○ alternate choice

KP6525	D1 size	L	L3	L2	D	number of flutes	dimension standard	class of fit
T640NC#06-32R2BX-D1	6 - 32	56	9	20	4,0	3	DIN 371	2BX
T640NF#06-40R2BX-D1 *	6 - 40	56	9	20	4,0	3	DIN 371	2BX
T640NC#08-32R2BX-D1	8 - 32	63	10	21	4,5	3	DIN 371	2BX
T640NC#10-24R2BX-D1	10 - 24	70	10	25	6,0	3	DIN 371	2BX
T640NF#10-32R2BX-D1	10 - 32	70	10	25	6,0	3	DIN 371	2BX
T640NC02500-20R3BX-D1	1/4 - 20	80	13	30	7,0	4	DIN 371	3BX
T640NF02500-28R3BX-D1	1/4 - 28	80	13	30	7,0	4	DIN 371	3BX
T640NC03125-18R3BX-D1	5/16 - 18	90	13	35	8,0	4	DIN 371	3BX
T640NF03125-24R3BX-D1	5/16 - 24	90	13	35	8,0	4	DIN 371	3BX
T640NC03750-16R3BX-D1	3/8 - 16	100	16	39	10,0	4	DIN 371	3BX
T640NF03750-24R3BX-D1	3/8 - 24	100	16	39	10,0	4	DIN 371	3BX
T640NC04375-14R3BX-D6	7/16 - 14	100	15	41	8,0	4	DIN 376	3BX
T640NF04375-20R3BX-D6	7/16 - 20	100	15	41	8,0	4	DIN 376	3BX
T640NC05000-13R3BX-D6	1/2 - 13	110	20	47	9,0	4	DIN 376	3BX
T640NF05000-20R3BX-D6	1/2 - 20	110	20	47	9,0	4	DIN 376	3BX

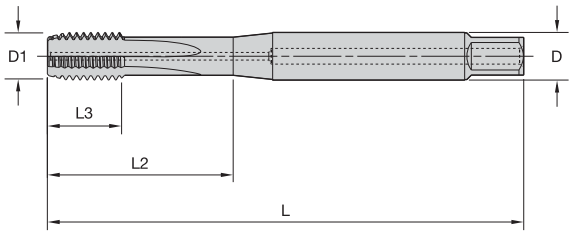
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

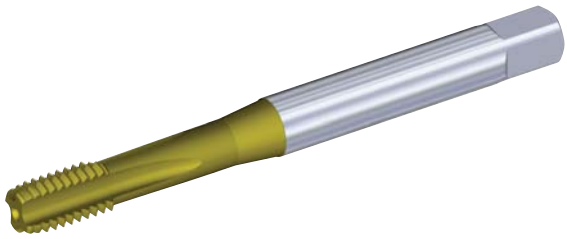
Shank Tolerance

D fractional	tolerance h6
>3–6	+0, -0,008
>6–10	+0, -0,009
<10–18	+0, -0,011

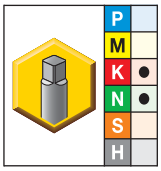
- KP6525 TiCN + TiN for cast iron and cast aluminium.







T641 • DIN 371 and 376 • Form C Semi-Bottoming Chamfer • Through Coolant • Fractional • For Cast Iron and Cast Aluminium



● first choice
○ alternate choice

KP6525	D1 size	L	L3	L2	D	number of flutes	dimension standard	class of fit
T641NC02500-20R3BX-D1	1/4 - 20	80	13	30	7,0	4	DIN 371	3BX
T641NF02500-28R3BX-D1	1/4 - 28	80	13	30	7,0	4	DIN 371	3BX
T641NC03125-18R3BX-D1	5/16 - 18	90	13	35	8,0	4	DIN 371	3BX
T641NF03125-24R3BX-D1	5/16 - 24	90	13	35	8,0	4	DIN 371	3BX
T641NC03750-16R3BX-D1	3/8 - 16	100	16	39	10,0	4	DIN 371	3BX
T641NF03750-24R3BX-D1	3/8 - 24	100	16	39	10,0	4	DIN 371	3BX
T641NC04375-14R3BX-D6	7/16 - 14	100	15	41	8,0	4	DIN 376	3BX
T641NF04375-20R3BX-D6	7/16 - 20	100	15	41	8,0	4	DIN 376	3BX
T641NC05000-13R3BX-D6	1/2 - 13	110	20	47	9,0	4	DIN 376	3BX
T641NF05000-20R3BX-D6	1/2 - 20	110	20	47	9,0	4	DIN 376	3BX

Shank Tolerance

D fractional	tolerance h6
>3–6	+0, -0,008
>6–10	+0, -0,009
<10–18	+0, -0,011

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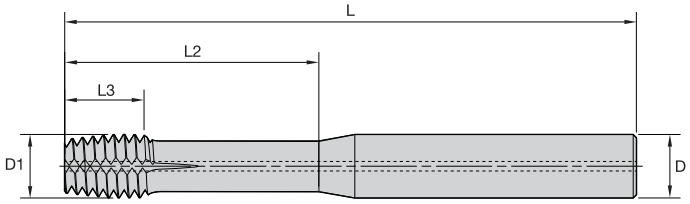
• KCN14 TiN + CrC/C for aluminium.

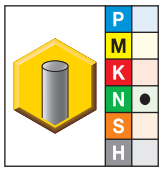






beyond

T491 • Form E Bottoming Entry Taper • Through Coolant M6 and Larger • Metric • Solid Carbide • For Aluminium



● first choice
○ alternate choice

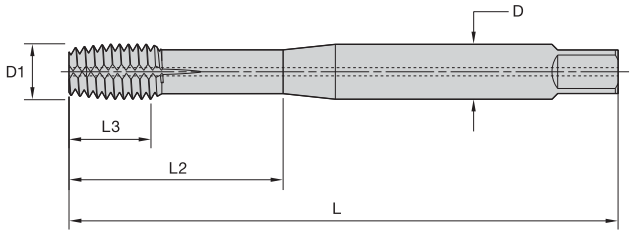
KCN14	D1 size	L	L3	L2	D	number of lube grooves	class of fit
T491M050X080R6HX	M5 X 0,8	60	7	20	6,0	2	6HX
T491M060X100R6HX	M6 X 1	70	8	24	6,0	2	6HX
T491M080X125R6HX	M8 X 1,25	80	10	32	8,0	2	6HX
T491M100X150R6HX	M10 X 1,5	90	12	40	10,0	3	6HX
T491M120X175R6HX	M12 X 1,75	100	14	48	12,0	3	6HX

Shank Tolerance

D	tolerance h6
6	+0, -0,008
8–10	+0, -0,009
12–16	+0, -0,011

• KCN14 TiN + CrC/C for aluminium.

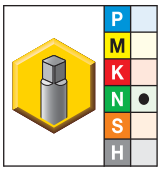






beyond

T491 • DIN 2174 • Form E Bottoming Chamfer • Through Coolant • Metric • Solid Carbide • For Aluminium



● first choice
○ alternate choice

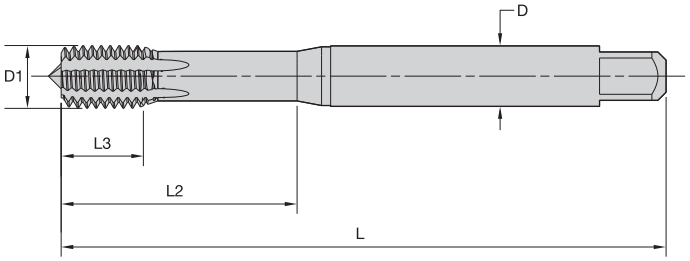
KCN14	D1 size	L	L3	L2	D	number of lube grooves	dimension standard	class of fit
T491M060X100R6HX-D74	M6 X 1	80	10	30	6,0	2	DIN 2174	6HX
T491M080X125R6HX-D74	M8 X 1,25	90	13	35	8,0	2	DIN 2174	6HX
T491M100X150R6HX-D74	M10 X 1,5	100	15	39	10,0	3	DIN 2174	6HX

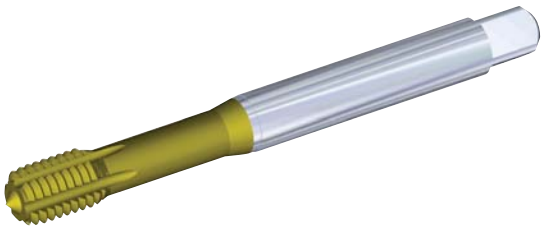
Shank Tolerance

D	tolerance h6
3–6	+0, -0,008
>6–10	+0, -0,009
>10–18	+0, -0,011
>18–30	+0, -0,013
>30–50	+0, -0,016

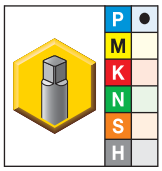
- KSP21 TiN for tapping steel.
- KSN28 DLC for tapping aluminium.

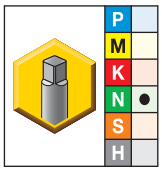






T622 • DIN 2174 • Form C Semi-Bottoming Entry Taper • Metric • For Steel and Aluminium





● first choice
○ alternate choice

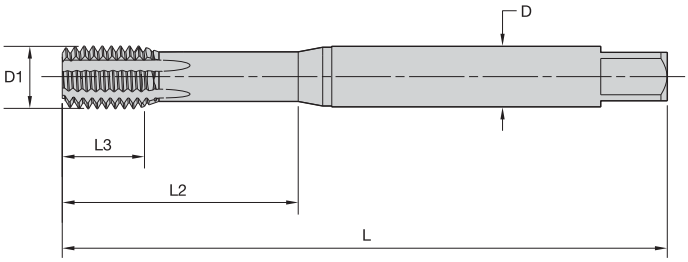
KSP21	KSN28	D1 size	L	L3	L2	D	number of lube grooves	dimension standard	class of fit
T622M030X050R6HX-D74	T622M030X050R6HX-D74	M3 X 0,5	56	6	18	3,5	4	DIN 2174	6HX
T622M040X070R6HX-D74	T622M040X070R6HX-D74	M4 X 0,7	63	7	21	4,5	4	DIN 2174	6HX
T622M050X080R6HX-D74	T622M050X080R6HX-D74	M5 X 0,8	70	8	25	6,0	4	DIN 2174	6HX
T622M060X100R6HX-D74	T622M060X100R6HX-D74	M6 X 1	80	10	30	6,0	5	DIN 2174	6HX
T622MF080X100R6HX-D74	T622MF080X100R6HX-D74	M8 X 1	90	10	35	8,0	5	DIN 2174	6HX
T622M080X125R6HX-D74	T622M080X125R6HX-D74	M8 X 1,25	90	14	35	8,0	5	DIN 2174	6HX
T622MF100X100R6HX-D74	T622MF100X100R6HX-D74 *	M10 X 1	90	10	35	10,0	5	DIN 2174	6HX
T622MF100X125R6HX-D74	T622MF100X125R6HX-D74	M10 X 1,25	100	16	39	10,0	5	DIN 2174	6HX
T622M100X150R6HX-D74	T622M100X150R6HX-D74	M10 X 1,5	100	16	39	10,0	5	DIN 2174	6HX
T622MF120X125R6HX-D74	T622MF120X125R6HX-D74	M12 X 1,25	100	15	39	9,0	6	DIN 2174	6HX
T622MF120X150R6HX-D74	T622MF120X150R6HX-D74	M12 X 1,5	100	15	39	9,0	6	DIN 2174	6HX
T622M120X175R6HX-D74	T622M120X175R6HX-D74	M12 X 1,75	110	18	44	9,0	6	DIN 2174	6HX
T622MF140X150R6HX-D74	T622MF140X150R6HX-D74	M14 X 1,5	100	15	47	11,0	6	DIN 2174	6HX
T622MF160X150R6HX-D74	T622MF160X150R6HX-D74	M16 X 1,5	100	15	46	12,0	6	DIN 2174	6HX
T622M160X200R6HX-D74	T622M160X200R6HX-D74	M16 X 2	110	22	51	12,0	6	DIN 2174	6HX

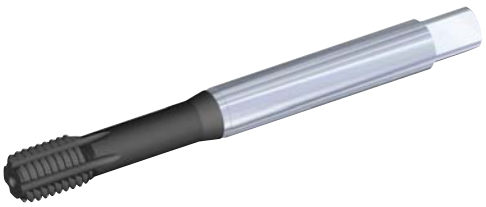
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Shank Tolerance	
D	tolerance h9
1–3	+0, -0,025
3,5–6	+0, -0,030
7–10	+0, -0,036
11–18	+0, -0,043

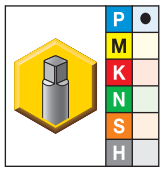
- KSP21 TiN for tapping steel.
- KSN28 DLC for tapping aluminium.

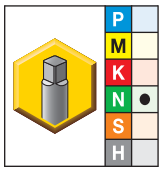






T623 • DIN 2174 • Form C Semi-Bottoming Entry Taper • Through Coolant • Metric • For Steel and Aluminium





● first choice
○ alternate choice

KSP21	KSN28	D1 size	L	L3	L2	D	number of lube grooves	dimension standard	class of fit
T623M050X080R6HX-D74	**T623M050X080R6HX-D74**	M5 X 0,8	70	8	25	6,0	4	DIN 2174	6HX
T623M060X100R6HX-D74	**T623M060X100R6HX-D74**	M6 X 1	80	10	30	6,0	5	DIN 2174	6HX
T623MF080X100R6HX-D74	**T623MF080X100R6HX-D74** *	M8 X 1	90	10	35	8,0	5	DIN 2174	6HX
T623M080X125R6HX-D74	**T623M080X125R6HX-D74**	M8 X 1,25	90	14	35	8,0	5	DIN 2174	6HX
T623MF100X100R6HX-D74	**T623MF100X100R6HX-D74**	M10 X 1	90	10	35	10,0	5	DIN 2174	6HX
T623M100X150R6HX-D74	**T623M100X150R6HX-D74**	M10 X 1,5	100	16	39	10,0	5	DIN 2174	6HX
T623MF120X150R6HX-D74	**T623MF120X150R6HX-D74**	M12 X 1,5	100	15	27	9,0	6	DIN 2174	6HX
T623M120X175R6HX-D74	**T623M120X175R6HX-D74**	M12 X 1,75	110	18	30	9,0	6	DIN 2174	6HX
T623MF140X150R6HX-D74	**T623MF140X150R6HX-D74**	M14 X 1,5	100	15	29	11,0	6	DIN 2174	6HX
T623MF160X150R6HX-D74	**T623MF160X150R6HX-D74**	M16 X 1,5	100	15	31	12,0	6	DIN 2174	6HX
T623M160X200R6HX-D74	**T623M160X200R6HX-D74**	M16 X 2	110	22	38	12,0	6	DIN 2174	6HX

NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Shank Tolerance

D	tolerance h9
1–3	+0, -0,025
3,5–6	+0, -0,030
7–10	+0, -0,036
11–18	+0, -0,043

Pipe Taps



High-Performance Pipe Taps for Through-Hole and Blind-Hole Applications

- Steel and steel alloys.
- Aluminium.

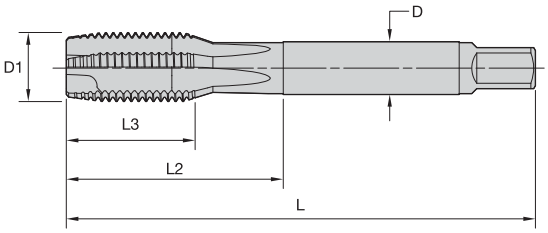
Multipurpose HSS-E GOtap™ Taps

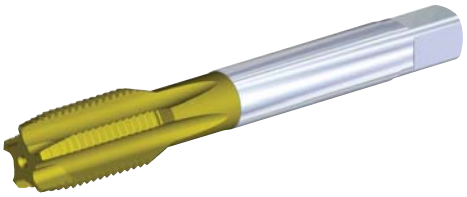
- NPT and NPTF taper pipe taps with standard projections and standard chamfers for ductile materials and mould steels.
- DIN EN ISO 228 G straight pipe taps with Whitworth thread form for ductile materials.
- Manufactured with high-vanadium HSS-E material for exceptional wear characteristics and longer tool life.
- Advanced PVD coatings to reduce tapping torque, resulting in high-quality thread finish and longer tool life.
- For use in both synchronous and non-synchronous machines, including rigid, synchronous, and tension/compression tap holders.



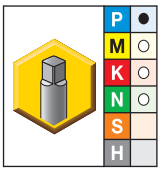
- KSU31 TiN
- KSP39 oxide

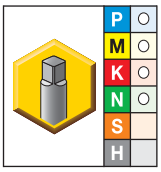






T877 • (G) Whitworth Pipe Thread • DIN EN ISO 228 • Form B





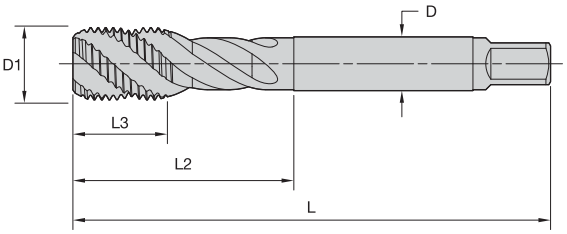
● first choice
○ alternate choice

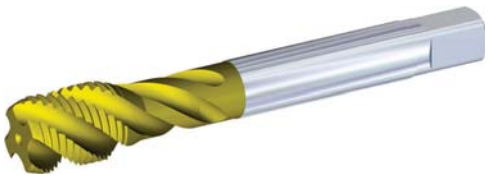
KSU31	KSP39	D1 size	L	L3	L2	D	number of flutes	thread type
T877G01250-28R-D56	T877G01250-28R-D56	1/8 - 28	90	15	35	7	3	G
T877G02500-19R-D56	T877G02500-19R-D56	1/4 - 19	100	22	44	11	3	G
T877G03750-19R-D56	T877G03750-19R-D56	3/8 - 19	100	22	47	12	4	G
T877G05000-14R-D56	T877G05000-14R-D56	1/2 - 14	125	25	55	16	4	G
T877G06250-14R-D56	T877G06250-14R-D56	5/8 - 14	125	25	61	18	4	G
T877G07500-14R-D56	T877G07500-14R-D56	3/4 - 14	140	25	60	20	4	G
T877G08750-14R-D56	T877G08750-14R-D56	7/8 - 14	150	28	68	22	4	G
T877G10000-11R-D56	T877G10000-11R-D56	1 - 11	160	30	68	25	5	G

GOtap™ Spiral-Flute HSS-E ISO Pipe Taps • Blind Holes

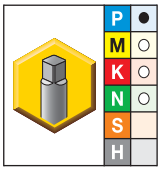
- KSU31 TiN
- KSP39 oxide

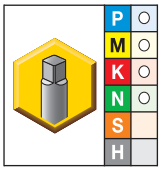






T857 • (G) Whitworth Pipe Thread • DIN EN ISO 228 • Form C • Tension/Compression Holders





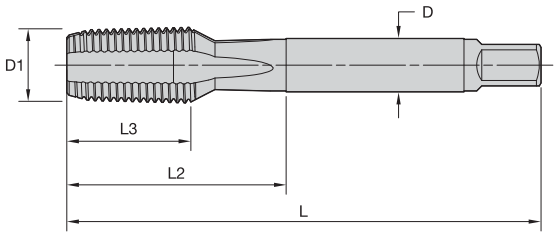
● first choice
○ alternate choice

KSU31	KSP39	D1 size	L	L3	L2	D	number of flutes	thread type
T857G01250-28R-D56	T857G01250-28R-D56	1/8 - 28	90	15	37	7	3	G
T857G02500-19R-D56	T857G02500-19R-D56	1/4 - 19	100	15	44	11	3	G
T857G03750-19R-D56	T857G03750-19R-D56	3/8 - 19	100	15	47	12	4	G
T857G05000-14R-D56	T857G05000-14R-D56	1/2 - 14	125	18	55	16	4	G
T857G06250-14R-D56	T857G06250-14R-D56	5/8 - 14	125	18	61	18	4	G
T857G07500-14R-D56	T857G07500-14R-D56	3/4 - 14	140	20	65	20	4	G
T857G08750-14R-D56	T857G08750-14R-D56	7/8 - 14	150	22	68	22	4	G
T857G10000-11R-D56	T857G10000-11R-D56	1 - 11	160	24	74	25	5	G

NOTE: Suitable for tension/compression holders.

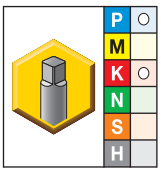
• KSU30 bright







T848 • NPT and NPTF • Standard Projection • Form C



● first choice
○ alternate choice

KSU30	D1 size	L	L3	L2	D	number of flutes	thread type
T848NPT00625-27R-D56	1/16 - 27	90	13	35	6	3	NPT
T848NPTF00625-27R-D56	1/16 - 27	90	13	35	6	3	NPTF
T848NPT01250-27R-D56	1/8 - 27	90	13	36	7	4	NPT
T848NPTF01250-27R-D56	1/8 - 27	90	13	36	7	4	NPTF
T848NPT02500-18R-D56	1/4 - 18	100	20	39	11	4	NPT
T848NPTF02500-18R-D56	1/4 - 18	100	20	39	11	4	NPTF
T848NPT03750-18R-D56	3/8 - 18	110	20	39	12	4	NPT
T848NPTF03750-18R-D56	3/8 - 18	110	20	39	12	4	NPTF
T848NPT05000-14R-D56	1/2 - 14	125	26	56	16	4	NPT
T848NPTF05000-14R-D56	1/2 - 14	125	26	56	16	4	NPTF
T848NPT07500-14R-D56	3/4 - 14	140	26	55	20	4	NPT
T848NPTF07500-14R-D56	3/4 - 14	140	26	55	20	4	NPTF
T848NPT10000-11,5R-D56	1 - 11 1/2	160	32	71	25	5	NPT
T848NPTF10000-11,5R-D56	1 - 11 1/2	160	32	71	25	5	NPTF

High-Performance Solid Carbide Thread Mills

Our solid carbide thread mills are designed to deliver high-quality internal threading on 3-axis CNC machines. Because these mills are made of carbide, they are capable of easily cutting most difficult materials up to 63 HRC. Thread mills make interrupted cuts and short chips.

The combination of these design elements offers a range of benefits to improve overall thread quality and tool production. Short, easily evacuated chips generate less heat and friction, so there is a lower risk of damage to threading. Also, the superior carbide grades make threading easier and machining times shorter.

Features and Benefits

System Requirements

- 3-axis CNC machine.
- Good clamping for tool and workpiece.
- Internal coolant supply.

Advantages

- Versatile.
- Better surface quality.
- No chip problems.
- No need to reverse the spindle.
- More production safety.

Features

- Interrupted cut.
- Short chips.
- Optimised carbide grades.
- Drill, thread, chamfer.





Through and Blind Holes (2 x D)

					
		Thread Mill	Thread Mill and Chamfer	Drill, Thread Mill, and Chamfer	Mill, Thread Mill, and Chamfer
P	<35 HRC	TM711	TM721	—	TM741_RHSF
P	35–43 HRC	—	TM721	—	TM741_RHSF
M		TM711	TM721	—	TM741_RHSF
K		TM711	TM721	TM731	TM741_RHSF
N	Wrought	TM711	TM721	—	TM731
N	Cast	TM711	TM721	TM731	TM741_RHSF
S		TM711	TM721	—	TM741_LHSF
H	44–63 HRC	—	—	—	TM741_RHSF TM741_LHSF

Solid Thread Mills Identification System

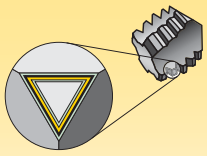


TM721	MF	120	X	150	R	2D	HA
Thread Mill Design	Type of Thread	Nominal Diameter of Thread		Pitch	Cutting Direction	Depth of Cut	Shank
		mm or inch (depending on type)		mm or TPI (depending on type)			

M = Metric coarse-pitch thread (ISO form)
MF = Metric fine-pitch thread (ISO form)
NC = Unified coarse series thread
NF = Unified fine series thread

DIN 6535
HA = Plain Shank
HB = Weldon® Shank
HE = Whistle Notch Shank

Style
TM711 = Solid Thread Mill; Through Coolant
TM721 = Solid Thread Mill and Chamfer; Through Coolant
TM731 = Solid Thread Mill, Chamfer, and Drill; Through Coolant
TM741 = Solid Thread Mill, Chamfer, and Mill; Through Coolant

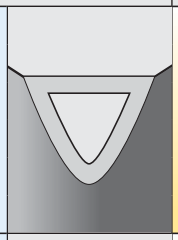
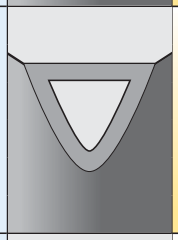
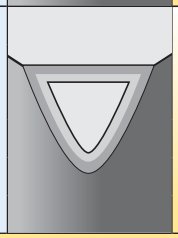


Coatings are designed for optimised tapping performance in specific materials.

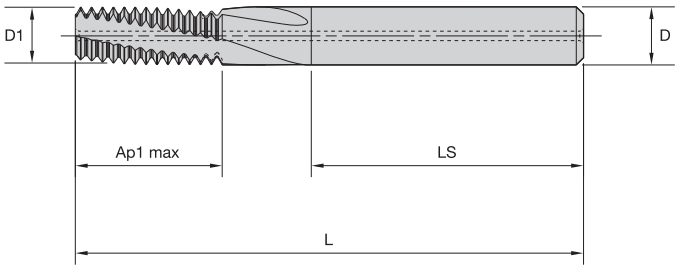
P	Steel
M	Stainless Steel
K	Cast Iron
N	Non-Ferrous
S	High-Temp Alloys
H	Hardened Materials

wear resistance ⟷ toughness

Grade

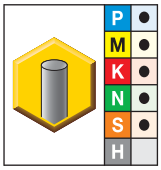
Coating		Grade Description		05	10	15	20	25	30	35	40	45
KCU32		Coated carbide. PVD — Fine-grain carbide substrate with high hardness TiCN coating. Universal grade for thread milling most materials.	P		■	■	■					
			M		■	■	■					
			K		■	■	■					
			N			■	■	■				
			S		■	■	■					
KCU33		Coated carbide. PVD — Carbide substrate with heat-resistant TiAlN coating. Universal grade for thread milling most materials.	P			■	■	■	■			
			M			■	■	■	■			
			K		■	■	■	■				
			N				■	■	■	■		
			S			■	■	■	■			
KCU36		Coated carbide. PVD — two-layer coating with heat-resistant TiAlN base layer and low-friction MoS_2 top layer over carbide substrate. Use for thread milling most materials including high hardness materials.	P				■	■	■	■		
			M				■	■	■	■		
			K			■	■	■	■			
			N			■	■	■	■			
			S				■	■	■	■		
			H					■	■	■	■	







TM711 • Through Coolant • Metric and Metric Fine • Solid Carbide



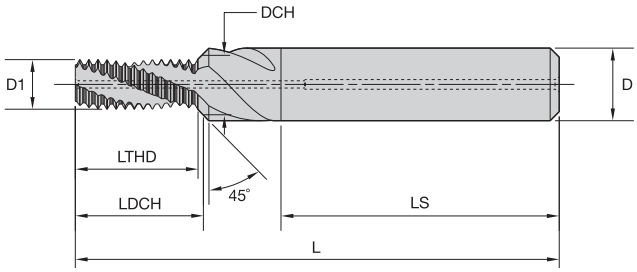
● first choice
○ alternate choice

KCU33	D1 size	D1	Ap1 max	L	LS	D	cutting edges
TM711M030X050R2DHA	M3 X 0.5	2,4	–	42	28	4,0	3
TM711MF040X050R2DHA	M4 X 0.5	3,4	8,2	55	36	6,0	3
TM711M040X070R2DHA	M4 X 0.7	3,2	–	55	36	6,0	3
TM711MF050X050R2DHA	M5 X 0.5	4,3	10,2	55	36	6,0	3
TM711M050X080R2DHA	M5 X 0.8	4,0	–	55	36	6,0	3
TM711MF060X075R2DHA	M6 X 0.75	5,0	12,0	55	36	6,0	3
TM711M060X100R2DHA	M6 X 1	4,8	12,0	55	36	6,0	3
TM711MF080X075R2DHA	M8 X 0.75	6,0	16,8	63	36	6,0	3
TM711MF080X100R2DHA	M8 X 1.0	6,0	16,4	63	36	6,0	3
TM711M080X125R2DHA	M8 X 1.25	5,9	16,0	63	36	6,0	3
TM711MF100X100R2DHA	M10 X 1.0	8,0	20,5	70	36	8,0	3
TM711M100X150R2DHA	M10 X 1.5	8,0	20,2	70	36	8,0	3
TM711MF120X100R2DHA	M12 X 1.0	10,0	24,5	80	40	10,0	4
TM711MF120X150R2DHA	M12 X 1.5	10,0	24,7	80	40	10,0	4
TM711M120X175R2DHA	M12 X 1.75	10,0	25,3	80	40	10,0	4
TM711MF140X150R2DHA	M14 X 1.5	10,0	29,2	80	40	10,0	4
TM711M140X200R2DHA	M14 X 2.0	11,6	28,0	90	45	12,0	4
TM711MF160X150R2DHA	M16 X 1.5	12,0	32,2	90	45	12,0	4
TM711M160X200R2DHA	M16 X 2.0	12,0	32,9	90	45	12,0	4
TM711MF180X150R2DHA	M18 X 1.5	14,0	36,7	90	45	14,0	4
TM711M180X250R2DHA	M18 X 2.5	14,0	38,7	90	45	14,0	4
TM711MF200X150R2DHA	M20 X 1.5	14,0	41,2	90	45	14,0	4
TM711M200X250R2DHA	M20 X 2.5	14,0	41,2	90	45	14,0	4

Shank Tolerance

D	tolerance h6
6	+0, -0,008
8–10	+0, -0,009
12–18	+0, -0,011
20–30	+0, -0,013







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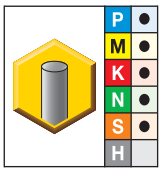


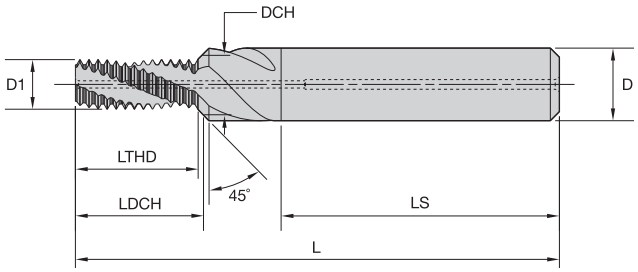
● first choice
○ alternate choice

KCU32	D1 size	D1	DCH	LTHD	LDCH	L	LS	D	cutting edges
TM721NC2500-20R2DHA	1/4-20	4,7	6,7	13,36	14,23	62	36	8,0	3
TM721NC3125-18R2DHA	5/16-18	6,2	8,3	16,26	17,19	74	40	10,0	3
TM721NC3750-16R2DHA	3/8-16	7,7	9,8	19,89	20,85	80	45	12,0	3
TM721NC4375-14R2DHA	7/16-14	9,0	11,4	22,72	23,79	80	45	12,0	3
TM721NC0500-13R2DHA	1/2-13	10,4	13,0	26,43	27,60	90	45	14,0	4
TM721NC5625-12R2DHA	9/16-12	11,8	14,6	30,75	31,99	100	48	16,0	4
TM721NC0625-11R2DHA	5/8-11	13,1	16,2	33,54	34,89	102	48	18,0	4

Shank Tolerance

D	tolerance h6
6	+0, -0,008
8–10	+0, -0,009
12–18	+0, -0,011
20–30	+0, -0,013







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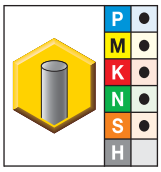


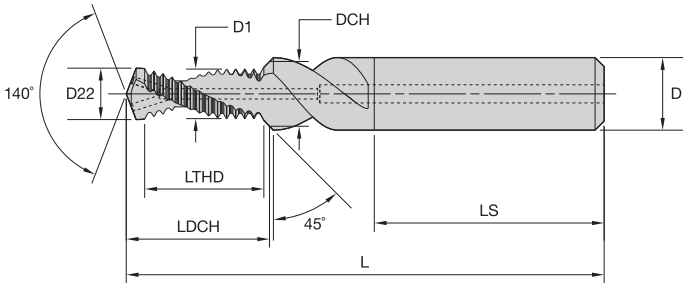
● first choice
○ alternate choice

KCU32	D1 size	D1	DCH	LTHD	LDCH	L	LS	D	cutting edges
TM721M060X100R2DHA	M6X1	4,8	6,3	12,52	13,19	62	36	8,0	3
TM721MF080X100R2DHA	M8X1	6,7	8,3	16,53	17,23	74	40	10,0	3
TM721M080X125R2DHA	M8X1.25	6,5	8,3	16,91	17,71	74	40	10,0	3
TM721M100X150R2DHA	M10X1.5	8,2	10,3	20,29	21,22	80	45	12,0	3
TM721MF120X125R2DHA	M12X1.25	10,4	12,3	24,43	25,24	90	45	14,0	4
TM721M120X175R2DHA	M12X1.75	9,9	12,3	25,42	26,48	90	45	14,0	4
TM721MF140X150R2DHA	M14X1.5	12,1	14,3	29,31	30,25	100	48	16,0	4
TM721M140X200R2DHA	M14X2	11,6	14,3	29,05	30,24	100	48	16,0	4
TM721M160X200R2DHA	M16X2	13,6	16,3	33,05	34,24	102	48	18,0	4

Shank Tolerance

D	tolerance h6
6	+0, -0,008
8–10	+0, -0,009
12–18	+0, -0,011
20–30	+0, -0,013







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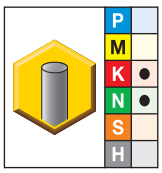


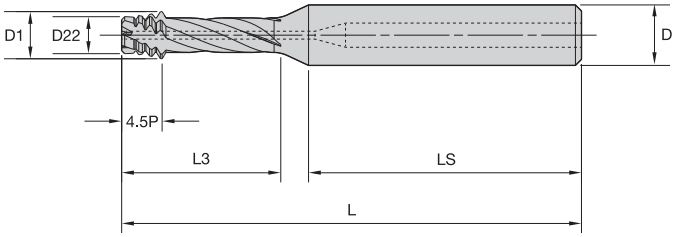
● first choice
○ alternate choice

KCU32	D1 size	D22	D1	DCH	LTHD	LDCH	L	LS	D	cutting edges
TM731M040X070R2DHA	M4X0.7	3,3	3,2	4,3	7,74	9,59	49	36	6,0	2
TM731M050X080R2DHA	M5X0.8	4,2	4,0	5,3	9,65	11,82	55	36	6,0	2
TM731M060X100R2DHA	M6X1	5,0	4,8	6,3	12,06	14,69	62	36	8,0	2
TM731MF080X100R2DHA	M8X1	7,0	6,8	8,3	16,09	19,10	74	40	10,0	2
TM731M080X125R2DHA	M8X1.25	6,8	6,5	8,3	15,08	18,42	74	40	10,0	2
TM731M100X150R2DHA	M10X1.5	8,5	8,2	10,3	19,59	23,65	79	45	12,0	2
TM731M120X175R2DHA	M12X1.7w5	10,3	9,9	12,3	22,86	27,63	89	45	14,0	2
TM731M160X200R2DHA	M16X2	14,0	13,6	16,3	32,13	38,00	102	48	18,0	2

Shank Tolerance

D	tolerance h6
6	+0, -0,008
8–10	+0, -0,009
12–18	+0, -0,011
20–30	+0, -0,013







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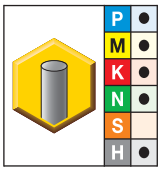


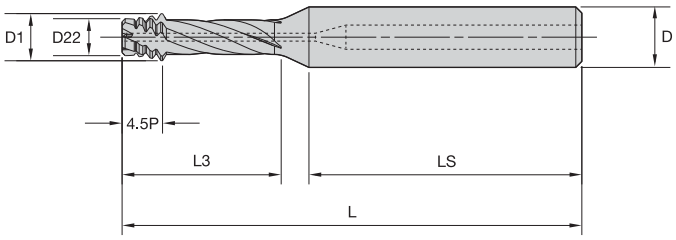
● first choice
○ alternate choice

KCU36	D1 size	D1	D22	L3	L	LS	D	cutting edges
TM741NC2500-20R2DHA	1/4-20	4,64	3,34	17,0	60	36	8,0	3
TM741NF2500-28R2DHA	1/4-28	4,66	3,62	17,0	60	36	8,0	3
TM741NC3125-18R2DHA	5/16-18	5,64	4,12	21,9	76	40	10,0	4
TM741NF3125-24R2DHA	5/16-24	5,64	4,48	21,9	76	40	10,0	4
TM741NC3750-16R2DHA	3/8-16	7,16	5,42	26,3	76	40	10,0	4
TM741NF3750-24R2DHA	3/8-24	7,14	6,00	26,3	76	40	10,0	4
TM741NC0500-13R2DHA	1/2-13	10,08	7,95	33,4	86	45	12,0	4
TM741NF0500-20R2DHA	1/2-20	8,45	7,06	33,0	86	45	12,0	4
TM741NF0625-18R2DHA	5/8-18	12,38	10,83	42,0	98	48	16,0	4
TM741NC0750-10R2DHA	3/4-10	15,50	12,77	51,3	111	50	20,0	5
TM741NC0750-16R2DHA	3/4-16	15,38	13,65	51,3	111	50	20,0	5

Shank Tolerance

D	tolerance h6
6	+0, -0,008
8–10	+0, -0,009
12–18	+0, -0,011
20–30	+0, -0,013







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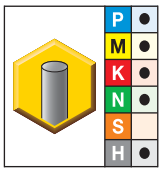


● first choice
○ alternate choice

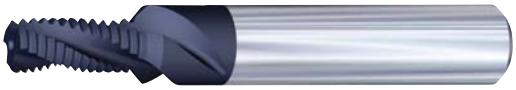
KCU36	D1 size	D1	D22	L3	L	LS	D	cutting edges
TM741M060X100R2DHA	M6X1	4,51	3,41	16,5	60	36	8,0	3
TM741MF080X100R2DHA	M8X1	6,23	5,13	21,9	71	40	10,0	4
TM741M080X125R2DHA	M8X1.25	6,23	4,91	21,9	71	40	10,0	4
TM741MF100X100R2DHA	M10X1	6,23	5,13	21,9	71	40	10,0	4
TM741MF100X125R2DHA	M10X1.25	6,23	4,91	21,9	71	40	10,0	4
TM741M100X150R2DHA	M10X1.5	7,75	6,11	26,3	76	40	10,0	4
TM741MF120X150R2DHA	M12X1.5	7,75	6,11	26,3	76	40	10,0	4
TM741M120X175R2DHA	M12X1.75	9,16	7,21	32,4	86	45	12,0	4
TM741M140X200R2DHA	M14X2	11,08	8,91	41,0	98	48	16,0	4
TM741M160X200R2DHA	M16X2	11,08	8,91	41,0	98	48	16,0	4
TM741M180X250R2DHA	M18X2.5	14,38	11,71	51,3	111	50	20,0	5
TM741M200X250R2DHA	M20X2.5	14,38	11,71	51,3	111	50	20,0	5

Shank Tolerance

D	tolerance h6
6	+0, -0,008
8–10	+0, -0,009
12–18	+0, -0,011
20–30	+0, -0,013

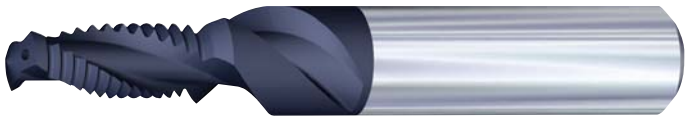


Thread Mill TM711



Thread Mill and Chamfer TM721

Material Group		Cutting Speed — vc Range — m/min			Feed/Tooth by Diameter			Cutting Speed — vc Range — m/min			Feed/Tooth by Diameter		
		min	Starting Value	max		<10mm	>10mm	min	Starting Value	max		<10mm	>10mm
P	1	90	**115**	150	mm/r	0,05	0,08	140	**185**	240	mm/r	0,06	0,10
	2	90	**115**	150	mm/r	0,05	0,08	140	**185**	240	mm/r	0,06	0,10
	3	40	**50**	70	mm/r	0,02	0,03	70	**90**	120	mm/r	0,03	0,04
	4	–	**—**	–	–	–	–	70	**90**	120	mm/r	0,03	0,04
	5	60	**80**	100	mm/r	0,04	0,06	70	**90**	120	mm/r	0,05	0,08
	6	–	**—**	–	–	–	–	–	**—**	–	–	–	–
M	1	60	**80**	100	mm/r	0,04	0,06	70	**90**	120	mm/r	0,05	0,08
	2	60	**80**	100	mm/r	0,04	0,06	70	**90**	120	mm/r	0,05	0,08
	3	–	**—**	–	–	–	–	–	**—**	–	–	–	–
K	1	120	**150**	200	mm/r	0,06	0,10	130	**170**	220	mm/r	0,06	0,11
	2	120	**150**	200	mm/r	0,06	0,10	130	**170**	220	mm/r	0,06	0,11
	3	90	**115**	150	mm/r	0,05	0,07	110	**140**	180	mm/r	0,05	0,07
N	1	250	**275**	300	mm/r	0,07	0,09	270	**300**	330	mm/r	0,08	0,16
	2	200	**225**	250	mm/r	0,05	0,06	270	**300**	330	mm/r	0,08	0,16
	3	170	**190**	210	mm/r	0,04	0,05	160	**175**	190	mm/r	0,08	0,16
	4	250	**275**	300	mm/r	0,07	0,09	270	**300**	330	mm/r	0,08	0,16
	5	270	**300**	330	mm/r	0,12	0,13	250	**275**	300	mm/r	0,11	0,20
	6	170	**190**	210	mm/r	0,05	0,06	90	**100**	110	mm/r	0,11	0,20
S	1	60	**80**	100	mm/r	0,04	0,06	70	**90**	120	mm/r	0,05	0,08
	2	50	**65**	80	mm/r	0,03	0,04	50	**60**	80	mm/r	0,03	0,05
	3	50	**65**	80	mm/r	0,03	0,04	50	**60**	80	mm/r	0,03	0,05
	4	50	**65**	80	mm/r	0,03	0,04	50	**60**	80	mm/r	0,03	0,05



Drill, Chamfer, and Thread Mill TM731

Material Group		Cutting Speed — vc Range — m/min			Drilling Recommended Feed by Diameter				Milling Feed/Tooth by Diameter			
		min	Starting Value	max		<6mm	6–10mm	10–16mm		<6mm	6–10mm	10–16mm
K	1	130	**175**	230	mm/r	0,10	0,16	0,30	mm/r	0,05	0,07	0,10
N	2	270	**300**	330	mm/r	0,15	0,25	0,34	mm/r	0,06	0,08	0,12
	3	140	**150**	170	mm/r	0,15	0,25	0,34	mm/r	0,06	0,08	0,12
	4	270	**300**	330	mm/r	0,15	0,25	0,34	mm/r	0,06	0,08	0,12
	5	110	**120**	130	mm/r	0,12	0,20	0,32	mm/r	0,06	0,08	0,12



Mill, Chamfer, and Thread Mill TM741

Material Group		TM Style	Grade	Cutting Speed — vc Range — m/min min	Starting Value	max	Feed/Tooth by Diameter	<10mm	>10mm
P	1	TM741 R	KCU36	170	**225**	290	mm/r	0,05	0,08
	2	TM741 R	KCU36	170	**225**	290	mm/r	0,05	0,08
	3	TM741 R	KCU36	120	**150**	200	mm/r	0,03	0,05
	4	TM741 R	KCU36	100	**125**	160	mm/r	0,03	0,05
	5	TM741 R	KCU36	120	**150**	200	mm/r	0,03	0,04
	6	TM741 R	KCU36	60	**80**	100	mm/r	0,03	0,04
M	1	TM741 R	KCU36	120	**150**	200	mm/r	0,03	0,04
	2	TM741 R	KCU36	120	**150**	200	mm/r	0,03	0,04
	3	TM741 R	KCU36	120	**150**	200	mm/r	0,03	0,04
K	1	TM741 R	KCU36	190	**250**	330	mm/r	0,06	0,10
	2	TM741 R	KCU36	190	**250**	330	mm/r	0,06	0,10
	3	TM741 R	KCU36	140	**185**	240	mm/r	0,04	0,07
N	1	–	–	–	**–**	–	–	–	–
	2	–	–	–	**–**	–	–	–	–
	3	TM741 R	KCU36	180	**230**	300	mm/r	0,06	0,07
	4	TM741 R	KCU36	210	**275**	360	mm/r	0,06	0,07
	5	–	–	–	**–**	–	–	–	–
	6	TM741 R	KCU36	210	**275**	360	mm/r	0,06	0,07
S	1	TM741 L	KCU36	120	**150**	200	mm/r	0,025	0,045
	2	TM741 L	KCU36	50	**60**	80	mm/r	0,015	0,025
	3	TM741 L	KCU36	50	**60**	80	mm/r	0,015	0,025
	4	TM741 L	KCU36	70	**90**	120	mm/r	0,025	0,035
H	1	TM741	KCU36	80	**100**	130	mm/r	0,030	0,050
	2	TM741	KCU36	80	**100**	130	mm/r	0,030	0,050
	3	TM741	KCU36	50	**65**	80	mm/r	0,020	0,030
	4	TM741	KCU36	50	**65**	80	mm/r	0,020	0,030

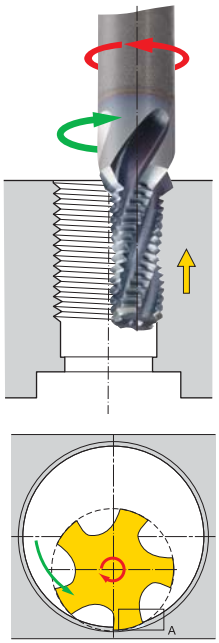
NOTE: For thread depths over 2 x D up to 3 x D, reduce speed and feed by 25%.

Milling Methods

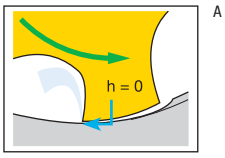
Climb Milling

Properties:

- Tool rotation direction clockwise
- Tool moves anti-clockwise
- Pitch “upwards”
- Right-hand thread



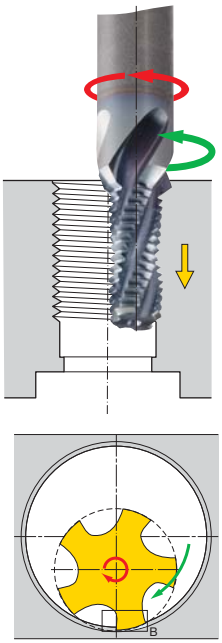
Climb milling is always when the cutting edge goes out of the material with a chip thickness h = 0



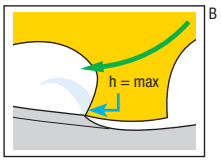
Conventional Milling

Properties:

- Tool rotation direction clockwise
- Tool moves clockwise
- Pitch “downwards”
- Right-hand thread

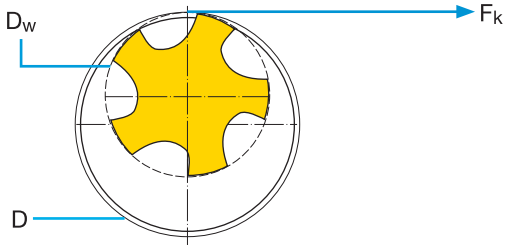


Conventional milling is always when the cutting edge goes out of the material with a chip thickness h = max



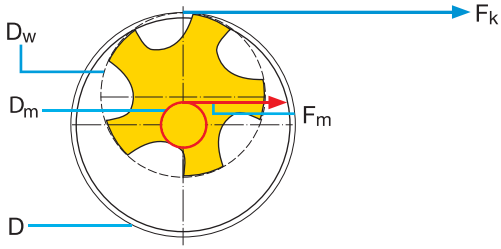
Counter Feed F_k

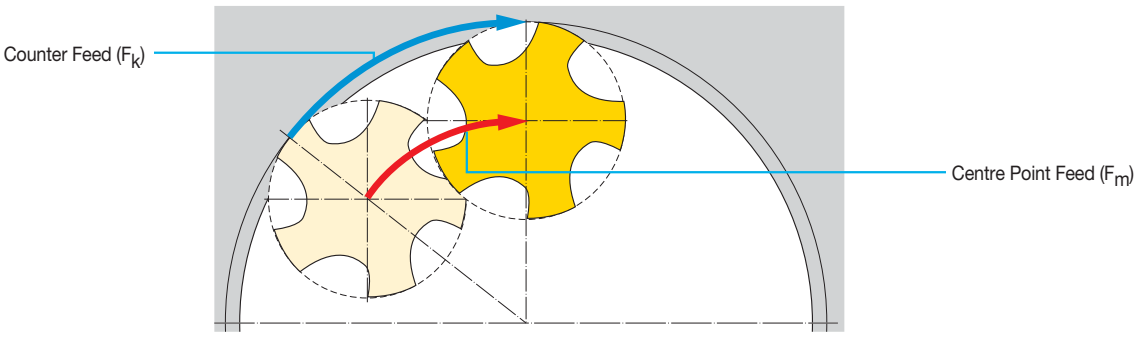
$$F_k = n \bullet f_z \bullet Z \text{ [mm/min]}$$



Centre Point Feed F_m

$$F_m = \frac{F_k \bullet (D\text{-}Dw)}{D} \text{ [mm/min]}$$





D_W = Tool diameter [mm]
n = RPM [min-1]
f_Z = Feed per tooth [mm]
Z = Number of teeth on tool (radial)
D = Nominal diameter of thread = Diameter of external contour [mm]
D_m = Diameter of the centre point ($D\text{-}D_W$) [mm]

Drill Thread Mill TM741 • Right Hand

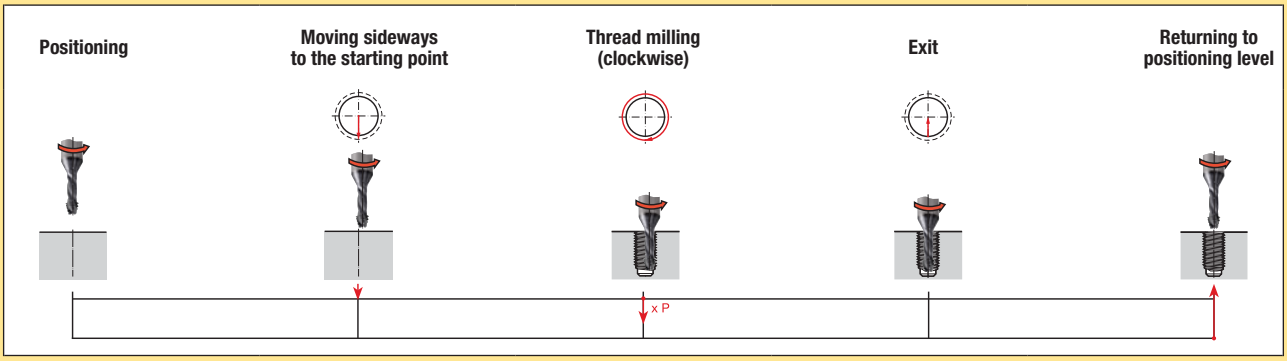
Preparation

None

Process Principle

Milling thread and core hole, countersinking (conventional milling)

Cycle



Required Specification Values



Example

Size — M10-6H

Thread diameter D	10mm
Pitch P	1,5mm
Core hole diameter D_1	8,5mm

Material — Hard steel, 50 HRC
Grade — KCU36

Tool — TM741 Right Hand

Catalogue number	TM741M100X150R2DHA
Number of teeth Z	4
Tool diameter d_1	7,75mm*
Tool radius compensation k[1]	0,08mm**
Tool radius to be programmed[2]	3,795mm***
Thread depth b[3]	20mm
Cutting speed v_c	100 m/min
Feed (milling) f_z	0,04 mm/tooth
Number of turns [5]	17

$$N = \frac{V_c \bullet 1000}{d_1 \bullet \pi} \qquad S = 4109$$

$$v_f = f_z \bullet Z \bullet n \qquad F = 657 \text{ (contour)}$$

$$N = \frac{v_f \text{ contour} \bullet (D-d_1)}{D} \qquad F = 148 \text{ (centre point)}$$

*(measured on the cutting part) **(0.01 x D; adjust to application) ***(1/2 d_1 - k)

Programme to DIN 66025 (conventional milling, on the contour, incremental)

Positioning the tool	N 10	G 54	G 90	G 00	X…	Y…	Z 1.500	S 4109	T01 [2]	M03
Incremental programming	N 20	G 91								
Moving sideways to the starting point	N 30	G 42	G 01	X 0	Y-5	F 657 (contour)		[F 148] [4] (centre point)		
Thread milling	N 40	G 02		X 0	Y 0	Z-1.500	I 0	J 5.000		
Repeat thread milling	… [5]									
Exit	N 50	G 40	G 01	X 0	Y 5					
Retracting tool to positioning level	N 70	G 90	G 00	Z 2						

Cutting time t_h

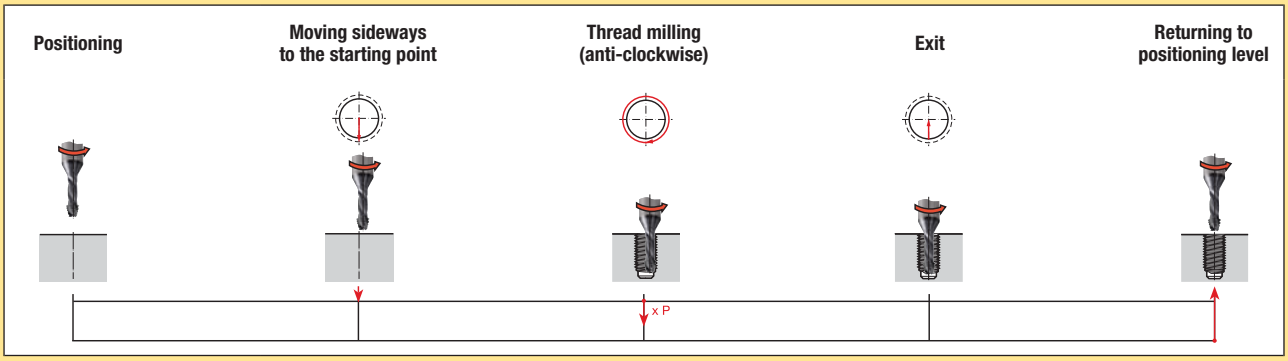
51,6 seconds

NOTES:
[1] The cutter radius measured over the tooth crests of the threaded part must be reduced by the amount of the cutter radius compensation. This is necessary to achieve a depth of cut to the middle of the 6H/ISO2 nut tolerance. Please note, however, that this also depends on the radial deflection of the tool (tensile strength of the material, projecting length of the tool).
[2] The cutter radius to be programmed is normally included in the tool memory.
[3] The thread depth b must be divisible by the thread pitch P.
[4] The feed values in brackets must be used for controllers, which do not calculate the centre point feed themselves.
[5] **Set N40 must be repeated with the number of threads.** Repetitions N = thread depth b/pitch P (rounded up to the nearest integer).

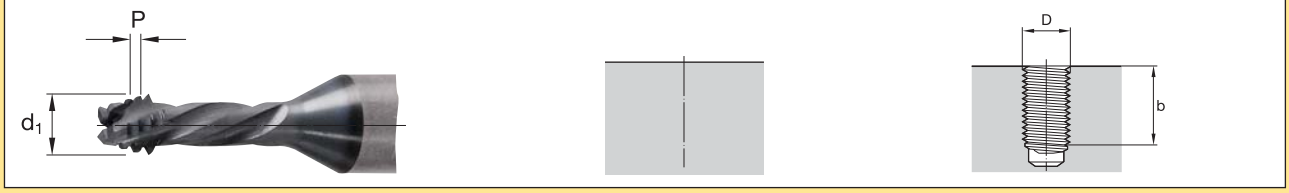
Drill Thread Mill TM741 • Left Hand

Preparation	None
Process Principle	Milling thread and core hole, countersinking (climb milling)

Cycle



Required Specification Values



Example

Size — M10-6H
Thread diameter D 10mm
Pitch P 1,5mm
Core hole diameter D_1 ..... 8,5mm

Material — TiAl6V4 titanium
Grade — KCU36

Tool — TM741 Left Hand
Catalogue number TM741M100X150L2DHA
Number of teeth Z 4
Tool diameter d_1 ..... 7,75mm*
Tool radius compensation k[1] 0,08mm**
Tool radius to be programmed[2] 3,795mm***
Drilling/countersink depth l_E 20mm
Cutting speed v_c ..... 100 m/min
Feed (milling) f_z ..... 0,03 mm/tooth
Number of turns [5] 17

$N = \frac{V_c \bullet 1000}{d_1 \bullet \pi}$ S = 4109

$v_f = f_z \bullet Z \bullet n$ F = 493 (contour)

$v_f = \frac{v_f \text{ contour} \bullet (D-d_1)}{D}$ F = 111 (centre point)

*(measured on the cutting part) **(0.01 x D) ***(1/2 d_1 - k)

Programme to DIN 66025 (climb milling, on the contour, incremental)

Positioning the tool	N 10 G 54 G 90 G 00 X… Y… Z 1.500 S 4109 T01 [2] M04
Incremental programming	N 20 G 91
Moving sideways to the starting point	N 30 G 42 G 01 X 0 Y-5 F 493 (contour) [F 111] [4] (centre point)
Thread milling	N 40 G 02 X 0 Y 0 Z-1.500 I 0 J 5.000
Repeat thread milling	… [5]
Exit	N 50 G 40 G 01 X 0 Y 5
Retracting tool to positioning level	N 70 G 90 G 00 Z 2

Cutting time t_h	**68,8 seconds**

NOTES:
[1] The cutter radius measured over the tooth crests of the threaded part must be reduced by the amount of the cutter radius compensation. This is necessary to achieve a depth of cut to the middle of the 6H/ISO2 nut tolerance. Please note, however, that this also depends on the radial deflection of the tool (tensile strength of the material, projecting length of the tool).
[2] The cutter radius to be programmed is normally included in the tool memory.
[3] The thread depth b must be divisible by the thread pitch P.
[4] The feed values in brackets must be used for controllers, which do not calculate the centre point feed themselves.
[5] **Set N40 must be repeated with the number of threads.** Repetitions N = thread depth b/pitch P (rounded up to the nearest integer).

Drill Thread Mill TM731

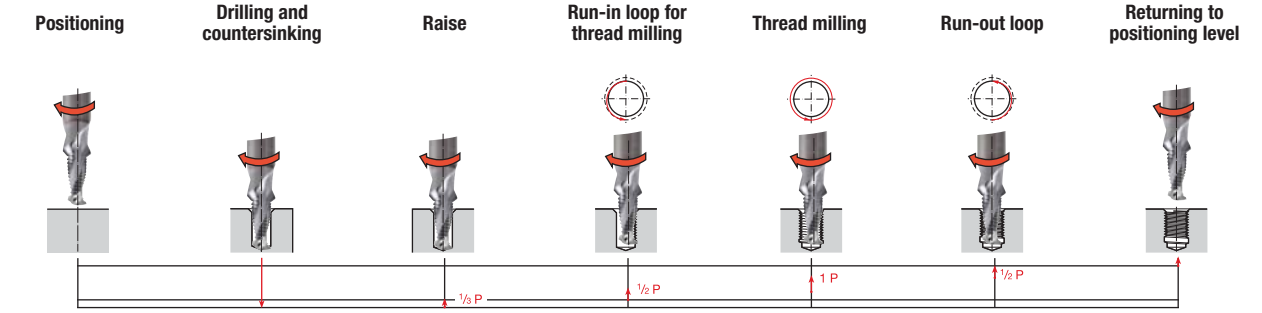
Preparation

None

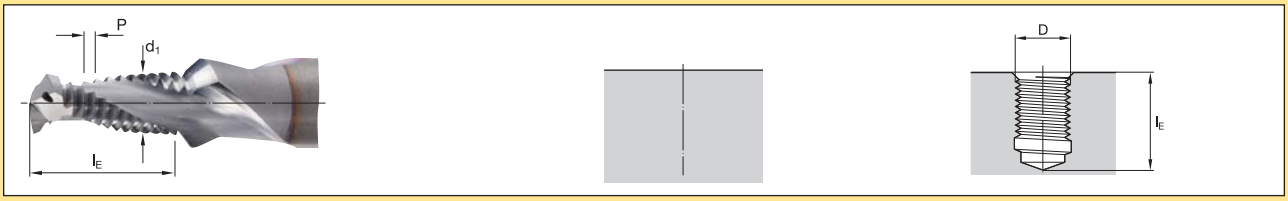
Process Principle

Drilling, countersinking, thread milling (climb milling)

Cycle



Required Specification Values



Example

Size — M10-6H

Thread diameter D	10mm
Pitch P	1,5mm
Core hole diameter D_1	8,5mm

Material — Grey cast iron
Grade — KCU32

Tool — TM731

Catalogue number	TM731M100X150R2DHA
Number of teeth Z	2
Tool diameter d_1	8,2mm*
Tool radius compensation k[1]	0,1mm**
Tool radius to be programmed[2]	4mm***
Drilling/countersink depth l_E	19,11mm
Cutting speed v_c	250 m/min
Feed (drilling, countersinking) f_b	0,25 mm/U
Feed (milling) f_z	0,1 mm/tooth

*(measured on the cutting part) **(0.01 x D) ***(1/2 d_1 - k)

$$N = \frac{v_c \bullet 1000}{d_1 \bullet \pi} \qquad S = 9709$$

$$v_b = f_b \bullet n \qquad F = 2427 \text{ (drilling, countersinking)}$$

$$v_f = f_z \bullet Z \bullet n \qquad F = 1942 \text{ (contour)}$$

$$v_f = \frac{v_f \text{ contour} \bullet (D-d_1)}{D} \qquad F = 350 \text{ (centre point)}$$

Programme to DIN 66025 (climb milling, on the contour, incremental)

Positioning the tool	N 10 G 54 G 90 G 00 X… Y… Z 2 S 9709 T01 [2] M03
Drilling and countersinking	N 20 G 91 G 01 Z-21.110 F 2427 (drill, countersink)
Raise	N 30 G 01 Z 0.500
Moving sideways to the starting point	N 40 G 41 Y-4.250 F 971 (milling, 1/2 contour) [F 175] [3] (1/2 centre point)
Run-in loop in arc	N 50 G 03 X 0 Y 9.250 Z 0.750 I 0 J 4.625
Thread milling	N 60 G 03 X 0 Y 0 Z 1.500 I 0 J -5.000 F1942 [F 350] [3] (centre point)
Run-out loop in arc	N 70 G 03 X 0 Y-9.250 Z 0.750 I 0 J- 4.625
Exit	N 80 G 00 G 40 X 0 Y 4.250
Retracting tool to positioning level	N 90 G 90 Z 2

Cutting time t_h

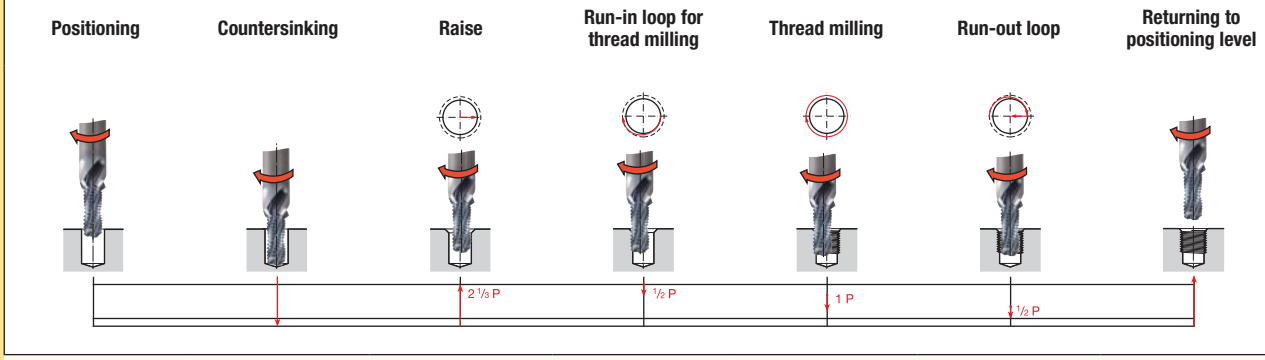
2,3 seconds

NOTES:
[1] The cutter radius measured over the tooth crests of the threaded part must be reduced by the amount of the cutter radius compensation. This is necessary to achieve a depth of cut to the middle of the 6H/ISO2 nut tolerance. Please note, however, that this also depends on the radial deflection of the tool (tensile strength of the material, projecting length of the tool).
[2] The cutter radius to be programmed is normally included in the tool memory.
[3] The feed values in brackets must be used for controllers, which do not calculate the centre point feed themselves.

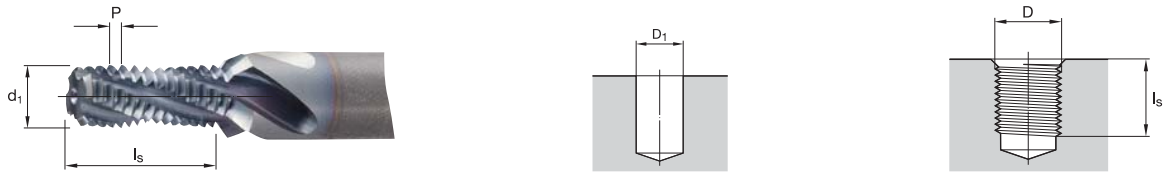
Thread Mill TM721

Preparation	Drilling of thread hole
Process Principle	Countersinking, thread milling (conventional milling)

Cycle



Required Specification Values



Example

Size — M10-6H
Thread diameter D 10mm
Pitch P 1,5mm
Core hole diameter D_1 ..... 8,5mm

Material — Cast aluminium
Grade — KCU32

Tool — TM721
Catalogue number TM721M100X150R2DHA
Number of teeth Z 3
Tool diameter d_1 ..... 8,2mm*
Tool radius compensation k[1] 0,1mm**
Tool radius to be programmed[2] 4mm***
Countersink depth l_S 21,2mm
Cutting speed v_c ..... 250 m/min
Feed (countersinking) f_S ..... 0,3 mm/U
Feed (milling) f_z ..... 0,09 mm/tooth

*(measured on the cutting part) **(0.01 x D) ***(1/2 d_1 - k)

$$N = \frac{V_c \bullet 1000}{d_1 \bullet \pi} \qquad S = 9709$$

$$v_S = f_S \bullet n \qquad F = 2913 \text{ (countersinking)}$$

$$v_f = f_z \bullet Z \bullet n \qquad F = 2622 \text{ (contour)}$$

$$v_f = \frac{v_f \text{ contour} \bullet (D - d_1)}{D} \qquad F = 472 \text{ (centre point)}$$

Programme to DIN 66025 (conventional milling, on the contour, incremental)

Positioning the tool	N 10	G 54	G 90	G 00	X…	Y…	Z 2	S 9709	T01 [2]	M03
Advancing tool to full thread depth	N 20	G 91	Z-21.200							
Countersinking	N 30	G 01	Z-2	F 2913	(countersink)					
Raise	N 40	G 00	Z 3.450							
Moving sideways to the starting point	N 50	G 42	G01	X 4.250	F 1311	(milling, 1/2 contour)		[F 236] [3]	(milling,1/2 centre point)	
Run-in loop in arc	N 60	G 02	X-9.25	Y 0.000	Z-0.750	I-4.625	J 0			
Thread milling	N 70	G 02	X 0	Y 0	Z-1.500	I 5	J 0.000	F2622	[F 472] [3]	(centre point)
Run-out loop in arc	N 80	G 02	X 9.25	Y 0.000	Z-0.750	I 4.625	J 0			
Exit	N 90	G 40	G 01	X-4.25						
Retracting tool to positioning level	N 100	G 90	G 00	Z 2						

Cutting time t_h	**1,4 seconds**

NOTES:
[1] The cutter radius measured over the tooth crests of the threaded part must be reduced by the amount of the cutter radius compensation. This is necessary to achieve a depth of cut to the middle of the 6H/ISO2 nut tolerance. Please note, however, that this also depends on the radial deflection of the tool (tensile strength of the material, projecting length of the tool).
[2] The cutter radius to be programmed is normally included in the tool memory.
[3] The feed values in brackets must be used for controllers, which do not calculate the centre point feed themselves.

High-Performance Taps • Carbide • Metric

Material Group		Through Holes					Blind Holes				
				Range — m/min					Range — m/min		
		Tap Style	Grade	min	Starting Value	max	Tap Style	Grade	min	Starting Value	max
P	1	T320, T321	KC7542	60	**100**	130	T331	KC7542	50	**70**	90
	2	T320, T321	KC7542	60	**90**	120	T331	KC7542	40	**60**	80
	3	T320, T321	KC7542	50	**80**	100	T331	KC7542	40	**60**	80
K	1	T340, T353	KC7542, KCK17	70	**105**	140	T351, T353	KC7542, KCK17	50	**70**	90
	2	T340, T353	KC7542, KCK17	60	**100**	130	T351, T353	KC7542, KCK17	50	**70**	90
	3	T340, T353	KC7542, KCK17	60	**90**	120	T351, T353	KC7542, KCK17	40	**60**	80
N	2	–	–	–	**–**	–	T471, T491	KCN14	60	**80**	100
	3	–	–	–	**–**	–	T471, T491	KCN14	50	**70**	90
	4	–	–	–	**–**	–	T471, T491	KCN14	40	**60**	80
H	1	T410	KCU36	1,2	**1,5**	2,0	T410	KCU36	0,8	**1,1**	1,4
	2	T410	KCU36	0,6	**0,8**	1,0	T410	KCU36	0,4	**0,5**	0,7

NOTE: Increase speed of T321 coolant taps by up to 25% of speeds listed for non-coolant T320 taps.

High-Performance Taps • HSS-E-PM • Metric

Material Group		Through Holes					Blind Holes				
				Range — m/min					Range — m/min		
		Tap Style	Grade	min	Starting Value	max	Tap Style	Grade	min	Starting Value	max
P	1	T620	KP6525	20	**30**	45	T630, T632, T650	KP6525	14	**21**	32
		T622	KSP21	18	**30**	50	T622	KSP21	13	**21**	35
	2	T620	KP6525	17	**25**	38	T630, T632, T650	KP6525	12	**18**	26
		T622	KSP21	15	**25**	42	T622	KSP21	10	**18**	29
	3	T620	KP6525	12	**15**	20	T630, T632, T650	KP6525	8	**11**	14
	4	T600	KSP21	5	**6**	8	T604	KSH26	3	**4**	5
	5	T620	KP6525	12	**15**	20	T630, T632, T650	KP6525	8	**11**	14
	6	T600	KSP21	6	**8**	10	T604	KSH26	4	**6**	7
M	1	T620	KM6515	12	**15**	20	T630, T632, T650	KM6515	8	**11**	14
	2	T620	KM6515	9	**12**	16	T630, T632, T650	KM6515	6	**8**	11
	3	T620	KM6515	8	**10**	13	T630, T632, T650	KM6515	5	**7**	9
K	1	T640	KP6525	27	**35**	46	T640, T642	KP6525	19	**25**	32
	2	T640	KP6525	23	**30**	39	T640, T642	KP6525	16	**21**	27
	3	T640	KP6525	19	**25**	33	T640, T642	KP6525	13	**18**	23
N	1	T670	KSN38	42	**55**	72	T680	KSN38	30	**39**	50
		T622	KSN28	37	**55**	72	T622	KSN28	26	**39**	50
	2	T640	KP6525	30	**45**	59	T640, T642	KP6525	21	**32**	41
		T622	KSN28	33	**50**	65	T622	KSN28	23	**35**	46
	4	T640	KP6525	7	**10**	15	T640, T642	KP6525	5	**7**	11
S	1	T620	KP6525	8	**12**	18	T630, T632	KP6525	6	**8**	13

NOTE: Increase speed by up to 25% when using coolant taps (T621, T623, T625, T627, T631, T633, T641, T643, T651).

GOtap™ • Metric

Material Group		Through Holes					Blind Holes				
				Range — m/min					Range — m/min		
		Tap Style	Grade	min	Starting Value	max	Tap Style	Grade	min	Starting Value	max
P	1	T820	KSU31, KSP32	23	**30**	38	T830, T832, T838, T839	KSU31, KSP32	15	**21**	30
		T820	KSP39, KSU30	11	**15**	19	T830, T832, T838, T839	KSP39, KSU30	7	**11**	15
		T854	KSU31	6	**8**	10	T854	KSU31	6	**8**	10
		T854	KSP39	5	**6**	8	T854	KSP39	5	**6**	8
		T877	KSU31	17	**22**	28	T857	KSU31	11	**15**	22
		T877	KSP39	8	**10**	13	T857	KSP39	5	**7**	10
		T848	KSU30	5	**6**	8	T848	KSU30	3	**4**	6
	2	T820	KSU31, KSP32	18	**24**	30	T830, T832, T838, T839	KSU31, KSP32	12	**17**	24
		T820	KSP39, KSU30	11	**14**	18	T830, T832, T838, T839	KSP39, KSU30	7	**10**	14
	3	T820	KSU31, KSP32	17	**22**	28	T830, T832, T838, T839	KSU31, KSP32	11	**15**	22
		T820	KSP39, KSU30	9	**12**	15	T830, T832, T838, T839	KSP39, KSU30	6	**8**	12
		T846	KSU31	6	**8**	10	T846	KSU31	6	**8**	10
		T846	KSU30	4	**5**	6	T846	KSU30	4	**5**	6
M	1	T820	KSMN34, KSP32	14	**18**	23	T830, T832, T838, T839	KSMN34, KSP32	9	**13**	18
		T820	KSP39, KSU30	8	**10**	13	T830, T832, T838, T839	KSP39, KSU30	5	**7**	10
		T854	KSU31	6	**8**	10	T854	KSU31	6	**8**	10
		T854	KSP39	4	**5**	6	T854	KSP39	4	**5**	6
		T877	KSU31	9	**12**	15	T857	KSU31	6	**8**	11
		T877	KSP39	5	**7**	9	T857	KSP39	4	**5**	7
		T848	KSU30	4	**5**	6	T848	KSU30	3	**4**	6
	3	T820	KSMN34, KSP32	11	**15**	19	T830, T832, T838, T839	KSMN34, KSP32	7	**11**	15
		T820	KSP39, KSU30	7	**9**	11	T830, T832, T838, T839	KSP39, KSU30	4	**6**	9
K	1	T846	KSU31	11	**15**	19	T846	KSU31	11	**15**	19
		T846	KSU30	6	**8**	10	T846	KSU30	6	**8**	10
	2	T820	KSU31, KSP32	16	**21**	26	T830, T832, T838, T839	KSU31, KSP32	10	**15**	21
		T820	KSP39, KSU30	9	**12**	15	T830, T832, T838, T839	KSP39, KSU30	6	**8**	12
		T877	KSU31	14	**18**	23	T857	KSU31	9	**13**	18
		T877	KSP39	7	**9**	11	T857	KSP39	4	**6**	9
		T848	KSU30	4	**5**	6	T848	KSU30	2	**4**	5
N	1	T820	KSMN34, KSP32	37	**49**	61	T830, T832, T838, T839	KSMN34, KSP32	24	**34**	49
		T820	KSU30	20	**27**	34	T830, T832	KSU30	13	**19**	27
	2	T820	KSMN34, KSP32	30	**40**	50	T830, T832, T838, T839	KSMN34, KSP32	20	**28**	40
		T820	KSU30	16	**21**	26	T830, T832	KSU30	10	**15**	21
		T877	KSU31	17	**22**	27	T857	KSU31	11	**15**	22
		T877	KSP39	8	**10**	12	T857	KSP39	5	**7**	10
		T848	KSU30	10	**13**	16	T848	KSU30	6	**9**	13
	4	T820	KSMN34, KSP32	37	**49**	61	T830, T832, T838, T839	KSMN34, KSP32	24	**34**	49
		T820	KSU30	20	**27**	33	T830, T832	KSU30	13	**19**	27

KSU30 = Bright
KSP39 = Oxide
KSU31 = TiN
KSP32 = TiCN/TiN
KSMN34 = TiN + CrC/C

Taps and Thread Milling Technical Information

Use the technical information offered here to assist with tapping and thread milling operations. This tech data includes information about tap dimensions and recommendations, as well as how to solve basic tapping and thread milling problems.

Included in This Section:

- Illustrations of tap terms.
- Explanations of tap chamfers.
- Dimensional information for various tap styles and lengths.
- Tap limitation data.
- Chip handling methods for different tap styles.
- Tap recommendations.
- Descriptions of screw thread tolerance and tolerance information.
- Information regarding surface treatments and coatings.
- Guidelines and tables for determining tapping speeds.
- Troubleshooting charts.
- Hardness conversion table.
- Taps custom order worksheet.
- Thread milling application sheet.
- Tap drill size charts.

This section will help you learn more about tapping and thread milling applications to maximise the performance of your tools.



How to Apply This Technical Information

Below is an example of how the technical information in this catalogue can be useful:

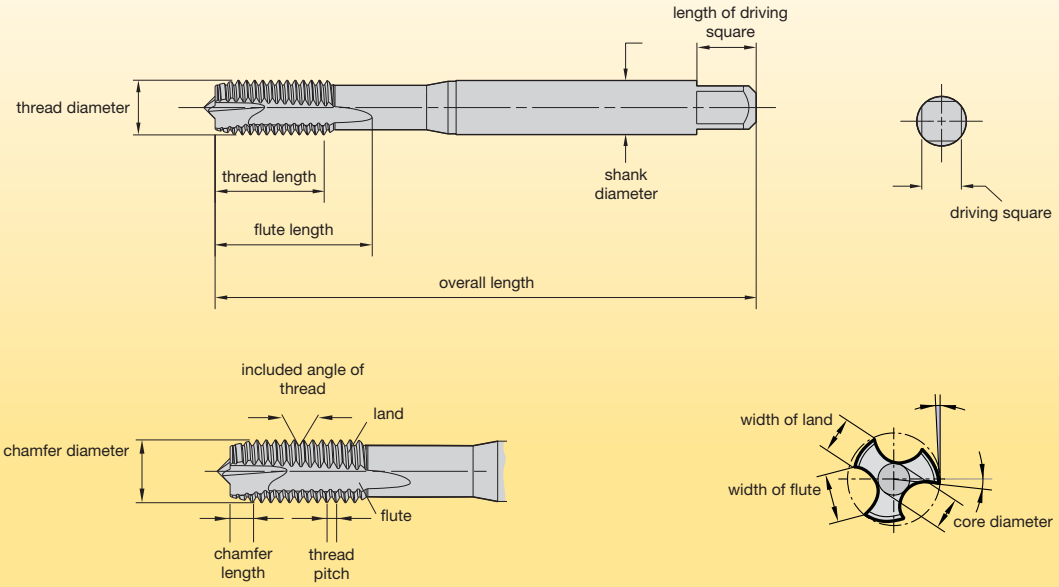
Problem

- Thread holes are oversized and taps are experiencing decreased tool life when used in stainless steel materials.

Solution

- Consult the troubleshooting portion of the technical information section to discover ways to correct the issue.

Definitions and Angles, Centres, and Flute Forms



Flute Forms



Straight-flute, form C plug chamfer **without spiral point**



Right-hand spiral flute

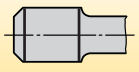
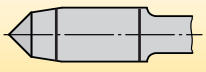
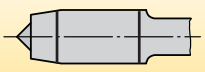
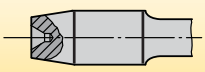


Straight-flute, form B plug chamfer **with spiral point**



Left-hand spiral flute

Types of Centres (Standard to DIN 2197/DIN 2175)

centre on thread section			
tap diameter range			
≤M10, 3/8 bottom or semi-bottom chamfer	≤M10, 3/8 plug chamfer	>M10, 3/8 all chamfers	
			
external centre removed	full external centre	partial external centre	internal centre

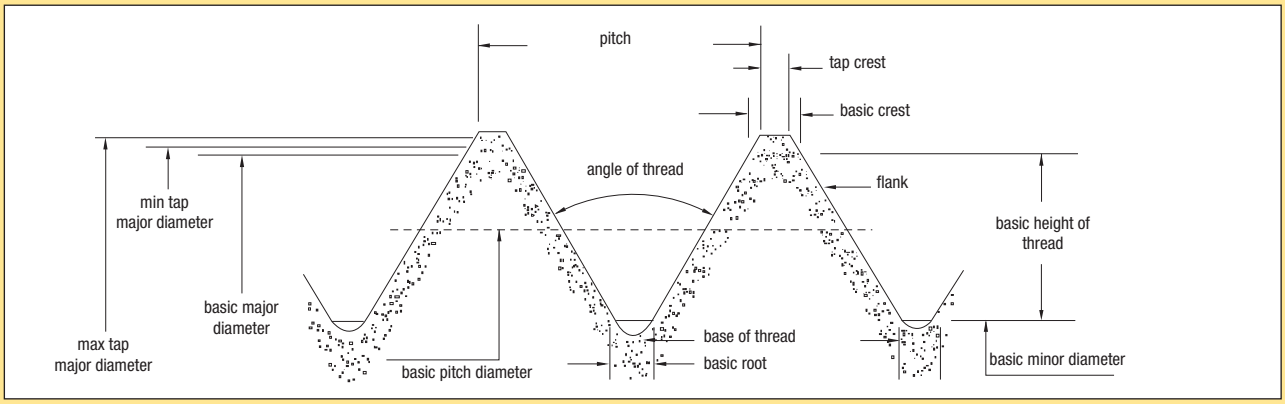
Coolant Hole Types

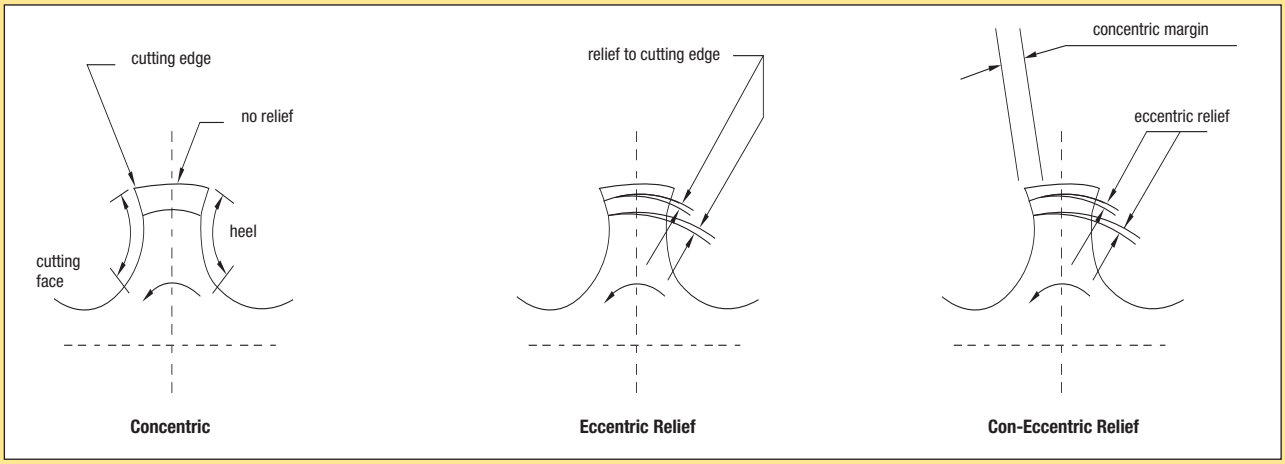


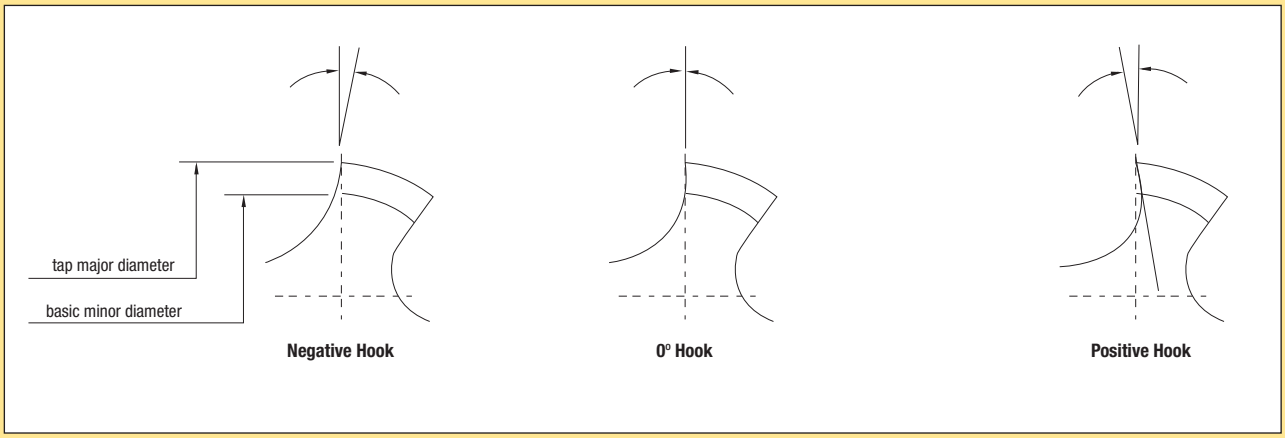
Axial coolant delivery with axial coolant exit hole

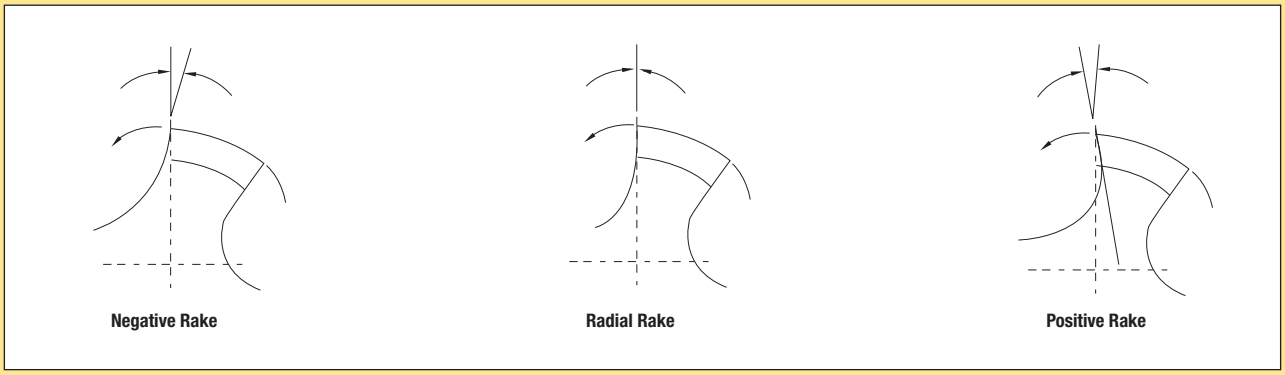


Axial coolant delivery with radial coolant hole exiting in the flutes









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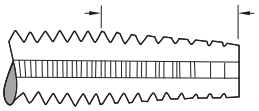
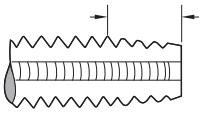
Tap Chamfers • DIN Taps

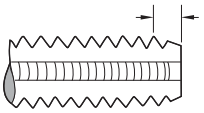
Taper Chamfer
7–10 Pitches



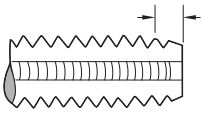
Plug Chamfer
3–5 Pitches



Modified Bottoming Chamfer
2–2.5 Pitches



Full Bottoming Chamfer
1–2 Pitches



Hand Tap Chamfers

Form A (6–8 pitches)

The Form A chamfer has the longest standard chamfer ensuring easier starting. It requires less tapping torque because of more working teeth.

Form B/D (3.5–5 pitches)

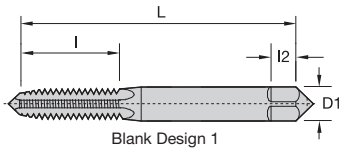
The most common chamfers for use by hand or machine in through or blind holes. Form B applies to spiral-point taps and Form D applies to straight-flute and spiral-flute taps. This chamfer is more efficient than Form E or Form C chamfers.

Form C (2–2.5 pitches)

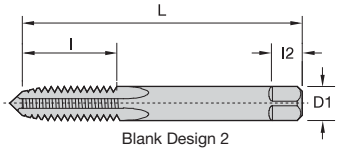
This short chamfer enables threading close to the bottom of blind holes. Due to the slightly longer chamfer and more working teeth, this chamfer is more efficient than a Form E chamfer.

Form E (1.5–2 pitches)

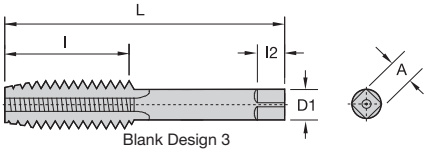
For threading close to the bottom of blind holes, the Form E chamfer is the least efficient chamfer available.



Blank Design 1



Blank Design 2



Blank Design 3

nominal diameter range (in)	machine screw size number	(in)	nominal fractional diameter	(in)	nominal metric diameter mm	(in)	blank design number	overall length L	thread length l	square length l2	shank diameter D1	square size A
.052–.065	0	(.0600)	–		M1.6	(.0630)	1	1.63	.31	.19	.1410	.110
.065–.078	1	(.0730)	–		M1.8	(.0709)	1	1.69	.38	.19	.1410	.110
.078–.091	2	(.0860)	–		M2 (0787),	M2.2 (.0866)	1	1.75	.44	.19	.1410	.110
.091–.104	3	(.0990)	–		M2.5	(.0984)	1	1.81	.50	.19	.1410	.110
.104–.117	4	(.1120)	–		–	–	1	1.88	.56	.19	.1410	.110
.117–.130	5	(.1250)	–		M3	(.1181)	1	1.94	.63	.19	.1410	.110
.130–.145	6	(.1380)	–		M3.5	(.1378)	1	2.00	.69	.19	.1410	.110
.145–.171	8	(.1640)	–		M4	(.1575)	1	2.13	.75	.25	.1680	.131
.171–.197	10	(.1900)	–		M4.5 (.1772),	M5 (.1969)	1	2.38	.88	.25	.1940	.152
.197–.223	12	(.2160)	–		–	–	1	2.38	.94	.28	.2200	.165
.223–.260	–		1/4	(.2500)	M6	(.2362)	2	2.50	1.00	.31	.2550	.191
.260–.323	–		5/16	(.3125)	M7 (.2756),	M8 (.3150)	2	2.72	1.13	.38	.3180	.238
.323–.395	–		3/8	(.3750)	M10	(.3937)	2	2.94	1.25	.44	.3810	.286
.395–.448	–		7/16	(.4375)	–	–	3	3.16	1.44	.41	.3230	.242
.448–.510	–		1/2	(.5000)	M12	(.4724)	3	3.38	1.66	.44	.3670	.275
.510–.573	–		9/16	(.5625)	M14	(.5512)	3	3.59	1.66	.50	.4290	.322
.573–.635	–		5/8	(.6250)	M16	(.6299)	3	3.81	1.81	.56	.4800	.360
.635–.709	–		11/16	(.6875)	M18	(.7087)	3	4.03	1.81	.63	.5420	.406
.709–.760	–		3/4	(.7500)	–	–	3	4.25	2.00	.69	.5900	.442
.760–.823	–		13/16	(.8125)	M20	(.7874)	3	4.47	2.00	.69	.6520	.489
.823–.885	–		7/8	(.8750)	M22	(.8661)	3	4.69	2.22	.75	.6970	.523
.885–.948	–		15/16	(.9375)	M24	(.9449)	3	4.91	2.22	.75	.7600	.570
.948–1.010	–		1	(1.0000)	M25	(.9843)	3	5.13	2.50	.81	.8000	.600
1.010–1.073	–		1-1/16	(1.0625)	M27	(1.0630)	3	5.13	2.50	.88	.8960	.672
1.073–1.135	–		1-1/8	(1.1250)	–	–	3	5.44	2.56	.88	.8960	.672
1.135–1.198	–		1-3/16	(1.1875)	M30	(1.1811)	3	5.44	2.56	1.00	1.0210	.766
1.198–1.260	–		1-1/4	(1.2500)	–	–	3	5.75	2.56	1.00	1.0210	.766
1.260–1.323	–		1-5/16	(1.3125)	M33	(1.2992)	3	5.75	2.56	1.06	1.1080	.831
1.323–1.385	–		1-3/8	(1.3750)	–	–	3	6.06	3.00	1.06	1.1080	.831
1.358–1.448	–		1-7/16	(1.4375)	M36	(1.4173)	3	6.06	3.00	1.13	1.2330	.925
1.448–1.510	–		1-1/2	(1.5000)	–	–	3	6.38	3.00	1.13	1.2330	.925
1.510–1.635	–		1-5/8	(1.6250)	M39	(1.5354)	3	6.69	3.19	1.13	1.3050	.979
1.635–1.760	–		1-3/4	(1.7500)	M42	(1.6535)	3	7.00	3.19	1.25	1.4300	1.072
1.760–1.885	–		1-7/8	(1.8750)	–	–	3	7.31	3.56	1.25	1.5190	1.139
1.885–2.010	–		2	(2.0000)	M48	(1.8898)	3	7.63	3.56	1.38	1.6440	1.233
2.010–2.135	–		2-1/8	(2.1250)	–	–	3	8.00	3.56	1.38	1.7690	1.327
2.135–2.260	–		2-1/4	(2.2500)	M56	(2.2047)	3	8.25	3.56	1.44	1.8940	1.420
2.260–2.385	–		2-3/8	(2.3750)	–	–	3	8.50	4.00	1.44	2.0190	1.514
2.385–2.510	–		2-1/2	(2.5000)	–	–	3	8.75	4.00	1.50	2.1000	1.575
2.510–2.635	–		2-5/8	(2.6250)	M64	(2.5197)	3	8.75	4.00	1.50	2.2250	1.669
2.635–2.760	–		2-3/4	(2.7500)	–	–	3	9.25	4.00	1.56	2.3500	1.762
2.760–2.885	–		2-7/8	(2.8750)	M72	(2.8346)	3	9.25	4.00	1.56	2.4750	1.856
2.885–3.010	–		3	(3.0000)	–	–	3	9.75	4.56	1.63	2.5430	1.907
3.010–3.135	–		3-1/8	(3.1250)	–	–	3	9.75	4.56	1.63	2.6680	2.001
3.135–3.260	–		3-1/4	(3.2500)	M80	(3.1496)	3	10.00	4.56	1.75	2.7930	2.095
3.260–3.385	–		3-3/8	(3.3750)	–	–	3	10.00	4.56	1.75	2.8830	2.162
3.385–3.510	–		3-1/2	(3.5000)	–	–	3	10.25	4.94	2.00	3.0080	2.256
3.510–3.635	–		3-5/8	(3.6250)	M90	(3.5433)	3	10.25	4.94	2.00	3.1330	2.350
3.635–3.760	–		3-3/4	(3.7500)	–	–	3	10.50	5.31	2.13	3.2170	2.413
3.760–3.885	–		3-7/8	(3.8750)	–	–	3	10.50	5.31	2.13	3.3420	2.506
3.885–4.010	–		4	(4.0000)	M100	(3.9370)	3	10.75	5.31	2.25	3.4670	2.600

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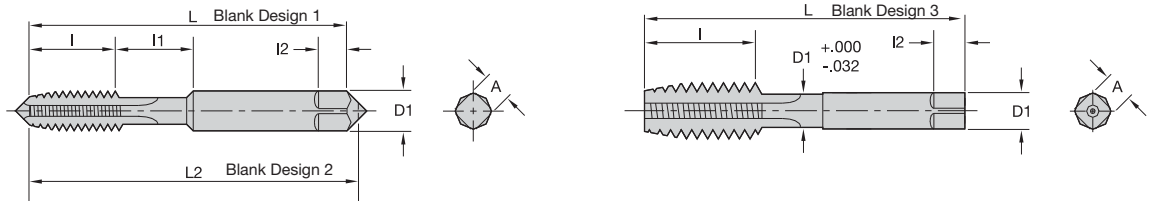

General Dimensions

Tap Dimensions — Inches

nominal diameter range (in)		machine screw size number (in)		nominal fractional diameter (in)		nominal metric diameter mm (in)		blank design number	overall length L	thread length l	neck length l1	square length l2	shank diameter D1	square size A
.104	.117	4	(.1120)	—		—	—	1	1.88	.31	.25	.19	.1410	.110
.117	.130	5	(.1250)			M3	(.1181)	1	1.94	.31	.31	.19	.1410	.110
.130	.145	6	(.1380)	—		M3.5	(.1378)	1	2.00	.38	.31	.19	.1410	.110
.145	.171	8	(.1640)			M4	(.1575)	1	2.13	.38	.38	.25	.1680	.131
.171	.197	10	(.1900)	—		M4.5	(.1772)	1	2.38	.50	.38	.25	.1940	.152
—	—	—	—			M5	(.1969)	—	—	—	—	—	—	—
.197	.223	12	(.2160)	—	—	—	—	1	2.38	.50	.44	.28	.2200	.165
.223	.260	—	—	1/4	(.2500)	M6	(.2362)	2	2.50	.63	.38	.31	.2550	.191
.260	.323	—		5/16	(.3125)	M7, M8	(.2756), (.3150)	2	2.72	.69	.44	.38	.3180	.238
.323	.395			3/8	(.3750)	M10	(.3937)	2	2.94	.75	.50	.44	.3810	.286
.395	.448	—		7/16	(.4375)	—	—	3	3.16	.88	—	.41	.3230	.242
.448	.510			1/2	(.5000)	M12	(.4724)	3	3.38	.94	—	.44	.3670	.275
.510	.573	—		9/16	(.5625)	M14	(.5541)	3	3.59	1.00	—	.50	.4290	.322
.573	.635			5/8	(.6250)	M16	(.6299)	3	3.81	1.09	—	.56	.4800	.360
.635	.709	—		11/16	(.6875)	M18	(.7087)	3	4.03	1.09	—	.63	.5420	.406
.709	.760			3/4	(.7500)	—	—	3	4.25	1.22	—	.69	.5900	.442
.760	.823	—		13/16	(.8125)	M20	(.7874)	3	4.47	1.22	—	.69	.6520	.489
.823	.885			7/8	(.8750)	M22	(.8661)	3	4.69	1.34	—	.75	.3670	.523
.885	.948	—		15/16	(.9375)	M24	(.9449)	3	4.91	1.34	—	.75	.7600	.570
.948	1.010			1	(1.0000)	M25	(.9843)	3	5.13	1.50	—	.81	.8000	.600

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NOTE: Thread length l is based on a length of 12 pitches of the UNC thread series. Thread length "l" is a minimum value and has no tolerance. When thread length "l" is added to neck length "l1", the total shall be no less than the minimum USCTI Table 302 thread length "l". Unless otherwise specified, all tolerances are in accordance with USCTI Table 302. For eccentricity tolerances, see USCTI Table 317. Table 302 is provided for reference only. The Kennametal tap dimensions may differ.

Tolerances

element	nominal diameter range (in)	direction	tolerance (in)
length overall — L	.0520–1.0100	plus or minus	.031
	1.0100–4.0100	plus or minus	.063
length of thread — l	.0520–.2230	plus or minus	.047
	.2230–.5100	plus or minus	.063
	.5100–1.5100	plus or minus	.094
	1.5100–4.0100	plus or minus	.125
length of square — l2	.0520–1.0100	plus or minus	.031
	1.0100–4.0100	plus or minus	.063
diameter of shank — d1	.0520–.2230	minus	.0015
	.2230–.6350	minus	.0015
	.6350–1.0100	minus	.0020
	1.0100–1.5100	minus	.0020
	1.5100–2.0100	minus	.0030
	2.0100–4.0100	minus	.0030
size of square — a	.0520–.5100	minus	.004
	.5100–1.0100	minus	.006
	1.0100–2.0100	minus	.008
	2.0100–4.0100	minus	.010

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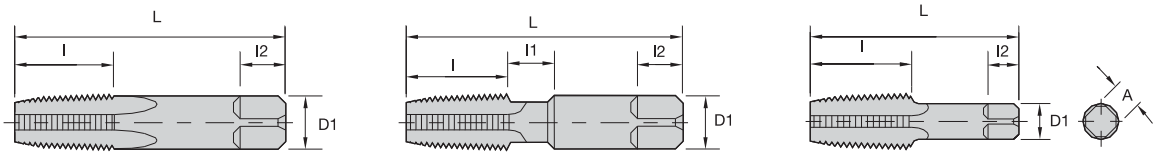
Special Taps

Unless otherwise specified: Special taps over 1.010–1.510" diameter inclusive, having 14 or more threads per inch or 1,75mm pitch and finer, and sizes over 1.510" diameter with 10 or more threads per inch or 2,5mm pitch and finer, are made to general dimensions shown in USCTI Table 303. Special tap thread limits are determined using the formulas shown in USCTI Table 331 for Unified Inch Screw Threads and USCTI Table 341 for metric m-profile screw threads.

NOTE: Tap sizes .395" and smaller have an external center on the thread end (may be removed on bottoming taps). Sizes .125" and smaller have an external centre on the shank end. Sizes .224–.395" have truncated partial cone centres on the shank end (length of cone approximately 1/4 of diameter of shank). Sizes over .395" have internal centres on both the thread and shank ends.

For standard thread limits and tolerances for Unified Inch Screw Threads, see USCTI Table 327, and for metric threads, see USCTI Table 337.

For eccentricity tolerances of tap elements, see USCTI Table 317.



General Dimensions

nominal size (in)	dimensions (in) overall length L	thread length l	square length l2	shank diameter D1	square size A	optional neck length l1
1/16	2.13	.69	.38	.3125	.234	.375
1/8	2.13	.75	.38	.3125	.234	–
1/8	2.13	.75	.38	.4375	.328	.375
1/4	2.44	1.06	.44	.5625	.421	.375
3/8	2.56	1.06	.50	.7000	.531	.375
1/2	3.13	1.38	.63	.6875	.515	–
3/4	3.25	1.38	.69	.9063	.679	–
1	3.75	1.75	.81	1.1250	.843	–
1-1/4	4.00	1.75	.94	1.3125	.984	–
1-1/2	4.25	1.75	1.00	1.5000	1.125	–
2	4.25	1.75	1.13	1.8750	1.406	–
2-1/2	5.50	2.56	1.25	2.2500	1.687	–
3	6.00	2.63	1.38	2.6250	1.968	–
3-1/2	6.50	2.69	1.50	2.8125	2.108	–
4	6.75	2.75	1.56	3.0000	2.250	–

Tolerances

element	range	direction	tolerance
length overall — L	1/16–3/4 inc.	plus/minus	.031
	1–4 inc.	plus/minus	.063
length of thread — l	1/16–3/4 inc.	plus/minus	.063
	1–1-1/4 inc.	plus/minus	.094
	1-1/2–4	plus/minus	.125
length of square — l2	1/16–3/4 inc.	plus/minus	.031
	1–4 inc.	plus/minus	.063
diameter of shank — d1	1/16–1/8	minus	.0015
	1/4–1 inc.	minus	.0020
	1-1/4–4 inc.	minus	.0030
size of square — a	1/16–1/8	minus	.004
	1/4–3/4 inc.	minus	.006
	1–4 inc.	minus	.008

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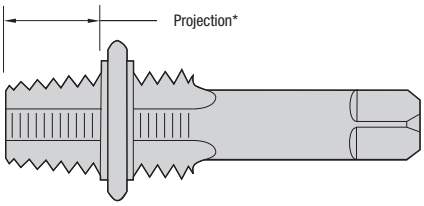
American National Standard Taper Pipe Thread Form (NPT)
Aeronautical National Taper Pipe Thread Form (ANPT)
Dryseal American National Standard Taper Pipe Thread Form (NPTF)



nominal size (in)	threads per inch	projection* (in)	projection tolerance + / –	taper per foot limits min	taper per foot limits max	length L1	tap drill size** NPT, ANPT, NFTF
1/16	27	.312	.063	.719	.781	.160	C
1/8	27	.312	.063	.719	.781	.1615	Q
1/4	18	.459	.063	.719	.781	.2278	7/16
3/8	18	.454	.063	.719	.781	.240	9/16
1/2	14	.579	.063	.719	.781	.320	45/64
3/4	14	.565	.063	.719	.781	.339	29/32
1	11-1/2	.678	.094	.719	.781	.400	1-9/64
1-1/4	11-1/2	.686	.094	.719	.781	.420	1-31/64
1-1/2	11-1/2	.699	.094	.719	.781	.420	1-23/32
2	11-1/2	.667	.094	.719	.781	.436	2-3/16
2-1/2	8	.925	.094	.734	.781	.682	2-39/64
3	8	.925	.094	.734	.781	.766	3-15/64
3-1/2	8	.938	.125	.734	.781	.821	—
4	8	.950	.125	.734	.781	.844	—

*Distance from small end of tap projects through L1 taper thread ring gage.
**Recommended size given permits direct tapping without reaming the hole, but only gives a full thread for approximately the L1 length.
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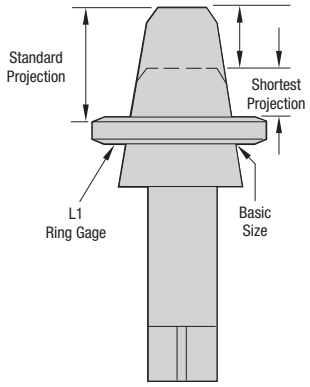
Pipe Taps

General-purpose pipe taps are appropriate for threading a wide variety of materials, both ferrous and non-ferrous.

Ground thread pipe taps are standard in American Standard Pipe Form (NPT) and American Standard Dryseal Pipe Form (NPFT). NPT threads require the use of a sealer, like Teflon® tape or pipe compound. Dryseal taps are used to tap fittings, which will give a pressure-tight joint without the use of a sealer.

The nominal size of a pipe tap is that of the pipe fitting to be tapped, not the actual size of the tap. The thread tapers 3/4" per foot.

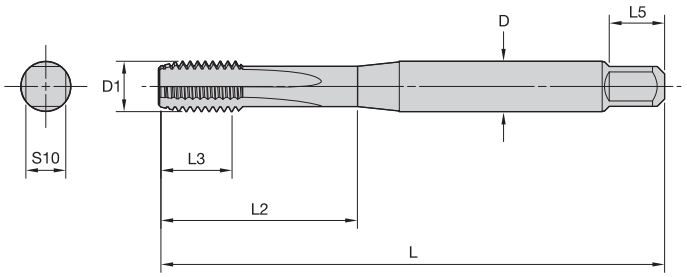
All pipe taps are furnished with 2-1/2–3-1/2 thread chamfer.



Short projection pipe taps are made with a projection shorter than standard for taper pipe tapping where the depth of tapping is limited.

Special short projection taper pipe taps can be furnished with American National Standard Taper Pipe thread (ANPT) or Dryseal American National Standard Taper Pipe thread (NPTF, PTF-SAE Short, or PTF-SPL Extra Short).

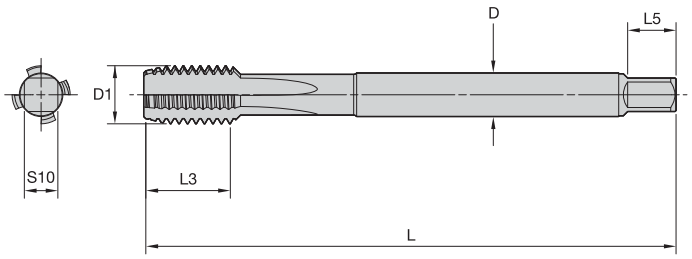
For information on short projection pipe taps and hole preparation for NPT, NPTF, and ANPT internal pipe threads, consult Kennametal Technical Bulletins.



DIN 371

D1	pitch	D	L	L3*	L2	L5	S10
M3	0,5	3,5	56	11	18	6	2,7
M3,5	0,6	4	56	12	20	6	3
M4	0,7	4,5	63	13	21	6	3,4
M4,5	0,75	6	70	16	25	8	4,9
M5	0,8	6	70	16	25	8	4,9
M6	1	6	80	19	30	8	4,9
M7	1	7	80	19	30	8	5,5
M8	0,75	8	80	18	30	9	6,2
M8	1,25	8	90	22	35	9	6,2
M9	0,75	9	80	18	30	10	7
M9	1,25	9	90	22	35	10	7
M10	1	10	90	20	35	11	8
M10	1,5	10	100	24	39	11	8

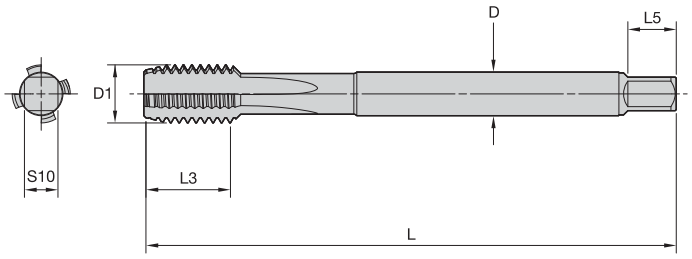
*Maximum



DIN 376

D1	pitch	D	L	L3*	L5	S10
M8	1,25	6	90	22	8	4,9
M9	1,25	7	90	22	8	5,5
M10	1,5	7	100	24	8	5,5
M11	1,5	8	100	24	9	6,2
M12	1,75	9	110	28	10	7
M14	2	11	110	30	12	9
M16	2	12	110	32	12	9
M18	2,5	14	125	34	14	11
M20	2,5	16	140	34	15	12
M22	2,5	18	140	34	17	14,5
M24	3	18	160	38	17	14,5
M27	3	20	160	38	19	16
M30	3,5	22	180	45	21	18
M33	3,5	25	180	50	23	20
M36	4	28	200	56	25	22
M39	4	32	200	60	27	24
M42	4,5	32	200	60	27	24
M45	4,5	36	220	65	32	29

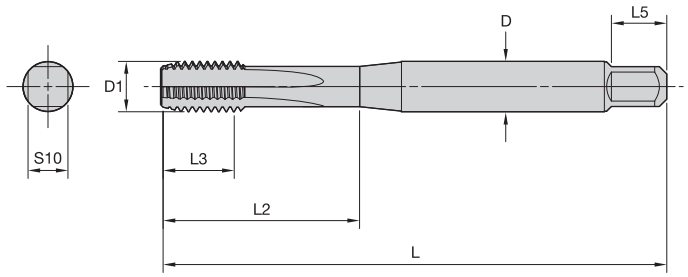
*Maximum



DIN 374

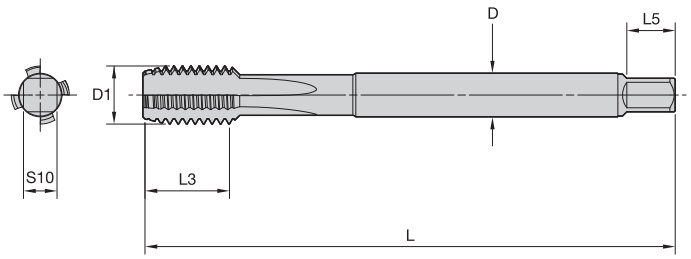
	pitch						
D1	**minimum**	**maximum**	**D**	**L**	**L3***	**L5**	**S10**
M8	0,2	0,75	6	80	18	8	4,9
M8	–	1	6	90	22	8	4,9
M9	0,2	0,75	7	80	18	8	5,5
M9	–	1	7	90	22	8	5,5
M10	0,2	1	7	90	20	8	5,5
M10	–	1,25	7	100	24	8	5,5
M11	0,35	1	8	90	20	9	6,2
M12	0,35	1,5	9	100	22	10	7
M14	0,35	1,5	11	100	22	12	9
M16	0,35	1,5	12	100	22	12	9
M16	–	2	12	110	32	12	9
M18	0,35	1,5	14	110	25	14	11
M18	–	2	14	125	34	14	11
M20	0,35	1,5	16	125	25	15	12
M20	–	2	16	140	34	15	12
M22	0,35	1,5	18	125	25	17	14,5
M22	–	2	18	140	34	17	14,5
M24	0,35	2	18	140	28	17	14,5
M27	0,35	2	20	140	28	19	16
M30	0,35	2	22	150	28	21	18
M30	–	3	22	180	45	21	18

*Maximum



JIS Type 2 Metric Coarse

				metric dimensions			
D1	**pitch**	**D**	**L**	**L3**	**L2**	**L5**	**S10**
M3	0,5	4	46	11	19	6	3,2
M3,5	0,6	4	48	13	20	6	3,2
M4	0,7	5	52	13	21	7	4
M4,5	0,75	5	55	13	21	7	4
M5	0,8	5,5	60	16	24	7	4,5
M6	1	6	62	19	29	7	4,5



JIS Type 3 Metric Coarse

			metric dimensions			
D1	**pitch**	**D**	**L**	**L3**	**L5**	**S10**
M8	1,25	6,2	70	22	8	5
M9	1,25	7	72	22	8	5,5
M10	1,5	7	75	24	8	5,5
M11	1,5	8	80	25	9	6
M12	1,75	8,5	82	29	9	6,5
M14	2	10,5	88	30	11	8
M16	2	12,5	95	32	13	10
M18	2,5	14	100	37	14	11
M20	2,5	15	105	37	15	12
M22	2,5	17	115	38	16	13
M24	3	19	120	45	18	15

Thread Cutting • UNC, UNF, and 8-pitch

tap size	Threads per Inch			65% thread						70% thread						75% thread					
				Metric			Inch			Metric			Inch			Metric			Inch		
	UNC	UNF	8-pitch	smallest drill	theoretical	largest drill	smallest drill	theoretical	largest drill	smallest drill	theoretical	largest drill	smallest drill	theoretical	largest drill	smallest drill	theoretical	largest drill	smallest drill	theoretical	largest drill
#0	–	80	–	1.20	**1.26**	1.30	0.0472	**0.0494**	0.0512	1.20	**1.24**	1.30	0.0472	**0.0486**	0.0512	1.20	**1.21**	1.30	0.0472	**0.0478**	0.0512
#1	64	–	–	1.50	**1.52**	1.60	0.0591	**0.0598**	0.0630	1.40	**1.49**	1.50	0.0551	**0.0588**	0.0591	1.40	**1.47**	1.50	0.0551	**0.0578**	0.0591
	–	72	–	1.50	**1.56**	1.60	0.0591	**0.0613**	0.0630	1.50	**1.53**	1.60	0.0591	**0.0604**	0.0630	1.50	**1.51**	1.60	0.0591	**0.0595**	0.0630
#2	56	–	–	1.80	**1.80**	1.80	0.0709	**0.0709**	0.0709	1.70	**1.77**	1.80	0.0669	**0.0698**	0.0709	1.70	**1.74**	1.80	0.0669	**0.0686**	0.0709
	–	64	–	1.80	**1.85**	1.90	0.0709	**0.0728**	0.0748	1.80	**1.82**	1.90	0.0709	**0.0718**	0.0748	1.80	**1.80**	1.80	0.0669	**0.0708**	0.0709
#3	48	–	–	2.00	**2.07**	2.10	0.0787	**0.0814**	0.0827	2.00	**2.03**	2.10	0.0787	**0.0801**	0.0827	2.00	**2.00**	2.00	0.0787	**0.0787**	0.0787
	–	56	–	2.10	**2.13**	2.20	0.0827	**0.0839**	0.0866	2.10	**2.10**	2.10	0.0827	**0.0828**	0.0866	2.00	**2.07**	2.10	0.0787	**0.0816**	0.0827
#4	40	–	–	2.30	**2.31**	2.38	0.0906	**0.0909**	0.0938	2.20	**2.27**	2.30	0.0866	**0.0893**	0.0906	2.20	**2.23**	2.30	0.0866	**0.0876**	0.0906
	–	48	–	2.40	**2.40**	2.40	0.0938	**0.0944**	0.0945	2.30	**2.36**	2.38	0.0906	**0.0931**	0.0938	2.30	**2.33**	2.38	0.0906	**0.0917**	0.0938
#5	40	–	–	2.64	**2.64**	2.64	0.1024	**0.1039**	0.1040	2.60	**2.60**	2.60	0.1015	**0.1023**	0.1024	2.50	**2.56**	2.58	0.0984	**0.1006**	0.1015
	–	44	–	2.64	**2.69**	2.70	0.1040	**0.1058**	0.1063	2.64	**2.65**	2.70	0.1040	**0.1043**	0.1063	2.60	**2.61**	2.64	0.1024	**0.1029**	0.1040
#6	32	–	–	2.82	**2.83**	2.87	0.1100	**0.1116**	0.1130	2.78	**2.78**	2.78	0.1094	**0.1096**	0.1102	2.71	**2.73**	2.78	0.1065	**0.1076**	0.1094
	–	40	–	2.95	**2.97**	3.00	0.1160	**0.1169**	0.1181	2.90	**2.93**	2.95	0.1142	**0.1153**	0.1160	2.87	**2.89**	2.90	0.1130	**0.1136**	0.1142
#8	32	–	–	3.50	**3.50**	3.50	0.1360	**0.1376**	0.1378	3.40	**3.44**	3.46	0.1339	**0.1356**	0.1360	3.30	**3.39**	3.40	0.1299	**0.1336**	0.1339
	–	36	–	3.57	**3.57**	3.57	0.1378	**0.1405**	0.1406	3.50	**3.52**	3.57	0.1378	**0.1387**	0.1406	3.46	**3.48**	3.50	0.1360	**0.1369**	0.1378
#10	24	–	–	3.90	**3.93**	3.97	0.1535	**0.1548**	0.1563	3.80	**3.86**	3.90	0.1496	**0.1521**	0.1535	3.73	**3.79**	3.80	0.1470	**0.1494**	0.1496
	–	32	–	4.10	**4.16**	4.20	0.1614	**0.1636**	0.1654	4.10	**4.10**	4.10	0.1614	**0.1616**	0.1654	4.04	**4.05**	4.09	0.1590	**0.1596**	0.1610
#12	24	–	–	4.50	**4.59**	4.60	0.1772	**0.1808**	0.1811	4.50	**4.52**	4.60	0.1772	**0.1781**	0.1811	4.40	**4.46**	4.50	0.1732	**0.1754**	0.1772
	–	28	–	4.70	**4.72**	4.76	0.1850	**0.1858**	0.1875	4.62	**4.66**	4.70	0.1820	**0.1835**	0.1850	4.60	**4.60**	4.60	0.1811	**0.1812**	0.1820
1/4	20	–	–	5.20	**5.28**	5.30	0.2047	**0.2078**	0.2087	5.20	**5.20**	5.20	0.2031	**0.2045**	0.2047	5.11	**5.11**	5.11	0.2010	**0.2013**	0.2031
	–	28	–	5.56	**5.58**	5.60	0.2188	**0.2198**	0.2205	5.50	**5.53**	5.56	0.2165	**0.2175**	0.2188	5.41	**5.47**	5.50	0.2130	**0.2152**	0.2165
5/16	18	–	–	6.75	**6.75**	6.75	0.2656	**0.2656**	0.2656	6.63	**6.65**	6.70	0.2610	**0.2620**	0.2638	6.53	**6.56**	6.60	0.2570	**0.2584**	0.2598
	–	24	–	7.00	**7.04**	7.10	0.2756	**0.2773**	0.2795	6.90	**6.98**	7.00	0.2717	**0.2746**	0.2756	6.90	**6.91**	7.00	0.2717	**0.2719**	0.2756
3/8	16	–	–	8.10	**8.18**	8.20	0.3189	**0.3222**	0.3228	8.00	**8.08**	8.10	0.3150	**0.3182**	0.3189	7.94	**7.98**	8.00	0.3125	**0.3141**	0.3150
	–	24	–	8.60	**8.63**	8.70	0.3386	**0.3398**	0.3425	8.50	**8.56**	8.60	0.3346	**0.3371**	0.3386	8.43	**8.49**	8.50	0.3320	**0.3344**	0.3346
7/16	14	–	–	9.53	**9.58**	9.60	0.3750	**0.3772**	0.3780	9.40	**9.46**	9.50	0.3701	**0.3726**	0.3740	9.30	**9.34**	9.35	0.3661	**0.3679**	0.3680
	–	20	–	10.00	**10.04**	10.10	0.3937	**0.3953**	0.3976	9.92	**9.96**	10.00	0.3906	**0.3920**	0.3937	9.80	**9.88**	9.90	0.3858	**0.3888**	0.3898
1/2	13	–	–	11.00	**11.05**	11.10	0.4331	**0.4351**	0.4370	10.90	**10.92**	11.00	0.4291	**0.4301**	0.4331	10.80	**10.80**	10.80	0.4219	**0.4251**	0.4252
	–	20	–	11.60	**11.63**	11.70	0.4528	**0.4578**	0.4606	11.51	**11.55**	11.60	0.4528	**0.4545**	0.4606	11.40	**11.46**	11.50	0.4488	**0.4513**	0.4528
9/16	12	–	–	12.50	**12.50**	12.50	0.4921	**0.4921**	0.4921	12.30	**12.36**	12.40	0.4844	**0.4867**	0.4882	12.20	**12.23**	12.30	0.4803	**0.4813**	0.4843
	–	18	–	13.10	**13.10**	13.10	0.5118	**0.5156**	0.5157	13.00	**13.00**	13.00	0.5118	**0.5120**	0.5157	12.80	**12.91**	13.00	0.5039	**0.5084**	0.5118
5/8	11	–	–	13.80	**13.93**	14.00	0.5433	**0.5482**	0.5512	13.50	**13.78**	13.80	0.5315	**0.5423**	0.5433	13.50	**13.63**	13.80	0.5315	**0.5364**	0.5433
	–	18	–	14.50	**14.68**	15.00	0.5709	**0.5781**	0.5906	14.50	**14.59**	15.00	0.5709	**0.5745**	0.5906	14.50	**14.50**	14.50	0.5709	**0.5709**	0.5709
3/4	10	–	–	16.50	**16.91**	17.00	0.6496	**0.6656**	0.6693	16.50	**16.74**	17.00	0.6496	**0.6591**	0.6693	16.50	**16.58**	17.00	0.6496	**0.6526**	0.6560
	–	16	–	17.50	**17.71**	18.00	0.6890	**0.6972**	0.7087	17.50	**17.61**	18.00	0.6890	**0.6932**	0.7087	17.50	**17.50**	17.50	0.6890	**0.6891**	0.6969
7/8	9	–	–	19.50	**19.84**	20.00	0.7677	**0.7812**	0.7874	19.50	**19.66**	20.00	0.7677	**0.7740**	0.7874	19.00	**19.48**	19.50	0.7660	**0.7668**	0.7677
	–	14	–	20.50	**20.69**	21.00	0.8071	**0.8147**	0.8268	20.50	**20.58**	21.00	0.8071	**0.8101**	0.8268	20.00	**20.46**	20.50	0.8012	**0.8054**	0.8071
1	8	–	–	22.50	**22.72**	22.77	0.8858	**0.8945**	0.8965	22.50	**22.51**	22.77	0.8858	**0.8863**	0.8965	22.23	**22.31**	22.44	0.8750	**0.8782**	0.8840
	–	12	–	23.50	**23.61**	23.81	0.9252	**0.9296**	0.9375	23.42	**23.48**	23.50	0.9220	**0.9242**	0.9252	23.30	**23.34**	23.42	0.9173	**0.9188**	0.9220
1-1/8	7	–	–	25.50	**25.51**	25.60	1.0039	**1.0044**	1.0080	25.07	**25.28**	25.40	0.9870	**0.9951**	1.0000	25.00	**25.04**	25.07	0.9843	**0.9858**	0.9870
	–	12	–	26.70	**26.79**	27.00	1.0512	**1.0546**	1.0610	26.59	**26.65**	26.70	1.0470	**1.0492**	1.0512	26.50	**26.51**	26.59	1.0433	**1.0438**	1.0470
	–	–	8	25.81	**25.89**	26.00	1.0160	**1.0195**	1.0236	25.67	**25.69**	25.81	1.0110	**1.0113**	1.0160	25.40	**25.48**	25.50	1.0000	**1.0032**	1.0039
1-1/4	7	–	–	28.58	**28.69**	29.00	1.1250	**1.1294**	1.1417	28.18	**28.45**	28.50	1.1090	**1.1201**	1.1220	28.18	**28.21**	28.50	1.1090	**1.1108**	1.1220
	–	12	–	29.77	**29.96**	30.00	1.1720	**1.1796**	1.1811	29.77	**29.83**	30.00	1.1720	**1.1742**	1.1811	29.50	**29.69**	29.73	1.1614	**1.1688**	1.1720
	–	–	8	29.00	**29.07**	29.50	1.1417	**1.1445**	1.1560	28.58	**28.86**	29.00	1.1250	**1.1363**	1.1417	28.58	**28.66**	29.00	1.1250	**1.1282**	1.1417

(continued)

(Thread Cutting • UNC, UNF, and 8-pitch — continued)

tap size	Threads per Inch			65% thread						70% thread						75% thread					
				Metric			Inch			Metric			Inch			Metric			Inch		
	UNC	UNF	8-pitch	smallest drill	theoretical	largest drill	smallest drill	theoretical	largest drill	smallest drill	theoretical	largest drill	smallest drill	theoretical	largest drill	smallest drill	theoretical	largest drill	smallest drill	theoretical	largest drill
	6	–	–	31.00	**31.35**	31.50	1.2200	**1.2343**	1.2402	31.00	**31.08**	31.50	1.2200	**1.2235**	1.2402	30.56	**30.80**	30.96	1.2030	**1.2126**	1.2190
1-3/8	–	12	–	33.00	**33.14**	33.34	1.2992	**1.3046**	1.3130	33.00	**33.00**	33.00	1.2992	**1.2992**	1.2992	32.54	**32.86**	32.94	1.2810	**1.2938**	1.2970
	–	–	8	32.00	**32.24**	32.50	1.2598	**1.2695**	1.2795	32.00	**32.04**	32.50	1.2598	**1.2613**	1.2795	31.75	**31.83**	32.00	1.2500	**1.2532**	1.2598
	6	–	–	34.50	**34.53**	34.93	1.3583	**1.3593**	1.3750	34.13	**34.25**	34.50	1.3440	**1.3485**	1.3583	33.73	**33.98**	34.00	1.3280	**1.3376**	1.3386
1-1/2	–	12	–	36.12	**36.31**	36.50	1.4220	**1.4296**	1.4375	36.12	**36.18**	36.50	1.4220	**1.4242**	1.4375	36.00	**36.04**	36.12	1.4173	**1.4188**	1.4220
	–	–	8	35.00	**35.42**	35.50	1.3780	**1.3945**	1.3976	35.00	**35.21**	35.50	1.3780	**1.3863**	1.3976	35.00	**35.01**	35.50	1.3780	**1.3782**	1.3976
1-5/8	–	–	8	38.50	**38.59**	39.00	1.5157	**1.5195**	1.5354	38.10	**38.39**	38.46	1.5000	**1.5113**	1.5140	38.10	**38.18**	38.46	1.5000	**1.5032**	1.5140
1-3/4	5	–	–	40.00	**40.16**	41.00	1.5750	**1.5811**	1.6140	39.50	**39.83**	40.00	1.5551	**1.5681**	1.5748	39.50	**39.50**	39.50	1.5551	**1.5552**	1.5748
	–	–	8	41.00	**41.77**	42.00	1.6140	**1.6445**	1.6540	41.00	**41.56**	42.00	1.6140	**1.6363**	1.6540	41.00	**41.36**	42.00	1.6140	**1.6282**	1.6540
1-7/8	–	–	8	44.00	**44.94**	45.00	1.7320	**1.7695**	1.7720	44.00	**44.74**	45.00	1.7320	**1.7613**	1.7720	44.00	**44.53**	45.00	1.7320	**1.7532**	1.7720
2	4 1/2	–	–	46.00	**46.03**	47.00	1.8110	**1.8124**	1.8500	45.00	**45.67**	46.00	1.7720	**1.7979**	1.8110	45.00	**45.30**	46.00	1.7720	**1.7835**	1.8110
	–	–	8	48.00	**48.12**	49.00	1.8900	**1.8945**	1.9290	47.00	**47.91**	48.00	1.8500	**1.8863**	1.8900	47.00	**47.71**	48.00	1.8500	**1.8782**	1.8900
2-1/4	4 1/2	–	–	52.00	**52.38**	53.00	2.0470	**2.0624**	2.0870	52.00	**52.02**	53.00	2.0470	**2.0479**	2.0870	51.00	**51.65**	52.00	2.0080	**2.0335**	2.0470
	–	–	8	54.00	**54.47**	55.00	2.1260	**2.1445**	2.1650	54.00	**54.26**	55.00	2.1260	**2.1363**	2.1650	54.00	**54.06**	55.00	2.1260	**2.1282**	2.1650
2-1/2	4	–	–	58.00	**58.14**	59.00	2.2840	**2.2889**	2.3230	57.00	**57.73**	58.00	2.2440	**2.2727**	2.2840	57.00	**57.31**	58.00	2.2440	**2.2564**	2.2840
	–	–	8	60.00	**60.82**	61.00	2.3620	**2.3945**	2.4020	60.00	**60.61**	61.00	2.3620	**2.3863**	2.4020	60.00	**60.41**	61.00	2.3620	**2.3782**	2.4020

Thread Cutting • M and MF

tap size	pitch		65% thread						70% thread						75% thread					
			Metric			Inch			Metric			Inch			Metric			Inch		
	M	MF	smallest drill	theoretical	largest drill	smallest drill	theoretical	largest drill	smallest drill	theoretical	largest drill	smallest drill	theoretical	largest drill	smallest drill	theoretical	largest drill	smallest drill	theoretical	largest drill
M1.6	0.35	–	1.20	**1.30**	1.30	0.0512	**0.0512**	0.0512	1.20	**1.28**	1.30	0.0472	**0.0504**	0.0512	1.20	**1.26**	1.30	0.0472	**0.0496**	0.0512
M1.7	0.35	–	1.40	**1.40**	1.40	0.0551	**0.0551**	0.0551	1.32	**1.38**	1.40	0.0520	**0.0543**	0.0550	1.32	**1.36**	1.40	0.0520	**0.0535**	0.0550
M1.8	0.35	–	1.50	**1.50**	1.50	0.0591	**0.0591**	0.0591	1.40	**1.48**	1.50	0.0551	**0.0583**	0.0591	1.40	**1.46**	1.50	0.0551	**0.0575**	0.0591
M2	0.4	–	1.60	**1.66**	1.70	0.0630	**0.0654**	0.0669	1.60	**1.64**	1.70	0.0630	**0.0646**	0.0669	1.60	**1.61**	1.70	0.0630	**0.0634**	0.0669
M2.2	0.45	–	1.80	**1.82**	1.90	0.0709	**0.0717**	0.0748	1.70	**1.79**	1.80	0.0669	**0.0705**	0.0709	1.70	**1.76**	1.80	0.0669	**0.0693**	0.0709
M2.5	0.45	–	2.10	**2.12**	2.20	0.0827	**0.0835**	0.0866	2.00	**2.09**	2.10	0.0787	**0.0823**	0.0827	2.00	**2.06**	2.10	0.0787	**0.0811**	0.0827
M2.6	0.45	–	2.20	**2.22**	2.30	0.0866	**0.0874**	0.0906	2.10	**2.19**	2.20	0.0827	**0.0862**	0.0866	2.10	**2.16**	2.20	0.0827	**0.0850**	0.0866
M3	0.5	–	2.58	**2.58**	2.58	0.1015	**0.1016**	0.1024	2.50	**2.55**	2.58	0.0984	**0.1004**	0.1015	2.50	**2.51**	2.58	0.0984	**0.0988**	0.1015
	–	0.35	2.70	**2.70**	2.70	0.1063	**0.1063**	0.1063	2.64	**2.68**	2.70	0.1040	**0.1055**	0.1063	2.64	**2.66**	2.70	0.1040	**0.1047**	0.1063
M3.5	0.6	–	2.95	**2.99**	3.00	0.1160	**0.1177**	0.1181	2.95	**2.95**	3.00	0.1160	**0.1161**	0.1181	2.90	**2.92**	2.95	0.1142	**0.1150**	0.1160
M4	0.7	–	3.40	**3.41**	3.46	0.1339	**0.1343**	0.1360	3.30	**3.36**	3.40	0.1299	**0.1323**	0.1339	3.30	**3.32**	3.40	0.1299	**0.1307**	0.1339
	–	0.5	3.57	**3.58**	3.60	0.1406	**0.1409**	0.1417	3.50	**3.54**	3.57	0.1378	**0.1394**	0.1406	3.50	**3.51**	3.57	0.1378	**0.1382**	0.1406
M4.5	0.75	–	3.80	**3.87**	3.90	0.1496	**0.1524**	0.1535	3.80	**3.82**	3.90	0.1496	**0.1504**	0.1535	3.73	**3.77**	3.80	0.1470	**0.1484**	0.1496
M5	0.8	–	4.30	**4.32**	4.37	0.1693	**0.1701**	0.1719	4.22	**4.27**	4.30	0.1660	**0.1681**	0.1693	4.22	**4.22**	4.30	0.1660	**0.1661**	0.1693
	–	0.5	4.50	**4.58**	4.60	0.1772	**0.1803**	0.1811	4.50	**4.54**	4.60	0.1772	**0.1787**	0.1811	4.50	**4.51**	4.60	0.1772	**0.1776**	0.1811
M6	1	–	5.16	**5.16**	5.16	0.2031	**0.2031**	0.2031	5.00	**5.09**	5.10	0.1969	**0.2004**	0.2008	5.00	**5.03**	5.10	0.1969	**0.1980**	0.2008
	–	0.75	5.30	**5.37**	5.40	0.2087	**0.2114**	0.2126	5.30	**5.32**	5.40	0.2087	**0.2094**	0.2126	5.20	**5.27**	5.30	0.2047	**0.2075**	0.2087
M7	1	–	6.10	**6.16**	6.20	0.2402	**0.2425**	0.2441	6.00	**6.09**	6.10	0.2362	**0.2398**	0.2402	6.00	**6.03**	6.10	0.2362	**0.2374**	0.2402

(continued)

(Thread Cutting • M and MF — continued)

tap size	pitch M	pitch MF	65% thread Metric smallest drill	65% thread Metric theoretical	65% thread Metric largest drill	65% thread Inch smallest drill	65% thread Inch theoretical	65% thread Inch largest drill	70% thread Metric smallest drill	70% thread Metric theoretical	70% thread Metric largest drill	70% thread Inch smallest drill	70% thread Inch theoretical	70% thread Inch largest drill	75% thread Metric smallest drill	75% thread Metric theoretical	75% thread Metric largest drill	75% thread Inch smallest drill	75% thread Inch theoretical	75% thread Inch largest drill
M8	1.25	–	6.90	**6.94**	7.00	0.2717	**0.2732**	0.2756	6.80	**6.86**	6.90	0.2677	**0.2701**	0.2717	6.75	**6.78**	6.80	0.2656	**0.2669**	0.2677
	–	1	7.15	**7.16**	7.20	0.2813	**0.2819**	0.2835	7.00	**7.09**	7.10	0.2756	**0.2791**	0.2795	7.00	**7.03**	7.10	0.2756	**0.2768**	0.2795
	–	0.75	7.30	**7.37**	7.40	0.2874	**0.2902**	0.2913	7.30	**7.32**	7.40	0.2874	**0.2882**	0.2913	7.20	**7.27**	7.30	0.2835	**0.2862**	0.2874
M10	1.5	–	8.70	**8.73**	8.73	0.3425	**0.3437**	0.3438	8.60	**8.64**	8.70	0.3386	**0.3402**	0.3425	8.50	**8.54**	8.60	0.3346	**0.3362**	0.3386
	–	1.25	8.90	**8.94**	9.00	0.3504	**0.3520**	0.3543	8.80	**8.86**	8.90	0.3465	**0.3488**	0.3504	8.73	**8.78**	8.80	0.3438	**0.3457**	0.3465
	–	1	9.13	**9.16**	9.20	0.3594	**0.3606**	0.3622	9.00	**9.09**	9.10	0.3543	**0.3579**	0.3583	9.00	**9.03**	9.10	0.3543	**0.3555**	0.3583
	–	0.75	9.35	**9.37**	9.40	0.3680	**0.3689**	0.3701	9.30	**9.32**	9.35	0.3661	**0.3669**	0.3680	9.20	**9.27**	9.30	0.3622	**0.3650**	0.3661
M12	1.75	–	10.50	**10.52**	10.60	0.4134	**0.4142**	0.4173	10.40	**10.41**	10.50	0.4094	**0.4098**	0.4134	10.30	**10.30**	10.30	0.4055	**0.4055**	0.4055
	–	1.5	10.72	**10.73**	10.80	0.4219	**0.4224**	0.4252	10.60	**10.64**	10.70	0.4173	**0.4189**	0.4213	10.50	**10.54**	10.60	0.4134	**0.4150**	0.4173
	–	1.25	10.90	**10.94**	11.00	0.4291	**0.4307**	0.4331	10.80	**10.86**	10.90	0.4252	**0.4276**	0.4291	10.72	**10.78**	10.80	0.4219	**0.4244**	0.4252
	–	1	11.15	**11.16**	11.20	0.4375	**0.4394**	0.4409	11.00	**11.09**	11.10	0.4331	**0.4366**	0.4370	11.00	**11.03**	11.10	0.4331	**0.4343**	0.4370
M14	2	–	12.30	**12.31**	12.40	0.4844	**0.4846**	0.4882	12.10	**12.18**	12.20	0.4764	**0.4795**	0.4803	12.00	**12.05**	12.10	0.4724	**0.4744**	0.4764
	–	1.5	12.70	**12.73**	12.80	0.5000	**0.5012**	0.5039	12.60	**12.64**	12.70	0.4961	**0.4976**	0.5000	12.50	**12.54**	12.60	0.4921	**0.4937**	0.4961
M16	2	–	14.20	**14.31**	14.50	0.5591	**0.5634**	0.5709	14.00	**14.18**	14.20	0.5512	**0.5583**	0.5591	14.00	**14.05**	14.20	0.5512	**0.5531**	0.5591
	–	1.5	14.50	**14.73**	15.00	0.5709	**0.5799**	0.5906	14.50	**14.64**	15.00	0.5709	**0.5764**	0.5906	14.50	**14.54**	15.00	0.5709	**0.5724**	0.5906
M18	2.5	–	15.80	**15.89**	16.00	0.6220	**0.6256**	0.6299	15.50	**15.73**	15.80	0.6102	**0.6193**	0.6220	15.50	**15.56**	15.80	0.6102	**0.6126**	0.6220
	–	1.5	16.50	**16.73**	17.00	0.6496	**0.6587**	0.6693	16.50	**16.64**	17.00	0.6496	**0.6551**	0.6693	16.50	**16.54**	17.00	0.6496	**0.6512**	0.6693
M20	2.5	–	17.50	**17.89**	18.00	0.6890	**0.7043**	0.7087	17.50	**17.73**	18.00	0.6890	**0.6980**	0.7087	17.50	**17.56**	18.00	0.6890	**0.6913**	0.7087
	–	1.5	18.50	**18.73**	19.00	0.7283	**0.7374**	0.7480	18.50	**18.64**	19.00	0.7283	**0.7339**	0.7480	18.50	**18.54**	19.00	0.7283	**0.7299**	0.7480
	–	1	19.00	**19.16**	19.50	0.7480	**0.7543**	0.7677	19.00	**19.09**	19.50	0.7480	**0.7516**	0.7677	19.00	**19.03**	19.50	0.7480	**0.7492**	0.7677
M22	2.5	–	19.50	**19.89**	20.00	0.7677	**0.7831**	0.7874	19.50	**19.73**	20.00	0.7677	**0.7768**	0.7874	19.50	**19.56**	20.00	0.7677	**0.7701**	0.7874
	–	2	20.00	**20.31**	20.50	0.7874	**0.7996**	0.8071	20.00	**20.18**	20.50	0.7874	**0.7945**	0.8071	20.00	**20.05**	20.50	0.7874	**0.7894**	0.8071
	–	1.5	20.50	**20.73**	21.00	0.8071	**0.8161**	0.8268	20.50	**20.64**	21.00	0.8071	**0.8126**	0.8268	20.50	**20.54**	21.00	0.8071	**0.8087**	0.8268
M24	3	–	21.43	**21.47**	21.50	0.8440	**0.8453**	0.8460	21.15	**21.27**	21.33	0.8327	**0.8374**	0.8398	21.00	**21.08**	21.15	0.8268	**0.8299**	0.8327
	–	2	22.23	**22.31**	22.44	0.8750	**0.8783**	0.8840	22.00	**22.18**	22.23	0.8661	**0.8732**	0.8750	22.00	**22.05**	22.23	0.8661	**0.8681**	0.8750
	–	1.5	22.50	**22.73**	22.77	0.8858	**0.8949**	0.8965	22.50	**22.64**	22.77	0.8858	**0.8913**	0.8965	22.50	**22.54**	22.77	0.8858	**0.8874**	0.8965
M27	3	–	24.30	**24.47**	24.50	0.9567	**0.9634**	0.9646	24.00	**24.27**	24.30	0.9449	**0.9555**	0.9567	24.00	**24.08**	24.30	0.9449	**0.9480**	0.9567
	–	2	25.07	**25.31**	25.40	0.9870	**0.9965**	1.0000	25.07	**25.18**	25.40	0.9870	**0.9913**	1.0000	25.00	**25.05**	25.07	0.9843	**0.9862**	0.9870
	–	1.5	25.67	**25.73**	25.81	1.0110	**1.0130**	1.0160	25.61	**25.64**	25.65	1.0080	**1.0094**	1.0098	25.50	**25.54**	25.60	1.0039	**1.0055**	1.0080
M30	3.5	–	27.00	**27.04**	27.50	1.0630	**1.0646**	1.0827	26.70	**26.82**	27.00	1.0512	**1.0559**	1.0610	26.59	**26.59**	26.59	1.0433	**1.0469**	1.0470
	–	2	28.18	**28.31**	28.50	1.1090	**1.1146**	1.1220	28.18	**28.18**	28.18	1.1090	**1.1094**	1.1220	28.00	**28.05**	28.10	1.1024	**1.1043**	1.1063
	–	1.5	28.58	**28.73**	29.00	1.1250	**1.1311**	1.1417	28.58	**28.64**	29.00	1.1250	**1.1276**	1.1417	28.50	**28.54**	28.58	1.1220	**1.1236**	1.1250
M33	3.5	–	30.00	**30.04**	30.16	1.1811	**1.1827**	1.1875	29.77	**29.82**	30.00	1.1720	**1.1740**	1.1811	29.50	**29.59**	29.73	1.1614	**1.1650**	1.1720
	–	2	31.00	**31.31**	31.50	1.2200	**1.2327**	1.2402	31.00	**31.18**	31.50	1.2200	**1.2276**	1.2402	31.00	**31.05**	31.50	1.2200	**1.2224**	1.2402
M36	4	–	32.54	**32.62**	32.94	1.2810	**1.2843**	1.2970	32.00	**32.36**	32.50	1.2598	**1.2740**	1.2795	32.00	**32.10**	32.50	1.2598	**1.2638**	1.2795
	–	3	33.40	**33.47**	33.50	1.3130	**1.3177**	1.3189	33.00	**33.27**	33.34	1.2992	**1.3098**	1.3130	33.00	**33.08**	33.34	1.2992	**1.3024**	1.3130
	–	2	34.13	**34.31**	34.50	1.3440	**1.3508**	1.3583	34.13	**34.18**	34.50	1.3440	**1.3457**	1.3583	34.00	**34.05**	34.13	1.3386	**1.3406**	1.3440
M39	4	–	35.50	**35.62**	35.72	1.3976	**1.4024**	1.4060	35.00	**35.36**	35.50	1.3780	**1.3921**	1.3976	35.00	**35.10**	35.50	1.3780	**1.3819**	1.3976
	–	2	37.31	**37.31**	37.31	1.4567	**1.4689**	1.4690	37.00	**37.18**	37.31	1.4567	**1.4638**	1.4690	37.00	**37.05**	37.31	1.4567	**1.4587**	1.4690
M42	4.5	–	38.10	**38.20**	38.46	1.5000	**1.5039**	1.5140	37.50	**37.91**	38.00	1.4764	**1.4925**	1.4961	37.50	**37.62**	38.00	1.4764	**1.4811**	1.4961
	–	3	39.00	**39.47**	39.50	1.5354	**1.5539**	1.5551	39.00	**39.27**	39.50	1.5354	**1.5461**	1.5551	39.00	**39.08**	39.50	1.5354	**1.5386**	1.5551
	–	2	40.00	**40.31**	41.00	1.5750	**1.5870**	1.6140	40.00	**40.18**	41.00	1.5750	**1.5819**	1.6140	40.00	**40.05**	41.00	1.5750	**1.5768**	1.6140

Thread Forming • UNC and UNF

tap size	pitch UNC	pitch UNF	65% thread Metric smallest drill	65% thread Metric theoretical	65% thread Metric largest drill	65% thread Inch smallest drill	65% thread Inch theoretical	65% thread Inch largest drill	70% thread Metric smallest drill	70% thread Metric theoretical	70% thread Metric largest drill	70% thread Inch smallest drill	70% thread Inch theoretical	70% thread Inch largest drill	75% thread Metric smallest drill	75% thread Metric theoretical	75% thread Metric largest drill	75% thread Inch smallest drill	75% thread Inch theoretical	75% thread Inch largest drill
#0	–	80	1.32	**1.38**	1.40	0.0520	**0.0545**	0.0550	1.32	**1.38**	1.40	0.0520	**0.0540**	0.0550	1.32	**1.36**	1.40	0.0520	**0.0536**	0.0550
#1	64	–	1.60	**1.68**	1.70	0.0630	**0.0661**	0.0669	1.60	**1.67**	1.70	0.0630	**0.0655**	0.0669	1.60	**1.65**	1.70	0.0630	**0.0650**	0.0669
	–	72	1.70	**1.70**	1.70	0.0669	**0.0669**	0.0669	1.60	**1.69**	1.70	0.0630	**0.0663**	0.0669	1.60	**1.67**	1.70	0.0630	**0.0659**	0.0669
#2	56	–	1.98	**1.98**	1.98	0.0781	**0.0781**	0.0781	1.90	**1.97**	1.98	0.0748	**0.0774**	0.0781	1.90	**1.95**	1.98	0.0748	**0.0769**	0.0781
	–	64	2.00	**2.01**	2.10	0.0787	**0.0791**	0.0827	2.00	**2.00**	2.00	0.0781	**0.0785**	0.0787	1.98	**1.98**	1.98	0.0748	**0.0780**	0.0781
#3	48	–	2.20	**2.28**	2.30	0.0866	**0.0898**	0.0906	2.20	**2.27**	2.30	0.0866	**0.0890**	0.0906	2.20	**2.25**	2.30	0.0866	**0.0884**	0.0906
	–	56	2.30	**2.31**	2.38	0.0906	**0.0911**	0.0938	2.30	**2.31**	2.38	0.0866	**0.0904**	0.0906	2.20	**2.28**	2.30	0.0866	**0.0899**	0.0906
#4	40	–	2.50	**2.57**	2.58	0.0984	**0.1010**	0.1015	2.50	**2.55**	2.58	0.0984	**0.1000**	0.1015	2.50	**2.52**	2.58	0.0984	**0.0993**	0.1015
	–	48	2.60	**2.61**	2.64	0.1024	**0.1028**	0.1040	2.60	**2.60**	2.60	0.1015	**0.1020**	0.1024	2.58	**2.58**	2.58	0.0984	**0.1014**	0.1015
#5	40	–	2.90	**2.90**	2.90	0.1130	**0.1140**	0.1142	2.87	**2.88**	2.90	0.1130	**0.1130**	0.1130	2.82	**2.85**	2.87	0.1110	**0.1123**	0.1130
	–	44	2.90	**2.92**	2.95	0.1142	**0.1150**	0.1160	2.90	**2.91**	2.95	0.1130	**0.1141**	0.1142	2.87	**2.88**	2.90	0.1130	**0.1134**	0.1142
#6	32	–	3.10	**3.16**	3.18	0.1220	**0.1243**	0.1250	3.10	**3.14**	3.18	0.1220	**0.1230**	0.1250	3.10	**3.10**	3.10	0.1220	**0.1221**	0.1250
	–	40	3.20	**3.23**	3.26	0.1260	**0.1270**	0.1285	3.20	**3.21**	3.26	0.1260	**0.1260**	0.1260	3.18	**3.18**	3.18	0.1250	**0.1253**	0.1260
#8	32	–	3.80	**3.82**	3.90	0.1496	**0.1503**	0.1535	3.80	**3.80**	3.80	0.1470	**0.1490**	0.1496	3.73	**3.76**	3.80	0.1470	**0.1481**	0.1496
	–	36	3.80	**3.86**	3.90	0.1496	**0.1518**	0.1535	3.80	**3.84**	3.90	0.1496	**0.1507**	0.1535	3.80	**3.80**	3.80	0.1496	**0.1498**	0.1535
#10	24	–	4.30	**4.36**	4.37	0.1693	**0.1716**	0.1719	4.30	**4.34**	4.37	0.1693	**0.1700**	0.1719	4.22	**4.29**	4.30	0.1660	**0.1688**	0.1693
	–	32	4.40	**4.48**	4.50	0.1732	**0.1762**	0.1772	4.40	**4.46**	4.50	0.1732	**0.1750**	0.1772	4.40	**4.42**	4.50	0.1732	**0.1741**	0.1772
#12	24	–	5.00	**5.02**	5.10	0.1969	**0.1976**	0.2008	5.00	**5.00**	5.00	0.1929	**0.1960**	0.1969	4.90	**4.95**	5.00	0.1929	**0.1948**	0.1969
	–	28	5.00	**5.09**	5.10	0.1969	**0.2002**	0.2008	5.00	**5.07**	5.10	0.1969	**0.1990**	0.2008	5.00	**5.02**	5.10	0.1969	**0.1978**	0.2008
1/4	20	–	5.70	**5.79**	5.80	0.2244	**0.2279**	0.2283	5.70	**5.76**	5.80	0.2244	**0.2260**	0.2283	5.70	**5.70**	5.70	0.2244	**0.2245**	0.2283
	–	28	5.95	**5.95**	5.95	0.2323	**0.2342**	0.2344	5.90	**5.94**	5.95	0.2323	**0.2329**	0.2344	5.80	**5.89**	5.90	0.2283	**0.2318**	0.2323
5/16	18	–	7.30	**7.31**	7.40	0.2874	**0.2879**	0.2913	7.30	**7.30**	7.30	0.2835	**0.2861**	0.2874	7.20	**7.22**	7.30	0.2835	**0.2842**	0.2874
	–	24	7.40	**7.47**	7.50	0.2913	**0.2941**	0.2953	7.40	**7.46**	7.50	0.2913	**0.2927**	0.2953	7.40	**7.40**	7.40	0.2874	**0.2912**	0.2913
3/8	16	–	8.80	**8.82**	8.90	0.3465	**0.3474**	0.3504	8.80	**8.80**	8.80	0.3438	**0.3452**	0.3465	8.70	**8.71**	8.73	0.3425	**0.3431**	0.3438
	–	24	9.00	**9.06**	9.10	0.3543	**0.3566**	0.3583	9.00	**9.06**	9.10	0.3543	**0.3552**	0.3583	8.90	**8.98**	9.00	0.3504	**0.3537**	0.3543
7/16	14	–	10.30	**10.31**	10.32	0.4055	**0.4059**	0.4063	10.20	**10.29**	10.30	0.4016	**0.4035**	0.4055	10.10	**10.19**	10.20	0.3976	**0.4011**	0.4016
	–	20	10.50	**10.55**	10.60	0.4134	**0.4154**	0.4173	10.50	**10.55**	10.60	0.4134	**0.4137**	0.4173	10.40	**10.46**	10.50	0.4094	**0.4120**	0.4134
1/2	13	–	11.80	**11.84**	11.90	0.4646	**0.4660**	0.4685	11.80	**11.82**	11.90	0.4606	**0.4634**	0.4646	11.70	**11.70**	11.70	0.4606	**0.4608**	0.4646
	–	20	12.10	**12.14**	12.20	0.4764	**0.4779**	0.4803	12.10	**12.14**	12.20	0.4724	**0.4762**	0.4764	12.00	**12.05**	12.10	0.4724	**0.4745**	0.4764
9/16	12	–	13.10	**13.35**	13.50	0.5157	**0.5257**	0.5315	13.10	**13.33**	13.50	0.5157	**0.5229**	0.5315	13.10	**13.21**	13.50	0.5157	**0.5200**	0.5315
	–	18	13.50	**13.66**	13.80	0.5315	**0.5379**	0.5433	13.50	**13.67**	13.80	0.5315	**0.5361**	0.5433	13.50	**13.57**	13.80	0.5315	**0.5342**	0.5433
5/8	11	–	14.50	**14.85**	15.00	0.5709	**0.5848**	0.5906	14.50	**14.83**	15.00	0.5709	**0.5817**	0.5906	14.50	**14.70**	15.00	0.5709	**0.5787**	0.5906
	–	18	15.10	**15.25**	15.50	0.5945	**0.6004**	0.6102	15.10	**15.26**	15.50	0.5945	**0.5986**	0.6102	15.10	**15.16**	15.50	0.5945	**0.5967**	0.6102
3/4	10	–	17.50	**17.93**	18.00	0.6890	**0.7058**	0.7087	17.50	**17.91**	18.00	0.6890	**0.7024**	0.7087	17.50	**17.75**	18.00	0.6890	**0.6990**	0.7087
	–	16	18.00	**18.35**	18.50	0.7087	**0.7224**	0.7283	18.00	**18.37**	18.50	0.7087	**0.7202**	0.7283	18.00	**18.24**	18.50	0.7087	**0.7181**	0.7283
7/8	9	–	20.50	**20.98**	21.00	0.8071	**0.8259**	0.8268	20.50	**20.96**	21.00	0.8071	**0.8221**	0.8268	20.50	**20.78**	21.00	0.8071	**0.8183**	0.8268
	–	14	21.33	**21.42**	21.43	0.8398	**0.8434**	0.8440	21.43	**21.45**	21.50	0.8398	**0.8410**	0.8440	21.15	**21.30**	21.33	0.8327	**0.8386**	0.8398
1	8	–	24.00	**24.00**	24.00	0.9380	**0.9448**	0.9449	23.81	**23.98**	24.00	0.9380	**0.9405**	0.9449	23.50	**23.78**	23.81	0.9252	**0.9363**	0.9375
	–	12	24.30	**24.47**	24.50	0.9567	**0.9632**	0.9646	24.30	**24.49**	24.50	0.9567	**0.9603**	0.9646	24.30	**24.32**	24.50	0.9567	**0.9575**	0.9646

Thread Forming • M and MF

tap size	pitch M	pitch MF	65% thread Metric smallest drill	65% thread Metric theoretical	65% thread Metric largest drill	65% thread Inch smallest drill	65% thread Inch theoretical	65% thread Inch largest drill	70% thread Metric smallest drill	70% thread Metric theoretical	70% thread Metric largest drill	70% thread Inch smallest drill	70% thread Inch theoretical	70% thread Inch largest drill	75% thread Metric smallest drill	75% thread Metric theoretical	75% thread Metric largest drill	75% thread Inch smallest drill	75% thread Inch theoretical	75% thread Inch largest drill
M1.6	0.35	–	1.40	**1.45**	1.50	0.0551	**0.0571**	0.0591	1.40	**1.43**	1.50	0.0551	**0.0563**	0.0591	1.40	**1.42**	1.50	0.0551	**0.0559**	0.0591
M1.7	0.35	–	1.50	**1.58**	1.60	0.0591	**0.0623**	0.0630	1.50	**1.57**	1.60	0.0591	**0.0620**	0.0630	1.50	**1.56**	1.60	0.0591	**0.0617**	0.0630
M1.8	0.35	–	1.60	**1.65**	1.70	0.0630	**0.0650**	0.0669	1.60	**1.63**	1.70	0.0630	**0.0642**	0.0669	1.60	**1.62**	1.70	0.0630	**0.0638**	0.0669
M2	0.4	–	1.80	**1.82**	1.90	0.0709	**0.0717**	0.0748	1.80	**1.81**	1.90	0.0709	**0.0713**	0.0748	1.80	**1.80**	1.80	0.0709	**0.0709**	0.0709
M2.2	0.45	–	2.00	**2.00**	2.00	0.0787	**0.0787**	0.0787	1.98	**1.99**	2.00	0.0781	**0.0783**	0.0787	1.90	**1.97**	1.98	0.0748	**0.0776**	0.0781
M2.5	0.45	–	2.30	**2.30**	2.30	0.0906	**0.0906**	0.0906	2.20	**2.29**	2.30	0.0866	**0.0902**	0.0906	2.20	**2.27**	2.30	0.0866	**0.0894**	0.0906
M2.6	0.45	–	2.40	**2.43**	2.44	0.0945	**0.0957**	0.0960	2.40	**2.42**	2.44	0.0945	**0.0953**	0.0960	2.40	**2.41**	2.44	0.0945	**0.0949**	0.0960
M3	0.5	–	2.78	**2.78**	2.80	0.1094	**0.1094**	0.1094	2.71	**2.76**	2.78	0.1065	**0.1087**	0.1094	2.71	**2.75**	2.78	0.1065	**0.1083**	0.1094
	–	0.35	2.87	**2.88**	2.90	0.1130	**0.1134**	0.1142	2.87	**2.87**	2.87	0.1130	**0.1130**	0.1130	2.82	**2.86**	2.87	0.1110	**0.1126**	0.1130
M3.5	0.6	–	3.20	**3.23**	3.26	0.1260	**0.1272**	0.1285	3.20	**3.21**	3.26	0.1260	**0.1264**	0.1285	3.18	**3.19**	3.20	0.1250	**0.1256**	0.1260
M4	0.7	–	3.66	**3.69**	3.70	0.1440	**0.1453**	0.1457	3.66	**3.67**	3.70	0.1440	**0.1445**	0.1457	3.60	**3.64**	3.66	0.1417	**0.1433**	0.1440
	–	0.5	3.73	**3.78**	3.80	0.1470	**0.1488**	0.1496	3.73	**3.76**	3.80	0.1470	**0.1480**	0.1496	3.73	**3.75**	3.80	0.1470	**0.1476**	0.1496
M4.5	0.75	–	4.10	**4.17**	4.20	0.1614	**0.1642**	0.1654	4.10	**4.14**	4.20	0.1614	**0.1630**	0.1654	4.10	**4.12**	4.20	0.1614	**0.1622**	0.1654
M5	0.8	–	4.62	**4.65**	4.70	0.1820	**0.1831**	0.1850	4.60	**4.62**	4.62	0.1811	**0.1819**	0.1820	4.50	**4.59**	4.60	0.1772	**0.1807**	0.1811
	–	0.5	4.76	**4.78**	4.80	0.1875	**0.1882**	0.1890	4.70	**4.76**	4.76	0.1850	**0.1874**	0.1875	4.70	**4.75**	4.76	0.1850	**0.1870**	0.1875
M6	1	–	5.56	**5.56**	5.60	0.2188	**0.2189**	0.2205	5.50	**5.52**	5.56	0.2165	**0.2173**	0.2188	5.41	**5.49**	5.50	0.2130	**0.2161**	0.2165
	–	0.75	5.62	**5.67**	5.70	0.2211	**0.2232**	0.2244	5.62	**5.64**	5.70	0.2211	**0.2220**	0.2244	5.62	**5.62**	5.70	0.2211	**0.2213**	0.2244
M7	1	–	6.53	**6.56**	6.60	0.2570	**0.2583**	0.2598	6.50	**6.52**	6.53	0.2559	**0.2567**	0.2570	6.40	**6.49**	6.50	0.2520	**0.2555**	0.2559
M8	1.25	–	7.40	**7.45**	7.50	0.2913	**0.2933**	0.2953	7.40	**7.41**	7.50	0.2913	**0.2917**	0.2953	7.30	**7.36**	7.40	0.2874	**0.2898**	0.2913
	–	1	7.54	**7.56**	7.60	0.2969	**0.2976**	0.2992	7.50	**7.52**	7.54	0.2953	**0.2961**	0.2969	7.40	**7.49**	7.50	0.2913	**0.2949**	0.2953
	–	0.75	7.60	**7.67**	7.70	0.2992	**0.3020**	0.3031	7.60	**7.64**	7.70	0.2992	**0.3008**	0.3031	7.60	**7.62**	7.70	0.2992	**0.3000**	0.3031
M10	1.5	–	9.30	**9.34**	9.35	0.3661	**0.3677**	0.3680	9.20	**9.29**	9.30	0.3622	**0.3657**	0.3661	9.20	**9.24**	9.30	0.3622	**0.3638**	0.3661
	–	1.25	9.40	**9.45**	9.50	0.3701	**0.3720**	0.3740	9.40	**9.41**	9.50	0.3701	**0.3705**	0.3740	9.35	**9.36**	9.40	0.3680	**0.3685**	0.3701
	–	1	9.53	**9.56**	9.60	0.3750	**0.3764**	0.3780	9.50	**9.52**	9.53	0.3740	**0.3748**	0.3750	9.40	**9.49**	9.50	0.3701	**0.3736**	0.3740
	–	0.75	9.60	**9.67**	9.70	0.3780	**0.3807**	0.3819	9.60	**9.64**	9.70	0.3780	**0.3795**	0.3819	9.60	**9.62**	9.70	0.3780	**0.3787**	0.3819
M12	1.75	–	11.20	**11.23**	11.30	0.4409	**0.4421**	0.4449	11.15	**11.17**	11.20	0.4375	**0.4398**	0.4409	11.10	**11.11**	11.15	0.4370	**0.4374**	0.4375
	–	1.5	11.30	**11.34**	11.40	0.4449	**0.4465**	0.4488	11.20	**11.29**	11.30	0.4449	**0.4484**	0.4488	11.20	**11.24**	11.30	0.4409	**0.4425**	0.4449
	–	1.25	11.40	**11.45**	11.50	0.4488	**0.4508**	0.4528	11.40	**11.41**	11.50	0.4488	**0.4492**	0.4528	11.30	**11.36**	11.40	0.4449	**0.4472**	0.4488
	–	1	11.51	**11.56**	11.60	0.4531	**0.4551**	0.4567	11.51	**11.52**	11.60	0.4531	**0.4535**	0.4567	11.40	**11.49**	11.50	0.4488	**0.4524**	0.4528
M14	2	–	13.10	**13.12**	13.50	0.5157	**0.5165**	0.5315	13.00	**13.05**	13.10	0.5118	**0.5138**	0.5157	12.80	**12.98**	13.00	0.5039	**0.5110**	0.5118
	–	1.5	13.10	**13.34**	13.50	0.5157	**0.5252**	0.5315	13.10	**13.29**	13.50	0.5157	**0.5232**	0.5315	13.10	**13.24**	13.50	0.5157	**0.5213**	0.5315
M16	2	–	15.10	**15.12**	15.50	0.5945	**0.5953**	0.6102	15.00	**15.05**	15.10	0.5906	**0.5925**	0.5945	14.50	**14.98**	15.00	0.5709	**0.5898**	0.5906
	–	1.5	15.10	**15.34**	15.50	0.5945	**0.6039**	0.6102	15.10	**15.29**	15.50	0.5945	**0.6020**	0.6102	15.10	**15.24**	15.50	0.5945	**0.6000**	0.6102
M18	2.5	–	16.50	**16.90**	17.00	0.6496	**0.6654**	0.6693	16.50	**16.81**	17.00	0.6496	**0.6618**	0.6693	16.50	**16.73**	17.00	0.6496	**0.6587**	0.6693
	–	1.5	17.00	**17.34**	17.50	0.6693	**0.6827**	0.6890	17.00	**17.29**	17.50	0.6693	**0.6807**	0.6890	17.00	**17.24**	17.50	0.6693	**0.6787**	0.6890
M20	2.5	–	18.50	**18.90**	19.00	0.7283	**0.7441**	0.7480	18.50	**18.81**	19.00	0.7283	**0.7406**	0.7480	18.50	**18.73**	19.00	0.7283	**0.7374**	0.7480
	–	1.5	19.00	**19.34**	19.50	0.7480	**0.7614**	0.7677	19.00	**19.29**	19.50	0.7480	**0.7594**	0.7677	19.00	**19.24**	19.50	0.7480	**0.7575**	0.7677
	–	1	19.50	**19.56**	20.00	0.7677	**0.7701**	0.7874	19.50	**19.52**	20.00	0.7677	**0.7685**	0.7874	19.00	**19.49**	19.50	0.7480	**0.7673**	0.7677
M22	2.5	–	20.50	**20.90**	21.00	0.8071	**0.8228**	0.8268	20.50	**20.81**	21.00	0.8071	**0.8193**	0.8268	20.50	**20.73**	21.00	0.8071	**0.8161**	0.8268
	–	2	21.00	**21.12**	21.15	0.8268	**0.8315**	0.8327	21.00	**21.05**	21.15	0.8268	**0.8287**	0.8327	20.50	**20.98**	21.00	0.8071	**0.8260**	0.8268
	–	1.5	21.33	**21.34**	21.43	0.8398	**0.8402**	0.8440	21.15	**21.29**	21.33	0.8327	**0.8382**	0.8398	21.15	**21.24**	21.33	0.8327	**0.8362**	0.8398
M24	3	–	22.50	**22.67**	22.77	0.8858	**0.8925**	0.8965	22.50	**22.57**	22.77	0.8858	**0.8886**	0.8965	22.44	**22.47**	22.50	0.8840	**0.8846**	0.8858
	–	2	23.10	**23.12**	23.30	0.9094	**0.9102**	0.9173	23.00	**23.05**	23.10	0.9055	**0.9075**	0.9094	22.77	**22.98**	23.00	0.8965	**0.9047**	0.9055
	–	1.5	23.30	**23.34**	23.42	0.9173	**0.9189**	0.9220	23.10	**23.29**	23.30	0.9094	**0.9169**	0.9173	23.10	**23.24**	23.30	0.9094	**0.9150**	0.9173

Pipe Taps

pipe tap size	NPT and NPTF		NPSM	NPSC	NPSF
	without reamer	with reamer			
1/16-27	0.2420	0.2344	—	0.2500	0.2460
1/8-27	0.3320	0.3281	0.3580	0.3320	0.3390
1/4-18	0.4375	0.4219	0.4688	0.4375	0.4375
3/8-18	0.5625	0.5625	0.6030	0.5781	0.5781
1/2-14	0.7031	0.6875	0.7480	0.7087	0.7087
3/4-14	0.9063	0.8906	0.9531	0.9219	0.9219
1-11 1/2	1.1406	1.1250	1.2031	1.1563	1.1563
1 1/4-11 1/2	1.4844	1.4688	1.5460	1.5000	—
1 1/2-11 1/2	1.7188	1.7031	1.7813	1.7344	—
2-11 1/2	2.1875	2.1719	2.2500	2.2031	—

Through Holes Push Chips



Spiral Point



LHSF



- Spiral point or LHSF (Left-Hand Spiral Flute).
- Ideal for materials with long chips.

Blind Holes Pull Chips



RHSF



- RHSF (Right-Hand Spiral Flute).
- Ideal for materials with long chips.

Blind or Through Holes Store Chips



STFL



- STFL (Straight Flute).
- Ideal for materials with short chips.

Blind or Through Holes No Chips



Forming Tap



- Forming.
- Ideal for ductile materials <32 HRC.

Unified Inch Screw Threads

thread size/pitch	recommended tap limits[1] class 2B	recommended tap limits[1] class 3B	internal thread pitch diameter limits min all classes (Basic)	internal thread pitch diameter limits max class 2B	internal thread pitch diameter limits max class 3B
0 - 80	H2	H2	0.0519	0.0542	0.0536
1 - 64	H2	H2	0.0629	0.0655	0.0648
1 - 72	H2	H2	0.0640	0.0665	0.0659
2 - 56	H2	H2	0.0744	0.0772	0.0765
2 - 64	H2	H2	0.0759	0.0786	0.0779
3 - 48	H3	H2	0.0855	0.0885	0.0877
3 - 56	H2	H2	0.0874	0.0902	0.0895
4 - 40	H3	H2	0.0958	0.0991	0.0982
4 - 48	H3	H2	0.0985	0.1016	0.1008
5 - 40	H3	H2	0.1088	0.1121	0.1113
5 - 44	H3	H2	0.1102	0.1134	0.1126
6 - 32	H3	H2	0.1177	0.1214	0.1204
6 - 40	H3	H2	0.1218	0.1252	0.1243
8 - 32	H3	H3	0.1437	0.1475	0.1465
8 - 36	H3	H3	0.1460	0.1496	0.1487
10 - 24	H3	H3	0.1629	0.1672	0.1661
10 - 32	H3	H3	0.1697	0.1736	0.1726
12 - 24	H3	H3	0.1889	0.1933	0.1922
12 - 28	H3	H3	0.1928	0.1970	0.1959
1/4 - 20	H5	H3	0.2175	0.2224	0.2211
1/4 - 28	H4	H3	0.2268	0.2311	0.2300
5/16 - 18	H5	H3	0.2764	0.2817	0.2803
5/16 - 24	H4	H3	0.2854	0.2902	0.2890
3/8 - 16	H5	H3	0.3344	0.3401	0.3387
3/8 - 24	H4	H3	0.3479	0.3528	0.3516
7/16 - 14	H5	H3	0.3911	0.3972	0.3957
7/16 - 20	H5	H3	0.4050	0.4104	0.4091
1/2 - 13	H5	H4	0.4500	0.4565	0.4548
1/2 - 20	H5	H3	0.4675	0.4731	0.4717
9/16 - 12	H5	H4	0.5084	0.5152	0.5135
9/16 - 18	H5	H3	0.5264	0.5323	0.5308
5/8 - 11	H5	H4	0.5660	0.5732	0.5714
5/8 - 18	H5	H3	0.5889	0.5949	0.5934
3/4 - 10	H5	H4	0.6850	0.6927	0.6907

(continued)

[1]Tap H limit selected for 3B will also produce thread to 2B.

NOTE: The above recommended taps normally produce the class of thread indicated in average materials when used with reasonable care. However, if the specified tap does not provide a satisfactory gage fit, choose an alternate tap limit.

Unified Inch Screw Threads *(continued)*

thread size/pitch	recommended tap limits[1] class 2B	recommended tap limits[1] class 3B	internal thread pitch diameter limits min all classes (Basic)	internal thread pitch diameter limits max class 2B	internal thread pitch diameter limits max class 3B
3/4 - 16	H5	H4	0.7094	0.7159	0.7143
7/8 - 9	H6	H4	0.8028	0.8110	0.8089
7/8 - 14	H6	H4	0.8286	0.8356	0.8339
1" - 8	H6	H5	0.9188	0.9276	0.9254
1" - 12	H6	H4	0.9459	0.9535	0.9516
1-1/8 - 7	H8	H6	1.0322	1.0416	1.0393
1-1/8 - 8	H8	H6	1.0438	1.0528	1.0505
1-1/8 - 12	H6	H5	1.0709	1.0787	1.0768
1-1/4 - 7	H8	H6	1.1572	1.1668	1.1644
1-1/4 - 8	H8	H6	1.1688	1.1780	1.1757
1-1/4 - 12	H6	H5	1.1959	1.2039	1.2019
1-3/8 - 6	H8	H6	1.2667	1.2771	1.2745
1-3/8 - 8	H8	H6	1.2938	1.3031	1.3008
1-3/8 - 12	H6	H5	1.3209	1.3291	1.3270
1-1/2 - 6	H8	H6	1.3917	1.4022	1.3996
1-1/2 - 8	H8	H6	1.4188	1.4283	1.4259
1-1/2 - 12	H6	H5	1.4459	1.4542	1.4522
1-3/4 - 5	H8	H7	1.6201	1.6317	1.6288
2 - 4 1/2	H8	H7	1.8557	1.8681	1.8650

[1]Tap H limit selected for 3B will also produce thread to 2B.

Tap Recommendations for Class 6H Metric Screw Threads

thread size nominal diameter (mm)	thread size pitch (mm)	recommended tap limit number	internal thread product limits — class 6H pitch diameter (mm) min	pitch diameter (mm) max	pitch diameter (in) min	pitch diameter (in) max
1,6	0,35	D3	1,373	1,458	.05406	.05740
2	0,4	D3	1,740	1,830	.06850	.07205
2,5	0,45	D3	2,208	2,303	.08693	.09067
3	0,5	D3	2,675	2,775	.10531	.10925
3,5	0,6	D4	3,110	3,222	.12244	.12685
4	0,7	D4	3,545	3,663	.13957	.14421
4,5	0,75	D4	4,013	4,131	.15789	.16264
5	0,8	D4	4,480	4,605	.17638	.18130
6	1	D5	5,350	5,500	.21063	.21654
7	1	D5	6,350	6,500	.25000	.25591
8	1,25	D5	7,188	7,348	.28299	.28929
10	1,5	D6	9,026	9,206	.35535	.36244
12	1,75	D6	10,863	11,063	.42768	.43555
14	2	D7	12,701	12,913	.50004	.50839
16	2	D7	14,701	14,913	.57878	.58713
20	2,5	D7	18,376	18,600	.72346	.73228
24	3	D8	22,051	22,316	.86815	.87858
30	3,5	D9	27,727	28,007	1.09161	1.10264
36	4	D9	33,402	33,702	1.31504	1.32685

In addition to the nominal size and pitch of a tap, there is another important dimensional factor to be considered when selecting a ground thread tap for a given job. This factor is the pitch diameter tap limit, "H" and "L". "H" represents (high) above basic pitch diameter; "L" (low) is below basic pitch diameter. Tap limits have been established to provide a choice in the selection of the tap size best suited to produce the class of thread desired.

Figure 1 Illustrates the numbering system and the .0005" diameter increment separation between successive limits. Because the starting point is basic pitch diameter, dividing the limit number by two establishes, in thousandths of an inch, the amount the maximum tap pitch diameter is above basic in the "H" series and the amount the minimum tap pitch diameter is under basic in the "L" series.

Figure 2 Illustrates the positioning of the tap limits in relation to the various classes of threads for a 1/4–20 size.

Figure 1

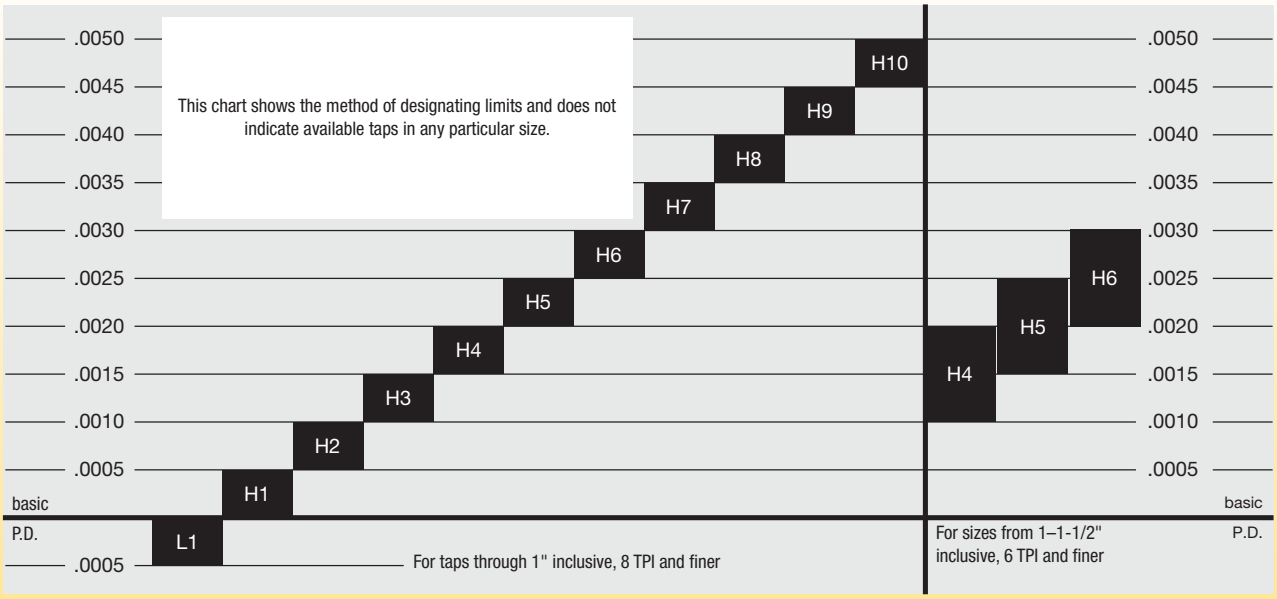
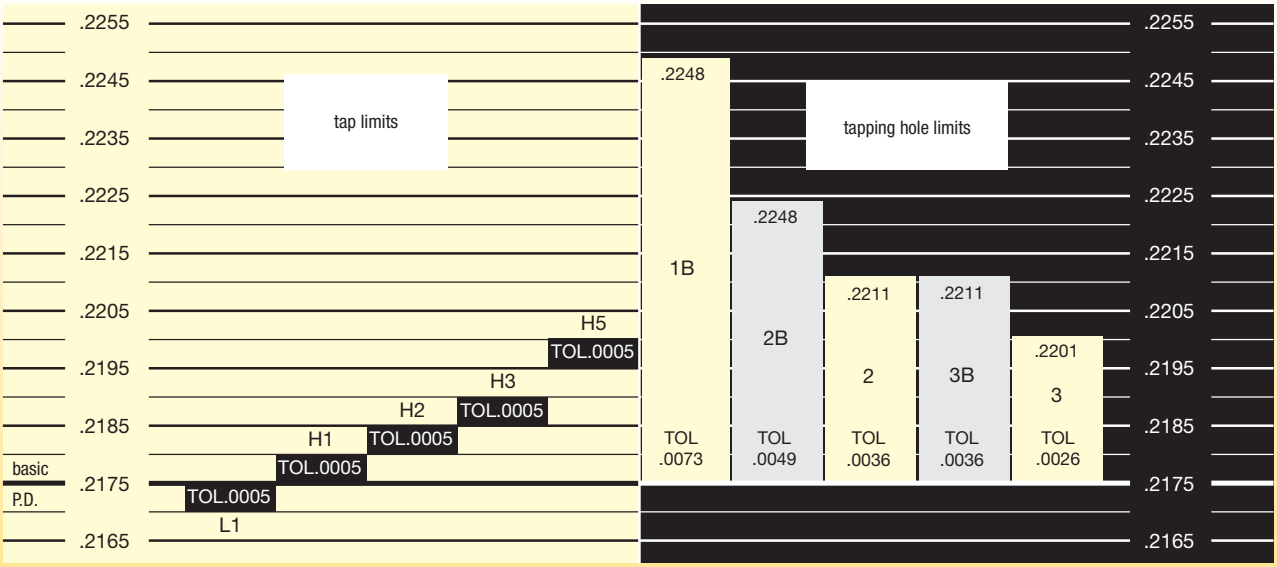
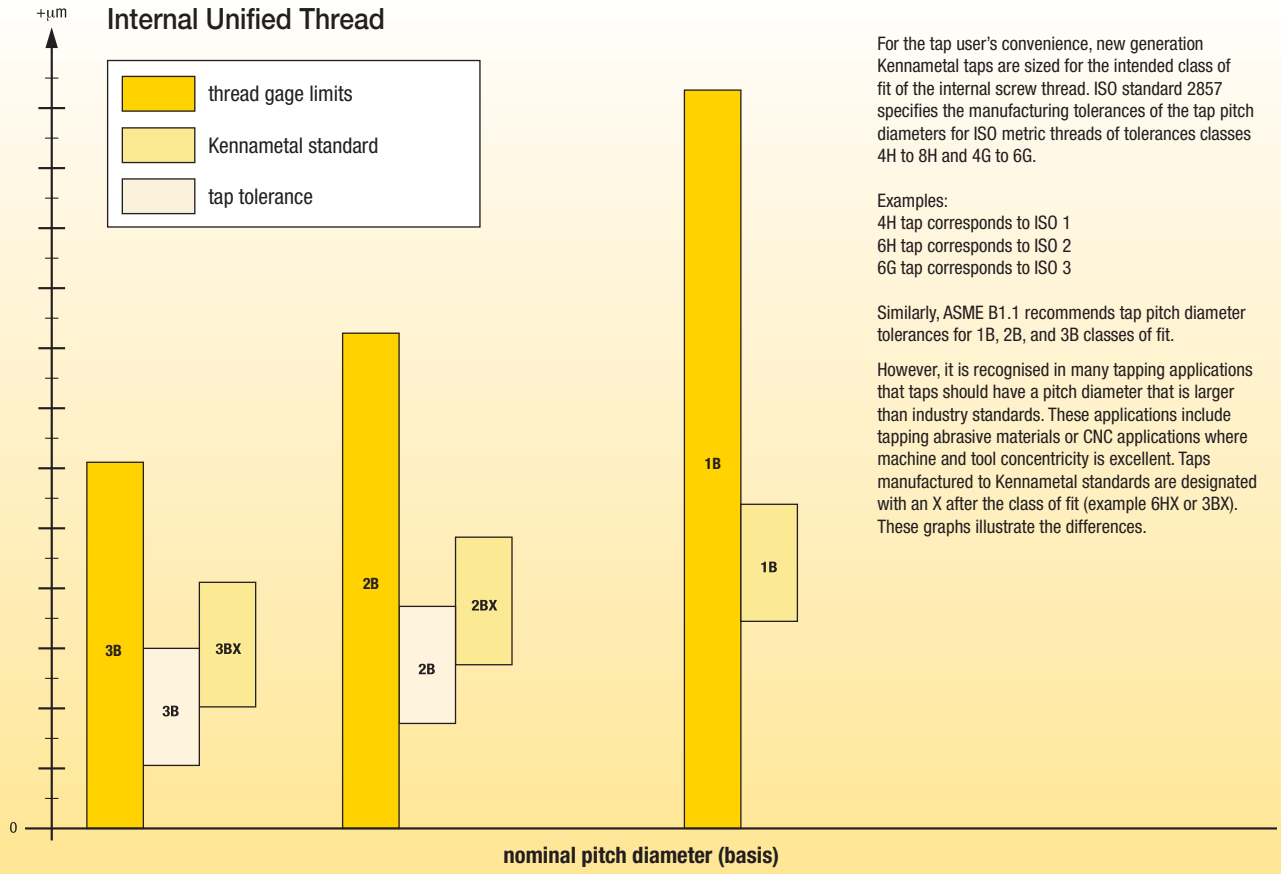


Figure 2

Class of Thread – 1/4–20 UNC and NC



Internal Unified Thread



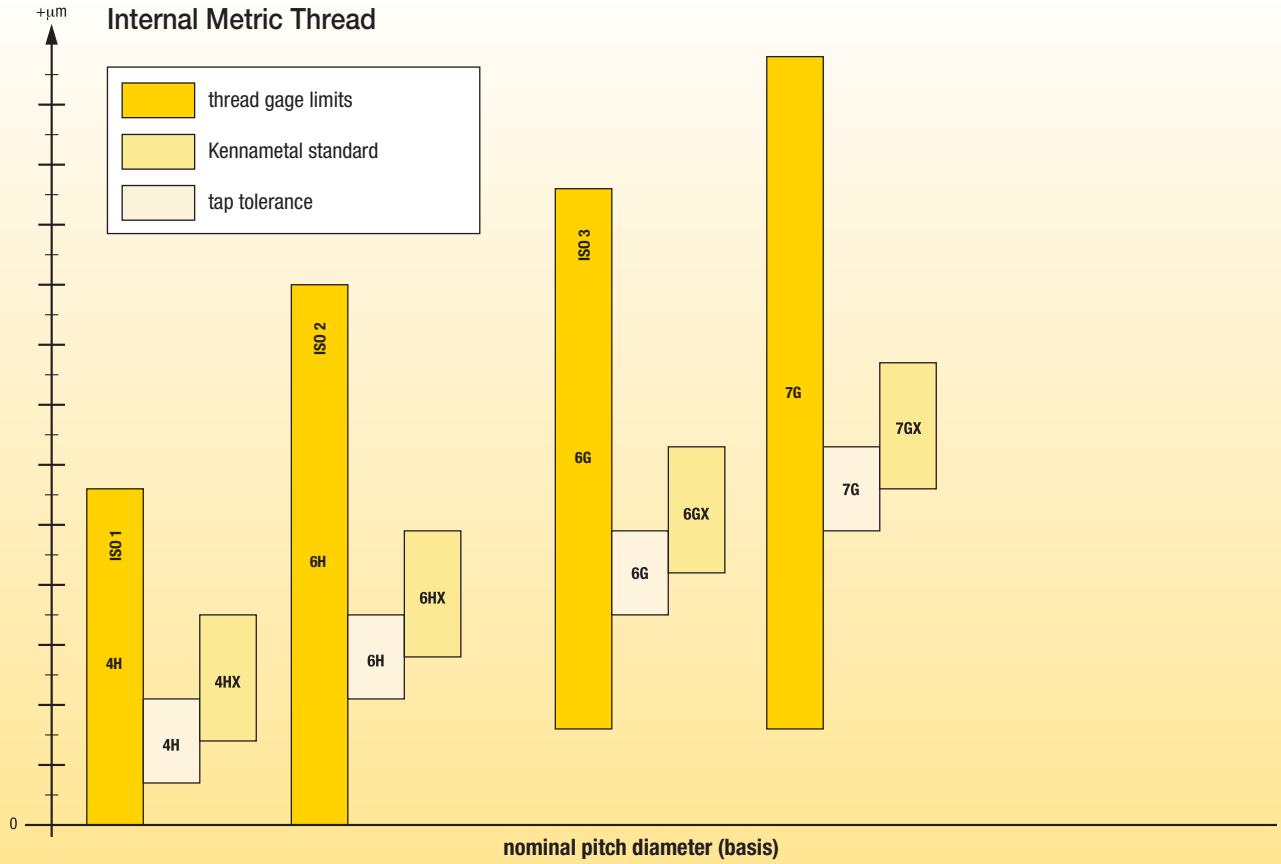
For the tap user's convenience, new generation Kennametal taps are sized for the intended class of fit of the internal screw thread. ISO standard 2857 specifies the manufacturing tolerances of the tap pitch diameters for ISO metric threads of tolerances classes 4H to 8H and 4G to 6G.

Examples:
4H tap corresponds to ISO 1
6H tap corresponds to ISO 2
6G tap corresponds to ISO 3

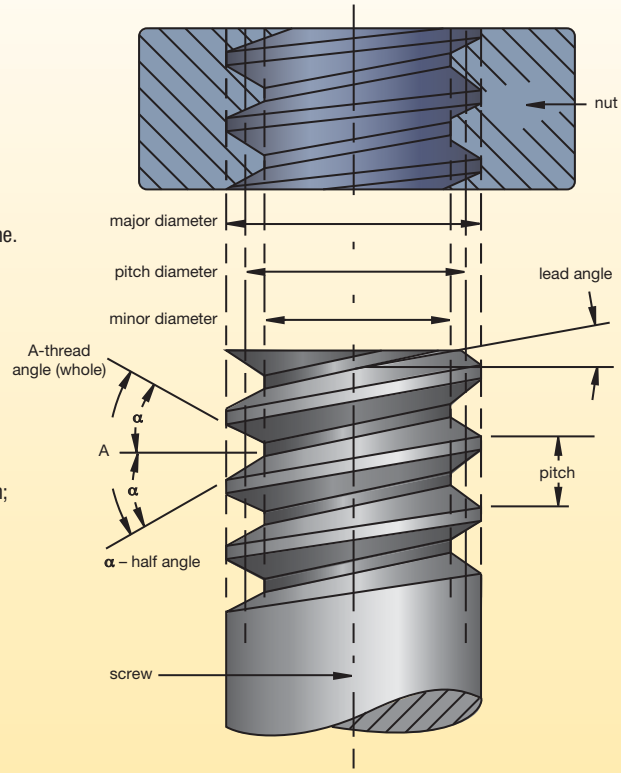
Similarly, ASME B1.1 recommends tap pitch diameter tolerances for 1B, 2B, and 3B classes of fit.

However, it is recognised in many tapping applications that taps should have a pitch diameter that is larger than industry standards. These applications include tapping abrasive materials or CNC applications where machine and tool concentricity is excellent. Taps manufactured to Kennametal standards are designated with an X after the class of fit (example 6HX or 3BX). These graphs illustrate the differences.

Internal Metric Thread



It is generally recognised that, in mass production, it is impossible to reproduce in exact detail the theoretically perfect product as laid out on the drawing board. The allowed slight variation between the theoretically perfect product drawing and each unit of the actual product is called the tolerance.



Allowance

An intentional difference in correlated dimensions of mating parts. It is the minimum clearance or maximum interference between such parts.

Angle of Thread

The angle included between the flanks of the thread measured in an axial plane.

Half Angle of Thread

The angle included between a flank of the thread and the normal (90°) to the axis, measured in an axial plane.

Lead of Thread

The distance a screw thread advances axially in one turn. On a single-thread screw, the lead and pitch are identical. On a double thread, the lead is 2x pitch; on a triple thread, the lead is 3x pitch, etc.

Major Diameter

The largest diameter of a straight-screw thread.

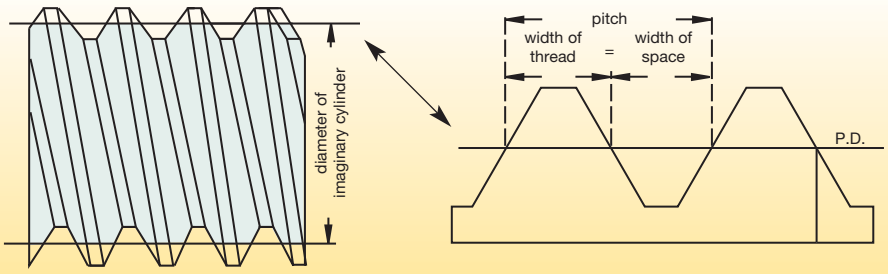
Minor Diameter

The smallest diameter of a straight-screw thread.

Pitch

The distance from a point on a screw thread to a corresponding point on the next thread measured parallel to the axis.

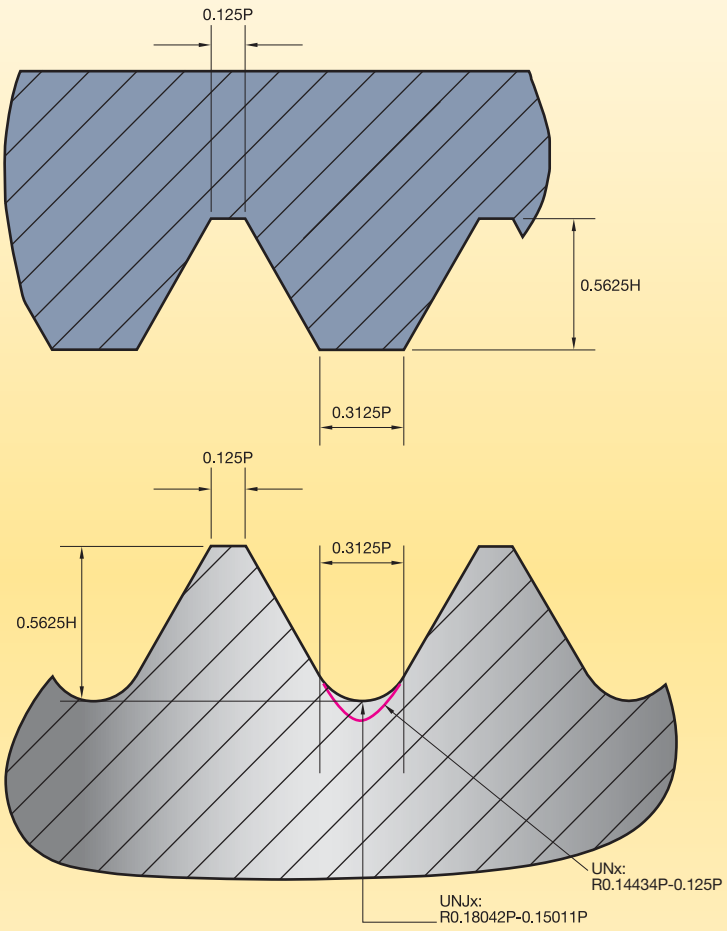
The pitch in inches = $\frac{1}{\text{number of threads per inch}}$



Pitch Diameter

On a straight-screw thread, the diameter of an imaginary cylinder that would pass through the threads at such points as to make equal the width of the threads and the width of the spaces cut by the surface of the cylinder.

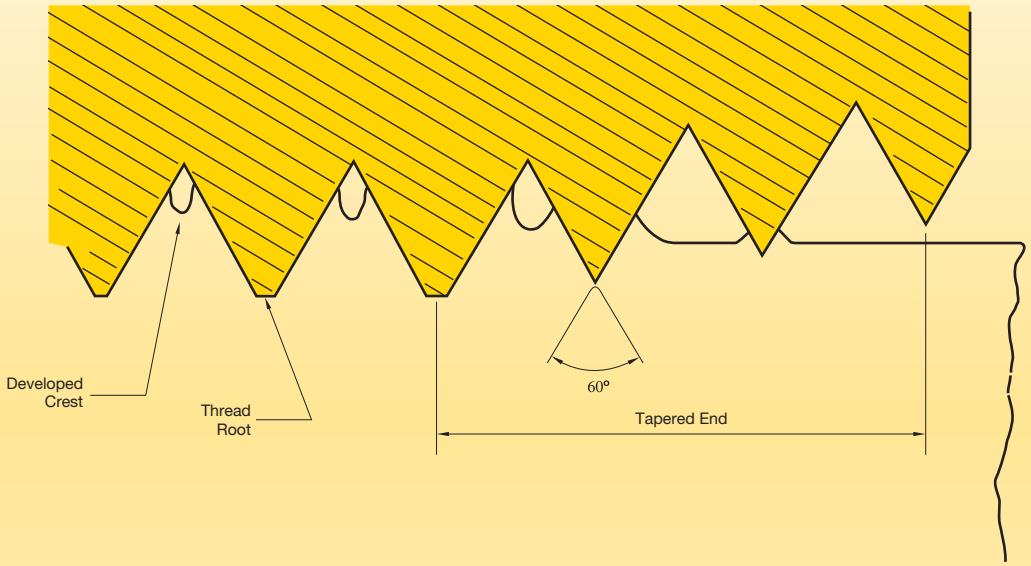
A thread system is available for aerospace and other applications where high fatigue strength is required. The UNJ thread form is defined by ASME B1.15 and is similar to Military Specification MIL-S-8879. Screw thread assemblies consist of external and internal threads. In order to minimise the stress on the external UNJ thread, a controlled root radius is required that is equal to 0.15011P to 0.18042P, where P is the thread pitch. Internal UNJ threads are not required to have a radius at either the major or minor diameters.



Because external UNJ threads must be produced with a defined root radius, standard UN tooling may not be used. However, internal UNF threads may be produced with ground thread UN taps sized to produce the proper class of fit. The tap does not need to be marked with a letter J. Attention must be paid to the tap drill since the minor diameter has to be specified so as to provide clearance with the root radius on the external thread.

For UNJ thread specifications, the reader is referred to ASME B1.15. Please note this standard includes Class 3 and Class 2 UNJ screw threads. However, only Class 3 UNJ threads meet the requirements of Military Specification MIL-S-8879. For Unified Inch (UN) thread specifications, refer to ASME B1.1.

Unlike cutting taps, which remove material, forming taps generate an internal screw thread by displacing material and forming it into the V-shaped thread. A common misconception is that a thread rolling action occurs. Instead, the threads are formed over the tapered entry section of the tap as the tap rotates into the hole. A succession of deeper penetrating lobes over the entry plastically displaces material radially between the tap's thread flanks until the entry length is reached. At this point, the thread is fully formed at the correct thread height.



Forming taps have numerous advantages over cutting taps. The most obvious advantage is that forming taps do not create chips. There are no chip removal problems. Bird nesting is a situation that occurs when chips wrap around the shank of spiral-fluted taps when tapping blind holes in long chipping materials. Forming taps help this to be avoided. Since forming taps avoid this problem, they are stronger and more resistant to breakage. Another misconception is that forming taps produce stronger threads. Although the forming process strain hardens the thread flanks, it has very little effect on the major diameter, the location where internal threads strip.

Forming taps can only be used in ductile materials. Due to increased friction relative to cutting, forming taps require higher torque than cutting taps. In some situations, oil-based lubrications are required, and this might not be convenient on CNC machining centres that use water soluble coolant. In this situation, the lubricant concentration should be increased.

Since forming taps displace material, larger diameter pre-tap holes are required. This is especially important when converting from cutting taps to forming taps. If a cutting tap hole size is used, the displaced material will over-fill the tap's threads and breakage will result. Please consult hole size charts for forming taps.

coating	properties and application	precautions
Titanium Nitride (TiN)	Proprietary TiN coating (hardness 2300 Vickers) offers significantly improved wear life and thread finish, often at higher tapping speeds, in a broad range of materials, especially steels, irons, and plastics. Golden colour.	Use with caution in non-ferrous materials such as aluminium because of tendency to gall.
Titanium Carbonitride (TiCN)	Proprietary TiCN coating (hardness 3000 Vickers) is harder, tougher, and more wear resistant than TiN under conditions of moderate cutting temperatures. Like TiN, TiCN may be used at higher cutting speeds in a broad range of materials, especially steels and irons. Blue-grey colour.	Use with caution in non-ferrous materials such as aluminium because of tendency to gall. TiAlN is a better choice when used at extreme temperatures.
Titanium Nitride + Chromium Carbide Carbon (TiN + CrC/C)	Proprietary coating (hardness 2300 Vickers) that combines the wear resistance of smooth TiN coating with a lubricous top layer of chromium carbide carbon. Effective in stainless steel and non-ferrous materials including aluminium and titanium. Ideal choice for 300 series stainless steels, wrought, and die cast aluminiums. Black/grey colour.	Effective in both ferrous and non-ferrous materials.
Titanium Aluminium Nitride (TiAlN)	Nanolayer TiAlN coating (hardness 3300 Vickers) offers improved wear life and thread finish, especially in conditions where high temperatures can be generated. Use for PH stainless steels and nickel-based alloys like INCONEL®. Violet/grey colour.	Use with caution in non-ferrous materials because of tendency to gall.
Chromium Nitride (CrN)	CrN is medium hard (hardness 1800 Vickers) and has a lower wear resistance than TiN, TiCN, and TiAlN. However, unlike these coatings, CrN does not gall when used in some non-ferrous work materials. Use for brass, bronze, zinc alloys, and magnesium alloys. Silver colour.	Ineffective in ferrous materials.
Nitride	Hardened case extends wear life in abrasive materials. Use for aluminium and other non-ferrous materials.	Avoid on taper pipe, fast spiral, and small diameter (<#6) or fine pitch taps due to tendency for thread chipping.
Oxide	Helps prevent galling in ferrous (iron-based) materials. For free machining steel. Use for steels, stainless steels, and irons.	Has a tendency to cause galling in non-ferrous materials such as aluminium.
Nitride and Oxide	Combines the benefits of nitride and oxide surface treatments. For steels, stainless steels, and nickel alloys.	See precautions for nitride and oxide surface treatments.

Factors when trying to determine the best tapping speeds:

- Material to be tapped
- Length of chamfer on tap
- Percentage of full thread to be cut
- Length of hole (depth of thread)
- Pitch of thread
- Cutting fluids
- Machine equipment
- Horizontal or vertical tapping

The best and most efficient operating speeds for taps cannot be calculated with the same certainty, as for many other metalcutting tools.

With other tools, the feed per revolution can be set at any desired point and can be varied as conditions demand. Taps, on the other hand, must always be advanced at a rate equal to one pitch for every revolution. The style of tap may vary the conditions.

For example, with a bottoming tap, the first thread on each land cuts the full height of thread, while, with a taper or starting tap, a number of threads do their share of the cutting before the full height of thread is reached.

The depth of thread also varies, depending on the pitch. The coarser the thread, the greater the advance of the tap per revolution and the greater the amount of material removed.

The method of feeding the tap, and the type of equipment for driving, also influences the permissible speeds. If taps are mechanically fed at the proper rate of advance, they can be operated at higher speeds than if they are required to feed themselves and pull some part of the machine along with them.

Speeds may be modified to take into account any or all of these factors:

- Speeds must be lowered as length of thread increases because, in deep thread holes, the accumulated chips increase friction and interfere with lubrication.
- Bottoming taps must be run slower than plug taps.
- Tapping full height of thread calls for slower speed than if the commercial 75% height only is required.
- Coarse-thread taps in the larger diameters should be run more slowly than fine-thread taps of the same diameters.
- The quantity and quality of cutting fluid may affect the permissible speeds as much as 100%.
- Taper threaded taps, such as pipe taps, should be operated from 1/2–3/4 the speed of a straight thread tap of comparable major diameter.

RPM Formulas

SFM = Surface Feet per Minute
RPM = Revolutions per Minute
IPM = Inches per Minute
TPI = Threads per Inch

S m/min = Surface Metres per Minute
$\pi = 3.1416$
mm/min = millimetres per minute
P = Pitch (1/number of threads per inch)

Inch Sizes

SFM	=	$\frac{\text{RPM x tool diameter}}{3.82}$	or	0.26 x RPM x tool diameter
RPM	=	$\frac{3.82 \text{ x SFM}}{\text{tool diameter}}$		
IPM	=	$\frac{\text{RPM}}{\text{TPI*}}$	or	*P x RPM

Metric Sizes

S m/min	=	$\frac{\pi \text{ x tool diameter x RPM}}{1000}$
RPM	=	$\frac{\text{mm/min x 1000}}{\pi \text{ x tool diameter}}$
mm/min	=	mm P x RPM

UNC/UNF and NPT/NPTF

tap size	taper pipe taps	surface feet per minute (SFM) 5'	10'	15'	20'	25'	30'	40'	50'	60'	70'	80'	90'	100'	110'	120'	130'	140'	150'
		revolutions per minute (RPM)																	
0	–	318	637	955	1273	1592	1910	2546	3183	3820	4456	5093	5729	6366	7003	7639	8276	8913	9549
1	–	273	546	819	1046	1308	1570	2093	2617	3140	3663	4186	4710	5233	5756	6279	6805	7326	1849
2	–	212	424	637	888	1110	1333	1777	2221	2665	3109	3554	3999	4442	4886	5330	5774	6218	6662
3	–	191	382	573	772	964	1157	1543	1929	2315	2701	3086	3472	3858	4244	4629	5015	5401	5787
4	–	174	347	521	682	853	1023	1364	1705	2046	2387	2728	3069	3411	3751	4092	4434	4775	5115
5	–	147	294	441	611	764	917	1222	1528	1833	2139	2445	2750	3056	3361	3667	3973	4278	4584
6	–	136	273	409	553	691	829	1106	1382	1859	1935	2212	2488	2766	3042	3318	3595	3871	4148
8	–	119	239	358	466	583	699	932	1165	1398	1631	1864	2097	2330	2563	2796	3029	3262	3495
10	–	101	201	302	402	502	603	804	1005	1205	1406	1607	1808	2009	2210	2411	2612	2813	3014
12	–	87	174	260	354	442	531	707	884	1061	1238	1415	1592	1769	1945	2122	2300	2476	2653
1/4	–	76	153	229	306	382	458	611	764	917	1070	1222	1375	1528	1681	1833	1986	2139	2292
5/16	–	62	123	185	245	306	367	489	611	733	856	978	1100	1222	1345	1467	1589	1711	1833
3/8	–	50	101	151	204	255	305	407	509	611	713	815	917	1019	1120	1222	1324	1426	1528
7/16	1/8	43	87	130	175	219	262	349	437	524	611	698	786	873	960	1048	1135	1222	1310
1/2	–	38	76	115	153	191	229	305	382	458	535	611	688	764	840	917	993	1070	1146
9/16	1/4	34	68	102	137	172	206	274	342	410	478	547	616	683	752	820	888	952	1020
5/8	–	32	64	96	122	153	183	244	306	367	428	489	550	611	672	733	794	856	917
11/16	3/8	28	55	83	111	138	167	222	278	333	389	444	500	556	611	667	722	778	833
3/4	–	25	51	76	102	128	153	203	255	305	357	407	458	509	560	611	662	713	764
7/8	1/2	22	43	65	87	109	131	175	218	262	306	350	392	437	480	524	568	611	655
1	–	19	38	57	76	96	115	153	191	230	268	305	344	382	420	458	497	535	573
1-1/8	3/4	17	34	51	68	84	102	136	170	204	238	272	306	340	373	407	441	475	509
1-1/4	–	15	31	46	61	76	92	122	153	183	214	244	275	305	336	367	397	428	458
1-3/8	1	14	28	42	56	69	83	111	139	167	194	222	250	278	306	333	361	389	417
1-1/2	–	13	25	38	51	63	76	102	127	153	178	204	229	255	280	305	331	356	382
1-5/8	–	12	23	35	47	59	71	94	118	141	165	188	212	235	259	282	306	329	353
1-3/4	–	11	22	33	44	55	65	87	109	131	153	175	196	218	240	262	284	306	327
1-7/8	–	10	20	30	41	51	61	81	102	122	143	163	183	204	224	244	265	285	306
2	–	9	19	29	38	48	57	76	96	115	134	153	172	191	210	229	248	267	287

Metric

metric taps	vc = metres per minute (m/min) 1,5	3	4,5	6	7,5	10	12	15	18	21	24	27	30	33	36	39	42	45
	revolutions per minute (RPM)																	
M1	490	979	1469	1959	2449	2938	3918	4897	5877	6856	7836	8815	9795	10774	11754	12733	13713	14692
M2	242	484	725	967	1209	1451	1934	2418	2901	3385	3868	4352	4835	5319	5803	6286	6770	7253
M3	162	324	486	347	809	971	1295	1619	1942	2266	2590	2914	3237	3561	3885	4208	4532	4856
M3.5	138	277	415	554	692	830	1107	1384	1661	1938	2214	1491	2768	3045	3322	3599	3875	4152
M4	122	243	365	487	608	730	973	1217	1460	1703	1946	2190	2433	2676	2920	3163	3406	3650
M5	97	194	291	388	485	582	776	970	1163	1357	1551	1745	1939	2133	2327	2521	2715	2905
M6	81	162	243	324	405	486	647	809	971	1133	1295	1457	1619	1781	1942	2104	2266	2428
M7	69	138	208	277	346	415	554	692	830	969	1107	1246	1384	1522	1661	1799	1938	2076
M8	61	121	182	243	303	364	485	606	728	849	970	1091	1213	1334	1455	1577	1698	1819
M10	48	97	145	194	242	291	388	485	582	679	776	873	970	1067	1163	1260	1357	1454
M12	40	81	121	162	202	243	324	405	486	567	647	728	809	890	971	1052	1133	1214
M14	35	69	104	139	173	208	277	347	416	485	555	624	693	763	832	901	971	1040
M16	30	61	91	121	152	182	243	303	364	424	485	546	606	667	728	788	849	910
M18	27	54	81	108	135	162	216	269	323	377	431	485	539	593	647	700	754	808
M20	24	49	73	97	121	146	194	243	291	340	388	437	485	534	582	631	680	728
M22	22	44	66	88	110	132	176	221	265	309	353	397	441	485	529	573	618	662
M24	20	40	61	81	101	121	162	202	243	283	323	364	404	445	485	526	566	606
M27	18	36	54	72	90	108	144	180	216	252	287	323	359	395	431	467	503	539
M30	16	32	49	65	81	97	129	162	194	226	259	291	323	356	388	420	453	485

Partial List of Solutions to Tapping Problems

application	symptom	common cause	remedy
general	gage out of limits	tap size and gage mismatch	select tap size for gage
	oversize thread	alignment, spindle feed	correct
	oversize at top	runout or alignment	correct
	go gage binds part way	worn tool, tap cuts off lead	replace tap, synchronous holder
	thread shaving	feed error, high axial force	programme, synchronous holder
	chipping	high cutting force, worn tap	tap geometry, replace tap
	breakage	chip jamming flutes	tap geometry, tapping depth
	–	worn tool, high torque	replace tap with new tool
	short life, low speed	excessive wear	SC or HSS-E-PM HP taps
steel	birdnest blind hole	long, ductile chips	T630 KP6505 (oxide), peck feed
	chipping	high material hardness	T600, T602 KSP21 (TiN)
	breakage in blind holes	hole depth >2D, chip jamming	T604 KHS26 (TiN/MoS_2)
stainless steel	oversize thread, low life	galling	T620, T630 KM6515 (TiN-CrC/C)
	short life	work hardened core hole	replace drill
cast iron	excessive wear	abrasion	T640 KP6525 (TiCN)
aluminium, cast	excessive wear	high silicon	T640 KP6525 (TiCN)
aluminium, wrought	oversize thread	galling	T672, T682, T686 KSMN34 (TiN-CrC/C)
nickel, cobalt alloys	short life	high cutting temperature	T690, T692, T694 KSP27 (AlCrTiN)
titanium	short life	high cutting temperature	T660, T662 KSSM24 (TiN-CrC/C)

Thread Mills

	vibration marks	major crest wear	edge chipping	cone-shaped thread	entry marks
cutting speed	check	reduce	–	–	–
feed per tooth	check	increase	reduce	–	–
workpiece clamping	improve	improve	improve	–	improve
machine tool stability	improve	improve	improve	–	improve
cantilever arm	shorten	shorten	–	–	shorten
helix angle	increase	reduce	–	–	–
radial runout	check	check	–	–	–
coating	–	improve	improve	–	–
milling operation	–	climb mill	climb mill	climb mill	–
line feed/entry ramp	check	check	–	–	improve
coolant pressure	–	check (>20 bar, 290 psi)	check (>20 bar, 290 psi)	–	–

drill size	decimal (in)	drill size	decimal (in)	drill size	decimal (in)	drill size	decimal (in)	drill size	decimal (in)	drill size	decimal (in)
0,30mm	.0118	54	.0550	3,10mm	.1220	5,50mm	.2165	8,50mm	.3346	9/16	.5625
0,32mm	.0126	1,40mm	.0551	1/18	.1250	7/32	.2188	8,60mm	.3386	14,50mm	.5709
80	.0135	1,45mm	.0571	3,20mm	.1260	5,60mm	.2205	R	.3390	37/64	.5781
0,35mm	.0138	1,50mm	.0591	30	.1285	2	.2210	8,70mm	.3425	14,75mm	.5807
79	.0145	53	.0595	3,30mm	.1299	5,70mm	.2244	11/32	.3438	15,00mm	.5906
0,38mm	.0150	1,55mm	.0610	3,40mm	.1339	1	.2280	8,80mm	.3465	19/32	.5938
1/64	.0156	1/16	.0625	29	.1360	5,80mm	.2283	S	.3480	15,25mm	.6004
0,40mm	.0157	1,60mm	.0630	3,50mm	.1378	5,90mm	.2323	8,90mm	.3504	39/64	.6094
78	.0160	52	.0635	28	.1405	A	.2340	9,00mm	.3543	15,50mm	.6102
0,42mm	.0165	1,65mm	.0650	9/64	.1406	15/64	.2344	T	.3580	15,75mm	.6201
0,45mm	.0177	1,70mm	.0669	3,60mm	.1417	6,00mm	.2362	9,10mm	.3583	5/8	.6250
77	.0180	51	.0670	27	.1440	B	.2380	23/64	.3594	16,00mm	.6299
0,48mm	.0189	1,75mm	.0689	3,70mm	.1457	6,10mm	.2402	9,20mm	.3622	16,25mm	.6398
0,50mm	.0197	50	.0700	26	.1470	C	.2420	9,30mm	.3661	41/64	.6406
76	.0200	1,80mm	.0709	25	.1495	6,20mm	.2441	U	.3680	16,50mm	.6496
75	.0210	1,85mm	.0728	3,80mm	.1496	D	.2460	9,40mm	.3701	21/32	.6562
0,55mm	.0217	49	.0730	24	.1520	6,30mm	.2480	9,50mm	.3740	16,75mm	.6594
74	.0225	1,90mm	.0748	3,90mm	.1535	1/4, E	.2500	3/8	.3750	17,00mm	.6693
0,60mm	.0236	48	.0760	23	.1540	6,40mm	.2520	V	.3770	43/64	.6719
73	.0240	1,95mm	.0768	5/32	.1562	6,50mm	.2559	9,60mm	.3780	17,25mm	.6791
0,62mm	.0244	5/64	.0781	22	.1570	F	.2570	9,70mm	.3819	11/16	.6875
72	.0250	47	.0785	4,00mm	.1575	6,60mm	.2598	9,80mm	.3858	17,50mm	.6890
0,65mm	.0256	2,00mm	.0787	21	.1590	G	.2610	W	.3860	45/64	.7031
71	.0260	2,05mm	.0807	20	.1610	6,70mm	.2638	9,90mm	.3898	18,00mm	.7087
0,70mm	.0276	46	.0810	4,10mm	.1614	17/64	.2656	25/64	.3906	23/32	.7188
70	.0280	45	.0820	4,20mm	.1654	H	.2660	10,00mm	.3937	18,50mm	.7283
69	.0292	2,10mm	.0827	19	.1660	6,80mm	.2677	X	.3970	47/64	.7344
0,75mm	.0295	2,15mm	.0846	4,30mm	.1693	6,90mm	.2717	10,20mm	.4016	19,00mm	.7480
68	.0310	44	.0860	18	.1695	I	.2720	Y	.4040	3/4	.7500
1/32	.0312	2,20mm	.0866	11/64	.1719	7,00mm	.2756	13/32	.4062	49/64	.7656
0,80mm	.0315	2,25mm	.0886	17	.1730	J	.2770	Z	.4130	19,50mm	.7677
67	.0320	43	.0890	4,40mm	.1732	7,10mm	.2795	10,50mm	.4134	25/32	.7812
66	.0330	2,30mm	.0906	16	.1770	K	.2810	27/64	.4219	20,00mm	.7874
0,85mm	.0335	2,35mm	.0925	4,50mm	.1772	9/32	.2812	10,80mm	.4252	51/64	.7969
65	.0350	42	.0935	15	.1800	7,20mm	.2835	11,00mm	.4331	20,50mm	.8071
0,90mm	.0354	3/32	.0938	4,60mm	.1811	7,30mm	.2874	7/16	.4375	13/16	.8125
64	.0360	2,40mm	.0945	14	.1820	L	.2900	11,20mm	.4409	21,00mm	.8268
63	.0370	41	.0960	4,70mm, 13	.1850	7,40mm	.2913	11,50mm	.4528	53/64	.8281
0,95mm	.0374	2,45mm	.0965	3/16	.1875	M	.2950	29/64	.4531	27/32	.8438
62	.0380	40	.0980	4,80mm, 12	.1890	7,50mm	.2953	11,80mm	.4646	21,50mm	.8465
61	.0390	2,50mm	.0984	11	.1910	19/64	.2969	15/32	.4688	55/64	.8594
1,00mm	.0394	39	.0995	4,90mm	.1929	7,60mm	.2992	12,00mm	.4724	22,00mm	.8661
60	.0400	38	.1015	10	.1935	N	.3020	12,20mm	.4803	7/8	.8750
59	.0410	2,60mm	.1024	9	.1960	7,70mm	.3031	31/64	.4844	22,50mm	.8858
1,05mm	.0413	37	.1040	5,00mm	.1969	7,80mm	.3071	12,50mm	.4921	57/64	.8906
58	.0420	2,70mm	.1063	8	.1990	7,90mm	.3110	1/2	.5000	23,00mm	.9055
57	.0430	36	.1065	5,10mm	.2008	5/16	.3125	12,80mm	.5039	29/32	.9062
1,10mm	.0433	7/64	.1094	7	.2010	8,00mm	.3150	13,00mm	.5118	59/64	.9219
1,15mm	.0453	35	.1100	13/64	.2031	O	.3160	33/64	.5156	23,50mm	.9252
56	.0465	2,80mm	.1102	6	.2040	8,10mm	.3189	13,20mm	.5197	15/16	.9375
3/64	.0469	34	.1110	5,20mm	.2047	8,20mm	.3228	17/32	.5312	24,00mm	.9449
1,20mm	.0472	33	.1130	5	.2055	P	.3230	13,50mm	.5315	61/64	.9531
1,25mm	.0492	2,90mm	.1142	5,30mm	.2087	8,30mm	.3268	13,80mm	.5433	24,50mm	.9646
1,30mm	.0512	32	.1160	4	.2090	21/64	.3281	35/64	.5469	31/32	.9688
55	.0520	3,00mm	.1181	5,40mm	.2126	8,40mm	.3307	14,00mm	.5512	25,00mm	.9843
1,35mm	.0531	31	.1200	3	.2130	Q	.3320	14,25mm	.5610	63/64	.9844
–	–	–	–	–	–	–	–	–	–	1"	1.0000

Metric Fractional Wire gage Letter size

Tap Custom-Order Worksheet

Use this Custom-Order Worksheet to modify an existing product to meet your specifications. If your custom requirements do not fall into these categories, simply contact your Kennametal Distributor.

Trust our experienced distributors and Kennametal engineering team to design the best solution for you.

1. Start with the standard product most similar to your specifications:

catalogue number _____ **grade/coating** _____

2. Type of tap needed:

❑ solid carbide ❑ high-performance HSS ❑ general purpose ❑ spiral point

❑ hand ❑ forming ❑ spiral flute

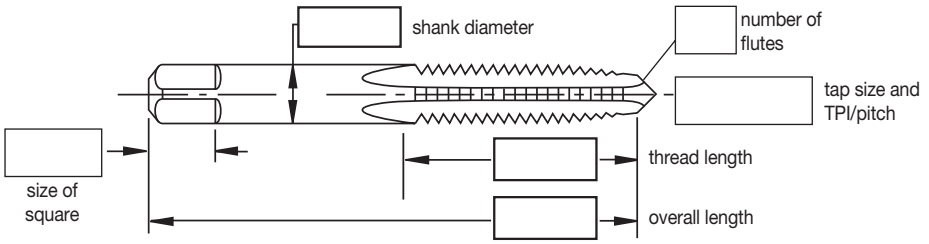
_____ pipe (and style) _____ other

3. Direction of cut (circle one): left hand right hand

4. Material overview:

❑ ANSI ❑ DIN ❑ JIS ❑ other

5. Desired dimension:

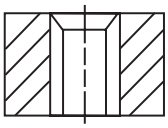


6. Choose one:

through hole:

hole diameter _____

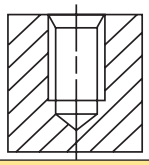
hole depth _____



blind hole:

hole diameter _____

hole depth _____



7. Chamfer:

❑ taper: 7–10 pitch ❑ plug: 3–5 pitch ❑ semi-bottom: 2–3 pitch ❑ bottom: 1–2 pitch



8. Class of fit: **H limit** _____ **metric D limit** _____ **diameter pitch limit** _____

9. Workpiece material: _____

10. Hardness: _____

11. Number of taps required: _____

12. Price

Contact your Authorised Kennametal Distributor partners.

13. Other comments or special characteristics:

customer company name	**date**
address	**phone number**
city, state, zip	**fax number**
customer contact	**customer email address**
sales representative	

Application Sheet for Thread Milling

Test form thread data:				**Date:**	
Customer Data					
Company:				**Department:**	
Street:				**Position:**	
Postal code:				**Telephone:**	
City:				**Fax:**	
Country:				**E-mail:**	
Tool Data					
Engaged Kennametal tool:				**Tool life:**	
Competitive tool:					
Workpiece Data					
Thread size:				**Name of workpiece:**	
Class of fit:				**Picture, sketch...**	
Thread depth:		mm			
Thread type:	❑ Through hole	❑ Blind hole			
Drill hole ø:		mm			
Depth of drill hole:		mm			
Type of drilled hole:	❑ Drilled	❑ No hole			
Material:					
Hardness:					
Machine Data					
Manufacturer:				**Description:**	
CNC-machine type:	❑ Turning machine	❑ Milling machine		**Working direction:**	❑ Horizontal ❑ Vertical
Control type:	❑ DIN	❑ Heidenhain		**Coolant:**	❑ Emulsion ❑ MQL ❑ Compressed air ❑ Dry
Coolant supply type:	❑ Internal	❑ External		**Coolant pressure:**	Bar
Revolutions max:		❑ 1/min		**Spindle power:**	kW
Clamping device:	❑ Weldon® ❑ Shrinking	❑ Collet ❑ Hydraulic expansion			
Cutting Conditions					
Cutting speed vc:			m/min	**Revolutions:**	1/min
Feed fz:			mm/tooth	**Programmed feed:**	mm/min
Milling direction:	❑ Climb milling	❑ Down milling		**Type of feed:**	❑ Feed on contour ❑ Feed on center
Allocated cut over depth of thread:	❑ Yes	❑ No		**Allocated cut over profile:**	❑ By depth of profile ❑ By thread depth
Number of cuts:				**Number of cuts:**	

Knowing the hardness of the work material to be tapped is essential in selecting the best tap for the job.

10 mm/min ball 3000 kg	120° cone 150 kg	1/16" ball 100 kg	model C	1000 lb per sq. in.	10 mm/min ball 3000 kg	120° cone 150 kg	1/16" ball 100 kg	model C	1000 lb per sq. in.
Brinell	Rockwell C	Rockwell B	Shore Scleroscope	tensile strength	Brinell	Rockwell C	Rockwell B	Shore Scleroscope	tensile strength
800	72	–	100	–	276	30	105	42	136
780	71	–	99	–	269	29	104	41	132
760	70	–	98	–	261	28	103	40	129
745	68	–	97	367	258	27	102	39	127
725	67	–	96	357	255	26	102	39	125
712	66	–	95	350	249	25	101	38	123
682	65	–	93	337	245	24	100	37	119
668	64	–	91	326	240	23	99	36	117
652	63	–	89	318	237	23	99	35	115
626	62	–	87	306	229	22	98	34	113
614	61	–	85	299	224	21	97	33	110
601	60	–	83	292	217	20	96	33	107
590	59	–	81	290	211	19	95	32	104
576	57	–	79	281	206	18	94	32	102
552	56	–	76	270	203	17	94	31	100
545	55	–	75	268	200	16	93	31	98
529	54	–	74	259	196	15	92	30	96
514	53	120	72	254	191	14	92	30	94
502	52	119	70	247	187	13	91	29	92
495	51	119	69	244	185	12	91	29	91
477	49	118	67	233	183	11	90	28	90
461	48	117	66	227	180	10	89	28	89
451	47	117	65	223	175	9	88	27	86
444	46	116	64	219	170	7	87	27	84
427	46	115	62	209	167	6	87	27	82
415	44	115	60	204	165	5	86	26	81
401	43	114	58	196	163	4	85	26	80
388	42	114	57	191	160	3	84	25	78
375	41	113	55	184	156	2	83	25	76
370	40	112	54	182	154	1	82	25	75
362	39	111	53	179	152	–	82	24	74
351	38	111	51	173	150	–	81	24	74
346	37	110	50	170	147	–	80	24	72
341	37	110	49	168	145	–	79	23	71
331	36	109	47	163	143	–	79	23	70
323	35	109	46	158	141	–	78	23	69
311	34	108	46	153	140	–	77	22	69
301	33	107	45	148	135	–	75	22	67
293	32	106	44	144	130	–	72	22	65
285	31	105	43	140	–	–	–	–	–

High-Performance Multipurpose HSS-E GOtap™



GOtap is the solution for high-performance multipurpose tapping. GOtap includes optimised flute geometries and PVD coatings capable of tapping a broad assortment of ductile materials, such as stainless steels, carbon and alloy steels, cast aluminium, and ductile iron. The unmatched versatility of GOtap means lower inventory costs with no loss of productivity, consistent tool life, and high-quality thread finish.

ADVANCED TECHNOLOGY

- Manufactured with high-vanadium HSS-E material for exceptional wear characteristics and longer tool life.
- Optimised geometries for efficient chip evacuation in both through and blind holes.
- Advanced PVD coatings to reduce tapping torque resulting in high-quality thread finish and longer tool life.

Experience the advantages at your Authorised Kennametal Distributor or at **kennametal.com**.

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Solid End Milling

Solid End Milling Introduction N2–N3

Duo-Lock Modular Milling O1–O59

High-Performance Solid Carbide End Mills P1–P197

General Purpose Solid Carbide End Mills Q1–Q43



Solid End Milling Products

Our latest Metalcutting Innovations are designed to deliver higher productivity, longer tool life, and increased application versatility.

For more information about the latest products and services from Kennametal, please contact your Kennametal Representative or Authorised Kennametal Distributor, or visit **kennametal.com**.

MODULAR END MILLS

See Section O for more details.

HARVI™ I
HARVI II
HARVI III
MaxiMet™
High-Performance Rougher
High-Performance Finisher
Corner Tooling

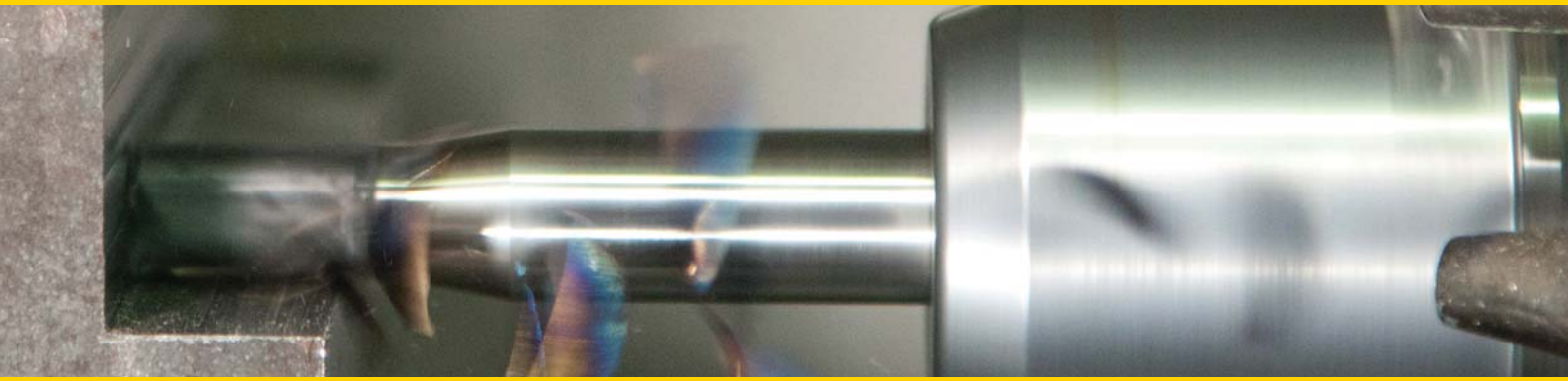


HIGH CAPABILITY END MILLS

See Section P for more details.

HARVI I
HARVI II
HARVI II Long
HARVI II Trochoidal
HARVI III
XE/XER





MATERIAL SPECIFIC END MILLS

See Section P for more details.

Aluminium Machining
Hard Materials Machining
CFRP Machining



APPLICATION SPECIFIC END MILLS

See Section P for more details.

High-Performance Roughing End Mills
High-Performance Finishing End Mills
RSM II
KenFeed™
GOmill™

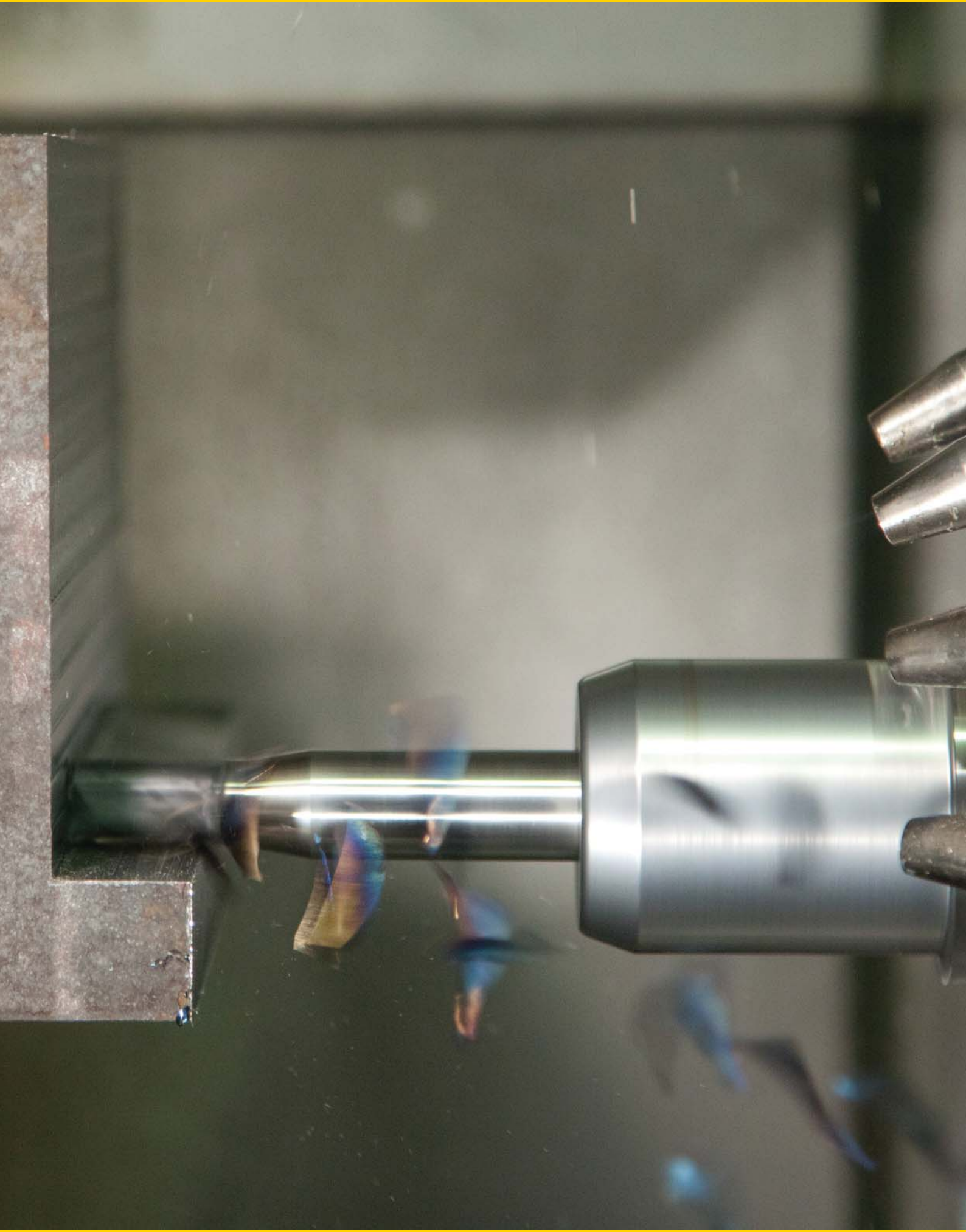


GENERAL PURPOSE END MILLS

See Section Q for more details.

GOmill GP 2FL
GOmill GP 3FL
GOmill GP 4FL





Solid End Milling • Duo-Lock Modular Milling

Duo-Lock Tool Selector and Grades O2–O4

HARVI Modular End Mills O6–O24

MaxiMet Modular End Mills O26–O30

Modular Roughing End Mills O32–O39

Modular Finishing End Mills O40–O45

Modular Corner Rounding and Chamfering End Mills O46–O51

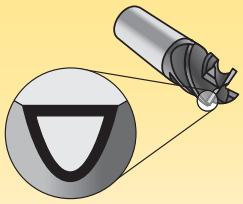
Adaptors O52–O58

Assembly Information O59

product line		series	D1 diameter (mm)	length of cut	flute Z	helix	internal coolant	
HARVI™ I		UKDV	10–32	1,5 x D	ZU=4	37°		
HARVI I		ULDV	10–32	1,5 x D	ZU=4	37°		
HARVI II		UCDV	10–32	1,5 x D	ZU=5	37°		
HARVI II		UDDV	10–32	1,5 x D	ZU=5	37°		
HARVI III		UJDV	10–32	1,5 x D	ZU=6	37°		
HARVI Ball Nose		UKBV	10–25	1,5 x D	ZU=4	37°		
HARVI III Ball Nose		UJBV	10–25	1,5 x D	ZU=6	37°		
MaxiMet™		ABDF	10–20	1,5 x D	ZU=2	45°		
MaxiMet		ABDE	10–25	1,5 x D	ZU=3	38°		
KenFeed™		KMDA	10–20	0,75 x D	ZU=6	20°		
HP Rougher		RQDB	10–25	1,5 x D	ZU=X	20°		
HP Rougher		RKDF	10–25	1,5 x D	ZU=X	45°		
HP Rougher		RQBB	10–25	1,5 x D	ZU=4	40°		
HP Finisher		FMDF	10–25	1,5 x D	ZU=6	45°		
HP Finisher		FSDE	10–25	1,5 x D	ZU=X	36°		
Corner Tooling		XADA	10–16	2–4	ZU=X	0°		
Corner Tooling		XRDA	10–16	1,5–4	ZU=X	0°		

							shank	centre cutting	neck	P	M	K	N	S	H							product page(s)	cutting data page(s)
				✓				✓	✓	●	●			○		✓	✓	✓	✓			O8	O10
					✓			✓	✓	●	●	○		●	○	✓	✓	✓	✓			O9	O11
				✓					✓	●	●	●		○	○	✓	✓	✓				O12	O14
					✓				✓	●				●	○	✓	✓	✓				O13	O15
					✓			✓	✓	○	●			●	○	✓		✓				O16	O17
						✓		✓	✓	●	●	●		○	○	✓	✓			✓		O18	O20
						✓		✓	✓	○	●	○		●	○	✓				✓		O19	O21–O22
		✓						✓	✓				●			✓	✓	✓	✓			O28	O30
					✓			✓	✓				●			✓	✓	✓	✓			O29	O30
	✓								✓	○					●			✓		✓		contact us	contact us
				✓				✓	✓	●	●	●		○	○	✓	✓	✓				O34	O37
				✓				✓	✓	○	●	○		●	○	✓	✓	✓				O35	O38
						✓		✓	✓	●	●	●		○	○	✓	✓			✓		O36	O39
					✓			✓	✓	●	●	●		○	○	✓						O42	O44
					✓				✓	○	●			●	○	✓						O43	O45
									✓	●	●	●	●	○	○							O48	O50
									✓	●	●	●	●	○	○							O49	O51

● first choice
○ alternate choice



Coatings provide high-speed capability and are engineered for roughing to finishing.

P	Steel
M	Stainless Steel
K	Cast Iron
N	Non-Ferrous
S	High-Temp Alloys
H	Hardened Materials

Grades

Coating	Grade Description	wear resistance ← → toughness: 05	10	15	20	25	30	35	40	45
K600	Carbide grade made from high-quality, micrograin materials for cutting all types of workpiece materials. Very high toughness ensures a controlled wear rate. The micrograin structure enables extremely sharp cutting edges.	N	N	N	N	N	N			
KCPM15	Coated carbide grade with thick PVD coating and optimised chemistry and process for increased wear resistance. Outstanding protection in milling stainless steel to mitigate crater, DOCN (depth-of-cut notching), and flank wear. Excellent performance up to 52 HRC.	P	P	P	P	P	P			
		M	M	M	M	M	M			
		K	K	K	K	K	K			
KC643M	Coated fine-grain grade with PVD multilayer (AlTiN). KC643M™ is a very thin and hard PVD coating particularly suited for cutting steel, cast iron, stainless steel (wet), and titanium (wet). This grade can be used for materials with hardness up to 52 HRC.	P	P	P	P	P	P			
		M	M	M	M	M	M			
		K	K	K	K	K	K			
		S	S	S	S	S	S			
KC639M	PVD (AlTiN)-coated carbide on a submicron carbide substrate. This hard coating provides outstanding performance in milling hardened materials (58–65 HRC).	P	P	P	P	P	P			
		H	H	H						
KCSM15	Coated carbide grade with thick PVD coating and optimised chemistry and process for increased wear resistance. Outstanding protection in milling stainless steel to mitigate crater, DOCN (depth-of-cut notching), and flank wear. Excellent performance up to 52 HRC.	S	S	S	S					
		H	H	H	H					

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DUO-λOCK® HARVI™

Primary Application

HARVI geometries for Duo-Lock™ target applications where solid carbide end mills are currently used.
The Duo-Lock™ system combines the highest runout accuracy and length repeatability with maximum coupling stability.
This enables the Duo-Lock™ system to use the full potential of Kennametal cutting geometries and grades with the flexibility of a modular system. Significant metal removal rates can be achieved. A wide range of diameters and corner configurations, such as chamfer, radii, and sharp edges, are available from stock.

- Cutting data and tool life comparable to high-performance solid carbide.
- Proprietary HARVI geometries enable roughing and finishing with one tool.
- 1,5 x D standard cutting edge length enables fewer passes.
- Up to 1 x D full slotting increases metal removal rates, increasing productivity significantly.
- Extensive offering of straight and conical shank tools, and integral adaptors that include DV, BT, and HSK.

Features and Benefits

Advanced Technology

- New asymmetrical HARVI 4-flute geometry for higher feed-per-tooth rates.
- Variable helix design for chatter-free machining at high feed rates.
- Less pressure on cutting edge through tailored axial and radial rake angles.
- Eccentric relief design increases tool life through higher edge stability.
- Proprietary tapered core for highest tool stability when roughing and finishing.

Tailored Grades

- KCSM15™ Beyond™ grade for exceptional tool life in titanium and stainless steels.
- KCPM15™ Beyond grade for outstanding wear protection in stainless steel to mitigate cratering, depth-of-cut notching, and flank wear.
- Universal KC643M™ grade for cutting steel, cast iron, stainless steel (wet), and titanium (wet).

Customisation

- Intermediate diameters are available between 10–32mm.
- Chip divider geometry helps reduce power usage and improve chip formation in difficult-to-cut materials.
- Engineered solutions including shank and non-standard length versions available.
- Custom solutions within standard blank dimension are available.

Extensive Standard Offering

- Diameter ranges 10–32mm.
- Necked, corner radii, chamfer, and square-end tips available.
- Integral adaptors to reduce interface for maximum accuracy.
- Steel extensions with Safe-Lock™ by HAIMER shanks to prevent pullout.
- Cut-to-size extra-long extensions available upon request off the shelf.

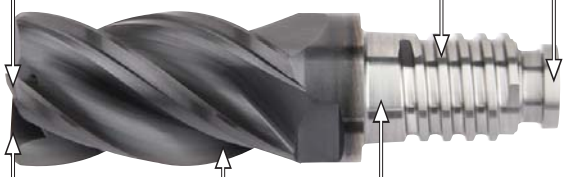
High-performance modular solid carbide end mills.



Intelligent Thread
Ensures that stress levels remain below critical values.

High-Performance Geometries
Highest metal removal rates with up to 1 x D full slotting and up to 1,5 x D side milling at 50% ae capability.

3rd Contact Surface
Delivers high stiffness and highest accuracy below 5µm runout.



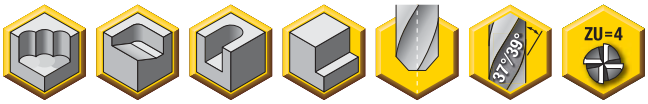
DUO-LOCK®
by HAIMER® and Kennametal

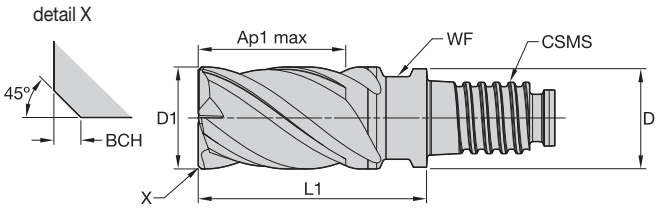
Unequal Flute Spacing
Reduces vibrations. Improves surface finish.

Double Cone
Eliminates expensive presetting processes by providing an axial 10µm repeatability.

37°/39° Variable Helix Technology
Minimises chatter and harmonics for smoother machining.

- Asymmetrical flute spacing and variable helix configuration minimises chatter and harmonics for smoother machining.
- Centre cutting.
- Single tool for both roughing and finishing, reducing setups.
- Standard items listed. Additional styles and coatings made-to-order.



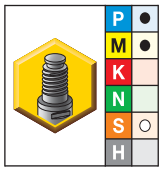




End Mill Tolerances

D1	tolerance e8
> 10–18	-0,032/-0,059
> 18–30	-0,040/-0,073
> 30	-0,050/-0,089

UKDV • 4 Flute • Metric

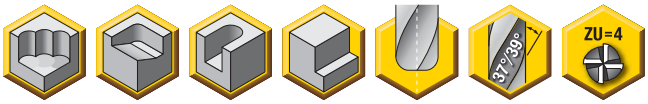


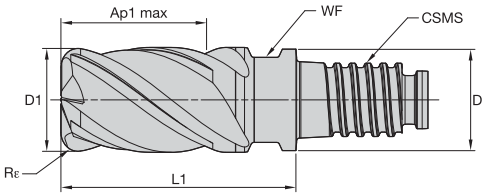
● first choice
○ alternate choice

KCPM15	D1	D	Ap1 max	L1	CSMS system size	WF	BCH
UKDV1000X4CV	10,00	9,60	15,00	22,50	DL10	8,00	0,50
UKDV1200X4CV	12,00	11,50	18,00	27,00	DL12	9,50	0,50
UKDV1600X4CV	16,00	15,50	24,00	36,00	DL16	13,00	0,50
UKDV2000X4CV	20,00	19,30	30,00	45,00	DL20	16,00	0,50
UKDV2500X4CV	25,00	24,00	37,50	56,50	DL25	21,00	0,50
UKDV3200X4CV	32,00	31,00	48,00	71,20	DL32	28,00	0,50

NOTE: For application data, please see page O10.

- Asymmetrical flute spacing and variable helix configuration minimises chatter and harmonics for smoother machining.
- Centre cutting.
- Single tool for both roughing and finishing, reducing setups.
- Standard items listed. Additional styles and coatings made-to-order.



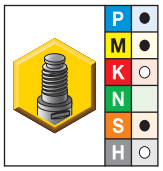




End Mill Tolerances

D1	tolerance e8
> 10–18	-0,032/-0,059
> 18–30	-0,040/-0,073
> 30	-0,050/-0,089

ULDV • 4 Flute • Metric



● first choice
○ alternate choice

KCSM15	D1	D	Ap1 max	L1	CSMS system size	WF	Rε
ULDV1000X4CQE	10,00	9,60	15,00	22,50	DL10	8,00	0,50
ULDV1000X4CQG	10,00	9,60	15,00	22,50	DL10	8,00	1,00
ULDV1000X4CQJ	10,00	9,60	15,00	22,50	DL10	8,00	1,50
ULDV1200X4CQE	12,00	11,50	18,00	27,00	DL12	9,50	0,50
ULDV1200X4CQG	12,00	11,50	18,00	27,00	DL12	9,50	1,00
ULDV1200X4CQJ	12,00	11,50	18,00	27,00	DL12	9,50	1,50
ULDV1200X4CQL	12,00	11,50	18,00	27,00	DL12	9,50	2,50
ULDV1600X4CQG	16,00	15,50	24,00	36,00	DL16	13,00	1,00
ULDV1600X4CQJ	16,00	15,50	24,00	36,00	DL16	13,00	1,50
ULDV1600X4CQK	16,00	15,50	24,00	36,00	DL16	13,00	2,00
ULDV1600X4CQL	16,00	15,50	24,00	36,00	DL16	13,00	2,50
ULDV1600X4CQM	16,00	15,50	24,00	36,00	DL16	13,00	3,00
ULDV2000X4CQG	20,00	19,30	30,00	45,00	DL20	16,00	1,00
ULDV2000X4CQK	20,00	19,30	30,00	45,00	DL20	16,00	2,00
ULDV2000X4CQL	20,00	19,30	30,00	45,00	DL20	16,00	2,50
ULDV2000X4CQM	20,00	19,30	30,00	45,00	DL20	16,00	3,00
ULDV2000X4CQN	20,00	19,30	30,00	45,00	DL20	16,00	4,00
ULDV2500X4CQL	25,00	24,00	37,50	56,50	DL25	21,00	2,50
ULDV2500X4CQN	25,00	24,00	37,50	56,50	DL25	21,00	4,00
ULDV3200X4CQL	32,00	31,00	48,00	71,70	DL32	28,00	2,50
ULDV3200X4CQN	32,00	31,00	48,00	71,70	DL32	28,00	4,00

NOTE: For application data, please see page O11.

HARVI • UKDV • Asymmetrical Flute Spacing





Material Group		Side Milling (A) and Slotting (B)			short			medium			long			Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 20%.						
		A		B	adaptor reach KCPM15 Cutting Speed — vc m/min			adaptor reach KCPM15 Cutting Speed — vc m/min			adaptor reach KCPM15 Cutting Speed — vc m/min			D1 — Diameter						
		ap	ae	ap	min		max	min		max	min		max	mm	10,0	12,0	16,0	20,0	25,0	32,0
P	0	1,5 x D	0,5 x D	1 x D	150	–	200	135	–	180	135	–	180	fz	0,061	0,070	0,086	0,097	0,105	0,106
	1	1,5 x D	0,5 x D	1 x D	150	–	200	135	–	180	135	–	180	fz	0,061	0,070	0,086	0,097	0,105	0,106
	2	1,5 x D	0,5 x D	1 x D	140	–	190	126	–	171	126	–	171	fz	0,061	0,070	0,086	0,097	0,105	0,106
	3	1,5 x D	0,5 x D	1 x D	120	–	160	108	–	144	108	–	144	fz	0,051	0,060	0,074	0,086	0,097	0,105
	4	1,5 x D	0,4 x D	0,75 x D	90	–	150	81	–	135	81	–	135	fz	0,046	0,053	0,065	0,075	0,083	0,087
	5	1,5 x D	0,4 x D	1 x D	60	–	100	51	–	85	48	–	80	fz	0,041	0,048	0,059	0,069	0,077	0,084
	6	1,5 x D	0,4 x D	0,75 x D	50	–	75	42,5	–	63,75	40	–	60	fz	0,034	0,040	0,048	0,055	0,060	0,062
M	1	1,5 x D	0,4 x D	1 x D	90	–	115	72	–	92	63	–	80,5	fz	0,051	0,060	0,074	0,086	0,097	0,105
	2	1,5 x D	0,4 x D	1 x D	60	–	80	48	–	64	42	–	56	fz	0,041	0,048	0,059	0,069	0,077	0,084
	3	1,5 x D	0,4 x D	1 x D	60	–	70	48	–	56	42	–	49	fz	0,034	0,040	0,048	0,055	0,060	0,062
S	1	1,5 x D	0,3 x D	0,3 x D	50	–	90	40	–	72	30	–	54	fz	0,051	0,060	0,074	0,086	0,097	0,105
	2	1,5 x D	0,3 x D	0,3 x D	25	–	40	20	–	32	15	–	24	fz	0,027	0,032	0,039	0,046	0,052	0,057
	3	1,5 x D	0,3 x D	0,3 x D	25	–	40	20	–	32	15	–	24	fz	0,027	0,032	0,039	0,046	0,052	0,057
	4	1,5 x D	0,4 x D	1 x D	50	–	60	40	–	48	30	–	36	fz	0,038	0,044	0,055	0,063	0,071	0,077

NOTE: Those guidelines may require variations to achieve optimum results.
Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. Please adjust parameters according to system stability.
For side milling with ap larger than 1 x D, reduce fz by 20%!
Cylindrical shanks not recommended for full slotting.

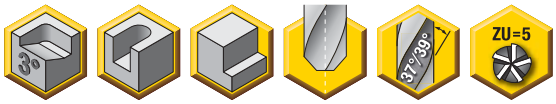
HARVI • ULDV • Asymmetrical Flute Spacing

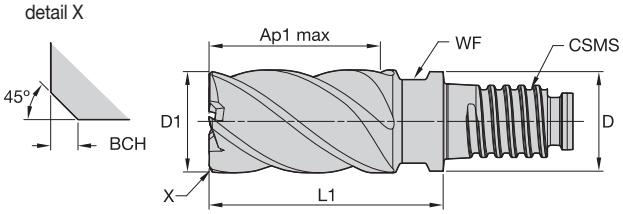


Material Group		Side Milling (A) and Slotting (B)			short			medium			long			Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 20%.						
		A		B	adaptor reach KCSM15 Cutting Speed – vc m/min			adaptor reach KCSM15 Cutting Speed – vc m/min			adaptor reach KCSM15 Cutting Speed – vc m/min			D1 – Diameter						
		ap	ae	ap	min		max	min		max	min		max	mm	10,0	12,0	16,0	20,0	25,0	32,0
P	0	1,5 x D	0,5 x D	1 x D	150	–	200	135	–	180	135	–	180	fz	0,061	0,070	0,086	0,097	0,105	0,106
	1	1,5 x D	0,5 x D	1 x D	150	–	200	135	–	180	135	–	180	fz	0,061	0,070	0,086	0,097	0,105	0,106
	2	1,5 x D	0,5 x D	1 x D	140	–	190	126	–	171	126	–	171	fz	0,061	0,070	0,086	0,097	0,105	0,106
	3	1,5 x D	0,5 x D	1 x D	120	–	160	108	–	144	108	–	144	fz	0,051	0,060	0,074	0,086	0,097	0,105
	4	1,5 x D	0,4 x D	0,75 x D	90	–	150	81	–	135	81	–	135	fz	0,046	0,053	0,065	0,075	0,083	0,087
	5	1,5 x D	0,4 x D	1 x D	60	–	100	51	–	85	48	–	80	fz	0,041	0,048	0,059	0,069	0,077	0,084
	6	1,5 x D	0,4 x D	0,75 x D	50	–	75	42,5	–	63,75	40	–	60	fz	0,034	0,040	0,048	0,055	0,060	0,062
M	1	1,5 x D	0,4 x D	1 x D	90	–	115	72	–	92	63	–	80,5	fz	0,051	0,060	0,074	0,086	0,097	0,105
	2	1,5 x D	0,4 x D	1 x D	60	–	80	48	–	64	42	–	56	fz	0,041	0,048	0,059	0,069	0,077	0,084
	3	1,5 x D	0,4 x D	1 x D	60	–	70	48	–	56	42	–	49	fz	0,034	0,040	0,048	0,055	0,060	0,062
K	1	1,5 x D	0,5 x D	1 x D	120	–	150	108	–	135	108	–	135	fz	0,061	0,070	0,086	0,097	0,105	0,106
	2	1,5 x D	0,5 x D	1 x D	110	–	140	99	–	126	99	–	126	fz	0,051	0,060	0,074	0,086	0,097	0,105
	3	1,5 x D	0,5 x D	1 x D	110	–	130	99	–	117	99	–	117	fz	0,041	0,048	0,059	0,069	0,077	0,084
S	1	1,5 x D	0,3 x D	0,3 x D	50	–	90	40	–	72	30	–	54	fz	0,051	0,060	0,074	0,086	0,097	0,105
	2	1,5 x D	0,3 x D	0,3 x D	25	–	40	20	–	32	15	–	24	fz	0,027	0,032	0,039	0,046	0,052	0,057
	3	1,5 x D	0,3 x D	0,3 x D	25	–	40	20	–	32	15	–	24	fz	0,027	0,032	0,039	0,046	0,052	0,057
	4	1,5 x D	0,4 x D	1 x D	50	–	60	40	–	48	30	–	36	fz	0,038	0,044	0,055	0,063	0,071	0,077
H	1	1,5 x D	0,4 x D	0,75 x D	80	–	140	64	–	112	48	–	84	fz	0,046	0,053	0,065	0,075	0,083	0,087
	2	1,5 x D	0,2 x D	0,5 x D	70	–	120	56	–	96	42	–	72	fz	0,034	0,040	0,048	0,055	0,060	0,062

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. Please adjust parameters according to system stability.
For side milling with ap larger than 1 x D, reduce fz by 20%!
Cylindrical shanks not recommended for full slotting.

- Unequal flute spacing and variable helix configuration minimise chatter and harmonics for smoother machining.
- Non-centre cutting.
- Ramping up to 3°.
- Five-flute geometry able to slot up to 1 x D.
- Single tool for both roughing and finishing, reducing setups.
- Standard items listed. Additional styles and coatings made-to-order.



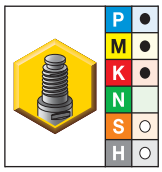




End Mill Tolerances

D1	tolerance e8
> 10–18	-0,032/-0,059
> 18–30	-0,040/-0,073
> 30	-0,050/-0,089

UCDV • 5 Flute • Metric

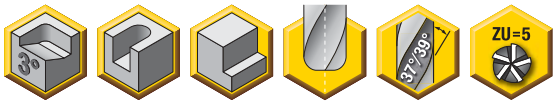


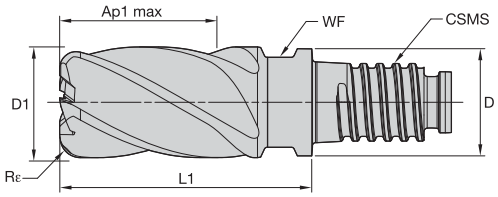
● first choice
○ alternate choice

KCPM15	D1	D	Ap1 max	L1	CSMS system size	WF	BCH
UCDV1000X5CV	10,00	9,60	15,00	22,50	DL10	8,00	0,50
UCDV1200X5CV	12,00	11,50	18,00	27,00	DL12	9,50	0,50
UCDV1600X5CV	16,00	15,50	24,00	36,00	DL16	13,00	0,50
UCDV2000X5CV	20,00	19,30	30,00	45,00	DL20	16,00	0,50
UCDV2500X5CV	25,00	24,00	37,50	56,50	DL25	21,00	0,50
UCDV3200X5CV	32,00	31,00	48,00	71,20	DL32	28,00	0,50

NOTE: For application data, please see page O14.

- Unequal flute spacing and variable helix configuration minimise chatter and harmonics for smoother machining.
- Non-centre cutting.
- Ramping up to 3°.
- Five-flute geometry able to slot up to 1 x D.
- Single tool for both roughing and finishing, reducing setups.
- Standard items listed. Additional styles and coatings made-to-order.



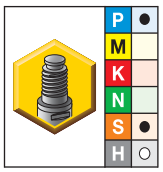




End Mill Tolerances

D1	tolerance e8
> 10–18	-0,032/-0,059
> 18–30	-0,040/-0,073
> 30	-0,050/-0,089

UDDV • 5 Flute • Metric



● first choice
○ alternate choice

KC643M	D1	D	Ap1 max	L1	CSMS system size	WF	Rε
UDDV1000X5CQE	10,00	9,60	15,00	22,50	DL10	8,00	0,50
UDDV1000X5CQG	10,00	9,60	15,00	22,50	DL10	8,00	1,00
UDDV1000X5CQJ	10,00	9,60	15,00	22,50	DL10	8,00	1,50
UDDV1200X5CQE	12,00	11,50	18,00	27,00	DL12	9,50	0,50
UDDV1200X5CQG	12,00	11,50	18,00	27,00	DL12	9,50	1,00
UDDV1200X5CQJ	12,00	11,50	18,00	27,00	DL12	9,50	1,50
UDDV1200X5CQL	12,00	11,50	18,00	27,00	DL12	9,50	2,50
UDDV1600X5CQG	16,00	15,50	24,00	36,00	DL16	13,00	1,00
UDDV1600X5CQJ	16,00	15,50	24,00	36,00	DL16	13,00	1,50
UDDV1600X5CQK	16,00	15,50	24,00	36,00	DL16	13,00	2,00
UDDV1600X5CQL	16,00	15,50	24,00	36,00	DL16	13,00	3,00
UDDV1600X5CQM	16,00	15,50	24,00	36,00	DL16	13,00	3,00
UDDV1600X5CQN	16,00	15,50	24,00	36,00	DL16	13,00	4,00
UDDV1600X5CQP	16,00	15,50	24,00	36,00	DL16	13,00	6,00
UDDV2000X5CQG	20,00	19,30	30,00	45,00	DL20	16,00	1,00
UDDV2000X5CQM	20,00	19,30	30,00	45,00	DL20	16,00	1,00
UDDV2000X5CQK	20,00	19,30	30,00	45,00	DL20	16,00	2,00
UDDV2000X5CQL	20,00	19,30	30,00	45,00	DL20	16,00	2,50
UDDV2000X5CQN	20,00	19,30	30,00	45,00	DL20	16,00	3,00
UDDV2000X5CQQ	20,00	19,30	30,00	45,00	DL20	16,00	5,00
UDDV2500X5CQG	25,00	24,00	37,50	56,50	DL25	21,00	1,00
UDDV2500X5CQL	25,00	24,00	37,50	56,50	DL25	21,00	2,50
UDDV2500X5CQN	25,00	24,00	37,50	56,50	DL25	21,00	4,00
UDDV2500X5CQQ	25,00	24,00	37,50	56,50	DL25	21,00	5,00
UDDV3200X5CQG	32,00	31,00	48,00	71,70	DL32	28,00	1,00
UDDV3200X5CQL	32,00	31,00	48,00	71,70	DL32	28,00	2,50
UDDV3200X5CQN	32,00	31,00	48,00	71,70	DL32	28,00	4,00
UDDV3200X5CQQ	32,00	31,00	48,00	71,70	DL32	28,00	5,00

NOTE: For application data, please see page O15.

HARVI II • UCDV • Unequal Flute Spacing





Material Group		Side Milling (A) and Slotting (B)			short			medium			long			Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 20%.						
		A		B	adaptor reach KCPM15 Cutting Speed — vc m/min			adaptor reach KCPM15 Cutting Speed — vc m/min			adaptor reach KCPM15 Cutting Speed — vc m/min			D1 — Diameter						
		ap	ae	ap	min		max	min		max	min		max	mm	10,0	12,0	16,0	20,0	25,0	32,0
P	0	1,5 x D	0,5 x D	1 x D	150	–	200	135	–	180	135	–	180	fz	0,061	0,070	0,086	0,097	0,105	0,106
	1	1,5 x D	0,5 x D	1 x D	150	–	200	135	–	180	135	–	180	fz	0,061	0,070	0,086	0,097	0,105	0,106
	2	1,5 x D	0,5 x D	1 x D	140	–	190	126	–	171	126	–	171	fz	0,061	0,070	0,086	0,097	0,105	0,106
	3	1,5 x D	0,5 x D	1 x D	120	–	160	108	–	144	108	–	144	fz	0,051	0,060	0,074	0,086	0,097	0,105
	4	1,5 x D	0,4 x D	0,75 x D	90	–	150	81	–	135	81	–	135	fz	0,046	0,053	0,065	0,075	0,083	0,087
	5	1,5 x D	0,4 x D	1 x D	60	–	100	51	–	85	48	–	80	fz	0,041	0,048	0,059	0,069	0,077	0,084
	6	1,5 x D	0,4 x D	0,75 x D	50	–	75	42,5	–	63,75	40	–	60	fz	0,034	0,040	0,048	0,055	0,060	0,062
M	1	1,5 x D	0,4 x D	1 x D	90	–	115	72	–	92	63	–	80,5	fz	0,051	0,060	0,074	0,086	0,097	0,105
	2	1,5 x D	0,4 x D	1 x D	60	–	80	48	–	64	42	–	56	fz	0,041	0,048	0,059	0,069	0,077	0,084
	3	1,5 x D	0,4 x D	1 x D	60	–	70	48	–	56	42	–	49	fz	0,034	0,040	0,048	0,055	0,060	0,062
K	1	1,5 x D	0,5 x D	1 x D	120	–	150	108	–	135	108	–	135	fz	0,061	0,070	0,086	0,097	0,105	0,106
	2	1,5 x D	0,5 x D	1 x D	110	–	140	99	–	126	99	–	126	fz	0,051	0,060	0,074	0,086	0,097	0,105
	3	1,5 x D	0,5 x D	1 x D	110	–	130	99	–	117	99	–	117	fz	0,041	0,048	0,059	0,069	0,077	0,084
S	1	1,5 x D	0,3 x D	0,3 x D	50	–	90	40	–	72	30	–	54	fz	0,051	0,060	0,074	0,086	0,097	0,105
	2	1,5 x D	0,3 x D	0,3 x D	25	–	40	20	–	32	15	–	24	fz	0,027	0,032	0,039	0,046	0,052	0,057
	3	1,5 x D	0,3 x D	0,3 x D	25	–	40	20	–	32	15	–	24	fz	0,027	0,032	0,039	0,046	0,052	0,057
	4	1,5 x D	0,4 x D	1 x D	50	–	60	40	–	48	30	–	36	fz	0,038	0,044	0,055	0,063	0,071	0,077
H	1	1,5 x D	0,4 x D	0,75 x D	80	–	140	64	–	112	48	–	84	fz	0,046	0,053	0,065	0,075	0,083	0,087
	2	1,5 x D	0,2 x D	0,5 x D	70	–	120	56	–	96	42	–	72	fz	0,034	0,040	0,048	0,055	0,060	0,062

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. Please adjust parameters according to system stability.
For side milling with ap larger than 1 x D, reduce fz by 20%!
Cylindrical shanks not recommended for full slotting.

HARVI II • UDDV • Unequal Flute Spacing

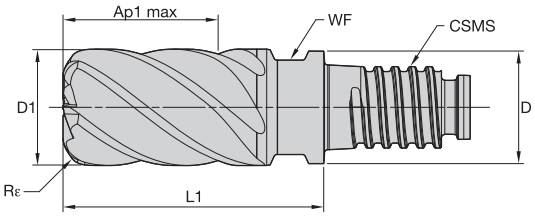


Material Group		Side Milling (A) and Slotting (B)			short			medium			long			Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 20%.						
		A		B	adaptor reach KC643M Cutting Speed — vc m/min			adaptor reach KC643M Cutting Speed — vc m/min			adaptor reach KC643M Cutting Speed — vc m/min			D1 — Diameter						
		ap	ae	ap	min		max	min		max	min		max	mm	10,0	12,0	16,0	20,0	25,0	32,0
P	5	1,5 x D	0,4 x D	1 x D	60	–	100	51	–	85	48	–	80	fz	0,041	0,048	0,059	0,069	0,077	0,084
	6	1,5 x D	0,4 x D	0,75 x D	50	–	75	42,5	–	63,75	40	–	60	fz	0,034	0,040	0,048	0,055	0,060	0,062
S	1	1,5 x D	0,3 x D	0,3 x D	50	–	90	40	–	72	30	–	54	fz	0,051	0,060	0,074	0,086	0,097	0,105
	2	1,5 x D	0,3 x D	0,3 x D	25	–	40	20	–	32	15	–	24	fz	0,027	0,032	0,039	0,046	0,052	0,057
	3	1,5 x D	0,3 x D	0,3 x D	25	–	40	20	–	32	15	–	24	fz	0,027	0,032	0,039	0,046	0,052	0,057
	4	1,5 x D	0,4 x D	1 x D	50	–	60	40	–	48	30	–	36	fz	0,038	0,044	0,055	0,063	0,071	0,077
H	1	1,5 x D	0,4 x D	0,75 x D	80	–	140	64	–	112	48	–	84	fz	0,046	0,053	0,065	0,075	0,083	0,087
	2	1,5 x D	0,2 x D	0,5 x D	70	–	120	56	–	96	42	–	72	fz	0,034	0,040	0,048	0,055	0,060	0,062

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. Please adjust parameters according to system stability.
For side milling with ap larger than 1 x D, reduce fz by 20%!
Cylindrical shanks not recommended for full slotting.

- Unequal flute spacing and variable helix configuration minimise chatter and harmonics for smoother machining.
- Centre cutting.
- Optimised geometry for titanium machining.
- Single tool for both roughing and finishing, reducing setups.
- Standard items listed. Additional styles and coatings made-to-order.



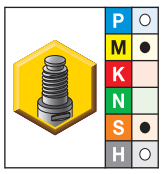




End Mill Tolerances

D1	tolerance e8
> 10–18	-0,032/-0,059
> 18–30	-0,040/-0,073
> 30	-0,050/-0,089

UJDV • 6-Flute with Eccentric Relief Grind • Metric



● first choice
○ alternate choice

KCSM15	D1	D	Ap1 max	L1	CSMS system size	WF	Rε
UJDV1000X6CQE	10,00	9,60	15,00	22,50	DL10	8,00	0,50
UJDV1000X6CQG	10,00	9,60	15,00	22,50	DL10	8,00	1,00
UJDV1000X6CQJ	10,00	9,60	15,00	22,50	DL10	8,00	1,50
UJDV1200X6CQE	12,00	11,50	18,00	27,00	DL12	9,50	0,50
UJDV1200X6CQG	12,00	11,50	18,00	27,00	DL12	9,50	1,00
UJDV1200X6CQJ	12,00	11,50	18,00	27,00	DL12	9,50	1,50
UJDV1200X6CQL	12,00	11,50	18,00	27,00	DL12	9,50	2,50
UJDV1600X6CQG	16,00	15,50	24,00	36,00	DL16	13,00	1,00
UJDV1600X6CQJ	16,00	15,50	24,00	36,00	DL16	13,00	1,50
UJDV1600X6CQK	16,00	15,50	24,00	36,00	DL16	13,00	2,00
UJDV1600X6CQL	16,00	15,50	24,00	36,00	DL16	13,00	2,50
UJDV1600X6CQM	16,00	15,50	24,00	36,00	DL16	13,00	3,00
UJDV2000X6CQG	20,00	19,30	30,00	45,00	DL20	16,00	1,00
UJDV2000X6CQK	20,00	19,30	30,00	45,00	DL20	16,00	2,00
UJDV2000X6CQL	20,00	19,30	30,00	45,00	DL20	16,00	2,50
UJDV2000X6CQM	20,00	19,30	30,00	45,00	DL20	16,00	3,00
UJDV2000X6CQN	20,00	19,30	30,00	45,00	DL20	16,00	4,00
UJDV2500X6CQL	25,00	24,00	37,50	56,50	DL25	21,00	2,50
UJDV2500X6CQN	25,00	24,00	37,50	56,50	DL25	21,00	4,00
UJDV3200X6CQL	32,00	31,00	48,00	71,70	DL32	28,00	2,50
UJDV3200X6CQN	32,00	31,00	48,00	71,70	DL32	28,00	4,00

NOTE: For application data, please see page O17.

HARVI III • UJDV • Unequal Flute Spacing • Roughing



Material Group		Side Milling (A)		short			medium			long			Recommended feed per tooth (fz = mm/th) for side milling (A).						
		A		adaptor reach KCSM15 Cutting Speed — vc m/min			adaptor reach KCSM15 Cutting Speed — vc m/min			adaptor reach KCSM15 Cutting Speed — vc m/min			D1 — Diameter						
		ap	ae	min		max	min		max	min		max	mm	10,0	12,0	16,0	20,0	25,0	32,0
P	4	Ap max	0,4 x D	90	–	150	81	–	135	81	–	135	fz	0,046	0,053	0,065	0,075	0,083	0,087
	5	Ap max	0,4 x D	60	–	100	51	–	85	48	–	80	fz	0,041	0,048	0,059	0,069	0,077	0,084
M	1	Ap max	0,4 x D	90	–	115	72	–	92	63	–	80,5	fz	0,051	0,060	0,074	0,086	0,097	0,105
	2	Ap max	0,4 x D	60	–	80	48	–	64	42	–	56	fz	0,041	0,048	0,059	0,069	0,077	0,084
	3	Ap max	0,4 x D	60	–	70	48	–	56	42	–	49	fz	0,034	0,040	0,048	0,055	0,060	0,062
S	1	Ap max	0,4 x D	50	–	90	40	–	72	30	–	54	fz	0,051	0,060	0,074	0,086	0,097	0,105
	2	Ap max	0,4 x D	25	–	40	20	–	32	15	–	24	fz	0,027	0,032	0,039	0,046	0,052	0,057
	3	Ap max	0,4 x D	25	–	40	20	–	32	15	–	24	fz	0,027	0,032	0,039	0,046	0,052	0,057
	4	Ap max	0,4 x D	50	–	60	40	–	48	30	–	36	fz	0,038	0,044	0,055	0,063	0,071	0,077
H	1	Ap max	0,4 x D	80	–	140	64	–	112	48	–	84	fz	0,046	0,053	0,065	0,075	0,083	0,087
	2	Ap max	0,4 x D	70	–	120	56	–	96	42	–	72	fz	0,034	0,040	0,048	0,055	0,060	0,062

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. Please adjust parameters according to system stability.
For side milling with ap larger than 1 x D, reduce fz by 20%!
Cylindrical shanks not recommended for full slotting.

HARVI III • UJDV • Unequal Flute Spacing • Finishing

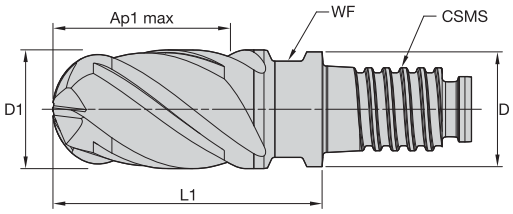


Material Group		Side Milling (A)		short			medium			long			Recommended feed per tooth (fz = mm/th) for side milling (A).						
		A		adaptor reach KCSM15 Cutting Speed — vc m/min			adaptor reach KCSM15 Cutting Speed — vc m/min			adaptor reach KCSM15 Cutting Speed — vc m/min			D1 — Diameter						
		ap	ae	min		max	min		max	min		max	mm	10,0	12,0	16,0	20,0	25,0	32,0
P	4	Ap max	0,06 x D	171	–	285	153,9	–	256,5	153,9	–	256,5	fz	0,046	0,053	0,065	0,075	0,083	0,087
	5	Ap max	0,06 x D	114	–	190	96,9	–	161,5	91,2	–	152	fz	0,041	0,048	0,059	0,069	0,077	0,084
M	1	Ap max	0,06 x D	171	–	218,5	136,8	–	174,8	119,7	–	152,95	fz	0,051	0,060	0,074	0,086	0,097	0,105
	2	Ap max	0,06 x D	114	–	152	91,2	–	121,6	79,8	–	106,4	fz	0,041	0,048	0,059	0,069	0,077	0,084
	3	Ap max	0,06 x D	114	–	133	91,2	–	106,4	79,8	–	93,1	fz	0,034	0,040	0,048	0,055	0,060	0,062
S	1	Ap max	0,06 x D	95	–	171	76	–	136,8	57	–	102,6	fz	0,051	0,060	0,074	0,086	0,097	0,105
	2	Ap max	0,06 x D	47,5	–	76	38	–	60,8	28,5	–	45,6	fz	0,027	0,032	0,039	0,046	0,052	0,057
	3	Ap max	0,06 x D	47,5	–	76	38	–	60,8	28,5	–	45,6	fz	0,027	0,032	0,039	0,046	0,052	0,057
	4	Ap max	0,06 x D	95	–	114	76	–	91,2	57	–	68,4	fz	0,038	0,044	0,055	0,063	0,071	0,077
H	1	Ap max	0,06 x D	152	–	266	121,6	–	212,8	91,2	–	159,6	fz	0,046	0,053	0,065	0,075	0,083	0,087
	2	Ap max	0,06 x D	133	–	228	106,4	–	182,4	79,8	–	136,8	fz	0,034	0,040	0,048	0,055	0,060	0,062

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. Please adjust parameters according to system stability.
For side milling with ap larger than 1 x D, reduce fz by 20%!
Cylindrical shanks not recommended for full slotting.

- Asymmetrical flute spacing and variable helix configuration minimise chatter and harmonics for smoother machining.
- Centre cutting.
- Single tool for both roughing and finishing operations, reducing setups.
- Standard items listed. Additional styles and coatings made-to-order.



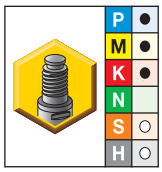




End Mill Tolerances

D1	tolerance e8
> 10–18	-0,032/-0,059
> 18–30	-0,040/-0,073

UKBV • 4-Flute Ball Nose • Metric



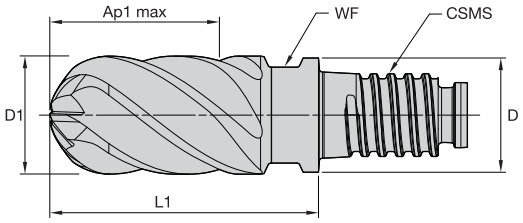
● first choice
○ alternate choice

KCPM15	D1	D	Ap1 max	L1	CSMS system size	WF
UKBV1000X4CN	10,00	9,60	15,00	22,50	DL10	8,00
UKBV1200X4CN	12,00	11,50	18,00	27,00	DL12	9,50
UKBV1600X4CN	16,00	15,50	24,00	36,00	DL16	13,00
UKBV2000X4CN	20,00	19,30	30,00	45,00	DL20	16,00
UKBV2500X4CN	25,00	24,00	37,50	56,50	DL25	21,00

NOTE: For application data, please see page O20.

- Unequal flute spacing and variable helix configuration minimise chatter and harmonics for smoother machining.
- Centre cutting.
- Optimised geometry for titanium machining.
- Single tool for both roughing and finishing operations, reducing setups.
- Standard items listed. Additional styles and coatings made-to-order.



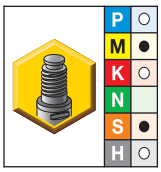




End Mill Tolerances

D1	tolerance e8
> 10–18	-0,032/-0,059
> 18–30	-0,040/-0,073

UJBV • 6-Flute Ball Nose with Eccentric Relief Grind • Metric

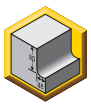


● first choice
○ alternate choice

KCSM15	D1	D	Ap1 max	L1	CSMS system size	WF
UJBV1000X6CN	10,00	9,60	15,00	22,50	DL10	8,00
UJBV1200X6CN	12,00	11,50	18,00	27,00	DL12	9,50
UJBV1600X6CN	16,00	15,50	24,00	36,00	DL16	13,00
UJBV2000X6CN	20,00	19,30	30,00	45,00	DL20	16,00
UJBV2500X6CN	25,00	24,00	37,50	56,50	DL25	21,00

NOTE: For application data, please see pages O21–O22.

HARVI Ball Nose • UKBV • Asymmetrical Flute Spacing • Roughing • Finishing





Material Group		Side Milling (A) and Slotting (B)			short			medium			long			Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 20%.					
		A		B	adaptor reach KCPM15 Cutting Speed — vc m/min			adaptor reach KCPM15 Cutting Speed — vc m/min			adaptor reach KCPM15 Cutting Speed — vc m/min			D1 — Diameter					
		ap	ae	ap	min		max	min		max	min		max	mm	10,0	12,0	16,0	20,0	25,0
P	0	1,25 x D	0,5 x D	1 x D	150	–	200	135	–	180	135	–	180	fz	0,061	0,070	0,086	0,097	0,105
	1	1,25 x D	0,5 x D	1 x D	150	–	200	135	–	180	135	–	180	fz	0,061	0,070	0,086	0,097	0,105
	2	1,25 x D	0,5 x D	1 x D	140	–	190	126	–	171	126	–	171	fz	0,061	0,070	0,086	0,097	0,105
	3	1,25 x D	0,5 x D	1 x D	120	–	160	108	–	144	108	–	144	fz	0,051	0,060	0,074	0,086	0,097
	4	1,25 x D	0,4 x D	0,75 x D	90	–	150	81	–	135	81	–	135	fz	0,046	0,053	0,065	0,075	0,083
	5	1,25 x D	0,4 x D	1 x D	60	–	100	51	–	85	48	–	80	fz	0,041	0,048	0,059	0,069	0,077
	6	1,25 x D	0,4 x D	0,75 x D	50	–	75	42,5	–	63,75	40	–	60	fz	0,034	0,040	0,048	0,055	0,060
M	1	1,25 x D	0.4 x D	1 x D	90	–	115	72	–	92	63	–	80,5	fz	0,051	0,060	0,074	0,086	0,097
	2	1,25 x D	0,4 x D	1 x D	60	–	80	48	–	64	42	–	56	fz	0,041	0,048	0,059	0,069	0,077
	3	1,25 x D	0,4 x D	1 x D	60	–	70	48	–	56	42	–	49	fz	0,034	0,040	0,048	0,055	0,060
K	1	1,25 x D	0,5 x D	1 x D	120	–	150	108	–	135	108	–	135	fz	0,061	0,070	0,086	0,097	0,105
	2	1,25 x D	0,5 x D	1 x D	110	–	140	99	–	126	99	–	126	fz	0,051	0,060	0,074	0,086	0,097
	3	1,25 x D	0,5 x D	1 x D	110	–	130	99	–	117	99	–	117	fz	0,041	0,048	0,059	0,069	0,077
S	1	1 x D	0,3 x D	0,3 x D	50	–	90	40	–	72	30	–	54	fz	0,051	0,060	0,074	0,086	0,097
	2	1 x D	0,3 x D	0,3 x D	25	–	40	20	–	32	15	–	24	fz	0,027	0,032	0,039	0,046	0,052
	3	1,25 x D	0,3 x D	0,3 x D	25	–	40	20	–	32	15	–	24	fz	0,027	0,032	0,039	0,046	0,052
	4	1,25 x D	0,4 x D	1 x D	50	–	60	40	–	48	30	–	36	fz	0,038	0,044	0,055	0,063	0,071
H	1	1,25 x D	0,4 x D	0,75 x D	80	–	140	64	–	112	48	–	84	fz	0,046	0,053	0,065	0,075	0,083
	2	1,25 x D	0,2 x D	0,5 x D	70	–	120	56	–	96	42	–	72	fz	0,034	0,040	0,048	0,055	0,060

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. Please adjust parameters according to system stability.
For side milling with ap larger than 1 x D, reduce fz by 20%!
Cylindrical shanks not recommended for full slotting.

HARVI III Ball Nose • UJBV • Unequal Flute Spacing • Roughing



Material Group		Side Milling (A)		short			medium			long			Recommended feed per tooth (fz = mm/th) for side milling (A).					
		A		adaptor reach KCSM15 Cutting Speed — vc m/min			KCSM15 Cutting Speed — vc m/min			KCSM15 Cutting Speed — vc m/min			D1 — Diameter					
		ap	ae	min		max	min		max	min		max	mm	10,0	12,0	16,0	20,0	25,0
P	0	Ap max	0,4 x D	150	–	200	135	–	180	135	–	180	fz	0,052	0,060	0,073	0,082	0,089
	1	Ap max	0,4 x D	150	–	200	135	–	180	135	–	180	fz	0,052	0,060	0,073	0,082	0,089
	2	Ap max	0,4 x D	140	–	190	126	–	171	126	–	171	fz	0,052	0,060	0,073	0,082	0,089
	3	Ap max	0,4 x D	120	–	160	108	–	144	108	–	144	fz	0,044	0,051	0,063	0,073	0,082
	4	Ap max	0,4 x D	90	–	150	81	–	135	81	–	135	fz	0,039	0,045	0,055	0,064	0,070
	5	Ap max	0,4 x D	60	–	100	51	–	85	48	–	80	fz	0,035	0,041	0,050	0,058	0,066
	6	Ap max	0,4 x D	50	–	75	42,5	–	63,75	40	–	60	fz	0,029	0,034	0,041	0,047	0,051
M	1	Ap max	0,4 x D	90	–	115	72	–	92	63	–	80,5	fz	0,044	0,051	0,063	0,073	0,082
	2	Ap max	0,4 x D	60	–	80	48	–	64	42	–	56	fz	0,035	0,041	0,050	0,058	0,066
	3	Ap max	0,4 x D	60	–	70	48	–	56	42	–	49	fz	0,029	0,034	0,041	0,047	0,051
K	1	Ap max	0,4 x D	120	–	150	108	–	135	108	–	135	fz	0,052	0,060	0,073	0,082	0,089
	2	Ap max	0,4 x D	110	–	140	99	–	126	99	–	126	fz	0,044	0,051	0,063	0,073	0,082
	3	Ap max	0,4 x D	110	–	130	99	–	117	99	–	117	fz	0,035	0,041	0,050	0,058	0,066
S	1	Ap max	0,4 x D	50	–	90	40	–	72	30	–	54	fz	0,044	0,051	0,063	0,073	0,082
	2	Ap max	0,4 x D	25	–	40	20	–	32	15	–	24	fz	0,023	0,027	0,034	0,039	0,044
	3	Ap max	0,4 x D	25	–	40	20	–	32	15	–	24	fz	0,023	0,027	0,034	0,039	0,044
	4	Ap max	0,4 x D	50	–	60	40	–	48	30	–	36	fz	0,032	0,037	0,046	0,054	0,060
H	1	Ap max	0,4 x D	80	–	140	64	–	112	48	–	84	fz	0,039	0,045	0,055	0,064	0,070
	2	Ap max	0,4 x D	70	–	120	56	–	96	42	–	72	fz	0,029	0,034	0,041	0,047	0,051

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. Please adjust parameters according to system stability.
For side milling with ap larger than 1 x D, reduce fz by 20%!
Cylindrical shanks not recommended for full slotting.

HARVI III Ball Nose • UJBV • Unequal Flute Spacing • Finishing



Material Group		Side Milling (A)		short			medium			long			Recommended feed per tooth (fz = mm/th) for side milling (A).					
		A		adaptor reach									D1 — Diameter					
				KCSM15			KCSM15			KCSM15								
				Cutting Speed — vc m/min			Cutting Speed — vc m/min			Cutting Speed — vc m/min								
		ap	ae	min		max	min		max	min		max	mm	10,0	12,0	16,0	20,0	25,0
P	0	Ap max	0,06 x D	285	–	380	257	–	342	257	–	342	fz	0,061	0,070	0,086	0,097	0,105
	1	Ap max	0,06 x D	285	–	380	257	–	342	257	–	342	fz	0,061	0,070	0,086	0,097	0,105
	2	Ap max	0,06 x D	266	–	361	239	–	325	239	–	325	fz	0,061	0,070	0,086	0,097	0,105
	3	Ap max	0,06 x D	228	–	304	205	–	274	205	–	274	fz	0,051	0,060	0,074	0,086	0,097
	4	Ap max	0,06 x D	171	–	285	154	–	257	154	–	257	fz	0,046	0,053	0,065	0,075	0,083
	5	Ap max	0,06 x D	114	–	190	97	–	162	91	–	152	fz	0,041	0,048	0,059	0,069	0,077
	6	Ap max	0,06 x D	95	–	143	81	–	121	76	–	114	fz	0,034	0,040	0,048	0,055	0,060
M	1	Ap max	0,06 x D	171	–	219	137	–	175	120	–	153	fz	0,051	0,060	0,074	0,086	0,097
	2	Ap max	0,06 x D	114	–	152	91	–	122	80	–	106	fz	0,041	0,048	0,059	0,069	0,077
	3	Ap max	0,06 x D	114	–	133	91	–	106	80	–	93	fz	0,034	0,040	0,048	0,055	0,060
K	1	Ap max	0,06 x D	228	–	285	205	–	257	205	–	257	fz	0,061	0,070	0,086	0,097	0,105
	2	Ap max	0,06 x D	209	–	266	188	–	239	188	–	239	fz	0,051	0,060	0,074	0,086	0,097
	3	Ap max	0,06 x D	209	–	247	188	–	222	188	–	222	fz	0,041	0,048	0,059	0,069	0,077
S	1	Ap max	0,06 x D	95	–	171	76	–	137	57	–	103	fz	0,051	0,060	0,074	0,086	0,097
	2	Ap max	0,06 x D	48	–	76	38	–	61	29	–	46	fz	0,027	0,032	0,039	0,046	0,052
	3	Ap max	0,06 x D	48	–	76	38	–	61	29	–	46	fz	0,027	0,032	0,039	0,046	0,052
	4	Ap max	0,06 x D	95	–	114	76	–	91	57	–	68	fz	0,038	0,044	0,055	0,063	0,071
H	1	Ap max	0,06 x D	152	–	266	122	–	213	91	–	160	fz	0,046	0,053	0,065	0,075	0,083
	2	Ap max	0,06 x D	133	–	228	106	–	182	80	–	137	fz	0,034	0,040	0,048	0,055	0,060

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. Please adjust parameters according to system stability.
For side milling with ap larger than 1 x D, reduce fz by 20%!
Cylindrical shanks not recommended for full slotting.



Duo-Lock™ HARVI™ III

CHALLENGE

- Facing steel (1215) material.
- External emulsion.
- Current solution solid carbide.

SOLUTION

- Duo-Lock™ Ø 15,875mm
- HARVI III UJDV
- Corner Radius R = 0,4mm

CUTTING DATA

- v_c 213 m/min
- f_z 0,05 mm/Z
- a_p 1,27mm
- a_e 12,0mm

RESULT

- 40% higher feed per tooth.
- 15% increase in cutting speed.
- Good surface finish and minimum wear on edges.

BENEFIT

- Reduced machining time.
- Increased productivity.
- Reduced tooling cost.



Duo-Lock™ HARVI

CHALLENGE

- Roughing of sensor mounting slot in cast iron.
- External emulsion.
- Current solution solid carbide.

SOLUTION

- Duo-Lock™ Ø 16mm — cylindrical shank
- HARVI UKDV
- Corner Radius R = 0,5mm

CUTTING DATA

- v_c 58 m/min
- f_z 0,065 mm/Z
- a_p 22mm
- a_e 8,0mm

RESULT

- Less wear.
- More stable process.

BENEFIT

- No unpredictable breakage like with competitive solid carbide tool.
- Stable machining process.

(continued)

(continued)



Duo-Lock™ HARVI™ III

CHALLENGE

- Finishing contour milling with lightly interrupted cut.
- Blade machining of X20Cr and X22Cr (M3).
- External emulsion.
- Current solution solid carbide.

SOLUTION

- Duo-Lock™ Ø 16mm – cylindrical shank
- HydroForce™ with reducer sleeve
- HARVI III UJDV geometry in KCSM15™
- Corner Radius R = 4mm

CUTTING DATA

- v_c 350 m/min
- f_z 0,12 mm/Z
- a_p 0,5mm
- a_e 4,0mm

RESULT

- Tool life increased from 34 to 103 parts.
- Machining time per part reduced by 50%.

BENEFIT

- Increase of productivity.
- Cost reduction through almost triple tool life.
- Improved surface finish.



Duo-Lock™ HARVI III

CHALLENGE

- Hard machining — side milling.
- Hardened steel (17–4 PH) — 35 HRC.
- External emulsion.
- Current solution solid carbide.

SOLUTION

- Duo-Lock™ Ø 15,875mm
- HARVI III UJDV
- Corner Radius R = 0,4mm

CUTTING DATA

- v_c 224 m/min
- f_z 0,113 mm/Z
- a_p 15,25mm
- a_e 0,76mm

RESULT

- 15% increase in cutting speed.
- Good surface finish and minimum wear on edges.

BENEFIT

- Increased productivity.
- Reduced tooling cost.
- Long reach capability.

CFRP Machining Tooling

KCN05™

Engineered for machining difficult CFRP (Carbon-Fibre Reinforced Polymer) and non-ferrous components. KCN05 solid carbide tooling provides excellent tool life and produces smooth finishes with improved edge quality.

- Excellent tool life due to KCN05 diamond-film coating.
- Proprietary substrate improves coating adhesion to extend tool life.
- Design minimises delamination and bur formation.
- Compression-style end mills for trimming operations.
- Left-hand down cut and ball nose cutters for machining cavities.
- Bur-style router for highest Metal Removal Rates (MRR).



Visit **kennametal.com** or contact your local Authorised Kennametal Distributor.

KENNAMETAL®

kennametal.com

DUO-λOCK® MaxiMet™

High-Performance Modular Solid Carbide End Mills

Primary Application

The MaxiMet system provides extraordinary metal removal rates by combining roughing and finishing operations with any aluminium plunging, slotting, and profiling application. Its proprietary flute geometry is designed for high stiffness and improved chip evacuation to generate exceptional wall-to-floor perpendicularity, even in thin-wall applications. To ensure a superior floor surface finish, the MaxiMet front geometry is equipped with a wiper facet grind.

- Only one tool needed for roughing and finishing operations.
- Slotting depths up to 1 x D and side milling up to 0,5 x D radial and 1,5 x D axial engagement.
- Unequal flute spacing for chatter-free performance with 3-flute series.
- Multiple corner radii and extended neck configurations available as standard with 3-flute series.

Features and Benefits

Advanced Technology

- Increase output with fewer tool changes and higher metal removal rates.
- No specific tools necessary for roughing and finishing.
- Fewer passes due to 1 x D slotting capability.
- Perfect for MQL (minimum quantity lubrication) methods.

Tailored Grades

- K600 uncoated grade for longest tool life in aluminium and other non-ferrous materials.

Customisation

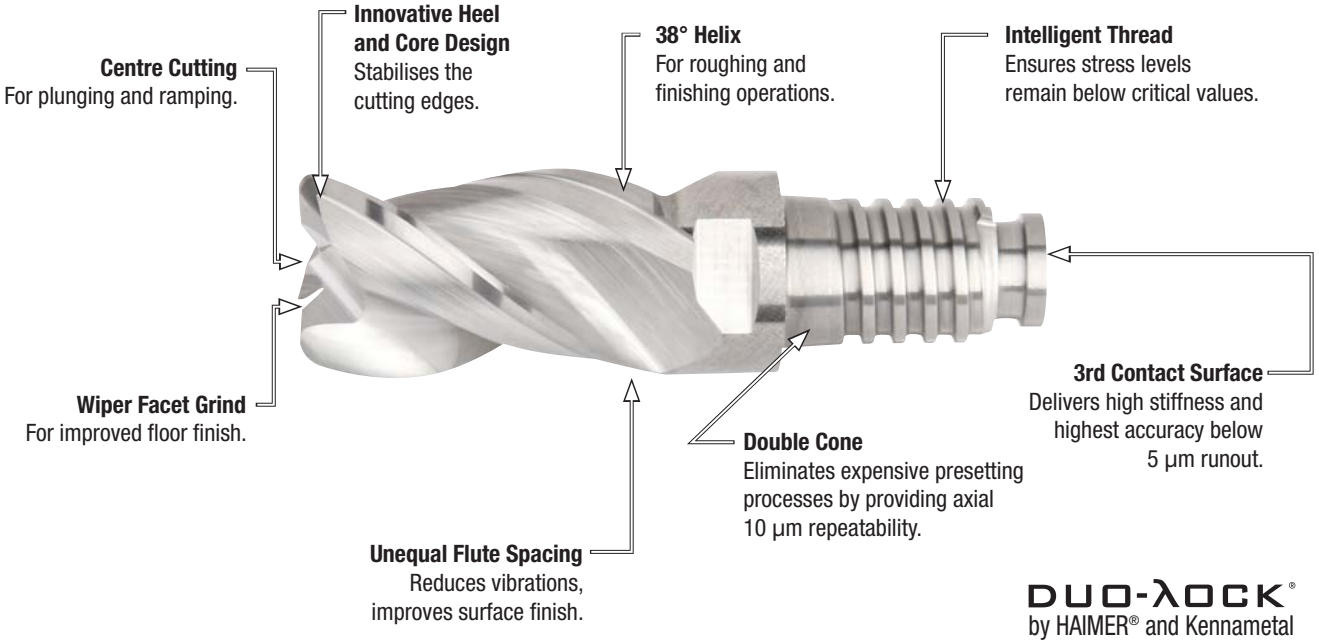
- Intermediate diameters are available between 10–32mm.

Extensive Standard Offering

- Diameter ranges 10–25mm.
- Necked, corner radii, and square-end tips available.
- Integral adaptors reduce the amount of interface for maximum accuracy. Steel extensions with Safe-Lock™ by HAIMER shanks prevent pullout.
- Cut-to-size extra-long extensions available upon request off the shelf.

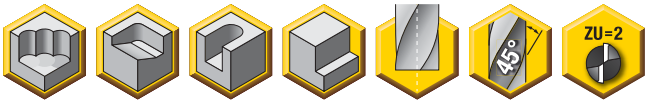
For high metal removal rates and superior surface finishes.

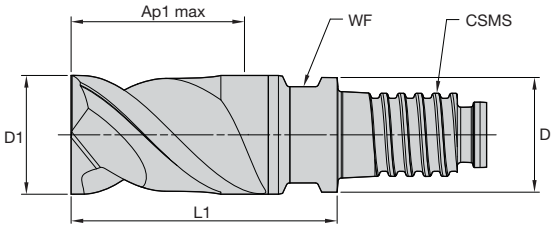




DUO-LOCK®
by HAIMER® and Kennametal

- Centre cutting.
- Optimised for thin wall applications.
- Wiper facet, special end gash, and flute geometry enable improved surface finishes.
- Standard items listed. Additional styles and coatings made-to-order.



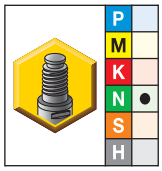




End Mill Tolerances

D1	tolerance e8
> 10–18	-0,032/-0,059
> 18–30	-0,040/-0,073

ABDF • 2 Flute • Metric

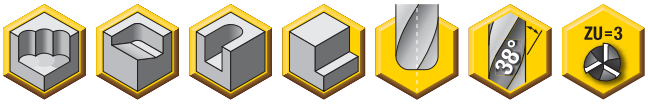


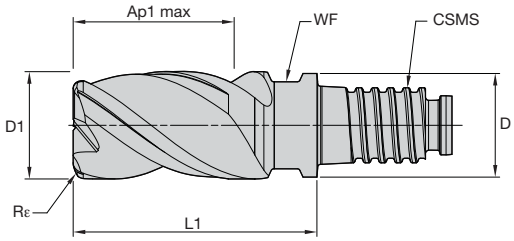
● first choice
○ alternate choice

K600	D1	D	Ap1 max	L1	CSMS system size	WF
ABDF1000X2CU	10,00	9,60	15,00	22,50	DL10	8,00
ABDF1200X2CU	12,00	11,50	18,00	27,00	DL12	9,50
ABDF1600X2CU	16,00	15,50	24,00	36,00	DL16	13,00
ABDF2000X2CU	20,00	19,30	30,00	45,00	DL20	16,00

NOTE: For application data, please see page O30.

- Centre cutting.
- Optimised for thin wall applications.
- Wiper facet, special end gash, and flute geometry enable improved surface finishes.
- Standard items listed. Additional styles and coatings made-to-order.



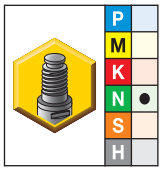




End Mill Tolerances

D1	tolerance e8
> 10–18	-0,032/-0,059
> 18–30	-0,040/-0,073

ABDE • 3 Flute • Metric



● first choice
○ alternate choice

K600	D1	D	Ap1 max	L1	CSMS system size	WF	Rε
ABDE1000X3CQE	10,00	9,60	15,00	22,50	DL10	8,00	0,50
ABDE1000X3CQG	10,00	9,60	15,00	22,50	DL10	8,00	1,00
ABDE1000X3CQJ	10,00	9,60	15,00	22,50	DL10	8,00	1,50
ABDE1200X3CQE	12,00	11,50	18,00	27,00	DL12	9,50	0,50
ABDE1200X3CQG	12,00	11,50	18,00	27,00	DL12	9,50	1,00
ABDE1200X3CQJ	12,00	11,50	18,00	27,00	DL12	9,50	1,50
ABDE1200X3CQL	12,00	11,50	18,00	27,00	DL12	9,50	2,50
ABDE1600X3CQG	16,00	15,50	24,00	36,00	DL16	13,00	1,00
ABDE1600X3CQJ	16,00	15,50	24,00	36,00	DL16	13,00	1,50
ABDE1600X3CQK	16,00	15,50	24,00	36,00	DL16	13,00	2,00
ABDE1600X3CQL	16,00	15,50	24,00	36,00	DL16	13,00	2,50
ABDE1600X3CQM	16,00	15,50	24,00	36,00	DL16	13,00	3,00
ABDE2000X3CQG	20,00	19,30	30,00	45,00	DL20	16,00	1,00
ABDE2000X3CQK	20,00	19,30	30,00	45,00	DL20	16,00	2,00
ABDE2000X3CQL	20,00	19,30	30,00	45,00	DL20	16,00	2,50
ABDE2000X3CQM	20,00	19,30	30,00	45,00	DL20	16,00	3,00
ABDE2000X3CQN	20,00	19,30	30,00	45,00	DL20	16,00	4,00
ABDE2500X3CQL	25,00	24,00	37,50	56,50	DL25	21,00	2,50
ABDE2500X3CQN	25,00	24,00	37,50	56,50	DL25	21,00	4,00

NOTE: For application data, please see page O30.

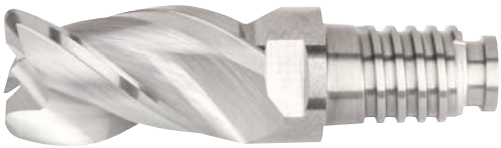
MaxiMet • ABDF • Wiper Facet



Material Group		Side Milling (A) and Slotting (B)			short			medium			long			Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 20%.				
		A		B	adaptor reach													
					K600			K600			K600			D1 — Diameter				
		Cutting Speed — vc m/min																
		ap	ae	ap	min		max	min		max	min		max	mm	10,0	12,0	16,0	20,0
N	1	1,5 x D	0,3 x D	1,0 x D	500	–	2000	400	–	1200	300	–	1200	fz	0,077	0,092	0,122	0,153
	2	1,5 x D	0,3 x D	1,0 x D	500	–	1500	400	–	900	300	–	900	fz	0,069	0,083	0,110	0,138
	3	1,5 x D	0,3 x D	1,0 x D	500	–	1500	400	–	900	300	–	900	fz	0,054	0,064	0,086	0,107
	4	1,5 x D	0,3 x D	1,0 x D	400	–	750	320	–	450	240	–	450	fz	0,054	0,064	0,086	0,107
	5	1,5 x D	0,3 x D	1,0 x D	250	–	1000	200	–	600	150	–	600	fz	0,069	0,083	0,110	0,138

NOTE: Ap for spindle with ceramic bearings multiply by 0,5.
For better surface finish, reduce feed per tooth.
Above parameters are based on ideal conditions. Please adjust parameters according to system stability.
For side milling with Ap bigger than 1 x D, reduce fz by 20%!
Cylindrical shanks not recommended for full slotting.

MaxiMet • ABDE • Wiper Facet • Unequal Flute Spacing



Material Group		Side Milling (A) and Slotting (B)			short			medium			long			Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 20%.				
		A		B	adaptor reach													
					K600			K600			K600			D1 — Diameter				
		Cutting Speed — vc m/min																
		ap	ae	ap	min		max	min		max	min		max	mm	10,0	12,0	16,0	20,0
N	1	1,5 x D	0,3 x D	1,0 x D	500	–	2000	400	–	1200	300	–	1200	fz	0,077	0,092	0,122	0,153
	2	1,5 x D	0,3 x D	1,0 x D	500	–	1500	400	–	900	300	–	900	fz	0,069	0,083	0,110	0,138
	3	1,5 x D	0,3 x D	1,0 x D	500	–	1500	400	–	900	300	–	900	fz	0,054	0,064	0,086	0,107
	4	1,5 x D	0,3 x D	1,0 x D	400	–	750	320	–	450	240	–	450	fz	0,054	0,064	0,086	0,107
	5	1,5 x D	0,3 x D	1,0 x D	250	–	1000	200	–	600	150	–	600	fz	0,069	0,083	0,110	0,138

NOTE: Ap for spindle with ceramic bearings multiply by 0,5.
For better surface finish, reduce feed per tooth.
Above parameters are based on ideal conditions. Please adjust parameters according to system stability.
For side milling with Ap bigger than 1 x D, reduce fz by 20%!
Cylindrical shanks not recommended for full slotting.

HARVI™ II Long

- Long wall semi- and fine-finishing.
- Significant straight wall accuracy.
- Thin wall machining up to 5 x D.
- Eliminates feed rate reduction in corner machining.
- For machining titanium, steels, and stainless steels.



KC643M™

- Universal grade suitable for cutting steel, cast iron, stainless steel, and titanium.

Advanced Technology

- Five unequally spaced flutes for chatter-free machining at high feed rates, improving surface finish and tool life.
- Innovative core design increases stability for exceptionally straight walls.

Visit **kennametal.com** or contact your local Authorised Kennametal Distributor.

KENNAMETAL®

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DUO-λOCK®

High-Performance Modular Roughing Solid Carbide End Mills

Primary Application

Duo-Lock™ high-performance roughing tools provide superior metal removal rates while reducing machine power consumption. Applicable on a wide range of workpiece materials such as steels, stainless steels, and difficult-to-machine materials. Tailored to roughing profiles, provides excellent chip management, and reduces cutting forces to the necessary level. Combines roughing and semi-finishing for fewer tool changes.

- High-performance universal tools for almost all cutting materials.
- Lowering cutting forces and spindle power consumption.
- Centre cutting for ramping, profiling, high-feed slotting, and side milling.

Features and Benefits

Advanced Technology

- Up to full length of cut for:
  - — Slotting
  - — Side milling
  - — Profiling
  - — Semi-finishing
- Various roughing profiles available to choose from for the right balance between cutting forces, feed rates, and surface quality.
- Fewer passes due to 1 x D slotting capability.

Tailored Grades

- KCPM15™ Beyond™ grade for outstanding wear protection in stainless steel to mitigate crater, depth-of-cut notching, and flank wear.
- KCSM15™ Beyond grade for exceptional tool life in titanium and stainless steels.

Customisation

- Intermediate diameters are available between 10–32mm.

Extensive Standard Offering

- Diameter ranges 10–25mm.
- Necked, corner radii, and chamfered tips offered.
- Integral adaptors reduce the amount of interface for maximum accuracy. Steel extensions with Safe-Lock™ by HAIMER shanks to prevent pullout.
- Cut-to-size extra-long extensions available upon request off the shelf.

For high metal removal rates and low power consumption.





Various Roughing Profiles
Tailored cord and shallow-pitch profile for improved chip formation.

Centre Cutting
For plunging and ramping.

Intelligent Thread
Ensures stress levels remain below critical values.

Various Helix Configurations
20° for roughing ISO P-M-K materials.
45° for roughing ISO S-M materials.

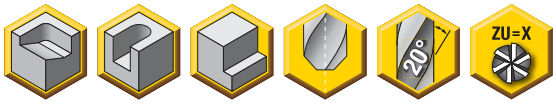
3rd Contact Surface
Delivers high stiffness and highest accuracy below 5 µm runout.

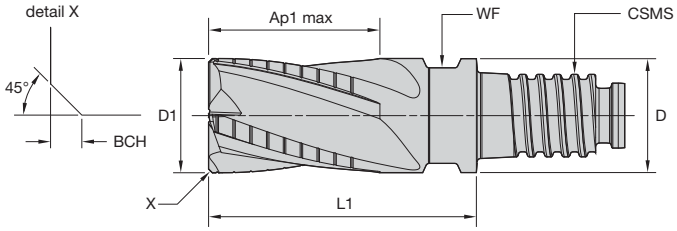
Double Cone
Eliminates expensive presetting processes by providing axial 10 µm repeatability.

KCPM15™ and KCSM15™ Grades
Long tool life.
Enables higher cutting speeds.

DUO-LOCK®
by HAIMER® and Kennametal

- Centre cutting.
- Cord profile reduces machine power consumption.
- Standard items listed. Additional styles and coatings made-to-order.



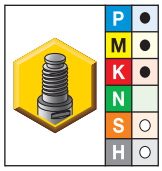




End Mill Tolerances

D1	tolerance d11
> 10–18	-0,050/-0,160
> 18–30	-0,065/-0,195

RQDB • Metric



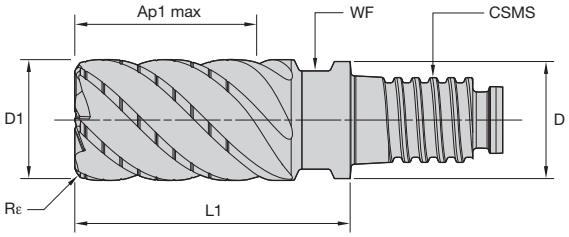
● first choice
○ alternate choice

KCPM15	D1	D	Ap1 max	L1	CSMS system size	WF	BCH	Z U
RQDB1000X4CV	10,00	9,60	15,00	22,50	DL10	8,00	0,50	4
RQDB1200X4CV	12,00	11,50	18,00	27,00	DL12	9,50	0,50	4
RQDB1600X4CV	16,00	15,50	24,00	36,00	DL16	13,00	0,50	4
RQDB2000X4CV	20,00	19,30	30,00	45,00	DL20	16,00	0,50	4
RQDB2500X5CV	25,00	24,00	37,50	56,50	DL25	21,00	0,50	5

NOTE: For application data, please see page O37.

- Centre cutting.
- Shallow-pitch profile reduces machine power consumption.
- Standard items listed. Additional styles and coatings made-to-order.



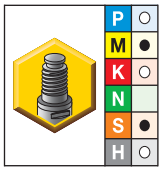




End Mill Tolerances

D1	tolerance d11
> 10–18	-0,050/-0,160
> 18–30	-0,065/-0,195

RKDF • Metric

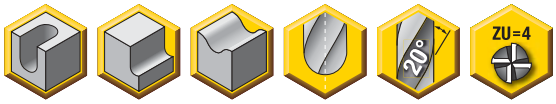


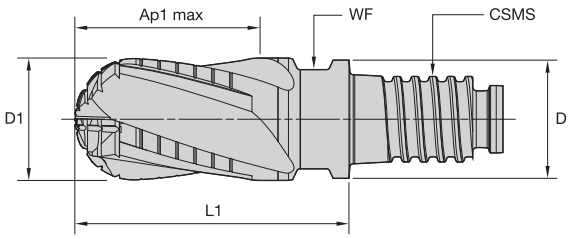
● first choice
○ alternate choice

KCSM15	D1	D	Ap1 max	L1	CSMS system size	WF	Rε	Z U
RKDF1000X4CQE	10,00	9,60	15,00	23,00	DL10	8,00	0,50	4
RKDF1200X4CQF	12,00	11,50	18,00	27,50	DL12	9,50	0,75	4
RKDF1600X6CQF	16,00	15,50	24,00	36,50	DL16	13,00	0,75	6
RKDF2000X6CQF	20,00	19,30	30,00	45,50	DL20	16,00	0,75	6
RKDF2500X6CQF	25,00	24,00	37,50	57,00	DL25	21,00	0,75	6

NOTE: For application data, please see page O38.

- Centre cutting.
- Cord profile reducing machine power consumption.
- Standard items listed. Additional styles and coatings made-to-order.



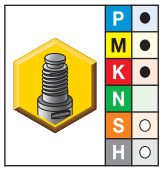




End Mill Tolerances

D1	tolerance d11
> 10–18	-0,050/-0,160
> 18–30	-0,065/-0,195

RQBB • Metric



● first choice
○ alternate choice

KCPM15	D1	D	Ap1 max	L1	CSMS system size	WF
RQBB1000X4CN	10,00	9,60	15,00	22,50	DL10	8,00
RQBB1200X4CN	12,00	11,50	18,00	27,00	DL12	9,50
RQBB1600X4CN	16,00	15,50	24,00	36,00	DL16	13,00
RQBB2000X4CN	20,00	19,30	30,00	45,00	DL20	16,00
RQBB2500X4CN	25,00	24,00	37,50	56,50	DL25	21,00

NOTE: For application data, please see page O39.

RQDB • Metric





Material Group		Side Milling (A) and Slotting (B)			short			medium			long			Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 20%.					
		A		B	adaptor reach									D1 — Diameter					
					KCPM15			KCPM15			KCPM15								
					Cutting Speed — vc m/min			Cutting Speed — vc m/min			Cutting Speed — vc m/min								
		ap	ae	ap	min		max	min		max	min		max	mm	10,0	12,0	16,0	20,0	25,0
P	0	1,5 x D	0,5 x D	1 x D	120	–	160	108	–	144	108	–	144	fz	0,061	0,070	0,086	0,097	0,105
	1	1,5 x D	0,5 x D	1 x D	120	–	160	108	–	144	108	–	144	fz	0,061	0,070	0,086	0,097	0,105
	2	1,5 x D	0,5 x D	1 x D	112	–	152	100,8	–	136,8	100,8	–	136,8	fz	0,061	0,070	0,086	0,097	0,105
	3	1,5 x D	0,4 x D	0,75 x D	96	–	128	86,4	–	115,2	86,4	–	115,2	fz	0,051	0,060	0,074	0,086	0,097
	4	1,5 x D	0,3 x D	0,3 x D	72	–	120	64,8	–	108	64,8	–	108	fz	0,046	0,053	0,065	0,075	0,083
	5	1,5 x D	0,4 x D	0,75 x D	48	–	80	40,8	–	68	38,4	–	64	fz	0,041	0,048	0,059	0,069	0,077
M	1	1,5 x D	0,4 x D	0,75 x D	72	–	92	57,6	–	73,6	50,4	–	64,4	fz	0,051	0,060	0,074	0,086	0,097
	2	1,5 x D	0,4 x D	0,75 x D	48	–	64	38,4	–	51,2	33,6	–	44,8	fz	0,041	0,048	0,059	0,069	0,077
	3	1,5 x D	0,4 x D	0,75 x D	48	–	56	38,4	–	44,8	33,6	–	39,2	fz	0,034	0,040	0,048	0,055	0,060
K	1	1,5 x D	0,5 x D	1 x D	96	–	120	86,4	–	108	86,4	–	108	fz	0,061	0,070	0,086	0,097	0,105
	2	1,5 x D	0,4 x D	1 x D	88	–	112	79,2	–	100,8	79,2	–	100,8	fz	0,051	0,060	0,074	0,086	0,097
	3	1,5 x D	0,4 x D	1 x D	88	–	104	79,2	–	93,6	79,2	–	93,6	fz	0,041	0,048	0,059	0,069	0,077
S	1	1,5 x D	0,4 x D	0,75 x D	40	–	72	32	–	57,6	24	–	43,2	fz	0,051	0,060	0,074	0,086	0,097
	3	1,5 x D	0,4 x D	0,75 x D	20	–	32	16	–	25,6	12	–	19,2	fz	0,027	0,032	0,039	0,046	0,052
H	1	1,5 x D	0,3 x D	0,3 x D	64	–	112	51,2	–	89,6	38,4	–	67,2	fz	0,046	0,053	0,065	0,075	0,083

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. Please adjust parameters according to system stability.
For side milling with ap larger than 1 x D, reduce fz by 20%!
Cylindrical shanks not recommended for full slotting.

RKDF • Metric

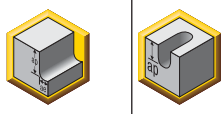




Material Group		Side Milling (A) and Slotting (B)			short			medium			long			Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 20%.					
		A		B	adaptor reach									D1 — Diameter					
					KCSM15			KCSM15			KCSM15								
					Cutting Speed — vc m/min			Cutting Speed — vc m/min			Cutting Speed — vc m/min								
		ap	ae	ap	min		max	min		max	min		max	mm	10,0	12,0	16,0	20,0	25,0
P	3	1,0 x D	0,5 x D	0,75 x D	120	–	160	108	–	144	108	–	144	fz	0,051	0,060	0,074	0,086	0,097
	4	1,0 x D	0,3 x D	0,75 x D	90	–	150	81	–	135	81	–	135	fz	0,046	0,053	0,065	0,075	0,083
	5	1,0 x D	0,4 x D	0,75 x D	60	–	100	51	–	85	48	–	80	fz	0,041	0,048	0,059	0,069	0,077
	6	1,0 x D	0,3 x D	0,3 x D	50	–	75	42,5	–	63,75	40	–	60	fz	0,034	0,040	0,048	0,055	0,060
M	1	1,0 x D	0,4 x D	0,75 x D	90	–	115	72	–	92	63	–	80,5	fz	0,051	0,060	0,074	0,086	0,097
	2	1,0 x D	0,4 x D	0,75 x D	60	–	80	48	–	64	42	–	56	fz	0,041	0,048	0,059	0,069	0,077
	3	1,0 x D	0,4 x D	0,75 x D	60	–	70	48	–	56	42	–	49	fz	0,034	0,040	0,048	0,055	0,060
K	1	1,0 x D	0,5 x D	1 x D	120	–	150	108	–	135	108	–	135	fz	0,061	0,070	0,086	0,097	0,105
	2	1,0 x D	0,5 x D	1 x D	110	–	140	99	–	126	99	–	126	fz	0,051	0,060	0,074	0,086	0,097
	3	1,0 x D	0,5 x D	1 x D	110	–	130	99	–	117	99	–	117	fz	0,041	0,048	0,059	0,069	0,077
S	1	1,0 x D	0,3 x D	0,75 x D	50	–	90	40	–	72	30	–	54	fz	0,051	0,060	0,074	0,086	0,097
	2	1,0 x D	0,3 x D	0,75 x D	25	–	40	20	–	32	15	–	24	fz	0,027	0,032	0,039	0,046	0,052
	3	1,0 x D	0,3 x D	0,75 x D	25	–	40	20	–	32	15	–	24	fz	0,027	0,032	0,039	0,046	0,052
	4	1,0 x D	0,4 x D	0,75 x D	50	–	60	40	–	48	30	–	36	fz	0,038	0,044	0,055	0,063	0,071
H	1	1,0 x D	0,3 x D	0,3 x D	80	–	140	64	–	112	48	–	84	fz	0,046	0,053	0,065	0,075	0,083
	2	1,0 x D	0,2 x D	0,2 x D	70	–	120	56	–	96	42	–	72	fz	0,034	0,040	0,048	0,055	0,060
	3	1,0 x D	0,2 x D	0,2 x D	60	–	90	48	–	72	36	–	54	fz	0,027	0,032	0,039	0,046	0,052

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. Please adjust parameters according to system stability.
For side milling with Ap bigger than 1 x D, reduce fz by 20%!
Cylindrical shanks not recommended for full slotting.

RQBB • Metric





Material Group		Side Milling (A) and Slotting (B)			short			medium			long			Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 20%.					
		A		B	adaptor reach									D1 — Diameter					
					KCPM15			KCPM15			KCPM15								
					Cutting Speed — vc m/min			Cutting Speed — vc m/min			Cutting Speed — vc m/min								
		ap	ae	ap	min		max	min		max	min		max	mm	10,0	12,0	16,0	20,0	25,0
P	0	1,5 x D	0,5 x D	1 x D	150	–	200	135	–	180	135	–	180	fz	0,061	0,070	0,086	0,097	0,105
	1	1,5 x D	0,5 x D	1 x D	150	–	200	135	–	180	135	–	180	fz	0,061	0,070	0,086	0,097	0,105
	2	1,5 x D	0,5 x D	1 x D	140	–	190	126	–	171	126	–	171	fz	0,061	0,070	0,086	0,097	0,105
	3	1,5 x D	0,4 x D	0,75 x D	120	–	160	108	–	144	108	–	144	fz	0,051	0,060	0,074	0,086	0,097
	4	1,5 x D	0,3 x D	0,3 x D	90	–	150	81	–	135	81	–	135	fz	0,046	0,053	0,065	0,075	0,083
	5	1,5 x D	0,4 x D	0,75 x D	60	–	100	51	–	85	48	–	80	fz	0,041	0,048	0,059	0,069	0,077
	6	1,5 x D	0,3 x D	0,3 x D	50	–	75	42,5	–	63,75	40	–	60	fz	0,034	0,040	0,048	0,055	0,060
M	1	1,5 x D	0,4 x D	0,75 x D	90	–	115	72	–	92	63	–	80,5	fz	0,051	0,060	0,074	0,086	0,097
	2	1,5 x D	0,4 x D	0,75 x D	60	–	80	48	–	64	42	–	56	fz	0,041	0,048	0,059	0,069	0,077
	3	1,5 x D	0,4 x D	0,75 x D	60	–	70	48	–	56	42	–	49	fz	0,034	0,040	0,048	0,055	0,060
K	1	1,5 x D	0,5 x D	1 x D	120	–	150	108	–	135	108	–	135	fz	0,061	0,070	0,086	0,097	0,105
	2	1,5 x D	0,4 x D	1 x D	110	–	140	99	–	126	99	–	126	fz	0,051	0,060	0,074	0,086	0,097
	3	1,5 x D	0,4 x D	1 x D	110	–	130	99	–	117	99	–	117	fz	0,041	0,048	0,059	0,069	0,077
S	1	1,5 x D	0,4 x D	0,75 x D	50	–	90	40	–	72	30	–	54	fz	0,051	0,060	0,074	0,086	0,097
	2	1,5 x D	0,3 x D	0,3 x D	25	–	40	20	–	32	15	–	24	fz	0,027	0,032	0,039	0,046	0,052
	3	1,5 x D	0,3 x D	0,3 x D	25	–	40	20	–	32	15	–	24	fz	0,027	0,032	0,039	0,046	0,052
	4	1,5 x D	0,3 x D	0,75 x D	50	–	60	40	–	48	30	–	36	fz	0,038	0,044	0,055	0,063	0,071
H	1	1,5 x D	0,3 x D	0,3 x D	80	–	140	64	–	112	48	–	84	fz	0,046	0,053	0,065	0,075	0,083
	2	1,5 x D	0,2 x D	0,2 x D	70	–	120	56	–	96	42	–	72	fz	0,034	0,040	0,048	0,055	0,060
	3	1,5 x D	0,2 x D	0,2 x D	60	–	90	48	–	72	36	–	54	fz	0,027	0,032	0,039	0,046	0,052

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. Please adjust parameters according to system stability.
For side milling with Ap bigger than 1 x D, reduce fz by 20%!
Cylindrical shanks not recommended for full slotting.

DUO-λOCK®

High-Performance Modular Finishing Solid Carbide End Mills

Primary Application

Duo-Lock™ high-performance finishing tools are designed for machining titanium, steels, and stainless steels with excellent surface finishes at maximum Metal Removal Rates (MRR) in two basic geometries. The FMDF geometry is perfectly suited for finishing steels and stainless steels. The Duo-Lock™ RSM II geometry is designed for high-speed peel milling with secure chip formation and evacuation in deep cavities with the maximum amount of edges at a given diameter.

- Specifically designed geometries for finishing in a wide range of materials.
- Higher number of flutes and higher helix angles for super finishing applications.
- High metal removal rates for fewer passes, longer tool life, and superior surface finishes.

Features and Benefits

Advanced Technology

- RSM II FSDE geometry:
  - — Maximum number of flutes increases feed rates and reduces vibration.
  - — Proprietary W-shaped flute form improves chip formation and reduces cutting forces.
  - — Unequal flute spacing increases tool life and surface quality.
- FMDF geometry:
  - — Excellent geometry for steels and stainless steel.
  - — Protection radii helps extend tool life.

Tailored Grades

- KCPM15™ Beyond™ grade for outstanding wear protection in stainless steel to mitigate cratering, depth-of-cut notching, and flank wear.
- KC643M™ grade provides highest fine finishing and longest tool life.

Customisation

- Intermediate diameters are available from 10–32mm.

Extensive Standard Offering

- Diameter ranges 10–25mm.
- Necked and corner radii tips available.
- Integral adaptors reduce the amount of interface for maximum accuracy. Steel extensions with Safe-Lock™ by HAIMER shanks prevent pullout.
- Cut-to-size extra-long extensions available upon request off the shelf.

For highest surface quality.





45° Helix Angle with FMDF
Specifically engineered for fine finishing steels and stainless steels.

KCPM15™ Grade
Longest tool life.
Enables higher cutting speeds.

36° Helix Angle with FSDE
Specifically engineered for fine finishing titanium and other ISO S-M materials.

Intelligent Thread
Ensures stress levels remain below critical values.

DUO-LOCK®
by HAIMER® and Kennametal



3rd Contact Surface
Delivers high stiffness and highest accuracy below 5 µm runout.

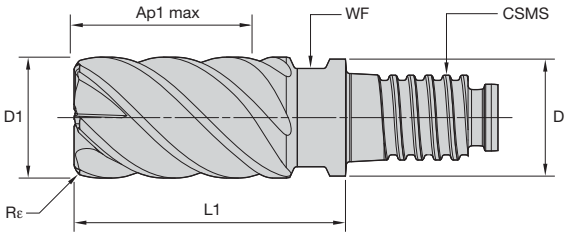
W-shaped Flute Design with FSDE
Wider flute space for optimised chip evacuation.

KC643M™ Grade
Unmatched fine finishing and tool life.

Double Cone
Eliminates expensive presetting processes by providing axial 10 µm repeatability.

- Centre cutting.
- Standard items listed. Additional styles and coatings made-to-order.



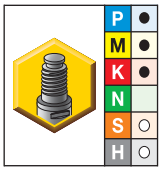




End Mill Tolerances

D1	tolerance e8
> 10–18	-0,032/-0,059
> 18–30	-0,040/-0,073
> 30	-0,050/-0,089

FMDF • Metric



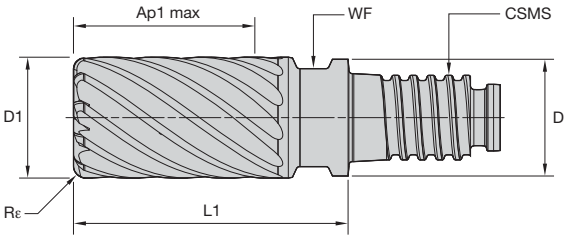
● first choice
○ alternate choice

KCPM15	D1	D	Ap1 max	L1	CSMS system size	WF	Rε
FMDF1000X6CQE	10,00	9,60	15,00	22,50	DL10	8,00	0,50
FMDF1200X6CQF	12,00	11,50	18,00	27,00	DL12	9,50	0,75
FMDF1600X6CQF	16,00	15,50	24,00	36,00	DL16	13,00	0,75
FMDF2000X6CQF	20,00	19,30	30,00	45,00	DL20	16,00	0,75
FMDF2500X6CQF	25,00	24,00	37,50	56,50	DL25	21,00	0,75

NOTE: For application data, please see page O44.

- Non-centre cutting.
- Optimised geometry for titanium machining.
- Unequal flute spacing minimises chatter for smoother machining.
- Standard items listed. Additional styles and coatings made-to-order.



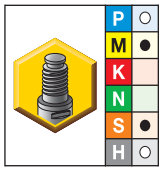




End Mill Tolerances

D1	tolerance e8
> 10–18	-0,032/-0,059
> 18–30	-0,040/-0,073
> 30	-0,050/-0,089

FSDE • Metric



● first choice
○ alternate choice

KC643M	D1	D	Ap1 max	L1	CSMS system size	WF	Rε	Z U
FSDE1000X9CQE	10,00	9,60	15,00	22,50	DL10	8,00	0,50	9
FSDE1000X9CQG	10,00	9,60	15,00	22,50	DL10	8,00	1,00	9
FSDE1000X9CQJ	10,00	9,60	15,00	22,50	DL10	8,00	1,50	9
FSDE1200X9CQE	12,00	11,50	18,00	27,00	DL12	9,50	0,50	9
FSDE1200X9CQG	12,00	11,50	18,00	27,00	DL12	9,50	1,00	9
FSDE1200X9CQJ	12,00	11,50	18,00	27,00	DL12	9,50	1,50	9
FSDE1200X9CQL	12,00	11,50	18,00	27,00	DL12	9,50	2,50	9
FSDE1600XBCQG	16,00	15,50	24,00	36,00	DL16	13,00	1,00	11
FSDE1600XBCQJ	16,00	15,50	24,00	36,00	DL16	13,00	1,50	11
FSDE1600XBCQK	16,00	15,50	24,00	36,00	DL16	13,00	2,00	11
FSDE1600XBCQL	16,00	15,50	24,00	36,00	DL16	13,00	2,50	11
FSDE1600XBCQM	16,00	15,50	24,00	36,00	DL16	13,00	3,00	11
FSDE2000XFCQG	20,00	19,30	30,00	45,00	DL20	16,00	1,00	15
FSDE2000XFCQK	20,00	19,30	30,00	45,00	DL20	16,00	2,00	15
FSDE2000XFCQL	20,00	19,30	30,00	45,00	DL20	16,00	2,50	15
FSDE2000XFCQM	20,00	19,30	30,00	45,00	DL20	16,00	3,00	15
FSDE2000XFCQN	20,00	19,30	30,00	45,00	DL20	16,00	4,00	15
FSDE2500XJCQL	25,00	24,00	37,50	56,50	DL25	21,00	2,50	19
FSDE2500XJCQN	25,00	24,00	37,50	56,50	DL25	21,00	4,00	19

NOTE: For application data, please see page O45.

FMDF • Metric



Material Group		Side Milling (A)		short			medium			long			Recommended feed per tooth (fz = mm/th) for side milling (A).					
		A		adaptor reach									D1 — Diameter					
				KCPM15			KCPM15			KCPM15								
				Cutting Speed — vc m/min			Cutting Speed — vc m/min			Cutting Speed — vc m/min								
		ap	ae	min		max	min		max	min		max	mm	10,0	12,0	16,0	20,0	25,0
P	0	1,5 x D	0,1 x D	150	–	200	135	–	180	135	–	180	fz	0,072	0,083	0,101	0,114	0,124
	1	1,5 x D	0,1 x D	150	–	200	135	–	180	135	–	180	fz	0,072	0,083	0,101	0,114	0,124
	2	1,5 x D	0,1 x D	140	–	190	126	–	171	126	–	171	fz	0,072	0,083	0,101	0,114	0,124
	3	1,5 x D	0,1 x D	120	–	160	108	–	144	108	–	144	fz	0,061	0,070	0,087	0,101	0,114
	4	1,5 x D	0,1 x D	90	–	150	81	–	135	81	–	135	fz	0,054	0,062	0,077	0,088	0,098
	5	1,5 x D	0,1 x D	60	–	100	51	–	85	48	–	80	fz	0,048	0,056	0,070	0,081	0,091
	6	1,5 x D	0,1 x D	50	–	75	42,5	–	63,75	40	–	60	fz	0,040	0,047	0,057	0,065	0,071
M	1	1,5 x D	0,1 x D	90	–	115	72	–	92	63	–	80,5	fz	0,061	0,070	0,087	0,101	0,114
	2	1,5 x D	0,1 x D	60	–	80	48	–	64	42	–	56	fz	0,048	0,056	0,070	0,081	0,091
	3	1,5 x D	0,1 x D	60	–	70	48	–	56	42	–	49	fz	0,040	0,047	0,057	0,065	0,071
K	1	1,5 x D	0,1 x D	120	–	150	108	–	135	108	–	135	fz	0,072	0,083	0,101	0,114	0,124
	2	1,5 x D	0,1 x D	110	–	140	99	–	126	99	–	126	fz	0,061	0,070	0,087	0,101	0,114
	3	1,5 x D	0,1 x D	110	–	130	99	–	117	99	–	117	fz	0,048	0,056	0,070	0,081	0,091
S	1	1,5 x D	0,1 x D	50	–	90	40	–	72	30	–	54	fz	0,061	0,070	0,087	0,101	0,114
	2	1,5 x D	0,1 x D	25	–	40	20	–	32	15	–	24	fz	0,032	0,037	0,046	0,054	0,061
	3	1,5 x D	0,1 x D	25	–	40	20	–	32	15	–	24	fz	0,032	0,037	0,046	0,054	0,061
	4	1,5 x D	0,15 x D	50	–	60	40	–	48	30	–	36	fz	0,045	0,052	0,064	0,074	0,084
H	1	1,5 x D	0,1 x D	80	–	140	64	–	112	48	–	84	fz	0,054	0,062	0,077	0,088	0,098
	2	1,5 x D	0,1 x D	70	–	120	56	–	96	42	–	72	fz	0,040	0,047	0,057	0,065	0,071

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. Please adjust parameters according to system stability.
For side milling with ap larger than 1 x D, reduce fz by 20%!
Cylindrical shanks not recommended for full slotting.

FSDE • Metric



Material Group		Side Milling (A)		short			medium			long			Recommended feed per tooth (fz = mm/th) for side milling (A).					
		A		adaptor reach									D1 — Diameter					
				KC643M			KC643M			KC643M								
				Cutting Speed — vc m/min			Cutting Speed — vc m/min			Cutting Speed — vc m/min								
		ap	ae	min		max	min		max	min		max	mm	10,0	12,0	16,0	20,0	25,0
P	4	1,5 x D	0,2–0,3mm	135	–	495	122	–	446	122	–	446	fz	0,120	0,129	0,149	0,163	0,166
	5	1,5 x D	0,2–0,3mm	90	–	330	77	–	281	72	–	264	fz	0,108	0,116	0,135	0,150	0,155
M	1	1,5 x D	0,2–0,3mm	135	–	379,5	108	–	304	95	–	266	fz	0,135	0,145	0,169	0,187	0,193
	2	1,5 x D	0,2–0,3mm	90	–	264	72	–	211	63	–	185	fz	0,108	0,116	0,135	0,150	0,155
	3	1,5 x D	0,2–0,3mm	90	–	231	72	–	185	63	–	162	fz	0,090	0,096	0,110	0,120	0,121
S	1	1,5 x D	0,2–0,3mm	75	–	297	60	–	238	45	–	178	fz	0,135	0,145	0,169	0,187	0,193
	2	1,5 x D	0,2–0,3mm	37,5	–	132	30	–	106	23	–	79	fz	0,071	0,077	0,090	0,100	0,104
	3	1,5 x D	0,2–0,3mm	37,5	–	132	30	–	106	23	–	79	fz	0,071	0,077	0,090	0,100	0,104
	4	1,5 x D	0,2–0,3mm	75	–	198	60	–	158	45	–	119	fz	0,099	0,107	0,124	0,138	0,142
H	1	1,5 x D	0,2–0,3mm	120	–	462	96	–	370	72	–	277	fz	0,120	0,129	0,149	0,163	0,166
	2	1,5 x D	0,2–0,3mm	105	–	396	84	–	317	63	–	238	fz	0,090	0,096	0,110	0,120	0,121

NOTE: For better surface finish, reduce feed per tooth.
For side milling with ap larger than 1 x D, reduce fz by 20%!
Cylindrical shanks not recommended for full slotting.

DUO-λOCK®

Corner Rounding and Chamfering Solid Carbide Tips

Primary Application

Duo-Lock™ XRDA corner rounding and XADA chamfering tools perfectly complete the offering of high-performance end mills.

- Universal tools for almost all workpiece materials.
- Able to be reconditioned multiple times.

Features and Benefits

Advanced Technology

- Tailored amount of edges for each diameter.

Tailored Grades

- KCPM15™ Beyond™ grade for outstanding wear protection in various materials to mitigate crater, depth-of-cut notching, and flank wear.

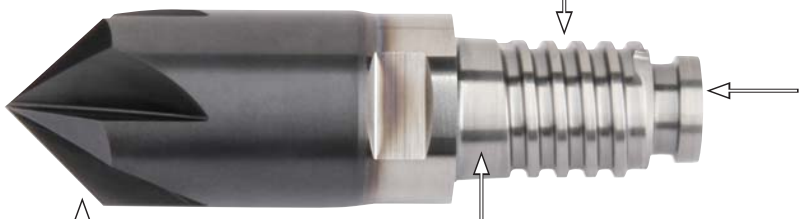
Customisation

- Intermediate diameters are available between 10–32mm.
- Various angles and inverse radii possible.

Extensive Standard Offering

- Diameter ranges 10–16mm.
- Integral adaptors reduce the amount of interface for maximum accuracy. Steel extensions with Safe-Lock™ by HAIMER shanks prevent pullout.
- Cut-to-size extra-long extensions available upon request off the shelf.





Intelligent Thread
Ensures stress levels remain below critical values.

3rd Contact Surface
Delivers high stiffness and highest accuracy below 5 µm runout.

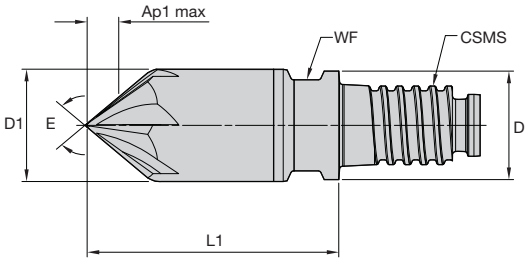
KCPM15™ Grade
Longest tool life.

Double Cone
Eliminates expensive presetting processes by providing axial 10 µm repeatability.

DUO-LOCK®
by HAIMER® and Kennametal

- Non-centre cutting.
- Standard items listed. Additional styles and coatings made-to-order.



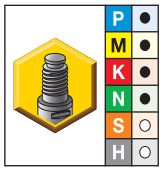




End Mill Tolerances

D1	tolerance h10 + / -
> 10–18	0/-0,070

XADA • Metric



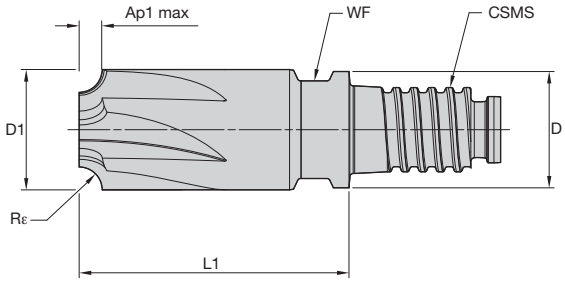
● first choice
○ alternate choice

KCPM15	D1	D	Ap1 max	L1	CSMS system size	WF	E	Z U
XADA1000X4CH45	10,00	9,60	2,00	22,60	DL10	8,00	90	4
XADA1000X4CH60	10,00	9,60	2,00	22,60	DL10	8,00	60	4
XADA1200X5CH45	12,00	11,50	3,00	27,20	DL12	9,50	90	5
XADA1200X5CH60	12,00	11,50	3,00	27,20	DL12	9,50	60	5
XADA1600X6CH45	16,00	15,50	4,00	36,25	DL16	13,00	90	6
XADA1600X6CH60	16,00	15,50	4,00	36,00	DL16	13,00	60	6

NOTE: For application data, please see page O50.

- Non-centre cutting.
- Standard items listed. Additional styles and coatings made-to-order.



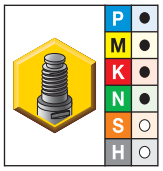




End Mill Tolerances

D1	tolerance h10 + / -
> 10–18	0/-0,070

XRDA • Metric



● first choice
○ alternate choice

KCPM15	D1	D	Ap1 max	L1	CSMS system size	WF	Rε	Z U
XRDA1000X4CHJ	10,00	9,60	1,50	22,50	DL10	8,00	1,50	4
XRDA1000X4CRM	10,00	9,60	3,00	22,50	DL10	8,00	3,00	4
XRDA1200X5CRG	12,00	11,50	1,00	27,00	DL12	9,50	1,00	5
XRDA1200X5CRK	12,00	11,50	2,00	27,20	DL12	9,50	2,00	5
XRDA1200X5CRM	12,00	11,50	3,00	27,00	DL12	9,50	3,00	5
XRDA1600X6CRK	16,00	15,50	2,00	36,10	DL16	13,00	2,00	6
XRDA1600X6CRM	16,00	15,50	3,00	35,93	DL16	13,00	3,00	6
XRDA1600X6CRN	16,00	15,50	4,00	35,95	DL16	13,00	4,00	6

NOTE: For application data, please see page O51.

XADA • Metric





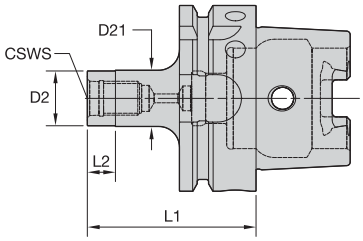
Material Group		Chamfering (A)		short			medium			long			Recommended feed per tooth (fz = mm/th) for side milling (A).			
		A		adaptor reach									D1 — Diameter			
				KCPM15			KCPM15			KCPM15						
				Cutting Speed — vc m/min			Cutting Speed — vc m/min			Cutting Speed — vc m/min						
		ap	ae	min		max	min		max	min		max	mm	10,0	12,0	16,0
P	0	0,35 x D	0,35 x D	150	–	200	135	–	180	135	–	180	fz	0,058	0,066	0,081
	1	0,35 x D	0,35 x D	150	–	200	135	–	180	135	–	180	fz	0,058	0,066	0,081
	2	0,35 x D	0,35 x D	140	–	190	126	–	171	126	–	171	fz	0,058	0,066	0,081
	3	0,35 x D	0,35 x D	120	–	160	108	–	144	108	–	144	fz	0,048	0,056	0,070
	4	0,35 x D	0,35 x D	90	–	150	81	–	135	81	–	135	fz	0,043	0,050	0,061
	5	0,35 x D	0,35 x D	60	–	100	51	–	85	48	–	80	fz	0,039	0,045	0,056
	6	0,35 x D	0,35 x D	50	–	75	42,5	–	63,75	40	–	60	fz	0,032	0,037	0,046
M	1	0,35 x D	0,35 x D	90	–	115	72	–	92	63	–	80,5	fz	0,048	0,056	0,070
	2	0,35 x D	0,35 x D	60	–	80	48	–	64	42	–	56	fz	0,039	0,045	0,056
	3	0,35 x D	0,35 x D	60	–	70	48	–	56	42	–	49	fz	0,032	0,037	0,046
K	1	0,35 x D	0,35 x D	120	–	150	108	–	135	108	–	135	fz	0,058	0,066	0,081
	2	0,35 x D	0,35 x D	110	–	140	99	–	126	99	–	126	fz	0,048	0,056	0,070
	3	0,35 x D	0,35 x D	110	–	130	99	–	117	99	–	117	fz	0,039	0,045	0,056
N	1	0,35 x D	0,35 x D	500	–	2000	400	–	1600	300	–	1200	fz	0,080	0,096	0,128
	2	0,35 x D	0,35 x D	500	–	1500	400	–	1200	300	–	900	fz	0,072	0,086	0,115
	3	0,35 x D	0,35 x D	500	–	1500	400	–	1200	300	–	900	fz	0,056	0,067	0,090
	4	0,35 x D	0,35 x D	400	–	750	320	–	600	240	–	450	fz	0,056	0,067	0,090
	5	0,35 x D	0,35 x D	250	–	1000	200	–	800	150	–	600	fz	0,072	0,086	0,115
	6	0,35 x D	0,35 x D	100	–	750	80	–	600	60	–	450	fz	0,080	0,096	0,128
	7	0,35 x D	0,35 x D	100	–	750	80	–	600	60	–	450	fz	0,056	0,067	0,090
S	1	0,35 x D	0,35 x D	50	–	90	40	–	72	30	–	54	fz	0,048	0,056	0,070
	2	0,35 x D	0,35 x D	25	–	40	20	–	32	15	–	24	fz	0,026	0,030	0,037
	3	0,35 x D	0,35 x D	25	–	40	20	–	32	15	–	24	fz	0,026	0,030	0,037
	4	0,35 x D	0,35 x D	50	–	60	40	–	48	30	–	36	fz	0,036	0,041	0,051
H	1	0,35 x D	0,35 x D	80	–	140	64	–	112	48	–	84	fz	0,043	0,050	0,061

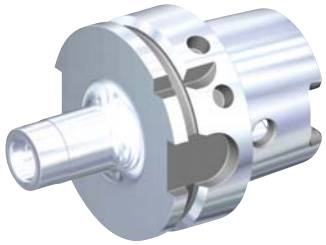
XRDA • Metric



Material Group		Corner Rounding (A)		short			medium			long			Recommended feed per tooth (fz = mm/th) for side milling (A).			
		A		adaptor reach									D1 — Diameter			
				KCPM15			KCPM15			KCPM15						
				Cutting Speed — vc m/min			Cutting Speed — vc m/min			Cutting Speed — vc m/min						
		ap	ae	min		max	min		max	min		max	mm	10,0	12,0	16,0
P	0	0,35 x D	0,35 x D	150	–	200	135	–	180	135	–	180	fz	0,058	0,066	0,081
	1	0,35 x D	0,35 x D	150	–	200	135	–	180	135	–	180	fz	0,058	0,066	0,081
	2	0,35 x D	0,35 x D	140	–	190	126	–	171	126	–	171	fz	0,058	0,066	0,081
	3	0,35 x D	0,35 x D	120	–	160	108	–	144	108	–	144	fz	0,048	0,056	0,070
	4	0,35 x D	0,35 x D	90	–	150	81	–	135	81	–	135	fz	0,043	0,050	0,061
	5	0,35 x D	0,35 x D	60	–	100	51	–	85	48	–	80	fz	0,039	0,045	0,056
	6	0,35 x D	0,35 x D	50	–	75	42,5	–	63,75	40	–	60	fz	0,032	0,037	0,046
M	1	0,35 x D	0,35 x D	90	–	115	72	–	92	63	–	80,5	fz	0,048	0,056	0,070
	2	0,35 x D	0,35 x D	60	–	80	48	–	64	42	–	56	fz	0,039	0,045	0,056
	3	0,35 x D	0,35 x D	60	–	70	48	–	56	42	–	49	fz	0,032	0,037	0,046
K	1	0,35 x D	0,35 x D	120	–	150	108	–	135	108	–	135	fz	0,058	0,066	0,081
	2	0,35 x D	0,35 x D	110	–	140	99	–	126	99	–	126	fz	0,048	0,056	0,070
	3	0,35 x D	0,35 x D	110	–	130	99	–	117	99	–	117	fz	0,039	0,045	0,056
N	1	0,35 x D	0,35 x D	500	–	2000	400	–	1600	300	–	1200	fz	0,080	0,096	0,128
	2	0,35 x D	0,35 x D	500	–	1500	400	–	1200	300	–	900	fz	0,072	0,086	0,115
	3	0,35 x D	0,35 x D	500	–	1500	400	–	1200	300	–	900	fz	0,056	0,067	0,090
	4	0,35 x D	0,35 x D	400	–	750	320	–	600	240	–	450	fz	0,056	0,067	0,090
	5	0,35 x D	0,35 x D	250	–	1000	200	–	800	150	–	600	fz	0,072	0,086	0,115
	6	0,35 x D	0,35 x D	100	–	750	80	–	600	60	–	450	fz	0,080	0,096	0,128
	7	0,35 x D	0,35 x D	100	–	750	80	–	600	60	–	450	fz	0,056	0,067	0,090
S	1	0,35 x D	0,35 x D	50	–	90	40	–	72	30	–	54	fz	0,048	0,056	0,070
	2	0,35 x D	0,35 x D	25	–	40	20	–	32	15	–	24	fz	0,026	0,030	0,037
	3	0,35 x D	0,35 x D	25	–	40	20	–	32	15	–	24	fz	0,026	0,030	0,037
	4	0,35 x D	0,35 x D	50	–	60	40	–	48	30	–	36	fz	0,036	0,041	0,051
H	1	0,35 x D	0,35 x D	80	–	140	64	–	112	48	–	84	fz	0,043	0,050	0,061





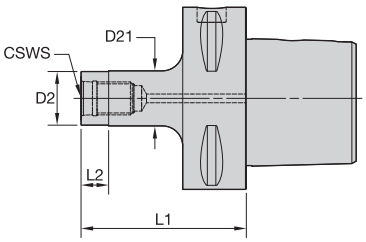


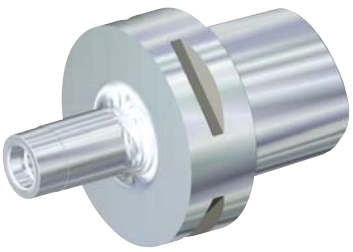
DL HSK Form A Metric

order number	catalogue number	CSWS system size	D2	D21	L1	L2	kg
6136949	HSK63ADL10048M	DL10	10	10	48	5	0,69
6136950	HSK63ADL12052M	DL12	12	12	52	6	0,69
6136951	HSK63ADL16057M	DL16	16	16	57	8	0,70
6136952	HSK63ADL20057M	DL20	19	20	57	10	0,72
6136953	HSK63ADL25061M	DL25	24	25	61	12	0,74
6136954	HSK63ADL32072M	DL32	31	32	72	16	0,83

PSC63 Duo-Lock™ Integrated



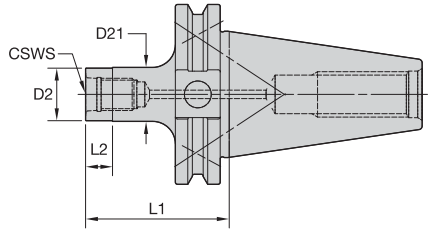


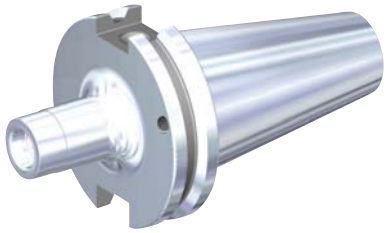


DL PSC63 Metric

order number	catalogue number	CSWS system size	D2	D21	L1	L2	kg
6136955	PSC63DL10050M	DL10	10	10	50	5	0,77
6136956	PSC63DL12050M	DL12	12	12	50	6	0,77
6136957	PSC63DL16055M	DL16	16	16	55	8	0,78
6136958	PSC63DL20055M	DL20	19	20	55	10	0,80
6136959	PSC63DL25060M	DL25	24	25	60	12	0,83
6136960	PSC63DL32068M	DL32	31	32	68	16	0,91





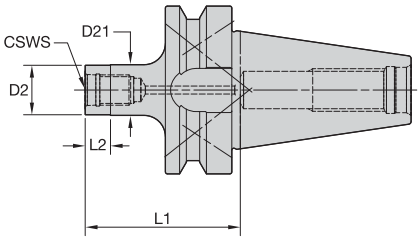


DL CV40 Metric

order number	catalogue number	CSWS system size	D2	D21	L1	L2	kg
6136971	**CV40BDL10041M**	DL10	10	10	41	5	0,82
6136972	**CV40BDL12041M**	DL12	12	12	41	6	0,81
6136973	**CV40BDL16050M**	DL16	16	16	50	8	0,83
6136974	**CV40BDL20050M**	DL20	19	20	50	10	0,84
6136975	**CV40BDL25056M**	DL25	24	25	56	12	0,87
6136976	**CV40BDL32065M**	DL32	31	32	65	16	0,95

BT40 Duo-Lock™ Integrated



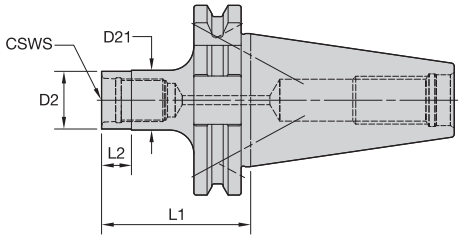


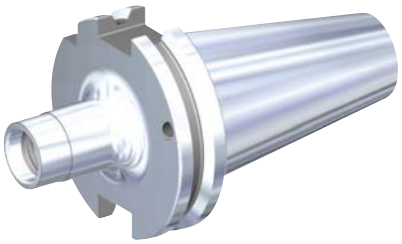


DL BT40 Metric

order number	catalogue number	CSWS system size	D2	D21	L1	L2	kg
6136977	**BT40BDL10049M**	DL10	10	10	49	5	0,98
6136978	**BT40BDL12049M**	DL12	12	12	49	6	0,97
6136979	**BT40BDL16058M**	DL16	16	16	58	8	1,00
6136980	**BT40BDL20058M**	DL20	19	20	58	10	1,00
6136991	**BT40BDL25060M**	DL25	24	25	60	12	1,02
6136992	**BT40BDL32068M**	DL32	31	32	68	16	1,09

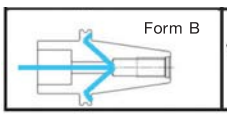






DL DV40 Metric

order number	catalogue number	CSWS system size	D2	D21	L1	L2	kg
6136993	**DV40BDL10041M**	DL10	10	10	41	5	0,82
6136994	**DV40BDL12041M**	DL12	12	12	41	6	0,81
6136995	**DV40BDL16050M**	DL16	16	16	50	8	0,83
6136996	**DV40BDL20050M**	DL20	19	20	50	10	0,84
6136997	**DV40BDL25056M**	DL25	24	25	56	12	0,87
6136998	**DV40BDL32065M**	DL32	31	32	65	16	0,95

 Form B			**40**	(2x) MS2221**S**	2,5mm
			50	(2x) MS1296**S**	3mm

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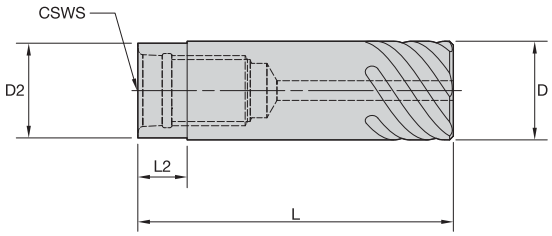
Numbers shown only serve the originating country listed.





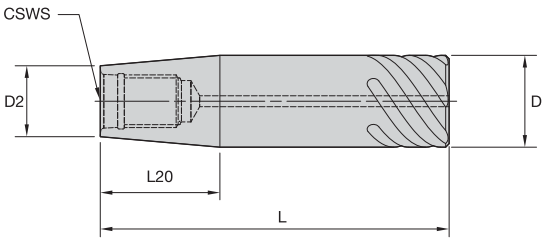


DL SS SL Cylindrical Metric

order number	catalogue number	CSWS system size	D	D2	L	L2	kg
6134889	**SS10SLDL10055M**	DL10	10	9,58	55	6	0,03
6135043	**SS12SLDL12065M**	DL12	12	11,50	65	7	0,05
6135049	**SS16SLDL16070M**	DL16	16	15,50	70	9	0,09
6135057	**SS20SLDL20080M**	DL20	20	19,30	80	11	0,16
6135063	**SS25SLDL25090M**	DL25	25	24,00	90	13	0,27
6135067	**SS32SLDL32105M**	DL32	32	31,00	105	17	0,52

NOTE: Cylindrical shanks not recommended for full slotting.



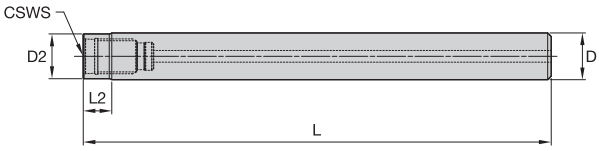




DL SS SL Conical Metric

order number	catalogue number	CSWS system size	D	D2	L	L20	kg
6135041	**SS12SLDL10065M**	DL10	12	9,58	65	14	0,05
6135045	**SS16SLDL10090M**	DL10	16	9,58	90	37	0,11
6135051	**SS20SLDL10115M**	DL10	20	9,58	115	59	0,21
6135047	**SS16SLDL12080M**	DL12	16	11,50	80	26	0,11
6135053	**SS20SLDL12105M**	DL12	20	11,50	105	49	0,20
6135055	**SS20SLDL16080M**	DL16	20	15,50	80	26	0,16
6135059	**SS25SLDL16115M**	DL16	25	15,50	115	54	0,35
6135061	**SS25SLDL20095M**	DL20	25	19,30	95	33	0,30
6135065	**SS32SLDL25105M**	DL25	32	24,00	105	46	0,52
6135069	**SS40SLDL32140M**	DL32	40	31,00	140	51	1,13
6135081	**SS50SLDL32200M**	DL32	50	31,00	200	109	2,35





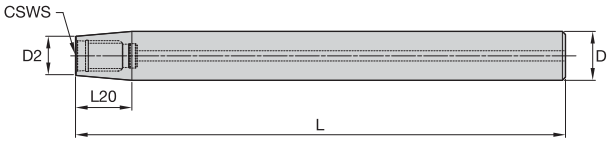


DL SS Cylindrical Cut Off to Modify Length Metric

order number	catalogue number	CSWS system size	D	D2	L	L2	kg
6134890	**SS10DL10100M**	DL10	10	9,58	100	5	0,05
6135044	**SS12DL12120M**	DL12	12	11,50	120	6	0,09
6135050	**SS16DL16160M**	DL16	16	15,50	160	8	0,23
6135058	**SS20DL20200M**	DL20	20	19,30	200	10	0,45
6135064	**SS25DL25250M**	DL25	25	24,00	250	13	0,86
6135068	**SS32DL32250M**	DL32	32	31,00	250	16	1,41

NOTE: Standard catalogue cutting data does not apply. Consult tooling application expert before use.







DL SS Conical Cut Off to Modify Length Metric

order number	catalogue number	CSWS system size	D	D2	L	L20	kg
6135042	**SS12DL10120M**	DL10	12	9,58	120	14	0,10
6135046	**SS16DL10160M**	DL10	16	9,58	160	37	0,22
6135052	**SS20DL10200M**	DL10	20	9,58	200	59	0,42
6135048	**SS16DL12160M**	DL12	16	11,50	160	26	0,23
6135054	**SS20DL12200M**	DL12	20	11,50	200	48	0,43
6135056	**SS20DL16200M**	DL16	20	15,50	200	26	0,45
6135060	**SS25DL16250M**	DL16	25	15,50	250	54	0,86
6135062	**SS25DL20250M**	DL20	25	19,30	250	32	0,89
6135066	**SS32DL25250M**	DL25	32	24,00	250	45	1,42
6135070	**SS40DL32250M**	DL32	40	31,00	250	51	2,20
6135082	**SS50DL32250M**	DL32	50	31,00	250	108	3,14

NOTE: Standard catalogue cutting data does not apply. Consult tooling application expert before use.



Torque Wrench

order number	catalogue number	Description
6135413	TWDLTM	BASIC DUO LOCK WRENCH
6135414	TWTMINSERTDL10	TORQUE WRENCH INSERT DL10
6135415	TWTMINSERTDL12	TORQUE WRENCH INSERT DL12
6135416	TWTMINSERTDL16	TORQUE WRENCH INSERT DL16
6135417	TWTMINSERTDL20	TORQUE WRENCH INSERT DL20
6135418	TWTMINSERTDL25	TORQUE WRENCH INSERT DL25
6135419	TWTMINSERTDL32	TORQUE WRENCH INSERT DL32
6135420	TWTMINSERTDL10W	TORQUE WRENCH INSERT DL10 WEAR
6135421	TWTMINSERTDL12W	TORQUE WRENCH INSERT DL12 WEAR
6135422	TWTMEXT	TORQUE WRENCH EXTENSION HANDLE
6135423	TWTMBC	TORQUE WRENCH BOLT SET

NOTE: Combine basic Duo-Lock™ wrench with selected torque wrench inserts needed.

Wrench Kit

1 Basic Duo-Lock™ Wrench

2 Insert

3 Extension Handle



Order this

Get that

order number	catalogue number	kit description	
6342967	TWDL10TM	D-L WRENCH WITH DL10 INSERT AND HANDLES	1+2+3
6342968	TWDL12TM	D-L WRENCH WITH DL12 INSERT AND HANDLES	
6342969	TWDL16TM	D-L WRENCH WITH DL16 INSERT AND HANDLES	
6342970	TWDL20TM	D-L WRENCH WITH DL20 INSERT AND HANDLES	
6343061	TWDL25TM	D-L WRENCH WITH DL25 INSERT AND HANDLES	
6343062	TWDL32TM	D-L WRENCH WITH DL32 INSERT AND HANDLES	

Assembly

Please wear sufficient personal safety equipment such as gloves and eye protection during assembly.

1 Clean the Duo-Lock™ cutting insert and shank coupling.





2 Mount the Duo-Lock™ adaptor in a mounting block with a clamping chuck sufficient to enable torque transmission.



3 Screw the Duo-Lock™ cutting tip into adaptor by hand.

Attention: Use of protective gloves is mandatory!



4 A gap of approx. 0,15–0,3mm should be visible.



5 Apply the torque shown in the table. Use of a high quality common torque wrench is mandatory. The ERICKSON™ Torque Master wrench is recommended.



Duo-Lock™ Size	Torque Nm
DL 10	20
DL 12	30
DL 16	60
DL 20	80
DL 25	100
DL 32	130



Solid End Milling •
High-Performance Solid Carbide End Mills

High-Performance Tool Selector and Grades P2–P11

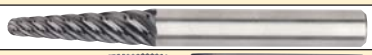
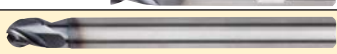
High-Performance Capability End Mills P12–P74

High-Performance Roughing End Mills P76–P98

High-Performance Finishing End Mills P100–P114

High-Performance Material Specific End Mills P116–P138

High-Performance Application Specific End Mills P140–P197

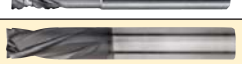
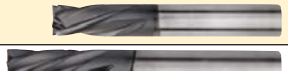
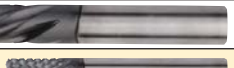
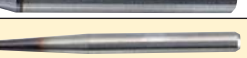
beyond *Beyond™ grade		series	D1 diameter (mm)	length of cut	flute Z	helix	internal coolant
HARVI™ I*		F4AS...DL	4–25	1,8–3 x D1			
HARVI I		UADE	4–25	3–4 x D			
HARVI I*		F4AS..WM-WX-WL/UBDE	6–25	2–2,5 x D1			
HARVI I Chipbreaker*		F4BS..WM-WX-WL	6–25	1,5 x D1			
HARVI I Extended Reach		UADE	6–20	2 x D1			
HARVI I Ball Nose*		F4AW..WL-WX	6–16	1 x D1			
HARVI I Taper Ball Nose		F4AW..AWL38-AWX38	4–16	5–7 x D			
XE		XE	2–20	2–2,5 x D1			
XER		XER	2–20	2 x D			
HARVI II*		UCDE	4–25	1,8–2,7 x D1			
HARVI II		UDDE	6–25	1,8–2,2 x D1			
HARVI II LONG		UGDE	6–25	3 x D			
HARVI II LONG		UGDE	6–25	5 x D			
HARVI II Trochoidal		TCDE	8–25	3 x D			
HARVI III		UJDE	10–25	2 x D			
HARVI III		UJDE	10–25	3 x D			
HARVI III Ball Nose		UJBE	10–20	1 x D1			
HARVI III Taper Ball Nose		UJBE	4–10	5–6 x D			
HP Rougher*		F3BH-F4BJ-F5BJ... WS-WM-WL-WX	4–25	1,8–2,7 x D1			
HP Rougher*		F3BH-F4BJ... WS-WM-WL-WX	8–20	1,3–1,9 x D1			
HP Rougher		RUDC	4–25	2 x D			
HP Rougher*		F3BH...DL	4–25	1,8–2 x D1			
HP Rougher*		F3BS..DK-DL	6–20	1–1,6 x D1			
HP Rougher*		F4BJ...DL	6–20	1,9–2,2 x D1			
HP Rougher*		F4BJ-F6BJ...DL	6–25	1,8–2,1 x D1			
RSM II Short		FSDE	10–25	2 x D			
RSM II with neck		FSDE	6–25	2 x D			
HP Finisher*		F3AS...DK	3–20	1–1,3 x D1			
HP Finisher		F3AW...WL-WX	6–16	1 x D1			
HP Finisher*		F8AJ-F10AJ...DK	8–20	1 x D1			
HP Finisher*		F6AJ-F8AJ...DL	6–25	2–3 x D1			
Aluminium MaxiMet™		ABDF	1,5–20	1,9–4 x D1			
Aluminium MaxiMet		ABDE	3–20	1,9–4 x D1			
Aluminium MaxiMet		ABDE	6–25	1,5 x D1			
Aluminium		F1AA	2–12	2–3 x D			
Aluminium		F2AA...DL	4–20	1,6–2 x D7			

							shank	centre cutting	neck	P	M	K	N	C	S	H							product page(s)	cutting data page(s)
				✓				✓		●	●	●			●	○	✓	✓	✓	✓		✓	P16	P23
				✓				✓	✓	●	●	●			○	○	✓	✓	✓	✓		✓	P17	P23
					✓			✓	✓	●	●	●				○	✓	✓	✓	✓		✓	P18	P23–P24
					✓			✓	✓	●	●	●				○	✓	✓	✓	✓		✓	P19	P24
				✓				✓	✓	●	●	●				○	✓	✓	✓			✓	P20	P25
						✓		✓	✓	●	●	●				○	✓	✓			✓	✓	P21	P26
	✓							✓		○	○				○	○	✓				✓		P22	P27
					✓			✓		●	●		●				✓	✓	✓	✓		✓	P72	P74
					✓			✓		●	●		●				✓	✓	✓	✓		✓	P73	P74
			✓		✓					●	●	●				○	✓	✓	✓			✓	P30	P33
			✓		✓				✓	●	●	●			●		✓	✓	✓			✓	P31–P32	P33
					✓					●	●	○			●	○	✓					✓	P36	P38
					✓					●	●	○			●	○	✓					✓	P37	P39
					✓					○	●				●	○	✓		✓	✓		✓	P42	P43–P44
			✓		✓			✓		○	●				●	○	✓		✓			✓	P48	P50
			✓		✓			✓	✓	○	●				●	○	✓		✓			✓	P49	P51
						✓				○	●				●	○	✓				✓	✓	P54	P58–P59
	✓									○	●				●	○	✓	✓			✓		P62	P68–P69
				✓				✓		○	●	●				○	✓	✓	✓				P78	P85
				✓				✓		●	●	●				○	✓	✓	✓				P79	P85
				✓				✓		●	●	●			●	○	✓	✓	✓				P80	P86
				✓				✓		●	●	●					✓	✓	✓	✓			P81	P86
					✓			✓		●	●	●				○	✓	✓	✓	✓			P82	P87
				✓				✓		●	●	○			○	○	✓	✓	✓	✓			P83	P87
				✓				✓		●	●	●				○	✓	✓	✓				P84	P88
					✓					○	●				●	○	✓						P92	P93
					✓				✓	○	●				●	○	✓						P94	P95
					✓			✓		●	●	●				○	✓	✓	✓	✓			P102	P106
						✓		✓		●	●	●				○	✓	✓			✓		P103	P106
					✓			✓	✓	●	●	●				○	✓					✓	P104	P107
				✓						●	●	●				○	✓					✓	P105	P107
			✓					✓					●				✓	✓	✓	✓			P110	P114
			✓					✓					●				✓	✓	✓	✓			P111	P114
					✓			✓	✓				●				✓	✓	✓	✓			P112–P113	P114
			✓					✓					●				✓	✓	✓				P118	P126
			✓					✓					●				✓	✓	✓	✓		✓	P119	P126

● first choice
○ alternate choice

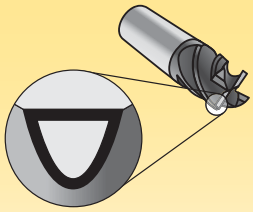
(continued)

(High-Performance Solid Carbide End Mills — continued)

beyond *Beyond™ grade		series	D1 diameter (mm)	length of cut	flute Z	helix	internal coolant
Aluminium		F2AA... WM-WL-WX	6–25	1,5 x D1	ZU-2	35°	
Aluminium		F3AA... WS-WM-WL-WX	3–20	1,9–4 x D7	ZU-3	35°	
Aluminium		F3AA... WS-WM-WL-WX	6–25	1,5 x D1	ZU-3	35°	
Aluminium		F3BA... WS-WM-WL-WX	6–25	1,8–2,1 x D1	ZU-3	35°	
Aluminium		F3BA... WS-WM-WL-WX	8–25	1,8–2 x D1	ZU-3	35°	
Aluminium		F3BA...DL	6–20	1,2 x D1	ZU-3	35°	
CFRP*		CCNC	6–12	3 x D1	ZU-X	35°	
CFRP*		CDDC	6–12	3 x D1	ZU-6	35°	
CFRP*		CBDB	6–12	3 x D1	ZU-12	35°	
KenFeed™		KHDA	6–20	—	ZU-6	35°	
KenFeed		KMDA	6–20	—	ZU-6	35°	
Hard Steels		F2AT...WM-WL-WX	2–12	1 x D1	ZU-2	35°	
Hard Steels		F4AT... WS-WM-WL-WX	4–12	1 x D1	ZU-4	35°	
Hard Steels		F4AJ-F5AJ... WS-WM-WL-WX	6–25	1,5 x D1	ZU-X	35°	
Hard Steels		F4AJ-F5AJ-F6AJ WS-WL-WX	6–25	1,5 x D1	ZU-X	35°	
Hard Steels		F6AV-F8AV...DL	6–25	2,2–3 x D1	ZU-X	35°	
Hard Steels Ball Nose		F2AL... WL-WM-WX	2–12	1 x D1	ZU-2	35°	
Hard Steels Ball Nose		F2AL... WL-WM	1–16	1 x D1	ZU-2	35°	
Hard Steels Ball Nose		F2AL... WL-WM-WX	6–16	1 x D1	ZU-2	35°	
Hard Steels Ball Nose		F2AB... WL-WM-WX	2–12	0,5 x D1	ZU-2	35°	
Hard Steels Ball Nose		F4AL... WL-WM-WX	3–10	1,2–1,5 x D1	ZU-4	35°	
Micro		F2AH...WS-WM	0,3–2,5	—	ZU-2	35°	
Micro		F2AH...WS	0,3–2,5	—	ZU-2	35°	
Micro		F3AH...WS	0,4–3	—	ZU-3	35°	
Micro		F2AL...WS	0,5–3	—	ZU-2	35°	
Micro		F2AL...WS	0,5–3	—	ZU-2	35°	
Micro		F2AL...WM	0,5–4	—	ZU-2	35°	
Ceramic Rougher		EADE	4–25	0,75 x D1	ZU-4	35°	
Ceramic Rougher		EADE	4–25	0,75 x D	ZU-6	35°	
HP Finisher		F2AU...DK	1,8–19,7	1 x D1	ZU-2	35°	
HP Finisher		F3AU...DK	2,8–19,7	1–1,3 x D1	ZU-3	35°	
GOmill™		UEDE	2–12	1,2–2 x D1	ZU-3	35°	
GOmill		UEDE	4–12	1,2–1,7 x D1	ZU-4	35°	
GOmill		UEBC	2–12	1,2–2 x D1	ZU-2	35°	
GOmill		UEBE	2–12	1,2–2 x D1	ZU-3	35°	

							shank	centre cutting	neck	P	M	K	N	C	S	H							product page(s)	cutting data page(s)
					✓			✓	✓				●				✓	✓	✓	✓		✓	P120	P126
		✓						✓					●				✓	✓	✓	✓		✓	P121	P126
					✓			✓	✓				●				✓	✓	✓	✓			P122	P127
					✓			✓					●				✓	✓	✓	✓		✓	P123	P127
					✓			✓					●				✓	✓	✓	✓			P124	P127
					✓			✓	✓				●				✓	✓	✓	✓			P125	P127
			✓											●			✓		✓				P130	P133
			✓					✓						●			✓	✓	✓	✓			P131	P133
			✓											●			✓	✓	✓				P132	P133
	✓								✓							●			✓		✓		P136	P138
	✓								✓	○						●			✓		✓		P137	P138
	✓							✓	✓	●						●	✓	✓			✓		P142	P152
	✓							✓	✓	●						●	✓	✓	✓		✓		P143	P152
					✓			✓		●						●	✓	✓					P144	P152
		✓						✓		●						●	✓	✓					P145	P153
					✓			✓		●						●	✓						P146	P153
						✓		✓	✓	●						●	✓				✓		P147	P154
						✓		✓		●						●	✓				✓		P148	P155
						✓		✓	✓	●						●	✓				✓		P149	P156
						✓		✓	✓	●						●	✓				✓		P150	P157
						✓		✓		●						●	✓				✓		P151	P158
		✓						✓	✓	●		●				●	✓	✓	✓				P162	P168
		✓						✓	✓	●	●	●	●	●		●		✓	✓				P163	P168
		✓						✓		●	●	●	●				✓	✓	✓				P164	P169
						✓		✓	✓	●						●	✓				✓		P165	P170
						✓				●						●	✓				✓		P166	P171
						✓		✓	✓	●						●	✓				✓		P167	P172
					✓				✓						●		✓	✓	✓				P176	P178
					✓										●		✓	✓	✓				P177	P178
					✓			✓	✓	●	●	●			●	○	✓	✓	✓	✓			P186	P188
					✓			✓	✓	●	●	●			●	○	✓	✓	✓	✓			P187	P189
		✓								●	●	●			●	○	✓	✓	✓	✓			P192	P196
			✓							●	●	●			●	○	✓	✓	✓	✓			P193	P196
						✓				●	●	●			●	○	✓	✓			✓		P194	P197
						✓				●	●	●			●	○	✓	✓		✓	✓		P195	P197

● first choice
○ alternate choice



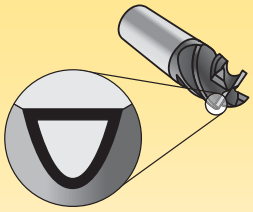
Coatings provide high-speed capability and are engineered for roughing to finishing.

P	Steel
M	Stainless Steel
K	Cast Iron
N	Non-Ferrous
S	High-Temp Alloys
H	Hardened Materials
C	CFRP Materials

Grades

Coating	Grade Description		05	10	15	20	25	30	35	40	45
K600	Carbide grade made from high-quality, micrograin materials for cutting all types of workpiece materials. Very high toughness ensures a controlled wear rate. The micrograin structure enables extremely sharp cutting edges.	N									
KCPM15	Coated carbide grade with thick PVD coating and optimised chemistry and process for increased wear resistance. Outstanding protection in milling stainless steel to mitigate crater, DOCN (depth-of-cut notching), and flank wear. Excellent performance up to 52 HRC.	P, M, K									
KC643M	Coated fine-grain grade with PVD multilayer (AlTiN). KC643M™ is a very thin and hard PVD coating particularly suited for cutting steel, cast iron, stainless steel (wet), and titanium (wet). This grade can be used for materials with hardness up to 52 HRC.	P, M, K, S									
KC637M	Coated, tough, wear-resistant carbide grade with hard PVD coating, particularly suitable for machining steels above 48 HRC.	S, H									
KC635M	Coated carbide grade with TiAlN coating. KC635M is a high-performance grade for higher speeds and is the first choice for stainless steels. KC635M grade is characterised by a high hardness and wear resistance. This grade is suitable for cutting hard materials (up to 65 HRC).	P, M, K, S									

wear resistance ⟷ toughness



Coatings provide high-speed capability and are engineered for roughing to finishing.

P	Steel
M	Stainless Steel
K	Cast Iron
N	Non-Ferrous
S	High-Temp Alloys
H	Hardened Materials
C	CFRP Materials

Grades

Coating	Grade Description		wear resistance ← → toughness								
			05	10	15	20	25	30	35	40	45
KC625M	Coated carbide grade with PVD (TiCN) coating. For universal use due to its high wear resistance and hardness. Only use wet or with MQL (minimum quantity lubrication).	P			■	■	■	■			
		K			■	■	■	■			
		S			■	■	■	■			
KC639M	PVD (AlTiN)-coated carbide on a submicron carbide substrate. This hard coating provides outstanding performance in milling hardened materials (58–65 HRC).	P			■	■	■	■			
		H	■	■	■						
KCSM15	Coated carbide grade with thick PVD coating and optimised chemistry and process for increased wear resistance. Outstanding protection in milling stainless steel to mitigate crater, DOCN (depth-of-cut notching), and flank wear. Excellent performance up to 52 HRC.	M		■	■	■	■				
		S	■	■	■	■	■				
		H	■	■	■	■					
KCN05	High-performance grade A pure, diamond-coated carbide for milling CFRP and graphite. It is a very tough and wear-resistant grade.	C	■	■							
KC633M	Coated carbide grade with PVD multilayer coating. KC633M™ is designed for dry milling most types of material, apart from the hardened variety. This grade is characterised by good hardness and wear resistance. It provides outstanding protection for solid carbide tools against cratering and abrasion.	P			■	■	■	■			
		M			■	■	■	■			
		S			■	■	■	■			

Beyond™ Solid Carbide End Milling

High-Performance milling in a new dimension

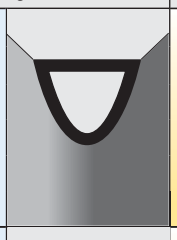
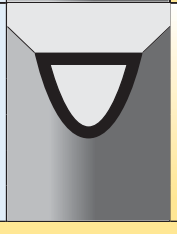
Kennametal is pleased to announce the KCPM15™ and KCSM15™ grades — the first Beyond grades for solid carbide end mills. KCPM15 and KCSM15 grades feature an improved high-performance carbide substrate with proprietary aluminium titanium nitride (AlTiN) PVD coating.

Features and Benefits

- Engineered to increase tool life and productivity by up to 30%.
- For use in milling steels and stainless steels.
- Improved resistance to cratering, flank wear, and depth-of-cut notching.

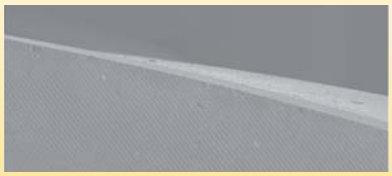
Workpiece Materials:

P	Steel
M	Stainless Steel
K	Cast Iron
N	Non-Ferrous
S	High-Temp Alloys
H	Hardened Materials

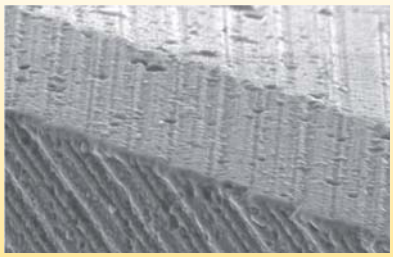
Coating		Grade Description	
KCPM15		Coated carbide grade with thick PVD coating and optimised chemistry and process for increased wear resistance. Outstanding protection in milling stainless steel to mitigate crater, DOCN (depth-of-cut notching), and flank wear. Excellent performance up to 52 HRC.	P M K
KCSM15		Coated carbide grade with thick PVD coating and optimised chemistry and process for increased wear resistance. Outstanding protection in milling stainless steel to mitigate crater, DOCN (depth-of-cut notching), and flank wear. Excellent performance up to 52 HRC.	S H

Conventional End Mill Cutting Edge

Conventional



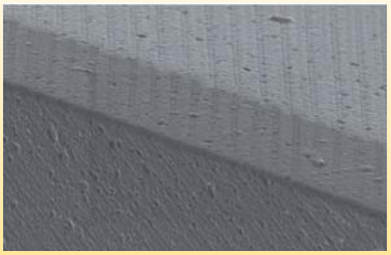


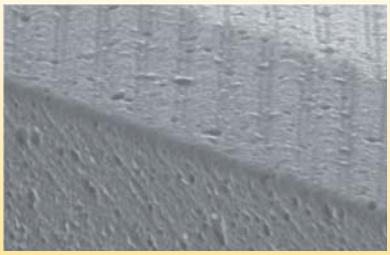


KCPM15™/KCSM15™ End Mill Cutting Edge

KCPM15/KCSM15 grade

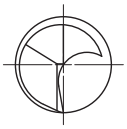
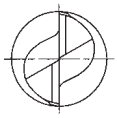
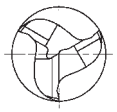
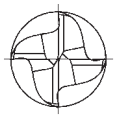
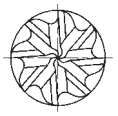
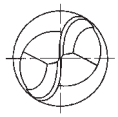
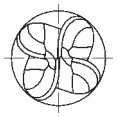
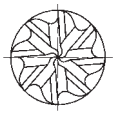






View: 1st and 2nd relief.

End Mill Type Recommendation

End Mills									
Z = number of teeth		Fine Finishing	Finishing	Roughing	Slot Milling	Plunging	Contour Milling	Peel Milling	Trochoidal Milling
end mill Z = 1		○	○	●	●	●	○	○	○
end mill Z = 2		○	○	◑	●	●	○	○	○
end mill Z = 3		○	◑	◑	●	◑	○	○	○
end mill Z = 4/5		◑	●	●	●	○	○	●	●
multi-flute cutter Z = 6–19		●	●	○	○	○	○	●	●
Ball Nose and Torus End Mills									
ball nose end mill Z = 2					●		●		
ball nose end mill Z = 4					◑		●		
ball nose end mill Z = 6							●		

● first choice

◑ suitable with limitations

○ not recommended

Always select a tool with the shortest possible flute length whenever possible. This will increase the stability of the tool and give the best results.

When selecting an end mill, the following machining factors will affect your selection of the correct end mill for your application:

1. Tool overhang.
2. Coolant flow.
3. Machine and setup stability.
4. Machine power and torque.
5. Material to be machined.
6. Machine adaptor size (DV40, DV50, HSK63, etc.).
7. See Tool Reference Guides on pages P2–P5.

Recommended Adaptors per End Mill Platform

SCEM Platform	Recommended Adaptors	
	First Choice	Alternate Choice
HARVI™ I	HydroForce™	Shrink Fit
HARVI II	HydroForce	Shrink Fit
HARVI III	HydroForce	Shrink Fit
HARVI II Long	HydroForce	Shrink Fit
High-Performance Roughers	HydroForce	Weldon® Adaptor
RSM II	Shrink Fit	Shrink Fit
High-Performance Finishers	HydroForce	Shrink Fit
MaxiMet™/Aluminium Tools	HydroForce	Shrink Fit
Hard Material End Mills/KenFeed™	HydroForce	Shrink Fit
GOmill™	Shrink Fit	Weldon Adaptor

Select Adaptor per Technical Data/Characteristics

Technical data/characteristics	Toolholders				
	HydroForce high torque	Shrink Fit	Milling chuck	ER collet chuck	Weldon adaptor
torque transmission	★★★★★	★★★★	★★★★★	★★	★★★★★
radial runout (T.I.R.)[1]	★★★★★	★★★★★	★★★★	★★★	★
radial rigidity[2]	★★★★	★★★★★	★★★	★★★	★★★
tool length adjustment	★★★★★	★★★★	★	★★★★	★★
tool shank tolerance requirement	★★★★	★★	★★★	★★★★★	★★★
through coolant	★★★★★	★★★★★	★★★	★★★	★★
minimum quantity lubrication (MQL)	★★★★★	★★★★★	★	★	★
dampening capability	★★★★★	★	★★★	★★★	★★★
shank diameter range[3]	★★★★★	★	★★★★★	★★★★★	★
cost of toolholder	★★	★★★	★	★★★★	★★★★★
low requirement of external devices[4]	★★★★★	★	★★★★	★★★★	★★★★★
ease of handling	★★★★★	★★★	★★	★★★★	★★★★
dust resistance	★★★★★	★★★★★	★★★	★★★	★★★★
high-speed capability	★★★★★	★★★★★	★★★	★★★	★
balancing accuracy	★★★★★	★★★★★	★★★	★★★	★

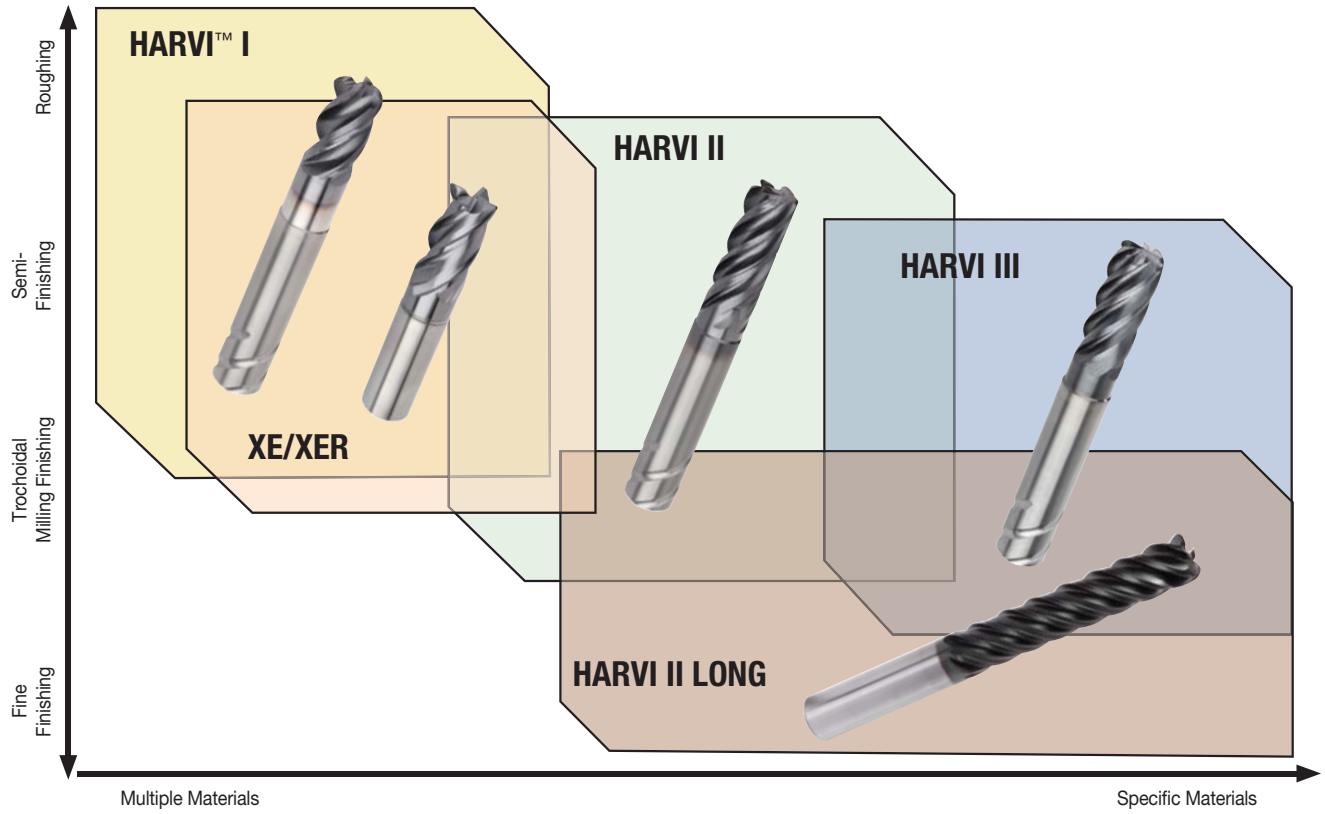
[1] Radial runout may affect tool life.
[2] Radial rigidity for Weldon holder is low at a direction perpendicular to the screw.
[3] Accepts different shank diameters through the use of reduction sleeves or due to collapse range.
[4] Collet chucks and milling chucks may require the use of a torque or special wrench; Shrink Fit adaptor requires a shrinking unit.

High-Performance Capability End Mills

Primary Application

High-performance capability offers plunging, slotting, and profiling at the highest possible feed rates for a wide range of materials from steel, stainless steel, cast iron, and high-temperature alloys to hard materials. These end mills are designed to provide maximum Metal Removal Rates (MRR) and to achieve superior surface conditions.

Several platforms with a wide range of diameters and corner configurations, such as chamfer, radii, sharp edges, and ball nose, are available from stock.



Designed for roughing and finishing with one tool in a wide range of applications and workpiece materials.



- Roughing, semi-finishing, and finishing with one tool.
- Outstanding metal removal rates increase productivity.
- Excellent surface quality and accuracy.
- KCPM15™ and KCSM15™ Beyond™ grades for long tool life.
- Increased process safety with Safe-Lock™ by HAIMER® shanks.

HARVI™ I

High-Performance Solid Carbide End Mills

Primary Application

The HARVI I system offers plunging, slotting, and profiling at the highest possible feed rates for a wide range of materials. These end mills are designed to provide maximum Metal Removal Rates (MRR) and to achieve superior surface conditions. A wide range of diameters and corner configurations, such as chamfer, radii, and sharp edges, are available from stock. To prevent pull out of end mills during heavy cuts, the HARVI I system is available equipped with the Safe-Lock™ system by HAIMER®.

- Roughing and finishing with one tool.
- Outstanding metal removal rates increase productivity.
- KCPM15™ and KCSM15™ Beyond™ grades for long tool life.

Features and Benefits

Advanced Technology

- Four unequally spaced flutes for chatter-free machining at high feed rates.
- Centre cutting design for plunging and improved ramping and helical interpolation capabilities.
- 1 x D full slotting capability in:
  - Steel
  - Stainless steel
  - Titanium

Tailored Grades

- KCPM15 Beyond grade for outstanding wear protection in stainless steel to mitigate crater, depth-of-cut notching, and flank wear.
- KCSM15 Beyond grade for exceptional tool life in titanium.
- Universal KC643M™ grade suitable for cutting steel, cast iron, stainless steel (wet), and titanium (wet).

Customisation

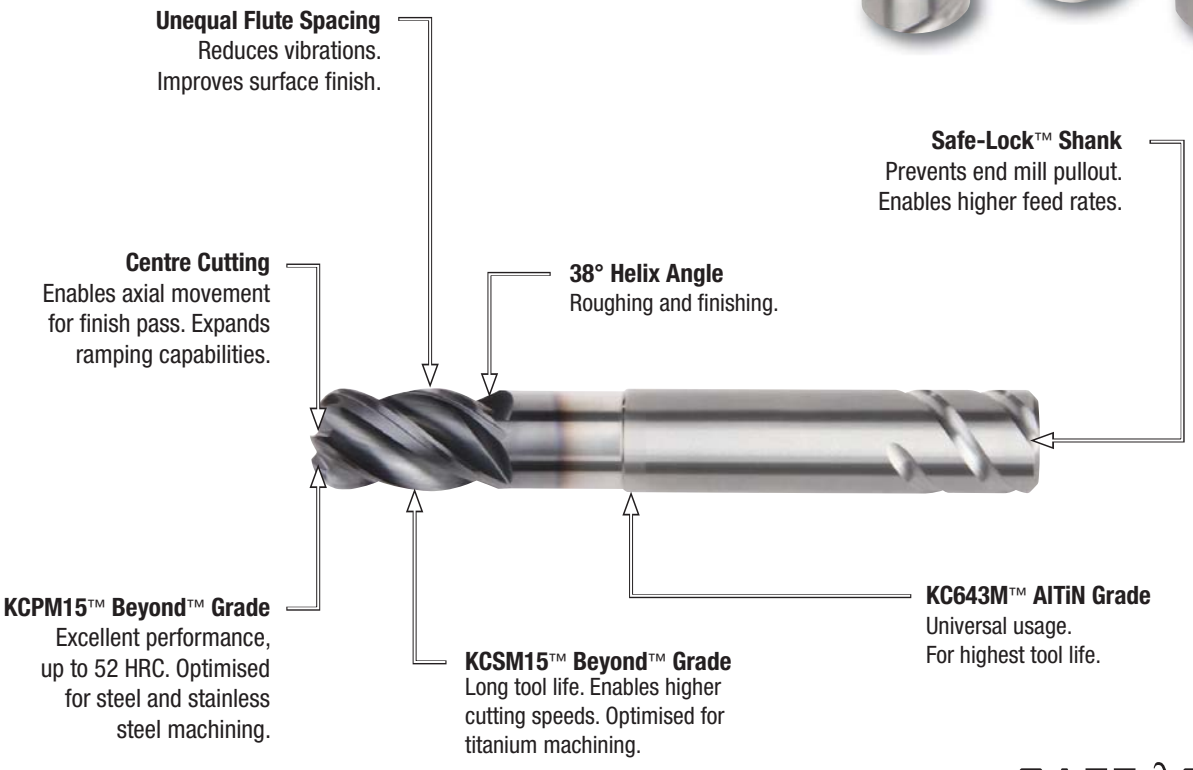
- Intermediate diameters available.
- Expanded length of tool and increased length of cut are possible.
- Chip divider geometry reduces power consumption and improves chip formation in difficult-to-cut materials.
- Internal coolant axial and radial available.
- Various shanks and non-standard coatings available.
- Multiple steps possible.

Extensive Standard Offering

- Diameter range 4–25mm.
- Necked, corner radii and chamfer offering.
- Extended-reach length.
- Ball nose with extended length of cut.
- Chip divider geometry for reduced power consumption and improved chip formation in difficult-to-cut materials.

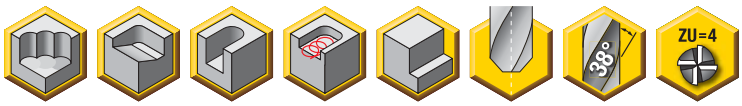
Designed for roughing and finishing with one tool in almost all materials.



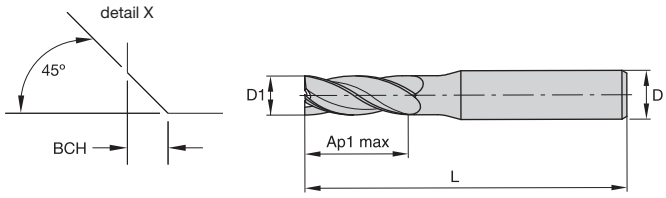


SAFE-λOCK®
by HAIMER®

- Single tool for roughing and finishing applications.
- Unequal flute spacing minimises chatter for smoother machining.
- Centre cutting.





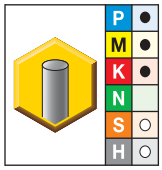


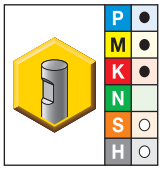
End Mill Tolerances

D1	tolerance e8	D	tolerance h6
≤3	-0,014/-0,028	≤3	+0/-0,006
>3–6	-0,020/-0,038	>3–6	+0/-0,008
>6–10	-0,025/-0,047	>6–10	+0/-0,009
>10–18	-0,032/-0,059	>10–18	+0/-0,011
>18–30	-0,040/-0,073	>18–30	+0/-0,013

beyond

F4AS...DL • 4-Flute • Metric



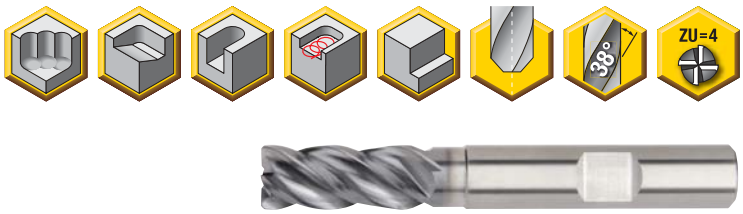


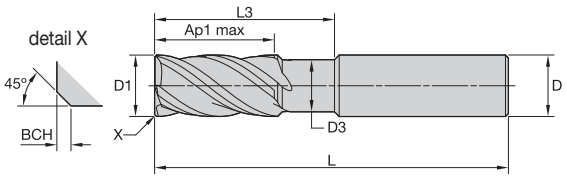
● first choice
○ alternate choice

KCPM15	KCPM15	D1	D	Ap1 max	L	BCH
F4AS0400ADL38	**F4AS0400BDL38**	4,00	6,00	12,00	55,00	0,40
F4AS0500ADL38	**F4AS0500BDL38**	5,00	6,00	13,00	57,00	0,40
F4AS0600ADL38	**F4AS0600BDL38**	6,00	6,00	13,00	57,00	0,40
F4AS0800ADL38	**F4AS0800BDL38**	8,00	8,00	16,00	63,00	0,40
F4AS1000ADL38	**F4AS1000BDL38**	10,00	10,00	22,00	72,00	0,50
F4AS1200ADL38	**F4AS1200BDL38**	12,00	12,00	26,00	83,00	0,50
F4AS1400ADL38	**F4AS1400BDL38**	14,00	14,00	26,00	83,00	0,50
F4AS1600ADL38	**F4AS1600BDL38**	16,00	16,00	32,00	92,00	0,50
F4AS1800ADL38	**F4AS1800BDL38**	18,00	18,00	32,00	92,00	0,50
F4AS2000ADL38	**F4AS2000BDL38**	20,00	20,00	38,00	104,00	0,50
F4AS2500ADL38	**F4AS2500BDL38**	25,00	25,00	45,00	121,00	0,50

NOTE: For application data, see page P23.

- Kennametal standard dimensions.
- Centre cutting.
- Unequal flute spacing minimises chatter for smoother machining.
- Single tool for both roughing and finishing operations requiring fewer setups.





End Mill Tolerances

D1	tolerance e8	D	tolerance h6 + / -
≤3	-0,014/-0,028	≤3	+0/-0,006
>3–6	-0,020/-0,038	>3–6	+0/-0,008
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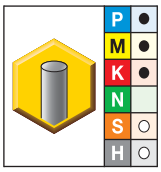
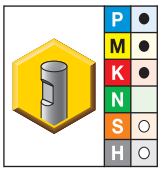
>10–18	-0,032/-0,059	>10–18	+0/-0,011
>18–30	-0,040/-0,073	>18–30	+0/-0,013

UADE.. • 4-Flute with Neck • Metric



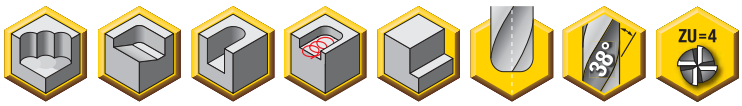


● first choice
○ alternate choice

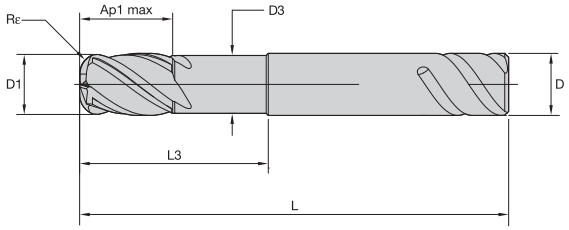
KCPM15	KCPM15	D1	D	D3	Ap1 max	L3	L	BCH
UADE0400A4BV	**UADE0400B4BV**	4,00	6,00	3,76	11,00	16,00	57,00	0,40
UADE0500A4BV	**UADE0500B4BV**	5,00	6,00	4,70	13,00	18,00	57,00	0,40
UADE0600A4BV	**UADE0600B4BV**	6,00	6,00	5,64	13,00	18,00	57,00	0,40
UADE0800A4BV	**UADE0800B4BV**	8,00	8,00	7,52	16,00	24,00	63,00	0,40
UADE1000A4BV	**UADE1000B4BV**	10,00	10,00	9,40	22,00	30,00	72,00	0,50
UADE1200A4BV	**UADE1200B4BV**	12,00	12,00	11,28	26,00	36,00	83,00	0,50
UADE1400A4BV	**UADE1400B4BV**	14,00	14,00	13,16	26,00	42,00	83,00	0,50
UADE1600A4BV	**UADE1600B4BV**	16,00	16,00	15,04	32,00	48,00	92,00	0,50
UADE2000A4BV	**UADE2000B4BV**	20,00	20,00	18,80	38,00	60,00	104,00	0,50
UADE2500A4BV	**UADE2500B4BV**	25,00	25,00	23,50	45,00	75,00	121,00	0,50

NOTE: For application data, see page P23.

- Kennametal standard dimensions.
- Centre cutting.
- Unequal flute spacing minimises chatter for smoother machining.
- Single tool for both roughing and finishing operations requiring fewer setups.





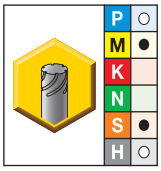


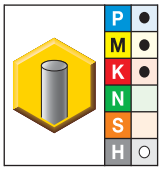
End Mill Tolerances

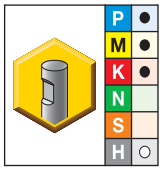
D1	tolerance e8	D	tolerance h6
≤3	-0,014/-0,028	≤3	+0/-0,006
>3–6	-0,020/-0,038	>3–6	+0/-0,008
>6–10	-0,025/-0,047	>6–10	+0/-0,009
>10–18	-0,032/-0,059	>10–18	+0/-0,011
>18–30	-0,040/-0,073	>18–30	+0/-0,013

beyond

UBDE • F4AS.. • 4-Flute with Neck • Metric







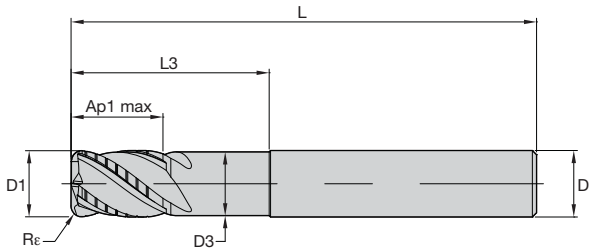
● first choice
○ alternate choice

KCSM15	KCPM15	KCPM15	D1	D	D3	Ap1 max	L3	L	Rε
–	F4AS0600AWM38R050	F4AS0600BWM38R050	6,00	6,00	5,64	9,00	18,00	63,00	0,50
–	F4AS0600AWM38R100	F4AS0600BWM38R100	6,00	6,00	5,64	9,00	18,00	63,00	1,00
–	F4AS0800AWM38R050	F4AS0800BWM38R050	8,00	8,00	7,52	12,00	24,00	68,00	0,50
–	F4AS0800AWM38R100	F4AS0800BWM38R100	8,00	8,00	7,52	12,00	24,00	68,00	1,00
–	F4AS1000AWL38R050	F4AS1000BWL38R050	10,00	10,00	9,40	15,00	30,00	76,00	0,50
–	F4AS1000AWL38R100	F4AS1000BWL38R100	10,00	10,00	9,40	15,00	30,00	76,00	1,00
–	F4AS1000AWL38R200	F4AS1000BWL38R200	10,00	10,00	9,40	15,00	30,00	76,00	2,00
–	F4AS1000AWL38R300	F4AS1000BWL38R300	10,00	10,00	9,40	15,00	30,00	76,00	3,00
–	F4AS1000AWL38R400	F4AS1000BWL38R400	10,00	10,00	9,40	15,00	30,00	76,00	4,00
UBDE1200E4AQE *	F4AS1200AWL38R050	F4AS1200BWL38R050	12,00	12,00	11,28	18,00	36,00	83,00	0,50
UBDE1200E4AQG *	F4AS1200AWL38R100	F4AS1200BWL38R100	12,00	12,00	11,28	18,00	36,00	83,00	1,00
UBDE1200E4AQK *	F4AS1200AWL38R200	F4AS1200BWL38R200	12,00	12,00	11,28	18,00	36,00	83,00	2,00
UBDE1200E4AQM *	F4AS1200AWL38R300	F4AS1200BWL38R300	12,00	12,00	11,28	18,00	36,00	83,00	3,00
UBDE1200E4AQN *	F4AS1200AWL38R400	F4AS1200BWL38R400	12,00	12,00	11,28	18,00	36,00	83,00	4,00
UBDE1600E4AQE *	F4AS1600AWX38R050	F4AS1600BWX38R050	16,00	16,00	15,04	24,00	48,00	100,00	0,50
UBDE1600E4AQG *	F4AS1600AWX38R100	F4AS1600BWX38R100	16,00	16,00	15,04	24,00	48,00	100,00	1,00
UBDE1600E4AQK *	F4AS1600AWX38R200	F4AS1600BWX38R200	16,00	16,00	15,04	24,00	48,00	100,00	2,00
UBDE1600E4AQM *	F4AS1600AWX38R300	F4AS1600BWX38R300	16,00	16,00	15,04	24,00	48,00	100,00	3,00
UBDE1600E4AQN *	F4AS1600AWX38R400	F4AS1600BWX38R400 *	16,00	16,00	15,04	24,00	48,00	100,00	4,00
UBDE1600E4AQP *	F4AS1600AWX38R600	F4AS1600BWX38R600	16,00	16,00	15,04	24,00	48,00	100,00	6,00
UBDE2000E4AQE *	F4AS2000AWX38R050	F4AS2000BWX38R050	20,00	20,00	18,80	30,00	60,00	115,00	0,50
UBDE2000E4AQG *	F4AS2000AWX38R100	F4AS2000BWX38R100	20,00	20,00	18,80	30,00	60,00	115,00	1,00
UBDE2000E4AQK *	F4AS2000AWX38R200	F4AS2000BWX38R200 *	20,00	20,00	18,80	30,00	60,00	115,00	2,00
UBDE2000E4AQM *	F4AS2000AWX38R300	F4AS2000BWX38R300	20,00	20,00	18,80	30,00	60,00	115,00	3,00
UBDE2000E4AQN *	F4AS2000AWX38R400	F4AS2000BWX38R400	20,00	20,00	18,80	30,00	60,00	115,00	4,00
UBDE2000E4AQP *	F4AS2000AWX38R600	F4AS2000BWX38R600	20,00	20,00	18,80	30,00	60,00	115,00	6,00
UBDE2500E4AQE *	F4AS2500AWX38R050	F4AS2500BWX38R050	25,00	25,00	23,50	37,50	75,00	135,00	0,50
UBDE2500E4AQG *	F4AS2500AWX38R100	–	25,00	25,00	23,50	37,50	75,00	135,00	1,00
UBDE2500E4AQK *	F4AS2500AWX38R200	F4AS2500BWX38R200	25,00	25,00	23,50	37,50	75,00	135,00	2,00
UBDE2500E4AQM *	–	F4AS2500BWX38R300	25,00	25,00	23,50	37,50	75,00	135,00	3,00
UBDE2500E4AQN *	F4AS2500AWX38R400	F4AS2500BWX38R400	25,00	25,00	23,50	37,50	75,00	135,00	4,00
UBDE2500E4AQP *	F4AS2500AWX38R600	F4AS2500BWX38R600	25,00	25,00	23,50	37,50	75,00	135,00	6,00

NOTE: For application data, see pages P23–P24.
*Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

- Kennametal standard dimensions.
- Centre cutting.
- Unequal flute spacing minimises chatter for smoother machining.
- Chipbreaker profile.



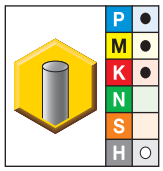


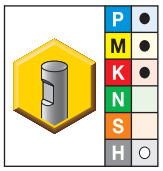
End Mill Tolerances

D1	tolerance e8	D	tolerance h6
≤3	-0,014/-0,028	≤3	+0/-0,006
>3–6	-0,020/-0,038	>3–6	+0/-0,008
>6–10	-0,025/-0,047	>6–10	+0/-0,009
>10–18	-0,032/-0,059	>10–18	+0/-0,011
>18–30	-0,040/-0,073	>18–30	+0/-0,013

beyond

F4BS.. • 4-Flute with Neck and Chipbreaker • Metric



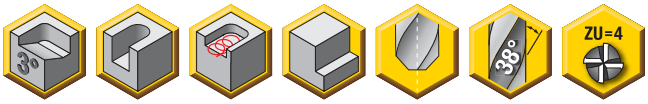


● first choice
○ alternate choice

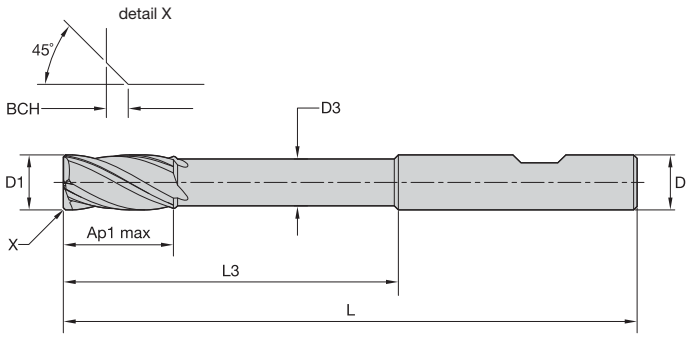
KCPM15	KCPM15	D1	D	D3	Ap1 max	L3	L	Rε
F4BS0600AWM38R050	F4BS0600BWM38R050	6,00	6,00	5,80	9,00	18,00	63,00	0,50
F4BS0600AWM38R100	F4BS0600BWM38R100 *	6,00	6,00	5,80	9,00	18,00	63,00	1,00
F4BS0800AWM38R050	F4BS0800BWM38R050	8,00	8,00	7,80	12,00	24,00	68,00	0,50
F4BS0800AWM38R100	F4BS0800BWM38R100	8,00	8,00	7,80	12,00	24,00	68,00	1,00
F4BS1000AWL38R050	F4BS1000BWL38R050	10,00	10,00	9,50	15,00	30,00	76,00	0,50
F4BS1000AWL38R100	F4BS1000BWL38R100	10,00	10,00	9,50	15,00	30,00	76,00	1,00
F4BS1000AWL38R200	F4BS1000BWL38R200 *	10,00	10,00	9,50	15,00	30,00	76,00	2,00
F4BS1000AWL38R300	F4BS1000BWL38R300	10,00	10,00	9,50	15,00	30,00	76,00	3,00
F4BS1000AWL38R400 *	F4BS1000BWL38R400	10,00	10,00	9,50	15,00	30,00	76,00	4,00
F4BS1200AWL38R050	F4BS1200BWL38R050	12,00	12,00	11,50	18,00	36,00	84,00	0,50
F4BS1200AWL38R100	F4BS1200BWL38R100	12,00	12,00	11,50	18,00	36,00	84,00	1,00
F4BS1200AWL38R200	F4BS1200BWL38R200	12,00	12,00	11,50	18,00	36,00	84,00	2,00
F4BS1200AWL38R300	F4BS1200BWL38R300 *	12,00	12,00	11,50	18,00	36,00	84,00	3,00
F4BS1200AWL38R400	F4BS1200BWL38R400	12,00	12,00	11,50	18,00	36,00	84,00	4,00
F4BS1600AWX38R050	F4BS1600BWX38R050 *	16,00	16,00	15,00	24,00	48,00	100,00	0,50
F4BS1600AWX38R100	F4BS1600BWX38R100 *	16,00	16,00	15,00	24,00	48,00	100,00	1,00
F4BS1600AWX38R200	F4BS1600BWX38R200 *	16,00	16,00	15,00	24,00	48,00	100,00	2,00
F4BS1600AWX38R300 *	F4BS1600BWX38R300	16,00	16,00	15,00	24,00	48,00	100,00	3,00
F4BS1600AWX38R400 *	F4BS1600BWX38R400	16,00	16,00	15,00	24,00	48,00	100,00	4,00
F4BS2000AWX38R050	F4BS2000BWX38R050	20,00	20,00	19,00	30,00	60,00	115,00	0,50
F4BS2000AWX38R100	F4BS2000BWX38R100 *	20,00	20,00	19,00	30,00	60,00	115,00	1,00
F4BS2000AWX38R200 *	F4BS2000BWX38R200 *	20,00	20,00	19,00	30,00	60,00	115,00	2,00
F4BS2000AWX38R300 *	F4BS2000BWX38R300 *	20,00	20,00	19,00	30,00	60,00	115,00	3,00
F4BS2000AWX38R400 *	F4BS2000BWX38R400 *	20,00	20,00	19,00	30,00	60,00	115,00	4,00
F4BS2500AWX38R050 *	F4BS2500BWX38R050 *	25,00	25,00	24,00	37,50	75,00	135,00	0,50
F4BS2500AWX38R100 *	F4BS2500BWX38R100 *	25,00	25,00	24,00	37,50	75,00	135,00	1,00
F4BS2500AWX38R200 *	F4BS2500BWX38R200 *	25,00	25,00	24,00	37,50	75,00	135,00	2,00
F4BS2500AWX38R300 *	F4BS2500BWX38R300 *	25,00	25,00	24,00	37,50	75,00	135,00	3,00
F4BS2500AWX38R400 *	F4BS2500BWX38R400 *	25,00	25,00	24,00	37,50	75,00	135,00	4,00

NOTE: For application data, see page P24.
*Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

- Kennametal standard dimensions.
- Centre cutting.
- Unequal flute spacing minimises chatter for smoother machining.
- Single tool for both roughing and finishing operations requiring fewer setups.





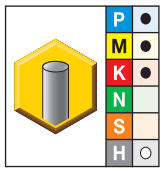


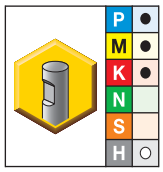
End Mill Tolerances

D1	tolerance e8	D	tolerance h6 + / -
≤ 3	-0,014/-0,028	≤ 3	0/0,006
> 3–6	-0,020/-0,038	> 3–6	0/0,008
> 6–10	-0,025/-0,047	> 6–10	0/0,009
> 10–18	-0,032/-0,059	> 10–18	0/0,011
> 18–30	-0,040/-0,073	> 18–30	0/0,013

beyond

UADE • 4-Flute Extended Reach • Metric





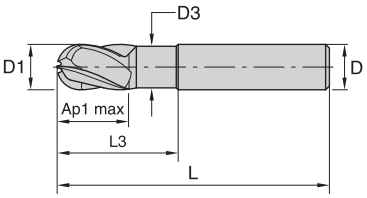
● first choice
○ alternate choice

KCPM15	KCPM15	D1	D	D3	Ap1 max	L3	L	BCH
UADE0600A4AL	**UADE0600B4AL**	6,00	6,00	5,50	12,00	42,00	100,00	0,40
UADE0800A4AL	**UADE0800B4AL**	8,00	8,00	7,30	16,00	62,00	100,00	0,40
UADE1000A4AL	**UADE1000B4AL**	10,00	10,00	9,10	20,00	60,00	100,00	0,50
UADE1200A4AL	**UADE1200B4AL**	12,00	12,00	11,00	24,00	73,00	125,00	0,50
UADE1600A4AL	**UADE1600B4AL**	16,00	16,00	15,00	32,00	100,00	150,00	0,50
UADE2000A4AL	**UADE2000B4AL**	20,00	20,00	19,00	40,00	98,00	175,00	0,50

NOTE: For application data, see page P25.

- Kennametal standard dimensions.
- Centre cutting.
- Unequal flute spacing minimises chatter for smoother machining.
- Single tool for both roughing and finishing operations requiring fewer setups.



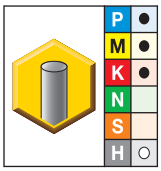


End Mill Tolerances

D1	tolerance e8	D	tolerance h6
≤3	-0,014/-0,028	≤3	+0/-0,006
>3–6	-0,020/-0,038	>3–6	+0/-0,008
>6–10	-0,025/-0,047	>6–10	+0/-0,009
>10–18	-0,032/-0,059	>10–18	+0/-0,011
>18–30	-0,040/-0,073	>18–30	+0/-0,013

beyond

F4AW.. • 4-Flute Extended Reach • Ball Nose • Metric



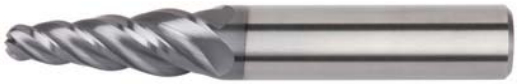
● first choice
○ alternate choice

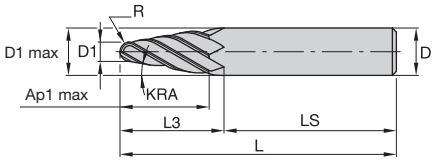
KCPM15	D1	D	D3	Ap1 max	L3	L
F4AW0600AWL38E120	6,00	6,00	5,80	6,00	12,00	76,00
F4AW0800AWL38E160	8,00	8,00	7,80	8,00	16,00	100,00
F4AW1000AWX38E200	10,00	10,00	9,50	10,00	20,00	121,50
F4AW1200AWX38E240	12,00	12,00	11,50	12,00	24,00	125,00
F4AW1600AWX38E320	16,00	16,00	15,00	16,00	32,00	150,00

NOTE: For application data, see page P26.

- Centre cutting.
- Unequal flute spacing minimises chatter for smoother machining.
- Single tool for both roughing and finishing operations requiring fewer setups.
- Side milling, slotting, and 3D milling.



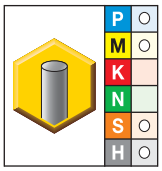




End Mill Tolerances

D1	tolerance e8	D	tolerance h6
≤3	-0,014/-0,028	≤3	+0/-0,006
>3–6	-0,020/-0,038	>3–6	+0/-0,008
>6–10	-0,025/-0,047	>6–10	+0/-0,009
>10–18	-0,032/-0,059	>10–18	+0/-0,011
>18–30	-0,040/-0,073	>18–30	+0/-0,013

F4AW..AWL38-WX38 • Unequal Flute Spacing • Taper Ball Nose



● first choice
○ alternate choice

KC633M	D1	D	Ap1 max	L2	LS	L	R	KRA
F4AW0400AWL38W040	4,00	8,0	30,5	36	45	76	2	4.0
F4AW0400AWL38W060	4,00	10,0	30,5	49	58	89	2	6.0
F4AW0500AWL38W040	5,00	10,0	38,0	44	57	89	3	4.0
F4AW0500AWL38W060	5,00	12,0	35,7	55	64	100	3	6.0
F4AW0600AWL38W040	6,00	12,0	45,8	55	54	100	3	4.0
F4AW0600AWL38W060	6,00	16,0	50,4	62	59	110	3	6.0
F4AW0800AWL38W060	8,00	16,0	42,0	62	68	110	4	6.0
F4AW0800AWL38W040	8,00	16,0	61,0	52	49	110	4	4.0
F4AW1000AWX38W040	10,00	16,0	47,7	60	62	110	5	4.0
F4AW1000AWX38W060	10,00	20,0	52,3	75	72	125	5	6.0

NOTE: For application data, see page P27.

HARVI I • UBDE • F4AS...DL • Unequal Flute Spacing



Material Group		Side Milling (A) and Slotting (B) A ap	A ae	B ap	KCPM15 Cutting Speed — vc m/min min	max	mm	Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 20%. D1 — Diameter 4,0	5,0	6,0	8,0	10,0	12,0	14,0	16,0	18,0	20,0	25,0
P	0	1,5 x D	0,5 x D	1 x D	150	200	fz	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114	0,124
	1	1,5 x D	0,5 x D	1 x D	150	200	fz	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114	0,124
	2	1,5 x D	0,5 x D	1 x D	140	190	fz	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114	0,124
	3	1,5 x D	0,5 x D	1 x D	120	160	fz	0,023	0,030	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101	0,114
	4	1,5 x D	0,5 x D	0,75 x D	90	150	fz	0,021	0,027	0,033	0,045	0,054	0,062	0,070	0,077	0,083	0,088	0,098
	5	1,5 x D	0,5 x D	1 x D	60	100	fz	0,019	0,024	0,029	0,040	0,048	0,056	0,063	0,070	0,076	0,081	0,091
	6	1,5 x D	0,5 x D	0,75 x D	50	75	fz	0,016	0,020	0,025	0,034	0,040	0,047	0,052	0,057	0,061	0,065	0,071
M	1	1,5 x D	0,5 x D	1 x D	90	115	fz	0,023	0,030	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101	0,114
	2	1,5 x D	0,5 x D	1 x D	60	80	fz	0,019	0,024	0,029	0,040	0,048	0,056	0,063	0,070	0,076	0,081	0,091
	3	1,5 x D	0,5 x D	1 x D	60	70	fz	0,016	0,020	0,025	0,034	0,040	0,047	0,052	0,057	0,061	0,065	0,071
K	1	1,5 x D	0,5 x D	1 x D	120	150	fz	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114	0,124
	2	1,5 x D	0,5 x D	1 x D	110	140	fz	0,023	0,030	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101	0,114
	3	1,5 x D	0,5 x D	1 x D	110	130	fz	0,019	0,024	0,029	0,040	0,048	0,056	0,063	0,070	0,076	0,081	0,091
S	1	1,5 x D	0,3 x D	0,3 x D	–	–	fz	0,023	0,030	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101	0,114
	2	1,5 x D	0,3 x D	0,3 x D	–	–	fz	0,013	0,016	0,019	0,026	0,032	0,037	0,042	0,046	0,050	0,054	0,061
	3	1,5 x D	0,3 x D	0,3 x D	–	–	fz	0,013	0,016	0,019	0,026	0,032	0,037	0,042	0,046	0,050	0,054	0,061
	4	1,5 x D	0,5 x D	1 x D	–	–	fz	0,016	0,021	0,026	0,037	0,045	0,052	0,058	0,064	0,069	0,074	0,084
H	1	1,5 x D	0,5 x D	0,75 x D	80	140	fz	0,021	0,027	0,033	0,045	0,054	0,062	0,070	0,077	0,083	0,088	0,098

NOTE: Those guidelines may require variations to achieve optimum results.
Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters accordingly on >12mm diameter.
For better surface finish, reduce feed per tooth.
Side milling applications — for longest reach (L3) tools, reduce ae by 30%.

HARVI I • UADE.. • Unequal Flute Spacing • With Neck



Material Group		Side Milling (A) and Slotting (B) A ap	A ae	B ap	KCPM15 Cutting Speed — vc m/min min	max	mm	Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 20%. D1 — Diameter 4,0	5,0	6,0	8,0	10,0	12,0	14,0	16,0	18,0	20,0	25,0
P	0	1,5 x D	0,5 x D	1 x D	150	200	fz	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114	0,124
	1	1,5 x D	0,5 x D	1 x D	150	200	fz	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114	0,124
	2	1,5 x D	0,5 x D	1 x D	140	190	fz	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114	0,124
	3	1,5 x D	0,5 x D	1 x D	120	160	fz	0,023	0,030	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101	0,114
	4	1,5 x D	0,5 x D	0,75 x D	90	150	fz	0,021	0,027	0,033	0,045	0,054	0,062	0,070	0,077	0,083	0,088	0,098
	5	1,5 x D	0,5 x D	1 x D	60	100	fz	0,019	0,024	0,029	0,040	0,048	0,056	0,063	0,070	0,076	0,081	0,091
	6	1,5 x D	0,5 x D	0,75 x D	50	75	fz	0,016	0,020	0,025	0,034	0,040	0,047	0,052	0,057	0,061	0,065	0,071
M	1	1,5 x D	0,5 x D	1 x D	90	115	fz	0,023	0,030	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101	0,114
	2	1,5 x D	0,5 x D	1 x D	60	80	fz	0,019	0,024	0,029	0,040	0,048	0,056	0,063	0,070	0,076	0,081	0,091
	3	1,5 x D	0,5 x D	1 x D	60	70	fz	0,016	0,020	0,025	0,034	0,040	0,047	0,052	0,057	0,061	0,065	0,071
K	1	1,5 x D	0,5 x D	1 x D	120	150	fz	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114	0,124
	2	1,5 x D	0,5 x D	1 x D	110	140	fz	0,023	0,030	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101	0,114
	3	1,5 x D	0,5 x D	1 x D	110	130	fz	0,019	0,024	0,029	0,040	0,048	0,056	0,063	0,070	0,076	0,081	0,091
S	1	1,5 x D	0,3 x D	0,3 x D	50	90	fz	0,023	0,030	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101	0,114
	3	1,5 x D	0,3 x D	0,3 x D	25	40	fz	0,013	0,016	0,019	0,026	0,032	0,037	0,042	0,046	0,050	0,054	0,061
H	1	1,5 x D	0,5 x D	0,75 x D	80	140	fz	0,021	0,027	0,033	0,045	0,054	0,062	0,070	0,077	0,083	0,088	0,098

NOTE: Those guidelines may require variations to achieve optimum results.
Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters accordingly on >12mm diameter.
For better surface finish, reduce feed per tooth.
Side milling applications — for longest reach (L3) tools, reduce ae by 30%.

HARVI I • F4AS.. WM-WX-WL • Unequal Flute Spacing • With Neck



Material Group		Side Milling (A) and Slotting (B)			KCPM15		KCSM15		Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 10%.												
		A		B	Cutting Speed — vc m/min					D1 — Diameter											
		ap	ae	ap	min	max	min	max	mm	4,0	5,0	6,0	8,0	10,0	12,0	14,0	16,0	18,0	20,0	25,0
P	0	1,5 x D	0,5 x D	1 x D	150	200	150	200	fz	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114	0,124
	1	1,5 x D	0,5 x D	1 x D	150	200	150	200	fz	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114	0,124
	2	1,5 x D	0,5 x D	1 x D	140	190	140	190	fz	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114	0,124
	3	1,5 x D	0,5 x D	1 x D	120	160	120	160	fz	0,023	0,030	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101	0,114
	4	1,5 x D	0,5 x D	0,75 x D	90	150	90	150	fz	0,021	0,027	0,033	0,045	0,054	0,062	0,070	0,077	0,083	0,088	0,098
	5	1,5 x D	0,5 x D	1 x D	60	100	60	100	fz	0,019	0,024	0,029	0,040	0,048	0,056	0,063	0,070	0,076	0,081	0,091
	6	1,5 x D	0,5 x D	0,75 x D	50	75	50	75	fz	0,016	0,020	0,025	0,034	0,040	0,047	0,052	0,057	0,061	0,065	0,071
M	1	1,5 x D	0,5 x D	1 x D	90	115	90	115	fz	0,023	0,030	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101	0,114
	2	1,5 x D	0,5 x D	1 x D	60	80	60	80	fz	0,019	0,024	0,029	0,040	0,048	0,056	0,063	0,070	0,076	0,081	0,091
	3	1,5 x D	0,5 x D	1 x D	60	70	60	70	fz	0,016	0,020	0,025	0,034	0,040	0,047	0,052	0,057	0,061	0,065	0,071
K	1	1,5 x D	0,5 x D	1 x D	120	150	–	–	fz	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114	0,124
	2	1,5 x D	0,5 x D	1 x D	110	140	–	–	fz	0,023	0,030	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101	0,114
	3	1,5 x D	0,5 x D	1 x D	110	130	–	–	fz	0,019	0,024	0,029	0,040	0,048	0,056	0,063	0,070	0,076	0,081	0,091
S	1	1,5 x D	0,3 x D	0,3 x D	–	–	50	90	fz	0,023	0,030	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101	0,114
	2	1,5 x D	0,3 x D	0,3 x D	–	–	25	40	fz	0,013	0,016	0,019	0,026	0,032	0,037	0,042	0,046	0,050	0,054	0,061
	3	1,5 x D	0,3 x D	0,3 x D	–	–	25	40	fz	0,013	0,016	0,019	0,026	0,032	0,037	0,042	0,046	0,050	0,054	0,061
	4	1,5 x D	0,5 x D	1 x D	–	–	50	60	fz	0,016	0,021	0,026	0,037	0,045	0,052	0,058	0,064	0,069	0,074	0,084
H	1	1,5 x D	0,5 x D	0,75 x D	80	140	80	140	fz	0,021	0,027	0,033	0,045	0,054	0,062	0,070	0,077	0,083	0,088	0,098

NOTE: Those guidelines may require variations to achieve optimum results.
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Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
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For better surface finish, reduce feed per tooth.
Side milling applications — for longest reach (L3) tools, reduce ae by 30%.

HARVI I • F4BS.. WM-WX-WL • Unequal Flute Spacing • With Neck and Chipbreaker



Material Group		Side Milling (A) and Slotting (B)			KCPM15		Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 20%.							
		A		B	Cutting Speed — vc m/min			D1 — Diameter						
		ap	ae	ap	min	max	mm	6,0	8,0	10,0	12,0	16,0	20,0	25,0
P	1	1,5 x D	0,5 x D	1 x D	150	200	fz	0,044	0,060	0,072	0,083	0,101	0,114	0,124
	2	1,5 x D	0,5 x D	1 x D	140	190	fz	0,044	0,060	0,072	0,083	0,101	0,114	0,124
	3	1,5 x D	0,5 x D	1 x D	120	160	fz	0,036	0,050	0,061	0,070	0,087	0,101	0,114
	4	1,5 x D	0,5 x D	0,75 x D	90	150	fz	0,033	0,045	0,054	0,062	0,077	0,088	0,098
	5	1,5 x D	0,5 x D	1 x D	60	100	fz	0,029	0,040	0,048	0,056	0,070	0,081	0,091
	6	1,5 x D	0,5 x D	0,75 x D	50	75	fz	0,025	0,034	0,040	0,047	0,057	0,065	0,071
M	1	1,5 x D	0,5 x D	1 x D	90	115	fz	0,036	0,050	0,061	0,070	0,087	0,101	0,114
	2	1,5 x D	0,5 x D	1 x D	60	80	fz	0,029	0,040	0,048	0,056	0,070	0,081	0,091
	3	1,5 x D	0,5 x D	1 x D	60	70	fz	0,025	0,034	0,040	0,047	0,057	0,065	0,071
K	1	1,5 x D	0,5 x D	1 x D	120	150	fz	0,044	0,060	0,072	0,083	0,101	0,114	0,124
	2	1,5 x D	0,5 x D	1 x D	110	130	fz	0,036	0,050	0,061	0,070	0,087	0,101	0,114
	3	1,5 x D	0,5 x D	1 x D	100	130	fz	0,029	0,040	0,048	0,056	0,070	0,081	0,091
H	1	1,5 x D	0,5 x D	0,75 x D	80	140	fz	0,033	0,045	0,054	0,062	0,077	0,088	0,098

NOTE: Those guidelines may require variations to achieve optimum results.
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Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters accordingly on >12mm diameter.
For better surface finish, reduce feed per tooth.
Side milling applications — for longest reach (L3) tools, reduce ae by 30%.

HARVI I • UADE • Unequal Flute Spacing • Extended Reach



Material Group		Side Milling (A) and Slotting (B)			KCPM15		Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 10%.							
		A		B	Cutting Speed — vc m/min			D1 — Diameter						
		ap	ae	ap	min	max	mm	6,0	8,0	10,0	12,0	14,0	16,0	18,0	20,0
P	0	0,75 x D	0,5 x D	0,75 x D	150	200	fz	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114
	1	0,75 x D	0,5 x D	0,75 x D	150	200	fz	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114
	2	0,75 x D	0,5 x D	0,75 x D	140	190	fz	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114
	3	0,75 x D	0,5 x D	0,75 x D	120	160	fz	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101
	4	0,75 x D	0,5 x D	0,5 x D	90	150	fz	0,033	0,045	0,054	0,062	0,070	0,077	0,083	0,088
	5	0,75 x D	0,5 x D	0,75 x D	60	100	fz	0,029	0,040	0,048	0,056	0,063	0,070	0,076	0,081
	6	0,75 x D	0,5 x D	0,5 x D	50	75	fz	0,025	0,034	0,040	0,047	0,052	0,057	0,061	0,065
M	1	0,75 x D	0,5 x D	0,75 x D	90	115	fz	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101
	2	0,75 x D	0,5 x D	0,75 x D	60	80	fz	0,029	0,040	0,048	0,056	0,063	0,070	0,076	0,081
	3	0,75 x D	0,5 x D	0,75 x D	60	70	fz	0,025	0,034	0,040	0,047	0,052	0,057	0,061	0,065
K	1	0,75 x D	0,5 x D	0,75 x D	120	150	fz	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114
	2	0,75 x D	0,5 x D	0,75 x D	110	140	fz	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101
	3	0,75 x D	0,5 x D	0,75 x D	110	130	fz	0,029	0,040	0,048	0,056	0,063	0,070	0,076	0,081
S	1	0,75 x D	0,5 x D	0,5 x D	80	140	fz	0,033	0,045	0,054	0,062	0,070	0,077	0,083	0,088

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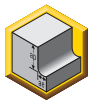
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters accordingly on >12mm diameter.
For better surface finish, reduce feed per tooth.
Side milling applications — for longest reach (L3) tools, reduce ae by 30%.

HARVI I • F4AW..WL-WX • Unequal Flute Spacing • Extended Reach • Ball Nose





Material Group		Side Milling (A) and Slotting (B)			KCPM15		Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 20%.					
		A		B	Cutting Speed — vc m/min			D1 — Diameter				
		ap	ae	ap	min	max	mm	6,0	8,0	10,0	12,0	16,0
P	0	0,5 x D	0,5 x D	0,5 x D	150	200	fz	0,044	0,060	0,072	0,083	0,101
	1	0,5 x D	0,5 x D	0,5 x D	150	200	fz	0,044	0,060	0,072	0,083	0,101
	2	0,5 x D	0,5 x D	0,5 x D	140	190	fz	0,044	0,060	0,072	0,083	0,101
	3	0,5 x D	0,5 x D	0,5 x D	120	160	fz	0,036	0,050	0,061	0,070	0,087
	4	0,5 x D	0,5 x D	0,5 x D	90	150	fz	0,033	0,045	0,054	0,062	0,077
	5	0,5 x D	0,5 x D	0,5 x D	60	100	fz	0,029	0,040	0,048	0,056	0,070
	6	0,5 x D	0,5 x D	0,5 x D	50	75	fz	0,025	0,034	0,040	0,047	0,057
M	1	0,5 x D	0,5 x D	0,5 x D	90	115	fz	0,036	0,050	0,061	0,070	0,087
	2	0,5 x D	0,5 x D	0,5 x D	60	80	fz	0,029	0,040	0,048	0,056	0,070
	3	0,5 x D	0,5 x D	0,5 x D	60	70	fz	0,025	0,034	0,040	0,047	0,057
K	1	0,5 x D	0,5 x D	0,5 x D	120	150	fz	0,044	0,060	0,072	0,083	0,101
	2	0,5 x D	0,5 x D	0,5 x D	110	130	fz	0,036	0,050	0,061	0,070	0,087
	3	0,5 x D	0,5 x D	0,5 x D	110	130	fz	0,029	0,040	0,048	0,056	0,070
H	1	0,5 x D	0,5 x D	0,5 x D	80	140	fz	0,033	0,045	0,054	0,062	0,077

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
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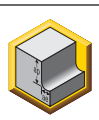
Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters accordingly on >12mm diameter.

HARVI I • F4AW..AWL38-WX38 • Unequal Flute Spacing • Taper Ball Nose • Roughing




Material Group		Side Milling (A)		KC633M			Recommended feed per tooth (fz = mm/th) for side milling (A).					
		A		Cutting Speed — vc m/min			D1 — Diameter					
		ap	ae	min		max	mm	4,0	5,0	6,0	8,0	10,0
P	0	Ap max	0,4 x D	150	–	200	fz	0,028	0,036	0,044	0,060	0,072
	1	Ap max	0,4 x D	150	–	200	fz	0,028	0,036	0,044	0,060	0,072
	2	Ap max	0,4 x D	140	–	190	fz	0,028	0,036	0,044	0,060	0,072
	3	Ap max	0,4 x D	120	–	160	fz	0,023	0,030	0,036	0,050	0,061
	4	Ap max	0,4 x D	90	–	150	fz	0,021	0,027	0,033	0,045	0,054
	5	Ap max	0,4 x D	60	–	100	fz	0,019	0,024	0,029	0,040	0,048
	6	Ap max	0.4 x D	50	–	75	fz	0,016	0,020	0,025	0,034	0,040
M	1	Ap max	0,4 x D	90	–	115	fz	0,023	0,030	0,036	0,050	0,061
	2	Ap max	0,4 x D	60	–	80	fz	0,019	0,024	0,029	0,040	0,048
	3	Ap max	0,4 x D	60	–	70	fz	0,016	0,020	0,025	0,034	0,040
S	1	Ap max	0,4 x D	50	–	90	fz	0,023	0,030	0,036	0,050	0,061
	2	Ap max	0,4 x D	25	–	40	fz	0,013	0,016	0,019	0,026	0,032
	3	Ap max	0,4 x D	25	–	40	fz	0,013	0,016	0,019	0,026	0,032
	4	Ap max	0,4 x D	50	–	60	fz	0,016	0,021	0,026	0,037	0,045
H	1	Ap max	0,4 x D	80	–	140	fz	0,021	0,027	0,033	0,045	0,054

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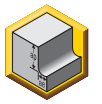
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions.
Side milling applications — for longest reach (L3) tools, reduce ae by 30%.

HARVI I • F4AW...AWL38-WX38 • Unequal Flute spacing • Taper Ball Nose • Finishing




Material Group		Side Milling (A)		KC633M			Recommended feed per tooth (fz = mm/th) for side milling (A).					
		A		Cutting Speed — vc m/min			D1 — Diameter					
		ap	ae	min		max	mm	4,0	5,0	6,0	8,0	10,0
P	0	Ap max	0,06 x D	285	–	380	fz	0,034	0,043	0,053	0,072	0,086
	1	Ap max	0,06 x D	285	–	380	fz	0,034	0,043	0,053	0,072	0,086
	2	Ap max	0,06 x D	266	–	361	fz	0,034	0,043	0,053	0,072	0,086
	3	Ap max	0,06 x D	228	–	304	fz	0,028	0,036	0,044	0,060	0,073
	4	Ap max	0,06 x D	171	–	285	fz	0,026	0,033	0,039	0,054	0,065
	5	Ap max	0,06 x D	114	–	190	fz	0,023	0,029	0,035	0,048	0,058
	4	Ap max	0,06 x D	95	–	142,5	fz	0,019	0,024	0,030	0,040	0,048
M	1	Ap max	0,06 x D	171	–	218,5	fz	0,028	0,036	0,044	0,060	0,073
	2	Ap max	0,06 x D	114	–	152	fz	0,023	0,029	0,035	0,048	0,058
	3	Ap max	0,06 x D	114	–	133	fz	0,019	0,024	0,030	0,040	0,048
S	1	Ap max	0,06 x D	95	–	171	fz	0,028	0,036	0,044	0,060	0,073
	2	Ap max	0,06 x D	47,5	–	76	fz	0,015	0,019	0,023	0,032	0,038
	3	Ap max	0,06 x D	47,5	–	76	fz	0,015	0,019	0,023	0,032	0,038
	4	Ap max	0,06 x D	95	–	114	fz	0,019	0,025	0,031	0,044	0,053
H	1	Ap max	0,06 x D	152	–	266	fz	0,026	0,033	0,039	0,054	0,065

NOTE: Those guidelines may require variations to achieve optimum results.
Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions.
Side milling applications — for longest reach (L3) tools, reduce ae by 30%.

HARVI™ II

High-Performance Solid Carbide End Mills

Primary Application

The HARVI II system is designed to provide maximum metal removal rates with five unequally spaced flutes for roughing and finishing operations in side milling, slotting, and profiling. A wide range of diameters and corner configurations, such as chamfer, radii, and sharp edges, are available from stock. To prevent pullout of end mills during heavy cuts, the HARVI II system is available equipped with the Safe-Lock™ system by HAIMER®.

- 1 x D slotting in titanium and stainless steels with five unequally spaced flutes.
- Roughing and finishing with one tool.
- KCPM15™ and KCSM15™ Beyond™ grades for long tool life.

Features and Benefits

Advanced Technology

- Five unequally spaced flutes for chatter-free machining at high feed rates.
- Proprietary parabolic core design increases stability.
- Ramping up to 3°.
- 1 x D full slotting capability in:
  - — Titanium
  - — Stainless steel

Tailored Grades

- KCPM15™ Beyond grade for outstanding wear protection in stainless steel to mitigate crater, depth-of-cut notching, and flank wear.
- KCSM15™ Beyond grade for exceptional tool life in titanium.
- Universal KC643M™ grade suitable for cutting steel, cast iron, stainless steel (wet), and titanium (wet).

Customisation

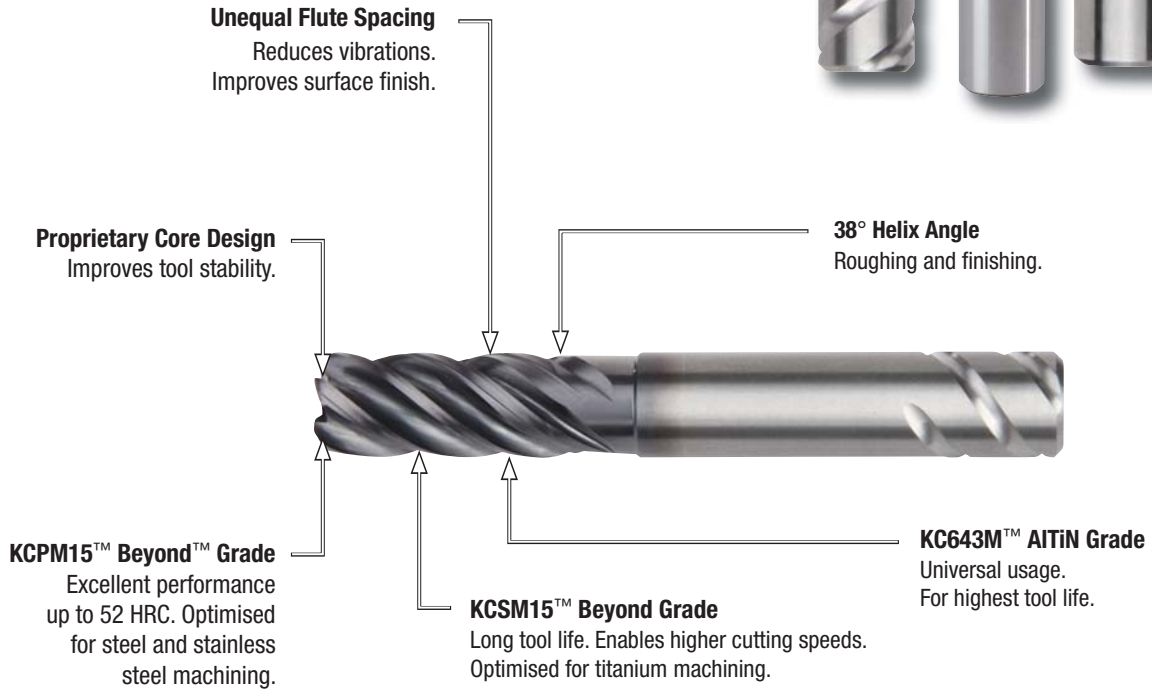
- Intermediate diameters available.
- Expanded length of tool and increased length of cut possible.
- Chip divider geometry reduces power consumption and improves chip formation in difficult-to-cut materials.
- Ball-nose version available.
- Internal coolant axial and radial available.
- Various shanks and non-standard coatings available.
- Multiple steps possible.

Extensive Standard Offering

- Diameter range 4–25mm.
- Necked, corner radii, and square-end offering.

High-feed roughing and finishing with one tool at highest length of cut.

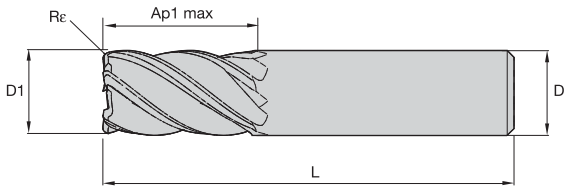




SAFE-λOCK®
by HAIMER®

- Single tool for both roughing and finishing operations for fewer setups.
- Unequal flute spacing minimises chatter for smoother machining.
- Kennametal standard dimensions.
- Non-centre cutting.
- Five-flute geometry enables slotting up to 1 x D.



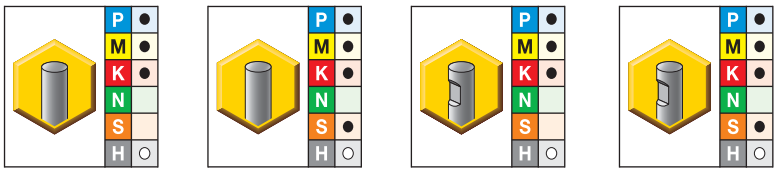


End Mill Tolerances

D1	tolerance e8	D	tolerance h6
≤3	-0,014/-0,028	≤3	+0/-0,006
>3–6	-0,020/-0,038	>3–6	+0/-0,008
>6–10	-0,025/-0,047	>6–10	+0/-0,009
>10–18	-0,032/-0,059	>10–18	+0/-0,011
>18–30	-0,040/-0,073	>18–30	+0/-0,013

beyond

UCDE • 5-Flute • Metric



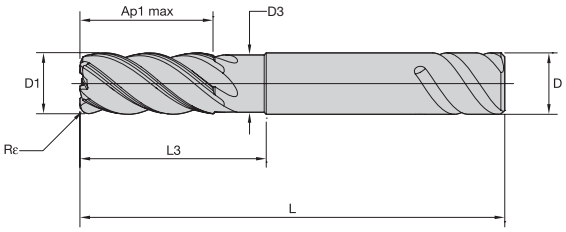
● first choice
○ alternate choice

KCPM15	KC643M	KCPM15	KC643M	D1	D	Ap1 max	L	Rε
UCDE0400A5ARA	UCDE0400A5ARA	UCDE0400B5ARA	UCDE0400B5ARA	4,00	6,00	11,00	55,00	0,25
UCDE0400A5ASA	UCDE0400A5ASA	–	–	4,00	6,00	11,00	55,00	–
UCDE0500A5ARA	UCDE0500A5ARA	UCDE0500B5ARA	UCDE0500B5ARA	5,00	6,00	13,00	57,00	0,25
UCDE0500A5ASA	UCDE0500A5ASA	–	–	5,00	6,00	13,00	57,00	–
UCDE0600A5ARA	UCDE0600A5ARA	UCDE0600B5ARA	UCDE0600B5ARA	6,00	6,00	13,00	57,00	0,40
UCDE0600A5ASA	UCDE0600A5ASA	–	–	6,00	6,00	13,00	57,00	–
UCDE0700A5ARA	UCDE0700A5ARA	UCDE0700B5ARA	UCDE0700B5ARA	7,00	8,00	16,00	63,00	0,40
UCDE0700A5ASA	UCDE0700A5ASA	–	–	7,00	8,00	16,00	63,00	–
UCDE0800A5ARA	UCDE0800A5ARA	UCDE0800B5ARA	UCDE0800B5ARA	8,00	8,00	19,00	63,00	0,50
UCDE0800A5ASA	UCDE0800A5ASA	–	–	8,00	8,00	19,00	63,00	–
UCDE0900A5ARA	UCDE0900A5ARA	UCDE0900B5ARA	UCDE0900B5ARA *	9,00	10,00	19,00	72,00	0,50
UCDE0900A5ASA	UCDE0900A5ASA	–	–	9,00	10,00	19,00	72,00	–
UCDE1000A5ARA	UCDE1000A5ARA	UCDE1000B5ARA	UCDE1000B5ARA	10,00	10,00	22,00	72,00	0,50
UCDE1000A5ASA	UCDE1000A5ASA	–	–	10,00	10,00	22,00	72,00	–
UCDE1200A5ARA	UCDE1200A5ARA	UCDE1200B5ARA	UCDE1200B5ARA	12,00	12,00	26,00	83,00	0,75
UCDE1200A5ASA	UCDE1200A5ASA	–	–	12,00	12,00	26,00	83,00	–
UCDE1400A5ARA	UCDE1400A5ARA	UCDE1400B5ARA	UCDE1400B5ARA	14,00	14,00	26,00	83,00	0,75
UCDE1400A5ASA	UCDE1400A5ASA	–	–	14,00	14,00	26,00	83,00	–
UCDE1600A5ARA	UCDE1600A5ARA	UCDE1600B5ARA	UCDE1600B5ARA	16,00	16,00	32,00	92,00	0,75
UCDE1600A5ASA	UCDE1600A5ASA	–	–	16,00	16,00	32,00	92,00	–
UCDE1800A5ARA	UCDE1800A5ARA	UCDE1800B5ARA	UCDE1800B5ARA	18,00	18,00	32,00	92,00	0,75
UCDE1800A5ASA	UCDE1800A5ASA	–	–	18,00	18,00	32,00	92,00	–
UCDE2000A5ARA	UCDE2000A5ARA	UCDE2000B5ARA	UCDE2000B5ARA	20,00	20,00	38,00	104,00	0,75
UCDE2000A5ASA	UCDE2000A5ASA	–	–	20,00	20,00	38,00	104,00	–
UCDE2500A5ARA	UCDE2500A5ARA	UCDE2500B5ARA	UCDE2500B5ARA	25,00	25,00	45,00	121,00	0,75
UCDE2500A5ASA	UCDE2500A5ASA	–	–	25,00	25,00	45,00	121,00	–

NOTE: For application data, see page P33.
*Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

- Kennametal standard dimensions.
- Non-centre cutting.
- Ramping up to 3°.
- Optimised geometry for titanium machining.
- Unequal flute spacing minimises chatter for smoother machining.
- Single tool for both roughing and finishing operations requiring fewer setups.
- Five-flute geometry enables slotting up to 1 x D.



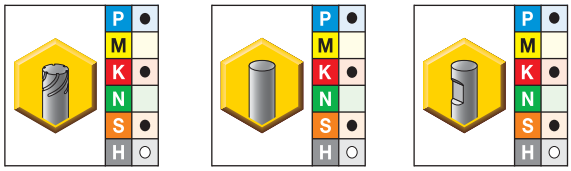


End Mill Tolerances

D1	tolerance e8	D	tolerance h6
≤3	-0,014 / -0,028	≤3	+0 / -0,006
>3–6	-0,020 / -0,038	>3–6	+0 / -0,008
>6–10	-0,025 / -0,047	>6–10	+0 / -0,009
>10–18	-0,032 / -0,059	>10–18	+0 / -0,011
>18–30	-0,040 / -0,073	>18–30	+0 / -0,013

beyond

UDDE • 5-Flute with Neck • Metric

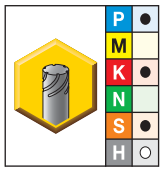


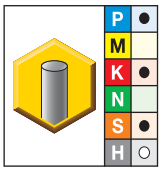
● first choice
○ alternate choice

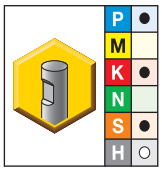
KCSM15	KC643M	KC643M	D1	D	D3	Ap1 max	L3	L	Rε
–	–	UDDE0600B5ARA	6,00	6,00	5,64	13,00	18,00	63,00	0,20
–	UDDE0600A5ARA	UDDE0600B5ARB	6,00	6,00	5,64	13,00	18,00	63,00	0,50
–	UDDE0600A5ARB	UDDE0600B5ARC	6,00	6,00	5,64	13,00	18,00	63,00	1,00
–	UDDE0600A5ARC	UDDE0600B5ARD	6,00	6,00	5,64	13,00	18,00	63,00	1,50
–	UDDE0600A5ASA	–	6,00	6,00	5,64	13,00	18,00	63,00	–
–	–	UDDE0800B5ARA	8,00	8,00	7,52	19,00	24,00	76,00	0,20
–	UDDE0800A5ARA	UDDE0800B5ARB	8,00	8,00	7,52	19,00	24,00	76,00	0,50
–	UDDE0800A5ARB	UDDE0800B5ARC	8,00	8,00	7,52	19,00	24,00	76,00	1,00
–	UDDE0800A5ARC	UDDE0800B5ARD	8,00	8,00	7,52	19,00	24,00	76,00	2,00
–	UDDE0800A5ASA	–	8,00	8,00	7,52	19,00	24,00	76,00	–
–	UDDE1000A5ARA	UDDE1000B5ARA	10,00	10,00	9,40	22,00	30,00	76,00	0,50
–	UDDE1000A5ARB	UDDE1000B5ARB	10,00	10,00	9,40	22,00	30,00	76,00	1,00
–	UDDE1000A5ARC	UDDE1000B5ARC	10,00	10,00	9,40	22,00	30,00	76,00	2,00
–	UDDE1000A5ARD	UDDE1000B5ARD	10,00	10,00	9,40	22,00	30,00	76,00	2,50
–	UDDE1000A5ASA	–	10,00	10,00	9,40	22,00	30,00	76,00	–
UDDE1200E5AQE *	UDDE1200A5ARA	UDDE1200B5ARA	12,00	12,00	11,28	26,00	36,00	83,00	0,50
UDDE1200E5AQG *	UDDE1200A5ARB	UDDE1200B5ARB	12,00	12,00	11,28	26,00	36,00	83,00	1,00
UDDE1200E5AQK *	UDDE1200A5ARC	UDDE1200B5ARC	12,00	12,00	11,28	26,00	36,00	83,00	2,00
UDDE1200E5AQM *	UDDE1200A5ARD	UDDE1200B5ARD	12,00	12,00	11,28	26,00	36,00	83,00	3,00
–	UDDE1200A5ASA	–	12,00	12,00	11,28	26,00	36,00	83,00	–
–	UDDE1400A5ARA	–	14,00	14,00	13,15	26,00	42,00	84,00	0,50
–	–	UDDE1400B5ARB	14,00	14,00	13,15	26,00	42,00	84,00	1,00
–	UDDE1400A5ARC	–	14,00	14,00	13,15	26,00	42,00	84,00	2,00
–	UDDE1400A5ARD	–	14,00	14,00	13,15	26,00	42,00	84,00	3,00
–	UDDE1400A5ASA	–	14,00	14,00	13,15	26,00	42,00	84,00	–
UDDE1600E5AQE *	UDDE1600A5ARA	UDDE1600B5ARA	16,00	16,00	15,04	32,00	48,00	100,00	0,50
UDDE1600E5AQG *	UDDE1600A5ARB	UDDE1600B5ARB	16,00	16,00	15,04	32,00	48,00	100,00	1,00
UDDE1600E5AQK *	UDDE1600A5ARC	UDDE1600B5ARC	16,00	16,00	15,04	32,00	48,00	100,00	2,00

(continued)

(UDDE • 5-Flute with Neck • Metric — continued)





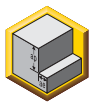


● first choice
○ alternate choice

KCSM15	KC643M	KC643M	D1	D	D3	Ap1 max	L3	L	Rε
UDDE1600E5AQM *	**UDDE1600A5ARD**	**UDDE1600B5ARD**	16,00	16,00	15,04	32,00	48,00	100,00	3,00
UDDE1600E5AQN *	**UDDE1600A5ARE**	**UDDE1600B5ARE**	16,00	16,00	15,04	32,00	48,00	100,00	4,00
UDDE1600E5AQP *	**UDDE1600A5ARP**	**UDDE1600B5ARP**	16,00	16,00	15,04	32,00	48,00	100,00	6,00
—	**UDDE1600A5ASA**	**—**	16,00	16,00	15,04	32,00	48,00	100,00	—
UDDE2000E5AQE *	**UDDE2000A5ARA**	**UDDE2000B5ARA**	20,00	20,00	18,80	38,00	60,00	115,00	0,50
UDDE2000E5AQG *	**UDDE2000A5ARB**	**UDDE2000B5ARB**	20,00	20,00	18,80	38,00	60,00	115,00	1,00
UDDE2000E5AQK *	**UDDE2000A5ARC**	**UDDE2000B5ARC**	20,00	20,00	18,80	38,00	60,00	115,00	2,00
UDDE2000E5AQM *	**UDDE2000A5ARD**	**UDDE2000B5ARD**	20,00	20,00	18,80	38,00	60,00	115,00	3,00
UDDE2000E5AQN *	**UDDE2000A5ARE**	**UDDE2000B5ARE**	20,00	20,00	18,80	38,00	60,00	115,00	4,00
UDDE2000E5AQP *	**UDDE2000A5ARP**	**UDDE2000B5ARP**	20,00	20,00	18,80	38,00	60,00	115,00	6,00
—	**UDDE2000A5ASA**	**—**	20,00	20,00	18,80	38,00	60,00	115,00	—
UDDE2500E5AQE *	**UDDE2500A5ARA**	**UDDE2500B5ARA**	25,00	25,00	23,50	45,00	75,00	135,00	0,50
UDDE2500E5AQG *	**UDDE2500A5ARB**	**UDDE2500B5ARB**	25,00	25,00	23,50	45,00	75,00	135,00	1,00
UDDE2500E5AQK *	**UDDE2500A5ARC**	**UDDE2500B5ARC**	25,00	25,00	23,50	45,00	75,00	135,00	2,00
UDDE2500E5AQM *	**UDDE2500A5ARD**	**UDDE2500B5ARD**	25,00	25,00	23,50	45,00	75,00	135,00	3,00
UDDE2500E5AQN *	**UDDE2500A5ARE**	**UDDE2500B5ARE**	25,00	25,00	23,50	45,00	75,00	135,00	4,00
UDDE2500E5AQP *	**UDDE2500A5ARP**	**UDDE2500B5ARP**	25,00	25,00	23,50	45,00	75,00	135,00	6,00
—	**UDDE2500A5ASA**	**—**	25,00	25,00	23,50	45,00	75,00	135,00	—

NOTE: For application data, see page P33.
*Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

HARVI II • UCDE • Unequal Flute Spacing





Material Group		Side Milling (A) and Slotting (B)			KC643M		KCPM15		Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 10%.										
		A		B	Cutting Speed — vc m/min		Cutting Speed — vc m/min			D1 — Diameter									
		ap	ae	ap	min	max	min	max	mm	5,0	6,0	8,0	10,0	12,0	14,0	16,0	18,0	20,0	25,0
P	0	1,5 x D	0,5 x D	1 x D	150	200	150	200	fz	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114	0,124
	1	1,5 x D	0,5 x D	1 x D	150	200	150	200	fz	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114	0,124
	2	1,5 x D	0,5 x D	1 x D	140	190	140	190	fz	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114	0,124
	3	1,5 x D	0,5 x D	1 x D	120	160	120	160	fz	0,030	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101	0,114
	4	1,5 x D	0,5 x D	0,75 x D	90	150	90	150	fz	0,027	0,033	0,045	0,054	0,062	0,070	0,077	0,083	0,088	0,098
	5	1,5 x D	0,5 x D	1 x D	60	100	60	100	fz	0,024	0,029	0,040	0,048	0,056	0,063	0,070	0,076	0,081	0,091
	6	1,5 x D	0,5 x D	0,75 x D	50	75	50	75	fz	0,020	0,025	0,034	0,040	0,047	0,052	0,057	0,061	0,065	0,071
M	1	1,5 x D	0,5 x D	1 x D	90	115	90	115	fz	0,030	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101	0,114
	2	1,5 x D	0,5 x D	1 x D	60	80	60	80	fz	0,024	0,029	0,040	0,048	0,056	0,063	0,070	0,076	0,081	0,091
	3	1,5 x D	0,5 x D	1 x D	60	70	60	70	fz	0,020	0,025	0,034	0,040	0,047	0,052	0,057	0,061	0,065	0,071
K	1	1,5 x D	0,5 x D	1 x D	120	150	120	150	fz	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114	0,124
	2	1,5 x D	0,5 x D	1 x D	110	140	110	140	fz	0,030	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101	0,114
	3	1,5 x D	0,5 x D	1 x D	110	130	110	130	fz	0,024	0,029	0,040	0,048	0,056	0,063	0,070	0,076	0,081	0,091
S	1	1,5 x D	0,3 x D	0,3 x D	50	90	–	–	fz	0,030	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101	0,114
	2	1,5 x D	0,3 x D	0,3 x D	25	40	–	–	fz	0,016	0,019	0,026	0,032	0,037	0,042	0,046	0,050	0,054	0,061
	3	1,5 x D	0,3 x D	0,3 x D	25	40	–	–	fz	0,016	0,019	0,026	0,032	0,037	0,042	0,046	0,050	0,054	0,061
	4	1,5 x D	0,5 x D	1 x D	50	60	–	–	fz	0,021	0,026	0,037	0,045	0,052	0,058	0,064	0,069	0,074	0,084
H	1	1,5 x D	0,5 x D	0,75 x D	80	140	80	140	fz	0,027	0,033	0,045	0,054	0,062	0,070	0,077	0,083	0,088	0,098

NOTE: Those guidelines may require variations to achieve optimum results.
Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters accordingly on >12mm diameter.

HARVI II • UDDE • Unequal Flute Spacing





Material Group		Side Milling (A) and Slotting (B)			KCSM15/ KC643M		Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 10%.									
		A		B	Cutting Speed — vc m/min			D1 — Diameter								
		ap	ae	ap	min	max	mm	6,0	8,0	10,0	12,0	14,0	16,0	18,0	20,0	25,0
P	5	1,5 x D	0,5 x D	1 x D	60	100	fz	0,029	0,040	0,048	0,056	0,063	0,070	0,076	0,081	0,091
	6	1,5 x D	0,5 x D	0,75 x D	50	75	fz	0,025	0,034	0,040	0,047	0,052	0,057	0,061	0,065	0,071
K	1	1,5 x D	0,5 x D	1 x D	120	150	fz	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114	0,124
	2	1,5 x D	0,5 x D	1 x D	110	140	fz	0,036	0,050	0,061	0,07	0,079	0,087	0,095	0,101	0,114
	3	1,5 x D	0,5 x D	1 x D	110	130	fz	0,029	0,040	0,048	0,056	0,063	0,070	0,076	0,081	0,091
S	1	1,5 x D	0,3 x D	0,3 x D	50	90	fz	0,036	0,050	0,061	0,07	0,079	0,087	0,095	0,101	0,114
	2	1,5 x D	0,3 x D	0,3 x D	25	40	fz	0,019	0,026	0,032	0,037	0,042	0,046	0,050	0,054	0,061
	3	1,5 x D	0,3 x D	0,3 x D	25	40	fz	0,019	0,026	0,032	0,037	0,042	0,046	0,050	0,054	0,061
	4	1,5 x D	0,5 x D	1 x D	50	60	fz	0,026	0,037	0,045	0,052	0,058	0,064	0,069	0,074	0,084
H	1	1,5 x D	0,5 x D	0,75 x D	80	140	fz	0,033	0,045	0,054	0,062	0,070	0,077	0,083	0,088	0,098

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters accordingly on > 12mm diameter.
Side milling applications — for longest reach (L3) tools, reduce ae by 30%.
Slot milling applications — for longest reach (L3) tools, reduce ae by 30%.

HARVI™ II Long

High-Performance Solid Carbide End Mills

Primary Application

The HARVI II Long system is designed for machining titanium, steels, and stainless steels with excellent surface finishes at maximum Metal Removal Rates (MRR). The extended cutting length enables the HARVI II Long system to machine deep pockets with thin walls in semi-finishing and finishing operations. It also reduces the number of cuts when machining wing profiles for the aerospace industry.

- Up to 5 x D side milling finishing operations in titanium and stainless steels.
- Exceptionally straight walls.
- Universal KC643M™ grade for long tool life.

Features and Benefits

Advanced Technology

- Five unequally spaced flutes for chatter-free machining at high feed rates, improving surface finish and tool life.
- 3 x D and 5 x D lengths for reduced number of cuts.
- Innovative core design increases stability for exceptionally straight walls.
- Improved feed rate in corner machining operations versus conventional cutters.

Tailored Grades

- Universal KC643M grade suitable for cutting steel, cast iron, stainless steel (wet), and titanium (wet).

Customisation

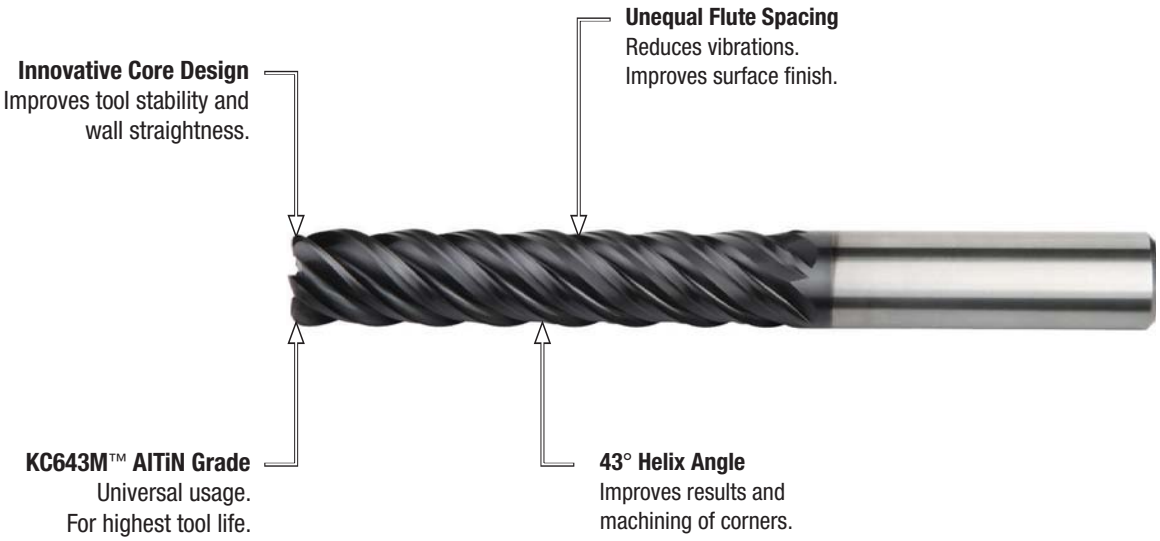
- Intermediate diameters available.
- Chip divider geometry available for reduced power consumption and improved chip formation in difficult-to-cut materials.
- Internal coolant axial, as well as radial, available.
- Various shank options and non-standard coatings available.

Extensive Standard Offering

- Diameter range 6–25mm.
- Various corner radii in stock.

3 x D and 5 x D lengths of cut without reduced feed rates when machining corners.

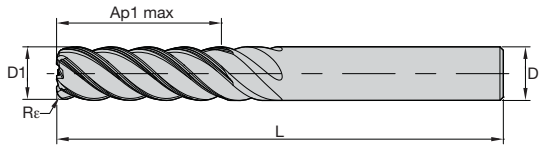




- For finishing and semi-finishing applications.
- Unequal flute spacing minimises chatter for smoother machining.
- Non-centre cutting.
- Kennametal standard dimensions.



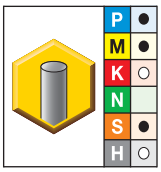




End Mill Tolerances

D1	tolerance e8	D	tolerance h6
≤3	-0,014 / -0,028	≤3	+0 / -0,006
>3–6	-0,020 / -0,038	>3–6	+0 / -0,008
>6–10	-0,025 / -0,047	>6–10	+0 / -0,009
>10–18	-0,032 / -0,059	>10–18	+0 / -0,011
>18–30	-0,040 / -0,073	>18–30	+0 / -0,013

HARVI II • UGDE • 3 x D Lengths of Cut



● first choice
○ alternate choice

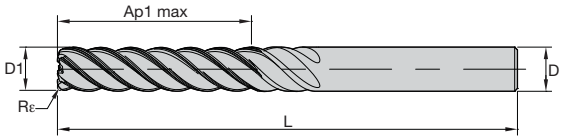
KC643M	D1	D	Ap1 max	L	Rε
UGDE0600A5ARA	6,00	6,00	18,00	63,00	0,20
UGDE0600A5ARB	6,00	6,00	18,00	63,00	0,50
UGDE0600A5ARC	6,00	6,00	18,00	63,00	1,00
UGDE0800A5ARA	8,00	8,00	24,00	67,00	0,20
UGDE0800A5ARB	8,00	8,00	24,00	67,00	0,50
UGDE0800A5ARC	8,00	8,00	24,00	67,00	1,00
UGDE1000A5ARA	10,00	10,00	30,00	76,00	0,50
UGDE1000A5ARB	10,00	10,00	30,00	76,00	1,00
UGDE1000A5ARC	10,00	10,00	30,00	76,00	2,00
UGDE1000A5ARD	10,00	10,00	30,00	76,00	2,50
UGDE1200A5ARA	12,00	12,00	36,00	100,00	0,50
UGDE1200A5ARB	12,00	12,00	36,00	100,00	1,00
UGDE1200A5ARC	12,00	12,00	36,00	100,00	2,00
UGDE1200A5ARD	12,00	12,00	36,00	100,00	2,50
UGDE1400A5ARD	14,00	14,00	42,00	100,00	3,00
UGDE1600A5ARA	16,00	16,00	48,00	110,00	1,00
UGDE1600A5ARB	16,00	16,00	48,00	110,00	2,00
UGDE1600A5ARC	16,00	16,00	48,00	110,00	2,50
UGDE1600A5ARD	16,00	16,00	48,00	110,00	3,00
UGDE1600A5ARE	16,00	16,00	48,00	110,00	4,00
UGDE1600A5ARP	16,00	16,00	48,00	110,00	6,00
UGDE2000A5ARA	20,00	20,00	60,00	125,00	1,00
UGDE2000A5ARB	20,00	20,00	60,00	125,00	2,00
UGDE2000A5ARC	20,00	20,00	60,00	125,00	2,50
UGDE2000A5ARD	20,00	20,00	60,00	125,00	3,00
UGDE2000A5ARE	20,00	20,00	60,00	125,00	4,00
UGDE2000A5ARP	20,00	20,00	60,00	125,00	6,00
UGDE2500A5ARA	25,00	25,00	75,00	150,00	1,00
UGDE2500A5ARB	25,00	25,00	75,00	150,00	2,00
UGDE2500A5ARC	25,00	25,00	75,00	150,00	2,50
UGDE2500A5ARD	25,00	25,00	75,00	150,00	3,00
UGDE2500A5ARE	25,00	25,00	75,00	150,00	4,00
UGDE2500A5ARP	25,00	25,00	75,00	150,00	6,00

NOTE: For application data, see page P38.

- For finishing and semi-finishing applications.
- Unequal flute spacing minimises chatter for smoother machining.
- Non-centre cutting.
- Kennametal standard dimensions.



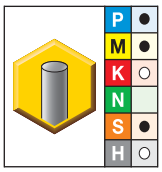




End Mill Tolerances

D1	tolerance e8	D	tolerance h6
≤3	-0,014 / -0,028	≤3	+0 / -0,006
>3–6	-0,020 / -0,038	>3–6	+0 / -0,008
>6–10	-0,025 / -0,047	>6–10	+0 / -0,009
>10–18	-0,032 / -0,059	>10–18	+0 / -0,011
>18–30	-0,040 / -0,073	>18–30	+0 / -0,013

HARVI II • UGDE • 5 x D Lengths of Cut



● first choice
○ alternate choice

KC643M	D1	D	Ap1 max	L	Rε
UGDE0600A5BRA	6,00	6,00	30,00	76,00	0,20
UGDE0600A5BRB	6,00	6,00	30,00	76,00	0,50
UGDE0600A5BRC	6,00	6,00	30,00	76,00	1,00
UGDE0800A5BRA	8,00	8,00	40,00	87,00	0,20
UGDE0800A5BRB	8,00	8,00	40,00	87,00	0,50
UGDE0800A5BRC	8,00	8,00	40,00	87,00	1,00
UGDE1000A5BRA	10,00	10,00	50,00	100,00	0,50
UGDE1000A5BRB	10,00	10,00	50,00	100,00	1,00
UGDE1000A5BRC	10,00	10,00	50,00	100,00	2,00
UGDE1000A5BRD	10,00	10,00	50,00	100,00	2,50
UGDE1200A5BRA	12,00	12,00	60,00	125,00	0,50
UGDE1200A5BRB	12,00	12,00	60,00	125,00	1,00
UGDE1200A5BRC	12,00	12,00	60,00	125,00	2,00
UGDE1200A5BRD	12,00	12,00	60,00	125,00	2,50
UGDE1400A5BRD	14,00	14,00	70,00	120,00	3,00
UGDE1600A5BRA	16,00	16,00	80,00	141,00	1,00
UGDE1600A5BRB	16,00	16,00	80,00	141,00	2,00
UGDE1600A5BRC	16,00	16,00	80,00	141,00	2,50
UGDE1600A5BRD	16,00	16,00	80,00	141,00	3,00
UGDE1600A5BRE	16,00	16,00	80,00	141,00	4,00
UGDE1600A5BRP	16,00	16,00	80,00	141,00	6,00
UGDE2000A5BRA	20,00	20,00	100,00	166,00	1,00
UGDE2000A5BRB	20,00	20,00	100,00	166,00	2,00
UGDE2000A5BRC	20,00	20,00	100,00	166,00	2,50
UGDE2000A5BRD	20,00	20,00	100,00	166,00	3,00
UGDE2000A5BRE	20,00	20,00	100,00	166,00	4,00
UGDE2000A5BRP	20,00	20,00	100,00	166,00	6,00
UGDE2500A5BRA	25,00	25,00	125,00	190,00	1,00
UGDE2500A5BRB	25,00	25,00	125,00	190,00	2,00
UGDE2500A5BRC *	25,00	25,00	125,00	190,00	2,50
UGDE2500A5BRD	25,00	25,00	125,00	190,00	3,00
UGDE2500A5BRE	25,00	25,00	125,00	190,00	4,00
UGDE2500A5BRP	25,00	25,00	125,00	190,00	6,00

NOTE: For application data, see page P39.
*Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

HARVI™ II • UGDE • Unequal Flute Spacing • 3 x D Lengths of Cut



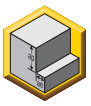


Material Group		Side Milling (A)		KC643M		Recommended feed per tooth (fz = mm/th) for side milling (A).								
		A		Cutting Speed — vc m/min			D1 — Diameter							
		ap	ae	min	max	mm	6,0	8,0	10,0	12,0	14,0	16,0	20,0	25,0
P	1	Ap1 max	0,05 x D*	300	400	fz	0,044	0,060	0,072	0,083	0,092	0,101	0,114	0,124
	2	Ap1 max	0,05 x D*	280	380	fz	0,044	0,060	0,072	0,083	0,092	0,101	0,114	0,124
	3	Ap1 max	0,05 x D*	240	320	fz	0,036	0,050	0,061	0,070	0,079	0,087	0,101	0,114
	4	Ap1 max	0,05 x D*	180	300	fz	0,033	0,045	0,054	0,062	0,070	0,077	0,088	0,098
	5	Ap1 max	0,05 x D*	120	200	fz	0,029	0,040	0,048	0,056	0,063	0,070	0,081	0,091
	6	Ap1 max	0,05 x D*	100	150	fz	0,025	0,034	0,040	0,047	0,052	0,057	0,065	0,071
M	1	Ap1 max	0,05 x D*	180	230	fz	0,036	0,050	0,061	0,070	0,079	0,087	0,101	0,114
	2	Ap1 max	0,05 x D*	120	160	fz	0,029	0,040	0,048	0,056	0,063	0,070	0,081	0,091
	3	Ap1 max	0,05 x D*	120	140	fz	0,025	0,034	0,040	0,047	0,052	0,057	0,065	0,071
K	1	Ap1 max	0,05 x D*	240	300	fz	0,044	0,060	0,072	0,083	0,092	0,101	0,114	0,124
	2	Ap1 max	0,05 x D*	220	260	fz	0,036	0,050	0,061	0,070	0,079	0,087	0,101	0,114
	3	Ap1 max	0,05 x D*	200	260	fz	0,029	0,040	0,048	0,056	0,063	0,070	0,081	0,091
S	1	Ap1 max	0,05 x D*	100	180	fz	0,036	0,050	0,061	0,070	0,079	0,087	0,101	0,114
	2	Ap1 max	0,05 x D*	100	180	fz	0,036	0,050	0,061	0,070	0,079	0,087	0,101	0,114
	3	Ap1 max	0,05 x D*	50	80	fz	0,019	0,026	0,032	0,037	0,042	0,046	0,054	0,061
	4	Ap1 max	0,05 x D*	100	120	fz	0,026	0,037	0,045	0,052	0,058	0,064	0,074	0,084
H	1	Ap1 max	0,05 x D*	160	280	fz	0,033	0,045	0,054	0,062	0,070	0,077	0,088	0,098

* For the above cutting data, do not exceed an overall ae of 0,8mm.

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. For smaller taper machinining centres, please adjust parameters accordingly on >12mm diameter.

HARVI™ II • UGDE • Unequal Flute Spacing • 5 x D Lengths of Cut





Material Group		Side Milling (A)		KC643M		Recommended feed per tooth (fz = mm/th) for side milling (A).								
		A		Cutting Speed — vc m/min			D1 — Diameter							
		ap	ae	min	max	mm	6,0	8,0	10,0	12,0	14,0	16,0	20,0	25,0
P	1	Ap1 max	0,05 x D*	300	400	fz	0,044	0,060	0,072	0,083	0,092	0,101	0,114	0,124
	2	Ap1 max	0,05 x D*	280	380	fz	0,044	0,060	0,072	0,083	0,092	0,101	0,114	0,124
	3	Ap1 max	0,05 x D*	240	320	fz	0,036	0,050	0,061	0,070	0,079	0,087	0,101	0,114
	4	Ap1 max	0,05 x D*	180	300	fz	0,033	0,045	0,054	0,062	0,070	0,077	0,088	0,098
	5	Ap1 max	0,05 x D*	120	200	fz	0,029	0,040	0,048	0,056	0,063	0,070	0,081	0,091
	6	Ap1 max	0,05 x D*	100	150	fz	0,025	0,034	0,040	0,047	0,052	0,057	0,065	0,071
M	1	Ap1 max	0,05 x D*	180	230	fz	0,036	0,050	0,061	0,070	0,079	0,087	0,101	0,114
	2	Ap1 max	0,05 x D*	120	160	fz	0,029	0,040	0,048	0,056	0,063	0,070	0,081	0,091
	3	Ap1 max	0,05 x D*	120	140	fz	0,025	0,034	0,040	0,047	0,052	0,057	0,065	0,071
K	1	Ap1 max	0,05 x D*	240	300	fz	0,044	0,060	0,072	0,083	0,092	0,101	0,114	0,124
	2	Ap1 max	0,05 x D*	220	260	fz	0,036	0,050	0,061	0,070	0,079	0,087	0,101	0,114
	3	Ap1 max	0,05 x D*	200	260	fz	0,029	0,040	0,048	0,056	0,063	0,070	0,081	0,091
S	1	Ap1 max	0,05 x D*	100	180	fz	0,036	0,050	0,061	0,070	0,079	0,087	0,101	0,114
	2	Ap1 max	0,05 x D*	100	180	fz	0,036	0,050	0,061	0,070	0,079	0,087	0,101	0,114
	3	Ap1 max	0,05 x D*	50	80	fz	0,019	0,026	0,032	0,037	0,042	0,046	0,054	0,061
	4	Ap1 max	0,05 x D*	100	120	fz	0,026	0,037	0,045	0,052	0,058	0,064	0,074	0,084
H	1	Ap1 max	0,05 x D*	160	280	fz	0,033	0,045	0,054	0,062	0,070	0,077	0,088	0,098

* For the above cutting data, do not exceed an overall ae of 0,8mm.

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. For smaller taper machinining centres, please adjust parameters accordingly on >12mm diameter.

HARVI™ II Trochoidal

High-Performance Solid Carbide End Mills

Primary Application

Kennametal trochoidal end mills are designed for high-feed applications up to 3 x D with low radial engagement and are tailored for CAM tool path generation software.

Designated for both roughing and finishing operations on open contours and deep cavities. Penetration of deep pockets bottoms of via helical interpolation with same tool reduces tool inventory and set-up time.

Features and Benefits

Advanced Technology

- Five unequally spaced flutes designed for chatter-free machining at highest feed rates.
- Front-end design optimised for helical operations.
- Patented flute and flute space for optimised chip control.

Tailored Grades

- KC643M™ grade optimised for steel, stainless, and high-temperature alloys.

Customisation

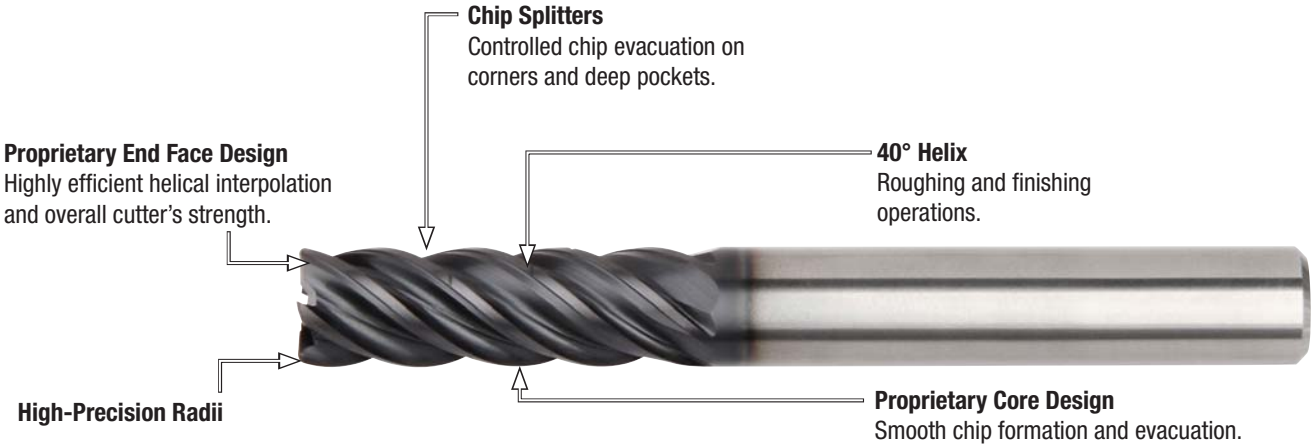
- Intermediate diameters available.
- Expanded length of tool, as well as increased length of cuts is possible.
- Different radii available.

Standard Offering

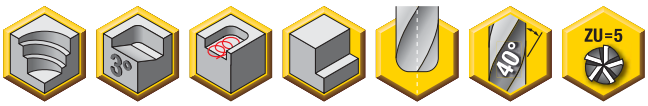
- Diameter ranges 8–25mm.

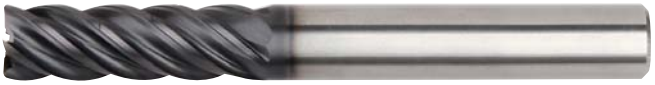
Designed for dynamic milling and trochoidal milling.

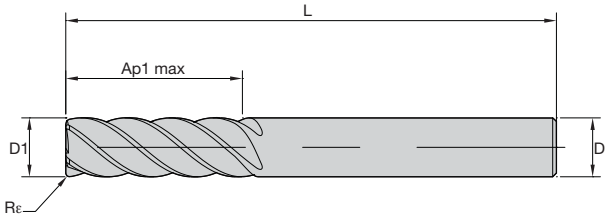




- Kennametal standard dimensions.
- Non-centre cutting.
- Roughing and finishing, cavities and open contour, requiring fewer setups.
- Unequally spaced fluted for chatter-free machining at highest feed rates.
- Optimised for trochoidal milling and helical operations.
- Patented flute and flute space for optimised chip control.



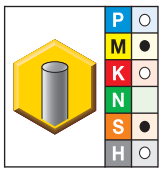




End Mill Tolerances

D1	tolerance	D	tolerance h6
≤3	-0,014/-0,028	≤3	+0/-0,006
>3–6	-0,020/-0,038	>3–6	+0/-0,008
>6–10	-0,025/-0,047	>6–10	+0/-0,009
>10–18	-0,032/-0,059	>10–18	+0/-0,011
>18–30	-0,040/-0,073	>18–30	+0/-0,013

TCDE • Unequal Flute Spacing • With Chipsplitter



● first choice
○ alternate choice

KC643M	D1	D	Ap1 max	L	Rε
TCDE0800A5CRE	8,00	8,00	24,00	67,00	0,50
TCDE1000A5CRE	10,00	10,00	30,00	80,00	0,50
TCDE1200A5CRF	12,00	12,00	36,00	100,00	0,75
TCDE1600A5CRG	16,00	16,00	48,00	110,00	1,00
TCDE2000A5CRG	20,00	20,00	60,00	125,00	1,00
TCDE2500A5CRG	25,00	25,00	75,00	150,00	1,00

NOTE: For application data, see pages P43–P44.

HARVI II Trochoidal • TCDE • Unequal Flute Spacing • ae 10% of D1

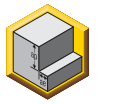
Material Group		Side Milling (A)		KC643M			Recommended feed per tooth (fz = mm/th) for side milling (A).						
		A		Cutting Speed — vc m/min			D1 — Diameter						
		ap	ae	min		max	mm	8,0	10,0	12,0	16,0	20,0	25,0
P	0	Ap max	0,1 x D	150	–	440	fz	0,072	0,086	0,099	0,121	0,137	0,149
	1	Ap max	0,1 x D	150	–	440	fz	0,072	0,086	0,099	0,121	0,137	0,149
	2	Ap max	0,1 x D	140	–	418	fz	0,072	0,086	0,099	0,121	0,137	0,149
	3	Ap max	0,1 x D	120	–	352	fz	0,060	0,073	0,084	0,105	0,121	0,137
	4	Ap max	0,1 x D	90	–	330	fz	0,054	0,065	0,075	0,092	0,106	0,117
	5	Ap max	0,1 x D	60	–	220	fz	0,048	0,058	0,067	0,084	0,097	0,109
	6	Ap max	0,1 x D	50	–	165	fz	0,040	0,048	0,056	0,068	0,078	0,085
M	1	Ap max	0,1 x D	90	–	253	fz	0,060	0,073	0,084	0,105	0,121	0,137
	2	Ap max	0,1 x D	60	–	176	fz	0,048	0,058	0,067	0,084	0,097	0,109
	3	Ap max	0,1 x D	60	–	154	fz	0,040	0,048	0,056	0,068	0,078	0,085
K	1	Ap max	0,1 x D	120	–	330	fz	0,072	0,086	0,099	0,121	0,137	0,149
	2	Ap max	0,1 x D	110	–	308	fz	0,060	0,073	0,084	0,105	0,121	0,137
	3	Ap max	0,1 x D	110	–	286	fz	0,048	0,058	0,067	0,084	0,097	0,109
S	1	Ap max	0,1 x D	50	–	198	fz	0,060	0,073	0,084	0,105	0,121	0,137
	2	Ap max	0,1 x D	25	–	88	fz	0,032	0,038	0,045	0,056	0,065	0,074
	3	Ap max	0,1 x D	25	–	88	fz	0,032	0,038	0,045	0,056	0,065	0,074
	4	Ap max	0,1 x D	50	–	132	fz	0,044	0,053	0,062	0,077	0,089	0,100
H	1	Ap max	0,1 x D	80	–	308	fz	0,054	0,065	0,075	0,092	0,106	0,117
	2	Ap max	0,1 x D	70	–	264	fz	0,040	0,048	0,056	0,068	0,078	0,085

HARVI II Trochoidal • TCDE • Unequal Flute Spacing • ae 5% of D1

Material Group		Side Milling (A)		KC643M			Recommended feed per tooth (fz = mm/th) for side milling (A).						
		A		Cutting Speed — vc m/min			D1 — Diameter						
		ap	ae	min		max	mm	8,0	10,0	12,0	16,0	20,0	25,0
P	0	Ap max	0,05 x D	150	–	540	fz	0,097	0,117	0,134	0,163	0,185	0,200
	1	Ap max	0,05 x D	150	–	540	fz	0,097	0,117	0,134	0,163	0,185	0,200
	2	Ap max	0,05 x D	140	–	513	fz	0,097	0,117	0,134	0,163	0,185	0,200
	3	Ap max	0,05 x D	120	–	432	fz	0,081	0,098	0,114	0,141	0,164	0,184
	4	Ap max	0,05 x D	90	–	405	fz	0,073	0,087	0,101	0,124	0,143	0,158
	5	Ap max	0,05 x D	60	–	270	fz	0,065	0,078	0,091	0,113	0,131	0,147
	6	Ap max	0,05 x D	50	–	202,5	fz	0,054	0,065	0,075	0,092	0,105	0,115
M	1	Ap max	0,05 x D	90	–	310,5	fz	0,081	0,098	0,114	0,141	0,164	0,184
	2	Ap max	0,05 x D	60	–	216	fz	0,065	0,078	0,091	0,113	0,131	0,147
	3	Ap max	0,05 x D	60	–	189	fz	0,054	0,065	0,075	0,092	0,105	0,115
K	1	Ap max	0,05 x D	120	–	405	fz	0,097	0,117	0,134	0,163	0,185	0,200
	2	Ap max	0,05 x D	110	–	378	fz	0,081	0,098	0,114	0,141	0,164	0,184
	3	Ap max	0,05 x D	110	–	351	fz	0,065	0,078	0,091	0,113	0,131	0,147
S	1	Ap max	0,05 x D	50	–	243	fz	0,081	0,098	0,114	0,141	0,164	0,184
	2	Ap max	0,05 x D	25	–	108	fz	0,043	0,052	0,060	0,075	0,087	0,099
	3	Ap max	0,05 x D	25	–	108	fz	0,043	0,052	0,060	0,075	0,087	0,099
	4	Ap max	0,05 x D	50	–	162	fz	0,060	0,072	0,084	0,104	0,120	0,135
H	1	Ap max	0,05 x D	80	–	378	fz	0,073	0,087	0,101	0,124	0,143	0,158
	2	Ap max	0,05 x D	70	–	324	fz	0,054	0,065	0,075	0,092	0,105	0,115

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. For smaller taper machinining centres, please adjust parameters accordingly on >12mm diameter.
For better surface finish, reduce feed per tooth.

HARVI II Trochoidal • TCDE • Unequal Flute Spacing • ae 2% of D1





Material Group		Side Milling (A)		KC643M			Recommended feed per tooth (fz = mm/th) for side milling (A).						
		A		Cutting Speed — vc m/min			D1 — Diameter						
		ap	ae	min		max	mm	8,0	10,0	12,0	16,0	20,0	25,0
P	0	Ap max	0,02 x D	150	–	660	fz	0,140	0,168	0,194	0,236	0,267	0,290
	1	Ap max	0,02 x D	150	–	660	fz	0,140	0,168	0,194	0,236	0,267	0,290
	2	Ap max	0,02 x D	140	–	627	fz	0,140	0,168	0,194	0,236	0,267	0,290
	3	Ap max	0,02 x D	120	–	528	fz	0,117	0,142	0,164	0,204	0,236	0,266
	4	Ap max	0,02 x D	90	–	495	fz	0,105	0,126	0,146	0,180	0,206	0,228
	5	Ap max	0,02 x D	60	–	330	fz	0,094	0,113	0,131	0,163	0,189	0,213
	6	Ap max	0,02 x D	50	–	247,5	fz	0,079	0,095	0,109	0,133	0,152	0,166
M	1	Ap max	0,02 x D	90	–	379,5	fz	0,117	0,142	0,164	0,204	0,236	0,266
	2	Ap max	0,02 x D	60	–	264	fz	0,094	0,113	0,131	0,163	0,189	0,213
	3	Ap max	0,02 x D	60	–	231	fz	0,079	0,095	0,109	0,133	0,152	0,166
K	1	Ap max	0,02 x D	120	–	495	fz	0,140	0,168	0,194	0,236	0,267	0,290
	2	Ap max	0,02 x D	110	–	462	fz	0,117	0,142	0,164	0,204	0,236	0,266
	3	Ap max	0,02 x D	110	–	429	fz	0,094	0,113	0,131	0,163	0,189	0,213
S	1	Ap max	0,02 x D	50	–	297	fz	0,117	0,142	0,164	0,204	0,236	0,266
	2	Ap max	0,02 x D	25	–	132	fz	0,062	0,075	0,087	0,109	0,126	0,143
	3	Ap max	0,02 x D	25	–	132	fz	0,062	0,075	0,087	0,109	0,126	0,143
	4	Ap max	0,02 x D	50	–	198	fz	0,086	0,104	0,121	0,150	0,174	0,196
H	1	Ap max	0,02 x D	80	–	462	fz	0,105	0,126	0,146	0,180	0,206	0,228
	2	Ap max	0,02 x D	70	–	396	fz	0,079	0,095	0,109	0,133	0,152	0,166

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. For smaller taper machinining centres, please adjust parameters accordingly on >12mm diameter.
For better surface finish, reduce feed per tooth.

Dynamic Milling • Trochoidal Milling

The Concept

- Transfer the basic idea of controlling of chip thickness to dynamic processes.
- Dynamic adaption of feed in relation to ae and wrap angle through an intelligent CAM software.
- Using helix interpolation, D-lanes, and morphing cycles tailored to the workpiece shape and material.



The Benefits of Trochoidal Milling include:

For the tool:

- Better chip evacuation.
- Better usage of tool length.
- Higher cutting speed and feed per tooth possible.

For the machining process:

- Tremendously reduced chip load on the cutting edge.
- Reduced temperature during the machining process.
- Reduced cycle time and increased tool life.

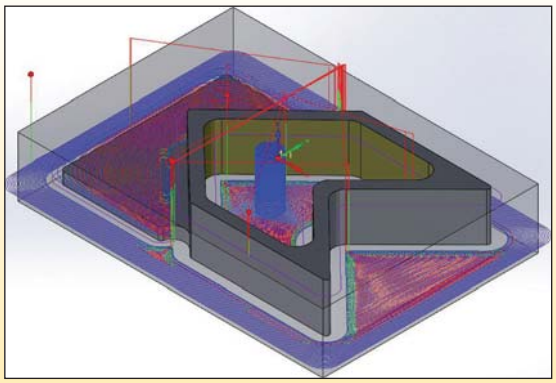
For the machining centre:

- Reduced torque and power requirements for the machine.
- Lower risk of spindle damage through torque fluctuation and reduced torque peaks caused by conventional milling processes.
- Addressing market shifts by utilising high RPM spindle machines previously dedicated for aluminium, and now for stainless steel, titanium, and other demanding applications.

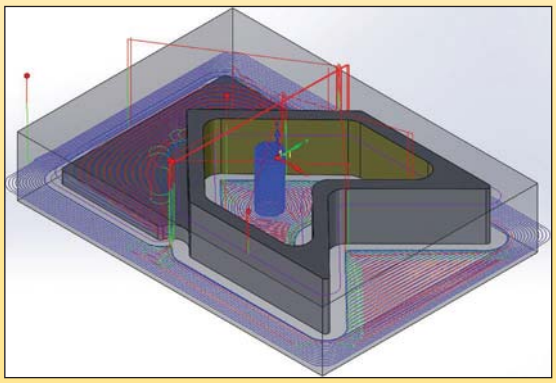
Requirements:

- Highly dynamic CNC machining centre.
- 3D model based CNC programming.
- CAD/CAM tool path optimisation software.
- Sophisticated end milling tool.
- Cutting data for trochoidal machining.

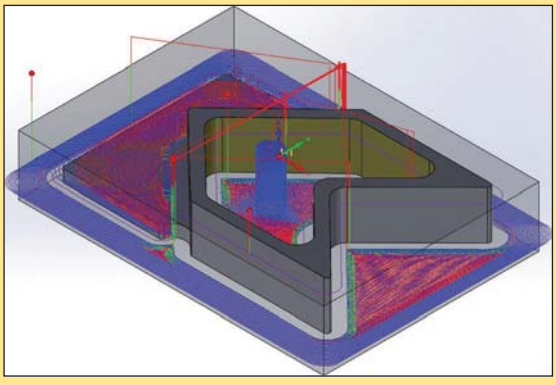
Tool path for high-alloy steel



Tool path for stainless steel



Tool path for titanium



HARVI™ III

High-Performance Solid Carbide End Mills

Primary Application

The HARVI III system takes high-performance profiling, semi-finishing, and finishing to the next level. These end mills are designed to provide maximum metal removal rates in titanium and stainless steel while achieving supreme surface conditions. A wide range of diameters and corner radii are available from stock as well as the Safe-Lock™ system by HAIMER® shanks.

- Outstanding metal removal rates increase productivity.
- Longest tool life due to eccentric relief grind and proprietary KCSM15™ Beyond™ grade.
- Increased process safety with Safe-Lock™ shanks.

Features and Benefits

Advanced Technology

- Six unequally spaced flutes for chatter-free machining at high feed rates.
- Lower cutting forces and pressure on cutting edge through tailored axial and radial rake angles.
- Eccentric relief design increases tool life through higher edge stability.
- Proprietary tapered core provides highest tool stability in roughing and finishing operations.
- Centre cutting design for higher flexibility as well as radial and axial finishing pass after roughing operation.

Tailored Grades

- KCSM15™ Beyond™ grade for exceptional tool life in titanium and stainless steels.

Customisation

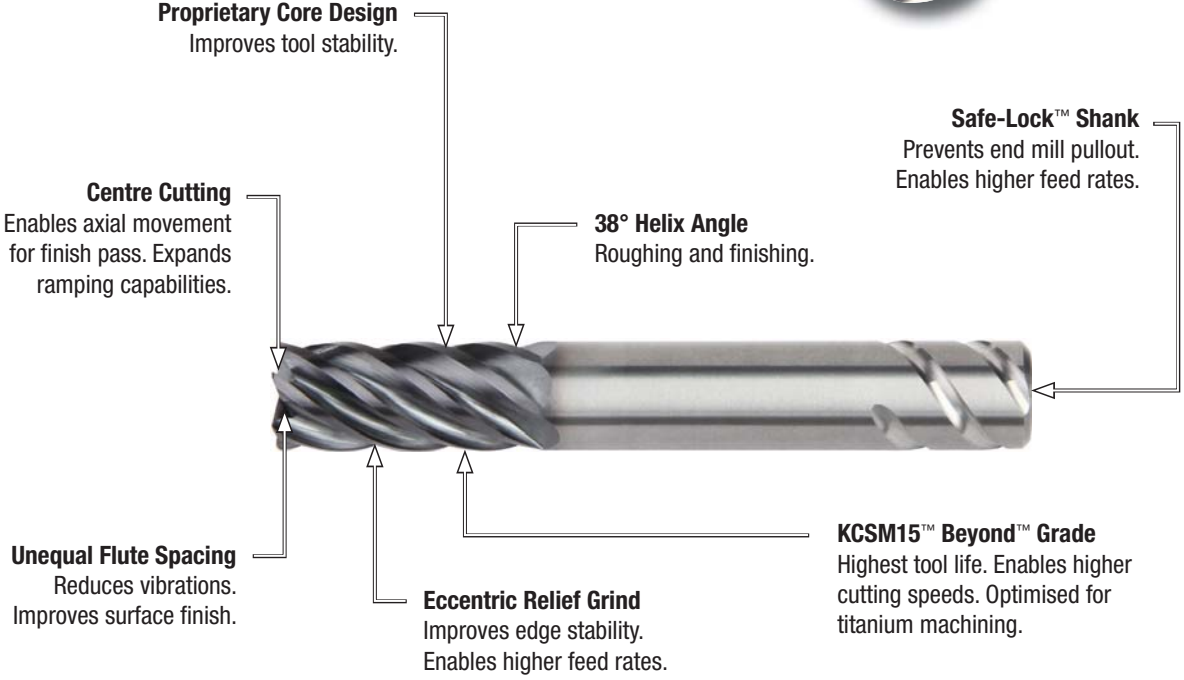
- Engineered solutions, including ball nose versions, are available upon request.

Extensive Standard Offering

- Diameter ranges 10–25mm.
- Necked, corner radii, and square-end offering.
- Round shank and Safe-Lock™ shank available.

Maximum metal removal rates in machining titanium and stainless steel with supreme surfaces.



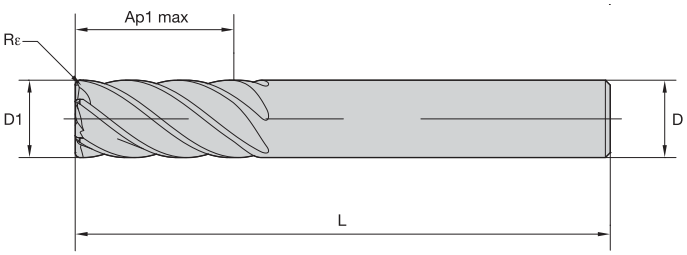


SAFE-λOCK®
by HAIMER®

- Kennametal standard dimensions.
- Centre cutting.
- Optimised geometry for titanium machining.
- Unequal flute spacing minimises chatter for smoother machining.
- Single tool for both roughing and finishing operations requiring fewer setups.





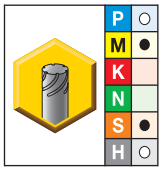


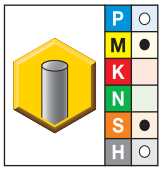
End Mill Tolerances

D1	tolerance e8	D	tolerance h6
≤3	-0,014/-0,028	≤3	+0/-0,006
>3–6	-0,020/-0,038	>3–6	+0/-0,008
>6–10	-0,025/-0,047	>6–10	+0/-0,009
>10–18	-0,032/-0,059	>10–18	+0/-0,011
>18–30	-0,040/-0,073	>18–30	+0/-0,013

beyond

UJDE • 6 Flute with Eccentric Relief Grind • Metric



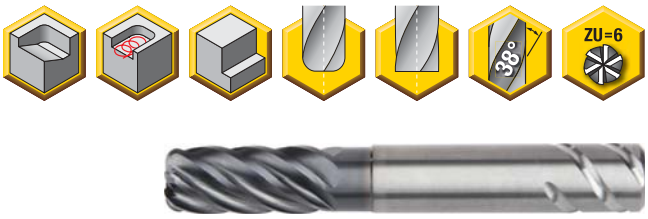


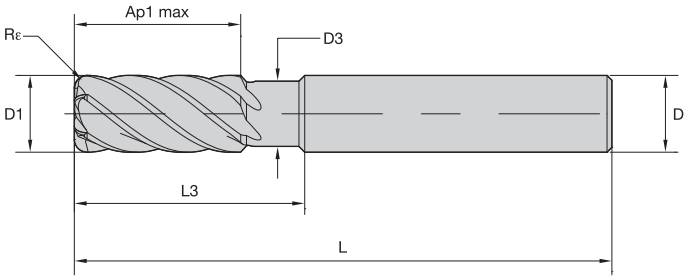
● first choice
○ alternate choice

KCSM15	KCSM15	D1	D	Ap1 max	L	Rε
–	**UJDE1000A6ARE**	10,00	10,00	22,00	72,00	0,50
–	**UJDE1000A6AS**	10,00	10,00	22,00	72,00	–
UJDE1200E6ARF	**UJDE1200A6ARF**	12,00	12,00	26,00	83,00	0,75
–	**UJDE1200A6AS**	12,00	12,00	26,00	83,00	–
UJDE1400E6ARF	**UJDE1400A6ARF**	14,00	14,00	26,00	83,00	0,75
–	**UJDE1400A6AS**	14,00	14,00	26,00	83,00	–
UJDE1600E6ARF	**UJDE1600A6ARF**	16,00	16,00	32,00	92,00	0,75
–	**UJDE1600A6AS**	16,00	16,00	32,00	92,00	–
UJDE2000E6ARF	**UJDE2000A6ARF**	20,00	20,00	38,00	104,00	0,75
–	**UJDE2000A6AS**	20,00	20,00	38,00	104,00	–
UJDE2500E6ARF	**UJDE2500A6ARF**	25,00	25,00	45,00	121,00	0,75
–	**UJDE2500A6AS**	25,00	25,00	45,00	121,00	–

NOTE: For application data, see page P50.

- Kennametal standard dimensions.
- Centre cutting.
- Optimised geometry for titanium machining.
- Unequal flute spacing minimises chatter for smoother machining.
- Single tool for both roughing and finishing operations requiring fewer setups.



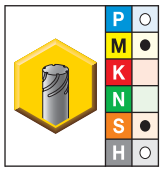


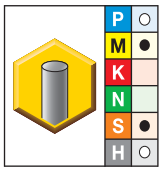
End Mill Tolerances

D1	tolerance e8	D	tolerance h6
≤3	-0,014 / -0,028	≤3	+0 / -0,006
>3–6	-0,020 / -0,038	>3–6	+0 / -0,008
>6–10	-0,025 / -0,047	>6–10	+0 / -0,009
>10–18	-0,032 / -0,059	>10–18	+0 / -0,011
>18–30	-0,040 / -0,073	>18–30	+0 / -0,013

beyond

UJDE • 6 Flute with Eccentric Relief Grind and Neck • Metric





● first choice
○ alternate choice

KCSM15	KCSM15	D1	D	D3	Ap1 max	L3	L	Rε
–	UJDE1000A6AQE	10,00	10,00	9,40	22,00	30,00	76,00	0,50
–	UJDE1000A6AQG	10,00	10,00	9,40	22,00	30,00	76,00	1,00
–	UJDE1000A6AQK	10,00	10,00	9,40	22,00	30,00	76,00	2,00
–	UJDE1000A6AQM *	10,00	10,00	9,40	22,00	30,00	76,00	3,00
–	UJDE1000A6ANS	10,00	10,00	9,40	22,00	30,00	76,00	–
UJDE1200E6AQE	UJDE1200A6AQE	12,00	12,00	11,28	26,00	36,00	83,00	0,50
UJDE1200E6AQG	UJDE1200A6AQG	12,00	12,00	11,28	26,00	36,00	83,00	1,00
UJDE1200E6AQK	UJDE1200A6AQK	12,00	12,00	11,28	26,00	36,00	83,00	2,00
UJDE1200E6AQM	UJDE1200A6AQM	12,00	12,00	11,28	26,00	36,00	83,00	3,00
–	UJDE1200A6ANS	12,00	12,00	11,28	26,00	36,00	83,00	–
UJDE1600E6AQE	UJDE1600A6AQE	16,00	16,00	15,04	32,00	48,00	100,00	0,50
UJDE1600E6AQG	UJDE1600A6AQG	16,00	16,00	15,04	32,00	48,00	100,00	1,00
UJDE1600E6AQK	UJDE1600A6AQK	16,00	16,00	15,04	32,00	48,00	100,00	2,00
UJDE1600E6AQM	UJDE1600A6AQM	16,00	16,00	15,04	32,00	48,00	100,00	3,00
UJDE1600E6AQN	UJDE1600A6AQN	16,00	16,00	15,04	32,00	48,00	100,00	4,00
–	UJDE1600A6AQP	16,00	16,00	15,04	32,00	48,00	100,00	6,00
–	UJDE1600A6ANS	16,00	16,00	15,04	32,00	48,00	100,00	–
UJDE2000E6AQE	UJDE2000A6AQE	20,00	20,00	18,80	38,00	60,00	115,00	0,50
UJDE2000E6AQG	UJDE2000A6AQG	20,00	20,00	18,80	38,00	60,00	115,00	1,00
UJDE2000E6AQK	UJDE2000A6AQK	20,00	20,00	18,80	38,00	60,00	115,00	2,00
UJDE2000E6AQM	UJDE2000A6AQM	20,00	20,00	18,80	38,00	60,00	115,00	3,00
UJDE2000E6AQN	UJDE2000A6AQN	20,00	20,00	18,80	38,00	60,00	115,00	4,00
–	UJDE2000A6AQP	20,00	20,00	18,80	38,00	60,00	115,00	6,00
–	UJDE2000A6ANS	20,00	20,00	18,80	38,00	60,00	115,00	–
UJDE2500E6AQE *	UJDE2500A6AQE *	25,00	25,00	23,50	45,00	75,00	135,00	0,50
UJDE2500E6AQG *	UJDE2500A6AQG *	25,00	25,00	23,50	45,00	75,00	135,00	1,00
UJDE2500E6AQK *	UJDE2500A6AQK *	25,00	25,00	23,50	45,00	75,00	135,00	2,00
UJDE2500E6AQM *	UJDE2500A6AQM *	25,00	25,00	23,50	45,00	75,00	135,00	3,00
UJDE2500E6AQN *	UJDE2500A6AQN *	25,00	25,00	23,50	45,00	75,00	135,00	4,00
–	UJDE2500A6AQP	25,00	25,00	23,50	45,00	75,00	135,00	6,00

NOTE: For application data, see page P51.
*Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

HARVI III • UJDE • Unequal Flute Spacing • Roughing

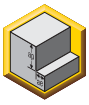




Material Group		Side Milling (A)		KCSM15		Recommended feed per tooth (fz = mm/th) for side milling (A).						
		A		Cutting Speed – vc m/min			D1 – Diameter					
		ap	ae	min	max	mm	10,0	12,0	16,0	18,0	20,0	25,0
P	4	Ap1 max	0,4 x D	90	150	fz	0,054	0,062	0,077	0,083	0,088	0,098
	5	Ap1 max	0,4 x D	60	100	fz	0,048	0,056	0,070	0,076	0,081	0,091
M	1	Ap1 max	0,4 x D	90	115	fz	0,061	0,070	0,087	0,095	0,101	0,114
	2	Ap1 max	0,4 x D	60	80	fz	0,048	0,056	0,070	0,076	0,081	0,091
	3	Ap1 max	0,4 x D	60	70	fz	0,040	0,047	0,057	0,061	0,065	0,071
S	1	Ap1 max	0,4 x D	50	90	fz	0,061	0,070	0,087	0,095	0,101	0,114
	2	Ap1 max	0,4 x D	25	40	fz	0,032	0,037	0,046	0,050	0,054	0,061
	3	Ap1 max	0,4 x D	25	40	fz	0,032	0,037	0,046	0,050	0,054	0,061
	4	Ap1 max	0,4 x D	50	60	fz	0,045	0,052	0,064	0,069	0,074	0,084
H	1	Ap1 max	0,4 x D	80	140	fz	0,054	0,062	0,077	0,083	0,088	0,098

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters accordingly on >12mm diameter.

HARVI III • UJDE • Unequal Flute Spacing • Finishing





Material Group		Side Milling (A)		KCSM15		Recommended feed per tooth (fz = mm/th) for side milling (A).						
		A		Cutting Speed – vc m/min			D1 – Diameter					
		ap	ae	min	max	mm	10,0	12,0	14,0	16,0	18,0	20,0	25,0
P	4	Ap1 max	0,06 x D	171	285	fz	0,065	0,075	0,084	0,092	0,099	0,106	0,117
	5	Ap1 max	0,06 x D	114	190	fz	0,058	0,067	0,076	0,084	0,091	0,097	0,109
M	1	Ap1 max	0,06 x D	171	218	fz	0,073	0,084	0,095	0,105	0,113	0,121	0,137
	2	Ap1 max	0,06 x D	114	152	fz	0,058	0,067	0,076	0,084	0,091	0,097	0,109
	3	Ap1 max	0,06 x D	114	133	fz	0,048	0,056	0,062	0,068	0,073	0,078	0,085
S	1	Ap1 max	0,06 x D	95	171	fz	0,073	0,084	0,095	0,105	0,113	0,121	0,137
	2	Ap1 max	0,06 x D	47,5	76	fz	0,038	0,045	0,050	0,056	0,060	0,065	0,074
	3	Ap1 max	0,06 x D	47,5	76	fz	0,038	0,045	0,050	0,056	0,060	0,065	0,074
	4	Ap1 max	0,06 x D	95	152	fz	0,053	0,062	0,070	0,077	0,083	0,089	0,100
H	1	Ap1 max	0,06 x D	152	266	fz	0,065	0,075	0,084	0,092	0,099	0,106	0,117
	2	Ap1 max	0,06 x D	133	228	fz	0,048	0,056	0,062	0,068	0,073	0,078	0,085

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters accordingly on >12mm diameter.

HARVI III • UJDE • Unequal Flute Spacing • Roughing • With Neck



Material Group		Side Milling (A)		KCSM15		Recommended feed per tooth (fz = mm/th) for side milling (A).						
		A		Cutting Speed — vc m/min			D1 — Diameter					
		ap	ae	min	max	mm	10,0	12,0	16,0	18,0	20,0	25,0
P	4	Ap max	0,4 x D	90	150	fz	0,054	0,062	0,077	0,083	0,088	0,098
	5	Ap max	0,4 x D	60	100	fz	0,048	0,056	0,070	0,076	0,081	0,091
M	1	Ap max	0,4 x D	90	115	fz	0,061	0,070	0,087	0,095	0,101	0,114
	2	Ap max	0,4 x D	60	80	fz	0,048	0,056	0,070	0,076	0,081	0,091
	3	Ap max	0,4 x D	60	70	fz	0,040	0,047	0,057	0,061	0,065	0,071
S	1	Ap max	0,4 x D	50	90	fz	0,061	0,070	0,087	0,095	0,101	0,114
	2	Ap max	0,4 x D	25	40	fz	0,032	0,037	0,046	0,050	0,054	0,061
	3	Ap max	0,4 x D	25	40	fz	0,032	0,037	0,046	0,050	0,054	0,061
	4	Ap max	0,4 x D	50	60	fz	0,045	0,052	0,064	0,069	0,074	0,084
H	1	Ap max	0,4 x D	80	140	fz	0,054	0,062	0,077	0,083	0,088	0,098

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters accordingly on >12mm diameter.

HARVI III • UJDE • Unequal Flute Spacing • Finishing • With Neck



Material Group		Side Milling (A)		KCSM15		Recommended feed per tooth (fz = mm/th) for side milling (A).						
		A		Cutting Speed — vc m/min			D1 — Diameter					
		ap	ae	min	max	mm	10,0	12,0	14,0	16,0	18,0	20,0	25,0
P	4	Ap max	0,06 x D	171	285	fz	0,065	0,075	0,084	0,092	0,099	0,106	0,117
	5	Ap max	0,06 x D	114	190	fz	0,058	0,067	0,076	0,084	0,091	0,097	0,109
M	1	Ap max	0,06 x D	171	218,5	fz	0,073	0,084	0,095	0,105	0,113	0,121	0,137
	2	Ap max	0,06 x D	114	152	fz	0,058	0,067	0,076	0,084	0,091	0,097	0,109
	3	Ap max	0,06 x D	114	133	fz	0,048	0,056	0,062	0,068	0,073	0,078	0,085
S	1	Ap max	0,06 x D	95	171	fz	0,073	0,084	0,095	0,105	0,113	0,121	0,137
	2	Ap max	0,06 x D	47,5	76	fz	0,038	0,045	0,050	0,056	0,060	0,065	0,074
	3	Ap max	0,06 x D	47,5	76	fz	0,038	0,045	0,050	0,056	0,060	0,065	0,074
	4	Ap max	0,06 x D	95	114	fz	0,053	0,062	0,070	0,077	0,083	0,089	0,100
H	1	Ap max	0,06 x D	152	266	fz	0,065	0,075	0,084	0,092	0,099	0,106	0,117
	2	Ap max	0,06 x D	133	228	fz	0,048	0,056	0,062	0,068	0,073	0,078	0,085

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters accordingly on >12mm diameter.

HARVI™ III Ball Nose

High-Performance Solid Carbide End Mills

Primary Application

HARVI III Ball Nose tooling takes high-performance profiling, semi-finishing, and finishing to the next level. Designed to provide maximum metal removal rates in titanium and stainless steel while achieving supreme surface conditions. A wide range of diameters and length variations are available from stock.

- Outstanding metal removal rates increase productivity.
- Highest tool life due to eccentric relief grind and proprietary KCSM15™ Beyond™ grade.

Features and Benefits

Advanced Technology

- Six unequally spaced flutes for chatter-free machining at high feed rates.
- Less cutting forces and pressure on cutting edge through tailored axial and radial rake angles.
- Eccentric relief design increases tool life through higher edge stability.
- Proprietary tapered core provides highest tool stability at roughing and finishing operations.

Tailored Grade

- KCSM15 Beyond grade for exceptional tool life in titanium and stainless steels.

Extensive Standard Offering

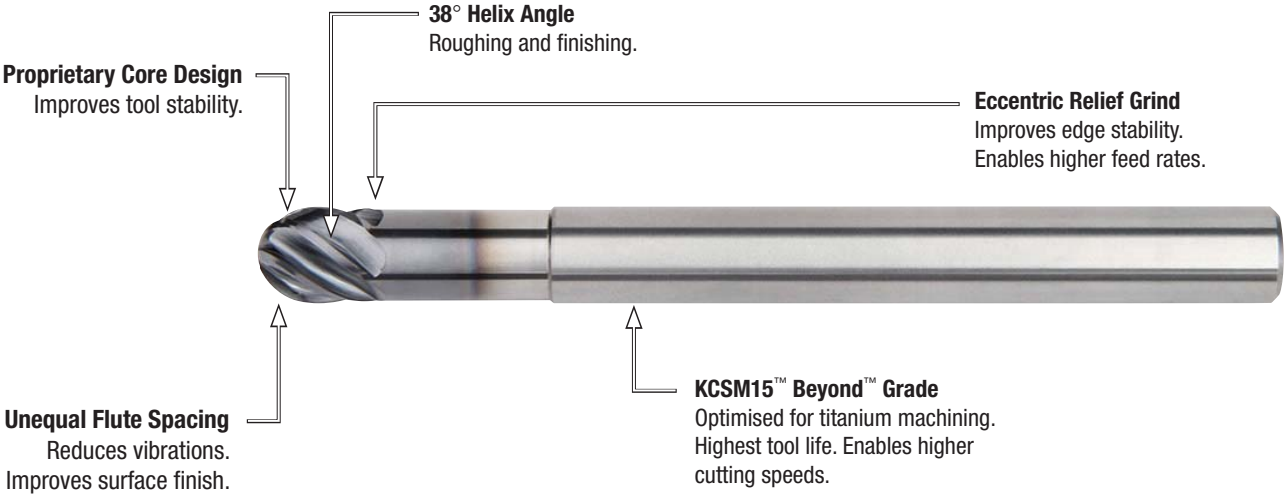
- Diameter ranges 10–20mm.
- Necked, round shank offering in two length variations.

Customisation

- Engineered solutions, including shank and non-standard length versions are available upon request.

3D profiling for highest productivity in titanium and stainless steel.

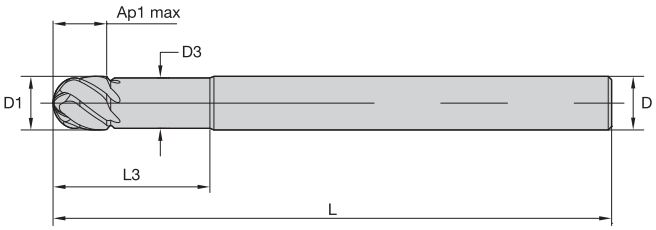




- Kennametal standard dimensions.
- Centre cutting.
- Optimised geometry for titanium machining.
- Unequal flute spacing minimises chatter for smoother machining.
- Single tool for both roughing and finishing operations requiring fewer setups.



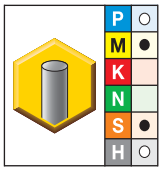




End Mill Tolerances

D1	tolerance	D	tolerance h6
≤3	-0,014/-0,028	≤3	+0/-0,006
>3–6	-0,020/-0,038	>3–6	+0/-0,008
>6–10	-0,025/-0,047	>6–10	+0/-0,009
>10–18	-0,032/-0,059	>10–18	+0/-0,011
>18–30	-0,040/-0,073	>18–30	+0/-0,013

UJBE • 6-Flute Ball Nose with Eccentric Relief Grind • Metric



● first choice
○ alternate choice

KCSM15	D1	D	D3	Ap1 max	L3	L
UJBE1000A6AN	10,00	10,00	9,40	10,00	30,00	72,00
UJBE1000A6AL	10,00	10,00	9,40	10,00	30,00	121,50
UJBE1200A6AN	12,00	12,00	11,28	12,00	36,00	83,00
UJBE1200A6AL	12,00	12,00	11,28	12,00	36,00	125,00
UJBE1600A6AN	16,00	16,00	15,04	16,00	48,00	100,00
UJBE1600A6AL	16,00	16,00	15,04	16,00	48,00	150,00
UJBE2000A6AN	20,00	20,00	18,80	20,00	60,00	115,00
UJBE2000A6AL	20,00	20,00	18,80	20,00	60,00	150,00

NOTE: For application data, see pages P58–P59.

EADE Solid Ceramic End Mill



- Roughing nickel-based high-temperature alloys.
- Highest productivity and longest tool life.
- Outstanding reduction of machining time.
- Fewer tool changes due to higher tool life.
- Benefit from throw-away type of tooling.
- Minimum cutting speed of 400 m/min.

Offering

- 4-flute necked tools for slotting.
- 6-flute version for face and side milling.

KYS40

- Cutting speeds up to 1000 m/min increases Metal Removal Rates (MRR).

beyond™

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HARVI III Ball Nose with Eccentric Relief

CHALLENGE

- Finish profile machining of keel for weapon attachment.
- Vertical machining centre.
- Titanium alloy beta (R56400).
- External emulsion.

SOLUTION

- HARVI III ball nose Ø 12,7mm with eccentric relief in KCSM15™.
- Six effective teeth.

CUTTING DATA

- vc 91 m/min
- fz 0,053 mm/z
- ap 30,5mm
- ae 0,6mm

RESULT

- Significantly increased tool life.
- Reduced machining time from 210 minutes to 90 minutes.
- Surface finish Ra 2,5 µm.

BENEFIT

- Predictable wear at main lands instead of cutting edge flaking with competitive tooling.
- Extended tool life of HARVI III eliminated a mid-part tool change.
- Improved surface finish compared to previous four-flute ball nose tools.

HARVI III Ball Nose with Eccentric Relief

CHALLENGE

- Rough profile yoke contour milling of bogey pitch trimmer.
- Lathe with driven tooling.
- 4340 low-alloy steel.
- External emulsion.

SOLUTION

- HARVI III ball nose Ø 20mm with eccentric relief in KCSM15.
- Six effective teeth.

CUTTING DATA

- vc 122 m/min
- fz 0,076 mm/z
- ap 43,2mm
- ae 2,5mm

RESULT

- Tool completed seven workpieces compared to five workpieces with existing tooling.
- Surface finish Ra 3,2 µm.

BENEFIT

- Reduced machining time from 88 minutes to 49 minutes.
- About 30% higher feed rate due to feed per tooth and six flutes rather than four flutes.

(continued)

(continued)



HARVI III Ball Nose with Eccentric Relief

CHALLENGE

- Hem stitch profile neck to flanged blend.
- Lathe with driven tooling.
- 4340 low alloy steel.
- External emulsion.

SOLUTION

- HARVI III ball nose Ø 12,7mm with eccentric relief in KCSM15™.
- Six effective teeth.

CUTTING DATA

- vc 107 m/min
- fz 0,064 mm/z
- ap 1,3mm
- ae 1,3mm

RESULT

- Increase in cutting speed from 46 m/mm to 107 m/min.
- Tool completed ten workpieces compared to six workpieces with existing tooling.

BENEFIT

- Reduced machining time to eight minutes compared to 29 minutes with competitive four-flute ball nose tool.
- 200% increase in Metal Removal Rates (MRR).

HARVI III Ball Nose with Eccentric Relief

CHALLENGE

- Finish interior walls and blend filet radius.
- Horizontal machining centre.
- 4340 low alloy steel.
- External emulsion.

SOLUTION

- HARVI III ball nose Ø 12,7mm with eccentric relief in KCSM15.
- Six effective teeth.

CUTTING DATA

- vc 107 m/min
- fz 0,064 mm/z
- ap 14mm
- ae 1,3mm

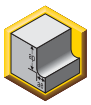
RESULT

- Tool completed six workpieces compared to two workpieces with existing solution.
- Surface finish Ra 2,75 µm.

BENEFIT

- Reduced machining time from 25 minutes to 10 minutes.
- Improved surface finish from Ra 3,93 µm to Ra 2,75 µm at accelerated feeds and speeds.
- Reduction in harmonics, noise level, and vibrations with HARVI III ball nose tooling.

HARVI III • UJBE • Ball Nose • Unequal Flute Spacing • Roughing





Material Group		Side Milling (A)		KCSM15			Recommended feed per tooth (fz = mm/th) for side milling (A).				
		A		Cutting Speed – vc m/min				D1 – Diameter			
		ap	ae	min		max	mm	10,0	12,0	16,0	20,0	25,0
P	0	Ap max	0,4 x D	150	–	200	fz	0,072	0,083	0,101	0,114	0,124
	1	Ap max	0,4 x D	150	–	200	fz	0,072	0,083	0,101	0,114	0,124
	2	Ap max	0,4 x D	140	–	190	fz	0,072	0,083	0,101	0,114	0,124
	3	Ap max	0,4 x D	120	–	160	fz	0,061	0,070	0,087	0,101	0,114
	4	Ap max	0,4 x D	90	–	150	fz	0,054	0,062	0,077	0,088	0,098
	5	Ap max	0,4 x D	60	–	100	fz	0,048	0,056	0,070	0,081	0,091
	6	Ap max	0,4 x D	50	–	75	fz	0,040	0,047	0,057	0,065	0,071
M	1	Ap max	0,4 x D	90	–	115	fz	0,061	0,070	0,087	0,101	0,114
	2	Ap max	0,4 x D	60	–	80	fz	0,048	0,056	0,070	0,081	0,091
	3	Ap max	0,4 x D	60	–	70	fz	0,040	0,047	0,057	0,065	0,071
S	1	Ap max	0,4 x D	50	–	90	fz	0,061	0,070	0,087	0,101	0,114
	2	Ap max	0,4 x D	25	–	40	fz	0,032	0,037	0,046	0,054	0,061
	3	Ap max	0,4 x D	25	–	40	fz	0,032	0,037	0,046	0,054	0,061
	4	Ap max	0,4 x D	50	–	60	fz	0,045	0,052	0,064	0,074	0,084
H	1	Ap max	0,4 x D	80	–	140	fz	0,054	0,062	0,077	0,088	0,098

NOTE: Those guidelines may require variations to achieve optimum results.
Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters accordingly on >12mm diameter.

HARVI III • UJBE • Ball Nose • Unequal Flute Spacing • Finishing





Material Group		Side Milling (A)		KCSM15			Recommended feed per tooth (fz = mm/th) for side milling (A).				
		A		Cutting Speed — vc m/min				D1 — Diameter			
		ap	ae	min		max	mm	10,0	12,0	16,0	20,0	25,0
P	0	Ap max	0,06 x D	285	–	380	fz	0,086	0,099	0,121	0,137	0,149
	1	Ap max	0,06 x D	285	–	380	fz	0,086	0,099	0,121	0,137	0,149
	2	Ap max	0,06 x D	266	–	361	fz	0,086	0,099	0,121	0,137	0,149
	3	Ap max	0,06 x D	228	–	304	fz	0,073	0,084	0,105	0,121	0,137
	4	Ap max	0,06 x D	171	–	285	fz	0,065	0,075	0,092	0,106	0,117
	5	Ap max	0,06 x D	114	–	190	fz	0,058	0,067	0,084	0,097	0,109
	6	Ap max	0,06 x D	95	–	142,5	fz	0,048	0,056	0,068	0,078	0,085
M	1	Ap max	0,06 x D	171	–	218,5	fz	0,073	0,084	0,105	0,121	0,137
	2	Ap max	0,06 x D	114	–	152	fz	0,058	0,067	0,084	0,097	0,109
	3	Ap max	0,06 x D	114	–	133	fz	0,048	0,056	0,068	0,078	0,085
S	1	Ap max	0,06 x D	95	–	171	fz	0,073	0,084	0,105	0,121	0,137
	2	Ap max	0,06 x D	47,5	–	76	fz	0,038	0,045	0,056	0,065	0,074
	3	Ap max	0,06 x D	47,5	–	76	fz	0,038	0,045	0,056	0,065	0,074
	4	Ap max	0,06 x D	95	–	114	fz	0,053	0,062	0,077	0,089	0,100
H	1	Ap max	0,06 x D	152	–	266	fz	0,065	0,075	0,092	0,106	0,117

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters accordingly on >12mm diameter.

HARVI™ III Taper Ball Nose

High-Performance Solid Carbide End Mills

Primary Application

HARVI III taper ball nose addresses the demand from energy and aerospace turbine customers to increase output and solve capacity issues by significantly reducing of machining time in 5-axis machining.

- Up to 50% higher Metal Removal Rates (MRR) with same tool life or up to 50% higher tool life due to 6-flute geometry with unequal flute spacing.
- Different tapered front end for highest tool stability on a variety of long-reach applications.
- Proprietary KCSM15™ grade for high tool life.

Features and Benefits

Advanced Technology

- Six flutes in ball nose and taper section for highest metal removal rates.
- Unequally spaced flutes to minimise vibrations and provide high tool life and superior surface quality.

Tailored Grades

- KCSM15 Beyond™ grade for outstanding wear protection in stainless steels and high-temperature alloys.

Customisation

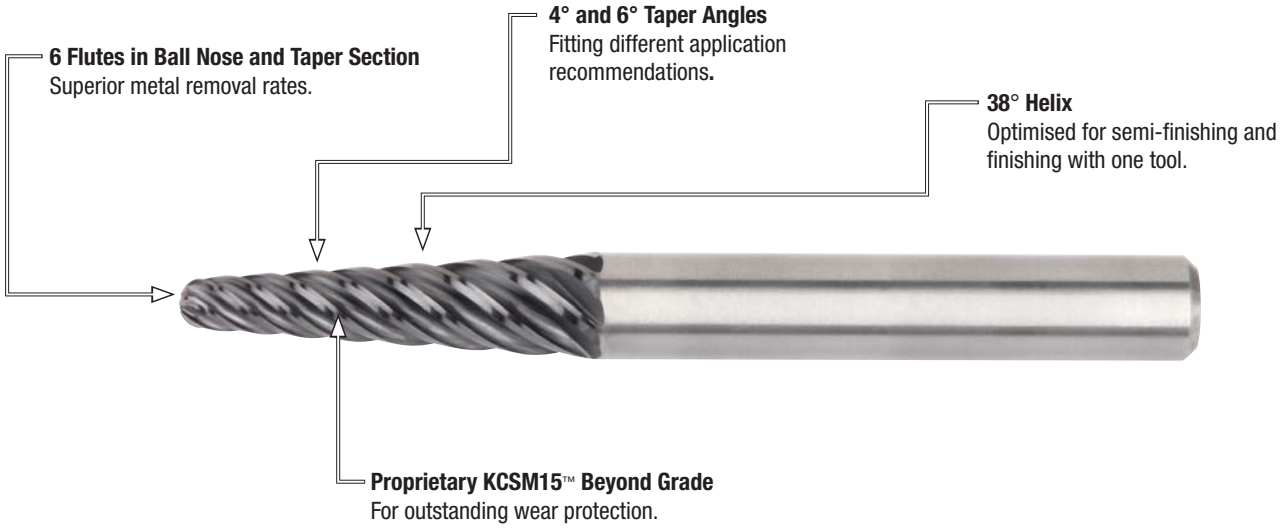
- Intermediate diameters available.
- Expanded length of tool and increased length of cut are possible.

Standard Offerings

- Diameter ranges 4–10mm

Designed for 5-axis machining in steel, stainless steel, nickel-based alloys, and titanium.

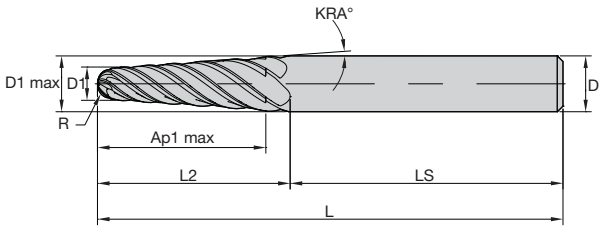




- Centre cutting.
- 6 flutes for highest material removal rates.
- Unequal flute spacing minimises chatter for smoother machining.
- 2 taper angle versions for optimised stability in long-reach operations.
- Single tool for both semi-finishing and finishing operations requiring fewer setups.
- Optimised geometry for stainless, nickel-based alloys, and titanium machining.



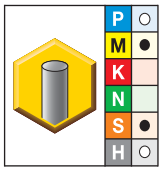




End Mill Tolerances

D1	tolerance	D	tolerance h6
≤3	-0,014/-0,028	≤3	+0/-0,006
>3–6	-0,020/-0,038	>3–6	+0/-0,008
>6–10	-0,025/-0,047	>6–10	+0/-0,009
>10–18	-0,032/-0,059	>10–18	+0/-0,011
>18–30	-0,040/-0,073	>18–30	+0/-0,013

UJBE • 6-Flute Taper Ball Nose • Unequal Flute Spacing



● first choice
○ alternate choice

KCSM15	D1	D	Ap1 max	L2	L	LS	R	KRA
UJBE0400A6CP	4,00	8,00	26,00	3 0,53	76,00	45,47	2,00	4.00
UJBE0400A6BP	4,00	10,00	25,00	30,44	89,00	58,56	2,00	6.00
UJBE0500A6CP	5,00	10,00	33,00	38,16	89,00	50,84	2,50	4.00
UJBE0500A6BP	5,00	12,00	29,00	35,67	100,00	64,33	2,50	6.00
UJBE0600A6BP	6,00	12,00	39,00	45,80	100,00	54,20	3,00	4.00
UJBE0600A6CP	6,00	16,00	42,00	50,42	110,00	59,59	3,00	6.00
UJBE0700A6BP	7,00	12,00	33,00	39,13	100,00	60,87	3,50	4.00
UJBE0700A6CP	7,00	16,00	38,00	46,13	110,00	63,87	3,50	6.00
UJBE0800A6CP	8,00	14,00	39,00	46,76	100,00	53,24	4,00	4.00
UJBE0800A6BP	8,00	16,00	33,00	41,85	110,00	68,15	4,00	6.00
UJBE1000A6BP	10,00	16,00	25,00	33,28	110,00	76,72	5,00	6.00
UJBE1000A6CP	10,00	16,00	39,00	47,73	110,00	62,27	5,00	4.00

NOTE: For application data, see pages P68–P69.

Superior Finishing

MaxiMet™

Designed to significantly reduce machining time in aluminium! The innovative geometry designs include a wiper facet for superior surface finish on aluminium parts. MaxiMet handles roughing and finishing cuts with one tool.

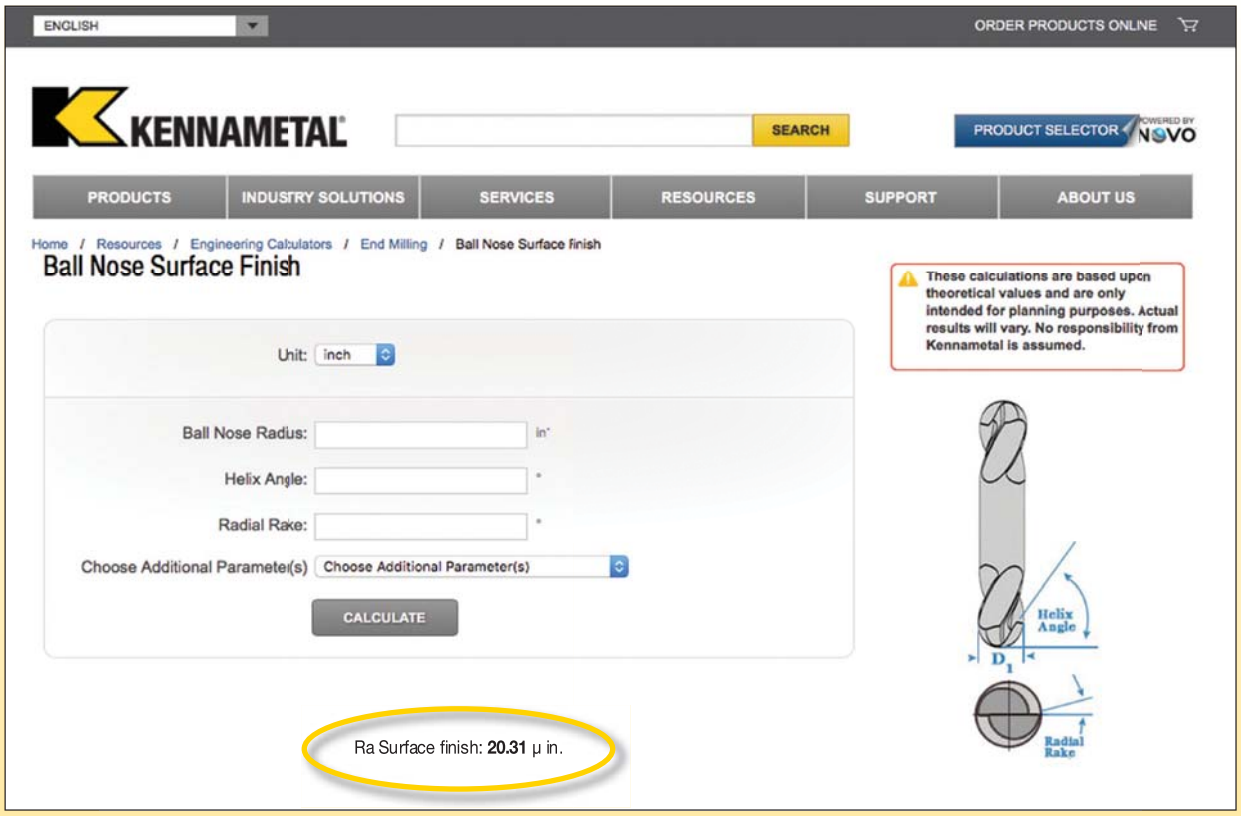
- Use only one tool for roughing and finishing operations.
- Slotting is effective up to full 1 x D axial depth; side milling is effective up to 0,5 x D radial, by 1,5 x D axial depth.
- Three-flute series uses unequal flute spacing for chatter-free performance.
- Effective in a full range of machine speeds.
- Multiple corner radii and extended neck configurations are available as standard.



Visit **kennametal.com** or contact your local Authorised Kennametal Distributor.

KENNAMETAL®

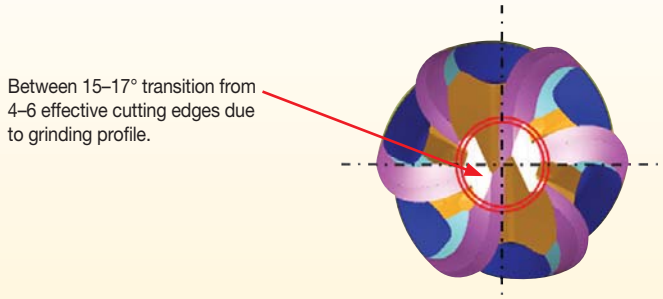
kennametal.com

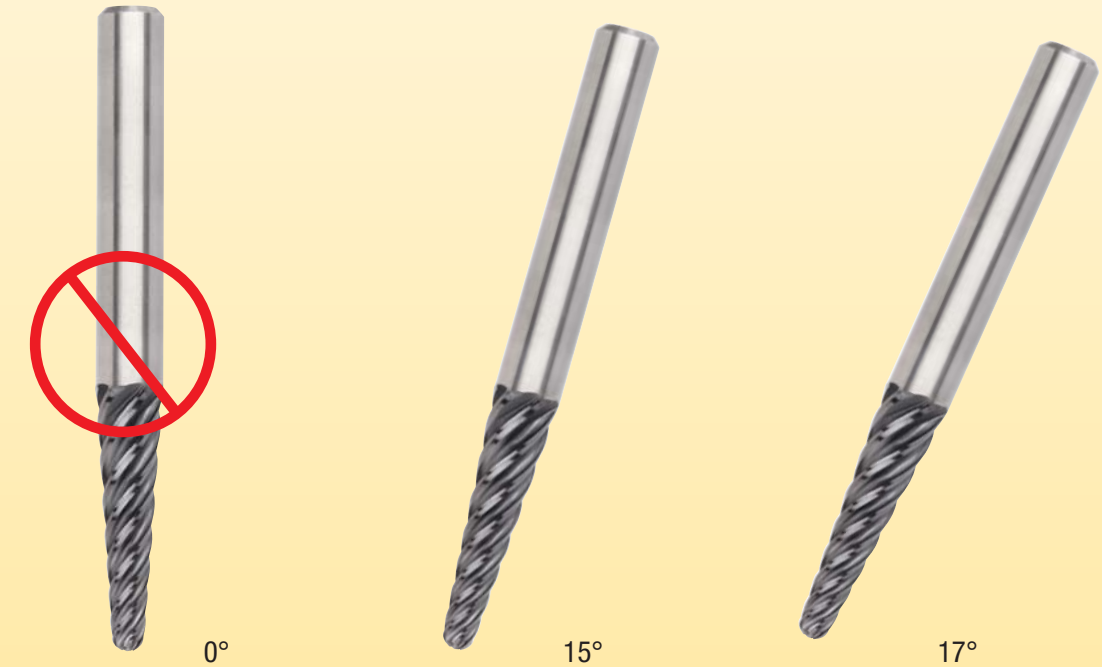


Use 5–10° for radial rake angle.

Make use of calculators such as:
kennametal.com/en/resources/calculators/
end-milling-calculators/ball-nose-surface-finish.html

Not all 6 cutting edges are reaching to the centre of the HARVI III taper ball nose end mill.
Therefore, certain machining angles will result in different numbers of effective cutting edges.





Avoid (centre cutting speed = 0)

<15° z = 2 effective cutting edges

>17° z = 6 effective cutting edges



HARVI™ III Taper Ball Nose UJBE

CHALLENGE

- Finishing contour milling with lightly interrupted cut.
- Blade machining for energy customer.
- X22 CrMoV12.
- External emulsion.

SOLUTION

- HARVI III taper ball nose UJBE, 6° taper angle, and KCSM15™ with 6 effective cutting edges, Ø 6mm.

CUTTING DATA

- vc 100 m/min
- fz 0,05mm/Z
- ap 2mm
- ae 0,6mm

RESULT

- 73% increased productivity.

BENEFIT

- Reduced cost per component as the tool life increased.
- New 6-flute geometry has given better surface finish compared to 4 flutes.
- Regrindable tool.

HARVI III Taper Ball Nose UJBE

CHALLENGE

- Finishing intersection and hub on blade airfoil.
- Blade machining for energy customer.
- X22CrMoV12-1.
- External emulsion.

SOLUTION

- HARVI III taper ball nose UJBE, 6° taper angle, and KCSM15 with 6 effective cutting edges, Ø 10mm.

CUTTING DATA

- vc 260 m/min
- fz 0,06mm/Z
- ap 0,6mm
- ae 0,6mm

RESULT

- 50% increase in feed.
- 28% increase in tool life.
- Improved surface finish and minimum wear on edges.

BENEFIT

- Reduced tooling cost.
- Reduction in cost per component.
- Good surface finish.
- Regrindable tool.

(continued)

(continued)



HARVI™ III Taper Ball Nose UJBE

CHALLENGE

- Finishing intersection and hub on blade airfoil.
- X22CrMoV12-1.
- External emulsion.

SOLUTION

- UJBE with KCSM15™.
- Ø 4mm with 8 effective cutting edges.

CUTTING DATA

- vc 140 m/min
- fz 0,015mm/Z
- ap 0,5mm
- ae 0,35mm

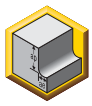
RESULT

- Substantial increase in Metal Removal Rates (MRR).

BENEFIT

- Improved surface quality.
- Regrindable tool to reduce tool cost.

HARVI III • UJBE • 6-Flute Taper Ball Nose • Unequal Flute Spacing • Semi-Finishing





Material Group		Side Milling (A)		KCSM15			Recommended feed per tooth (fz = mm/th) for side milling (A).					
		A		Cutting Speed — vc m/min				D1 — Diameter				
		ap	ae	min		max	mm	10,0	12,0	16,0	18,0	20,0	25,0
P	0	Ap max	0,4 x D	150	–	200	fz	0,072	0,083	0,101	0,108	0,114	0,124
	1	Ap max	0,4 x D	150	–	200	fz	0,072	0,083	0,101	0,108	0,114	0,124
	2	Ap max	0,4 x D	140	–	190	fz	0,072	0,083	0,101	0,108	0,114	0,124
	3	Ap max	0,4 x D	120	–	160	fz	0,061	0,070	0,087	0,095	0,101	0,114
	4	Ap max	0,4 x D	90	–	150	fz	0,054	0,062	0,077	0,083	0,088	0,098
	5	Ap max	0,4 x D	60	–	100	fz	0,048	0,056	0,070	0,076	0,081	0,091
M	1	Ap max	0,4 x D	90	–	115	fz	0,061	0,070	0,087	0,095	0,101	0,114
	2	Ap max	0,4 x D	60	–	80	fz	0,048	0,056	0,070	0,076	0,081	0,091
	3	Ap max	0,4 x D	60	–	70	fz	0,040	0,047	0,057	0,061	0,065	0,071
S	1	Ap max	0,4 x D	50	–	90	fz	0,061	0,070	0,087	0,095	0,101	0,114
	2	Ap max	0,4 x D	25	–	40	fz	0,032	0,037	0,046	0,050	0,054	0,061
	3	Ap max	0,4 x D	25	–	40	fz	0,032	0,037	0,046	0,050	0,054	0,061
	4	Ap max	0,4 x D	50	–	60	fz	0,045	0,052	0,064	0,069	0,074	0,084
H	1	Ap max	0,4 x D	80	–	140	fz	0,054	0,062	0,077	0,083	0,088	0,098

* For the above cutting data, do not exceed an overall ae of 0,8mm.

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. For smaller taper machinining centres, please adjust parameters accordingly on >12mm diameter.

UJBE • 6-Flute Taper Ball Nose • Unequal Flute Spacing • Finishing





Material Group		Side Milling (A)		KCSM15			Recommended feed per tooth (fz = mm/th) for side milling (A).					
		A		Cutting Speed — vc m/min				D1 — Diameter				
		ap	ae	min		max	mm	10,0	12,0	16,0	18,0	20,0	25,0
P	0	Ap max	0,06 x D	285	–	380	fz	0,086	0,099	0,121	0,130	0,137	0,149
	1	Ap max	0,06 x D	285	–	380	fz	0,086	0,099	0,121	0,130	0,137	0,149
	2	Ap max	0,06 x D	266	–	361	fz	0,086	0,099	0,121	0,130	0,137	0,149
	3	Ap max	0,06 x D	228	–	304	fz	0,073	0,084	0,105	0,113	0,121	0,137
	4	Ap max	0,06 x D	171	–	285	fz	0,065	0,075	0,092	0,099	0,106	0,117
	5	Ap max	0,06 x D	114	–	190	fz	0,058	0,067	0,084	0,091	0,097	0,109
M	1	Ap max	0,06 x D	171	–	218,5	fz	0,073	0,084	0,105	0,113	0,121	0,137
	2	Ap max	0,06 x D	114	–	152	fz	0,058	0,067	0,084	0,091	0,097	0,109
	3	Ap max	0,06 x D	114	–	133	fz	0,048	0,056	0,068	0,073	0,078	0,085
S	1	Ap max	0,06 x D	95	–	171	fz	0,073	0,084	0,105	0,113	0,121	0,137
	2	Ap max	0,06 x D	47,5	–	76	fz	0,038	0,045	0,056	0,060	0,065	0,074
	3	Ap max	0,06 x D	47,5	–	76	fz	0,038	0,045	0,056	0,060	0,065	0,074
	4	Ap max	0,06 x D	95	–	114	fz	0,053	0,062	0,077	0,083	0,089	0,100
H	1	Ap max	0,06 x D	152	–	266	fz	0,065	0,075	0,092	0,099	0,106	0,117

* For the above cutting data, do not exceed an overall ae of 0,8mm.

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. For smaller taper machinining centres, please adjust parameters accordingly on >12mm diameter.

XE/XER

High-Performance Solid Carbide End Mills

Primary Application

XE and XER radius end mills are specially developed and manufactured for stainless steel, titanium, and high-temperature alloys that are typically found in aerospace, defence, medical, oil, and gas end markets.

- Roughing and finishing with one tool.
- Highest Metal Removal Rates (MRR) optimise productivity.
- Tough and wear resistant substrate.
- Advanced nano composite PVD coating.

Features and Benefits

Advanced Technology

- Four flutes with unequal helix for chatter-free machining at high feed rates.
- Centre cutting for helical operations and pocketing.
- Front-end design and unequal helix for optimised chip control.

Tailored Grades

- SP4060 grade with tough and wear-resistant substrate, advanced nano-composite PVD coating for highest tool life.

Customisation

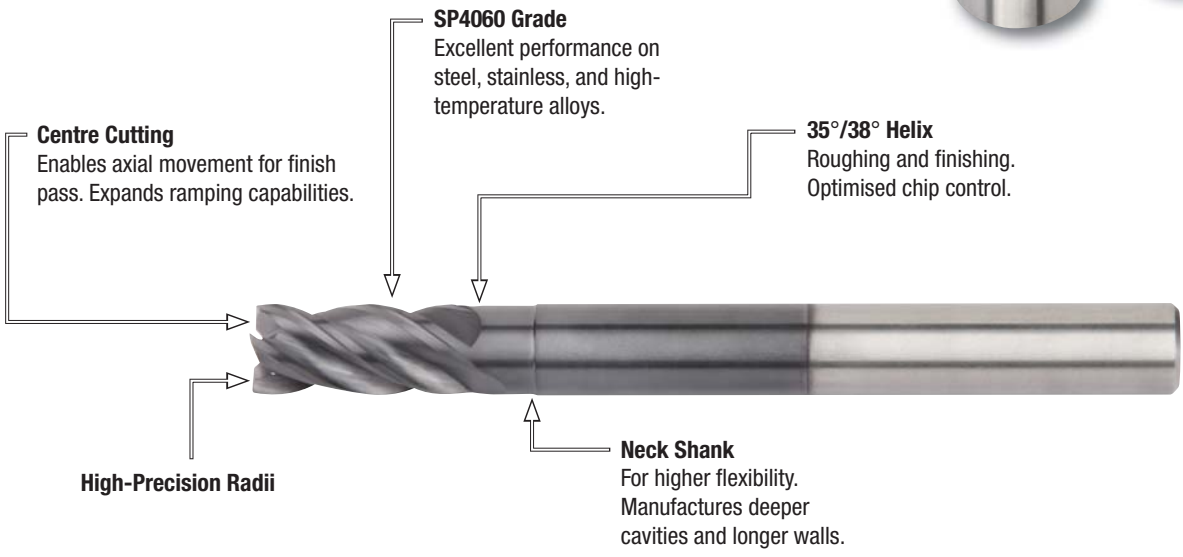
- Intermediate diameters available.
- Expanded length of tool and increased length of cut are possible.

Standard Offering

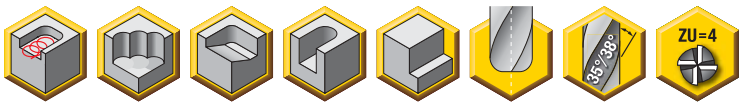
- Diameter ranges 2–20mm.

Designed for roughing and finishing with the highest Metal Removal Rates (MRR) in demanding materials.

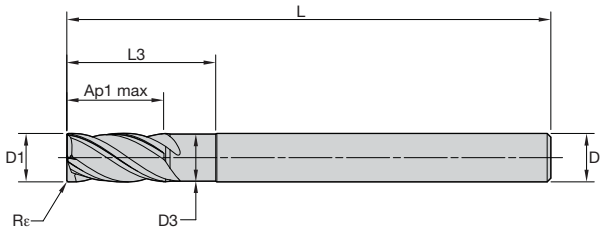




- Asymmetrical flute spacing and variable helix configuration minimises chatter and harmonics for smoother machining.
- Centre cutting.
- Single tool for both roughing and finishing operations requiring fewer setups.
- Standard items listed. Additional styles and coatings made-to-order.



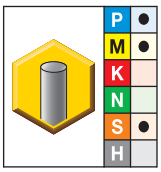




End Mill Tolerances

D1	tolerance h6/e8	D	tolerance h6
≤3	-0,006/-0,028	≤3	+0/-0,006
>3–6	-0,008/-0,068	>3–6	+0/-0,008
>6–10	-0,009/-0,047	>6–10	+0/-0,009
>10–18	-0,011/-0,059	>10–18	+0/-0,011
>18–30	-0,013/-0,073	>18–30	+0/-0,013
>30	-0,016/-0,089	>30	+0/-0,016

XE • 4 Flute • Metric

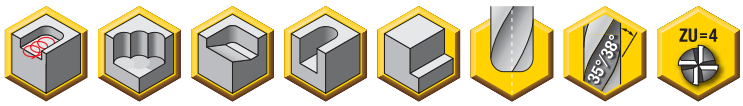


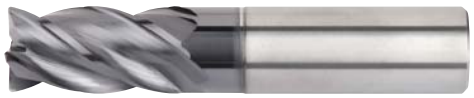
● first choice
○ alternate choice

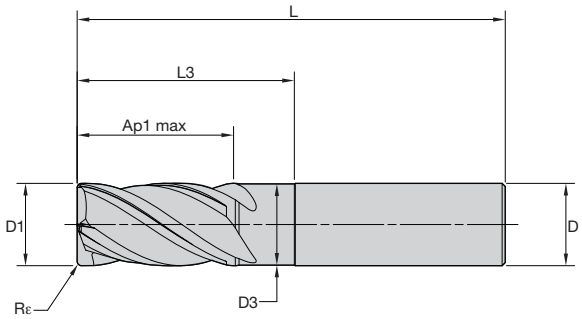
SP4060	D1	D	D3	Ap1 max	L	L3	Rε
XE020MTN4-C *	2,00	6,00	—	4,00	65,00	—	0,25
XE025MTN4-C *	2,50	6,00	—	5,00	65,00	—	0,25
XE030MTN4-C	3,00	6,00	—	6,00	65,00	—	0,25
XE040MTN4-C	4,00	6,00	—	8,00	65,00	—	0,25
XE050MTN4-C	5,00	6,00	—	10,00	75,00	—	0,25
XE060MN4-C	6,00	6,00	5,75	12,00	75,00	18,00	0,25
XE080MN4-C	8,00	8,00	7,75	16,00	75,00	24,00	0,25
XE100MN4-C	10,00	10,00	9,75	20,00	100,00	30,00	0,25
XE160MN4-C	16,00	16,00	15,75	32,00	115,00	48,00	0,25
XE200MN4-C *	20,00	20,00	19,75	40,00	120,00	60,00	0,25

NOTE: For application data, see page P74.
*Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

- Asymmetrical flute spacing and variable helix configuration minimises chatter and harmonics for smoother machining.
- Centre cutting.
- Single tool for both roughing and finishing operations requiring fewer setups.
- Standard items listed. Additional styles and coatings made-to-order.



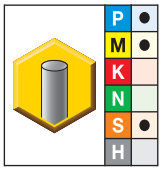




End Mill Tolerances

D1	tolerance h6/e8	D	tolerance h6
≤3	-0,006/-0,028	≤3	+0/-0,006
>3–6	-0,008/-0,068	>3–6	+0/-0,008
>6–10	-0,009/-0,047	>6–10	+0/-0,009
>10–18	-0,011/-0,059	>10–18	+0/-0,011
>18–30	-0,013/-0,073	>18–30	+0/-0,013
>30	-0,016/-0,089	>30	+0/-0,016

XER • 4 Flute • Metric



● first choice
○ alternate choice

SP4060	D1	D	D3	Ap1 max	L	L3	Rε
XER020NTN4-C *	2,00	6,00	—	7,00	57,00	—	0,25
XER030NTN4-C	3,00	6,00	—	8,00	57,00	—	0,25
XER040NTN4-C	4,00	6,00	—	11,00	57,00	—	0,25
XER040NTN4-E	4,00	6,00	—	11,00	57,00	—	0,50
XER050NTN4-E	5,00	6,00	—	13,00	57,00	—	0,50
XER060NN4-C	6,00	6,00	5,75	13,00	57,00	19,76	0,25
XER060NN4-E	6,00	6,00	5,75	13,00	57,00	19,76	0,50
XER060NN4-G	6,00	6,00	5,75	13,00	57,00	19,76	1,00
XER080NN4-C	8,00	8,00	7,75	19,00	63,00	25,76	0,25
XER080NN4-E	8,00	8,00	7,75	19,00	63,00	25,76	0,50
XER080NN4-G	8,00	8,00	7,75	19,00	63,00	25,76	1,00
XER100NN4-C	10,00	10,00	9,75	22,00	72,00	30,76	0,25
XER100NN4-E	10,00	10,00	9,75	22,00	72,00	30,76	0,50
XER100NN4-G	10,00	10,00	9,75	22,00	72,00	30,76	1,00
XER120NN4-C	12,00	12,00	11,75	26,00	83,00	36,76	0,25
XER120NN4-E *	12,00	12,00	11,75	26,00	83,00	36,76	0,50
XER120NN4-G	12,00	12,00	11,75	26,00	83,00	36,76	1,00
XER120NN4-J	12,00	12,00	11,75	26,00	83,00	36,76	1,50
XER120NN4-L	12,00	12,00	11,75	26,00	83,00	36,76	2,50
XER160NN4-C	16,00	16,00	15,75	32,00	92,00	43,00	0,25
XER160NN4-G	16,00	16,00	15,75	32,00	92,00	42,76	1,00
XER160NN4-J	16,00	16,00	15,75	32,00	92,00	42,76	1,50
XER160NN4-L	16,00	16,00	15,75	32,00	92,00	42,76	2,50
XER160NN4-M	16,00	16,00	15,75	32,00	92,00	42,76	3,00
XER160NN4-P	16,00	16,00	15,75	32,00	92,00	42,76	4,00
XER200NN4-G	20,00	20,00	19,75	38,00	104,00	52,76	1,00
XER200NN4-J	20,00	20,00	19,75	38,00	104,00	52,76	1,50
XER200NN4-M	20,00	20,00	19,75	38,00	104,00	52,76	3,00

NOTE: For application data, see page P74.
*Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

XE/XER • Asymmetrical Flute Spacing





Material Group		Side Milling (A) and Slotting (B)			SP4060			Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 20%.											
		A		B	Cutting Speed – vc m/min				D1 – Diameter										
		ap	ae	ap	min		max	mm	2,0	4,0	5,0	6,0	8,0	10,0	12,0	14,0	16,0	18,0	20,0
P	3	2,0 x D	0,5 x D	1 x D	120	–	160	fz	0,012	0,023	0,030	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101
	4	2,0 x D	0,5 x D	0,75 x D	90	–	150	fz	0,011	0,021	0,027	0,033	0,045	0,054	0,062	0,070	0,077	0,083	0,088
	5	2,0 x D	0,5 x D	1 x D	60	–	100	fz	0,010	0,019	0,024	0,029	0,040	0,048	0,056	0,063	0,070	0,076	0,081
	6	2,0 x D	0,5 x D	0,75 x D	50	–	75	fz	0,008	0,016	0,020	0,025	0,034	0,040	0,047	0,052	0,057	0,061	0,065
M	1	2,0 x D	0,5 x D	1 x D	90	–	115	fz	0,012	0,023	0,030	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101
	2	2,0 x D	0,5 x D	1 x D	60	–	80	fz	0,010	0,019	0,024	0,029	0,040	0,048	0,056	0,063	0,070	0,076	0,081
	3	2,0 x D	0,5 x D	1 x D	60	–	70	fz	0,008	0,016	0,020	0,025	0,034	0,040	0,047	0,052	0,057	0,061	0,065
S	1	2,0 x D	0,5 x D	1 x D	50	–	90	fz	0,012	0,023	0,030	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101
	2	2,0 x D	0,5 x D	1 x D	25	–	40	fz	0,006	0,013	0,016	0,019	0,026	0,032	0,037	0,042	0,046	0,050	0,054
	3	2,0 x D	0,5 x D	1 x D	25	–	40	fz	0,006	0,013	0,016	0,019	0,026	0,032	0,037	0,042	0,046	0,050	0,054
	4	2,0 x D	0,5 x D	1 x D	50	–	60	fz	0,008	0,016	0,021	0,026	0,037	0,045	0,052	0,058	0,064	0,069	0,074

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters accordingly on >12mm diameter.

NOVO KNOWS SEARCH

Searching for a tool has been enhanced by Advise and Select functions from NOVO™ applications — saving you time and money.

ADVISE

Uses a rules-based approach to provide cutting tool recommendations:

- Define Machining Feature (face milling, slotting, blind hole, etc.)
- Apply Constraint Requirements (geometric, material, tolerance, etc.)
- Set Machining Sequence (single or multi-step operations, rough then finish, etc.)
- Receive Ranked Results

SELECT

A method of selecting cutting tools from a tree structure via a hierarchy or parametric search:

- If you know which product you are looking for, a quick search can be performed by just the catalogue number or product description.
- Smart filters significantly reduce the amount of potential tooling solutions.
- After the tool is selected, NOVO also provides cutting and adaptive item options that fit with your solution.

NOVO applications can ensure you have the right tools on your machines, in the right sequence. Resulting in flawless execution that accelerates every job, and maximises every shift. **kennametal.com/novo**

High-Performance Solid Carbide Roughing End Mills

Primary Application

High-performance roughers can be applied in a wide range of workplace materials such as steels, stainless steels, cast irons, and in certain cases, hardened materials. Tailored roughing profiles reduce cutting forces to the necessary level or combine roughing and semi-finishing for fewer tool changes.

- High-performance universal tools for almost all cutting materials.
- Lower cutting forces and spindle power consumption.
- Centre cutting for plunging, ramping, profiling, high-feed slotting, and side milling.

Features and Benefits

Advanced Technology

- Up to full length of cut for:
  - Slotting
  - Side milling
  - Profiling
  - Semi-finishing
- Various roughing profiles available for the right balance between cutting forces, feed rates, and surface quality.
- Internal coolant for improved chip evacuation and extended tool life.

Tailored Grades

- From proprietary KCPM15™ Beyond™ grade for outstanding wear to uncoated tools suitable for a variety of workpiece materials.

Customisation

- Intermediate diameters available.
- Corner radii for near-shape roughing operations available.
- Various shank options, including the Safe-Lock™ system by HAIMER®, and non-standard coatings available.

Extensive Standard Offering

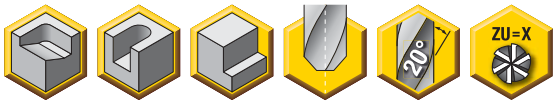
- Diameter ranges 4–25mm.
- Weldon® shank for maximum torque transmission.

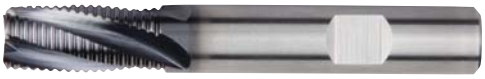
Highest metal removal rates — even on unstable machines or workpiece clamping.

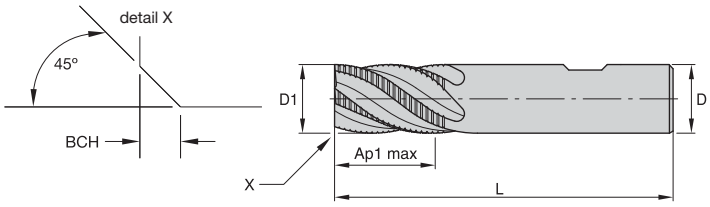




- Kennametal standard dimensions.
- Centre cutting.
- Cord profile.





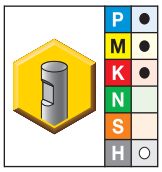


End Mill Tolerances

D1	tolerance d11	D	tolerance h6
≤ 3	-0,020/-0,080	≤ 3	+0/-0,006
> 3–6	-0,030/-0,105	> 3–6	+0/-0,008
> 6–10	-0,040/-0,130	> 6–10	+0/-0,009
> 10–18	-0,050/0,160	> 10–18	+0/-0,011
> 18–30	-0,065/-0,195	> 18–30	+0/-0,013

beyond

F3BH-F4BJ-F5BJ...WS-WM-WL-WX • Metric



● first choice
○ alternate choice

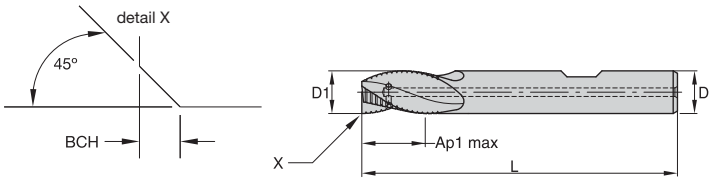
KCPM15	D1	D	Ap1 max	L	BCH	Z U
F3BH0400BWS20L110	4,00	6,00	11,00	55,00	0,30	3
F3BH0500BWS20L130	5,00	6,00	13,00	57,00	0,30	3
F3BH0600BWS20L080	6,00	6,00	8,00	54,00	0,30	3
F3BH0600BWS20L130	6,00	6,00	13,00	57,00	0,30	3
F3BH0800BWS20L110	8,00	8,00	11,00	58,00	0,30	3
F3BH0800BWM20L160	8,00	8,00	16,00	63,00	0,30	3
F4BJ1000BWM20L130	10,00	10,00	13,00	66,00	0,50	4
F4BJ1000BWM20L220	10,00	10,00	22,00	72,00	0,50	4
F4BJ1200BWM20L160	12,00	12,00	16,00	73,00	0,50	4
F4BJ1200BWL20L260	12,00	12,00	26,00	83,00	0,50	4
F4BJ1400BWL20L260	14,00	14,00	26,00	83,00	0,50	4
F4BJ1600BWL20L190	16,00	16,00	19,00	82,00	0,50	4
F4BJ1600BWL20L320	16,00	16,00	32,00	92,00	0,50	4
F4BJ2000BWL20L220	20,00	20,00	22,00	92,00	0,50	4
F4BJ2000BWX20L380	20,00	20,00	38,00	104,00	0,50	4
F5BJ2500BWX20L450	25,00	25,00	45,00	121,00	0,50	5

NOTE: For application data, see page P85.

- Kennametal standard dimensions.
- Centre cutting.
- Cord profile.
- Internal coolant for optimised chip removal and increased tool life.





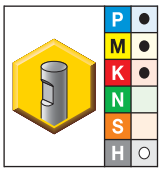


End Mill Tolerances

D1	tolerance d11	D	tolerance h6
≤ 3	-0,020 / -0,080	≤ 3	+0 / -0,006
> 3–6	-0,030 / -0,105	> 3–6	+0 / -0,008
> 6–10	-0,040 / -0,130	> 6–10	+0 / -0,009
> 10–18	-0,050 / -0,160	> 10–18	+0 / -0,011
> 18–30	-0,065 / -0,195	> 18–30	+0 / -0,013

beyond

F3BH-F4BJ...WS-WM-WL-WX • Internal Coolant • Metric

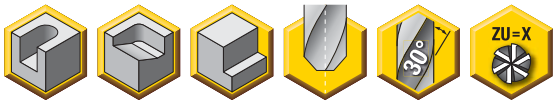


● first choice
○ alternate choice

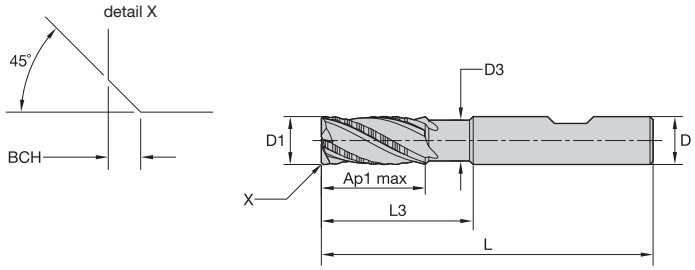
KCPM15	D1	D	Ap1 max	L	BCH	Z U
F3BH0800BWS20C110	8,00	8,00	11,00	58,00	0,30	3
F3BH0800BWM20C160	8,00	8,00	16,00	63,00	0,30	3
F4BJ1000BWM20C130	10,00	10,00	13,00	66,00	0,50	4
F4BJ1000BWM20C220	10,00	10,00	22,00	72,00	0,50	4
F4BJ1200BWM20C160	12,00	12,00	16,00	73,00	0,50	4
F4BJ1200BWL20C260	12,00	12,00	26,00	83,00	0,50	4
F4BJ1600BWL20C190	16,00	16,00	19,00	82,00	0,50	4
F4BJ1600BWL20C320	16,00	16,00	32,00	92,00	0,50	4
F4BJ2000BWL20C220	20,00	20,00	22,00	92,00	0,50	4
F4BJ2000BWX20C380	20,00	20,00	38,00	104,00	0,50	4

NOTE: For application data, see page P85.

- Kennametal standard dimensions.
- Centre cutting.
- Flat shallow profile.





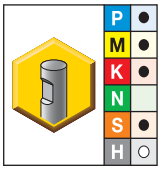


End Mill Tolerances

D1	tolerance d11	D	tolerance h6 + / -
≤ 3	-0,020/-0,080	≤ 3	0/0,006
> 3–6	-0,030/-0,105	> 3–6	0/0,008
> 6–10	-0,040/-0,130	> 6–10	0/0,009
> 10–18	-0,050/-0,160	> 10–18	0/0,011
> 18–30	-0,065/-0,195	> 18–30	0/0,013

beyond

RUDC.. • With Neck • Metric

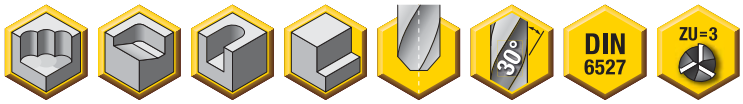


● first choice
○ alternate choice

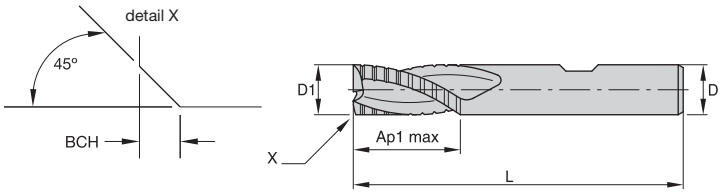
KCPM15	D1	D	D3	Ap1 max	L3	length L	BCH	Z U
RUDC0400B3BN	4,00	6,00	3,60	8,00	21,00	57,00	0,30	3
RUDC0500B3BN	5,00	6,00	4,60	13,00	21,00	57,00	0,30	3
RUDC0600B3BN	6,00	6,00	5,50	13,00	21,00	57,00	0,30	3
RUDC0800B3BN	8,00	8,00	7,50	16,00	27,00	63,00	0,30	3
RUDC1000B4BN	10,00	10,00	9,50	22,00	32,00	72,00	0,50	4
RUDC1200B4BN	12,00	12,00	11,00	26,00	38,00	83,00	0,50	4
RUDC1400B4BN	14,00	14,00	13,00	26,00	38,00	83,00	0,50	4
RUDC1600B4BN	16,00	16,00	15,00	32,00	44,00	92,00	0,50	4
RUDC1800B4BN	18,00	18,00	17,00	32,00	44,00	92,00	0,50	4
RUDC2000B4BN	20,00	20,00	19,00	38,00	54,00	104,00	0,50	4
RUDC2500B5BN	25,00	25,00	24,00	45,00	65,00	121,00	0,50	5

NOTE: For application data, see page P86.

- Centre cutting.
- Flat shallow profile.





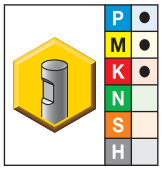


End Mill Tolerances

D1	tolerance h11	D	tolerance h6
≤3	+0/-0,060	≤3	+0/-0,006
>3–6	+0/-0,075	>3–6	+0/-0,008
>6–10	+0/-0,090	>6–10	+0/-0,009
>10–18	+0/-0,110	>10–18	+0/-0,011
>18–30	+0/-0,130	>18–30	+0/-0,013

beyond

F3BH...DL • DIN 6527 • Long • Metric

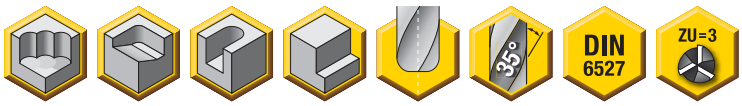


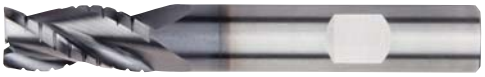
● first choice
○ alternate choice

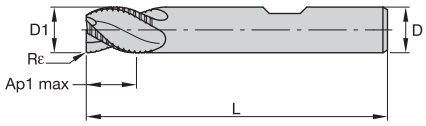
KCPM15	D1	D	Ap1 max	L	BCH
F3BH0400BDL30	4,00	6,00	8,00	57,00	0,10
F3BH0500BDL30	5,00	6,00	13,00	57,00	0,10
F3BH0600BDL30	6,00	6,00	10,00	57,00	0,10
F3BH0800BDL30	8,00	8,00	16,00	63,00	0,20
F3BH1000BDL30	10,00	10,00	19,00	72,00	0,30
F3BH1200BDL30	12,00	12,00	22,00	83,00	0,30
F3BH1600BDL30	16,00	16,00	26,00	92,00	0,40
F3BH2000BDL30	20,00	20,00	32,00	104,00	0,40
F3BH2500BDL30	25,00	25,00	45,00	121,00	0,40

NOTE: For application data, see page P86.

- Centre cutting.
- Chipbreaker profile.





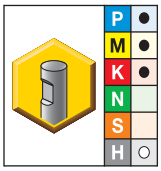


End Mill Tolerances

D1	tolerance d11	D	tolerance h6
≤ 3	-0,020/-0,080	≤ 3	+0/-0,006
> 3–6	-0,030/-0,105	> 3–6	+0/-0,008
> 6–10	-0,040/-0,130	> 6–10	+0/-0,009
> 10–18	-0,050/-0,160	> 10–18	+0/-0,011
> 18–30	-0,065/-0,195	> 18–30	+0/-0,013

beyond

F3BS...DK-DL • DIN 6527 • Short • Long • Metric

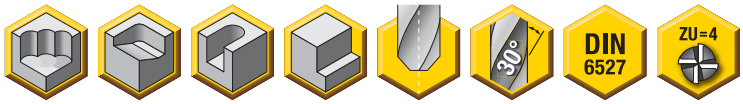


● first choice
○ alternate choice

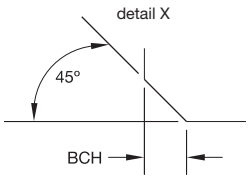
KCPM15	D1	D	Ap1 max	L	Rε
F3BS0600BDK35 *	6,00	6,00	7,00	57,00	0,45
F3BS0600BDL35	6,00	6,00	10,00	57,00	0,45
F3BS0800BDK35	8,00	8,00	9,00	58,00	0,45
F3BS0800BDL35	8,00	8,00	16,00	63,00	0,45
F3BS1000BDK35	10,00	10,00	11,00	66,00	0,45
F3BS1000BDL35	10,00	10,00	19,00	72,00	0,45
F3BS1200BDK35	12,00	12,00	12,00	73,00	0,45
F3BS1200BDL35	12,00	12,00	22,00	83,00	0,45
F3BS1400BDL35	14,00	14,00	22,00	83,00	0,45
F3BS1600BDK35	16,00	16,00	16,00	82,00	0,45
F3BS1600BDL35	16,00	16,00	32,00	92,00	0,45
F3BS2000BDK35	20,00	20,00	20,00	92,00	0,45
F3BS2000BDL35	20,00	20,00	38,00	104,00	0,45

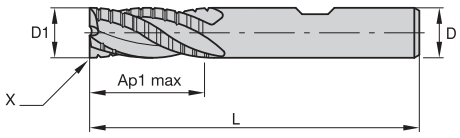
NOTE: For application data, see page P87.
*Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

- Centre cutting.
- Chipbreaker profile.







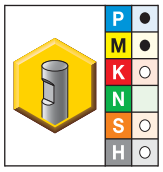


End Mill Tolerances

D1	tolerance h11	D	tolerance h6
≤ 3	+0/-0,060	≤ 3	+0/-0,006
> 3–6	+0/-0,075	> 3–6	+0/-0,008
> 6–10	+0/-0,090	> 6–10	+0/-0,009
> 10–18	+0/-0,110	> 10–18	+0/-0,011
> 18–30	+0/-0,130	> 18–30	+0/-0,013

beyond

F4BJ...DL • DIN 6527 • Long • Metric



● first choice
○ alternate choice

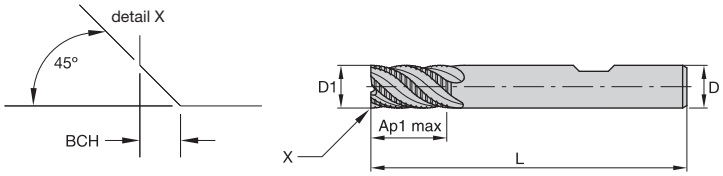
KCPM15	D1	D	Ap1 max	L	BCH
F4BJ0600BDL30	6,00	6,00	13,00	57,00	0,10
F4BJ0800BDL30	8,00	8,00	19,00	63,00	0,20
F4BJ1000BDL30	10,00	10,00	22,00	72,00	0,30
F4BJ1200BDL30	12,00	12,00	26,00	83,00	0,30
F4BJ1400BDL30	14,00	14,00	26,00	83,00	0,30
F4BJ1600BDL30	16,00	16,00	32,00	92,00	0,40
F4BJ1800BDL30	18,00	18,00	32,00	92,00	0,40
F4BJ2000BDL30	20,00	20,00	38,00	104,00	0,40

NOTE: For application data, see page P87.

- Centre cutting.
- Flat shallow profile.





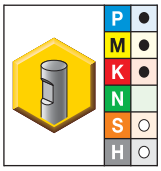


End Mill Tolerances

D1	tolerance h11	D	tolerance h6
≤ 3	+0/-0,060	≤ 3	+0/-0,006
> 3–6	+0/-0,075	> 3–6	+0/-0,008
> 6–10	+0/-0,090	> 6–10	+0/-0,009
> 10–18	+0/-0,110	> 10–18	+0/-0,011
> 18–30	+0/-0,130	> 18–30	+0/-0,013

beyond

F4BJ-F6BJ...DL • DIN 6527 • Long • Metric



● first choice
○ alternate choice

KCPM15	D1	D	Ap1 max	L	BCH	Z U
F4BJ0600BDL45	6,00	6,00	13,00	57,00	0,10	4
F4BJ0800BDL45	8,00	8,00	19,00	63,00	0,20	4
F4BJ1000BDL45	10,00	10,00	22,00	72,00	0,30	4
F4BJ1200BDL45	12,00	12,00	26,00	83,00	0,30	4
F6BJ1600BDL45	16,00	16,00	32,00	92,00	0,40	6
F6BJ2000BDL45	20,00	20,00	38,00	104,00	0,40	6
F6BJ2500BDL45	25,00	25,00	45,00	121,00	0,40	6

NOTE: For application data, see page P88.

F3BH-F4BJ-F5BJ...WS-WM-WL-WX



Material Group		Side Milling (A) and Slotting (B)			KCPM15		Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 20%.										
		A		B	Cutting Speed — vc m/min			D1 — Diameter									
		ap	ae	ap	min	max	mm	4,0	5,0	6,0	8,0	10,0	12,0	14,0	16,0	18,0	20,0	25,0
P	0	1,5 x D	0,5 x D	1 x D	150	200	fz	0,024	0,031	0,037	0,051	0,061	0,070	0,079	0,086	0,092	0,097	0,105
	1	1,5 x D	0,5 x D	1 x D	150	200	fz	0,024	0,031	0,037	0,051	0,061	0,070	0,079	0,086	0,092	0,097	0,105
	2	1,5 x D	0,5 x D	1 x D	140	190	fz	0,024	0,031	0,037	0,051	0,061	0,070	0,079	0,086	0,092	0,097	0,105
	3	1,5 x D	0,4 x D	0,75 x D	120	160	fz	0,020	0,025	0,031	0,043	0,051	0,060	0,067	0,074	0,080	0,086	0,097
	4	1,5 x D	0,3 x D	0,3 x D	90	150	fz	0,018	0,023	0,028	0,038	0,046	0,053	0,060	0,065	0,070	0,075	0,083
	5	1,5 x D	0,4 x D	0,75 x D	60	100	fz	0,016	0,021	0,025	0,034	0,041	0,048	0,054	0,059	0,064	0,069	0,077
M	1	1,5 x D	0,4 x D	0,75 x D	90	115	fz	0,020	0,025	0,031	0,043	0,051	0,060	0,067	0,074	0,080	0,086	0,097
	2	1,5 x D	0,4 x D	0,75 x D	60	80	fz	0,016	0,021	0,025	0,034	0,041	0,048	0,054	0,059	0,064	0,069	0,077
	3	1,5 x D	0,4 x D	0,75 x D	60	70	fz	0,014	0,017	0,021	0,029	0,034	0,040	0,044	0,048	0,052	0,055	0,060
K	1	1,5 x D	0,5 x D	1 x D	120	150	fz	0,024	0,031	0,037	0,051	0,061	0,070	0,079	0,086	0,092	0,097	0,105
	2	1,5 x D	0,4 x D	1 x D	110	140	fz	0,020	0,025	0,031	0,043	0,051	0,060	0,067	0,074	0,080	0,086	0,097
	3	1,5 x D	0,4 x D	1 x D	110	130	fz	0,016	0,021	0,025	0,034	0,041	0,048	0,054	0,059	0,064	0,069	0,077
H	1	1,5 x D	0,3 x D	0,3 x D	80	140	fz	0,018	0,023	0,028	0,038	0,046	0,053	0,060	0,065	0,070	0,075	0,083

NOTE: Those guidelines may require variations to achieve optimum results.
Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters accordingly on >12mm diameter.

F3BH-F4BJ...WS-WM-WL-WX • Internal Coolant



Material Group		Side Milling (A) and Slotting (B)			KCPM15		Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 20%.								
		A		B	Cutting Speed — vc m/min			D1 — Diameter							
		ap	ae	ap	min	max	mm	8,0	10,0	12,0	14,0	16,0	18,0	20,0	25,0
P	0	1,5 x D	0,5 x D	1 x D	150	200	fz	0,051	0,061	0,070	0,079	0,086	0,092	0,097	0,105
	1	1,5 x D	0,5 x D	1 x D	150	200	fz	0,051	0,061	0,070	0,079	0,086	0,092	0,097	0,105
	2	1,5 x D	0,5 x D	1 x D	140	190	fz	0,051	0,061	0,070	0,079	0,086	0,092	0,097	0,105
	3	1,5 x D	0,4 x D	0,75 x D	120	160	fz	0,043	0,051	0,060	0,067	0,074	0,080	0,086	0,097
	4	1,5 x D	0,3 x D	0,3 x D	90	150	fz	0,038	0,046	0,053	0,060	0,065	0,070	0,075	0,083
	5	1,5 x D	0,4 x D	0,75 x D	60	100	fz	0,034	0,041	0,048	0,054	0,059	0,064	0,069	0,077
M	1	1,5 x D	0,4 x D	0,75 x D	90	115	fz	0,043	0,051	0,060	0,067	0,074	0,080	0,086	0,097
	2	1,5 x D	0,4 x D	0,75 x D	60	80	fz	0,034	0,041	0,048	0,054	0,059	0,064	0,069	0,077
	3	1,5 x D	0,4 x D	0,75 x D	60	70	fz	0,029	0,034	0,040	0,044	0,048	0,052	0,055	0,060
K	1	1,5 x D	0,5 x D	1 x D	120	150	fz	0,051	0,061	0,070	0,079	0,086	0,092	0,097	0,105
	2	1,5 x D	0,4 x D	1 x D	110	140	fz	0,043	0,051	0,060	0,067	0,074	0,080	0,086	0,097
	3	1,5 x D	0,4 x D	1 x D	110	130	fz	0,034	0,041	0,048	0,054	0,059	0,064	0,069	0,077
H	1	1,5 x D	0,3 x D	0,3 x D	80	140	fz	0,038	0,046	0,053	0,060	0,065	0,070	0,075	0,083

NOTE: Those guidelines may require variations to achieve optimum results.
Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters accordingly on >12mm diameter.

RUDC.. • With Neck • Metric



Material Group		Side Milling (A) and Slotting (B)			KCPM15		Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 10%.										
		A		B	Cutting Speed — vc m/min			D1 — Diameter									
		ap	ae	ap	min	max	mm	4,0	5,0	6,0	8,0	10,0	12,0	14,0	16,0	18,0	20,0	25,0
P	0	1,5 x D	0,5 x D	1 x D	150	200	fz	0,024	0,031	0,037	0,051	0,061	0,070	0,079	0,086	0,092	0,097	0,105
	1	1,5 x D	0,5 x D	1 x D	150	200	fz	0,024	0,031	0,037	0,051	0,061	0,070	0,079	0,086	0,092	0,097	0,105
	2	1,5 x D	0,5 x D	1 x D	140	190	fz	0,024	0,031	0,037	0,051	0,061	0,070	0,079	0,086	0,092	0,097	0,105
	3	1,5 x D	0,4 x D	0,75 x D	120	160	fz	0,020	0,025	0,031	0,043	0,051	0,060	0,067	0,074	0,080	0,086	0,097
	4	1,5 x D	0,3 x D	0,3 x D	90	150	fz	0,018	0,023	0,028	0,038	0,046	0,053	0,060	0,065	0,070	0,075	0,083
	5	1,5 x D	0,4 x D	0,75 x D	60	100	fz	0,016	0,021	0,025	0,034	0,041	0,048	0,054	0,059	0,064	0,069	0,077
M	1	1,5 x D	0,4 x D	0,75 x D	90	115	fz	0,020	0,025	0,031	0,043	0,051	0,060	0,067	0,074	0,080	0,086	0,097
	2	1,5 x D	0,4 x D	0,75 x D	60	80	fz	0,016	0,021	0,025	0,034	0,041	0,048	0,054	0,059	0,064	0,069	0,077
	3	1,5 x D	0,4 x D	0,75 x D	60	70	fz	0,014	0,017	0,021	0,029	0,034	0,040	0,044	0,048	0,052	0,055	0,060
K	1	1,5 x D	0,5 x D	1 x D	120	150	fz	0,024	0,031	0,037	0,051	0,061	0,070	0,079	0,086	0,092	0,097	0,105
	2	1,5 x D	0,4 x D	1 x D	110	140	fz	0,020	0,025	0,031	0,043	0,051	0,060	0,067	0,074	0,080	0,086	0,097
	3	1,5 x D	0,4 x D	1 x D	110	130	fz	0,016	0,021	0,025	0,034	0,041	0,048	0,054	0,059	0,064	0,069	0,077
S	1	1,5 x D	0,4 x D	0,75 x D	50	90	fz	0,020	0,025	0,031	0,043	0,051	0,060	0,067	0,074	0,080	0,086	0,097
	3	1,5 x D	0,3 x D	0,3 x D	25	40	fz	0,011	0,014	0,017	0,022	0,027	0,032	0,036	0,039	0,043	0,046	0,052
H	1	1,5 x D	0,3 x D	0,3 x D	80	140	fz	0,018	0,023	0,028	0,038	0,046	0,053	0,060	0,065	0,070	0,075	0,083

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters accordingly on >12mm diameter.

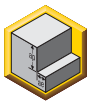
F3BH...DL • DIN 6527 • Long



Material Group		Side Milling (A) and Slotting (B)			KCPM15		Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 10%.							
		A		B	Cutting Speed — vc m/min			D1 — Diameter						
		ap	ae	ap	min	max	mm	4,0	6,0	8,0	10,0	12,0	16,0	20,0
P	1	1 x D	0,4 x D	0,75 x D	150	200	fz	0,028	0,044	0,060	0,072	0,083	0,101	0,114
	2	1 x D	0,4 x D	0,75 x D	140	190	fz	0,028	0,044	0,060	0,072	0,083	0,101	0,114
	3	1 x D	0,4 x D	0,75 x D	120	160	fz	0,023	0,036	0,050	0,061	0,070	0,087	0,101
	4	1 x D	0,3 x D	0,3 x D	90	150	fz	0,021	0,033	0,045	0,054	0,062	0,077	0,088
	5	1 x D	0,4 x D	0,75 x D	60	100	fz	0,019	0,029	0,040	0,048	0,056	0,070	0,081
	6	1 x D	0,3 x D	0,3 x D	50	75	fz	0,016	0,025	0,034	0,040	0,047	0,057	0,065
M	1	1 x D	0,4 x D	0,75 x D	80	100	fz	0,023	0,036	0,050	0,061	0,070	0,087	0,101
	2	1 x D	0,4 x D	0,75 x D	60	80	fz	0,019	0,029	0,040	0,048	0,056	0,070	0,081
	3	1 x D	0,4 x D	0,75 x D	60	80	fz	0,016	0,025	0,034	0,040	0,047	0,057	0,065
K	1	1 x D	0,4 x D	0,75 x D	120	160	fz	0,028	0,044	0,060	0,072	0,083	0,101	0,114
	2	1 x D	0,4 x D	0,75 x D	110	140	fz	0,023	0,036	0,050	0,061	0,070	0,087	0,101
	3	1 x D	0,4 x D	0,75 x D	100	130	fz	0,019	0,029	0,040	0,048	0,056	0,070	0,081

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters accordingly on >12mm diameter.

F3BS...DK-DL • DIN 6527 • Short • Long • Metric





Material Group		Side Milling (A) and Slotting (B)			KCPM15		Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 20%.						
		A		B	Cutting Speed — vc m/min			D1 — Diameter					
		ap	ae	ap	min	max	mm	6,0	8,0	10,0	12,0	16,0	20,0
P	1	1 x D	0,4 x D	0,75 x D	150	200	fz	0,044	0,060	0,072	0,083	0,101	0,114
	2	1 x D	0,4 x D	0,75 x D	140	190	fz	0,044	0,060	0,072	0,083	0,101	0,114
	3	1 x D	0,4 x D	0,75 x D	120	160	fz	0,036	0,050	0,061	0,070	0,087	0,101
	4	1 x D	0,3 x D	0,3 x D	90	150	fz	0,033	0,045	0,054	0,062	0,077	0,088
	5	1 x D	0,4 x D	0,75 x D	60	100	fz	0,029	0,040	0,048	0,056	0,070	0,081
	6	1 x D	0,3 x D	0,3 x D	50	75	fz	0,025	0,034	0,040	0,047	0,057	0,065
M	1	1 x D	0,4 x D	0,75 x D	80	100	fz	0,036	0,050	0,061	0,070	0,087	0,101
	2	1 x D	0,4 x D	0,75 x D	60	80	fz	0,029	0,040	0,048	0,056	0,070	0,081
	3	1 x D	0,4 x D	0,75 x D	60	80	fz	0,025	0,034	0,040	0,047	0,057	0,065
K	1	1 x D	0,4 x D	0,75 x D	120	160	fz	0,044	0,060	0,072	0,083	0,101	0,114
	2	1 x D	0,4 x D	0,75 x D	110	140	fz	0,036	0,050	0,061	0,070	0,087	0,101
	3	1 x D	0,4 x D	0,75 x D	100	130	fz	0,029	0,040	0,048	0,056	0,070	0,081
H	1	1 x D	0,3 x D	0,3 x D	100	140	fz	0,033	0,045	0,054	0,062	0,077	0,088

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters accordingly on >12mm diameter.

F4BJ...DL • DIN 6527 • Long





Material Group		Side Milling (A) and Slotting (B)			KCPM15		Feed per Tooth — fz information is for side milling (A). For slotting (B), reduce fz by 20%.							
		A		B	Cutting Speed — vc m/min			D1 — Diameter						
		ap	ae	ap	min	max	mm	4,0	5,0	6,0	8,0	10,0	12,0	16,0	20,0
P	3	0,8 x D	0,5 x D	0,75 x D	160	180	fz	0,020	0,025	0,031	0,043	0,051	0,063	0,078	0,101
	4	0,8 x D	0,4 x D	0,5 x D	140	160	fz	0,018	0,023	0,028	0,038	0,046	0,056	0,069	0,088
	5	0,8 x D	0,5 x D	0,75 x D	60	100	fz	0,016	0,021	0,025	0,034	0,041	0,051	0,063	0,081
	6	0,8 x D	0,4 x D	0,5 x D	50	80	fz	0,014	0,017	0,021	0,029	0,034	0,042	0,051	0,065
M	1	0,8 x D	0,5 x D	0,75 x D	80	100	fz	0,020	0,025	0,031	0,043	0,051	0,063	0,078	0,101
	2	0,8 x D	0,4 x D	0,75 x D	60	80	fz	0,016	0,021	0,025	0,034	0,041	0,051	0,063	0,081
	3	0,8 x D	0,4 x D	0,75 x D	60	80	fz	0,014	0,017	0,021	0,029	0,034	0,042	0,051	0,065
K	1	0,8 x D	0,5 x D	0,75 x D	120	160	fz	0,024	0,031	0,037	0,051	0,061	0,075	0,091	0,114
	2	0,8 x D	0,5 x D	0,75 x D	110	140	fz	0,020	0,025	0,031	0,043	0,051	0,063	0,078	0,101
	3	0,8 x D	0,4 x D	0,75 x D	100	130	fz	0,016	0,021	0,025	0,034	0,041	0,051	0,063	0,081
S	1	0,8 x D	0,4 x D	0,75 x D	90	115	fz	0,020	0,025	0,031	0,043	0,051	0,063	0,078	0,101
	2	0,8 x D	0,25 x D	0,3 x D	20	40	fz	0,011	0,014	0,017	0,022	0,027	0,033	0,042	0,054
	3	0,8 x D	0,4 x D	0,75 x D	50	80	fz	0,016	0,021	0,025	0,034	0,041	0,051	0,063	0,081
	4	0,8 x D	0,3 x D	0,5 x D	45	65	fz	0,013	0,018	0,022	0,031	0,038	0,046	0,058	0,074
H	1	0,8 x D	0,5 x D	0,5 x D	120	140	fz	0,018	0,023	0,028	0,038	0,046	0,056	0,069	0,088
	2	0,8 x D	0,2 x D	0,3 x D	80	130	fz	0,014	0,017	0,021	0,029	0,034	0,042	0,051	0,065
	3	0,8 x D	0,15 x D	0,2 x D	70	100	fz	0,011	0,014	0,017	0,023	0,027	0,034	0,041	0,052

NOTE: Thoes guidelines may require possible variations to achieve optimum results.
Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
For rougher tool with six flutes, use ap in slotting 60% of table value.
Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters accordingly on >12mm diameter.

F4BJ-F6BJ...DL • DIN 6527 • Long • Metric



Material Group		Side Milling (A) and Slotting (B)			KCPM15		Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 20%.						
		A		B	Cutting Speed — vc m/min			D1 — Diameter						
		ap	ae	ap	min	max	mm	6,0	8,0	10,0	12,0	16,0	20,0	25,0
P	3	1,0 x D	0,5 x D	0,75 x D	120	160	fz	0,036	0,050	0,061	0,070	0,087	0,101	0,114
	4	1,0 x D	0,3 x D	0,75 x D	90	150	fz	0,033	0,045	0,054	0,062	0,077	0,088	0,098
	5	1,0 x D	0,5 x D	0,75 x D	60	100	fz	0,029	0,040	0,048	0,056	0,070	0,081	0,091
	6	1,0 x D	0,3 x D	0,3 x D	50	75	fz	0,025	0,034	0,040	0,047	0,057	0,065	0,071
M	1	1,0 x D	0,5 x D	0,75 x D	80	100	fz	0,036	0,050	0,061	0,070	0,087	0,101	0,114
	2	1,0 x D	0,5 x D	0,75 x D	60	80	fz	0,029	0,040	0,048	0,056	0,070	0,081	0,091
	3	1,0 x D	0,5 x D	0,75 x D	60	80	fz	0,025	0,034	0,040	0,047	0,057	0,065	0,071
K	1	1,0 x D	0,5 x D	1 x D	120	160	fz	0,044	0,060	0,072	0,083	0,101	0,114	0,124
	2	1,0 x D	0,5 x D	1 x D	110	140	fz	0,036	0,050	0,061	0,070	0,087	0,101	0,114
	3	1,0 x D	0,5 x D	1 x D	100	130	fz	0,029	0,040	0,048	0,056	0,070	0,081	0,091
S	1	1,0 x D	0,3 x D	0,75 x D	50	90	fz	0,036	0,050	0,061	0,070	0,087	0,101	0,114
	2	1,0 x D	0,3 x D	0,75 x D	50	90	fz	0,019	0,026	0,032	0,037	0,046	0,054	0,061
	3	1,0 x D	0,3 x D	0,75 x D	20	40	fz	0,019	0,026	0,032	0,037	0,046	0,054	0,061
	4	1,0 x D	0,4 x D	0,75 x D	45	65	fz	0,026	0,037	0,045	0,052	0,064	0,074	0,084
H	1	1,0 x D	0,3 x D	0,3 x D	80	140	fz	0,033	0,045	0,054	0,062	0,077	0,088	0,098
	2	1,0 x D	0,2 x D	0,2 x D	70	120	fz	0,025	0,034	0,040	0,047	0,057	0,065	0,071
	3	1,0 x D	0,2 x D	0,2 x D	60	90	fz	0,019	0,026	0,032	0,037	0,046	0,054	0,061

NOTE: Those guidelines may require variations to achieve optimum results.
Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters accordingly on >12mm diameter.
For rougher tool with 6 flutes, use Ap in slotting 60% of table value.

The Economical Milling Cutter Line

GOmill™

The GOmill line is specifically engineered to work on short length-of-cut applications in multiple workpiece materials, like soft and hard steels up to 48 HRC, stainless steels, high-temperature alloys, and cast iron. With the very short overall length and soft cutting geometries, the line is made to conform to the growing market of mill-turn machines.

What does this mean for you?

- Unequal flute spacing.
- AlTiN coating.
- Short overall tool length.
- Positive rake angle.
- Better surface finish and tool life.
- Universal usage on multiple workpiece materials.
- Higher cutting conditions, higher productivity, lower price due to less carbide.
- Lower power consumption.



Visit **kennametal.com** or contact your local Authorised Kennametal Distributor.

KENNAMETAL®

kennametal.com

RSM II

Multi-Flute End Mills

Primary Application

RSM II offers the highest productivity in machining aerospace structural components in titanium and titanium alloys. These end mills are designed to utilise high-speed peel milling strategies with secure chip formation and evacuation in deep cavities. RSM II is available with the Safe-Lock™ system by HAIMER®.

- Excellent metal removal rates.
- Highest surface quality.
- Unmatched tool life and wear resistance using grade KC643M™.
- Highest process security.

Features and Benefits

Advanced Technology

- Maximum number of flutes for increased feed rates and less vibration tendency.
- Proprietary W-shaped flute form improves chip formation and reduces cutting forces.
- Unequal flute spacing increases tool life and surface quality.
- Proprietary AlTiN KC643M grade for increased tool life.

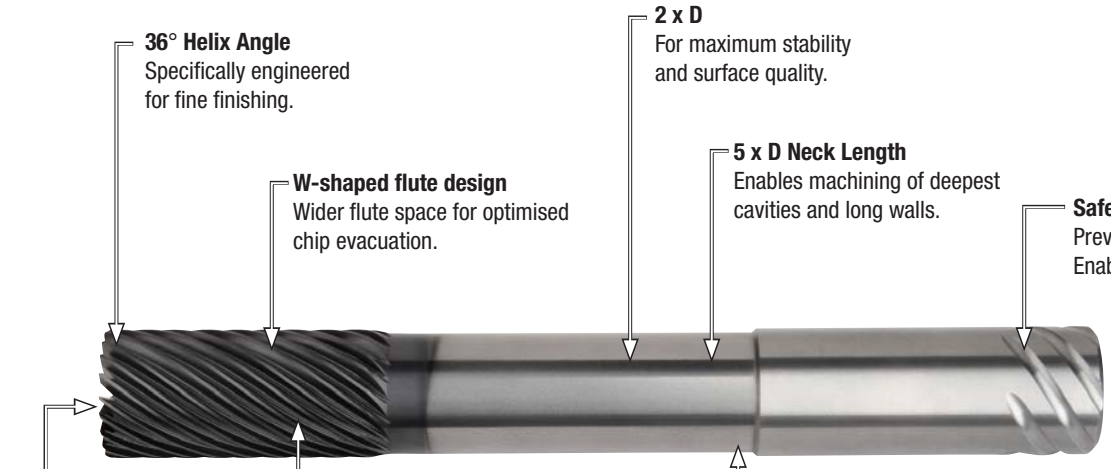
Customisation

- Custom overall length and length of cut.
- Different radii per diameter.
- Custom shank styles.
- Tapered versions available.
- Uncoated K600™ grade for milling critical-to-fly components.

Extensive Standard Offering

- Each diameter has an optimised number of flutes for constant edge-to-flute space ratio.
- Different radii per diameter.
- Safe-Lock™ and round shank.





36° Helix Angle
Specifically engineered for fine finishing.

W-shaped flute design
Wider flute space for optimised chip evacuation.

2 x D
For maximum stability and surface quality.

5 x D Neck Length
Enables machining of deepest cavities and long walls.

Safe-Lock™ Shank
Prevents end mill pullout. Enables higher feed rates.

SAFE-λOCK® by HAIMER®

Internal Coolant
Increases tool life and flushes out chips in deep cavities.

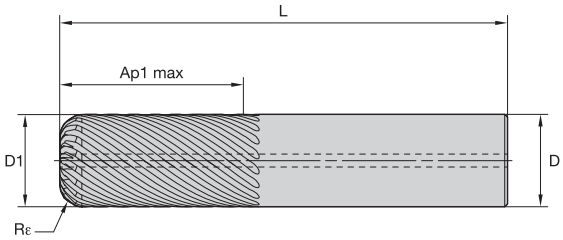
Eccentric Relief Grind
Improves edge stability and enables higher feed rates.

KC643M™ grade
Unmatched fine finishing and tool life results.

K600 Uncoated Grade
Addresses critical-to-fly applications for uncoated tools

- Kennametal standard dimensions.
- Non-centre cutting.
- Optimised geometry for titanium machining.
- Unequal flute spacing minimises chatter for smoother machining.



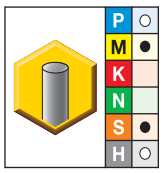




End Mill Tolerances

D1	tolerance e8	D	tolerance h6 + / -
≤3	-0,014/-0,028	≤3	+0/-0,006
>3–6	-0,020/-0,038	>3–6	+0/-0,008
>6–10	-0,025/-0,047	>6–10	+0/-0,009
>10–18	-0,032/-0,059	>10–18	+0/-0,011
>18–30	-0,040/-0,073	>18–30	+0/-0,013

FSDE.. • Multi-Flute • Short • Metric

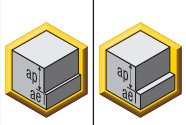


● first choice
○ alternate choice

KC643M	D1	D	Ap1 max	L	Rε	Z U
FSDE1000A9BCE	10,00	10,00	20,00	72,00	0,50	9
FSDE1000A9BCG	10,00	10,00	20,00	72,00	1,00	9
FSDE1200A9BCE	12,00	12,00	24,00	83,00	0,50	9
FSDE1200A9BCG	12,00	12,00	24,00	83,00	1,00	9
FSDE1200A9BCL	12,00	12,00	24,00	83,00	2,50	9
FSDE1200A9BCN	12,00	12,00	24,00	83,00	4,00	9
FSDE1600ABBCG	16,00	16,00	32,00	92,00	1,00	11
FSDE1600ABBCL	16,00	16,00	32,00	92,00	2,50	11
FSDE1600ABBCM	16,00	16,00	32,00	92,00	3,00	11
FSDE1600ABBCN	16,00	16,00	32,00	92,00	4,00	11
FSDE1600ABBCP	16,00	16,00	32,00	92,00	6,00	11
FSDE2000AFBCG	20,00	20,00	40,00	104,00	1,00	15
FSDE2000AFBCK	20,00	20,00	40,00	104,00	2,00	15
FSDE2000AFBCL	20,00	20,00	40,00	104,00	2,50	15
FSDE2000AFBCN	20,00	20,00	40,00	104,00	4,00	15
FSDE2000AFBCP	20,00	20,00	40,00	104,00	6,00	15
FSDE2500AJBCG	25,00	25,00	50,00	121,00	1,00	19
FSDE2500AJBCL	25,00	25,00	50,00	121,00	2,50	19
FSDE2500AJBCP	25,00	25,00	50,00	121,00	6,00	19

NOTE: For application data, please see page P93.

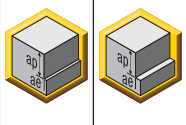
FSDE.. • Multi-Flute • Short • Metric • Roughing




Material Group		Side Milling (A)		KC643M			Recommended feed per tooth (fz = mm/th) for side milling (A).						
		A		Cutting Speed — vc m/min			D1 — Diameter						
		ap	ae	min		max	mm	6,0	8,0	10,0	12,0	16,0	20,0	25,0
P	4	Ap max	0,8–1,2	270	–	450	fz	0,076	0,084	0,090	0,097	0,112	0,130	0,146
	5	Ap max	0,8–1,2	180	–	300	fz	0,068	0,075	0,081	0,087	0,101	0,119	0,137
M	1	Ap max	0,8–1,2	270	–	345	fz	0,084	0,093	0,101	0,109	0,127	0,149	0,171
	2	Ap max	0,8–1,2	180	–	240	fz	0,068	0,075	0,081	0,087	0,101	0,119	0,137
	3	Ap max	0,8–1,2	180	–	210	fz	0,057	0,063	0,068	0,072	0,083	0,096	0,107
S	1	Ap max	0,8–1,2	150	–	270	fz	0,084	0,093	0,101	0,109	0,127	0,149	0,171
	2	Ap max	0,8–1,2	150	–	270	fz	0,045	0,049	0,053	0,058	0,067	0,080	0,092
	3	Ap max	0,8–1,2	75	–	120	fz	0,045	0,049	0,053	0,058	0,067	0,080	0,092
	4	Ap max	0,8–1,2	150	–	180	fz	0,059	0,069	0,074	0,080	0,093	0,110	0,125
H	1	Ap max	0,8–1,2	240	–	420	fz	0,076	0,084	0,090	0,097	0,112	0,130	0,146
	2	Ap max	0,8–1,2	210	–	360	fz	0,057	0,063	0,068	0,072	0,083	0,096	0,107

NOTE: For better surface finish, reduce feed per tooth.

FSDE.. • Multi-Flute • Short • Finishing

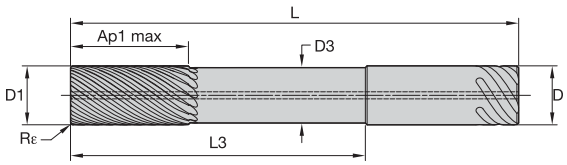



Material Group		Side Milling (A)		KC643M			Recommended feed per tooth (fz = mm/th) for side milling (A).						
		A		Cutting Speed — vc m/min			D1 — Diameter						
		ap	ae	min		max	mm	6,0	8,0	10,0	12,0	16,0	20,0	25,0
P	4	Ap max	0,2–0,3	135	–	495	fz	0,101	0,111	0,120	0,129	0,149	0,163	0,166
	5	Ap max	0,2–0,3	90	–	330	fz	0,091	0,099	0,108	0,116	0,135	0,150	0,155
M	1	Ap max	0,2–0,3	135	–	380	fz	0,112	0,124	0,135	0,145	0,169	0,187	0,193
	2	Ap max	0,2–0,3	90	–	264	fz	0,091	0,099	0,108	0,116	0,135	0,150	0,155
	3	Ap max	0,2–0,3	90	–	231	fz	0,076	0,084	0,090	0,096	0,110	0,120	0,121
S	1	Ap max	0,2–0,3	75	–	297	fz	0,112	0,124	0,135	0,145	0,169	0,187	0,193
	2	Ap max	0,2–0,3	38	–	132	fz	0,060	0,066	0,071	0,077	0,090	0,100	0,104
	3	Ap max	0,2–0,3	38	–	132	fz	0,060	0,066	0,071	0,077	0,090	0,100	0,104
	4	Ap max	0,2–0,3	75	–	198	fz	0,079	0,092	0,099	0,107	0,124	0,138	0,142
H	1	Ap max	0,2–0,3	120	–	462	fz	0,101	0,111	0,120	0,129	0,149	0,163	0,166
	2	Ap max	0,2–0,3	105	–	396	fz	0,076	0,084	0,090	0,096	0,110	0,120	0,121

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions.
For smaller taper machining centres, please adjust parameters accordingly on >12mm diameter.

- Kennametal standard dimensions.
- Non-centre cutting.
- Optimised geometry for titanium machining.
- Unequal flute spacing minimises chatter for smoother machining.
- Reach optimised for machining deep cavities.



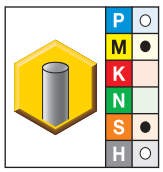


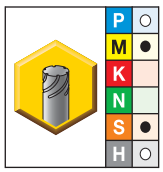


End Mill Tolerances

D1	tolerance e8	D	tolerance h6 + / -
≤3	-0,014/-0,028	≤3	+0/-0,006
>3–6	-0,020/-0,038	>3–6	+0/-0,008
>6–10	-0,025/-0,047	>6–10	+0/-0,009
>10–18	-0,032/-0,059	>10–18	+0/-0,011
>18–30	-0,040/-0,073	>18–30	+0/-0,013

FSDE.. • Multi-Flute with Neck • Metric





● first choice
○ alternate choice

KC643M	KC643M	D1	D	D3	Ap1 max	L3	L	Rε	Z U
FSDE0600A7DYA	–	6,00	6,00	5,64	12,00	30,00	76,00	0,20	7
FSDE0600A7DYE	–	6,00	6,00	5,64	12,00	30,00	76,00	0,50	7
FSDE0800A7DYA	–	8,00	8,00	7,52	16,00	40,00	87,00	0,20	7
FSDE0800A7DYE	–	8,00	8,00	7,52	16,00	40,00	87,00	0,50	7
FSDE1000A9DYE	–	10,00	10,00	9,40	20,00	50,00	100,00	0,50	9
FSDE1000A9DYG	–	10,00	10,00	9,40	20,00	50,00	100,00	1,00	9
–	**FSDE1200E9DYE**	12,00	12,00	11,28	24,00	60,00	125,00	0,50	9
–	**FSDE1200E9DYG**	12,00	12,00	11,28	24,00	60,00	125,00	1,00	9
–	**FSDE1200E9DYL**	12,00	12,00	11,28	24,00	60,00	125,00	2,50	9
–	**FSDE1600EBDYG**	16,00	16,00	15,04	32,00	80,00	141,00	1,00	11
–	**FSDE1600EBDYL**	16,00	16,00	15,04	32,00	80,00	141,00	2,50	11
–	**FSDE1600EBDYM**	16,00	16,00	15,04	32,00	80,00	141,00	3,00	11
–	**FSDE1600EBDYP**	16,00	16,00	15,04	32,00	80,00	141,00	6,00	11
–	**FSDE2000EFDYG**	20,00	20,00	18,80	40,00	100,00	166,00	1,00	15
–	**FSDE2000EFDYK**	20,00	20,00	18,80	40,00	100,00	166,00	2,00	15
–	**FSDE2000EFDYL**	20,00	20,00	18,80	40,00	100,00	166,00	2,50	15
–	**FSDE2000EFDYP**	20,00	20,00	18,80	40,00	100,00	166,00	6,00	15
–	**FSDE2500EJDYG**	25,00	25,00	23,50	50,00	125,00	190,00	1,00	19
–	**FSDE2500EJDYL**	25,00	25,00	23,50	50,00	125,00	190,00	2,50	19
–	**FSDE2500EJDYP**	25,00	25,00	23,50	50,00	125,00	190,00	6,00	19

NOTE: For application data, please see page P95.

FSDE.. • Multi-Flute with Neck





Material Group		Side Milling (A)		KC643M			Recommended feed per tooth (fz = mm/th) for side milling (A).							
		A		Cutting Speed — vc m/min			D1 — Diameter							
		ap	ae	min		max	mm	6,0	8,0	10,0	12,0	16,0	20,0	25,0
P	4	Ap max	0,2–0,3	135	–	495	fz	0,101	0,111	0,120	0,129	0,149	0,163	0,166
	5	Ap max	0,2–0,3	90	–	330	fz	0,091	0,099	0,108	0,116	0,135	0,150	0,155
M	1	Ap max	0,2–0,3	135	–	380	fz	0,112	0,124	0,135	0,145	0,169	0,187	0,193
	2	Ap max	0,2–0,3	90	–	264	fz	0,091	0,099	0,108	0,116	0,135	0,150	0,155
	3	Ap max	0,2–0,3	90	–	231	fz	0,076	0,084	0,090	0,096	0,110	0,120	0,121
S	1	Ap max	0,2–0,3	75	–	297	fz	0,112	0,124	0,135	0,145	0,169	0,187	0,193
	2	Ap max	0,2–0,3	75	–	297	fz	0,112	0,124	0,135	0,145	0,169	0,187	0,193
	3	Ap max	0,2–0,3	37,5	–	132	fz	0,060	0,066	0,071	0,077	0,090	0,100	0,104
	4	Ap max	0,2–0,3	75	–	198	fz	0,079	0,092	0,099	0,107	0,124	0,138	0,142
H	1	Ap max	0,2–0,3	120	–	462	fz	0,101	0,111	0,120	0,129	0,149	0,163	0,166
	2	Ap max	0,2–0,3	105	–	396	fz	0,076	0,084	0,090	0,096	0,110	0,120	0,121

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions.
For smaller taper machining centres, please adjust parameters accordingly on >12mm diameter.



FSDE 15-Flute End Mill

CHALLENGE

- Finishing contour milling on aerospace part with interrupted cut.
- Depth of cut: 40mm.
- Titanium alloy R56400.
- External emulsion.

SOLUTION

- RSM II multi-flute cutter with KC643M™.
- Ø 20mm with 15 effective cutting edges and 4mm radius.

CUTTING DATA

- vc 70 m/min
- fz 0,07 mm/Z
- ap 40mm
- ae 0,3mm

RESULT

- 3.75 times longer tool life compared to competitor solution.

BENEFIT

- Machining time reduction of 46%.
- Metal removal rate increase of 87%.

FSDE 11-Flute End Mill

CHALLENGE

- Finishing long channel on aerospace frame part.
- Depth of cut: 39mm.
- Titanium alloy.
- External emulsion.

SOLUTION

- RSM II multi-flute cutter with KC643M.
- Ø 15,875mm with 11 effective cutting edges and 0,762mm radius.

CUTTING DATA

- vc 130 m/min
- fz 0,05 mm/Z
- ap 39,37mm
- ae 0,03mm

RESULT

- 2.5 times higher feed rates compared to initial solution.

BENEFIT

- Machining time reduction of 60%.
- Metal removal rate increase of 150%.

(continued)

(continued)



FSDE 15-Flute End Mill

CHALLENGE

- Finishing external profile.
- Depth of cut: 20mm.
- Titanium alloy 6Al4V.
- External emulsion.

SOLUTION

- RSM II multi-flute cutter with KC643M™.
- Ø 20mm with 15 effective cutting edges and 4mm corner radius.

CUTTING DATA

- vc 150 m/min
- fz 0,06 mm/Z
- ap 20mm
- ae 0,6mm

RESULT

- 50% tool life increase.
- 3x cutting speed.
- Nearly 8x the feed rates.

BENEFIT

- Machining time reduction of 81% from 43.1–8.4 min vs competitor solution.
- Metal removal rate increase of 360% vs competitor solution.

FSDE 19-Flute End Mill

CHALLENGE

- Finishing external profile.
- Depth of cut: 20mm.
- Titanium alloy 6Al4V.
- External emulsion.

SOLUTION

- RSM II multi-flute cutter with KC643M.
- Ø 25mm with 19 effective cutting edges and 1mm corner radius.

CUTTING DATA

- vc 150 m/min
- fz 0,06 mm/Z
- ap 20mm
- ae 0,6mm

RESULT

- 50% tool life increase.
- 3x cutting speed.
- Nearly 8x the feed rates.

BENEFIT

- Machining time reduction of 81% from 43.1–8.3 min vs competitor solution.
- Metal removal rate increase of 366% vs competitor solution.

Materials to Cut	• Titanium and titanium alloys. • Nickel-based alloys. • Cobalt-based alloys. • Steels (P4–P5). • Stainless steels (M2–M3). • Hardened steels (H1).
Cutting Speed	• Refer to application data recommendation. • Highly dynamic machines recommended.
Feed Rate	• Refer to application data recommendation. • Highly dynamic machines recommended. • High-speed peel milling strategies require control of adequate feed rates.
Depth of Cut	• High-speed peel milling requires small depth of cut (approximately 5% of diameter) not exceeding 1mm.
Coolant	• Internal coolant for machining cavities. • External coolant for peripheral milling.
Adaptation	• Shrink Fit adaptation is preferred as alternate recommendation. • High-Performance Milling Chucks (HPMC) are applicable. • Collect chucks are not recommended due to high runout.
Roughing Application	• Not recommended.
Finishing Application	• Finishing and semi-finishing.
Milling Strategy	• Peel milling strategies are recommended. • Trochoidal milling is not recommended for this tool.
Applications	• Shoulder milling. • Shoulder milling and fine finishing. • Peel milling and HPC techniques. • Non-centre cutting. • No ramping and helical interpolation.
Corner Machining	• Pre-mill corner pocket to leave appropriate depth-of-cut for finishing application. • Use RSM with depth-of-cut at approximately 5% of diameter and below 1mm. • RSM II tool radius shall be smaller than final corner radius.
Engineered Solutions	• Available upon request.
Reconditioning Service	• Available with standard Kennametal reconditioning procedures. • Check services under Kennametal website for detailed information.

End Mills for High-Feed Milling

KenFeed™

Specifically engineered to machine hardened steel up to 65 HRC at extreme speeds and feeds.

FEATURES AND BENEFITS

- Unique tool with new 6-flute style for high productivity.
- Necked shanks provide extended reach in deep cavities.
- High-feed rates up to 0,6mm per tooth on a 20mm tool.
- Machine hardened materials at 2–3x the metal removal rate of competitive end mills.
- Wide range of cutting diameters: down to 6mm for small and medium pocket work.
- Innovative new geometry maximises metal removal rates.
- High metal removal rates lower manufacturing costs.



Visit **kennametal.com** or contact your local Authorised Kennametal Distributor.

KENNAMETAL®

kennametal.com

High-Performance Solid Carbide Finishing End Mills

Primary Application

High-performance finishing end mills can be used for a wide range of workpiece materials such as steel, stainless steel, cast titanium, high-temp alloys, and in certain cases, hard materials.

- High-performance tools for excellent surface quality and accuracy.
- Reduce harmonics for chatter-free machining.
- Different front and flute styles for a wide range of applications like open contour, contour milling, and pocketing, and milling long and thin walls.

Features and Benefits

Advanced Technology

- Various styles available to choose from for the right application and workpiece material.
- Designated platforms for aerospace, transportation, and general engineering requirements.
- Selective styles for machining up to 3 x D.

Tailored Grades

- Wide range of grades from uncoated to proprietary Beyond™ grades to cover a wide range of requirements.

Highest metal removal rates and surface finish.



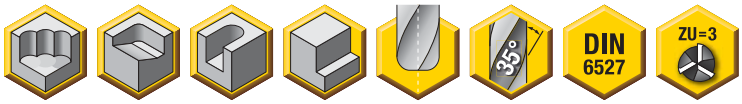
Customisation

- Intermediate diameters available.
- Expanded length of tool and increased length of cut are possible.
- Different radii available.

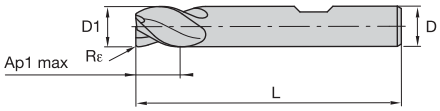
Standard Offering

- Diameter range 3–25mm.

• Centre cutting.





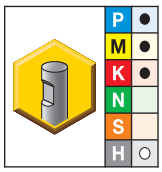


End Mill Tolerances

D1	tolerance e8	D	tolerance h6
≤3	-0,014/-0,028	≤3	+0/-0,006
>3–6	-0,020/-0,038	>3–6	+0/-0,008
>6–10	-0,025/-0,047	>6–10	+0/-0,009
>10–18	-0,032/-0,059	>10–18	+0/-0,011
>18–30	-0,040/-0,073	>18–30	+0/-0,013

beyond

F3AS...DK

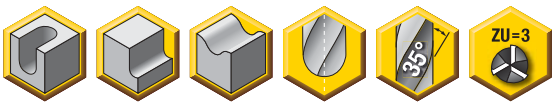


● first choice
○ alternate choice

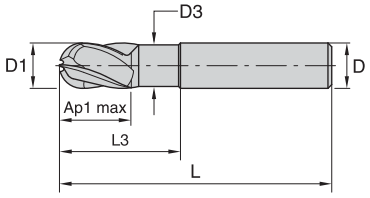
KCPM15	D1	D	Ap1 max	L	Rε
F3AS0300BDK35	3,00	6,00	4,00	50,00	0,25
F3AS0400BDK35	4,00	6,00	5,00	54,00	0,25
F3AS0500BDK35 *	5,00	6,00	6,00	54,00	0,25
F3AS0600BDK35	6,00	6,00	7,00	54,00	0,45
F3AS0800BDK35	8,00	8,00	9,00	58,00	0,45
F3AS1000BDK35	10,00	10,00	11,00	66,00	0,45
F3AS1200BDK35	12,00	12,00	12,00	73,00	0,45
F3AS1400BDK35	14,00	14,00	14,00	75,00	0,45
F3AS1600BDK35	16,00	16,00	16,00	82,00	0,45
F3AS2000BDK35	20,00	20,00	20,00	92,00	0,45

NOTE: For application data, see page P106.
*Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

- Kennametal standard dimensions.
- Centre cutting.





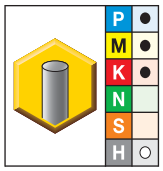


End Mill Tolerances

D1	tolerance e8	D	tolerance h6
All	+0/-0,03	≤3	+0/-0,006
		>3–6	+0/-0,008
		>6–10	+0/-0,009
		>10–18	+0/-0,011
		>18–30	+0/-0,013

beyond

F3AW...WL-WX • Extended Neck



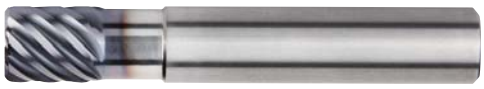
● first choice
○ alternate choice

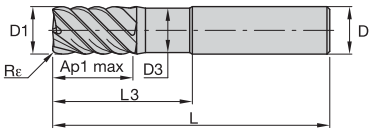
KCPM15	D1	D	D3	Ap1 max	L3	L
F3AW0600AWL35E120	6,00	6,00	5,80	6,00	12,00	76,00
F3AW0800AWL35E160	8,00	8,00	7,80	8,00	16,00	100,00
F3AW1000AWX35E200	10,00	10,00	9,50	10,00	20,00	121,50
F3AW1200AWX35E240 *	12,00	12,00	11,50	12,00	24,00	125,00
F3AW1600AWX35E320 *	16,00	16,00	15,00	16,00	32,00	150,00

NOTE: For application data, see page P106.
*Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

- Centre cutting.





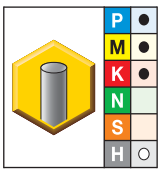


End Mill Tolerances

D1	tolerance e8	D	tolerance h6
≤3	-0,014/-0,028	≤3	+0/-0,006
>3–6	-0,020/-0,038	>3–6	+0/-0,008
>6–10	-0,025/-0,047	>6–10	+0/-0,009
>10–18	-0,032/-0,059	>10–18	+0/-0,011
>18–30	-0,040/-0,073	>18–30	+0/-0,013

beyond

F8AJ-F10AJ...DK • Extended Neck



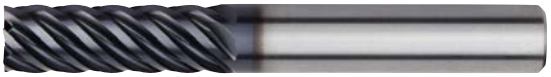
● first choice
○ alternate choice

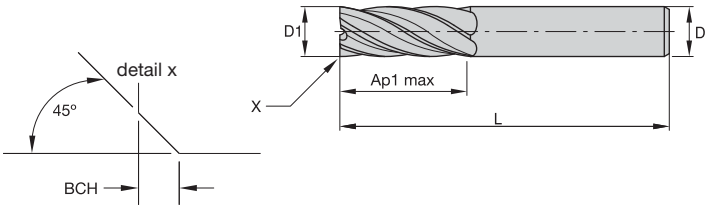
KCPM15	D1	D	D3	Ap1 max	L3	L	Rε	Z U
F8AJ0800ADK45E160	8,00	8,00	7,00	8,00	16,00	58,00	1,00	8
F8AJ1000ADK45E200	10,00	10,00	9,00	10,00	20,00	66,00	1,00	8
F8AJ1200ADK45E240	12,00	12,00	11,00	12,00	24,00	73,00	1,00	8
F10AJ1600ADK45E320	16,00	16,00	15,00	16,00	32,00	82,00	1,00	10
F10AJ2000ADK45E400	20,00	20,00	19,00	20,00	40,00	92,00	1,00	10

NOTE: For application data, see page P107.

- Non-centre cutting.





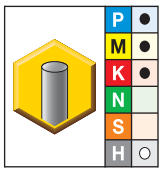


End Mill Tolerances

D1	tolerance e8	D	tolerance h6
≤3	-0,014/-0,028	≤3	+0/-0,006
>3–6	-0,020/-0,038	>3–6	+0/-0,008
>6–10	-0,025/-0,047	>6–10	+0/-0,009
>10–18	-0,032/-0,059	>10–18	+0/-0,011
>18–30	-0,040/-0,073	>18–30	+0/-0,013

beyond

F6AJ-F8AJ...DL • Multiflute • Long • Extra Long



● first choice
○ alternate choice

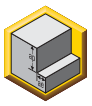
KCPM15	D1	D	Ap1 max	L	BCH	Z U
F6AJ0600ADL45	6,00	6,00	13,00	57,00	0,10	6
F6AJ0600AWM45	6,00	6,00	18,00	62,00	0,10	6
F6AJ0800ADL45	8,00	8,00	19,00	63,00	0,20	6
F6AJ0800AWM45	8,00	8,00	24,00	68,00	0,20	6
F6AJ1000ADL45	10,00	10,00	22,00	72,00	0,30	6
F6AJ1000AWL45	10,00	10,00	30,00	80,00	0,30	6
F6AJ1200ADL45	12,00	12,00	26,00	83,00	0,30	6
F6AJ1200AWL45	12,00	12,00	36,00	93,00	0,30	6
F6AJ1400ADL45	14,00	14,00	26,00	83,00	0,30	6
F6AJ1600ADL45	16,00	16,00	32,00	92,00	0,40	6
F6AJ1600AWX45	16,00	16,00	48,00	108,00	0,40	6
F8AJ2000AWX45	20,00	20,00	60,00	126,00	0,40	8
F8AJ2500AWX45	25,00	25,00	75,00	150,00	0,40	8

NOTE: For application data, see page P107.

Corner Chamfer (Chamfer height)

D1	BCH	Tolerance
2–6.75	0,10	-0,05
6.76–9.7	0,20	-0,10
9.71–15.7	0,30	-0,10
15.71–25	0,40	-0,20

F3AS...DK

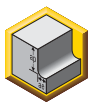




Material Group		Side Milling (A) and Slotting (B) A ap	A ae	B ap	KCPM15 Cutting Speed — vc m/min min	max	Feed per Tooth — fz information is for side milling (A). For slotting (B), reduce fz by 20%. mm	D1 — Diameter 3,0	4,0	6,0	8,0	10,0	12,0	16,0	20,0
P	1	0,75 x D	0,4 x D	0,5 x D	150	200	fz	0,021	0,028	0,044	0,060	0,072	0,083	0,101	0,114
	2	0,75 x D	0,4 x D	0,5 x D	140	190	fz	0,021	0,028	0,044	0,060	0,072	0,083	0,101	0,114
	3	0,75 x D	0,4 x D	0,5 x D	120	160	fz	0,018	0,023	0,036	0,050	0,061	0,070	0,087	0,101
	4	0,75 x D	0,4 x D	0,3 x D	90	150	fz	0,016	0,021	0,033	0,045	0,054	0,062	0,077	0,088
	5	0,75 x D	0,4 x D	0,5 x D	60	100	fz	0,014	0,019	0,029	0,040	0,048	0,056	0,070	0,081
	6	0,75 x D	0,4 x D	0,3 x D	50	75	fz	0,012	0,016	0,025	0,034	0,040	0,047	0,057	0,065
M	1	0,75 x D	0,4 x D	0,5 x D	80	100	fz	0,018	0,023	0,036	0,050	0,061	0,070	0,087	0,101
	2	0,75 x D	0,4 x D	0,5 x D	60	80	fz	0,014	0,019	0,029	0,040	0,048	0,056	0,070	0,081
	3	0,75 x D	0,4 x D	0,5 x D	60	80	fz	0,012	0,016	0,025	0,034	0,040	0,047	0,057	0,065
K	1	0,75 x D	0,4 x D	0,5 x D	120	160	fz	0,021	0,028	0,044	0,060	0,072	0,083	0,101	0,114
	2	0,75 x D	0,4 x D	0,5 x D	110	140	fz	0,018	0,023	0,036	0,050	0,061	0,070	0,087	0,101
	3	0,75 x D	0,4 x D	0,5 x D	100	130	fz	0,014	0,019	0,029	0,040	0,048	0,056	0,070	0,081
H	1	0,75 x D	0,4 x D	0,3 x D	100	140	fz	0,016	0,021	0,033	0,045	0,054	0,062	0,077	0,088

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters accordingly on >12mm diameter.

F3AW...WL-WX • Extended Neck

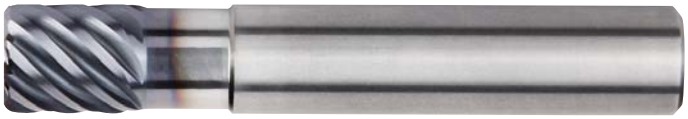




Material Group		Side Milling (A) and Slotting (B) A ap	A ae	B ap	KCPM15 Cutting Speed — vc m/min min	max	Feed per Tooth — fz information is for side milling (A). For slotting (B), reduce fz by 20%. mm	D1 — Diameter 3,0	5,0	6,0	8,0	10,0	12,0	16,0
P	1	1 x D	0,5 x D	1 x D	150	200	fz	0,022	0,036	0,044	0,060	0,072	0,083	0,101
	2	1 x D	0,5 x D	1 x D	140	190	fz	0,022	0,036	0,044	0,060	0,072	0,083	0,101
	3	1 x D	0,5 x D	1 x D	120	160	fz	0,018	0,030	0,036	0,050	0,061	0,070	0,087
	4	1 x D	0,5 x D	1 x D	90	150	fz	0,016	0,027	0,033	0,045	0,054	0,062	0,077
	5	1 x D	0,5 x D	1 x D	60	100	fz	0,015	0,024	0,029	0,040	0,048	0,056	0,070
	6	1 x D	0,5 x D	1 x D	50	75	fz	0,012	0,020	0,025	0,034	0,040	0,047	0,057
M	1	1 x D	0,5 x D	1 x D	80	100	fz	0,018	0,030	0,036	0,050	0,061	0,070	0,087
	2	1 x D	0,5 x D	1 x D	60	80	fz	0,015	0,024	0,029	0,040	0,048	0,056	0,070
	3	1 x D	0,5 x D	1 x D	60	80	fz	0,012	0,020	0,025	0,034	0,040	0,047	0,057
K	1	1 x D	0,5 x D	1 x D	120	160	fz	0,022	0,036	0,044	0,060	0,072	0,083	0,101
	2	1 x D	0,5 x D	1 x D	110	140	fz	0,018	0,030	0,036	0,050	0,061	0,070	0,087
	3	1 x D	0,5 x D	1 x D	100	130	fz	0,015	0,024	0,029	0,040	0,048	0,056	0,070
H	1	1 x D	0,5 x D	1 x D	100	140	fz	0,016	0,027	0,033	0,045	0,054	0,062	0,077

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters accordingly on >12mm diameter.

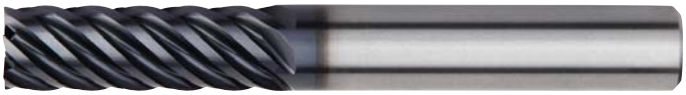
F8AJ-F10AJ...DK • Extended Neck



Material Group		Side Milling (A)		KCPM15		Feed per Tooth — fz information is for side milling (A).								
		A		Cutting Speed — vc m/min			D1 — Diameter							
		ap	ae	min	max	mm	6,0	8,0	10,0	12,0	14,0	16,0	18,0	20,0
P	0	Ap max	0,05 x D	150	200	fz	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114
	1	Ap max	0,05 x D	150	200	fz	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114
	2	Ap max	0,05 x D	140	190	fz	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114
	3	Ap max	0,05 x D	120	160	fz	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101
	4	Ap max	0,05 x D	90	150	fz	0,033	0,045	0,054	0,062	0,070	0,077	0,083	0,088
	5	Ap max	0,05 x D	60	100	fz	0,029	0,040	0,048	0,056	0,063	0,070	0,076	0,081
	6	Ap max	0,04 x D	50	75	fz	0,025	0,034	0,040	0,047	0,052	0,057	0,061	0,065
M	1	Ap max	0,05 x D	90	115	fz	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101
	2	Ap max	0,05 x D	60	80	fz	0,029	0,040	0,048	0,056	0,063	0,070	0,076	0,081
	3	Ap max	0,05 x D	60	70	fz	0,025	0,034	0,040	0,047	0,052	0,057	0,061	0,065
K	1	Ap max	0,05 x D	120	150	fz	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114
	2	Ap max	0,05 x D	110	140	fz	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101
	3	Ap max	0,05 x D	110	130	fz	0,029	0,040	0,048	0,056	0,063	0,070	0,076	0,081
H	1	Ap max	0,04 x D	80	140	fz	0,033	0,045	0,054	0,062	0,070	0,077	0,083	0,088

NOTE: Those guidelines may require variations to achieve optimum results.
Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters accordingly on >12mm diameter.
For better surface finish, reduce feed per tooth.

F6AJ-F8AJ...DL • Multi-flute • Long • Extra Long



Material Group		Side Milling (A)		KCPM15		Feed per Tooth — fz information is for side milling (A).									
		A		Cutting Speed — vc m/min			D1 — Diameter								
		ap	ae	min	max	mm	6,0	8,0	10,0	12,0	14,0	16,0	18,0	20,0	25,0
P	0	Ap max	0,05 x D	150	200	fz	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114	0,124
	1	Ap max	0,05 x D	150	200	fz	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114	0,124
	2	Ap max	0,05 x D	140	190	fz	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114	0,124
	3	Ap max	0,05 x D	120	160	fz	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101	0,114
	4	Ap max	0,05 x D	90	150	fz	0,033	0,045	0,054	0,062	0,070	0,077	0,083	0,088	0,098
	5	Ap max	0,05 x D	60	100	fz	0,029	0,040	0,048	0,056	0,063	0,070	0,076	0,081	0,091
	6	Ap max	0,04 x D	50	75	fz	0,025	0,034	0,040	0,047	0,052	0,057	0,061	0,065	0,071
M	1	Ap max	0,05 x D	90	115	fz	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101	0,114
	2	Ap max	0,05 x D	60	80	fz	0,029	0,040	0,048	0,056	0,063	0,070	0,076	0,081	0,091
	3	Ap max	0,05 x D	60	70	fz	0,025	0,034	0,040	0,047	0,052	0,057	0,061	0,065	0,071
K	1	Ap max	0,05 x D	120	150	fz	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114	0,124
	2	Ap max	0,05 x D	110	140	fz	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101	0,114
	3	Ap max	0,05 x D	110	130	fz	0,029	0,040	0,048	0,056	0,063	0,070	0,076	0,081	0,091
H	1	Ap max	0,04 x D	80	140	fz	0,033	0,045	0,054	0,062	0,070	0,077	0,083	0,088	0,098

NOTE: Those guidelines may require variations to achieve optimum results.
Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters accordingly on >12mm diameter.
For better surface finish, reduce feed per tooth.

MaxiMet™

Primary Application

The MaxiMet system provides extraordinary metal removal rates and combines roughing and finishing operations with any aluminium plunging, slotting, and profiling application. Its proprietary flute geometry is designed for high stiffness and improved chip evacuation, and generates exceptional wall to floor perpendicularity in thin-wall applications. To ensure a superior floor surface finish, the MaxiMet front geometry is equipped with a wiper facet grind.

- Use only one tool for roughing and finishing operations.
- Slotting depths up to 1 x D as well as side milling up to 0.5 x D radial and 1.5 x D axial engagement.
- Unequal flute spacing for chatter-free performance with the 3-flute series.
- Multiple corner radii and extended neck configurations available as standard.

Features and Benefits

Advanced Technology

- Increase output with fewer tool changes and increased metal removal rates.
- No specific tools for roughing and finishing necessary.
- Fewer passes due to 1 x D slotting capability.
- Perfect for MQL (minimum quantity lubrication) methods.

Tailored Grades

- K600 uncoated grade for longest tool life in aluminium and other non-ferrous materials.

Customisation

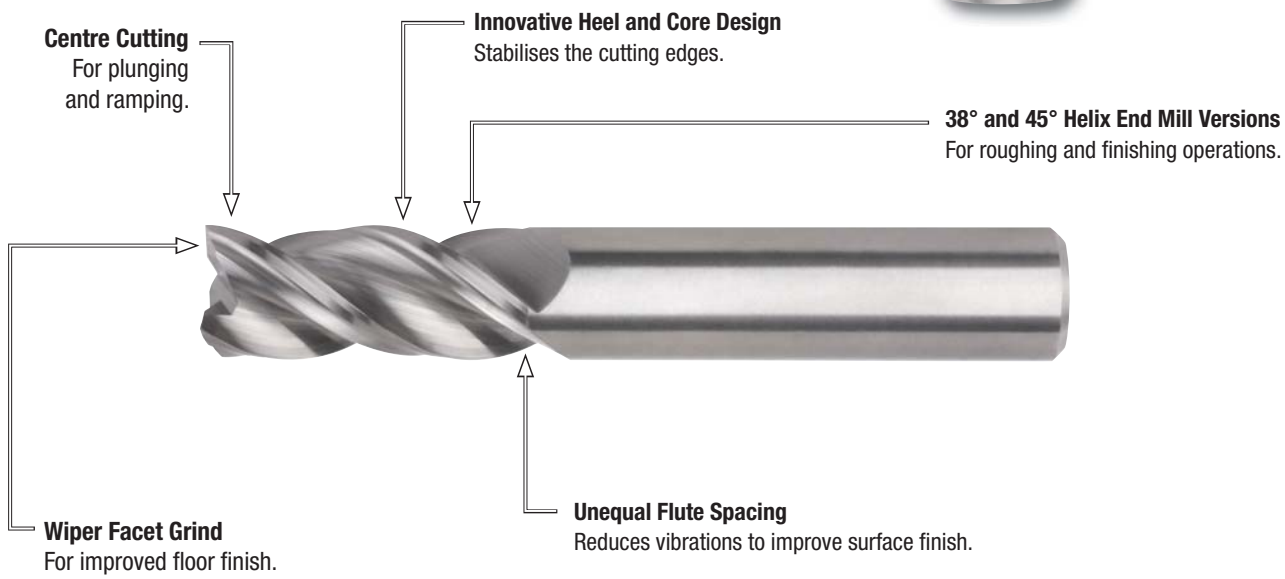
- Intermediate diameters available.
- Custom solutions available for machining titanium and other high-temperature alloys.
- Internal coolant axial and radial available.
- Various shank options and non-standard coatings available.

Extensive Standard Offering

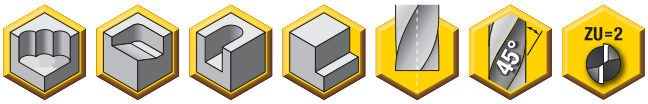
- Diameter ranges 1,5 to 25mm.
- Extended neck for long-reach applications and radii and sharp corner configurations.

Solid carbide end mills for high metal removal rates and superior surface finishes in aluminium.

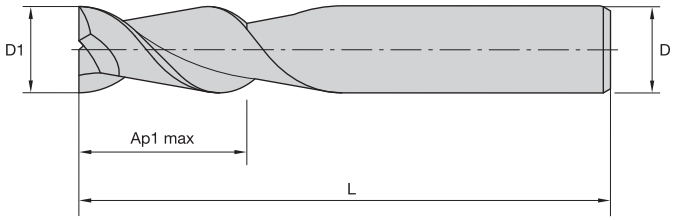




- Kennametal standard dimensions.
- Centre cutting.
- Effective in thin wall applications.
- Wiper facet, special end gash, and flute geometry provide better surface finishes.
- Unique geometry delivers maximum metal removal rates.



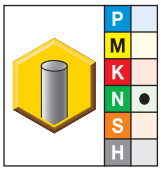




End Mill Tolerances

D1	D1 tolerance	D tolerance
<6mm	DIN e8	DIN h6
>6mm	DIN h6	DIN h6

ABDF • Wiper Facet

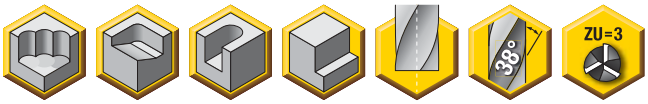


● first choice
○ alternate choice

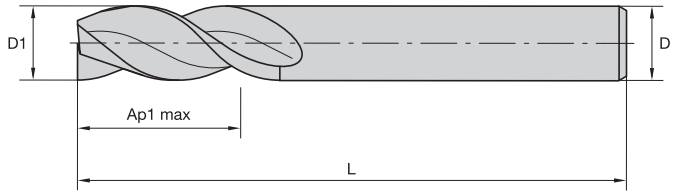
K600	D1	D	Ap1 max	L
ABDF0150A2AS	1,50	3,00	6,00	38,00
ABDF0200A2AS	2,00	3,00	8,00	38,00
ABDF0250A2AS	2,50	3,00	9,00	38,00
ABDF0300A2AS	3,00	3,00	12,00	38,00
ABDF0400A2AS	4,00	4,00	12,00	50,00
ABDF0500A2AS	5,00	6,00	14,00	50,00
ABDF0600A2AS	6,00	6,00	16,00	50,00
ABDF0800A2AS	8,00	8,00	20,00	63,00
ABDF1000A2AS	10,00	10,00	22,00	76,00
ABDF1200A2AS	12,00	12,00	25,00	76,00
ABDF1400A2AS	14,00	14,00	32,00	83,00
ABDF1600A2AS	16,00	16,00	32,00	89,00
ABDF1800A2AS	18,00	18,00	38,00	100,00
ABDF2000A2AS	20,00	20,00	38,00	104,00

NOTE: For application data, see page P114.

- Kennametal standard dimensions.
- Centre cutting.
- Effective in thin wall applications.
- Wiper facet, special end gash, and flute geometry provide better surface finishes.
- Unique geometry delivers maximum metal removal rates.



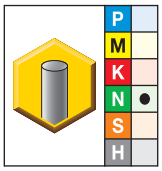




End Mill Tolerances

D1	D1 tolerance	D tolerance
<6mm	DIN e8	DIN h6
>6mm	DIN h6	DIN h6

ABDE • Wiper Facet

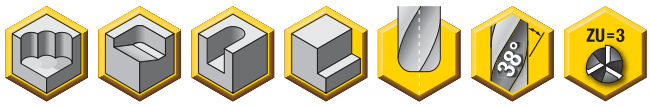


● first choice
○ alternate choice

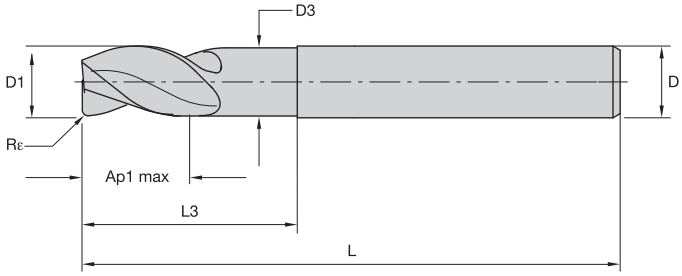
K600	D1	D	Ap1 max	L
ABDE0300A3AS	3,00	3,00	12,00	38,00
ABDE0400A3AS	4,00	4,00	12,00	50,00
ABDE0500A3AS	5,00	5,00	14,00	50,00
ABDE0600A3AS	6,00	6,00	16,00	50,00
ABDE0800A3AS	8,00	8,00	20,00	63,00
ABDE1000A3AS	10,00	10,00	22,00	76,00
ABDE1200A3AS	12,00	12,00	25,00	76,00
ABDE1400A3AS	14,00	14,00	32,00	83,00
ABDE1600A3AS	16,00	16,00	32,00	89,00
ABDE1800A3AS	18,00	18,00	38,00	100,00
ABDE2000A3AS	20,00	20,00	38,00	104,00

NOTE: For application data, see page P114.

- Kennametal standard dimensions.
- Centre cutting.
- Effective in thin wall applications.
- Wiper facet, special end gash, and flute geometry provide better surface finishes.
- Unique geometry delivers maximum metal removal rates.



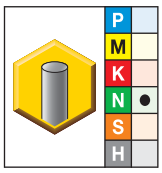




End Mill Tolerances

D1	D1 tolerance	D tolerance
<6mm	DIN e8	DIN h6
>6mm	DIN h6	DIN h6

ABDE • Wiper Facet • Extended Neck

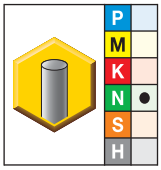


● first choice
○ alternate choice

K600	D1	D	D3	Ap1 max	L3	L	Rε
ABDE0600A3ARA	6,00	6,00	5,40	9,00	18,00	63,00	0,20
ABDE0600A3ARB	6,00	6,00	5,40	9,00	18,00	63,00	0,50
ABDE0600A3ARC	6,00	6,00	5,40	9,00	18,00	63,00	1,00
ABDE0800A3ARA	8,00	8,00	7,20	12,00	24,00	76,00	0,20
ABDE0800A3ARB	8,00	8,00	7,20	12,00	24,00	76,00	0,50
ABDE0800A3ARC	8,00	8,00	7,20	12,00	24,00	76,00	1,00
ABDE1000A3ARA	10,00	10,00	9,00	15,00	30,00	89,00	0,20
ABDE1000A3ARB	10,00	10,00	9,00	15,00	30,00	89,00	0,50
ABDE1000A3ARG	10,00	10,00	9,50	15,00	30,00	76,00	1,00
ABDE1000A3ARC	10,00	10,00	9,00	15,00	30,00	89,00	1,50
ABDE1000A3ARK	10,00	10,00	9,50	15,00	30,00	76,00	2,00
ABDE1000A3ARN	10,00	10,00	9,50	15,00	30,00	76,00	4,00
ABDE1200A3ARA	12,00	12,00	10,80	18,00	36,00	100,00	0,20
ABDE1200A3ARB	12,00	12,00	10,80	18,00	36,00	100,00	0,50
ABDE1200A3ARG	12,00	12,00	11,50	18,00	36,00	83,00	1,00
ABDE1200A3ARC	12,00	12,00	10,80	18,00	36,00	100,00	1,50
ABDE1200A3ARK	12,00	12,00	11,50	18,00	36,00	83,00	2,00
ABDE1200A3ARL	12,00	12,00	11,50	18,00	36,00	100,00	2,50
ABDE1200A3ARM	12,00	12,00	11,50	18,00	36,00	83,00	3,00
ABDE1200A3ARN	12,00	12,00	11,50	18,00	36,00	83,00	4,00
ABDE1600A3ARA	16,00	16,00	14,40	24,00	48,00	110,00	0,20
ABDE1600A3ARB	16,00	16,00	14,40	24,00	48,00	110,00	0,50
ABDE1600A3ARC	16,00	16,00	14,40	24,00	48,00	110,00	1,00
ABDE1600A3ARD	16,00	16,00	14,40	24,00	48,00	110,00	2,00

(continued)

(ABDE • Wiper Facet • Extended Neck — continued)

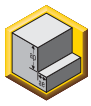


● first choice
○ alternate choice

K600	D1	D	D3	Ap1 max	L3	L	Rε
ABDE1600A3ARL	16,00	16,00	15,00	24,00	48,00	110,00	2,50
ABDE1600A3ARM	16,00	16,00	15,00	24,00	48,00	100,00	3,00
ABDE1600A3ARN	16,00	16,00	15,00	24,00	48,00	100,00	4,00
ABDE2000A3ARA	20,00	20,00	18,80	30,00	60,00	125,00	0,20
ABDE2000A3ARB	20,00	20,00	18,80	30,00	60,00	125,00	0,50
ABDE2000A3ARG *	20,00	20,00	19,00	30,00	60,00	115,00	1,00
ABDE2000A3ARC	20,00	20,00	18,80	30,00	60,00	125,00	1,50
ABDE2000A3ARK	20,00	20,00	19,00	30,00	60,00	115,00	2,00
ABDE2000A3ARM	20,00	20,00	19,00	30,00	60,00	115,00	3,00
ABDE2000A3ARD	20,00	20,00	18,80	30,00	60,00	125,00	4,00
ABDE2500A3ARE	25,00	25,00	24,00	37,50	75,00	135,00	0,50
ABDE2500A3ARG *	25,00	25,00	24,00	37,50	75,00	135,00	1,00
ABDE2500A3ARK *	25,00	25,00	24,00	37,50	75,00	135,00	2,00
ABDE2500A3ARM *	25,00	25,00	24,00	37,50	75,00	135,00	3,00
ABDE2500A3ARN *	25,00	25,00	24,00	37,50	75,00	135,00	4,00

NOTE: For application data, see page P114.
*Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

ABDE... • ABDF...

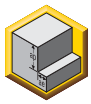




Material Group		Side Milling (A) and Slotting (B)			K600		Feed per Tooth — fz information is for side milling (A). For slotting (B), reduce fz by 20%.									
		A		B	Cutting Speed — vc m/min			D1 — Diameter								
		ap	ae	ap	min	max	mm	1,5	2,0	4,0	6,0	8,0	10,0	12,0	16,0	20,0
N	1	1,5 x D	0,5 x D	1,0 x D	500	2000	fz	0,014	0,018	0,036	0,054	0,072	0,090	0,108	0,144	0,180
	2	1,5 x D	0,5 x D	1,0 x D	500	1500	fz	0,012	0,016	0,032	0,049	0,065	0,081	0,097	0,130	0,162
	3	1,5 x D	0,5 x D	1,0 x D	500	1500	fz	0,009	0,013	0,025	0,038	0,050	0,063	0,076	0,101	0,126
	4	1,5 x D	0,5 x D	1,0 x D	400	750	fz	0,009	0,013	0,025	0,038	0,050	0,063	0,076	0,101	0,126
	5	1,5 x D	0,5 x D	1,0 x D	250	1000	fz	0,012	0,016	0,032	0,049	0,065	0,081	0,097	0,130	0,162

NOTE: Those guidelines may require variations to achieve optimum results. For better surface finish, reduce feed per tooth.
For cutting aluminium with high silicon, TiCN coating is recommended.
Ap for milling machine with ceramic bearings spindle, multiply by 0,5.
For better surface finish, reduce feed per tooth.
Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters accordingly on >12mm diameter.
For tools with reach >3 x D, reduce fz by 20%
For tools with reach >5 x D, reduce fz by 30%.
For tools with reach >10 x D, reduce vc and fz by 30%.

ABDE... • Extended Neck





Material Group		Side Milling (A) and Slotting (B)			K600		Feed per Tooth — fz information is for side milling (A). For slotting (B), reduce fz by 20%.						
		A		B	Cutting Speed — vc m/min			D1 — Diameter					
		ap	ae	ap	min	max	mm	6,0	8,0	10,0	12,0	16,0	20,0
N	1	1 x D	0,5 x D	1,0 x D	500	2000	fz	0,060	0,080	0,100	0,120	0,160	0,200
	2	1 x D	0,5 x D	1,0 x D	500	1500	fz	0,054	0,072	0,090	0,108	0,144	0,180
	3	1 x D	0,5 x D	1,0 x D	500	1500	fz	0,042	0,056	0,070	0,084	0,112	0,140
	4	1 x D	0,5 x D	1,0 x D	400	750	fz	0,042	0,056	0,070	0,084	0,112	0,140
	5	1 x D	0,5 x D	1,0 x D	250	1000	fz	0,054	0,072	0,090	0,108	0,144	0,180

NOTE: Those guidelines may require variations to achieve optimum results. For better surface finish, reduce feed per tooth.
For cutting aluminium with high silicon, TiCN coating is recommended.
Ap for milling machine with ceramic bearings spindle, multiply by 0,5.
For better surface finish, reduce feed per tooth.
Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters accordingly on >12mm diameter.
For tools with reach >3 x D, reduce fz by 20%
For tools with reach >5 x D, reduce fz by 30%.
For tools with reach >10 x D, reduce vc and fz by 30%.

DUO-λOCK®

Replaceable head system

- High accuracy and repeatability.
- Maximum stability and productivity.
- Solid carbide performance.



DUO-λOCK®
by HAIMER® and Kennametal

Offering

- HARVI™ I, II, and III.
- Roughers and finishers.
- Aluminium and high-feed cutters.
- Corner rounding and chamfering tools.

Advanced Technology

- Up to 1 x D full slotting.
- 1,5 x D side milling up to 50% radial engagement.
- Extensive straight shanks, conical shanks, and integral adaptors.
- Proprietary HARVI geometries enable roughing and finishing with one tool.

Visit **kennametal.com** or contact your local Authorised Kennametal Distributor.

KENNAMETAL®

kennametal.com

High-Performance Aluminium Solid Carbide End Mills

Primary Application

High-performance aluminium end mills from Kennametal provide the highest Metal Removal Rates (MRR) and high-quality surfaces while reducing machining time. The centre-cutting design enables plunging, slotting, and profiling applications in any type of aluminium workpiece materials. Designed to deliver exceptional chip evacuation and generate the highest floor-to-wall straightness. The portfolio offers many styles to choose from.

- Tools combine roughing and finishing operations beside pure rougher with cord profile.
- Capable of full slot depths up to 1 x D and side milling up to 0.5 x D radially at 1.5 x D axially.
- Multiple corner radii and extended neck configurations available as standard.

Features and Benefits

Advanced Technology

- No specific tools for roughing and finishing necessary.
- Fewer passes due to 1 x D slotting capability.
- Best suited for MQL (minimum quantity lubrication) applications.

Tailored Grades

- K600 uncoated grade for highest tool life in aluminium and other non-ferrous materials.

Customisation

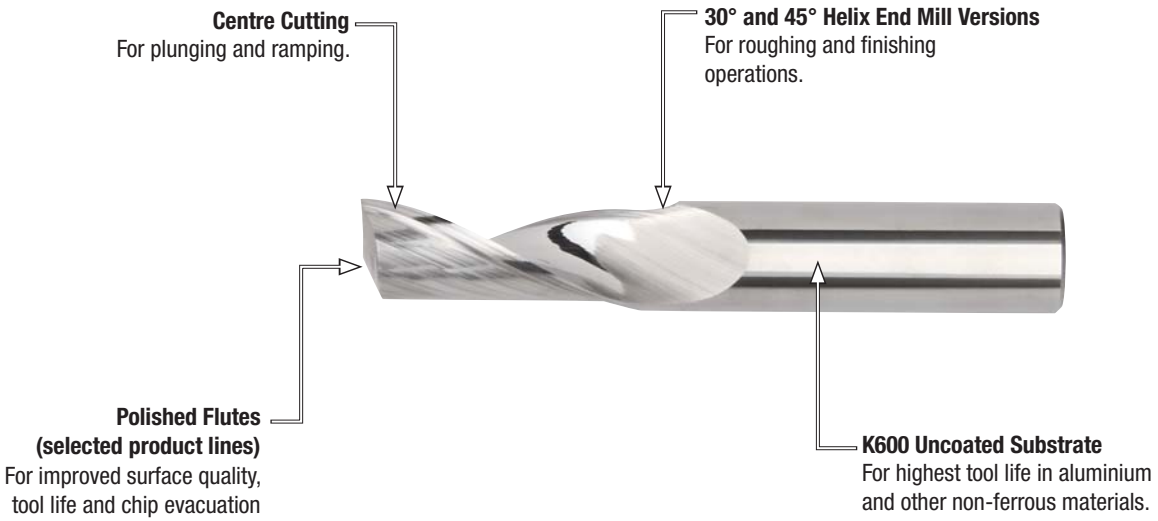
- Intermediate diameters available.
- Expanded length of tool and increased length of cut are possible.
- Internal coolant axial and radial available.
- Various shank options and non-standard coatings available.
- TiB_2 grade KC651M available as custom solution.

Extensive Standard Offering

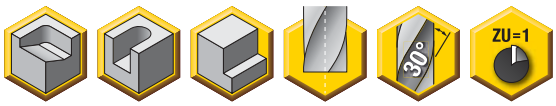
- Diameter ranges 2–25mm.
- Extended neck for long-reach applications as well as radii and sharp corner configurations.

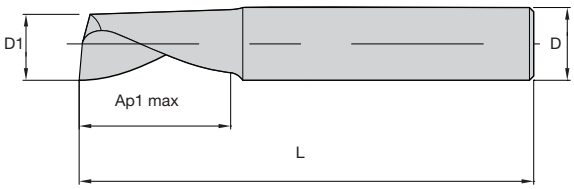
Extended neck for long-reach applications as well as radii and sharp corner configurations.





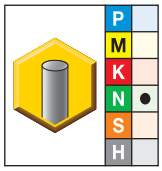
- Kennametal standard dimensions
- Centre cutting.
- Standard items listed. Additional styles and coatings made-to-order.







F1AA...WS—WM • Metric



● first choice
○ alternate choice

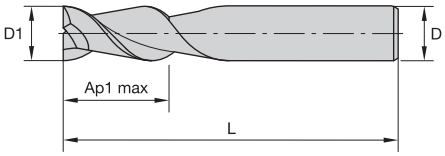
K600	D1	D	Ap1 max	L
F1AA0200AWS30	2,00	2,00	10,00	40,00
F1AA0300AWS30	3,00	3,00	10,00	40,00
F1AA0400AWS30	4,00	4,00	14,00	50,00
F1AA0500AWS30	5,00	5,00	16,00	60,00
F1AA0600AWS30	6,00	6,00	20,00	60,00
F1AA0800AWM30	8,00	8,00	25,00	75,00
F1AA1000AWM30	10,00	10,00	25,00	75,00
F1AA1200AWM30	12,00	12,00	25,00	75,00

NOTE: For application data, see page P126.

- Centre cutting.
- Standard items listed. Additional styles and coatings made-to-order.



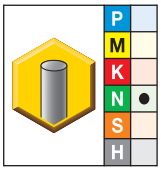




End Mill Tolerances

D1	D1 tolerance	D tolerance
<6mm	DIN e8	DIN h6
>6mm	DIN h6	DIN h6

F2AA...ADL45...



● first choice
○ alternate choice

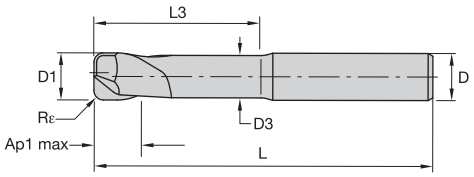
K600	D1	D	Ap1 max	L
F2AA0400ADL45	4,00	6,00	8,00	57,00
F2AA0500ADL45	5,00	6,00	10,00	57,00
F2AA0600ADL45	6,00	6,00	10,00	57,00
F2AA0800ADL45	8,00	8,00	16,00	63,00
F2AA1000ADL45	10,00	10,00	19,00	72,00
F2AA1200ADL45	12,00	12,00	22,00	83,00
F2AA1400ADL45	14,00	14,00	22,00	83,00
F2AA1600ADL45	16,00	16,00	26,00	92,00
F2AA1800ADL45	18,00	18,00	26,00	92,00
F2AA2000ADL45	20,00	20,00	32,00	104,00

NOTE: For application data, see page P126.

- Kennametal standard dimensions.
- Centre cutting.
- Standard items listed. Additional styles and coatings made-to-order.



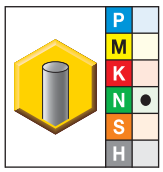




End Mill Tolerances

D1	D1 tolerance	D tolerance
<6mm	DIN e8	DIN h6
>6mm	DIN h6	DIN h6

F2AA...WM-WL-WX • Extended Neck

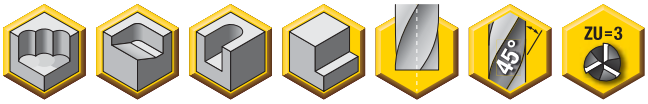


● first choice
○ alternate choice

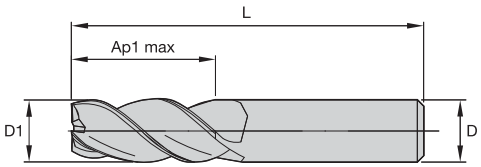
K600	D1	D	D3	Ap1 max	L3	L	Rε
F2AA0600AWM45R050	6,00	6,00	5,80	9,00	18,00	63,00	0,50
F2AA0600AWM45R100	6,00	6,00	5,80	9,00	18,00	63,00	1,00
F2AA0800AWM45R050	8,00	8,00	7,80	12,00	24,00	68,00	0,50
F2AA0800AWM45R100	8,00	8,00	7,80	12,00	24,00	68,00	1,00
F2AA1000AWL45R050	10,00	10,00	9,50	15,00	30,00	76,00	0,50
F2AA1000AWL45R100	10,00	10,00	9,50	15,00	30,00	76,00	1,00
F2AA1000AWL45R200	10,00	10,00	9,50	15,00	30,00	76,00	2,00
F2AA1000AWL45R300	10,00	10,00	9,50	15,00	30,00	76,00	3,00
F2AA1000AWL45R400	10,00	10,00	9,50	15,00	30,00	76,00	4,00
F2AA1200AWL45R050	12,00	12,00	11,50	18,00	36,00	84,00	0,50
F2AA1200AWL45R100	12,00	12,00	11,50	18,00	36,00	84,00	1,00
F2AA1200AWL45R200	12,00	12,00	11,50	18,00	36,00	84,00	2,00
F2AA1200AWL45R250	12,00	12,00	11,50	18,00	36,00	84,00	2,50
F2AA1200AWL45R300	12,00	12,00	11,50	18,00	36,00	84,00	3,00
F2AA1200AWL45R400	12,00	12,00	11,50	18,00	36,00	84,00	4,00
F2AA1600AWX45R050	16,00	16,00	15,00	24,00	48,00	100,00	0,50
F2AA1600AWX45R100	16,00	16,00	15,00	24,00	48,00	100,00	1,00
F2AA1600AWX45R200	16,00	16,00	15,00	24,00	48,00	100,00	2,00
F2AA1600AWX45R250	16,00	16,00	15,00	24,00	48,00	100,00	2,50
F2AA1600AWX45R300	16,00	16,00	15,00	24,00	48,00	100,00	3,00
F2AA1600AWX45R400	16,00	16,00	15,00	24,00	48,00	100,00	4,00
F2AA2000AWX45R050	20,00	20,00	19,00	30,00	60,00	115,00	0,50
F2AA2000AWX45R100	20,00	20,00	19,00	30,00	60,00	115,00	1,00
F2AA2000AWX45R200	20,00	20,00	19,00	30,00	60,00	115,00	2,00
F2AA2000AWX45R300	20,00	20,00	19,00	30,00	60,00	115,00	3,00
F2AA2000AWX45R400	20,00	20,00	19,00	30,00	60,00	115,00	4,00
F2AA2500AWX45R050	25,00	25,00	24,00	37,50	75,00	135,00	0,50
F2AA2500AWX45R100	25,00	25,00	24,00	37,50	75,00	135,00	1,00
F2AA2500AWX45R200 *	25,00	25,00	24,00	37,50	75,00	135,00	2,00
F2AA2500AWX45R300	25,00	25,00	24,00	37,50	75,00	135,00	3,00
F2AA2500AWX45R400	25,00	25,00	24,00	37,50	75,00	135,00	4,00

NOTE: For application data, see page P126.
*Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

- Kennametal standard dimensions.
- Centre cutting.
- Standard items listed. Additional styles and coatings made-to-order.



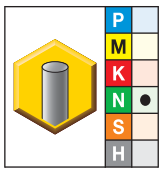




End Mill Tolerances

D1	D1 tolerance	D tolerance
<6mm	DIN e8	DIN h6
>6mm	DIN h6	DIN h6

F3AA...AWS/L45...

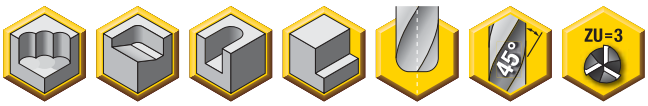


● first choice
○ alternate choice

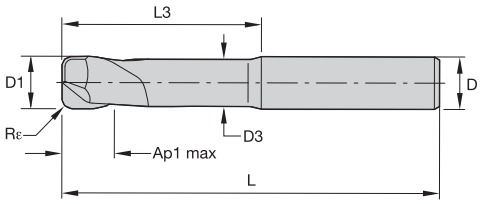
K600	D1	D	Ap1 max	L
F3AA0300AWS45	3,00	3,00	12,00	38,00
F3AA0400AWS45	4,00	4,00	12,00	50,00
F3AA0500AWS45	5,00	6,00	14,00	50,00
F3AA0600AWS45	6,00	6,00	16,00	50,00
F3AA0800AWM45	8,00	8,00	20,00	63,00
F3AA1000AWL45	10,00	10,00	22,00	76,00
F3AA1200AWL45	12,00	12,00	25,00	76,00
F3AA1400AWL45	14,00	14,00	32,00	83,00
F3AA1600AWL45	16,00	16,00	32,00	89,00
F3AA1800AWL45	18,00	18,00	38,00	100,00
F3AA2000AWX45	20,00	20,00	38,00	104,00

NOTE: For application data, see page P126.

- Kennametal standard dimension.
- Centre cutting.
- Standard items listed. Additional styles and coatings made-to-order.



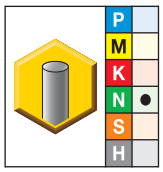




End Mill Tolerances

D1	D1 tolerance	D tolerance
<6mm	DIN e8	DIN h6
>6mm	DIN h6	DIN h6

F3AA...WS-WM-WL-WX • Extended Neck

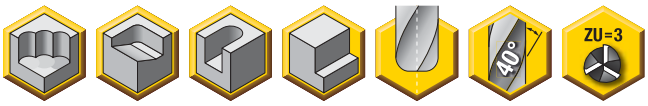


● first choice
○ alternate choice

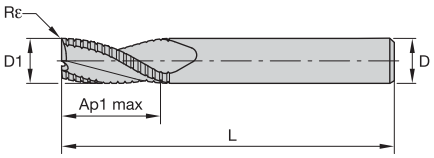
K600	D1	D	D3	Ap1 max	L3	L	Rε
F3AA0600AWM45R050	6,00	6,00	5,80	9,00	18,00	63,00	0,50
F3AA0600AWM45R100	6,00	6,00	5,80	9,00	18,00	63,00	1,00
F3AA0800AWM45R050	8,00	8,00	7,80	12,00	24,00	68,00	0,50
F3AA0800AWM45R100	8,00	8,00	7,80	12,00	24,00	68,00	1,00
F3AA1000AWL45R050	10,00	10,00	9,50	15,00	30,00	76,00	0,50
F3AA1000AWL45R100	10,00	10,00	9,50	15,00	30,00	76,00	1,00
F3AA1000AWL45R200	10,00	10,00	9,50	15,00	30,00	76,00	2,00
F3AA1000AWL45R300	10,00	10,00	9,50	15,00	30,00	76,00	3,00
F3AA1000AWL45R400	10,00	10,00	9,50	15,00	30,00	76,00	4,00
F3AA1200AWL45R050	12,00	12,00	11,50	18,00	36,00	84,00	0,50
F3AA1200AWL45R100	12,00	12,00	11,50	18,00	36,00	83,00	1,00
F3AA1200AWL45R200	12,00	12,00	11,50	18,00	36,00	83,00	2,00
F3AA1200AWL45R300	12,00	12,00	11,50	18,00	36,00	83,00	3,00
F3AA1200AWL45R400	12,00	12,00	11,50	18,00	36,00	83,00	4,00
F3AA1600AWX45R050	16,00	16,00	15,00	24,00	48,00	100,00	0,50
F3AA1600AWX45R100	16,00	16,00	15,00	24,00	48,00	100,00	1,00
F3AA1600AWX45R200	16,00	16,00	15,00	24,00	48,00	100,00	2,00
F3AA1600AWX45R300	16,00	16,00	15,00	24,00	48,00	100,00	3,00
F3AA1600AWX45R400	16,00	16,00	15,00	24,00	48,00	100,00	4,00
F3AA2000AWX45R050	20,00	20,00	19,00	30,00	60,00	115,00	0,50
F3AA2000AWX45R100	20,00	20,00	19,00	30,00	60,00	115,00	1,00
F3AA2000AWX45R200	20,00	20,00	19,00	30,00	60,00	115,00	2,00
F3AA2000AWX45R300	20,00	20,00	19,00	30,00	60,00	115,00	3,00
F3AA2000AWX45R400	20,00	20,00	19,00	30,00	60,00	115,00	4,00
F3AA2500AWX45R050	25,00	25,00	24,00	37,50	75,00	135,00	0,50
F3AA2500AWX45R100	25,00	25,00	24,00	37,50	75,00	135,00	1,00
F3AA2500AWX45R200	25,00	25,00	24,00	37,50	75,00	135,00	2,00
F3AA2500AWX45R300	25,00	25,00	24,00	37,50	75,00	135,00	3,00
F3AA2500AWX45R400 *	25,00	25,00	24,00	37,50	75,00	135,00	4,00

NOTE: For application data, see page P127.
*Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

- Aluminium profile.
- Kennametal standard dimensions.
- Centre cutting.
- Standard items listed. Additional styles and coatings made-to-order.



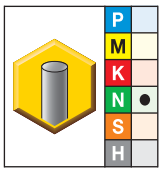




End Mill Tolerances

D1	tolerance d11	D	tolerance h6
≤3	-0,020/-0,080	≤3	+0/-0,006
>3–6	-0,030/-0,105	>3–6	+0/-0,008
>6–10	-0,040/-0,130	>6–10	+0/-0,009
>10–18	-0,050/-0,160	>10–18	+0/-0,011
>18–30	-0,065/-0,195	>18–30	+0/-0,013

F3BA...WS-WM-WL-WX

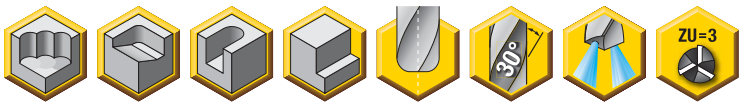


● first choice
○ alternate choice

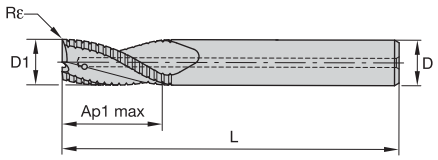
K600	D1	D	Ap1 max	L	Rε
F3BA0600BWS40	6,00	6,00	13,00	57,00	0,25
F3BA0800BWM40	8,00	8,00	16,00	63,00	0,25
F3BA1000BWM40	10,00	10,00	22,00	72,00	0,50
F3BA1200BWL40	12,00	12,00	26,00	83,00	0,50
F3BA1600BWL40	16,00	16,00	32,00	92,00	1,00
F3BA2000BWX40	20,00	20,00	38,00	104,00	1,00
F3BA2500BWX40	25,00	25,00	45,00	121,00	1,50

NOTE: For application data, see page P127.

- Aluminium profile.
- Kennametal standard dimensions.
- Centre cutting.
- Standard items listed. Additional styles and coatings made-to-order.



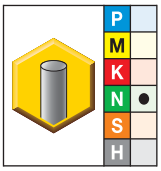




End Mill Tolerances

D1	tolerance d11	D	tolerance h6
≤3	-0,020/-0,080	≤3	+0/-0,006
>3–6	-0,030/-0,105	>3–6	+0/-0,008
>6–10	-0,040/-0,130	>6–10	+0/-0,009
>10–18	-0,050/-0,160	>10–18	+0/-0,011
>18–30	-0,065/-0,195	>18–30	+0/-0,013

F3BA..BWM/L/X40C...

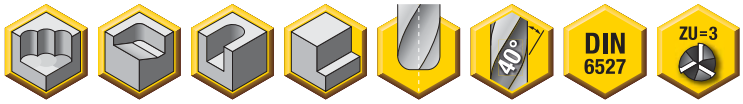


● first choice
○ alternate choice

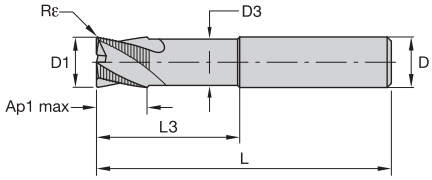
K600	D1	D	Ap1 max	L	Rε
F3BA0800BWM40C160	8,00	8,00	16,00	63,00	0,25
F3BA1000BWM40C220	10,00	10,00	22,00	72,00	0,50
F3BA1200BWL40C260	12,00	12,00	26,00	83,00	0,50
F3BA1600BWL40C320	16,00	16,00	32,00	92,00	1,00
F3BA2000BWX40C380	20,00	20,00	38,00	104,00	1,00
F3BA2500BWX40C450	25,00	25,00	45,00	121,00	1,50

NOTE: For application data, see page P127.

- Aluminium profile.
- Centre cutting.
- Standard items listed. Additional styles and coatings made-to-order.



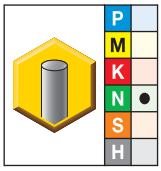




End Mill Tolerances

D1	tolerance d11	D	tolerance h6
≤3	-0,020/-0,080	≤3	+0/-0,006
>3–6	-0,030/-0,105	>3–6	+0/-0,008
>6–10	-0,040/-0,130	>6–10	+0/-0,009
>10–18	-0,050/-0,160	>10–18	+0/-0,011
>18–30	-0,065/-0,195	>18–30	+0/-0,013

F3BA...DL...



● first choice
○ alternate choice

K600	D1	D	D3	Ap1 max	L3	L	Rε
F3BA0600ADL40E180	6,00	6,00	5,00	8,00	18,00	57,00	0,25
F3BA0800ADL40E240	8,00	8,00	7,00	10,00	24,00	63,00	0,25
F3BA1000ADL40E300	10,00	10,00	9,00	12,00	30,00	72,00	0,25
F3BA1200ADL40E360	12,00	12,00	11,00	15,00	36,00	83,00	0,25
F3BA1600ADL40E480	16,00	16,00	15,00	20,00	48,00	92,00	1,00
F3BA2000ADL40E600	20,00	20,00	19,00	24,00	60,00	104,00	1,00

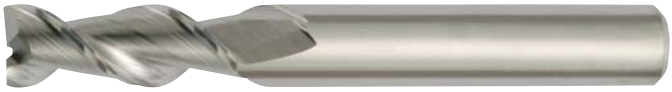
NOTE: For application data, see page P127.

F1AA...WS—WM



Material Group		Side Milling (A) and Slotting (B) A ap	Side Milling (A) and Slotting (B) A ae	Side Milling (A) and Slotting (B) B ap	K600 Cutting Speed — vc m/min min	K600 Cutting Speed — vc m/min max	mm	Feed per Tooth — fz information is for side milling (A). For slotting (B), reduce fz by 20%. D1 — Diameter 2,0	3,0	4,0	5,0	6,0	8,0	10,0	12,0
N	1	1,2 x D	0,5 x D	1,0 x D	500	2000	fz	0,014	0,021	0,028	0,035	0,042	0,056	0,070	0,084
	2	1,2 x D	0,5 x D	1,0 x D	500	1500	fz	0,013	0,019	0,025	0,032	0,038	0,050	0,063	0,076
	3	1,2 x D	0,5 x D	1,0 x D	500	1500	fz	0,010	0,015	0,020	0,025	0,029	0,039	0,049	0,059
	4	1,2 x D	0,5 x D	1,0 x D	400	750	fz	0,010	0,015	0,020	0,025	0,029	0,039	0,049	0,059
	5	1,2 x D	0,5 x D	1,0 x D	250	1000	fz	0,013	0,019	0,025	0,032	0,038	0,050	0,063	0,076

F2AA...ADL45...



Material Group		Side Milling (A) and Slotting (B) A ap	Side Milling (A) and Slotting (B) A ae	Side Milling (A) and Slotting (B) B ap	K600 Cutting Speed — vc m/min min	K600 Cutting Speed — vc m/min max	mm	Feed per Tooth — fz information is for side milling (A). For slotting (B), reduce fz by 20%. D1 — Diameter 4,0	6,0	8,0	10,0	12,0	14,0	16,0	18,0	20,0
N	1	1,5 x D	0,5 x D	1,0 x D	500	2000	fz	0,036	0,054	0,072	0,090	0,108	0,126	0,144	0,162	0,180
	2	1,5 x D	0,5 x D	1,0 x D	500	1500	fz	0,032	0,049	0,065	0,081	0,097	0,113	0,130	0,146	0,162
	3	1,5 x D	0,5 x D	1,0 x D	500	1500	fz	0,025	0,038	0,050	0,063	0,076	0,088	0,101	0,113	0,126
	4	1,5 x D	0,5 x D	1,0 x D	400	750	fz	0,025	0,038	0,050	0,063	0,076	0,088	0,101	0,113	0,126
	5	1,5 x D	0,5 x D	1,0 x D	250	1000	fz	0,032	0,049	0,065	0,081	0,097	0,113	0,130	0,146	0,162

F2AA...WS-WM-WL-WX



Material Group		Side Milling (A) and Slotting (B) A ap	Side Milling (A) and Slotting (B) A ae	Side Milling (A) and Slotting (B) B ap	K600 Cutting Speed — vc m/min min	K600 Cutting Speed — vc m/min max	mm	Feed per Tooth — fz information is for side milling (A). For slotting (B), reduce fz by 20%. D1 — Diameter 6,0	8,0	10,0	12,0	16,0	18,0	20,0	25,0
N	1	1,5 x D	0,5 x D	1,0 x D	500	2000	fz	0,054	0,072	0,090	0,108	0,144	0,162	0,180	0,225
	2	1,5 x D	0,5 x D	1,0 x D	500	1500	fz	0,049	0,065	0,081	0,097	0,130	0,146	0,162	0,203
	3	1,5 x D	0,5 x D	1,0 x D	500	1500	fz	0,038	0,050	0,063	0,076	0,101	0,113	0,126	0,158
	4	1,5 x D	0,5 x D	1,0 x D	400	750	fz	0,038	0,050	0,063	0,076	0,101	0,113	0,126	0,158
	5	1,5 x D	0,5 x D	1,0 x D	250	1000	fz	0,049	0,065	0,081	0,097	0,130	0,146	0,162	0,203

F3AA...WS-WM-WL-WX



Material Group		Side Milling (A) and Slotting (B) A ap	Side Milling (A) and Slotting (B) A ae	Side Milling (A) and Slotting (B) B ap	K600 Cutting Speed — vc m/min min	K600 Cutting Speed — vc m/min max	mm	Feed per Tooth — fz information is for side milling (A). For slotting (B), reduce fz by 20%. D1 — Diameter 3,0	4,0	6,0	8,0	10,0	12,0	16,0	20,0
N	1	1,5 x D	0,5 x D	1,0 x D	500	2000	fz	0,027	0,036	0,054	0,072	0,090	0,108	0,144	0,180
	2	1,5 x D	0,5 x D	1,0 x D	500	1500	fz	0,024	0,032	0,049	0,065	0,081	0,097	0,130	0,162
	3	1,5 x D	0,5 x D	1,0 x D	500	1500	fz	0,019	0,025	0,038	0,050	0,063	0,076	0,101	0,126
	4	1,5 x D	0,5 x D	1,0 x D	400	750	fz	0,019	0,025	0,038	0,050	0,063	0,076	0,101	0,126
	5	1,5 x D	0,5 x D	1,0 x D	250	1000	fz	0,024	0,032	0,049	0,065	0,081	0,097	0,130	0,162

NOTE: Those guidelines may require variations to achieve optimum results.
Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters accordingly on >12mm diameter.
For cutting aluminium with high silicon, TiCN coating is recommended.
Ap for spindle with ceramic bearings multiply by 0,5.
For better surface finish, reduce feed per tooth.
Side milling applications — for longest reach (L3) tools, reduce ae by 30%.
Slot milling applications — for longest reach (L3) tools, reduce ae by 30%.

F3AA...WS-WM-WL-WX • Extended Neck



Material Group		Side Milling (A) and Slotting (B) A ap	A ae	B ap	K600 Cutting Speed — vc m/min min	max	mm	Feed per Tooth — fz information is for side milling (A). For slotting (B), reduce fz by 20%. D1 — Diameter 6,0	8,0	10,0	12,0	16,0	18,0	20,0	25,0
N	1	1,5 x D	0,5 x D	1,0 x D	500	2000	fz	0,054	0,072	0,090	0,108	0,144	0,162	0,180	0,225
	2	1,5 x D	0,5 x D	1,0 x D	500	1500	fz	0,049	0,065	0,081	0,097	0,130	0,146	0,162	0,203
	3	1,5 x D	0,5 x D	1,0 x D	500	1500	fz	0,038	0,050	0,063	0,076	0,101	0,113	0,126	0,158
	4	1,5 x D	0,5 x D	1,0 x D	400	750	fz	0,038	0,050	0,063	0,076	0,101	0,113	0,126	0,158
	5	1,5 x D	0,5 x D	1,0 x D	250	1000	fz	0,049	0,065	0,081	0,097	0,130	0,146	0,162	0,203

F3BA...BWS/M/L/X40...



Material Group		Side Milling (A) and Slotting (B) A ap	A ae	B ap	K600 Cutting Speed — vc m/min min	max	mm	Feed per Tooth — fz information is for side milling (A). For slotting (B), reduce fz by 20%. D1 — Diameter 6,0	8,0	10,0	12,0	16,0	18,0	20,0	25,0
N	1	1,5 x D	0,5 x D	1,0 x D	500	2000	fz	0,072	0,096	0,120	0,144	0,192	0,216	0,240	0,300
	2	1,5 x D	0,5 x D	1,0 x D	500	1500	fz	0,065	0,086	0,108	0,130	0,173	0,194	0,216	0,270
	3	1,5 x D	0,5 x D	1,0 x D	500	1500	fz	0,050	0,067	0,084	0,101	0,134	0,151	0,168	0,210
	4	1,5 x D	0,5 x D	1,0 x D	400	750	fz	0,050	0,067	0,084	0,101	0,134	0,151	0,168	0,210
	5	1,5 x D	0,5 x D	1,0 x D	250	1000	fz	0,065	0,086	0,108	0,130	0,173	0,194	0,216	0,270

F3BA..BWM/L/X40C...



Material Group		Side Milling (A) and Slotting (B) A ap	A ae	B ap	K600 Cutting Speed — vc m/min min	max	mm	Feed per Tooth — fz information is for side milling (A). For slotting (B), reduce fz by 20%. D1 — Diameter 6,0	8,0	10,0	12,0	16,0	18,0	20,0	25,0
N	1	1,5 x D	0,5 x D	1,25 x D	500	2000	fz	0,072	0,096	0,120	0,144	0,192	0,216	0,240	0,300
	2	1,5 x D	0,5 x D	1,25 x D	500	1500	fz	0,065	0,086	0,108	0,130	0,173	0,194	0,216	0,270
	3	1,5 x D	0,5 x D	1,25 x D	500	1500	fz	0,050	0,067	0,084	0,101	0,134	0,151	0,168	0,210
	4	1,5 x D	0,5 x D	1,25 x D	400	750	fz	0,050	0,067	0,084	0,101	0,134	0,151	0,168	0,210
	5	1,5 x D	0,5 x D	1,25 x D	250	1000	fz	0,065	0,086	0,108	0,130	0,173	0,194	0,216	0,270

F3BA...DL4...



Material Group		Side Milling (A) and Slotting (B) A ap	A ae	B ap	K600 Cutting Speed — vc m/min min	max	mm	Feed per Tooth — fz information is for side milling (A). For slotting (B), reduce fz by 20%. D1 — Diameter 6,0	8,0	10,0	12,0	16,0	18,0	20,0
N	1	1,0 x D	0,5 x D	1,0 x D	500	2000	fz	0,078	0,104	0,130	0,156	0,208	0,234	0,260
	2	1,0 x D	0,5 x D	1,0 x D	500	1500	fz	0,070	0,094	0,117	0,140	0,187	0,211	0,234
	3	1,0 x D	0,5 x D	1,0 x D	500	1500	fz	0,055	0,073	0,091	0,109	0,146	0,164	0,182
	4	1,0 x D	0,5 x D	1,0 x D	400	750	fz	0,055	0,073	0,091	0,109	0,146	0,164	0,182
	5	1,0 x D	0,5 x D	1,0 x D	250	1000	fz	0,070	0,094	0,117	0,140	0,187	0,211	0,234

NOTE: Those guidelines may require variations to achieve optimum results. For better surface finish, reduce feed per tooth.
Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters accordingly on >12mm diameter.
For cutting aluminium with high silicon, TiCN coating is recommended.
Ap for milling machine with ceramic bearings spindle, multiply by 0,5.
For better surface finish, reduce feed per tooth.
Side milling applications — for longest reach (L3) tools, reduce ae by 30%.
Slot milling applications — for longest reach (L3) tools, reduce ae by 30%.

CFRP KCN05™ Beyond™ Grade

Solid Carbide Routers

Primary Application

KCN05 solid carbide router products provide excellent tool life and produce smooth finishes with improved edge quality when machining difficult CFRP (carbon-fibre reinforced polymer) and non-ferrous components. The unique geometries are free cutting, reduce heat generation, and provide high-quality machined surfaces.

- Designed to avoid delamination and bur formation.
- Excellent tool life due to KCN05 diamond film coating.

Features and Benefits

Advanced Technology

- Compression-style routers for trimming designed to provide high feed rates and quality edges on both sides of the material. Up-cut/down-cut geometry promotes stable cutting conditions.
- Down-cut style routers intended for surface work. Excellent ramping capabilities eliminate surface delamination machining pockets.
- Bur style for highest material removal rates and superior surface quality. Designed for trimming fibreglass and CFRP, and for slotting and profiling.

Tailored Grades

- KCN05 diamond coating uses a proprietary substrate to optimise coating adhesion and improve tool life.

Customisation

- Intermediate diameters available.
- Compression routers with six and eight flutes available for special wire CFRP.
- Bur-style routers with end cutting, drill-point cutting, and non-end cutting point styles available on request.

Extensive Standard Offering

- Diameters 6, 10, and 12mm.
- Different length versions.
- KCN05 routers.



Up-Cut/Down-Cut Geometry
Prevents delamination because cutting forces are directed inside the workpiece.

KCN05™ Diamond Coating
For excellent tool life and smooth finishes with improved edge quality.

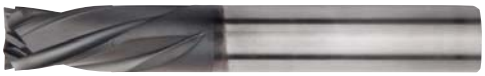


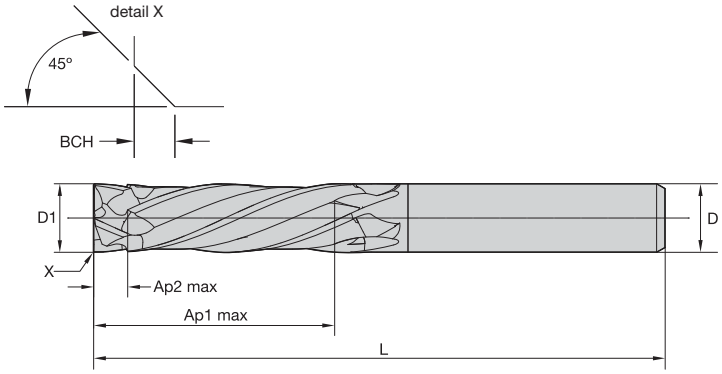
Highest Number of Cutting Edges
For excellent temperature control and highest metal removal rates.

Extended Length of Cut Version
Enables machining in different levels for multiplying tool life of same tool.

- Aerospace composites and fibreglass.
- Through-hole capability.
- Kennametal standard dimensions.
- Internal air coolant for ZU = 4.





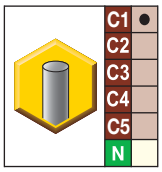


End Mill Tolerances

D1	tolerance	D	tolerance h6
All	+0/-0,05	≤3	+0/-0,006
		>3–6	+0/-0,008
		>6–10	+0/-0,009
		>10–18	+0/-0,011
		>18–24	+0/-0,013

beyond

Compression-Style Router • CCNC • Metric



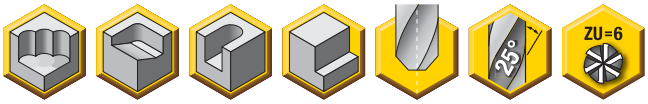
● first choice
○ alternate choice

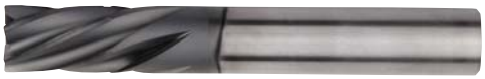
KCN05	D1	D	Ap1 max	Ap2 max	L	Z U	BCH
CCNC0600A3AH	6,00	6,00	18,01	3,18	63,00	3	0,13
CCNC0600A3BH	6,00	6,00	35,99	3,18	100,00	3	0,13
CCNC1000A4AH	10,00	10,00	18,01	3,18	83,00	4	0,13
CCNC1000A4BH	10,00	10,00	35,99	3,18	100,00	4	0,13
CCNC1200A4AH	12,00	12,00	18,01	3,18	83,00	4	0,13
CCNC1200A4BH	12,00	12,00	35,99	3,18	100,00	4	0,13

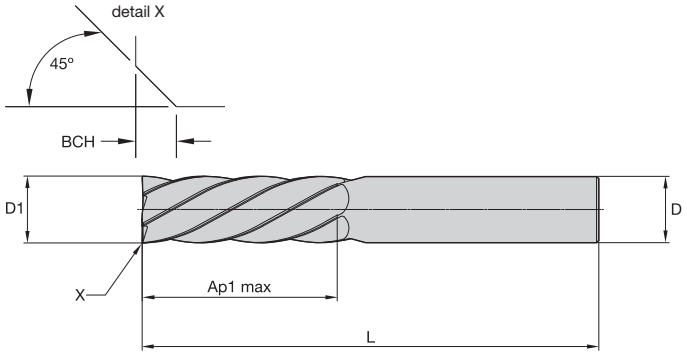
NOTE: For application data, see page P133.

C1	CFRP, CFRP/CFRP
C2	CFRP/Aluminium
C3	CFRP/Titanium
C4	CFRP/Stainless Steel
C5	CFRP/Aluminium/Titanium

- Aerospace composites and fibreglass.
- Kennametal standard dimensions.





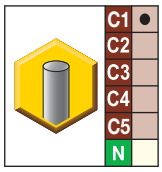


End Mill Tolerances

D1	tolerance	D	tolerance h6
All	+0/-0,05	≤3	+0/-0,006
		>3–6	+0/-0,008
		>6–10	+0/-0,009
		>10–18	+0/-0,011
		>18–24	+0/-0,013

beyond

Down-Cut Router • CDDC



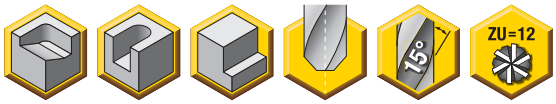
● first choice
○ alternate choice

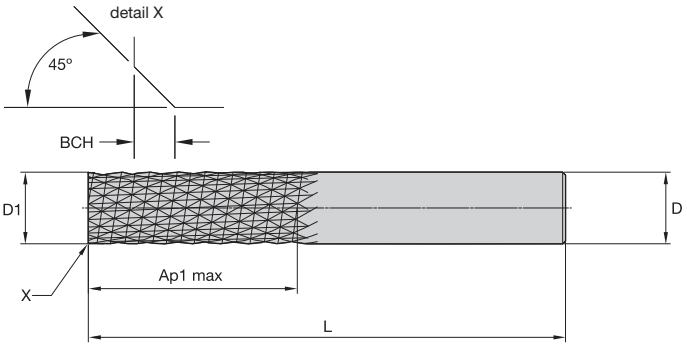
KCN05	D1	D	Ap1 max	L	BCH
CDDC0600A6AH	6,00	6,00	18,00	63,00	0,25
CDDC0600A6BH	6,00	6,00	36,00	100,00	0,25
CDDC1000A6AH	10,00	10,00	18,00	83,00	0,25
CDDC1000A6BH	10,00	10,00	36,00	100,00	0,25
CDDC1200A6AH	12,00	12,00	18,00	83,00	0,25
CDDC1200A6BH	12,00	12,00	36,00	100,00	0,25

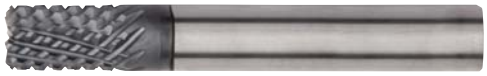
NOTE: For application data, see page P133.

C1	CFRP, CFRP/CFRP
C2	CFRP/Aluminium
C3	CFRP/Titanium
C4	CFRP/Stainless Steel
C5	CFRP/Aluminium/Titanium

- Kennametal standard dimensions.
- Aerospace composites and fibreglass.





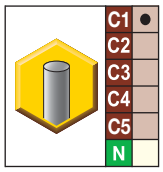


beyond

Bur-Style Router • CBDB

End Mill Tolerances

D1	tolerance	D	tolerance h6
All	+0/-0,05	≤3	+0/-0,006
		>3–6	+0/-0,008
		>6–10	+0/-0,009
		>10–18	+0/-0,011
		>18–24	+0/-0,013



● first choice
○ alternate choice

KCN05	D1	D	Ap1 max	L	Z U	BCH
CBDB0600AXAS	6,00	6,00	18,00	63,00	12	0,51
CBDB0600AXBS	6,00	6,00	36,00	100,00	12	0,51
CBDB1000AXAS	10,00	10,00	18,00	83,00	12	0,89
CBDB1000AXBS	10,00	10,00	36,00	100,00	12	0,89
CBDB1200AXAS	12,00	12,00	18,00	83,00	12	1,14
CBDB1200AXBS	12,00	12,00	36,00	100,00	12	1,14

NOTE: 12 RHS/RHC flutes. 10 LHS/RHC flutes, 6 end teeth.
For application data, see page P133.
Additional point styles are available upon request:

C1	CFRP, CFRP/CFRP
C2	CFRP/Aluminium
C3	CFRP/Titanium
C4	CFRP/Stainless Steel
C5	CFRP/Aluminium/Titanium

Additional point styles are available upon request:



End Mill End Cutting

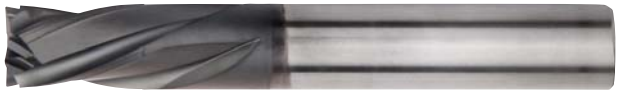


Drill-Point Cutting



Non-End Cutting

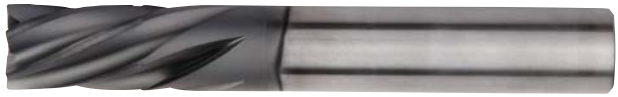
Compression-Style Router • CCNC • Metric



Material Group		Side Milling (A)		beyond KCN05			Feed per Tooth — fz information is for side milling (A).		
		A		Cutting Speed — vc m/min			D1 — Diameter		
		ap	ae	min	max	mm	6,0	10,0	12,0
C	1	Ap1 max	0,5 x D	100	150	fz	0,018	0,030	0,036

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters accordingly on >12mm diameter.

Down-Cut Router • CDDC • Metric



Material Group		Side Milling (A)		beyond KCN05			Feed per Tooth — fz information is for side milling (A).		
		A		Cutting Speed — vc m/min			D1 — Diameter		
		ap	ae	min	max	mm	6,0	10,0	12,0
C	1	Ap1 max	1 x D	100	150	fz	0,018	0,030	0,036

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters accordingly on >12mm diameter.

Bur-Style Router • CBDB • Metric



Material Group		Side Milling (A) and Slotting (B)			beyond KCN05		Feed per Revolution — fz information is for side milling (A). For slotting (B), reduce fz by 20%.			
		A		B	Cutting Speed — vc m/min			D1 — Diameter		
		ap	ae	ap	min	max	mm	6,0	10,0	12,0
C	1	Ap1 max	0,2 x D	1 x D	100	150	fz	0,15	0,25	0,30

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters accordingly on >12mm diameter.

KenFeed™

Primary Application

The numerous effective cutting edges of KenFeed end mills make them the right choice for machining heat-treated steels up to 67 HRc. The KenFeed system combines roughing and semi-finishing into one tool by taking very shallow-depth cuts at extremely high feed rates to maximise metal removal. The 3 x D neck and extended-reach design is perfectly suited for pocketing using 3D machining techniques, such as ramping and helical interpolation. During face milling, the proprietary front end geometry of the KenFeed system is entirely in contact with the workpiece, providing up to 55% engagement compared to regular ball nose-type tooling that provides only 5–10%.

- Unique tool with new 6-flute style for high productivity.
- Innovative new geometry maximises metal removal rates.
- High metal removal rates help to reduce manufacturing costs.

Features and Benefits

Advanced Technology

- Provides the benefits of indexable-style high-feed milling starting at 6mm.
- One tool for roughing and semi-finishing operations.
- Increases output by performing 3D machining, helical ramping, circular interpolation, face milling, and pocketing.
- Use in hardened materials from 40 to 67 HRC with two dedicated geometry variants.

Tailored Grades

- KC639 AlTiN-coated grade for longest tool life in hardened steels from 40 to 67 HRC.

Customisation

- Intermediate diameters available.
- Custom solutions available for machining titanium and other high-temperature alloys.
- Internal coolant axial and radial available.
- Various shank options and non-standard coatings available.

Extensive Standard Offering

- Diameter ranges 6–20mm.
- Extended neck for long-reach applications.

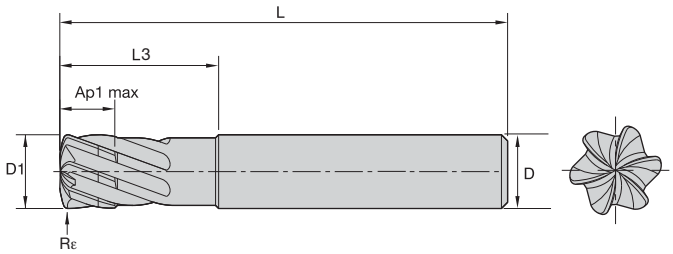
End mills for high-feed milling of medium and hard steels.





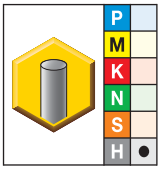
- Kennametal standard dimensions.
- Non-centre cutting.
- High feed.







KenFeed • KHDA

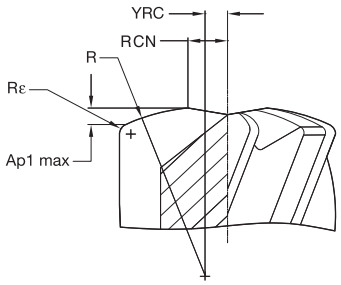


● first choice
○ alternate choice

KC639M	D1	D	D3	Ap1 max	L3	L	Rε
KHDA0600A6ANA	6,00	6,00	5,00	0,20	18,00	63,00	0,38
KHDA0800A6ANA	8,00	8,00	7,00	0,27	24,00	76,00	0,50
KHDA1000A6ANA	10,00	10,00	9,00	0,33	30,00	89,00	0,63
KHDA1200A6ANA	12,00	12,00	11,00	0,40	36,00	100,00	0,75
KHDA1600A6ANA	16,00	16,00	15,00	0,54	48,00	110,00	1,00
KHDA2000A6ANA	20,00	20,00	19,00	0,67	60,00	125,00	1,25

NOTE: For application data, see page P138.

D1	D1 tolerance	D tolerance
All	DIN e8	DIN h6



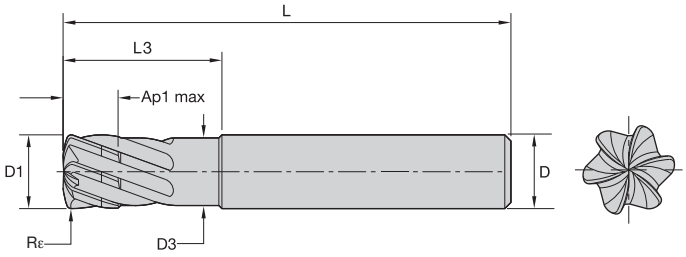
Programming Data

geometrical parameters							ramping guide for circular and linear ramping						
							circular interpolation		linear ramping				
							optimal range of circle diameter for a single pass		calculated length per ramp angle				
catalogue number	D1	Ap1 max	R	Rε	YRC	RCN	smallest	largest	1°	2°	3°	4°	5°
KHDA0600A6ANA	6	0,20	9	0,375	0,75	1,26	8,52	12,00	32,99	16,49	10,99	8,23	6,58
KHDA0800A6ANA	8	0,27	12	0,500	1,00	1,68	11,36	16,00	43,98	21,99	14,65	10,98	8,78
KHDA1000A6ANA	10	0,33	15	0,625	1,25	2,10	14,20	20,00	54,98	27,48	18,31	13,72	10,97
KHDA1200A6ANA	12	0,40	18	0,750	1,50	2,52	17,04	24,00	65,98	32,98	21,97	16,47	13,16
KHDA1600A6ANA	16	0,54	24	1,000	2,00	3,36	22,72	32,00	87,97	43,97	29,30	21,96	17,55
KHDA2000A6ANA	20	0,67	30	1,250	2,50	4,20	28,40	40,00	109,96	54,96	36,62	27,45	21,94
recommended percentage of programmed feed rate to use while ramping									100%	70%	50%	30%	10%

NOTE: YRC = distance from centre line to the crown of the R radius.
RCN = distance from centreline to the start of the cutting edge. This dimension can also help determine the minimum circle size when helical ramping.
R = the head radius size.
Rε = the shoulder radius or radius at the corner of the cutter.

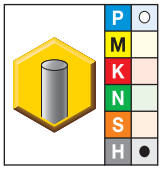
- High feed.
- Kennametal standard dimensions.
- Non-centre cutting.







KenFeed • KMDA



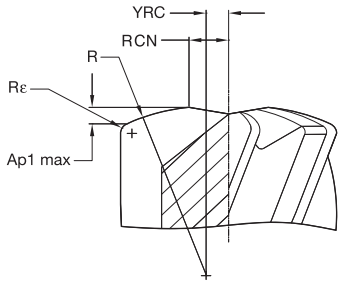
● first choice
○ alternate choice

KC639M	D1	D	D3	Ap1 max	L3	L	Rε
KMDA0600A6ANA	6,00	6,00	5,00	0,32	18,00	63,00	0,38
KMDA0800A6ANA	8,00	8,00	7,00	0,42	24,00	76,00	0,50
KMDA1000A6ANA	10,00	10,00	9,00	0,53	30,00	89,00	0,63
KMDA1200A6ANA	12,00	12,00	11,00	0,63	36,00	100,00	0,75
KMDA1600A6ANA	16,00	16,00	15,00	0,84	48,00	110,00	1,00
KMDA2000A6ANA	20,00	20,00	19,00	1,05	60,00	125,00	1,25

NOTE: For application data, see page P138.

End Mill Tolerances

D1	tolerance e8	D	tolerance h6
≤3	-0,014/-0,028	≤3	+0/-0,006
>3–6	-0,020/-0,038	>3–6	+0/-0,008
>6–10	-0,025/-0,047	>6–10	+0/-0,009
>10–18	-0,032/-0,059	>10–18	+0/-0,011
>18–30	-0,040/-0,073	>18–30	+0/-0,013



Programming Data

geometrical parameters							ramping guide for circular and linear ramping						
							circular interpolation		linear ramping				
							optimal range of circle diameter for a single pass		calculated length per ramp angle				
catalogue number	D1	Ap1 max	R	Rε	YRC	RCN	smallest	largest	1°	2°	3°	4°	5°
KMDA0600A6ANA	6	0,32	6	0,375	0,75	1,32	8,64	12,00	35,58	17,79	11,85	8,88	7,10
KMDA0800A6ANA	8	0,42	8	0,500	1,00	1,76	11,52	16,00	47,44	23,71	15,80	11,84	9,47
KMDA1000A6ANA	10	0,53	10	0,625	1,25	2,20	14,40	20,00	59,30	29,64	19,75	14,80	11,83
KMDA1200A6ANA	12	0,63	12	0,750	1,50	2,64	17,28	24,00	71,17	35,57	23,70	17,76	14,20
KMDA1600A6ANA	16	0,84	16	1,000	2,00	3,52	23,04	32,00	94,89	47,43	31,60	23,69	18,93
KMDA2000A6ANA	20	1,05	20	1,250	2,50	4,40	28,80	40,00	118,61	59,29	39,50	29,61	23,66
recommended degree of programmed feed rate to use while ramping									100%	70%	50%	30%	10%

NOTE: YRC = distance from centre line to the crown of the R radius.
RCN = distance from centreline to the start of the cutting edge. This dimension can also help determine the minimum circle size when helical ramping.
R = the head radius size.
Rε = the shoulder radius or radius at the corner of the cutter.

KenFeed • KHDA





Material Group		Profiling		KC639M		Feed per Tooth — fz information is for side milling (A).						
		A		Cutting Speed — vc m/min			D1 — Diameter					
		ap	ae	min	max	mm	6,0	8,0	10,0	12,0	16,0	20,0
H	2	0,03 x D	0,55 x D	100	120	fz	0,200	0,300	0,300	0,400	0,500	0,600
	3	0,03 x D	0,55 x D	80	100	fz	0,200	0,300	0,300	0,400	0,500	0,600
	4	0,03 x D	0,55 x D	50	70	fz	0,150	0,200	0,250	0,300	0,400	0,500

NOTE: These guidelines may require possible variations to achieve optimum results.

KenFeed • KMDA





Material Group		Profiling		KC639M		Feed per Tooth — fz information is for side milling (A).						
		A		Cutting Speed — vc m/min			D1 — Diameter					
		ap	ae	min	max	mm	6,0	8,0	10,0	12,0	16,0	20,0
P	4	0,05 x D	0,55 x D	160	180	fz	0,300	0,500	0,500	0,500	0,600	0,700
H	1	0,05 x D	0,55 x D	140	160	fz	0,300	0,500	0,500	0,500	0,600	0,700
	2	0,05 x D	0,55 x D	100	120	fz	0,200	0,300	0,300	0,400	0,500	0,600

NOTE: These guidelines may require possible variations to achieve optimum results.

GOmill™ GP

General Purpose End Mill Series

- Flexible — plunging, slotting, and profiling.
- Complete — wide range of diameters and lengths.
- Adaptive — wide range of applications and workpiece materials.
- Economical — excellent cost-benefit ratio.



Offering

- 2-flute version for unstable conditions.
- 3-flute version as alternative to 2 and 4 flutes.
- 4-flute version for high metal removal rates.

Advanced Technology

- Roughing and finishing with one tool.
- Eccentric relief increases edge stability.

Visit **kennametal.com** or contact your local Authorised Kennametal Distributor.

KENNAMETAL®

kennametal.com

High-Performance Hard-Machining Solid Carbide End Mills

Primary Application

These end mills from Kennametal for hard machining are engineered to machine hardened steels up to 67 HRC at extreme speeds and feeds. Designed with special coatings, substrates, and geometries to extend tool life in any application that requires machining of hardened workpiece materials.

- Capable of machining hardened steels more than 60 HRC.
- Unique design enables higher feeds and speeds to increase Metal Removal Rates (MRR).
- Sophisticated coatings for maximum wear resistance.

Features and Benefits

Advanced Technology

- Negative geometry for increased edge strength.
- Reinforced core for better rigidity.
- High helix for better surface finishes.

Tailored Grades

- Universal grade KC633M™.
- KC637M hard machining dedicated TiAlN coated wear-resistant substrate for highest tool life at materials above 48 HRC.

Customisation

- Intermediate diameters available.
- Expanded length of tool, as well as increased length of cut possible.
- Various shank options and non-standard coatings available.
- AlTiN grade KC643M™ available as custom solution.

Extensive Standard Offering

- Diameter ranges 2–25mm.
- Extended neck for long-reach applications and radii and sharp corner configurations.
- Toroidal, tapered ball nose as well as undercutting end mills (Spherical Lollipop-Style).

Sophisticated coatings for maximum wear resistance.



Parabolic Core Design
Proprietary technology stabilises end mill to avoid deflection in longer length of cut.

Various Helix End Mill Versions
Dedicated application-specific design.

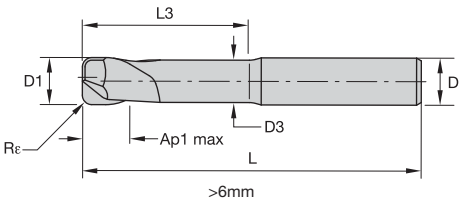


KC637M and KC633M™ TiAlN-Coated Substrate.
For longest tool life in challenging applications.

- Kennametal standard dimensions.
- Centre cutting.



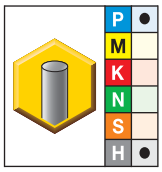




End Mill Tolerances

D1	tolerance e8	D	tolerance h6
≤3	-0,014/-0,028	≤3	+0/-0,006
>3–6	-0,020/-0,038	>3–6	+0/-0,008
>6–10	-0,025/-0,047	>6–10	+0/-0,009
>10–18	-0,032/-0,059	>10–18	+0/-0,011
>18–30	-0,040/-0,073	>18–30	+0/-0,013

F2AT...WM-WL-WX • Toroidal End • Long Reach



● first choice
○ alternate choice

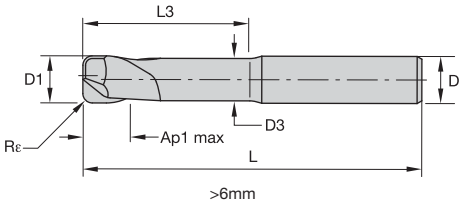
KC637M	D1	D	D3	Ap1 max	L3	L	Rε
F2AT0200AWM20R003	2,00	6,00	1,70	2,00	17,50	70,00	0,30
F2AT0200AWM20R005	2,00	6,00	1,70	2,00	17,50	70,00	0,50
F2AT0300AWM20R005	3,00	6,00	2,50	3,00	18,50	70,00	0,50
F2AT0300AWM20R010	3,00	6,00	2,50	3,00	18,50	70,00	1,00
F2AT0400AWL20R005	4,00	6,00	3,50	4,00	19,50	80,00	0,50
F2AT0400AWL20R010	4,00	6,00	3,50	4,00	19,50	80,00	1,00
F2AT0500AWL20R005	5,00	6,00	4,50	5,00	44,00	80,00	0,50
F2AT0500AWL20R010	5,00	6,00	4,50	5,00	44,00	80,00	1,00
F2AT0600AWL20R005	6,00	6,00	5,50	6,00	44,00	80,00	0,50
F2AT0600AWL20R010	6,00	6,00	5,50	6,00	44,00	80,00	1,00
F2AT0800AWL20R010	8,00	8,00	7,00	8,00	54,00	90,00	1,00
F2AT0800AWL20R020	8,00	8,00	7,00	8,00	54,00	90,00	2,00
F2AT1000AWL20R010	10,00	10,00	9,00	10,00	60,00	100,00	1,00
F2AT1000AWL20R020	10,00	10,00	9,00	10,00	60,00	100,00	2,00
F2AT1000AWL20R030	10,00	10,00	9,00	10,00	60,00	100,00	3,00
F2AT1200AWX20R005	12,00	12,00	11,00	12,00	65,00	110,00	0,50
F2AT1200AWX20R010	12,00	12,00	11,00	12,00	65,00	110,00	1,00
F2AT1200AWX20R030	12,00	12,00	11,00	12,00	65,00	110,00	3,00

NOTE: For application data, see page P152.

- Kennametal standard dimensions.
- Centre cutting.



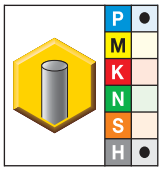




End Mill Tolerances

D1	tolerance e8	D	tolerance h6
≤3	-0,014/-0,028	≤3	+0/-0,006
>3–6	-0,020/-0,038	>3–6	+0/-0,008
>6–10	-0,025/-0,047	>6–10	+0/-0,009
>10–18	-0,032/-0,059	>10–18	+0/-0,011
>18–30	-0,040/-0,073	>18–30	+0/-0,013

F4AT...WS-WM-WL-WX • Toroidal End • Long Reach



● first choice
○ alternate choice

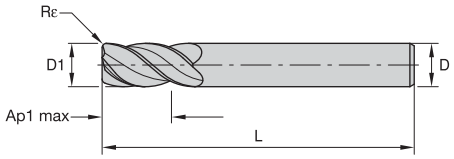
KC637M	D1	D	D3	Ap1 max	L3	L	Rε
F4AT0400AWS20R005	4,00	6,00	3,80	2,00	10,00	45,00	0,50
F4AT0400AWS20R010	4,00	6,00	3,80	2,00	10,00	45,00	1,00
F4AT0500AWS20R005	5,00	6,00	4,80	2,50	12,00	50,00	0,50
F4AT0500AWS20R010	5,00	6,00	4,80	2,50	12,00	50,00	1,00
F4AT0600AWS20R005	6,00	6,00	5,80	3,00	12,00	50,00	0,50
F4AT0600AWL20R005	6,00	6,00	5,80	6,00	42,00	80,00	0,50
F4AT0600AWL20R010	6,00	6,00	5,80	6,00	42,00	80,00	1,00
F4AT0800AWM20R010	8,00	8,00	7,80	4,00	20,00	60,00	1,00
F4AT0800AWM20R020	8,00	8,00	7,80	4,00	20,00	60,00	2,00
F4AT0800AWL20R005	8,00	8,00	7,80	8,00	52,00	90,00	0,50
F4AT0800AWL20R010	8,00	8,00	7,80	8,00	52,00	90,00	1,00
F4AT0800AWL20R020	8,00	8,00	7,80	8,00	52,00	90,00	2,00
F4AT1000AWM20R005	10,00	10,00	9,80	5,00	24,00	70,00	0,50
F4AT1000AWM20R025	10,00	10,00	9,80	5,00	24,00	70,00	2,50
F4AT1000AWL20R005	10,00	10,00	9,70	10,00	58,00	100,00	0,50
F4AT1000AWL20R010	10,00	10,00	9,70	10,00	58,00	100,00	1,00
F4AT1000AWL20R020	10,00	10,00	9,70	10,00	58,00	100,00	2,00
F4AT1000AWL20R025	10,00	10,00	9,70	10,00	58,00	100,00	2,50
F4AT1200AWL20R015	12,00	12,00	11,80	6,00	24,00	75,00	1,50
F4AT1200AWL20R030	12,00	12,00	11,80	6,00	24,00	75,00	3,00
F4AT1200AWX20R010	12,00	12,00	11,70	12,00	62,00	110,00	1,00
F4AT1200AWX20R015	12,00	12,00	11,70	12,00	62,00	110,00	1,50
F4AT1200AWX20R030	12,00	12,00	11,70	12,00	62,00	110,00	3,00

NOTE: For application data, see page P152.

- Kennametal standard dimensions.
- Centre cutting.



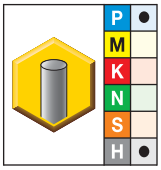




End Mill Tolerances

D1	tolerance e8	D	tolerance h6
≤3	-0,014/-0,028	≤3	+0/-0,006
>3–6	-0,020/-0,038	>3–6	+0/-0,008
>6–10	-0,025/-0,047	>6–10	+0/-0,009
>10–18	-0,032/-0,059	>10–18	+0/-0,011
>18–30	-0,040/-0,073	>18–30	+0/-0,013

F4AJ-F5AJ...WS-WM-WL-WX • Long



● first choice
○ alternate choice

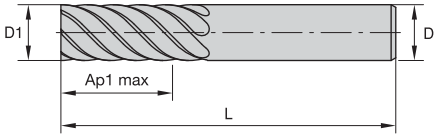
KC633M	D1	D	Ap1 max	L	Rε	Z U
F4AJ0600AWS50R025	6,00	6,00	9,00	50,00	0,25	4
F4AJ0600AWS50R050	6,00	6,00	9,00	50,00	0,50	4
F4AJ0800AWM50R050	8,00	8,00	12,00	63,00	0,50	4
F4AJ0800AWM50R100	8,00	8,00	12,00	63,00	1,00	4
F4AJ1000AWL50R050	10,00	10,00	15,00	76,00	0,50	4
F4AJ1000AWL50R100	10,00	10,00	15,00	76,00	1,00	4
F4AJ1200AWL50R050	12,00	12,00	18,00	76,00	0,50	4
F4AJ1200AWL50R150	12,00	12,00	18,00	76,00	1,50	4
F4AJ1600AWL50R050	16,00	16,00	24,00	89,00	0,50	4
F4AJ1600AWL50R150	16,00	16,00	24,00	89,00	1,50	4
F4AJ2000AWX50R050	20,00	20,00	30,00	104,00	0,50	4
F4AJ2000AWX50R200	20,00	20,00	30,00	104,00	2,00	4

NOTE: For application data, see page P152.

- Kennametal standard dimensions.
- Centre cutting.



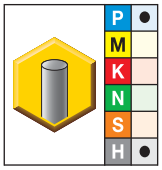




End Mill Tolerances

D1	tolerance e8	D	tolerance h6
≤3	-0,014/-0,028	≤3	+0/-0,006
>3–6	-0,020/-0,038	>3–6	+0/-0,008
>6–10	-0,025/-0,047	>6–10	+0/-0,009
>10–18	-0,032/-0,059	>10–18	+0/-0,011
>18–30	-0,040/-0,073	>18–30	+0/-0,013

F4AJ-F5AJ-F6AJ...WS-WL-WX • Extra Long



● first choice
○ alternate choice

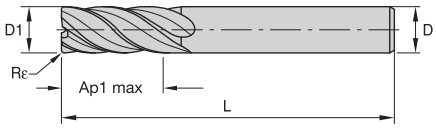
KC633M	D1	D	Ap1 max	L	Z U
F4AJ0600AWS50L090	6,00	6,00	9,00	50,00	4
F4AJ0800AWM50L120	8,00	8,00	12,00	63,00	4
F4AJ1000AWM50L150	10,00	10,00	15,00	76,00	4
F4AJ1600AWL50L240	16,00	16,00	24,00	89,00	4
F4AJ2000AWL50L300	20,00	20,00	30,00	104,00	4
F5AJ2500AWX50L380	25,00	25,00	38,00	121,00	5

NOTE: For application data, see page P153.

- Kennametal standard dimensions.
- Centre cutting.



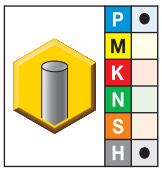




End Mill Tolerances

D1	tolerance e8	D	tolerance h6
≤3	-0,014/-0,028	≤3	+0/-0,006
>3–6	-0,020/-0,038	>3–6	+0/-0,008
>6–10	-0,025/-0,047	>6–10	+0/-0,009
>10–18	-0,032/-0,059	>10–18	+0/-0,011
>18–30	-0,040/-0,073	>18–30	+0/-0,013

F6AV-F8AV...DL • DIN 6527 • Long • Extra Long

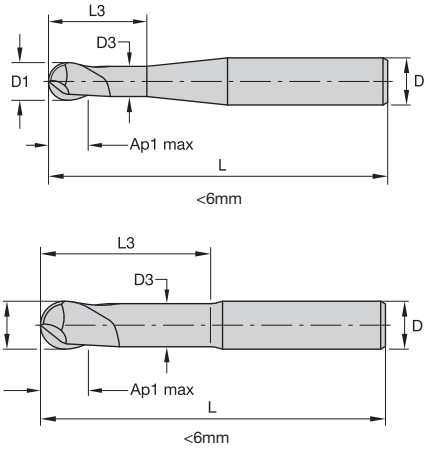


● first choice
○ alternate choice

KC637M	D1	D	Ap1 max	L	Rε	Z U
F6AV0600ADL45	6,00	6,00	13,00	57,00	0,50	6
F6AV0600AWM45	6,00	6,00	18,00	62,00	0,50	6
F6AV0800ADL45	8,00	8,00	19,00	63,00	0,50	6
F6AV0800AWM45	8,00	8,00	24,00	68,00	0,50	6
F6AV1000ADL45	10,00	10,00	22,00	72,00	0,50	6
F6AV1000AWL45	10,00	10,00	30,00	80,00	0,50	6
F6AV1200ADL45	12,00	12,00	26,00	83,00	1,00	6
F6AV1200AWL45	12,00	12,00	36,00	93,00	1,00	6
F6AV1600ADL45	16,00	16,00	32,00	92,00	1,00	6
F6AV1600AWX45	16,00	16,00	48,00	108,00	1,00	6
F8AV2000ADL45	20,00	20,00	38,00	104,00	1,00	8
F8AV2000AWX45	20,00	20,00	60,00	126,00	1,00	8
F8AV2500ADL45	25,00	25,00	45,00	121,00	1,50	8
F8AV2500AWX45	25,00	25,00	75,00	150,00	1,50	8

NOTE: For application data, see page P153.

- Kennametal standard dimensions.
- Centre cutting.

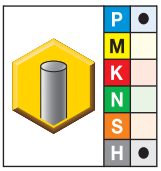




End Mill Tolerances

D1	tolerance h10	D	tolerance h6
≤3	+0/-0,040	≤3	+0-/0,006
>3–6	+0/-0,048	>3–6	+0/-0,008
>6–10	+0/-0,058	>6–10	+0/-0,009
>10–18	+0/-0,070	>10–18	+0/-0,011
>18–30	+0/-0,084	>18–30	+0/-0,013

F2AL...WL-WM-WX • Ball Nose • Extended Neck



● first choice
○ alternate choice

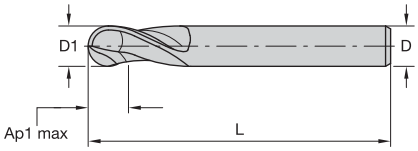
KC637M	D1	D	D3	Ap1 max	L3	L
F2AL0200AWM20	2,00	6,00	1,70	2,00	17,50	70,00
F2AL0300AWM20	3,00	6,00	2,50	3,00	18,50	70,00
F2AL0400AWL20	4,00	6,00	3,50	4,00	19,50	80,00
F2AL0500AWL20	5,00	6,00	4,50	5,00	44,00	80,00
F2AL0600AWL20	6,00	6,00	5,50	6,00	44,00	80,00
F2AL0800AWL20	8,00	8,00	7,00	8,00	54,00	90,00
F2AL1000AWL20	10,00	10,00	9,00	10,00	60,00	100,00
F2AL1200AWX20	12,00	12,00	11,70	12,00	65,00	110,00

NOTE: For application data, see page P154.

- Kennametal standard dimensions.
- Centre cutting.



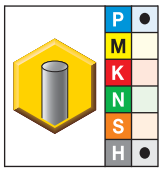




End Mill Tolerances

D1	tolerance h10	D	tolerance h6
≤3	+0/-0,040	≤3	+0/-0,006
>3–6	+0/-0,048	>3–6	+0/-0,008
>6–10	+0/-0,058	>6–10	+0/-0,009
>10–18	+0/-0,070	>10–18	+0/-0,011
>18–30	+0/-0,084	>18–30	+0/-0,013

F2AL...WL-WM • Ball Nose



● first choice
○ alternate choice

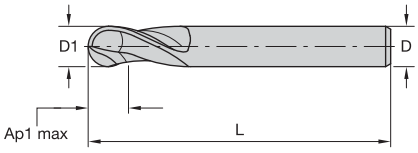
KC637M	D1	D	Ap1 max	L
F2AL0100AWL30	1,00	4,00	1,00	40,00
F2AL0150AWL30	1,50	4,00	1,50	40,00
F2AL0200AWL30	2,00	6,00	2,00	45,00
F2AL0300AWL30	3,00	6,00	3,00	45,00
F2AL0400AWL30	4,00	6,00	4,00	45,00
F2AL0500AWL30	5,00	6,00	5,00	50,00
F2AL0600AWL30	6,00	6,00	6,00	50,00
F2AL0800AWL30	8,00	8,00	8,00	60,00
F2AL1000AWM30	10,00	10,00	10,00	70,00
F2AL1200AWM30	12,00	12,00	12,00	75,00
F2AL1600AWM30	16,00	16,00	16,00	80,00

NOTE: For application data, see page P155.

- Kennametal standard dimensions.
- Centre cutting.



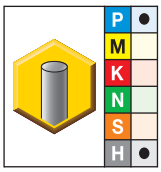




End Mill Tolerances

D1	tolerance h10	D	tolerance h6
≤3	+0/-0,040	≤3	+0/-0,006
>3–6	+0/-0,048	>3–6	+0/-0,008
>6–10	+0/-0,058	>6–10	+0/-0,009
>10–18	+0/-0,070	>10–18	+0/-0,011
>18–30	+0/-0,084	>18–30	+0/-0,013

F2AL...WL-WM-WX • Ball Nose • Long



● first choice
○ alternate choice

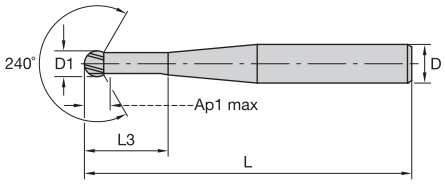
KC637M	D1	D	Ap1 max	L
F2AL0600AWM30	6,00	6,00	6,00	80,00
F2AL0800AWM30	8,00	8,00	8,00	90,00
F2AL1000AWL30	10,00	10,00	10,00	100,00
F2AL1200AWX30	12,00	12,00	12,00	110,00
F2AL1600AWX30	16,00	16,00	16,00	140,00

NOTE: For application data, see page P156.

- Kennametal standard dimensions.
- Centre cutting.



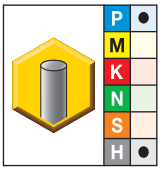




End Mill Tolerances

D1	tolerance h10	D	tolerance h6
≤3	+0/-0,040	≤3	+0/-0,006
>3–6	+0/-0,048	>3–6	+0/-0,008
>6–10	+0/-0,058	>6–10	+0/-0,009
>10–18	+0/-0,070	>10–18	+0/-0,011
>18–30	+0/-0,084	>18–30	+0/-0,013

F2AB...WL-WM-WX • Ball Nose • Extended Neck



● first choice
○ alternate choice

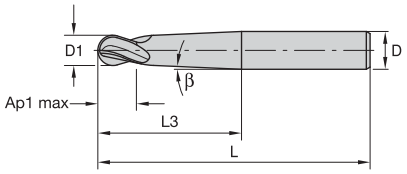
KC637M	D1	D	Ap1 max	L3	L
F2AB0200AWM30	2,00	6,00	1,00	17,00	70,00
F2AB0300AWM30	3,00	6,00	1,50	18,00	70,00
F2AB0400AWL30	4,00	6,00	2,00	19,00	80,00
F2AB0500AWL30	5,00	6,00	2,50	42,00	80,00
F2AB0600AWL30	6,00	6,00	3,00	42,00	80,00
F2AB1000AWL30	10,00	10,00	5,00	58,00	100,00
F2AB1200AWX30	12,00	12,00	6,00	63,00	110,00

NOTE: For application data, see page P157.

- Kennametal standard dimensions.
- Centre cutting.



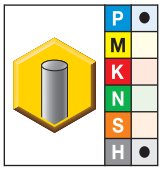




End Mill Tolerances

D1	tolerance h8	D	tolerance h6
≤3	+0/-0,014	≤3	+0/-0,006
>3–6	+0/-0,018	>3–6	+0/-0,008
>6–10	+0/-0,022	>6–10	+0/-0,009
>10–18	+0/-0,027	>10–18	+0/-0,011
>18–30	+0/-0,033	>18–30	+0/-0,013

F4AL...WL-WM-WX • Ball Nose • Tapered Neck



● first choice
○ alternate choice

KC637M	D1	D	Ap1 max	L3	L	β
F4AL0300AWM30L040	3,00	6,00	4,00	4,00	75,00	2.85
F4AL0300AWL30L040	3,00	6,00	4,00	4,00	100,00	1.65
F4AL0400AWM30L050	4,00	6,00	5,00	5,00	75,00	2.67
F4AL0400AWL30L050	4,00	6,00	5,00	5,00	100,00	1.18
F4AL0500AWM30L060	5,00	6,00	6,00	6,00	75,00	1.33
F4AL0500AWL30L060	5,00	8,00	6,00	6,00	100,00	1.75
F4AL0600AWM30L080	6,00	8,00	8,00	8,00	75,00	2.38
F4AL0600AWL30L080	6,00	10,00	8,00	8,00	100,00	2.52
F4AL0800AWL30L120	8,00	10,00	12,00	12,00	100,00	1.52
F4AL0800AWX30L120	8,00	12,00	12,00	12,00	150,00	1.40
F4AL1000AWL30L150	10,00	12,00	15,00	15,00	100,00	1.83
F4AL1000AWX30L150	10,00	12,00	15,00	15,00	150,00	0.80

NOTE: For application data, see page P158.

F2AT...WM-WL-WX • Toroidal End • Long Reach



Material Group		Side Milling (A) and Slotting (B)			KC637M		Feed per Tooth — fz information is for side milling (A). For slotting (B), reduce fz by 20%.								
		A		B	Cutting Speed — vc m/min			D1 — Diameter							
		ap	ae	ap	min	max	mm	2,0	3,0	4,0	5,0	6,0	8,0	10,0	12,0
P	3	0,5 x D	0,4 x D	0,3 x D	120	160	fz	0,011	0,017	0,026	0,033	0,040	0,055	0,067	0,077
	4	0,5 x D	0,4 x D	0,3 x D	90	150	fz	0,010	0,016	0,024	0,030	0,036	0,049	0,059	0,069
H	1	0,5 x D	0,4 x D	0,3 x D	80	140	fz	0,010	0,016	0,024	0,030	0,036	0,049	0,059	0,069
	2	0,5 x D	0,3 x D	0,2 x D	60	80	fz	0,012	0,016	0,018	0,022	0,027	0,037	0,044	0,051
	3	0,5 x D	0,15 x D	0,15 x D	50	70	fz	0,009	0,013	0,014	0,018	0,021	0,029	0,035	0,041
	4	0,5 x D	0,1 x D	0,1 x D	40	60	fz	0,006	0,008	0,009	0,012	0,014	0,019	0,023	0,027

NOTE: These guidelines may require possible variations to achieve optimum results.
Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters accordingly on >12mm diameter.

F4AT...WS-WM-WL-WX • Toroidal End • Long Reach



Material Group		Side Milling (A) and Slotting (B)			KC637M		Feed per Tooth — fz information is for side milling (A). For slotting (B), reduce fz by 20%.						
		A		B	Cutting Speed — vc m/min			D1 — Diameter					
		ap	ae	ap	min	max	mm	4,0	5,0	6,0	8,0	10,0	12,0
P	3	0,5 x D	0,4 x D	0,3 x D	120	160	fz	0,026	0,033	0,040	0,055	0,067	0,077
	4	0,5 x D	0,4 x D	0,3 x D	90	150	fz	0,024	0,030	0,036	0,049	0,059	0,069
H	1	0,5 x D	0,4 x D	0,3 x D	80	140	fz	0,024	0,030	0,036	0,049	0,059	0,069
	2	0,5 x D	0,3 x D	0,2 x D	60	80	fz	0,018	0,022	0,027	0,037	0,044	0,051
	3	0,5 x D	0,15 x D	0,15 x D	50	70	fz	0,014	0,018	0,021	0,029	0,035	0,041
	4	0,5 x D	0,1 x D	0,1 x D	40	60	fz	0,009	0,012	0,014	0,019	0,023	0,027

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters accordingly on >12mm diameter.

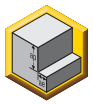
F4AJ-F5AJ...WS-WM-WL-WX • Long



Material Group		Side Milling (A) and Slotting (B)			KC633M		Feed per Tooth — fz information is for side milling (A). For slotting (B), reduce fz by 20%.								
		A		B	Cutting Speed — vc m/min			D1 — Diameter							
		ap	ae	ap	min	max	mm	4,0	5,0	6,0	8,0	10,0	12,0	16,0	20,0	25,0
P	3	1 x D	0,4 x D	1 x D	160	180	fz	0,026	0,033	0,040	0,055	0,067	0,077	0,096	0,111	0,125
	4	1 x D	0,4 x D	0,75 x D	140	160	fz	0,024	0,030	0,036	0,049	0,059	0,069	0,084	0,097	0,107
H	1	1 x D	0,4 x D	0,75 x D	120	140	fz	0,024	0,030	0,036	0,049	0,059	0,069	0,084	0,097	0,107
	2	1 x D	0,3 x D	0,5 x D	80	130	fz	0,018	0,022	0,027	0,037	0,044	0,051	0,063	0,071	0,078
	3	1 x D	0,15 x D	0,3 x D	70	100	fz	0,014	0,018	0,021	0,029	0,035	0,041	0,051	0,059	0,067
	4	1 x D	0,1 x D	0,15 x D	50	70	fz	0,009	0,012	0,014	0,019	0,023	0,027	0,034	0,039	0,044

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters accordingly on >12mm diameter.

F4AJ-F5AJ-F6AJ...WS-WL-WX • Extra Long

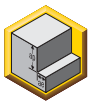




Material Group		Side Milling (A) and Slotting (B)			KC633M		Feed per Tooth — fz information is for side milling (A). For slotting (B), reduce fz by 20%.							
		A		B	Cutting Speed — vc m/min		D1 — Diameter							
		ap	ae	ap	min	max	mm	6,0	8,0	10,0	12,0	16,0	20,0	25,0
P	3	1 x D	0,4 x D	1 x D	160	180	fz	0,040	0,055	0,067	0,077	0,096	0,111	0,125
	4	1 x D	0,4 x D	0,75 x D	140	160	fz	0,036	0,049	0,059	0,069	0,084	0,097	0,107
H	1	1 x D	0,4 x D	0,75 x D	120	140	fz	0,036	0,049	0,059	0,069	0,084	0,097	0,107
	2	1 x D	0,3 x D	0,5 x D	80	130	fz	0,027	0,037	0,044	0,051	0,063	0,071	0,078
	3	1 x D	0,15 x D	0,3 x D	70	100	fz	0,021	0,029	0,035	0,041	0,051	0,059	0,067
	4	1 x D	0,1 x D	0,15 x D	50	70	fz	0,014	0,019	0,023	0,027	0,034	0,039	0,044

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters accordingly on >12mm diameter.

F6AV/F8AV..DL/WM/WX




Material Group		Side Milling (A)		KC637M		Feed per Tooth — fz information is for side milling (A).							
		A		Cutting Speed — vc m/min			D1 — Diameter						
		ap	ae	min	max	mm	6,0	8,0	10,0	12,0	16,0	20,0	25,0
P	3	Ap max	0,1 x D	120	160	fz	0,040	0,055	0,067	0,077	0,096	0,111	0,125
	4	Ap max	0,1 x D	90	150	fz	0,036	0,049	0,059	0,069	0,084	0,097	0,107
H	1	Ap max	0,1 x D	80	140	fz	0,036	0,049	0,059	0,069	0,084	0,097	0,107
	2	Ap max	0,1 x D	70	120	fz	0,027	0,037	0,044	0,051	0,063	0,071	0,078
	3	Ap max	0,1 x D	60	90	fz	0,021	0,029	0,035	0,041	0,051	0,059	0,067
	4	Ap max	0,05 x D	50	70	fz	0,014	0,019	0,023	0,027	0,034	0,039	0,044

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters accordingly on >12mm diameter.

F2AL...WL-WM-WX • Ball Nose • Extended Neck





Material Group		Profiling		KC637M		Roughing — Feed per Tooth — fz information is for side milling (A).								
		A		Cutting Speed — vc m/min			D1 — Diameter							
		ap	ae	min	max	mm	2,0	3,0	4,0	5,0	6,0	8,0	10,0	12,0
P	3	0,2 x D	0,1 x D	208	234	fz	0,015	0,023	0,031	0,040	0,049	0,067	0,081	0,094
	4	0,2 x D	0,1 x D	182	208	fz	0,014	0,021	0,029	0,036	0,044	0,060	0,073	0,084
H	1	0,15 x D	0,1 x D	140	196	fz	0,021	0,032	0,043	0,054	0,066	0,090	0,109	0,125
	2	0,1 x D	0,075 x D	119	204	fz	0,024	0,036	0,048	0,061	0,074	0,101	0,121	0,140
	3	0,05 x D	0,05 x D	138	207	fz	0,027	0,041	0,055	0,069	0,084	0,114	0,138	0,161
	4	0,05 x D	0,05 x D	115	161	fz	0,018	0,027	0,037	0,046	0,056	0,076	0,092	0,107





Material Group		Profiling		KC637M		Semi-Finishing — Feed per Tooth — fz information is for side milling (A).								
		A		Cutting Speed — vc m/min			D1 — Diameter							
		ap	ae	min	max	mm	2,0	3,0	4,0	5,0	6,0	8,0	10,0	12,0
P	3	0,1 x D	0,05 x D	272	306	fz	0,034	0,052	0,070	0,089	0,109	0,150	0,182	0,211
	4	0,1 x D	0,05 x D	238	272	fz	0,031	0,048	0,064	0,081	0,099	0,134	0,162	0,187
H	1	0,07 x D	0,1 x D	200	280	fz	0,039	0,060	0,080	0,102	0,123	0,168	0,203	0,234
	2	0,05 x D	0,04 x D	161	276	fz	0,034	0,052	0,070	0,088	0,107	0,145	0,174	0,201
	3	0,03 x D	0,03 x D	174	261	fz	0,031	0,047	0,063	0,079	0,096	0,130	0,158	0,183
	4	0,03 x D	0,03 x D	145	203	fz	0,021	0,031	0,042	0,053	0,064	0,087	0,105	0,122





Material Group		Profiling		KC637M		Finishing — Feed per Tooth — fz information is for side milling (A).								
		A		Cutting Speed — vc m/min			D1 — Diameter							
		ap	ae	min	max	mm	2,0	3,0	4,0	5,0	6,0	8,0	10,0	12,0
P	3	0,04 x D	0,04 x D	416	468	fz	0,052	0,080	0,108	0,137	0,168	0,231	0,279	0,324
	4	0,04 x D	0,04 x D	364	416	fz	0,048	0,073	0,099	0,125	0,152	0,207	0,249	0,288
H	1	0,03 x D	0,03 x D	290	406	fz	0,052	0,078	0,106	0,134	0,162	0,221	0,266	0,308
	2	0,03 x D	0,03 x D	203	348	fz	0,039	0,059	0,080	0,101	0,122	0,166	0,199	0,230
	3	0,02 x D	0,02 x D	216	324	fz	0,033	0,050	0,067	0,084	0,102	0,139	0,168	0,196
	4	0,02 x D	0,02 x D	180	252	fz	0,022	0,033	0,045	0,056	0,068	0,093	0,112	0,130

F2AL...WL-WM • Ball Nose

Material Group		Profiling		KC637M		Roughing — Feed per Tooth — fz information is for side milling (A).								
		A		Cutting Speed — vc m/min			D1 — Diameter							
		ap	ae	min	max	mm	1,0	2,0	4,0	6,0	8,0	10,0	12,0	16,0
P	3	0,2 x D	0,1 x D	208	234	fz	0,007	0,015	0,031	0,049	0,067	0,081	0,094	0,117
	4	0,2 x D	0,1 x D	182	208	fz	0,007	0,014	0,029	0,044	0,060	0,073	0,084	0,103
H	1	0,15 x D	0,1 x D	140	196	fz	0,010	0,021	0,043	0,066	0,090	0,109	0,125	0,154
	2	0,1 x D	0,075 x D	119	204	fz	0,012	0,024	0,048	0,074	0,101	0,121	0,140	0,171
	3	0,05 x D	0,05 x D	138	207	fz	0,013	0,027	0,055	0,084	0,114	0,138	0,161	0,200
	4	0,05 x D	0,05 x D	115	161	fz	0,009	0,018	0,037	0,056	0,076	0,092	0,107	0,133

Material Group		Profiling		KC637M		Semi-Finishing — Feed per Tooth — fz information is for side milling (A).								
		A		Cutting Speed — vc m/min			D1 — Diameter							
		ap	ae	min	max	mm	1,0	2,0	4,0	6,0	8,0	10,0	12,0	16,0
P	3	0,1 x D	0,05 x D	272	306	fz	0,017	0,034	0,070	0,109	0,150	0,182	0,211	0,262
	4	0,1 x D	0,05 x D	238	272	fz	0,016	0,031	0,064	0,099	0,134	0,162	0,187	0,230
H	1	0,07 x D	0,1 x D	200	280	fz	0,019	0,039	0,080	0,123	0,168	0,203	0,234	0,288
	2	0,05 x D	0,04 x D	161	276	fz	0,017	0,034	0,070	0,107	0,145	0,174	0,201	0,246
	3	0,03 x D	0,03 x D	174	261	fz	0,015	0,031	0,063	0,096	0,130	0,158	0,183	0,229
	4	0,03 x D	0,03 x D	145	203	fz	0,010	0,021	0,042	0,064	0,087	0,105	0,122	0,151

Material Group		Profiling		KC637M		Finishing — Feed per Tooth — fz information is for side milling (A).								
		A		Cutting Speed — vc m/min			D1 — Diameter							
		ap	ae	min	max	mm	1,0	2,0	4,0	6,0	8,0	10,0	12,0	16,0
P	3	0,04 x D	0,04 x D	416	468	fz	0,026	0,052	0,108	0,168	0,231	0,279	0,324	0,403
	4	0,04 x D	0,04 x D	364	416	fz	0,024	0,048	0,099	0,152	0,207	0,249	0,288	0,355
H	1	0,03 x D	0,03 x D	290	406	fz	0,025	0,052	0,106	0,162	0,221	0,266	0,308	0,379
	2	0,03 x D	0,03 x D	203	348	fz	0,019	0,039	0,080	0,122	0,166	0,199	0,230	0,281
	3	0,02 x D	0,02 x D	216	324	fz	0,016	0,033	0,067	0,102	0,139	0,168	0,196	0,244
	4	0,02 x D	0,02 x D	180	252	fz	0,011	0,022	0,045	0,068	0,093	0,112	0,130	0,162

F2AL...WL-WM-WX • Ball Nose • Long





Material Group		Profiling		KC637M		Finishing — Feed per Tooth — fz information is for side milling (A).								
		A		Cutting Speed — vc m/min			D1 — Diameter							
		ap	ae	min	max	mm	1,0	2,0	4,0	6,0	8,0	10,0	12,0	16,0
P	3	0,04 x D	0,04 x D	416	468	fz	0,026	0,052	0,108	0,168	0,231	0,279	0,324	0,403
	4	0,04 x D	0,04 x D	364	416	fz	0,024	0,048	0,099	0,152	0,207	0,249	0,288	0,355
H	1	0,03 x D	0,03 x D	290	406	fz	0,025	0,052	0,106	0,162	0,221	0,266	0,308	0,379
	2	0,03 x D	0,03 x D	203	348	fz	0,019	0,039	0,080	0,122	0,166	0,199	0,230	0,281
	3	0,02 x D	0,02 x D	216	324	fz	0,016	0,033	0,067	0,102	0,139	0,168	0,196	0,244
	4	0,02 x D	0,02 x D	180	252	fz	0,011	0,022	0,045	0,068	0,093	0,112	0,130	0,162





Material Group		Profiling		KC637M		Semi-Finishing — Feed per Tooth — fz information is for side milling (A).								
		A		Cutting Speed — vc m/min			D1 — Diameter							
		ap	ae	min	max	mm	1,0	2,0	4,0	6,0	8,0	10,0	12,0	16,0
P	3	0,1 x D	0,05 x D	272	306	fz	0,017	0,034	0,070	0,109	0,150	0,182	0,211	0,262
	4	0,1 x D	0,05 x D	238	272	fz	0,016	0,031	0,064	0,099	0,134	0,162	0,187	0,230
	1	0,07 x D	0,1 x D	200	280	fz	0,019	0,039	0,080	0,123	0,168	0,203	0,234	0,288
H	2	0,05 x D	0,04 x D	161	276	fz	0,017	0,034	0,070	0,107	0,145	0,174	0,201	0,246
	3	0,03 x D	0,03 x D	174	261	fz	0,015	0,031	0,063	0,096	0,130	0,158	0,183	0,229
	4	0,03 x D	0,03 x D	145	203	fz	0,010	0,021	0,042	0,064	0,087	0,105	0,122	0,151





Material Group		Profiling		KC637M		Roughing — Feed per Tooth — fz information is for side milling (A).								
		A		Cutting Speed — vc m/min			D1 — Diameter							
		ap	ae	min	max	mm	1,0	2,0	4,0	6,0	8,0	10,0	12,0	16,0
P	3	0,2 x D	0,1 x D	208	234	fz	0,007	0,015	0,031	0,049	0,067	0,081	0,094	0,117
	4	0,2 x D	0,1 x D	182	208	fz	0,007	0,014	0,029	0,044	0,060	0,073	0,084	0,103
H	1	0,15 x D	0,1 x D	140	196	fz	0,010	0,021	0,043	0,066	0,090	0,109	0,125	0,154
	2	0,1 x D	0,075 x D	119	204	fz	0,012	0,024	0,048	0,074	0,101	0,121	0,140	0,171
	3	0,05 x D	0,05 x D	138	207	fz	0,013	0,027	0,055	0,084	0,114	0,138	0,161	0,200
	4	0,05 x D	0,05 x D	115	161	fz	0,009	0,018	0,037	0,056	0,076	0,092	0,107	0,133

F2AB...WL-WM-WX • Ball Nose • Extended Neck





Material Group		Profiling		KC637M		Roughing — Feed per Tooth — fz information is for side milling (A).						
		A		Cutting Speed — vc m/min			D1 — Diameter					
		ap	ae	min	max	mm	2,0	4,0	6,0	8,0	10,0	12,0
P	3	0,2 x D	0,1 x D	208	234	fz	0,015	0,031	0,049	0,067	0,081	0,094
	4	0,2 x D	0,1 x D	182	208	fz	0,014	0,029	0,044	0,060	0,073	0,084
H	1	0,15 x D	0,1 x D	140	196	fz	0,021	0,043	0,066	0,090	0,109	0,125
	2	0,1 x D	0,075 x D	119	204	fz	0,024	0,048	0,074	0,101	0,121	0,140
	3	0,05 x D	0,05 x D	138	207	fz	0,027	0,055	0,084	0,114	0,138	0,161
	4	0,05 x D	0,05 x D	115	161	fz	0,018	0,037	0,056	0,076	0,092	0,107





Material Group		Profiling		KC637M		Semi-Finishing — Feed per Tooth — fz information is for side milling (A).						
		A		Cutting Speed — vc m/min			D1 — Diameter					
		ap	ae	min	max	mm	2,0	4,0	6,0	8,0	10,0	12,0
P	3	0,1 x D	0,05 x D	272	306	fz	0,034	0,070	0,109	0,150	0,182	0,211
	4	0,1 x D	0,05 x D	238	272	fz	0,031	0,064	0,099	0,134	0,162	0,187
H	1	0,07 x D	0,1 x D	200	280	fz	0,039	0,080	0,123	0,168	0,203	0,234
	2	0,05 x D	0,04 x D	161	276	fz	0,034	0,070	0,107	0,145	0,174	0,201
	3	0,03 x D	0,03 x D	174	261	fz	0,031	0,063	0,096	0,130	0,158	0,183
	4	0,03 x D	0,03 x D	145	203	fz	0,021	0,042	0,064	0,087	0,105	0,122





Material Group		Profiling		KC637M		Finishing — Feed per Tooth — fz information is for side milling (A).						
		A		Cutting Speed — vc m/min			D1 — Diameter					
		ap	ae	min	max	mm	2,0	4,0	6,0	8,0	10,0	12,0
P	3	0,04 x D	0,04 x D	416	468	fz	0,052	0,108	0,168	0,231	0,279	0,324
	4	0,04 x D	0,04 x D	364	416	fz	0,048	0,099	0,152	0,207	0,249	0,288
H	1	0,03 x D	0,03 x D	290	406	fz	0,052	0,106	0,162	0,221	0,266	0,308
	2	0,03 x D	0,03 x D	203	348	fz	0,039	0,080	0,122	0,166	0,199	0,230
	3	0,02 x D	0,02 x D	216	324	fz	0,033	0,067	0,102	0,139	0,168	0,196
	4	0,02 x D	0,02 x D	180	252	fz	0,022	0,045	0,068	0,093	0,112	0,130

F4AL...WL-WM-WX • Ball Nose • Tapered Neck





Material Group		Profiling		KC637M		Roughing — Feed per Tooth — fz information is for side milling (A).						
		A		Cutting Speed — vc m/min			D1 — Diameter					
		ap	ae	min	max	mm	3,0	4,0	5,0	6,0	8,0	10,0
P	3	0,2 x D	0,1 x D	208	234	fz	0,023	0,031	0,040	0,049	0,067	0,081
	4	0,2 x D	0,1 x D	182	208	fz	0,021	0,029	0,036	0,044	0,060	0,073
H	1	0,15 x D	0,1 x D	140	196	fz	0,032	0,043	0,054	0,066	0,090	0,109
	2	0,1 x D	0,075 x D	119	204	fz	0,036	0,048	0,061	0,074	0,101	0,121
	3	0,05 x D	0,05 x D	138	207	fz	0,041	0,055	0,069	0,084	0,114	0,138
	4	0,05 x D	0,05 x D	115	161	fz	0,027	0,037	0,046	0,056	0,076	0,092





Material Group		Profiling		KC637M		Semi-Finishing — Feed per Tooth — fz information is for side milling (A).						
		A		Cutting Speed — vc m/min			D1 — Diameter					
		ap	ae	min	max	mm	3,0	4,0	5,0	6,0	8,0	10,0
P	3	0,1 x D	0,05 x D	272	306	fz	0,052	0,070	0,089	0,109	0,150	0,182
	4	0,1 x D	0,05 x D	238	272	fz	0,048	0,064	0,081	0,099	0,134	0,162
H	1	0,07 x D	0,1 x D	200	280	fz	0,060	0,080	0,102	0,123	0,168	0,203
	2	0,05 x D	0,04 x D	161	276	fz	0,052	0,070	0,088	0,107	0,145	0,174
	3	0,03 x D	0,03 x D	174	261	fz	0,047	0,063	0,079	0,096	0,130	0,158
	4	0,03 x D	0,03 x D	145	203	fz	0,031	0,042	0,053	0,064	0,087	0,105





Material Group		Profiling		KC637M		Finishing — Feed per Tooth — fz information is for side milling (A).						
		A		Cutting Speed — vc m/min			D1 — Diameter					
		ap	ae	min	max	mm	3,0	4,0	5,0	6,0	8,0	10,0
P	3	0,04 x D	0,04 x D	416	468	fz	0,080	0,108	0,137	0,168	0,231	0,279
	4	0,04 x D	0,04 x D	364	416	fz	0,073	0,099	0,125	0,152	0,207	0,249
H	1	0,03 x D	0,03 x D	290	406	fz	0,078	0,106	0,134	0,162	0,221	0,266
	2	0,03 x D	0,03 x D	203	348	fz	0,059	0,080	0,101	0,122	0,166	0,199
	3	0,02 x D	0,02 x D	216	324	fz	0,050	0,067	0,084	0,102	0,139	0,168
	4	0,02 x D	0,02 x D	180	252	fz	0,033	0,045	0,056	0,068	0,093	0,112



Carbide Recycling

Help preserve and protect our planet!

It's easy for your company to be environmentally conscious with the Kennametal Carbide Recycling Programme.

By sending us your used carbide tools, you help preserve and protect the environment and ensure that these products are recycled responsibly. Kennametal accepts any coated or non-coated carbide items, including inserts, drills, reamers, and taps.

By using the Kennametal Carbide Recycling Programme, you will receive:

- A partner who cares about a sustainable environment.
- Easy-to-use web portal to value your used carbide.
- Access to our popular Green Box™ options for carbide collection.
- Systematic and efficient disposal of carbide materials.
- Improved profitability.

Programme is not currently available in all geographical areas.
For more information, please visit **kennametal.com/carbiderecycling**.

KENNAMETAL®

kennametal.com

High-Performance Micro-Machining End Mills

Primary Application

The full portfolio of industry standard micro-machining end mills from Kennametal consists of extended reach, necked, square end, and ball nose cutters. Engineered to machine steels and hardened steels up to 67 HRC, they provide the highest accuracy and longest tool life.

- End mills from cutting diameter D = 0,3mm.
- Short and long length of cut variations.
- Capable of machining steels and hardened steels up to more than 60 HRC.
- Sophisticated coatings for maximum wear resistance.

Features and Benefits

Advanced Technology

- Negative geometry for increased edge strength.
- Reinforced core for better rigidity.
- High helix for better surface finishes.

Tailored Grades

- TiAlN coated KC635M™ for additional wear resistance especially used at dry machining.
- KC637M™ hard machining dedicated TiAlN coated, wear resistant substrate for highest tool life in materials above 48 HRC.

Customisation

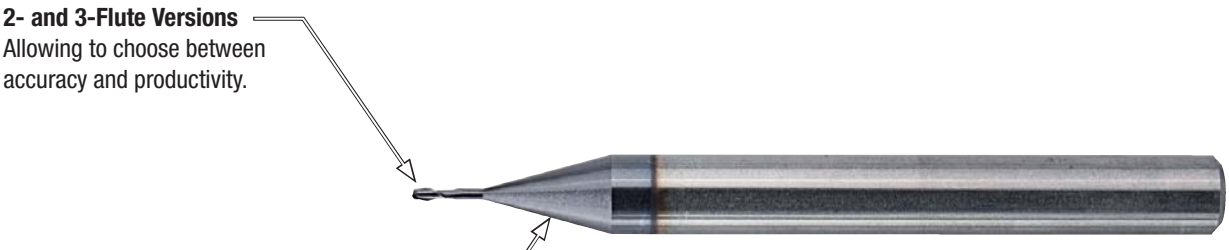
- Intermediate diameters available.
- Expanded length of tool and increased length of cut are possible.
- Various shank options and non-standard coatings available.
- AlTiN grade KC643M™ available as custom solution.

Extensive Standard Offering

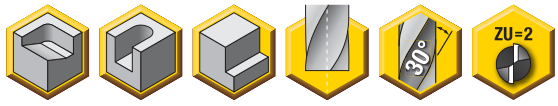
- Diameter ranges 0,3–6mm.
- Ball nose and square end offering.
- Extended tapered neck for long-reach applications.

Extended tapered neck for long-reach applications.

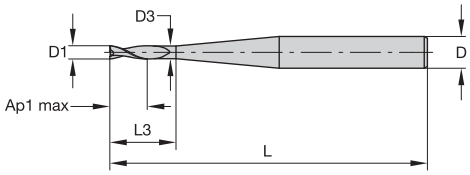




- Kennametal standard dimensions.
- Centre cutting.



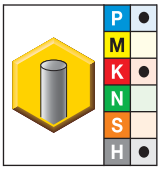




End Mill Tolerances

D1	tolerance e8	D	tolerance h6
≤3	-0,014/-0,028	≤3	+0/-0,006
>3–6	-0,020/-0,038	>3–6	+0/-0,008
>6–10	-0,025/-0,047	>6–10	+0/-0,009
>10–18	-0,032/-0,059	>10–18	+0/-0,011
>18–30	-0,040/-0,073	>18–30	+0/-0,013

F2AH...WS-WM • Extended Neck • Long

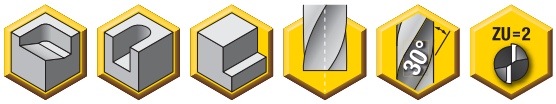


● first choice
○ alternate choice

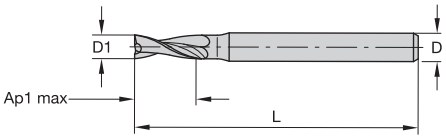
KC637M	D1	D	D3	Ap1 max	L3	L
F2AH0030AWS30L040	0,30	6,00	—	0,40	0,50	50,00
F2AH0050AWS30L070	0,50	6,00	0,45	0,70	1,50	50,00
F2AH0080AWM30L120	0,80	6,00	0,75	1,20	4,00	60,00
F2AH0100AWM30L150	1,00	6,00	0,95	1,50	5,00	60,00
F2AH0100AWS30L150	1,00	6,00	0,95	1,50	2,50	50,00
F2AH0150AWM30L230	1,50	6,00	1,45	2,30	7,50	60,00
F2AH0150AWS30L230	1,50	6,00	1,45	2,30	3,80	50,00
F2AH0160AWM30L240	1,60	6,00	1,55	2,40	8,00	60,00
F2AH0160AWS30L240	1,60	6,00	1,55	2,40	4,00	50,00
F2AH0180AWM30L270	1,80	6,00	1,75	2,70	9,00	60,00
F2AH0180AWS30L270	1,80	6,00	1,75	2,70	4,50	50,00
F2AH0200AWM30L300	2,00	6,00	1,95	3,00	10,00	60,00
F2AH0200AWS30L300	2,00	6,00	1,95	3,00	5,00	50,00
F2AH0250AWM30L370	2,50	6,00	2,40	3,70	12,50	60,00
F2AH0250AWS30L370	2,50	6,00	2,40	3,70	5,00	50,00

NOTE: For application data, see page P168.

- Kennametal standard dimensions.
- Centre cutting.



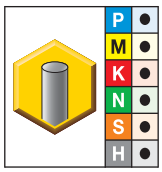




End Mill Tolerances

D1	tolerance e8	D	tolerance h6
≤3	-0,014/-0,028	≤3	+0/-0,006
>3–6	-0,020/-0,038	>3–6	+0/-0,008
>6–10	-0,025/-0,047	>6–10	+0/-0,009
>10–18	-0,032/-0,059	>10–18	+0/-0,011
>18–30	-0,040/-0,073	>18–30	+0/-0,013

F2AH...WS • Short

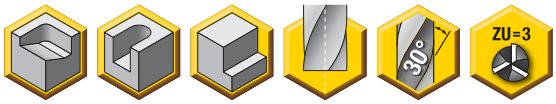


● first choice
○ alternate choice

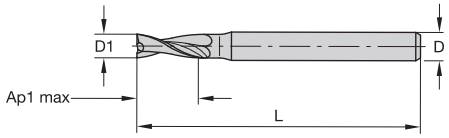
KC637M	D1	D	D3	Ap1 max	L3	L
F2AH0030AWS30L040	0,30	6,00	—	0,40	0,50	50,00
F2AH0050AWS30L070	0,50	6,00	0,45	0,70	1,50	50,00
F2AH0080AWM30L120	0,80	6,00	0,75	1,20	4,00	60,00
F2AH0100AWM30L150	1,00	6,00	0,95	1,50	5,00	60,00
F2AH0100AWS30L150	1,00	6,00	0,95	1,50	2,50	50,00
F2AH0150AWM30L230	1,50	6,00	1,45	2,30	7,50	60,00
F2AH0150AWS30L230	1,50	6,00	1,45	2,30	3,80	50,00
F2AH0160AWM30L240	1,60	6,00	1,55	2,40	8,00	60,00
F2AH0160AWS30L240	1,60	6,00	1,55	2,40	4,00	50,00
F2AH0180AWM30L270	1,80	6,00	1,75	2,70	9,00	60,00
F2AH0180AWS30L270	1,80	6,00	1,75	2,70	4,50	50,00
F2AH0200AWM30L300	2,00	6,00	1,95	3,00	10,00	60,00
F2AH0200AWS30L300	2,00	6,00	1,95	3,00	5,00	50,00
F2AH0250AWM30L370	2,50	6,00	2,40	3,70	12,50	60,00
F2AH0250AWS30L370	2,50	6,00	2,40	3,70	5,00	50,00

NOTE: For application data, see page P168.

- Kennametal standard dimensions.
- Centre cutting.



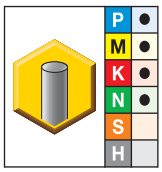




End Mill Tolerances

D1	tolerance e8	D	tolerance h6
≤3	-0,014/-0,028	≤3	+0/-0,006
>3–6	-0,020/-0,038	>3–6	+0/-0,008
>6–10	-0,025/-0,047	>6–10	+0/-0,009
>10–18	-0,032/-0,059	>10–18	+0/-0,011
>18–30	-0,040/-0,073	>18–30	+0/-0,013

F3AH...WS • Short



● first choice
○ alternate choice

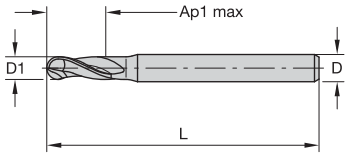
KC635M	D1	D	Ap1 max	L
F3AH0050AWS30	0,50	3,00	1,50	38,00
F3AH0060AWS30	0,60	3,00	1,50	38,00
F3AH0080AWS30	0,80	3,00	1,50	38,00
F3AH0100AWS30	1,00	3,00	2,00	38,00
F3AH0120AWS30	1,20	3,00	2,00	38,00
F3AH0150AWS30	1,50	3,00	2,00	38,00
F3AH0200AWS30	2,00	3,00	8,00	38,00
F3AH0250AWS30	2,50	3,00	9,00	38,00
F3AH0300AWS30	3,00	3,00	12,00	38,00

NOTE: For application data, see page P169.

- Kennametal standard dimensions.
- Centre cutting.



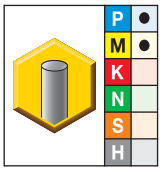




End Mill Tolerances

D1	tolerance h8	D	tolerance h6
≤3	+0/-0,014	≤3	+0/-0,006
>3–6	+0/-0,018	>3–6	+0/-0,008
>6–10	+0/-0,022	>6–10	+0/-0,009
>10–18	+0/-0,027	>10–18	+0/-0,011
>18–30	+0/-0,033	>18–30	+0/-0,013

F2AL...WS • Short



● first choice
○ alternate choice

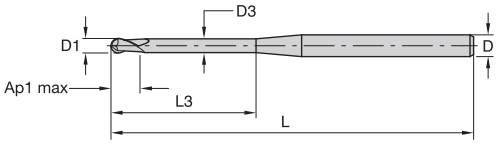
KC637M	D1	D	Ap1 max	L
F2AL0050AWS30	0,50	3,00	1,50	38,00
F2AL0100AWS30	1,00	3,00	2,00	38,00
F2AL0150AWS30	1,50	3,00	2,50	38,00
F2AL0200AWS30	2,00	3,00	3,00	38,00
F2AL0250AWS30	2,50	3,00	4,00	38,00
F2AL0300AWS30	3,00	3,00	5,00	38,00

NOTE: For application data, see page P170.

- Kennametal standard dimensions.
- Centre cutting.



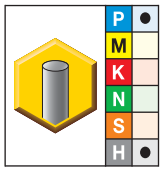




End Mill Tolerances

D1	tolerance e8	D	tolerance h6
≤3	-0,014/-0,028	≤3	+0/-0,006
>3–6	-0,020/-0,038	>3–6	+0/-0,008
>6–10	-0,025/-0,047	>6–10	+0/-0,009
>10–18	-0,032/-0,059	>10–18	+0/-0,011
>18–30	-0,040/-0,073	>18–30	+0/-0,013

F2AL...WS • Extended Neck



● first choice
○ alternate choice

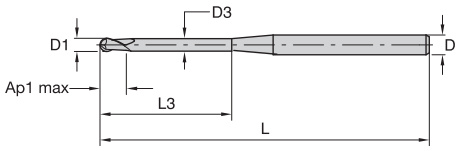
KC637M	D1	D	D3	Ap1 max	L3	L
F2AL0050AWS30L050	0,50	6,00	0,45	0,50	1,50	50,00
F2AL0060AWS30L060	0,60	6,00	0,55	0,60	1,80	50,00
F2AL0080AWS30L080	0,80	6,00	0,75	0,80	2,40	50,00
F2AL0100AWS30L100	1,00	6,00	0,95	1,00	2,50	50,00
F2AL0120AWS30L120	1,20	6,00	1,15	1,20	3,00	50,00
F2AL0150AWS30L150	1,50	6,00	1,45	1,50	3,80	50,00
F2AL0160AWS30L160	1,60	6,00	1,55	1,60	4,00	50,00
F2AL0180AWS30L180	1,80	6,00	1,75	1,80	4,50	50,00
F2AL0200AWS30L200	2,00	6,00	1,95	2,00	5,00	50,00
F2AL0250AWS30L250	2,50	6,00	2,40	2,50	5,00	50,00
F2AL0300AWS30L300	3,00	6,00	2,85	3,00	6,00	50,00
F2AL0400AWS30L400	4,00	6,00	3,85	4,00	6,00	50,00
F2AL0600AWS30L600	6,00	6,00	5,85	6,00	9,00	50,00

NOTE: For application data, see page P171.

- Kennametal standard dimensions.
- Centre cutting.



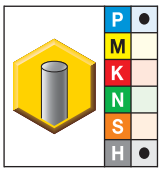




End Mill Tolerances

D1	tolerance e8	D	tolerance h6
≤3	-0,014/-0,028	≤3	+0/-0,006
>3–6	-0,020/-0,038	>3–6	+0/-0,008
>6–10	-0,025/-0,047	>6–10	+0/-0,009
>10–18	-0,032/-0,059	>10–18	+0/-0,011
>18–30	-0,040/-0,073	>18–30	+0/-0,013

F2AL...WM • Extended Neck • Long

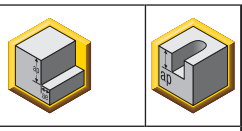


● first choice
○ alternate choice

KC637M	D1	D	D3	Ap1 max	L3	L
F2AL0100AWM30E060	1,00	4,00	0,95	1,60	6,00	65,00
F2AL0100AWM30E100	1,00	4,00	0,95	1,60	10,00	65,00
F2AL0100AWM30E160	1,00	4,00	0,95	1,60	16,00	65,00
F2AL0150AWM30E160	1,50	4,00	1,44	2,40	16,00	65,00
F2AL0200AWM30E0200	2,00	4,00	1,94	3,20	20,00	65,00
F2AL0200AWM30E100	2,00	4,00	1,94	3,20	10,00	65,00
F2AL0200AWM30E160	2,00	4,00	1,94	3,20	16,00	65,00
F2AL0400AWM30E060	4,00	6,00	3,92	6,00	6,00	70,00
F2AL0400AWM30E160	4,00	6,00	3,92	6,00	16,00	70,00

NOTE: For application data, see page P172.

F2AH...AWS/M30L...AWM • Extended Neck

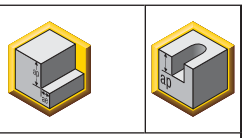




Material Group		Side Milling (A) and Slotting (B) A ap	A ae	B ap	KC637M Cutting Speed — vc m/min min		max	mm	Feed per Tooth — fz information is for side milling (A). For slotting (B), reduce fz by 20%. D1 — Diameter 0,4	0,5	0,6	0,8	1,0	1,5	2,0	2,5
P	2	1,25 x D	0,25 x D	0,75 x D	140	–	190	fz	0,003	0,003	0,004	0,005	0,007	0,010	0,014	0,017
	3	1,25 x D	0,25 x D	0,75 x D	120	–	160	fz	0,002	0,003	0,003	0,004	0,006	0,008	0,011	0,014
	4	1,25 x D	0,25 x D	0,5 x D	90	–	150	fz	0,002	0,003	0,003	0,004	0,005	0,008	0,010	0,013
	5	1,25 x D	0,25 x D	0,5 x D	60	–	100	fz	0,002	0,002	0,003	0,004	0,005	0,007	0,009	0,012
K	1	1,25 x D	0,25 x D	0,75 x D	120	–	150	fz	0,003	0,003	0,004	0,005	0,007	0,010	0,014	0,017
	2	1,25 x D	0,25 x D	0,5 x D	110	–	140	fz	0,002	0,003	0,003	0,004	0,006	0,008	0,011	0,014
H	1	1,25 x D	0,25 x D	0,5 x D	80	–	140	fz	0,002	0,003	0,003	0,004	0,005	0,008	0,010	0,013
	2	1,25 x D	0,25 x D	0,3 x D	70	–	120	fz	0,002	0,002	0,002	0,003	0,004	0,006	0,008	0,010
	3	1,25 x D	0,25 x D	0,25 x D	60	–	90	fz	0,001	0,002	0,002	0,002	0,003	0,005	0,006	0,008

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
For tools with reach >3 x D, reduce fz by 20%.
For tools with reach >5 x D, reduce fz by 30%.
For tools with reach >10 x D, reduce vc and fz by 20–30%.

F2AH...AWS30 • Short





Material Group		Side Milling (A) and Slotting (B) A ap	A ae	B ap	KC637M Cutting Speed — vc m/min min		max	mm	Feed per Tooth — fz information is for side milling (A). For slotting (B), reduce fz by 20%. D1 — Diameter 0,4	0,5	0,6	0,8	1,0	1,2	1,5	1,8	2,0	2,5
P	0	1 x D	0,1 x D	0,25 x D	150	–	200	fz	0,003	0,004	0,004	0,006	0,007	0,009	0,011	0,014	0,015	0,019
	1	1 x D	0,1 x D	0,25 x D	150	–	200	fz	0,003	0,004	0,004	0,006	0,007	0,009	0,011	0,014	0,015	0,019
	2	1 x D	0,1 x D	0,25 x D	140	–	190	fz	0,003	0,004	0,004	0,006	0,007	0,009	0,011	0,014	0,015	0,019
	3	1 x D	0,1 x D	0,25 x D	120	–	160	fz	0,002	0,003	0,004	0,005	0,006	0,007	0,009	0,011	0,012	0,016
	4	1 x D	0,1 x D	0,25 x D	90	–	150	fz	0,002	0,003	0,003	0,005	0,006	0,007	0,009	0,010	0,012	0,014
	5	1 x D	0,1 x D	0,25 x D	60	–	100	fz	0,002	0,003	0,003	0,004	0,005	0,006	0,008	0,009	0,010	0,013
M	1	1 x D	0,1 x D	0,25 x D	90	–	115	fz	0,002	0,003	0,004	0,005	0,006	0,007	0,009	0,011	0,012	0,016
	2	1 x D	0,1 x D	0,25 x D	60	–	80	fz	0,002	0,003	0,003	0,004	0,005	0,006	0,008	0,009	0,010	0,013
K	1	1 x D	0,1 x D	0,25 x D	120	–	150	fz	0,003	0,004	0,004	0,006	0,007	0,009	0,011	0,014	0,015	0,019
	2	1 x D	0,1 x D	0,25 x D	110	–	140	fz	0,002	0,003	0,004	0,005	0,006	0,007	0,009	0,011	0,012	0,016
N	1	1 x D	0,1 x D	0,25 x D	500	–	2000	fz	0,004	0,006	0,007	0,009	0,011	0,013	0,017	0,020	0,022	0,028
	2	1 x D	0,1 x D	0,25 x D	500	–	1500	fz	0,004	0,005	0,006	0,008	0,010	0,012	0,015	0,018	0,020	0,025
	3	1 x D	0,1 x D	0,25 x D	500	–	1500	fz	0,003	0,004	0,005	0,006	0,008	0,009	0,012	0,014	0,015	0,019
	5	1 x D	0,1 x D	0,25 x D	250	–	1000	fz	0,004	0,005	0,006	0,008	0,010	0,012	0,015	0,018	0,020	0,025
S	1	1 x D	0,1 x D	0,25 x D	50	–	90	fz	0,002	0,003	0,004	0,005	0,006	0,007	0,009	0,011	0,012	0,016
	2	1 x D	0,1 x D	0,25 x D	25	–	40	fz	0,001	0,002	0,002	0,003	0,003	0,004	0,005	0,006	0,007	0,009
	3	1 x D	0,1 x D	0,25 x D	25	–	40	fz	0,001	0,002	0,002	0,003	0,003	0,004	0,005	0,006	0,007	0,009
	4	1 x D	0,1 x D	0,25 x D	50	–	60	fz	0,001	0,002	0,002	0,003	0,004	0,005	0,006	0,007	0,008	0,010
H	1	1 x D	0,1 x D	0,25 x D	80	–	140	fz	0,002	0,003	0,003	0,005	0,006	0,007	0,009	0,010	0,012	0,014

NOTE: Those guidelines may require variations to achieve optimum results.
Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.

F3AH...AWS30... AWM • Short



Material Group		Side Milling (A) and Slotting (B)			KC635M		Feed per Tooth — fz information is for side milling (A). For slotting (B), reduce fz by 20%.										
		A		B	Cutting Speed — vc m/min			D1 — Diameter									
		ap	ae	ap	min	max	mm	0,4	0,5	0,6	0,8	1,0	1,2	1,5	1,8	2,0	2,5	3,0
P	0	1 x D	0,1 x D	0,25 x D	150	200	fz	0,003	0,004	0,004	0,006	0,007	0,009	0,011	0,014	0,015	0,019	0,023
	1	1 x D	0,1 x D	0,25 x D	150	200	fz	0,003	0,004	0,004	0,006	0,007	0,009	0,011	0,014	0,015	0,019	0,023
	2	1 x D	0,1 x D	0,25 x D	140	190	fz	0,003	0,004	0,004	0,006	0,007	0,009	0,011	0,014	0,015	0,019	0,023
	3	1 x D	0,1 x D	0,25 x D	120	160	fz	0,002	0,003	0,004	0,005	0,006	0,007	0,009	0,011	0,012	0,016	0,019
	4	1 x D	0,1 x D	0,25 x D	90	150	fz	0,002	0,003	0,003	0,005	0,006	0,007	0,009	0,010	0,012	0,014	0,017
M	1	1 x D	0,1 x D	0,25 x D	90	115	fz	0,002	0,003	0,004	0,005	0,006	0,007	0,009	0,011	0,012	0,016	0,019
	2	1 x D	0,1 x D	0,25 x D	60	80	fz	0,002	0,003	0,003	0,004	0,005	0,006	0,008	0,009	0,010	0,013	0,016
K	1	1 x D	0,1 x D	0,25 x D	120	150	fz	0,003	0,004	0,004	0,006	0,007	0,009	0,011	0,014	0,015	0,019	0,023
	2	1 x D	0,1 x D	0,25 x D	110	140	fz	0,002	0,003	0,004	0,005	0,006	0,007	0,009	0,011	0,012	0,016	0,019
N	1	1 x D	0,1 x D	0,25 x D	500	2000	fz	0,004	0,006	0,007	0,009	0,011	0,013	0,017	0,020	0,022	0,028	0,033
	2	1 x D	0,1 x D	0,25 x D	500	1500	fz	0,004	0,005	0,006	0,008	0,010	0,012	0,015	0,018	0,020	0,025	0,030
	5	1 x D	0,1 x D	0,25 x D	250	1000	fz	0,004	0,005	0,006	0,008	0,010	0,012	0,015	0,018	0,020	0,025	0,030

NOTE: Those guidelines may require variations to achieve optimum results.
Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
For better surface finish, reduce feed per tooth.

F2AL...AWS30 • Short



Material Group		Profiling		KC637M		Feed per Tooth — Roughing								
		A		Cutting Speed — vc m/min			D1 — Diameter							
		ap	ae	min	max	mm	0,5	0,6	0,8	1,0	1,5	2,0	2,5	3,0
P	3	0,2 x D	0,1 x D	208	234	fz	0,0037	0,0044	0,0059	0,0075	0,0113	0,0152	0,0192	0,0232
	4	0,2 x D	0,1 x D	182	208	fz	0,0035	0,0042	0,0056	0,0070	0,0105	0,0141	0,0177	0,0213
H	1	0,15 x D	0,1 x D	140	196	fz	0,0052	0,0062	0,0083	0,0104	0,0157	0,0211	0,0265	0,0319
	2	0,1 x D	0,075 x D	119	204	fz	0,0059	0,0070	0,0094	0,0118	0,0178	0,0238	0,0299	0,0360
	3	0,05 x D	0,05 x D	138	207	fz	0,0066	0,0080	0,0106	0,0133	0,0201	0,0269	0,0338	0,0408
	4	0,05 x D	0,05 x D	115	161	fz	0,0044	0,0053	0,0071	0,0089	0,0134	0,0179	0,0226	0,0272



Material Group		Profiling		KC637M		Feed per Tooth — Semi-Finishing								
		A		Cutting Speed — vc m/min			D1 — Diameter							
		ap	ae	min	max	mm	0,5	0,6	0,8	1,0	1,5	2,0	2,5	3,0
P	3	0,1 x D	0,05 x D	272	306	fz	0,0083	0,0099	0,0133	0,0167	0,0253	0,0339	0,0428	0,0518
	4	0,1 x D	0,05 x D	238	272	fz	0,0077	0,0093	0,0124	0,0155	0,0235	0,0314	0,0396	0,0477
H	1	0,07 x D	0,1 x D	200	280	fz	0,0097	0,0116	0,0155	0,0194	0,0294	0,0393	0,0495	0,0596
	2	0,05 x D	0,04 x D	161	276	fz	0,0084	0,0101	0,0135	0,0169	0,0255	0,0342	0,0430	0,0518
	3	0,03 x D	0,03 x D	174	261	fz	0,0076	0,0091	0,0122	0,0152	0,0230	0,0308	0,0387	0,0466
	4	0,03 x D	0,03 x D	145	203	fz	0,0051	0,0061	0,0081	0,0102	0,0153	0,0205	0,0258	0,0311



Material Group		Profiling		KC637M		Feed per Tooth — Finishing								
		A		Cutting Speed — vc m/min			D1 — Diameter							
		ap	ae	min	max	mm	0,5	0,6	0,8	1,0	1,5	2,0	2,5	3,0
P	3	0,04 x D	0,04 x D	416	468	fz	0,0127	0,0153	0,0204	0,0256	0,0389	0,0522	0,0659	0,0796
	4	0,04 x D	0,04 x D	364	416	fz	0,0119	0,0143	0,0191	0,0239	0,0361	0,0484	0,0609	0,0734
H	1	0,03 x D	0,03 x D	290	406	fz	0,0127	0,0153	0,0204	0,0255	0,0386	0,0517	0,0650	0,0784
	2	0,03 x D	0,03 x D	203	348	fz	0,0096	0,0116	0,0154	0,0193	0,0292	0,0391	0,0491	0,0592
	3	0,02 x D	0,02 x D	216	324	fz	0,0081	0,0097	0,0130	0,0163	0,0245	0,0328	0,0413	0,0497
	4	0,02 x D	0,02 x D	180	252	fz	0,0054	0,0065	0,0087	0,0108	0,0164	0,0219	0,0275	0,0331

F2AL...AWS30L • Extended Neck



Material Group		Profiling		KC637M		Feed per Tooth — Roughing								
		A		Cutting Speed — vc m/min			D1 — Diameter							
		ap	ae	min	max	mm	0,5	0,6	0,8	1,0	1,5	2,0	2,5	3,0
P	3	0,2 x D	0,1 x D	208	234	fz	0,0037	0,0044	0,0059	0,0075	0,0113	0,0152	0,0192	0,0232
	4	0,2 x D	0,1 x D	182	208	fz	0,0035	0,0042	0,0056	0,0070	0,0105	0,0141	0,0177	0,0213
H	1	0,15 x D	0,1 x D	140	196	fz	0,0052	0,0062	0,0083	0,0104	0,0157	0,0211	0,0265	0,0319
	2	0,1 x D	0,075 x D	119	204	fz	0,0059	0,0070	0,0094	0,0118	0,0178	0,0238	0,0299	0,0360
	3	0,05 x D	0,05 x D	138	207	fz	0,0066	0,0080	0,0106	0,0133	0,0201	0,0269	0,0338	0,0408
	4	0,05 x D	0,05 x D	115	161	fz	0,0044	0,0053	0,0071	0,0089	0,0134	0,0179	0,0226	0,0272



Material Group		Profiling		KC637M		Feed per Tooth — Semi-Finishing								
		A		Cutting Speed — vc m/min			D1 — Diameter							
		ap	ae	min	max	mm	0,5	0,6	0,8	1,0	1,5	2,0	2,5	3,0
P	3	0,1 x D	0,05 x D	272	306	fz	0,0083	0,0099	0,0133	0,0167	0,0253	0,0339	0,0428	0,0518
	4	0,1 x D	0,05 x D	238	272	fz	0,0077	0,0093	0,0124	0,0155	0,0235	0,0314	0,0396	0,0477
H	1	0,07 x D	0,1 x D	200	280	fz	0,0097	0,0116	0,0155	0,0194	0,0294	0,0393	0,0495	0,0596
	2	0,05 x D	0,04 x D	161	276	fz	0,0084	0,0101	0,0135	0,0169	0,0255	0,0342	0,0430	0,0518
	3	0,03 x D	0,03 x D	174	261	fz	0,0076	0,0091	0,0122	0,0152	0,0230	0,0308	0,0387	0,0466
	4	0,03 x D	0,03 x D	145	203	fz	0,0051	0,0061	0,0081	0,0102	0,0153	0,0205	0,0258	0,0311



Material Group		Profiling		KC637M		Feed per Tooth — Finishing								
		A		Cutting Speed — vc m/min			D1 — Diameter							
		ap	ae	min	max	mm	0,5	0,6	0,8	1,0	1,5	2,0	2,5	3,0
P	3	0,04 x D	0,04 x D	416	468	fz	0,0127	0,0153	0,0204	0,0256	0,0389	0,0522	0,0659	0,0796
	4	0,04 x D	0,04 x D	364	416	fz	0,0119	0,0143	0,0191	0,0239	0,0361	0,0484	0,0609	0,0734
H	1	0,03 x D	0,03 x D	290	406	fz	0,0127	0,0153	0,0204	0,0255	0,0386	0,0517	0,0650	0,0784
	2	0,03 x D	0,03 x D	203	348	fz	0,0096	0,0116	0,0154	0,0193	0,0292	0,0391	0,0491	0,0592
	3	0,02 x D	0,02 x D	216	324	fz	0,0081	0,0097	0,0130	0,0163	0,0245	0,0328	0,0413	0,0497
	4	0,02 x D	0,02 x D	180	252	fz	0,0054	0,0065	0,0087	0,0108	0,0164	0,0219	0,0275	0,0331

NOTE: These guidelines may require possible variations to achieve optimum results.

F2AL...AWM30E • Extended Neck Long





Material Group		Profiling		KC637M		Feed per Tooth — Roughing										
		A		Cutting Speed — vc m/min			D1 — Diameter									
		ap	ae	min	max	mm	0,3	0,4	0,5	0,6	0,8	1,0	1,5	2,0	2,5	3,0	4,0
P	3	0,2 x D	0,1 x D	187	211	fz	0,0022	0,0030	0,0037	0,0044	0,0059	0,0075	0,0113	0,0152	0,0192	0,0232	0,0309
	4	0,2 x D	0,1 x D	164	187	fz	0,0021	0,0028	0,0035	0,0042	0,0056	0,0070	0,0105	0,0141	0,0177	0,0213	0,0285
H	1	0,15 x D	0,1 x D	126	176	fz	0,0031	0,0041	0,0052	0,0062	0,0083	0,0104	0,0157	0,0211	0,0265	0,0319	0,0426
	2	0,1 x D	0,075 x D	107	184	fz	0,0035	0,0047	0,0059	0,0070	0,0094	0,0118	0,0178	0,0238	0,0299	0,0360	0,0480
	3	0,05 x D	0,05 x D	124	186	fz	0,0040	0,0053	0,0066	0,0080	0,0106	0,0133	0,0201	0,0269	0,0338	0,0408	0,0544
	4	0,05 x D	0,05 x D	104	145	fz	0,0027	0,0035	0,0044	0,0053	0,0071	0,0089	0,0134	0,0179	0,0226	0,0272	0,0362





Material Group		Profiling		KC637M		Feed per Tooth — Semi-Finishing										
		A		Cutting Speed — vc m/min			D1 — Diameter									
		ap	ae	min	max	mm	0,3	0,4	0,5	0,6	0,8	1,0	1,5	2,0	2,5	3,0	4,0
P	3	0,1 x D	0,05 x D	245	275	fz	0,0050	0,0066	0,0083	0,0099	0,0133	0,0167	0,0253	0,0339	0,0428	0,0518	0,0690
	4	0,1 x D	0,05 x D	214	245	fz	0,0046	0,0062	0,0077	0,0093	0,0124	0,0155	0,0235	0,0314	0,0396	0,0477	0,0636
H	1	0,07 x D	0,1 x D	180	252	fz	0,0058	0,0077	0,0097	0,0116	0,0155	0,0194	0,0294	0,0393	0,0495	0,0596	0,0795
	2	0,05 x D	0,04 x D	145	248	fz	0,0050	0,0067	0,0084	0,0101	0,0135	0,0169	0,0255	0,0342	0,0430	0,0518	0,0690
	3	0,03 x D	0,03 x D	157	235	fz	0,0045	0,0061	0,0076	0,0091	0,0122	0,0152	0,0230	0,0308	0,0387	0,0466	0,0621
	4	0,03 x D	0,03 x D	131	183	fz	0,0030	0,0040	0,0051	0,0061	0,0081	0,0102	0,0153	0,0205	0,0258	0,0311	0,0414





Material Group		Profiling		KC637M		Feed per Tooth — Finishing										
		A		Cutting Speed — vc m/min			D1 — Diameter									
		ap	ae	min	max	mm	0,3	0,4	0,5	0,6	0,8	1,0	1,5	2,0	2,5	3,0	4,0
P	3	0,04 x D	0,04 x D	374	421	fz	0,0076	0,0102	0,0127	0,0153	0,0204	0,0256	0,0389	0,0522	0,0659	0,0796	0,1062
	4	0,04 x D	0,04 x D	328	374	fz	0,0071	0,0095	0,0119	0,0143	0,0191	0,0239	0,0361	0,0484	0,0609	0,0734	0,0979
H	1	0,03 x D	0,03 x D	261	365	fz	0,0076	0,0102	0,0127	0,0153	0,0204	0,0255	0,0386	0,0517	0,0650	0,0784	0,1045
	2	0,03 x D	0,03 x D	183	313	fz	0,0058	0,0077	0,0096	0,0116	0,0154	0,0193	0,0292	0,0391	0,0491	0,0592	0,0789
	3	0,02 x D	0,02 x D	194	292	fz	0,0049	0,0065	0,0081	0,0097	0,0130	0,0163	0,0245	0,0328	0,0413	0,0497	0,0663
	4	0.02 x D	0,02 x D	162	227	fz	0,0032	0,0043	0,0054	0,0065	0,0087	0,0108	0,0164	0,0219	0,0275	0,0331	0,0442

HARVI™ III Family



High-temperature alloy machining

- Profiling, semi-finishing, and finishing.
- Maximum metal removal rates in titanium and stainless steel.
- Supreme surface conditions.
- Complete family of square end, ball nose, and taper ball nose cutters.

KCSM15™

- Proprietary Beyond™ grade for exceptional tool life in titanium and stainless steels.

Advanced Technology

- Six unequally spaced flutes for chatter-free machining.
- Eccentric relief design increases tool life through higher edge stability.
- Proprietary tapered core provides highest tool stability in roughing and finishing operations.

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Beyond™ EADE

Solid Ceramic End Mills

Primary Application

EADE solid ceramic end mills offer higher productivity and tool life in roughing nickel-based high-temperature alloys. Beyond grade KYS40™ delivers best-in-class tool life and exceptionally high Metal Removal Rates (MRR), surpassing those of other solutions on the market today.

- Outstanding reduction of machining time.
- Fewer tool changes due to longer tool life.
- Benefit from throw away-type of tooling.

Features and Benefits

Advanced Technology

- KYS40 Beyond grade solid SiAlON ceramic designed for machining nickel-based high-temperature alloys.
- Cutting speeds up to 1000 m/min increase metal removal rates.
- Tool life up to 5x that of carbide end mills.

Extensive Standard Offering

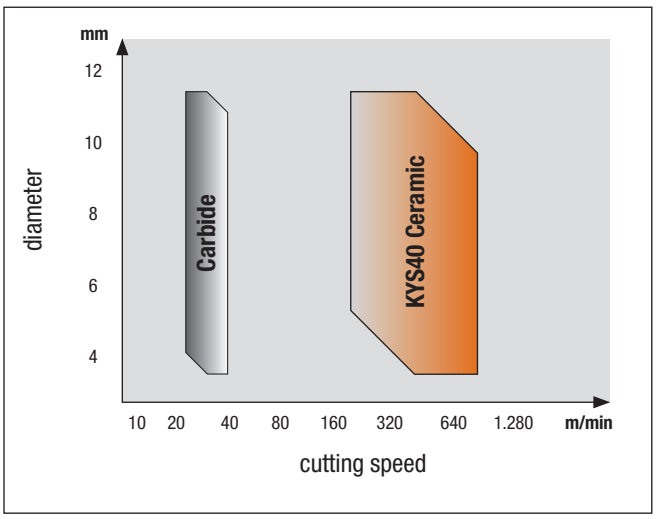
- 4-flute tooling for pocketing and slotting. Undersize end mills leaving stock for finishing operations.
- 6-flute tooling for face milling and profiling.

Customisation

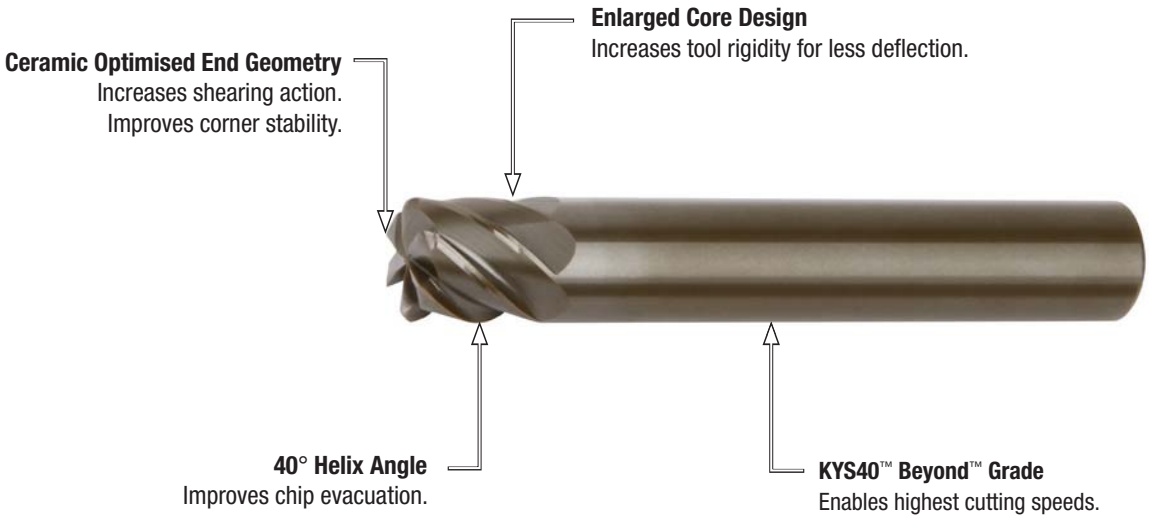
- Engineered solutions are available upon request.

Highest Cutting Speed Capability

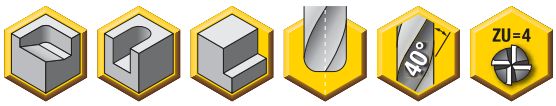
- Increase compared to carbide.



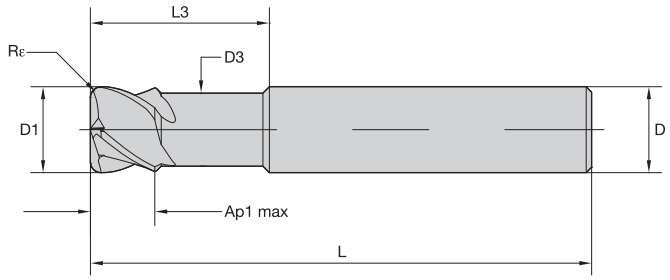



Enlarged Core Design
Increases tool rigidity for less deflection.
Ceramic Optimised End Geometry
Increases shearing action.
Improves corner stability.
40° Helix Angle
Improves chip evacuation.
KYS40™ Beyond™ Grade
Enables highest cutting speeds.

- Kennametal standard dimensions.
- Non-centre cutting.
- Ramping up to 2,5°.
- Optimised geometry for roughing nickel-based high-temperature alloys.





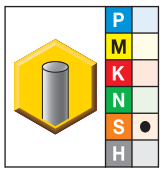


End Mill Tolerances

D1	tolerance e8	D	tolerance h6
≤3	-0,014/-0,028	≤3	+0/-0,006
>3–6	-0,020/-0,038	>3–6	+0/-0,008
>6–10	-0,025/-0,047	>6–10	+0/-0,009
>10–18	-0,032/-0,059	>10–18	+0/-0,011
>18–30	-0,040/-0,073	>18–30	+0/-0,013

beyond

EADE • 4 Flute with Neck • Metric

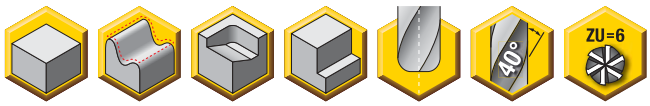


● first choice
○ alternate choice

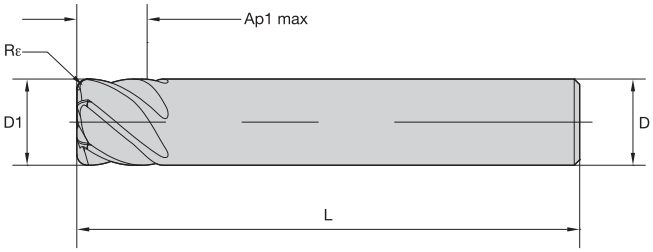
KYS40	D1	D	D3	Ap1 max	L	L3	Rε
EADE0380A4AQE KYS40	3,80	6,00	3,65	3,00	50,00	8,00	0,50
EADE0400A4AQE KYS40	4,00	6,00	3,84	3,00	50,00	8,00	0,50
EADE0570A4AQF KYS40	5,70	6,00	5,47	4,50	50,00	12,00	0,75
EADE0600A4AQF KYS40	6,00	6,00	5,76	4,50	50,00	12,00	0,75
EADE0760A4AQG KYS40	7,60	8,00	7,30	6,00	57,00	16,00	1,00
EADE0800A4AQG KYS40	8,00	8,00	7,68	6,00	57,00	16,00	1,00
EADE0950A4AQH KYS40	9,50	10,00	9,12	7,50	63,00	20,00	1,25
EADE1000A4AQH KYS40	10,00	10,00	9,60	7,50	63,00	20,00	1,25
EADE1140A4AQJ KYS40	11,40	12,00	10,94	9,00	70,00	24,00	1,50
EADE1200A4AQJ KYS40	12,00	12,00	11,52	9,00	70,00	23,50	1,50

NOTE: For application data, see page P178.
For full slotting, profiling, and 3D milling, do not exceed 0,5mm of Ap.

- Kennametal standard dimensions.
- Non-centre cutting.
- Ramping up to 2°.
- Optimised geometry for roughing nickel-based high-temperature alloys.





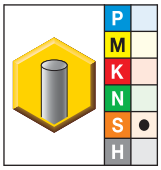


End Mill Tolerances

D1	tolerance e8	D	tolerance h6
≤3	-0,014/-0,028	≤3	+0/-0,006
>3–6	-0,020/-0,038	>3–6	+0/-0,008
>6–10	-0,025/-0,047	>6–10	+0/-0,009
>10–18	-0,032/-0,059	>10–18	+0/-0,011
>18–30	-0,040/-0,073	>18–30	+0/-0,013

beyond

EADE • 6 Flute • Metric

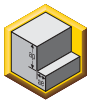


● first choice
○ alternate choice

KYS40	D1	D	Ap1 max	L	Rε
EADE0400A6ARE KYS40	4,00	6,00	3,00	50,00	0,50
EADE0600A6ARF KYS40	6,00	6,00	4,50	50,00	0,75
EADE0800A6ARG KYS40	8,00	8,00	6,00	57,00	1,00
EADE1000A6ARH KYS40	10,00	10,00	7,50	63,00	1,25
EADE1200A6ARJ KYS40	12,00	12,00	9,00	70,00	1,50

NOTE: For application data, see page P178.
For full slotting, profiling, and 3D milling, do not exceed 0,5mm of Ap.

4-Flute with Neck • Metric

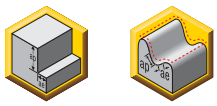




Material Group		Side Milling (A) and Slotting (B)			KYS40		Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 20%.					
		A		B	Cutting Speed — vc m/min			D1 — Diameter				
		ap	ae	ap	min	max	mm	4,0	6,0	8,0	10,0	12,0
S	3	Ap1 max	0,1 x D	0,5 x D*	250	1000	fz	0,020	0,024	0,028	0,030	0,032

NOTE: For above cutting data, do not exceed an overall ae of 1mm.
Use ap of 0.5mm as starting condition.

6-Flute • Metric





Material Group		Side Milling (A) and Profiling		KYS40		Recommended feed per tooth (fz = mm/th) for side milling (A).					
		A		Cutting Speed — vc m/min			D1 — Diameter				
		ap	ae	min	max	mm	4,0	6,0	8,0	10,0	12,0
S	3	Ap1 max*	0,1 x D	250	1000	fz	0,020	0,024	0,028	0,030	0,032

NOTE: For above cutting data, do not exceed an overall ae of 1mm.
Use ap of 0.5mm as starting condition.

NOVO KNOWS CAD/CAM

With the addition of NOVO™ applications to your team, your CAD/CAM capabilities become much more accurate, streamlined, and productive.

Before NOVO: The programmer would be in their CAD/CAM software, programming a part. Using the tedious method of finding a tool in a catalogue, and then manually inputting the tooling information from the catalogue into the CAD/CAM software.

The concern is that assumptions are made, and only partial tooling information is entered.

With NOVO: The powerful digital intelligence of NOVO applications not only help the programmer find the right tool for the metalcutting job, but also automatically integrates all the tooling data into a complete CAD/CAM solution. The integration of all the tooling data increases the viability of the part being programmed, and is delivered quickly — saving you time.

NOVO applications can ensure you have the right tools on your machines, in the right sequence. Resulting in flawless execution that accelerates every job, and maximises every shift. **kennametal.com/novo**





EADE 4-Flute End Mill

CHALLENGE

- Roughing a slot on turbine blade.
- Depth of slot 22mm
- INCONEL® 718 material.
- Dry machining.

SOLUTION

- Engineered solution EADE KYS40™ ceramic end mill with extended neck.
- Ø 11,4mm with 4 effective cutting edges and 1,5mm corner radii.

CUTTING DATA

- vc 800 m/min
- fz 0,03 mm/z
- ap 0,5mm
- ae 11,4mm

RESULT

- Customer proprietary information.

BENEFIT

- Machining time of 1 minute 54 seconds for one slot only.
- Metal removal rate of 15 cm^3/min consistently achieved.
- Productivity significantly increased.

EADE 4-Flute End Mill

CHALLENGE

- Rough profiling of small turbine blades.
- INCONEL 718 material.
- Dry machining.

SOLUTION

- Standard EADE KYS40 ceramic end mill.
- Ø 11,4mm with 4 effective cutting edges and standard neck.

CUTTING DATA

- vc 645 m/min
- fz 0,03 mm/z
- ap 0,5mm
- ae 11,4mm

RESULT

- 3x tool life compared to 2x tool life with competitive solution in less time.

BENEFIT

- 3x higher productivity as a result of increased cutting data.
- 50% longer tool life compared to competitive carbide end mill.

(continued)

(continued)



EADE 6-Flute End Mill

CHALLENGE

- Rough profiling of aerospace parts.
- Haynes® 288 and INCONEL® 718 material.
- Dry machining.

SOLUTION

- Standard EADE KYS40™ ceramic end mill.
- Ø 10mm with 6 effective cutting edges.

CUTTING DATA

- vc 462 m/min
- fz 0,03 mm/z
- ap 0,5–1mm
- ae Varying

RESULT

- Customer proprietary information.

BENEFIT

- Machining time reduced.
- Productivity significantly increased.

EADE 6-Flute End Mill

CHALLENGE

- Rough profiling of blisk (blade integrated disc).
- INCONEL 718 material (42 HRC).
- Compressed air coolant.

SOLUTION

- Standard EADE KYS40 ceramic end mill.
- Ø 12mm with 6 effective cutting edges.

CUTTING DATA

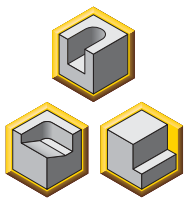
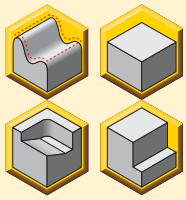
- vc 679 m/min
- fz 0,03 mm/z
- ap Varying up to 0,5mm
- ae Varying

RESULT

- 2 blisk segments machined with one tool.
- 12 minute machining time per segment.

BENEFIT

- Unprecedented reduction in machining time.

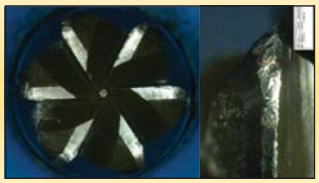
Materials to Cut	• Nickel-based high-temperature alloys. • Cobalt-based alloys after consulting technical assistance. • P6 and M1–3 stainless steels after consulting technical assistance. • Do not apply on iron-based high-temperature alloys.
Cutting Speed	• Maximum RPM machine can provide recommended cutting speed: 400–1000 m/min. • Highly dynamic machines recommended. • Use of spindle speeders applicable (no wet coolant).
Feed Rate	• Refer to application data recommendation. • General starting condition fz 0,03 mm/z.
Depth of Cut	• Refer to application data recommendation. • General starting condition ap 0,5mm.
Coolant	• Power cool nozzle preferred to flush chips away. • Pressurized air applicable. • Minimal quantity lubrication (MQL) and dry applicable. • No coolant with emulsion or oil due to thermal shock.
Adaptation	• Hydraulic chuck with or without sleeve preferred. • Collet or milling power chucks applicable. • Balancing at 25,000 RPM (2,5G) preferred.
Roughing Application	Yes
Finishing Application	No
Milling Strategy	• Conventional milling preferred at lower speeds. • Climb milling preferred at higher speeds.
4-Flute EADE	• Slotting and pocketing. • Common sizes and undersize leaving finishing stock. • Side milling possible up to ap max with increased feed. • Non-centre cutting. • Ramping and helical interpolation possible under 2.5°. 
6-Flute EADE	• Profiling and face milling. • Non-centre cutting. • Side milling possible up to ap max with increased feed. • Ramping and helical interpolation possible under 2°. 
Engineered Solutions	Available upon request.
Reconditioning Service	Not applicable.

Wear Indication

New

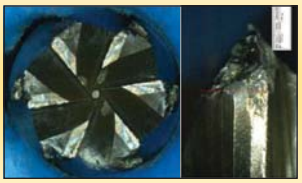


Used



Wear rate 0,48mm.
Still good to use.

End of Tool Life



Wear rate 1,4mm.
End of tool life reached.

Chip Formation

Carbide



Regular curled chips. Shape and length depend on end mill geometry and cutting data.

Ceramic



Chips are nearly like dust. Pressurised air coolant recommended to blow away chips.

Causes of and Remedies for End Milling Problems

problem	cause	remedy
Excessive bur formation	• Softness of material to cut. • Excessive wear on radii.	• Use undersize end mills that leave stock for finishing operation. • Replace tool as end of tool life reached. • Check tool runout.
Sudden breakage	• Vibration of the workpiece. • Unstable tool clamping. • Use of 6-flute tooling in slotting.	• Check workpiece and tool clamping. • Use of 4-flute EADE recommended.
Chips sticking	• Lack of cutting speed.	• Increase cutting speed.
Chipping	• Unstable tool and/or workpiece clamping. • Initial cutting speed too high.	• Check workpiece and tool clamping. • Reduce cutting speed during initial cut and increase as cutting continues.
Thermal cracks	• Wet coolant.	• Do not use wet coolant.

KC643M™ Key Way Cutter

Primary Application

F2AU and F3AU Key Way Cutters offer highest precision when machining slots for a shaft to hub connection. The corner radii increases workpiece durability as crack causing forces between floor and wall are minimised. To produce key slots according to ISO, the radii are adjusted accordingly to match this standard.

New KC643M Key Way Cutters replace old KC635M™ and KC625M™ versions.

- Highest accuracy with finishing (conventional milling).
- Roughing and finishing with one tool.
- Less tool changes due to higher tool life.

Features and Benefits

Advanced Technology

- Unequally spaced flutes with F3AU for chatter-free machining at high feed rates.
- F2AU designed for unstable machining conditions.
- Radii transition created between floor and wall at key slot increases durability of machined components by preventing cracks.
- True 90° wall straightness due to tapered peripheral edges creating a defined passive force during finishing cut (conventional cut).
- Roughing and finishing with one tool resulting in fewer tool changes and less tooling inventory necessary.

Tailored Grade

- Universal KC643M grade suitable for cutting steel, cast iron, stainless steel (wet), and titanium (wet).

Customisation

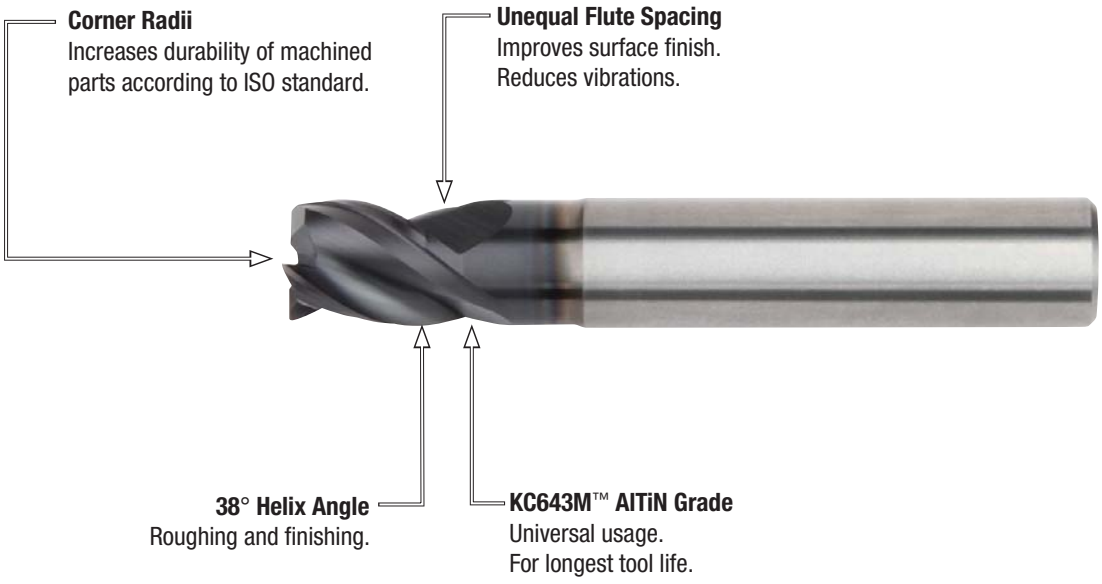
- Expanded length of tool as well as increased length of cut are possible.
- Internal coolant axial as well as radial available.
- Various shank and non-standard coatings options available.

Extensive Standard Offering

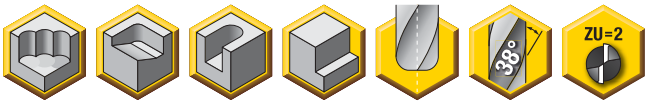
- Diameter range 1,80–19,70mm.
- 2-flute and 3-flute tooling in stock.

Various shank and non-standard coating options available.

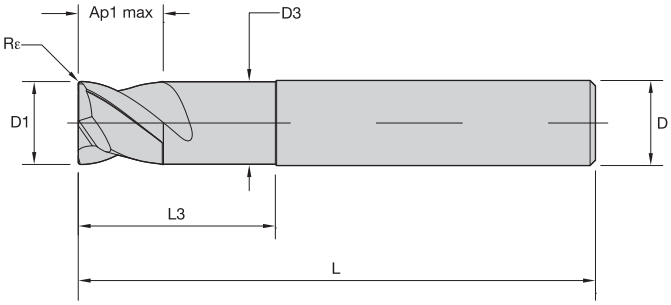




- Kennametal standard dimensions.
- Centre cutting.
- Single tool for roughing and finishing applications requiring fewer setups.
- Optimised for unstable machining conditions.



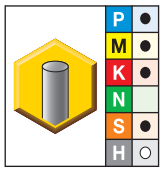




End Mill Tolerances

D1	tolerance e8	D	tolerance h6
≤3	-0,014/-0,028	≤3	+0/-0,006
>3–6	-0,020/-0,038	>3–6	+0/-0,008
>6–10	-0,025/-0,047	>6–10	+0/-0,009
>10–18	-0,032/-0,059	>10–18	+0/-0,011
>18–30	-0,040/-0,073	>18–30	+0/-0,013

F2AU.. • 2-Flute • Metric

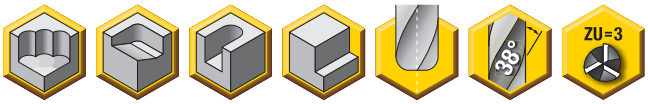


● first choice
○ alternate choice

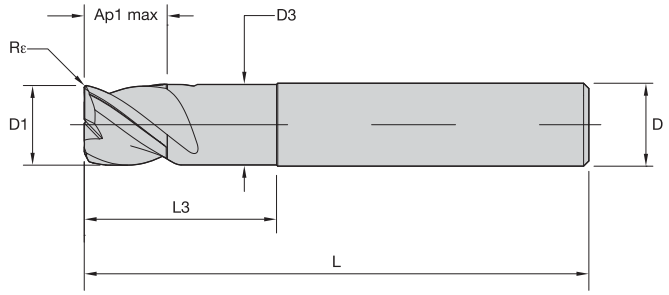
KC643M	D1	D	D3	Ap1 max	L3	L	Rε
F2AU0180ADK38	1,80	4,00	1,75	2,00	6,00	38,00	0,12
F2AU0280ADK38	2,80	6,00	2,75	4,00	12,00	50,00	0,12
F2AU0380ADK38	3,80	6,00	3,71	5,00	16,00	54,00	0,12
F2AU0480ADK38	4,80	6,00	4,71	6,00	16,00	54,00	0,20
F2AU0575ADK38	5,75	6,00	5,71	7,00	18,00	54,00	0,20
F2AU0775ADK38	7,75	8,00	7,70	9,00	22,00	58,00	0,20
F2AU0970ADK38	9,70	10,00	9,65	11,00	26,00	66,00	0,33
F2AU1170ADK38	11,70	12,00	11,64	12,00	28,00	73,00	0,33
F2AU1370ADK38	13,70	14,00	13,64	14,00	30,00	75,00	0,33
F2AU1570ADK38	15,70	16,00	15,64	16,00	34,00	82,00	0,33
F2AU1770ADK38	17,70	18,00	17,64	18,00	36,00	84,00	0,40
F2AU1970ADK38	19,70	20,00	19,63	20,00	42,00	92,00	0,40

NOTE: For application data, see page P188.

- Kennametal standard dimensions.
- Centre cutting.
- Unequal flute spacing minimises chatter for smoother machining.
- Single tool for roughing and finishing applications requiring fewer setups.
- Optimised for high Metal Removal Rates (MRR) under stable machining conditions.



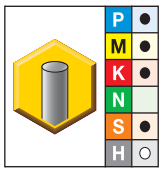




End Mill Tolerances

D1	tolerance e8	D	tolerance h6
≤3	-0,014/-0,028	≤3	+0/-0,006
>3–6	-0,020/-0,038	>3–6	+0/-0,008
>6–10	-0,025/-0,047	>6–10	+0/-0,009
>10–18	-0,032/-0,059	>10–18	+0/-0,011
>18–30	-0,040/-0,073	>18–30	+0/-0,013

F3AU.. • 3-Flute • Metric



● first choice
○ alternate choice

KC643M	D1	D	D3	Ap1 max	L3	L	Rε
F3AU0280ADK38	2,80	6,00	2,75	4,00	12,00	50,00	0,12
F3AU0380ADK38	3,80	6,00	3,71	5,00	16,00	54,00	0,12
F3AU0480ADK38	4,80	6,00	4,71	6,00	16,00	54,00	0,20
F3AU0575ADK38	5,75	6,00	5,71	7,00	18,00	54,00	0,20
F3AU0775ADK38	7,75	8,00	7,70	9,00	22,00	58,00	0,20
F3AU0970ADK38	9,70	10,00	9,65	11,00	26,00	66,00	0,33
F3AU1170ADK38	11,70	12,00	11,64	12,00	28,00	73,00	0,33
F3AU1370ADK38	13,70	14,00	13,64	14,00	30,00	75,00	0,33
F3AU1570ADK38	15,70	16,00	15,64	16,00	34,00	82,00	0,33
F3AU1770ADK38	17,70	18,00	17,64	18,00	36,00	84,00	0,40
F3AU1970ADK38	19,70	20,00	19,63	20,00	42,00	92,00	0,40

NOTE: For application data, see page P189.

F2AU...A/BDK38...



Material Group		Side Milling (A) and Slotting (B)			KC643M			Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 10%.										
		A		B	Cutting Speed — vc m/min				D1 — Diameter									
		ap	ae	ap	min		max	mm	2,0	3,0	4,0	6,0	8,0	10,0	12,0	14,0	16,0	20,0
P	0	1 x D	0,5 x D	0,75 x D	150	–	200	fz	0,014	0,021	0,028	0,044	0,060	0,072	0,083	0,092	0,101	0,114
	1	1 x D	0,5 x D	0,75 x D	150	–	200	fz	0,014	0,021	0,028	0,044	0,060	0,072	0,083	0,092	0,101	0,114
	2	1 x D	0,5 x D	0,75 x D	140	–	190	fz	0,014	0,021	0,028	0,044	0,060	0,072	0,083	0,092	0,101	0,114
	3	1 x D	0,5 x D	0,75 x D	120	–	160	fz	0,011	0,017	0,023	0,036	0,050	0,061	0,070	0,079	0,087	0,101
	4	1 x D	0,5 x D	0,75 x D	90	–	150	fz	0,010	0,016	0,021	0,033	0,045	0,054	0,062	0,070	0,077	0,088
	5	1 x D	0,5 x D	0,75 x D	60	–	100	fz	0,009	0,014	0,019	0,029	0,040	0,048	0,056	0,063	0,070	0,081
	6	1 x D	0,5 x D	0,75 x D	50	–	75	fz	0,008	0,012	0,016	0,025	0,034	0,040	0,047	0,052	0,057	0,065
M	1	1 x D	0,5 x D	0,75 x D	90	–	115	fz	0,011	0,017	0,023	0,036	0,050	0,061	0,070	0,079	0,087	0,101
	2	1 x D	0,5 x D	0,75 x D	60	–	80	fz	0,009	0,014	0,019	0,029	0,040	0,048	0,056	0,063	0,070	0,081
	3	1 x D	0,5 x D	0,75 x D	60	–	70	fz	0,008	0,012	0,016	0,025	0,034	0,040	0,047	0,052	0,057	0,065
K	1	1 x D	0,5 x D	0,75 x D	120	–	150	fz	0,014	0,021	0,028	0,044	0,060	0,072	0,083	0,092	0,101	0,114
	2	1 x D	0,5 x D	0,75 x D	110	–	140	fz	0,011	0,017	0,023	0,036	0,050	0,061	0,070	0,079	0,087	0,101
	3	1 x D	0,5 x D	0,75 x D	110	–	130	fz	0,009	0,014	0,019	0,029	0,040	0,048	0,056	0,063	0,070	0,081
S	1	1 x D	0,3 x D	0,3 x D	50	–	90	fz	0,011	0,017	0,023	0,036	0,050	0,061	0,070	0,079	0,087	0,101
	2	1 x D	0,3 x D	0,3 x D	25	–	40	fz	0,006	0,009	0,013	0,019	0,026	0,032	0,037	0,042	0,046	0,054
	3	1 x D	0,3 x D	0,3 x D	25	–	40	fz	0,006	0,009	0,013	0,019	0,026	0,032	0,037	0,042	0,046	0,054
	4	1 x D	0,5 x D	0,75 x D	50	–	60	fz	0,007	0,011	0,016	0,026	0,037	0,045	0,052	0,058	0,064	0,074
H	1	1 x D	0,5 x D	0,75 x D	80	–	140	fz	0,010	0,016	0,021	0,033	0,045	0,054	0,062	0,070	0,077	0,088

NOTE: Those guidelines may require variations to achieve optimum results.
Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters accordingly on >12mm diameter.

F3AU...A/BDK38... • Unequal Flute Spacing





Material Group		Side Milling (A) and Slotting (B)			KC643M			Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 10%.									
		A		B	Cutting Speed – vc m/min				D1 – Diameter								
		ap	ae	ap	min		max	mm	2,0	3,0	4,0	6,0	8,0	10,0	12,0	14,0	16,0	20,0
P	0	1 x D	0,5 x D	0,75 x D	150	–	200	fz	0,014	0,021	0,028	0,044	0,060	0,072	0,083	0,092	0,101	0,114
	1	1 x D	0,5 x D	0,75 x D	150	–	200	fz	0,014	0,021	0,028	0,044	0,060	0,072	0,083	0,092	0,101	0,114
	2	1 x D	0,5 x D	0,75 x D	140	–	190	fz	0,014	0,021	0,028	0,044	0,060	0,072	0,083	0,092	0,101	0,114
	3	1 x D	0,5 x D	0,75 x D	120	–	160	fz	0,011	0,017	0,023	0,036	0,050	0,061	0,070	0,079	0,087	0,101
	4	1 x D	0,5 x D	0,75 x D	90	–	150	fz	0,010	0,016	0,021	0,033	0,045	0,054	0,062	0,070	0,077	0,088
	5	1 x D	0,5 x D	0,75 x D	60	–	100	fz	0,009	0,014	0,019	0,029	0,040	0,048	0,056	0,063	0,070	0,081
	6	1 x D	0,5 x D	0,75 x D	50	–	75	fz	0,008	0,012	0,016	0,025	0,034	0,040	0,047	0,052	0,057	0,065
M	1	1 x D	0,5 x D	0,75 x D	90	–	115	fz	0,011	0,017	0,023	0,036	0,050	0,061	0,070	0,079	0,087	0,101
	2	1 x D	0,5 x D	0,75 x D	60	–	80	fz	0,009	0,014	0,019	0,029	0,040	0,048	0,056	0,063	0,070	0,081
	3	1 x D	0,5 x D	0,75 x D	60	–	70	fz	0,008	0,012	0,016	0,025	0,034	0,040	0,047	0,052	0,057	0,065
K	1	1 x D	0,5 x D	0,75 x D	120	–	150	fz	0,014	0,021	0,028	0,044	0,060	0,072	0,083	0,092	0,101	0,114
	2	1 x D	0,5 x D	0,75 x D	110	–	140	fz	0,011	0,017	0,023	0,036	0,050	0,061	0,070	0,079	0,087	0,101
	3	1 x D	0,5 x D	0,75 x D	110	–	130	fz	0,009	0,014	0,019	0,029	0,040	0,048	0,056	0,063	0,070	0,081
S	1	1 x D	0,3 x D	0,3 x D	50	–	90	fz	0,011	0,017	0,023	0,036	0,050	0,061	0,070	0,079	0,087	0,101
	2	1 x D	0,3 x D	0,3 x D	25	–	40	fz	0,006	0,009	0,013	0,019	0,026	0,032	0,037	0,042	0,046	0,054
	3	1 x D	0,3 x D	0,3 x D	25	–	40	fz	0,006	0,009	0,013	0,019	0,026	0,032	0,037	0,042	0,046	0,054
	4	1 x D	0,5 x D	0,75 x D	50	–	60	fz	0,007	0,011	0,016	0,026	0,037	0,045	0,052	0,058	0,064	0,074
H	1	1 x D	0,5 x D	0,75 x D	80	–	140	fz	0,010	0,016	0,021	0,033	0,045	0,054	0,062	0,070	0,077	0,088

NOTE: Those guidelines may require variations to achieve optimum results.
Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters accordingly on >12mm diameter.

GOmill™

Economical High-Performance End Mills

Primary Application

The GOmill line is specifically engineered to work on short length-of-cut applications in multiple workpiece materials, like soft and hard steels up to 48 HRC, stainless steels, high-temperature alloys, and cast iron. With the very short overall length and soft cutting geometries, this line is made to conform to the growing market of mill-turn machines.

- Extremely stable cutting tool due to extremely short design.
- Less vibration due to unequal flute spacing.
- Soft cut to support mill-turn machines as well driven units in lathe tooling.
- Use a new GOmill with 100% performance instead of regrinding.

Features and Benefits

Advanced Technology

- The 3-flute sharp and 4-flute chamfer versions support roughing, semi-finishing, and finishing applications.
- The 3-flute ball nose tool supports roughing and semi-finishing applications.
- All geometries work in slotting and side milling applications up to 1 x D depth of cut.
- Shortened shank applicable for all common clamping adaptors without modifications. Only use clamping sleeve in hydraulic chucks to avoid vibrations.

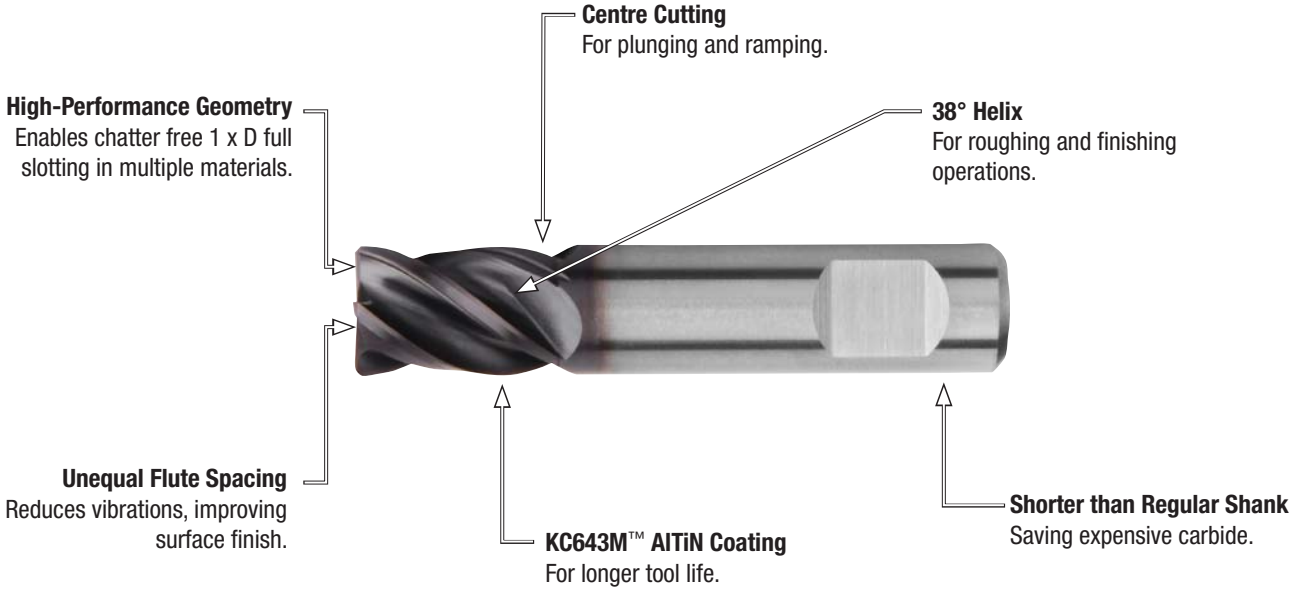
Tailored Grades

- Universal KC643M™ grade suitable for cutting steel, cast iron, stainless steel (wet), and titanium (wet).

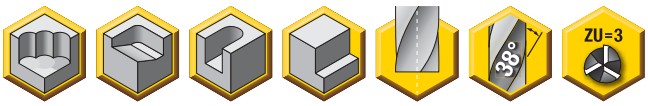
Extensive Standard Offering

- Diameter ranges 2 to 12mm.
- Straight and adapted Weldon® shanks.

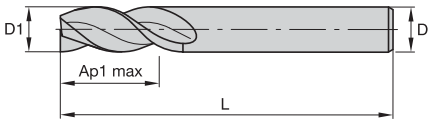



Centre Cutting
For plunging and ramping.
High-Performance Geometry
Enables chatter free 1 x D full slotting in multiple materials.
38° Helix
For roughing and finishing operations.
Unequal Flute Spacing
Reduces vibrations, improving surface finish.
KC643M™ AlTiN Coating
For longer tool life.
Shorter than Regular Shank
Saving expensive carbide.

- Kennametal standard dimensions.
- Centre cutting.
- Unequal flute spacing.
- Roughing/finishing.





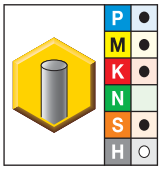


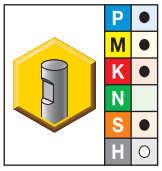
End Mill Tolerances

D1	tolerance e8	D	tolerance h6
≤ 3	-0,014 / -0,028	≤ 3	+0 / -0,006
> 3–6	-0,020 / -0,038	> 3–6	+0 / -0,008
> 6–10	-0,025 / -0,047	> 6–10	+0 / -0,009
> 10–18	-0,032 / -0,059	> 10–18	+0 / -0,011
> 18–30	-0,040 / -0,073	> 18–30	+0 / -0,013

GOmill

GOmill • UEDE



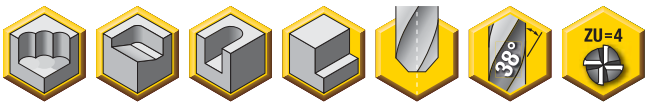


● first choice
○ alternate choice

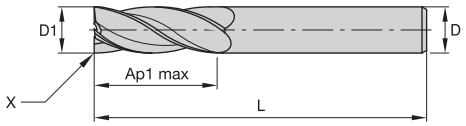
KC643M	KC643M	D1	D	Ap1 max	L
UEDE0200A3AS	**UEDE0200B3AS**	2,00	6,00	4,00	38,00
UEDE0300A3AS	**UEDE0300B3AS**	3,00	6,00	5,00	38,00
UEDE0400A3AS	**UEDE0400B3AS**	4,00	6,00	7,00	38,00
UEDE0500A3AS	**UEDE0500B3AS**	5,00	6,00	8,00	38,00
UEDE0600A3AS	**UEDE0600B3AS**	6,00	6,00	8,00	38,00
UEDE0800A3AS	**UEDE0800B3AS**	8,00	8,00	11,00	43,00
UEDE1000A3AS	**UEDE1000B3AS**	10,00	10,00	13,00	50,00
UEDE1200A3AS	**UEDE1200B3AS**	12,00	12,00	15,00	55,00

NOTE: For application data, see page P196.
Use reducer sleeve when clamping in hydraulic chucks.

- Single tool for both roughing and finishing operations for fewer setups.
- Unequal flute spacing minimises chatter for smoother machining.
- Kennametal standard dimensions.
- Centre cutting.





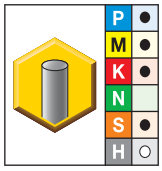


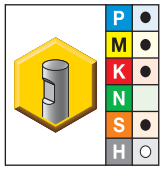
End Mill Tolerances

D1	tolerance e8	D	tolerance h6
≤ 3	-0,014 / -0,028	≤ 3	+0 / -0,006
> 3–6	-0,020 / -0,038	> 3–6	+0 / -0,008
> 6–10	-0,025 / -0,047	> 6–10	+0 / -0,009
> 10–18	-0,032 / -0,059	> 10–18	+0 / -0,011
> 18–30	-0,040 / -0,073	> 18–30	+0 / -0,013

GOmill™

GOmill • UEDE





● first choice
○ alternate choice

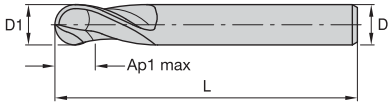
KC643M	KC643M	D1	D	Ap1 max	L
UEDE0400A4AH	**UEDE0400B4AH**	4,00	6,00	7,00	38,00
UEDE0600A4AH	**UEDE0600B4AH**	6,00	6,00	8,00	38,00
UEDE0800A4AH	**UEDE0800B4AH**	8,00	8,00	11,00	43,00
UEDE1000A4AH	**UEDE1000B4AH**	10,00	10,00	13,00	50,00
UEDE1200A4AH	**UEDE1200B4AH**	12,00	12,00	15,00	55,00

NOTE: For application data, see page P196.
Use reducer sleeve when clamping in hydraulic chucks.

- Kennametal standard dimensions.
- Semi-finishing/finishing.
- Centre cutting.





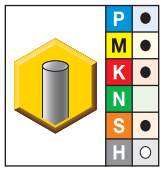


End Mill Tolerances

D1	tolerance e8	D	tolerance h6
≤ 3	-0,014 / -0,028	≤ 3	+0 / -0,006
> 3–6	-0,020 / -0,038	> 3–6	+0 / -0,008
> 6–10	-0,025 / -0,047	> 6–10	+0 / -0,009
> 10–18	-0,032 / -0,059	> 10–18	+0 / -0,011
> 18–30	-0,040 / -0,073	> 18–30	+0 / -0,013

GOmill

GOmill • UEBC



● first choice
○ alternate choice

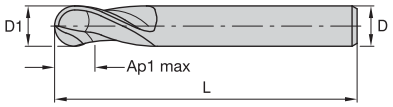
KC643M	D1	D	Ap1 max	L
UEBC0200A2A	2,00	6,00	4,00	38,00
UEBC0300A2A	3,00	6,00	5,00	38,00
UEBC0400A2A	4,00	6,00	7,00	38,00
UEBC0500A2A	5,00	6,00	8,00	38,00
UEBC0600A2A	6,00	6,00	8,00	38,00
UEBC0800A2A	8,00	8,00	11,00	43,00
UEBC1000A2A	10,00	10,00	13,00	50,00
UEBC1200A2A	12,00	12,00	15,00	73,00

NOTE: For application data, see page P197.
Use reducer sleeve when clamping in hydraulic chucks.

- Single tool for both roughing and finishing operations for fewer setups.
- Unequal flute spacing minimises chatter for smoother machining.
- Kennametal standard dimensions.
- Centre cutting.





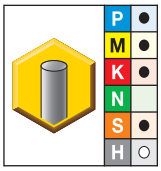


End Mill Tolerances

D1	tolerance e8	D	tolerance h6
≤ 3	-0,014 / -0,028	≤ 3	+0 / -0,006
> 3–6	-0,020 / -0,038	> 3–6	+0 / -0,008
> 6–10	-0,025 / -0,047	> 6–10	+0 / -0,009
> 10–18	-0,032 / -0,059	> 10–18	+0 / -0,011
> 18–30	-0,040 / -0,073	> 18–30	+0 / -0,013

GOmill™

GOmill • UEBE

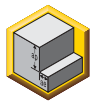


● first choice
○ alternate choice

KC643M	D1	D	Ap1 max	L
UEBE0200A3A	2,00	6,00	4,00	38,00
UEBE0300A3A	3,00	6,00	5,00	38,00
UEBE0400A3A	4,00	6,00	7,00	38,00
UEBE0500A3A	5,00	6,00	8,00	38,00
UEBE0600A3A	6,00	6,00	8,00	38,00
UEBE0800A3A	8,00	8,00	11,00	43,00
UEBE1000A3A	10,00	10,00	13,00	50,00
UEBE1200A3A	12,00	12,00	15,00	55,00

NOTE: For application data, see page P197.
Use reducer sleeve when clamping in hydraulic chucks.

UEDE • 3-Flute Sharp

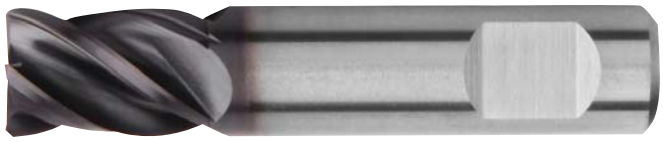




Material Group		Side Milling (A) and Slotting (B)			KC643M			Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 10%.							
		A		B	Cutting Speed — vc m/min			D1 — Diameter							
		ap	ae	ap	min	max	mm	2,0	3,0	4,0	5,0	6,0	8,0	10,0	12,0
P	0	1,5 x D	0,5 x D	1 x D	150	200	fz	0,014	0,022	0,028	0,036	0,044	0,060	0,072	0,083
	1	1,5 x D	0,5 x D	1 x D	150	200	fz	0,014	0,022	0,028	0,036	0,044	0,060	0,072	0,083
	2	1,5 x D	0,5 x D	1 x D	140	190	fz	0,014	0,022	0,028	0,036	0,044	0,060	0,072	0,083
	3	1,5 x D	0,5 x D	1 x D	120	160	fz	0,012	0,018	0,023	0,030	0,036	0,050	0,061	0,070
	4	1,5 x D	0,5 x D	0,75 x D	90	150	fz	0,011	0,016	0,021	0,027	0,033	0,045	0,054	0,062
	5	1,5 x D	0,5 x D	1 x D	60	100	fz	0,010	0,015	0,019	0,024	0,029	0,040	0,048	0,056
	6	1,5 x D	0,5 x D	0,75 x D	50	75	fz	0,008	0,012	0,016	0,020	0,025	0,034	0,040	0,047
M	1	1,5 x D	0,5 x D	1 x D	90	115	fz	0,012	0,018	0,023	0,030	0,036	0,050	0,061	0,070
	2	1,5 x D	0,5 x D	1 x D	60	80	fz	0,010	0,015	0,019	0,024	0,029	0,040	0,048	0,056
	3	1,5 x D	0,5 x D	1 x D	60	70	fz	0,008	0,012	0,016	0,020	0,025	0,034	0,040	0,047
K	1	1,5 x D	0,5 x D	1 x D	120	150	fz	0,014	0,022	0,028	0,036	0,044	0,060	0,072	0,083
	2	1,5 x D	0,5 x D	1 x D	110	140	fz	0,012	0,018	0,023	0,030	0,036	0,050	0,061	0,070
	3	1,5 x D	0,5 x D	1 x D	110	130	fz	0,010	0,015	0,019	0,024	0,029	0,040	0,048	0,056
S	1	1,5 x D	0,3 x D	0,3 x D	50	90	fz	0,012	0,018	0,023	0,030	0,036	0,050	0,061	0,070
	2	1,5 x D	0,3 x D	0,3 x D	25	40	fz	0,006	0,010	0,013	0,016	0,019	0,026	0,032	0,037
	3	1,5 x D	0,3 x D	0,3 x D	25	40	fz	0,006	0,010	0,013	0,016	0,019	0,026	0,032	0,037
	4	1,5 x D	0,5 x D	1 x D	50	60	fz	0,008	0,013	0,016	0,021	0,026	0,037	0,045	0,052
H	1	1,5 x D	0,5 x D	0,75 x D	80	140	fz	0,011	0,016	0,021	0,027	0,033	0,045	0,054	0,062

UEDE • 4-Flute Chamfer





Material Group		Side Milling (A) and Slotting (B)			KC643M			Feed per Tooth — fz information is for side milling (A). For slotting (B), reduce fz by 20%.						
		A		B	Cutting Speed — vc m/min			D1 — Diameter						
		ap	ae	ae	min	max	mm	3,0	4,0	5,0	6,0	8,0	10,0	12,0
P	0	1,5 x D	0,5 x D	1 x D	150	200	fz	0,022	0,028	0,036	0,044	0,060	0,072	0,083
	1	1,5 x D	0,5 x D	1 x D	150	200	fz	0,022	0,028	0,036	0,044	0,060	0,072	0,083
	2	1,5 x D	0,5 x D	1 x D	140	190	fz	0,022	0,028	0,036	0,044	0,060	0,072	0,083
	3	1,5 x D	0,5 x D	1 x D	120	160	fz	0,018	0,023	0,030	0,036	0,050	0,061	0,070
	4	1,5 x D	0,5 x D	0,75 x D	90	150	fz	0,016	0,021	0,027	0,033	0,045	0,054	0,062
	5	1,5 x D	0,5 x D	1 x D	60	100	fz	0,015	0,019	0,024	0,029	0,040	0,048	0,056
	6	1,5 x D	0,5 x D	0,75 x D	50	75	fz	0,012	0,016	0,020	0,025	0,034	0,040	0,047
M	1	1,5 x D	0,5 x D	1 x D	90	115	fz	0,018	0,023	0,030	0,036	0,050	0,061	0,070
	2	1,5 x D	0,5 x D	1 x D	60	80	fz	0,015	0,019	0,024	0,029	0,040	0,048	0,056
	3	1,5 x D	0,5 x D	1 x D	60	70	fz	0,012	0,016	0,020	0,025	0,034	0,040	0,047
K	1	1,5 x D	0,5 x D	1 x D	120	150	fz	0,022	0,028	0,036	0,044	0,060	0,072	0,083
	2	1,5 x D	0,5 x D	1 x D	110	140	fz	0,018	0,023	0,030	0,036	0,050	0,061	0,070
	3	1,5 x D	0,5 x D	1 x D	110	130	fz	0,015	0,019	0,024	0,029	0,040	0,048	0,056
S	1	1,5 x D	0,3 x D	0,3 x D	50	90	fz	0,018	0,023	0,030	0,036	0,050	0,061	0,070
	2	1,5 x D	0,3 x D	0,3 x D	25	40	fz	0,010	0,013	0,016	0,019	0,026	0,032	0,037
	3	1,5 x D	0,3 x D	0,3 x D	25	40	fz	0,010	0,013	0,016	0,019	0,026	0,032	0,037
	4	1,5 x D	0,5 x D	1 x D	50	60	fz	0,013	0,016	0,021	0,026	0,037	0,045	0,052
H	1	1,5 x D	0,5 x D	0,75 x D	80	140	fz	0,016	0,021	0,027	0,033	0,045	0,054	0,062

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.

UEBC • 2-Flute Ball Nose



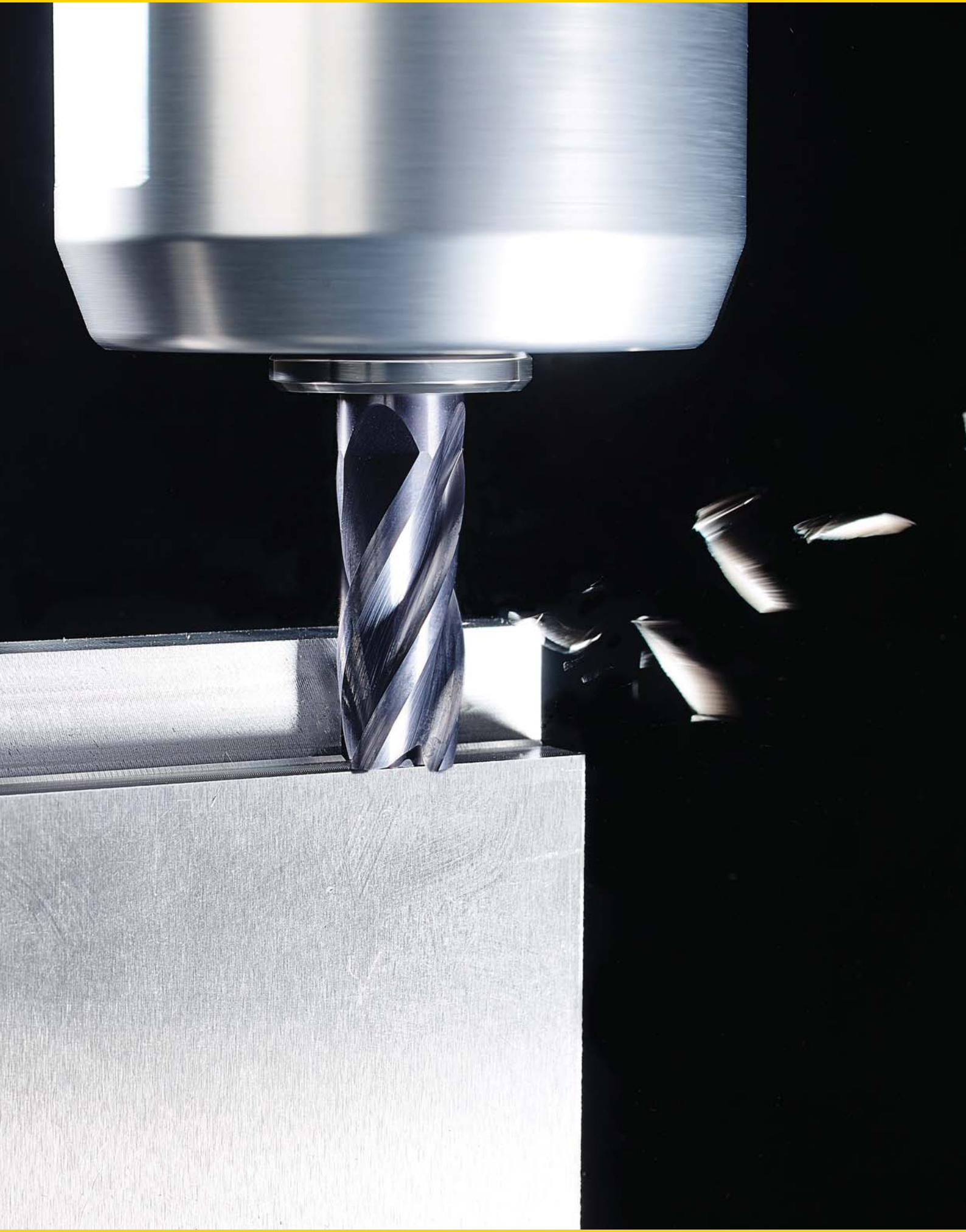
Material Group		Side Milling (A) and Slotting (B) A ap	A ae	B ap	KC643M Cutting Speed — vc m/min min		max		Feed per Tooth — fz information is for side milling (A). For slotting (B), reduce fz by 20%. D1 — Diameter mm	2,0	3,0	4,0	5,0	6,0	8,0	10,0	12,0
P	0	1,5 x D	0,5 x D	1 x D	150	–	200	fz	0,014	0,022	0,028	0,036	0,044	0,060	0,072	0,083
	1	1,5 x D	0,5 x D	1 x D	150	–	200	fz	0,014	0,022	0,028	0,036	0,044	0,060	0,072	0,083
	2	1,5 x D	0,5 x D	1 x D	140	–	190	fz	0,014	0,022	0,028	0,036	0,044	0,060	0,072	0,083
	3	1,5 x D	0,5 x D	1 x D	120	–	160	fz	0,012	0,018	0,023	0,030	0,036	0,050	0,061	0,070
	4	1,5 x D	0,5 x D	0,75 x D	90	–	150	fz	0,011	0,016	0,021	0,027	0,033	0,045	0,054	0,062
	5	1,5 x D	0,5 x D	1 x D	60	–	100	fz	0,010	0,015	0,019	0,024	0,029	0,040	0,048	0,056
	6	1,5 x D	0,5 x D	0,75 x D	50	–	75	fz	0,008	0,012	0,016	0,020	0,025	0,034	0,040	0,047
M	1	1,5 x D	0,5 x D	1 x D	90	–	115	fz	0,012	0,018	0,023	0,030	0,036	0,050	0,061	0,070
	2	1,5 x D	0,5 x D	1 x D	60	–	80	fz	0,010	0,015	0,019	0,024	0,029	0,040	0,048	0,056
	3	1,5 x D	0,5 x D	1 x D	60	–	70	fz	0,008	0,012	0,016	0,020	0,025	0,034	0,040	0,047
K	1	1,5 x D	0,5 x D	1 x D	120	–	150	fz	0,014	0,022	0,028	0,036	0,044	0,060	0,072	0,083
	2	1,5 x D	0,5 x D	1 x D	110	–	140	fz	0,012	0,018	0,023	0,030	0,036	0,050	0,061	0,070
	3	1,5 x D	0,5 x D	1 x D	110	–	130	fz	0,010	0,015	0,019	0,024	0,029	0,040	0,048	0,056
S	1	1,5 x D	0,3 x D	0,3 x D	50	–	90	fz	0,012	0,018	0,023	0,030	0,036	0,050	0,061	0,070
	2	1,5 x D	0,3 x D	0,3 x D	25	–	40	fz	0,006	0,010	0,013	0,016	0,019	0,026	0,032	0,037
	3	1,5 x D	0,3 x D	0,3 x D	25	–	40	fz	0,006	0,010	0,013	0,016	0,019	0,026	0,032	0,037
	4	1,5 x D	0,5 x D	1 x D	50	–	60	fz	0,008	0,013	0,016	0,021	0,026	0,037	0,045	0,052
H	1	1,5 x D	0,5 x D	0,75 x D	80	–	140	fz	0,011	0,016	0,021	0,027	0,033	0,045	0,054	0,062

UEBE • 3-Flute Ball Nose



Material Group		Side Milling (A) and Slotting (B) A ap	A ae	B ap	KC643M Cutting Speed — vc m/min min		max		Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 20%. D1 — Diameter mm	2,0	3,0	4,0	5,0	6,0	8,0	10,0	12,0
P	0	1,5 x D	0,5 x D	1 x D	150	–	200	fz	0,014	0,022	0,028	0,036	0,044	0,060	0,072	0,083
	1	1,5 x D	0,5 x D	1 x D	150	–	200	fz	0,014	0,022	0,028	0,036	0,044	0,060	0,072	0,083
	2	1,5 x D	0,5 x D	1 x D	140	–	190	fz	0,014	0,022	0,028	0,036	0,044	0,060	0,072	0,083
	3	1,5 x D	0,5 x D	1 x D	120	–	160	fz	0,012	0,018	0,023	0,030	0,036	0,050	0,061	0,070
	4	1,5 x D	0,5 x D	0,75 x D	90	–	150	fz	0,011	0,016	0,021	0,027	0,033	0,045	0,054	0,062
	5	1,5 x D	0,5 x D	1 x D	60	–	100	fz	0,010	0,015	0,019	0,024	0,029	0,040	0,048	0,056
	6	1,5 x D	0,5 x D	0,75 x D	50	–	75	fz	0,008	0,012	0,016	0,020	0,025	0,034	0,040	0,047
M	1	1,5 x D	0,5 x D	1 x D	90	–	115	fz	0,012	0,018	0,023	0,030	0,036	0,050	0,061	0,070
	2	1,5 x D	0,5 x D	1 x D	60	–	80	fz	0,010	0,015	0,019	0,024	0,029	0,040	0,048	0,056
	3	1,5 x D	0,5 x D	1 x D	60	–	70	fz	0,008	0,012	0,016	0,020	0,025	0,034	0,040	0,047
K	1	1,5 x D	0,5 x D	1 x D	120	–	150	fz	0,014	0,022	0,028	0,036	0,044	0,060	0,072	0,083
	2	1,5 x D	0,5 x D	1 x D	110	–	140	fz	0,012	0,018	0,023	0,030	0,036	0,050	0,061	0,070
	3	1,5 x D	0,5 x D	1 x D	110	–	130	fz	0,010	0,015	0,019	0,024	0,029	0,040	0,048	0,056
S	1	1,5 x D	0,3 x D	0,3 x D	50	–	90	fz	0,012	0,018	0,023	0,030	0,036	0,050	0,061	0,070
	2	1,5 x D	0,3 x D	0,3 x D	25	–	40	fz	0,006	0,010	0,013	0,016	0,019	0,026	0,032	0,037
	3	1,5 x D	0,3 x D	0,3 x D	25	–	40	fz	0,006	0,010	0,013	0,016	0,019	0,026	0,032	0,037
	4	1,5 x D	0,5 x D	1 x D	50	–	60	fz	0,008	0,013	0,016	0,021	0,026	0,037	0,045	0,052
H	1	1,5 x D	0,5 x D	0,75 x D	80	–	140	fz	0,011	0,016	0,021	0,027	0,033	0,045	0,054	0,062

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.



Solid End Milling • General Purpose Solid Carbide End Mills

GOmill Portfolio Overview.....Q2–Q3

GOmill GP 2-Flute End Mills Q4–Q15

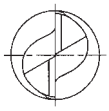
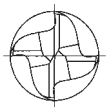
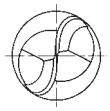
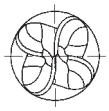
GOmill GP 3-Flute End Mills Q16–Q21

GOmill GP 4-Flute End Mills Q22–Q33

Catalogue Numbering System.....Q34

GOmill GP Cross Reference Guide.....Q35–Q43

End Mill Type Recommendation

End Mills									
Z = number of teeth		Fine Finishing	Finishing	Roughing	Slot Milling	Plunging	Contour Milling	Peel Milling	Trochoidal Milling
end mill Z = 2		○	○	◑	●	●	○	○	○
end mill Z = 3		○	◑	◑	●	◑	○	○	○
end mill Z = 4		◑	●	●	●	○	○	●	●
Ball Nose End Mills									
ball nose end mill Z = 2					●		●		
ball nose end mill Z = 4					◑		●		

● first choice

◑ suitable with limitations

○ not recommended

Always select a tool with the shortest possible flute length whenever possible. This will increase the stability of the tool and give the best results.

When selecting an end mill, the following machining factors will affect your selection of the correct end mill for your application:

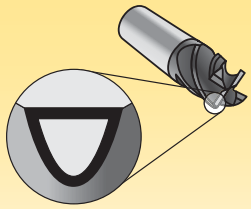
1. Tool overhang.
2. Coolant flow.
3. Machine and setup stability.
4. Machine power and torque.
5. Material to be machined.
6. Machine adaptor size (DV40, DV50, HSK63, etc.).

Select Adaptor per Technical Data/Characteristics

Technical data/characteristics	Toolholders				
	HydroForce™ high torque	Shrink Fit	Milling chuck	ER collet chuck	Weldon® adaptor
torque transmission	★★★★★	★★★★	★★★★★	★★	★★★★★
radial runout (T.I.R.)[1]	★★★★★	★★★★★	★★★★	★★★	★
radial rigidity[2]	★★★★	★★★★★	★★★	★★★	★★★
tool length adjustment	★★★★★	★★★★	★	★★★★	★★
tool shank tolerance requirement	★★★★	★★	★★★	★★★★★	★★★
through coolant	★★★★★	★★★★★	★★★	★★★	★★
minimum quantity lubrication (MQL)	★★★★★	★★★★★	★	★	★
dampening capability	★★★★★	★	★★★	★★★	★★★
shank diameter range[3]	★★★★★	★	★★★★★	★★★★★	★
cost of toolholder	★★	★★★	★	★★★★	★★★★★
low requirement of external devices[4]	★★★★★	★	★★★★	★★★★	★★★★★
ease of handling	★★★★★	★★★	★★	★★★★	★★★★
dust resistance	★★★★★	★★★★★	★★★	★★★	★★★★
high-speed capability	★★★★★	★★★★★	★★★	★★★	★
balancing accuracy	★★★★★	★★★★★	★★★	★★★	★

[1] Radial runout may affect tool life.
[2] Radial rigidity for Weldon holder is low at a direction perpendicular to the screw.
[3] Accepts different shank diameters through the use of reduction sleeves or due to collapse range.
[4] Collet chucks and milling chucks may require the use of a torque or special wrench; Shrink Fit adaptor requires a shrinking unit.

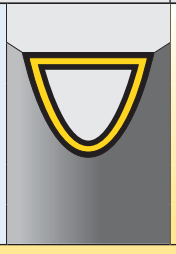
Grades and Grade Descriptions



Coatings provide high-speed capability and are engineered for roughing to finishing.

P	Steel
M	Stainless Steel
K	Cast Iron

wear resistance ◄——► toughness

Grade	Coating	Grade Description		05	10	15	20	25	30	35	40	45
KC633M		Coated carbide grade with PVD multilayer coating. KC633M™ is designed for dry milling most types of material, apart from the hardened variety. This grade is characterised by high hardness and wear resistance. It provides outstanding protection for solid carbide tools against cratering and abrasion.	P									
			M									
			K									

GOmill™ GP General Purpose Solid Carbide End Mills · 2 Flute

Primary Application

The GOmill GP series offers plunging, slotting, and profiling with long tool life on a wide range of workpiece materials. They are designed to provide high Metal Removal Rates (MRR) and achieve good surface quality at an excellent cost-benefit ratio. A wide range of diameters and lengths are available with chamfered edge and ball nose as stocked standard.

- Roughing and finishing with one tool.
- Excellent cost-benefit ratio.
- Multilayer KC633M™ grades for high tool life.



Features and Benefits

Advanced Technology

- Roughing and finishing with one tool reduces tool changes and unnecessary tooling inventory.
- Eccentric relief increases edge stability for longer tool life and better surface quality.
- Eccentric relief eases regrinding and reduces reconditioning cost.
- 2-flute design for unstable conditions and high flexibility.

Tailored Grades

- Universal multilayer KC633M coating for cutting steel, cast iron, and stainless (wet).

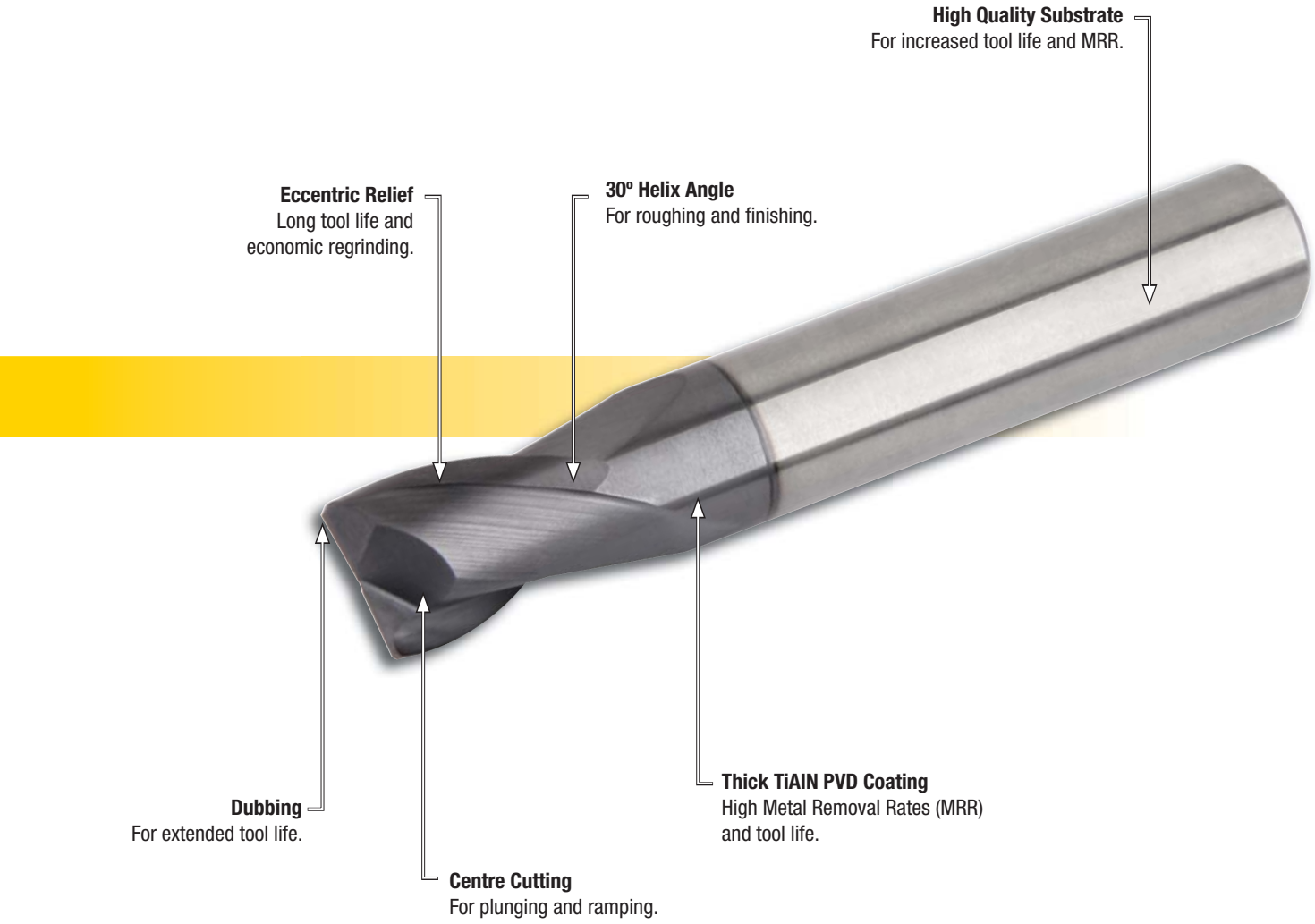
Customisation

- Intermediate diameters available.

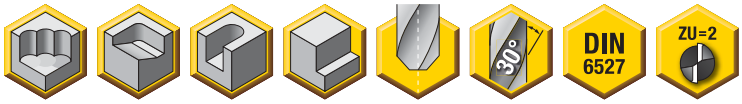
Extensive Standard Offering

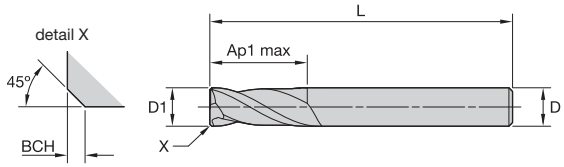
- Diameter range 1–20mm.
- Chamfered edge and ball nose as standard offering.

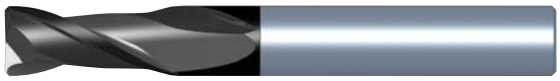
Designed for roughing and finishing with one tool at a value price.



- Centre cutting.



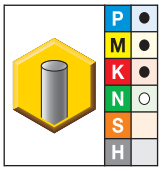


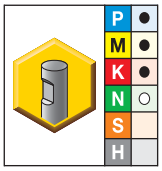


End Mill Tolerances

D1	tolerance e8	D	tolerance h6 + / -
≤ 3	-0,014/-0,028	≤ 3	0/0,006
> 3–6	-0,020/-0,038	> 3–6	0/0,008
> 6–10	-0,025/-0,047	> 6–10	0/0,009
> 10–18	-0,032/-0,059	> 10–18	0/0,011
> 18–30	-0,040/-0,073	> 18–30	0/0,013

2CH..DK-DL • 2 Flute • Metric



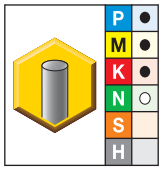


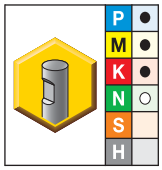
● first choice
○ alternate choice

KC633M	KC633M	D1	D	length of cut Ap1 max	length L	BCH
2CH0200DK003A	–	2,0	6	3,00	50	–
2CH0300DK004A	–	3,0	6	4,00	50	–
2CH0300DL007A	–	3,0	6	7,00	57	–
2CH0350DK004A	–	3,5	6	4,00	50	–
2CH0400DK005A	–	4,0	6	5,00	54	0,10
2CH0400DL008A	–	4,0	6	8,00	57	0,10
2CH0450DK005A	–	4,5	6	5,00	54	0,10
2CH0450DL008A	–	4,5	6	8,00	57	0,10
2CH0500DK006A	–	5,0	6	6,00	54	0,10
2CH0500DL010A	–	5,0	6	10,00	57	0,10
2CH0600DK007A	–	6,0	6	7,00	54	0,10
2CH0600DL010A	–	6,0	6	10,00	57	0,10
2CH0700DK008A	–	7,0	8	8,00	58	0,10
2CH0700DL013A	–	7,0	8	13,00	63	0,10
2CH0800DK009A	–	8,0	8	9,00	58	0,20
2CH0800DL016A	–	8,0	8	16,00	63	0,20
2CH0900DK010A	–	9,0	10	10,00	66	0,20
2CH0900DL016A	–	9,0	10	16,00	72	0,20
2CH1000DK011A	–	10,0	10	11,00	66	0,20
2CH1000DL019A	–	10,0	10	19,00	72	0,20
2CH1200DK012A	2CH1200DK012B	12,0	12	12,00	73	0,30
2CH1200DL022A	2CH1200DL022B	12,0	12	22,00	83	0,30
2CH1400DK014A	2CH1400DK014B	14,0	14	14,00	75	0,30
2CH1400DL022A	2CH1400DL022B	14,0	14	22,00	83	0,30

(continued)

(2CH..DK-DL • 2 Flute • Metric — continued)



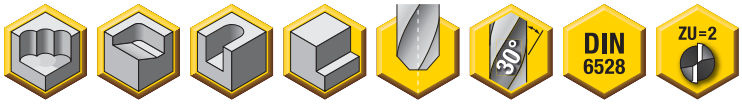


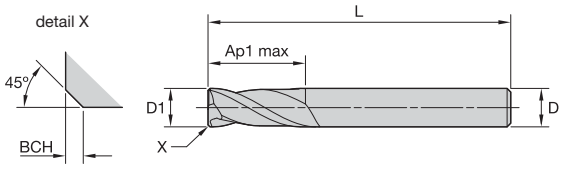
● first choice
○ alternate choice

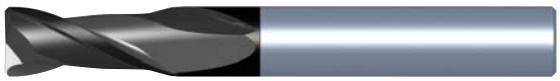
KC633M	KC633M	D1	D	length of cut Ap1 max	length L	BCH
2CH1600DK016A	**2CH1600DK016B**	16,0	16	16,00	82	0,30
2CH1600DL026A	**2CH1600DL026B**	16,0	16	26,00	92	0,30
2CH1800DK018A	**2CH1800DK018B**	18,0	18	18,00	84	0,30
2CH1800DL026A	**–**	18,0	18	26,00	92	0,30
2CH2000DK020A	**2CH2000DK020B**	20,0	20	20,00	92	0,30
2CH2000DL032A	**2CH2000DL032B**	20,0	20	32,00	104	0,30

NOTE: For application data, please see page Q14.

• Centre cutting.



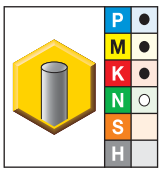




End Mill Tolerances

D1	tolerance e8	D	tolerance h6 + / -
≤ 3	-0,014/-0,028	≤ 3	0/0,006
> 3–6	-0,020/-0,038	> 3–6	0/0,008
> 6–10	-0,025/-0,047	> 6–10	0/0,009
> 10–18	-0,032/-0,059	> 10–18	0/0,011
> 18–30	-0,040/-0,073	> 18–30	0/0,013

2CH..DD • 2 Flute • Metric

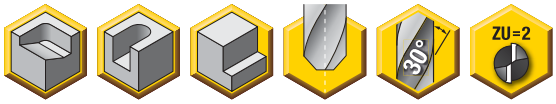


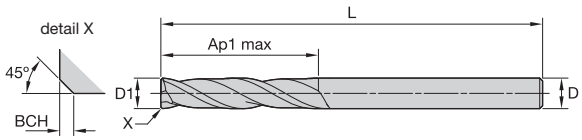
● first choice
○ alternate choice

KC633M	D1	D	length of cut Ap1 max	length L	BCH
2CH0300DD007A	3,0	3	8,00	50	–
2CH0400DD008A	4,0	4	8,00	50	0,10
2CH0500DD010A	5,0	5	10,00	50	0,10
2CH0600DD010A	6,0	6	10,00	57	0,10
2CH0700DD013A	7,0	7	13,00	60	0,10
2CH0800DD016A	8,0	8	16,00	63	0,20
2CH0900DD016A	9,0	9	16,00	67	0,20
2CH1000DD019A	10,0	10	19,00	72	0,20
2CH1200DD022A	12,0	12	22,00	83	0,30
2CH1400DD022A	14,0	14	22,00	83	0,30
2CH1500DD026A	15,0	15	26,00	92	0,30
2CH1600DD026A	16,0	16	26,00	92	0,30
2CH1800DD026A	18,0	18	26,00	92	0,30
2CH2000DD032A	20,0	20	32,00	104	0,30

NOTE: For application data, please see page Q14.

• Centre cutting.



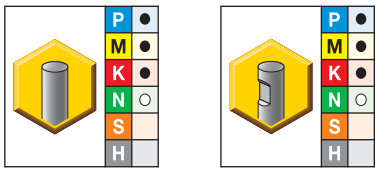




End Mill Tolerances

D1	tolerance e8	D	tolerance h6 + / -
≤ 3	-0,014/-0,028	≤ 3	0/0,006
> 3–6	-0,020/-0,038	> 3–6	0/0,008
> 6–10	-0,025/-0,047	> 6–10	0/0,009
> 10–18	-0,032/-0,059	> 10–18	0/0,011
> 18–30	-0,040/-0,073	> 18–30	0/0,013

2CH..MR-ML-MX • 2 Flute • Metric

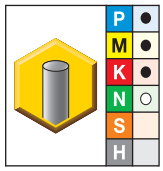


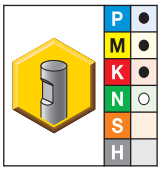
● first choice
○ alternate choice

KC633M	KC633M	D1	D	length of cut Ap1 max	length L	BCH
2CH0200MR006A	–	2,0	3	6,30	38	–
2CH0250MR006A	–	2,5	3	6,30	38	–
2CH0300MR009A	–	3,0	3	9,50	38	–
2CH0300ML019A	–	3,0	3	19,00	63	–
2CH0300MX025A	–	3,0	3	25,00	75	–
2CH0350MR012A	–	3,5	4	12,00	50	–
2CH0400MR012A	–	4,0	4	12,00	50	0,10
2CH0400ML019A	–	4,0	4	19,00	63	0,10
2CH0400MX031A	–	4,0	4	31,00	75	0,10
2CH0450MR014A	–	4,5	6	14,00	50	0,10
2CH0480MR014A	–	4,8	6	14,00	50	0,10
2CH0500MR014A	–	5,0	5	14,00	50	0,10
2CH0500ML020A	–	5,0	5	20,00	63	0,10
2CH0500MX031A	–	5,0	5	31,00	100	0,10
2CH0550MR014A	–	5,5	6	14,00	50	0,10
2CH0600MR016A	–	6,0	6	16,00	50	0,10
2CH0600ML028A	–	6,0	6	28,00	76	0,10
2CH0600MX038A	–	6,0	6	38,00	100	0,10
2CH0700MR020A	–	7,0	7	20,00	63	0,10
2CH0800MR020A	–	8,0	8	20,00	63	0,20
2CH0800ML028A	–	8,0	8	28,00	76	0,20
2CH0800MX041A	–	8,0	8	41,00	100	0,20
2CH0900MR020A	–	9,0	9	20,00	63	0,20
2CH1000MR022A	–	10,0	10	22,00	72	0,20
2CH1000ML032A	–	10,0	10	32,00	89	0,20
2CH1000MX045A	–	10,0	10	45,00	100	0,20
2CH1100MR025A	–	11,0	11	25,00	76	0,30
2CH1200MR025A	2CH1200MR025B	12,0	12	25,00	76	0,30

(continued)

(2CH..MR-ML-MX • 2 Flute • Metric — continued)





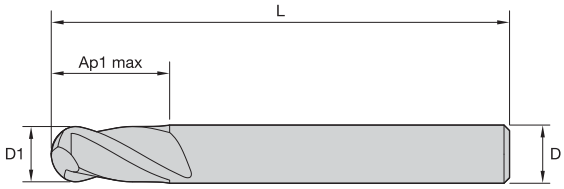
● first choice
○ alternate choice

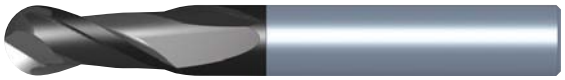
KC633M	KC633M	D1	D	length of cut Ap1 max	length L	BCH
2CH1200ML045A	**2CH1200ML045B**	12,0	12	45,00	100	0,30
2CH1200MX075A	**2CH1200MX075B**	12,0	12	75,00	150	0,30
2CH1400MR032A	**2CH1400MR032B**	14,0	14	32,00	83	0,30
2CH1400ML050A	**2CH1400ML050B**	14,0	14	50,00	100	0,30
2CH1400MX075A	**2CH1400MX075B**	14,0	14	75,00	150	0,30
2CH1600MR032A	**2CH1600MR032B**	16,0	16	32,00	89	0,30
2CH1600ML056A	**2CH1600ML056B**	16,0	16	56,00	110	0,30
2CH1600MX075A	**2CH1600MX075B**	16,0	16	75,00	150	0,30
2CH1800MX075A	**–**	18,0	18	75,00	150	0,30
2CH2000MR038A	**2CH2000MR038B**	20,0	20	38,00	104	0,30
2CH2000ML056A	**2CH2000ML056B**	20,0	20	56,00	125	0,30
2CH2000MX075A	**2CH2000MX075B**	20,0	20	75,00	150	0,30

NOTE: For application data, please see page Q14.

• Centre cutting.



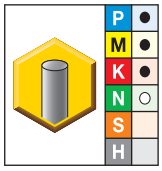




End Mill Tolerances

D1	tolerance e8	D	tolerance h6 + / -
≤ 3	-0,014/-0,028	≤ 3	0/0,006
> 3–6	-0,020/-0,038	> 3–6	0/0,008
> 6–10	-0,025/-0,047	> 6–10	0/0,009
> 10–18	-0,032/-0,059	> 10–18	0/0,011
> 18–30	-0,040/-0,073	> 18–30	0/0,013

2BN..DK-DL • 2 Flute • Ball Nose • Metric



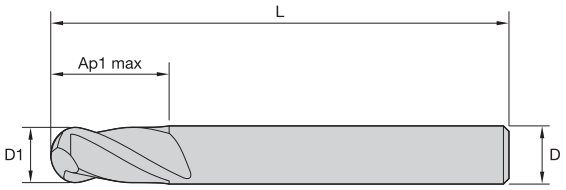
● first choice
○ alternate choice

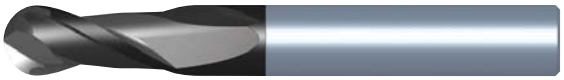
KC633M	D1	D	length of cut Ap1 max	length L
2BN0200DL006A	2,0	6	6,00	57
2BN0300DK004A	3,0	6	4,00	50
2BN0300DL007A	3,0	6	7,00	57
2BN0400DK005A	4,0	6	5,00	54
2BN0400DL008A	4,0	6	8,00	57
2BN0500DL010A	5,0	6	10,00	57
2BN0600DL010A	6,0	6	10,00	57
2BN0700DL013A	7,0	8	13,00	63
2BN0800DL016A	8,0	8	16,00	63
2BN1000DL019A	10,0	10	19,00	72
2BN1200DL022A	12,0	12	22,00	83
2BN1400DL022A	14,0	14	22,00	83
2BN1600DL026A	16,0	16	26,00	92
2BN2000DK020A	20,0	20	20,00	92
2BN2000DL032A	20,0	20	32,00	104

NOTE: For application data, please see page Q15.

• Centre cutting.



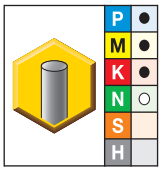




End Mill Tolerances

D1	tolerance e8	D	tolerance h6 + / -
≤ 3	-0,014/-0,028	≤ 3	0/0,006
> 3–6	-0,020/-0,038	> 3–6	0/0,008
> 6–10	-0,025/-0,047	> 6–10	0/0,009
> 10–18	-0,032/-0,059	> 10–18	0/0,011
> 18–30	-0,040/-0,073	> 18–30	0/0,013

2BN..DD • 2 Flute • Ball Nose • Metric

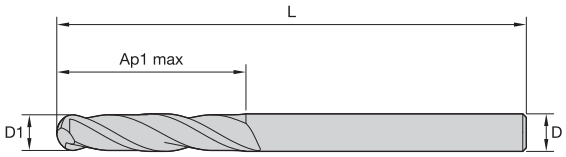


● first choice
○ alternate choice

KC633M	D1	D	length of cut Ap1 max	length L
2BN0200DD007A	2,0	2	7,00	50
2BN0300DD007A	3,0	3	7,00	50
2BN0400DD008A	4,0	4	8,00	50
2BN0500DD010A	5,0	5	10,00	50
2BN0600DD010A	6,0	6	10,00	57
2BN0800DD016A	8,0	8	16,00	63
2BN1000DD019A	10,0	10	19,00	72
2BN1200DD022A	12,0	12	22,00	83
2BN1400DD022A	14,0	14	22,00	83
2BN1600DD026A	16,0	16	26,00	92
2BN2000DD032A	20,0	20	32,00	104

NOTE: For application data, please see page Q15.

• Centre cutting.



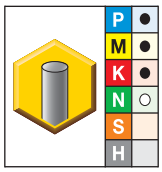




End Mill Tolerances

D1	tolerance e8	D	tolerance h6 + / -
≤ 3	-0,014/-0,028	≤ 3	0/0,006
> 3–6	-0,020/-0,038	> 3–6	0/0,008
> 6–10	-0,025/-0,047	> 6–10	0/0,009
> 10–18	-0,032/-0,059	> 10–18	0/0,011
> 18–30	-0,040/-0,073	> 18–30	0/0,013

2BN..MR-ML-MX • 2 Flute • Ball Nose • Metric



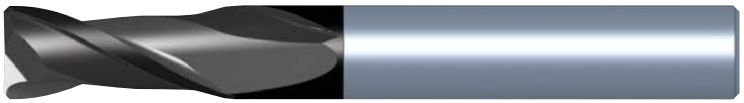
● first choice
○ alternate choice

KC633M	D1	D	length of cut Ap1 max	length L
2BN0100MR004A	1,0	3	4,00	38
2BN0200MR006A	2,0	3	6,30	38
2BN0300MR009A	3,0	3	9,50	38
2BN0350MR012A	3,5	4	12,00	50
2BN0400MR012A	4,0	4	12,00	50
2BN0500MR014A	5,0	6	14,00	50
2BN0600MR038A	6,0	6	38,00	100
2BN0800MR040A	8,0	8	40,00	100
2BN1000MR045A	10,0	10	45,00	100
2BN1200MR025A	12,0	12	25,00	75
2BN1200ML045A	12,0	12	45,00	100
2BN1200MX075A	12,0	12	75,00	150
2BN1400MR032A	14,0	14	32,00	89
2BN1600MR032A	16,0	16	32,00	89
2BN2000MR038A	20,0	20	38,00	100
2BN2000ML075A	20,0	20	75,00	150

NOTE: For application data, please see page Q15.

GOmill GP • 2CH..DK-MR • 2 Flute • Short • Regular

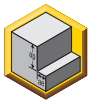
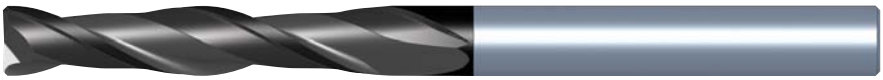




Material Group		Side Milling (A) and Slotting (B)			KC633M			Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 20%.												
		A		B	Cutting Speed — vc m/min			D1 — Diameter												
		ap	ae	ap	min		max	mm	2,0	3,0	4,0	5,0	6,0	8,0	10,0	12,0	14,0	16,0	18,0	20,0
P	0	Ap1 max	0,1 x D	0,5 x D	150	–	200	fz	0,014	0,021	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114
	1	Ap1 max	0,1 x D	0,5 x D	150	–	200	fz	0,014	0,021	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114
	2	Ap1 max	0,1 x D	0,5 x D	140	–	190	fz	0,014	0,021	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114
	3	Ap1 max	0,1 x D	0,5 x D	120	–	160	fz	0,011	0,017	0,023	0,030	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101
	4	Ap1 max	0,1 x D	0,5 x D	90	–	150	fz	0,010	0,016	0,021	0,027	0,033	0,045	0,054	0,062	0,070	0,077	0,083	0,088
M	1	Ap1 max	0,1 x D	0,5 x D	90	–	115	fz	0,011	0,017	0,023	0,030	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101
	2	Ap1 max	0,1 x D	0,5 x D	60	–	80	fz	0,009	0,014	0,019	0,024	0,029	0,040	0,048	0,056	0,063	0,070	0,076	0,081
K	1	Ap1 max	0,1 x D	0,5 x D	120	–	150	fz	0,014	0,021	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114
	2	Ap1 max	0,1 x D	0,5 x D	110	–	140	fz	0,011	0,017	0,023	0,030	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101
N	1	Ap1 max	0,1 x D	0,5 x D	250	–	1000	fz	0,020	0,030	0,040	0,050	0,060	0,080	0,100	0,120	0,140	0,160	0,180	0,200
	2	Ap1 max	0,1 x D	0,5 x D	250	–	750	fz	0,016	0,024	0,032	0,040	0,048	0,064	0,080	0,096	0,112	0,128	0,144	0,160
	4	Ap1 max	0,1 x D	0,5 x D	250	–	750	fz	0,018	0,027	0,036	0,045	0,054	0,072	0,090	0,108	0,126	0,144	0,162	0,180

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters accordingly on >12mm diameter.

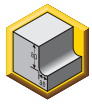
GOmill GP • 2CH..DL-DD-ML-MX • 2 Flute • Long • Extra Long

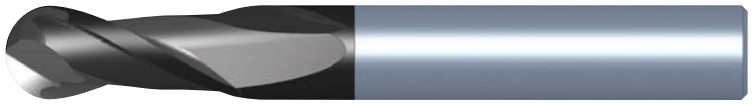



Material Group		Side Milling (A)		KC633M			Recommended feed per tooth (fz = mm/th) for side milling (A).										
		A		Cutting Speed — vc m/min			D1 — Diameter										
		ap	ae	min		max	mm	3,0	4,0	5,0	6,0	8,0	10,0	12,0	14,0	16,0	18,0	20,0
P	0	Ap1 max	0,1 x D	150	–	200	fz	0,021	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114
	1	Ap1 max	0,1 x D	150	–	200	fz	0,021	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114
	2	Ap1 max	0,1 x D	140	–	190	fz	0,021	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114
	3	Ap1 max	0,1 x D	120	–	160	fz	0,017	0,023	0,030	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101
	4	Ap1 max	0,1 x D	90	–	150	fz	0,016	0,021	0,027	0,033	0,045	0,054	0,062	0,070	0,077	0,083	0,088
M	1	Ap1 max	0,1 x D	90	–	115	fz	0,017	0,023	0,030	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101
	2	Ap1 max	0,1 x D	60	–	80	fz	0,014	0,019	0,024	0,029	0,040	0,048	0,056	0,063	0,070	0,076	0,081
K	1	Ap1 max	0,1 x D	120	–	150	fz	0,021	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114
	2	Ap1 max	0,1 x D	110	–	140	fz	0,017	0,023	0,030	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101
N	1	Ap1 max	0,1 x D	250	–	1000	fz	0,030	0,040	0,050	0,060	0,080	0,100	0,120	0,140	0,160	0,180	0,200
	2	Ap1 max	0,1 x D	250	–	750	fz	0,024	0,032	0,040	0,048	0,064	0,080	0,096	0,112	0,128	0,144	0,160
	4	Ap1 max	0,1 x D	250	–	750	fz	0,027	0,036	0,045	0,054	0,072	0,090	0,108	0,126	0,144	0,162	0,180

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters accordingly on >12mm diameter.

GOmill GP • 2BN..DK-MR • 2 Flute • Ball Nose • Short • Regular

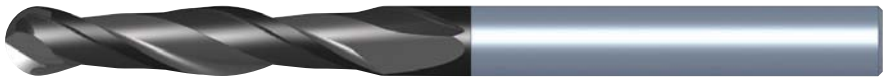




Material Group		Side Milling (A) and Slotting (B)			KC633M			Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 20%.													
		A		B	Cutting Speed — vc m/min			D1 — Diameter													
		ap	ae	ap	min		max	mm	1,0	2,0	3,0	4,0	5,0	6,0	8,0	10,0	12,0	14,0	16,0	18,0	20,0
P	0	Ap1 max	0,1 x D	0,5 x D	150	–	200	fz	0,007	0,014	0,021	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114
	1	Ap1 max	0,1 x D	0,5 x D	150	–	200	fz	0,007	0,014	0,021	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114
	2	Ap1 max	0,1 x D	0,5 x D	140	–	190	fz	0,007	0,014	0,021	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114
	3	Ap1 max	0,1 x D	0,5 x D	120	–	160	fz	0,006	0,011	0,017	0,023	0,030	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101
	4	Ap1 max	0,1 x D	0,5 x D	90	–	150	fz	0,005	0,010	0,016	0,021	0,027	0,033	0,045	0,054	0,062	0,070	0,077	0,083	0,088
M	1	Ap1 max	0,1 x D	0,5 x D	90	–	115	fz	0,006	0,011	0,017	0,023	0,030	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101
	2	Ap1 max	0,1 x D	0,5 x D	60	–	80	fz	0,005	0,009	0,014	0,019	0,024	0,029	0,040	0,048	0,056	0,063	0,070	0,076	0,081
K	1	Ap1 max	0,1 x D	0,5 x D	120	–	150	fz	0,007	0,014	0,021	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114
	2	Ap1 max	0,1 x D	0,5 x D	110	–	140	fz	0,006	0,011	0,017	0,023	0,030	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101
N	1	Ap1 max	0,1 x D	0,5 x D	250	–	1000	fz	0,010	0,020	0,030	0,040	0,050	0,060	0,080	0,100	0,120	0,140	0,160	0,180	0,200
	2	Ap1 max	0,1 x D	0,5 x D	250	–	750	fz	0,008	0,016	0,024	0,032	0,040	0,048	0,064	0,080	0,096	0,112	0,128	0,144	0,160
	4	Ap1 max	0,1 x D	0,5 x D	250	–	750	fz	0,009	0,018	0,027	0,036	0,045	0,054	0,072	0,090	0,108	0,126	0,144	0,162	0,180

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters accordingly on >12mm diameter.

GOmill GP • 2BN..DL-DD-ML-MX • 2 Flute • Ball Nose • Long • Extra Long

Material Group		Side Milling (A)		KC633M			Recommended feed per tooth (fz = mm/th) for side milling (A).											
		A		Cutting Speed — vc m/min			D1 — Diameter											
		ap	ae	min		max	mm	2,0	3,0	4,0	5,0	6,0	8,0	10,0	12,0	14,0	16,0	18,0	20,0
P	0	Ap1 max	0,1 x D	150	–	200	fz	0,014	0,021	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114
	1	Ap1 max	0,1 x D	150	–	200	fz	0,014	0,021	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114
	2	Ap1 max	0,1 x D	140	–	190	fz	0,014	0,021	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114
	3	Ap1 max	0,1 x D	120	–	160	fz	0,011	0,017	0,023	0,030	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101
	4	Ap1 max	0,1 x D	90	–	150	fz	0,010	0,016	0,021	0,027	0,033	0,045	0,054	0,062	0,070	0,077	0,083	0,088
M	1	Ap1 max	0,1 x D	90	–	115	fz	0,011	0,017	0,023	0,030	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101
	2	Ap1 max	0,1 x D	60	–	80	fz	0,009	0,014	0,019	0,024	0,029	0,040	0,048	0,056	0,063	0,070	0,076	0,081
K	1	Ap1 max	0,1 x D	120	–	150	fz	0,014	0,021	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114
	2	Ap1 max	0,1 x D	110	–	140	fz	0,011	0,017	0,023	0,030	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101
N	1	Ap1 max	0,1 x D	250	–	1000	fz	0,020	0,030	0,040	0,050	0,060	0,080	0,100	0,120	0,140	0,160	0,180	0,200
	2	Ap1 max	0,1 x D	250	–	750	fz	0,016	0,024	0,032	0,040	0,048	0,064	0,080	0,096	0,112	0,128	0,144	0,160
	4	Ap1 max	0,1 x D	250	–	750	fz	0,018	0,027	0,036	0,045	0,054	0,072	0,090	0,108	0,126	0,144	0,162	0,180

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters accordingly on >12mm diameter.

GOmill™ GP General Purpose Solid Carbide End Mills · 3 Flute

Primary Application

The GOmill GP series offers plunging, slotting, and profiling with long tool life on a wide range of materials. Designed to provide high Metal Removal Rates (MRR) and to achieve good surface conditions at excellent cost-benefit ratio. A wide range of diameters and lengths with sharp edge are available from stock.

- Roughing and finishing with one tool.
- Excellent cost-benefit ratio.
- Multilayer KC633M™ grades for long tool life.



Features and Benefits

Advanced Technology

- Roughing and finishing with one tool reduces tool changes and unnecessary tooling inventory.
- Eccentric relief increases edge stability for longer tool life and better surface quality.
- Eccentric relief eases regrinding and enables higher flexibility and lower reconditioning cost.
- 3-flute design for maximum manufacturing flexibility.

Tailored Grade

- Universal multilayer KC633M coating for cutting steel, cast iron, and stainless steel (wet).

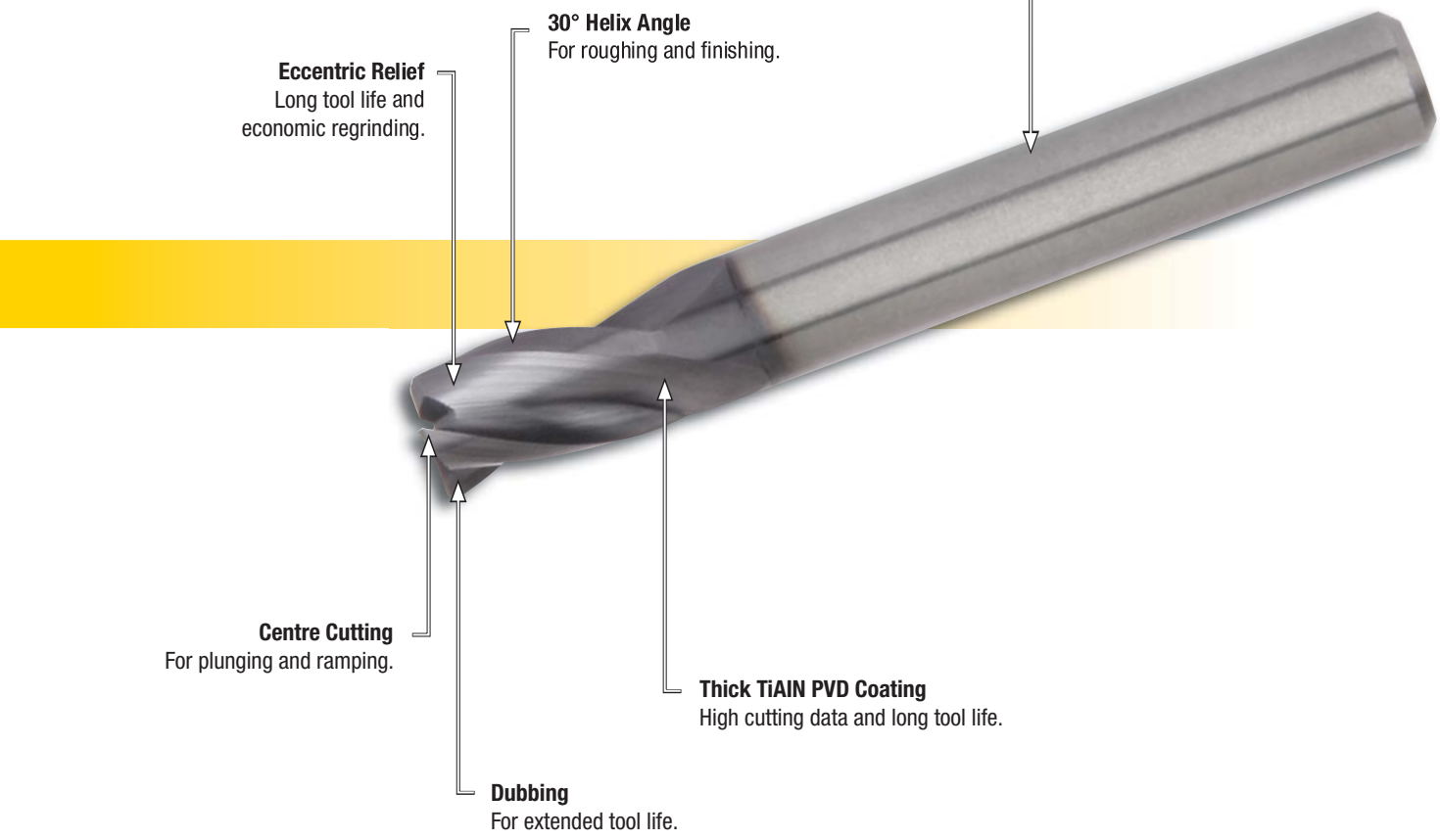
Customisation

- Intermediate diameters available.

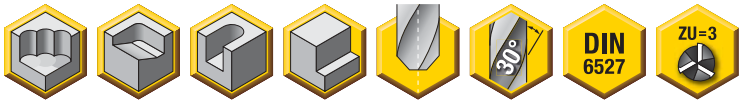
Extensive Standard Offering

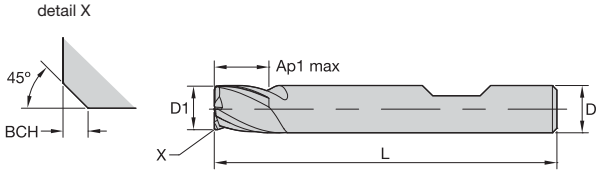
- Diameter range 1–20mm.
- Chamfered edge as standard offering.
- Four different lengths as DIN and factory standards in stock.

Designed for roughing and finishing with one tool at an economical price.



• Centre cutting.



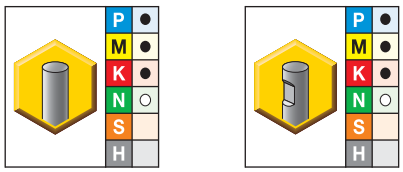




End Mill Tolerances

D1	tolerance e8	D	tolerance h6 + / -
≤ 3	-0,014/-0,028	≤ 3	0/0,006
> 3–6	-0,020/-0,038	> 3–6	0/0,008
> 6–10	-0,025/-0,047	> 6–10	0/0,009
> 10–18	-0,032/-0,059	> 10–18	0/0,011
> 18–30	-0,040/-0,073	> 18–30	0/0,013

3CH..DK-DL • 3 Flute • Metric

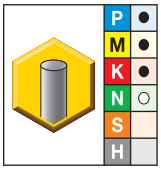


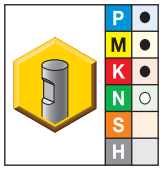
● first choice
○ alternate choice

KC633M	KC633M	D1	D	length of cut Ap1 max	length L	BCH
3CH0200DL006A	3CH0200DL006B	2,0	6	6,00	57	–
3CH0250DK003A	3CH0250DK003B	2,5	6	3,00	50	–
3CH0250DL007A	3CH0250DL007B	2,5	6	7,00	57	–
3CH0300DK004A	3CH0300DK004B	3,0	6	4,00	50	–
3CH0300DL007A	3CH0300DL007B	3,0	6	7,00	57	–
3CH0350DK004A	3CH0350DK004B	3,5	6	4,00	50	–
3CH0350DL007A	3CH0350DL007B	3,5	6	7,00	57	–
3CH0400DK005A	3CH0400DK005B	4,0	6	5,00	54	0,10
3CH0400DL008A	3CH0400DL008B	4,0	6	8,00	57	0,10
3CH0450DK005A	3CH0450DK005B	4,5	6	5,00	54	0,10
3CH0450DL008A	3CH0450DL008B	4,5	6	8,00	57	0,10
3CH0500DK006A	3CH0500DK006B	5,0	6	6,00	54	0,10
3CH0500DL010A	3CH0500DL010B	5,0	6	10,00	57	0,10
3CH0550DK007A	3CH0550DK007B	5,5	6	7,00	54	0,10
3CH0550DL010A	3CH0550DL010B	5,5	6	10,00	57	0,10
3CH0600DK007A	3CH0600DK007B	6,0	6	7,00	54	0,10
3CH0600DL010A	3CH0600DL010B	6,0	6	10,00	57	0,10
3CH0700DK008A	3CH0700DK008B	7,0	8	8,00	58	0,10
3CH0700DL013A	3CH0700DL013B	7,0	8	13,00	63	0,10
3CH0800DK009A	3CH0800DK009B	8,0	8	9,00	58	0,20
3CH0800DL016A	3CH0800DL016B	8,0	8	16,00	63	0,20
3CH1000DK011A	3CH1000DK011B	10,0	10	11,00	66	0,20
3CH1000DL019A	3CH1000DL019B	10,0	10	19,00	72	0,20
3CH1200DK012A	3CH1200DK012B	12,0	12	12,00	73	0,30

(continued)

(3CH..DK-DL • 3 Flute • Metric — continued)



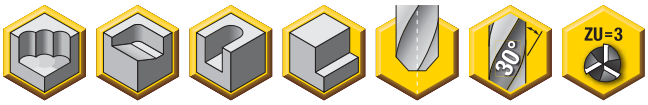


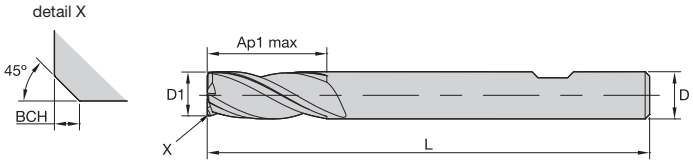
● first choice
○ alternate choice

KC633M	KC633M	D1	D	length of cut Ap1 max	length L	BCH
3CH1200DL022A	**3CH1200DL022B**	12,0	12	22,00	83	0,30
3CH1400DK014A	**3CH1400DK014B**	14,0	14	14,00	75	0,30
3CH1400DL022A	**3CH1400DL022B**	14,0	14	22,00	83	0,30
3CH1600DK016A	**3CH1600DK016B**	16,0	16	16,00	82	0,30
3CH1600DL026A	**3CH1600DL026B**	16,0	16	26,00	92	0,30
3CH1800DK018A	**3CH1800DK018B**	18,0	18	18,00	84	0,30
3CH1800DL026A	**3CH1800DL026B**	18,0	18	26,00	92	0,30
3CH2000DK020A	**3CH2000DK020B**	20,0	20	20,00	92	0,30
3CH2000DL032A	**3CH2000DL032B**	20,0	20	32,00	104	0,30

NOTE: For application data, please see page Q21.

- Centre cutting.



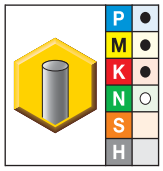


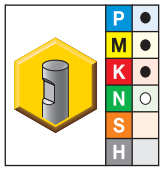


End Mill Tolerances

D1	tolerance e8	D	tolerance h6 + / -
≤ 3	-0,014/-0,028	≤ 3	0/0,006
> 3–6	-0,020/-0,038	> 3–6	0/0,008
> 6–10	-0,025/-0,047	> 6–10	0/0,009
> 10–18	-0,032/-0,059	> 10–18	0/0,011
> 18–30	-0,040/-0,073	> 18–30	0/0,013

3CH..MS-MX • 3 Flute • Metric





● first choice
○ alternate choice

KC633M	KC633M	D1	D	length of cut Ap1 max	length L	BCH
3CH0100MS004A	–	1,0	3	4,00	38	–
3CH0150MS004A	–	1,5	3	4,00	38	–
3CH0200MS006A	–	2,0	3	6,30	38	–
3CH0250MS006A	–	2,5	3	6,30	38	–
3CH0300MS009A	–	3,0	3	9,50	38	–
3CH0300MX019A	**3CH0300MX019B**	3,0	6	19,00	63	–
3CH0400MS012A	–	4,0	4	12,00	50	0,10
3CH0400MX019A	–	4,0	4	19,00	63	0,10
3CH0500MX020A	**3CH0500MX020B**	5,0	6	20,00	63	0,10
3CH0600MS016A	**3CH0600MS016B**	6,0	6	16,00	50	0,10
3CH0600MX028A	**3CH0600MX028B**	6,0	6	28,00	75	0,10
3CH0800MS019A	–	8,0	8	19,00	63	0,20
3CH0800MX028A	**3CH0800MX028B**	8,0	8	28,00	75	0,20
3CH1000MS022A	**3CH1000MS022B**	10,0	10	22,00	76	0,20
3CH1000MX032A	**3CH1000MX032B**	10,0	10	32,00	89	0,20
3CH1200MS025A	**3CH1200MS025B**	12,0	12	25,00	75	0,30
3CH1200MX045A	**3CH1200MX045B**	12,0	12	45,00	100	0,30
3CH1600MS032A	**3CH1600MS032B**	16,0	16	32,00	89	0,30
3CH1600MX056A	**3CH1600MX056B**	16,0	16	56,00	110	0,30
3CH2000MX064A	**3CH2000MX064B**	20,0	20	64,00	125	0,30

NOTE: For application data, please see page Q21.

GOmill • GP 3CH..DK-DL-MS • 3 Flute • Short • Regular



Material Group		Side Milling (A) and Slotting (B)			KC633M			Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 20%.													
		A		B	Cutting Speed – vc m/min				D1 – Diameter												
		ap	ae	ap	min		max	mm	1,0	2,0	3,0	4,0	5,0	6,0	8,0	10,0	12,0	14,0	16,0	18,0	20,0
P	0	Ap1 max	0,1 x D	0,5 x D	150	–	200	fz	0,007	0,014	0,021	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114
	1	Ap1 max	0,1 x D	0,5 x D	150	–	200	fz	0,007	0,014	0,021	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114
	2	Ap1 max	0,1 x D	0,5 x D	140	–	190	fz	0,007	0,014	0,021	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114
	3	Ap1 max	0,1 x D	0,5 x D	120	–	160	fz	0,006	0,011	0,017	0,023	0,030	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101
	4	Ap1 max	0,1 x D	0,5 x D	90	–	150	fz	0,005	0,010	0,016	0,021	0,027	0,033	0,045	0,054	0,062	0,070	0,077	0,083	0,088
M	1	Ap1 max	0,1 x D	0,5 x D	90	–	115	fz	0,006	0,011	0,017	0,023	0,030	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101
	2	Ap1 max	0,1 x D	0,5 x D	60	–	80	fz	0,005	0,009	0,014	0,019	0,024	0,029	0,040	0,048	0,056	0,063	0,070	0,076	0,081
K	1	Ap1 max	0,1 x D	0,5 x D	120	–	150	fz	0,007	0,014	0,021	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114
	2	Ap1 max	0,1 x D	0,5 x D	110	–	140	fz	0,006	0,011	0,017	0,023	0,030	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101
N	1	Ap1 max	0,1 x D	0,5 x D	250	–	1000	fz	0,010	0,020	0,030	0,040	0,050	0,060	0,080	0,100	0,120	0,140	0,160	0,180	0,200
	2	Ap1 max	0,1 x D	0,5 x D	250	–	750	fz	0,008	0,016	0,024	0,032	0,040	0,048	0,064	0,080	0,096	0,112	0,128	0,144	0,160
	4	Ap1 max	0,1 x D	0,5 x D	250	–	750	fz	0,009	0,018	0,027	0,036	0,045	0,054	0,072	0,090	0,108	0,126	0,144	0,162	0,180

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters accordingly on diameters >12mm.

GOmill • GP 3CH..MX • 3 Flute • Long



Material Group		Side Milling (A)		KC633M			Recommended feed per tooth (fz = mm/th) for side milling (A).													
		A		Cutting Speed – vc m/min				D1 – Diameter												
		ap	ae	min		max	mm	1,0	2,0	3,0	4,0	5,0	6,0	8,0	10,0	12,0	14,0	16,0	18,0	20,0
P	0	Ap1 max	0,1 x D	150	–	200	fz	0,007	0,014	0,021	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114
	1	Ap1 max	0,1 x D	150	–	200	fz	0,007	0,014	0,021	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114
	2	Ap1 max	0,1 x D	140	–	190	fz	0,007	0,014	0,021	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114
	3	Ap1 max	0,1 x D	120	–	160	fz	0,006	0,011	0,017	0,023	0,030	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101
	4	Ap1 max	0,1 x D	90	–	150	fz	0,005	0,010	0,016	0,021	0,027	0,033	0,045	0,054	0,062	0,070	0,077	0,083	0,088
M	1	Ap1 max	0,1 x D	90	–	115	fz	0,006	0,011	0,017	0,023	0,030	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101
	2	Ap1 max	0,1 x D	60	–	80	fz	0,005	0,009	0,014	0,019	0,024	0,029	0,040	0,048	0,056	0,063	0,070	0,076	0,081
K	1	Ap1 max	0,1 x D	120	–	150	fz	0,007	0,014	0,021	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114
	2	Ap1 max	0,1 x D	110	–	140	fz	0,006	0,011	0,017	0,023	0,030	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101
N	1	Ap1 max	0,1 x D	250	–	1000	fz	0,010	0,020	0,030	0,040	0,050	0,060	0,080	0,100	0,120	0,140	0,160	0,180	0,200
	2	Ap1 max	0,1 x D	250	–	750	fz	0,008	0,016	0,024	0,032	0,040	0,048	0,064	0,080	0,096	0,112	0,128	0,144	0,160
	4	Ap1 max	0,1 x D	250	–	750	fz	0,009	0,018	0,027	0,036	0,045	0,054	0,072	0,090	0,108	0,126	0,144	0,162	0,180

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters accordingly on diameters >12mm.

GOmill™ GP General Purpose Solid Carbide End Mills · 4 Flute

Primary Application

The GOmill GP series offers plunging, slotting, and profiling with long tool life in a wide range of workpiece materials. These end mills are designed to provide high Metal Removal Rates (MRR) and to achieve good surface quality at an excellent cost-benefit ratio. A wide range of diameters and lengths are available with chamfered edge and ball nose as stocked standard.

- Roughing and finishing with one tool.
- Excellent cost-benefit ratio.
- Multilayer KC633M™ grades for long tool life.



Features and Benefits

Advanced Technology

- Roughing and finishing with one tool reduces tool changes and unnecessary tooling inventory.
- Eccentric relief increases edge stability for longer tool life and better surface quality.
- Eccentric relief eases regrinding and reduces reconditioning cost.
- 4-flute design for high MRR and reduced machining time.

Tailored Grades

- Universal multilayer KC633M coating for cutting steel, cast iron, and stainless steel (wet).

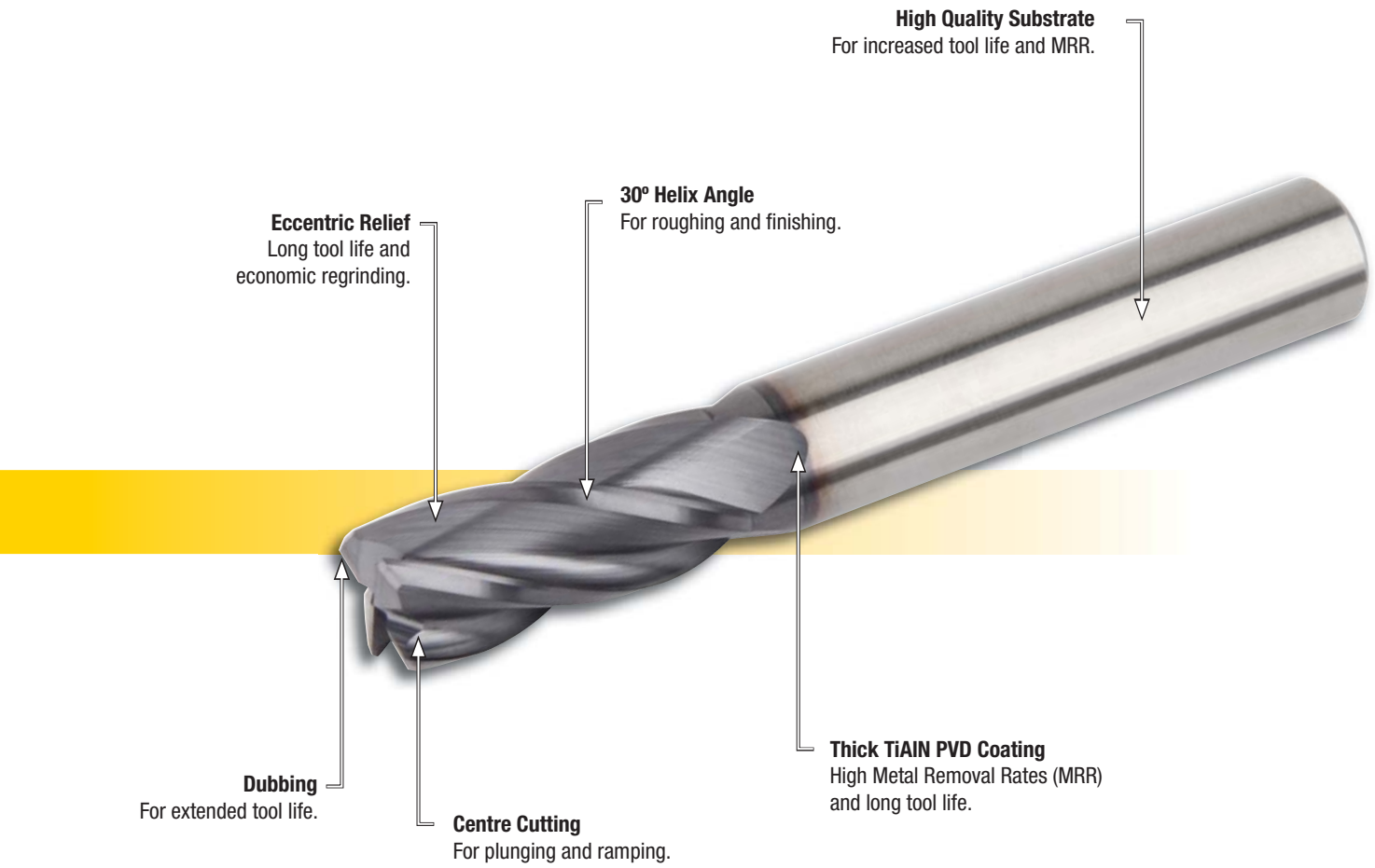
Customisation

- Intermediate diameters available.

Extensive Standard Offering

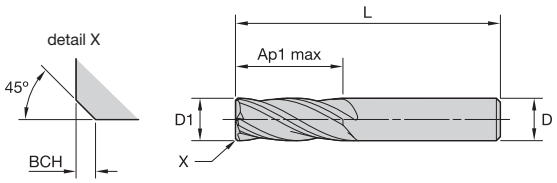
- Diameter range 2–20mm.
- Chamfered edge and ball nose as standard offering.

Designed for roughing and finishing with one tool at a value price.



• Centre cutting.



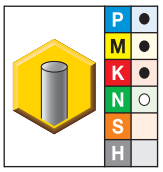


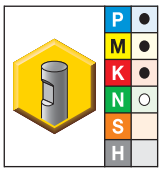


End Mill Tolerances

D1	tolerance e8	D	tolerance h6 + / -
≤ 3	-0,014/-0,028	≤ 3	0/0,006
> 3–6	-0,020/-0,038	> 3–6	0/0,008
> 6–10	-0,025/-0,047	> 6–10	0/0,009
> 10–18	-0,032/-0,059	> 10–18	0/0,011
> 18–30	-0,040/-0,073	> 18–30	0/0,013

4CH..DK-DL • 4 Flute • Metric



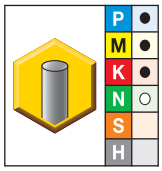


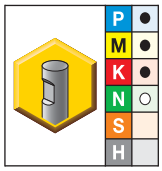
● first choice
○ alternate choice

KC633M	KC633M	D1	D	length of cut Ap1 max	length L	BCH
4CH0200DK004A	–	2,0	3	4,00	38	–
4CH0250DL008A	–	2,5	6	8,00	57	–
4CH0300DK005A	–	3,0	6	5,00	50	–
4CH0350DL010A	–	3,5	6	10,00	58	–
4CH0400DK008A	–	4,0	6	8,00	54	0,10
4CH0400DL011A	–	4,0	6	11,00	57	0,10
4CH0450DL011A	–	4,5	6	11,00	57	0,10
4CH0500DK009A	–	5,0	6	9,00	54	0,10
4CH0500DL013A	–	5,0	6	13,00	57	0,10
4CH0550DL013A	–	5,5	6	13,00	57	0,10
4CH0600DK010A	–	6,0	6	10,00	54	0,10
4CH0600DL013A	–	6,0	6	13,00	57	0,10
4CH0650DL016A	–	6,5	8	16,00	63	0,10
4CH0700DK011A	–	7,0	8	11,00	58	0,10
4CH0700DL016A	–	7,0	8	16,00	63	0,10
4CH0800DK012A	–	8,0	8	12,00	58	0,20
4CH0800DL019A	–	8,0	8	19,00	63	0,20
4CH0900DK013A	–	9,0	10	13,00	66	0,20
4CH0900DL019A	–	9,0	10	19,00	72	0,20
4CH1000DK014A	–	10,0	10	14,00	66	0,20
4CH1000DL022A	–	10,0	10	22,00	72	0,20
4CH1200DK016A	4CH1200DK016B	12,0	12	16,00	73	0,30
4CH1200DL026A	4CH1200DL026B	12,0	12	26,00	83	0,30
4CH1400DK018A	4CH1400DK018B	14,0	14	18,00	75	0,30

(continued)

(4CH..DK-DL • 4 Flute • Metric — continued)





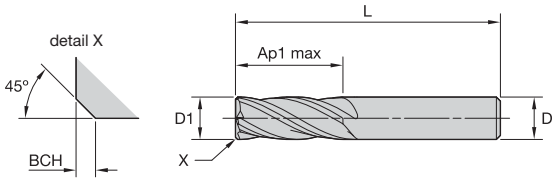
● first choice
○ alternate choice

KC633M	KC633M	D1	D	length of cut Ap1 max	length L	BCH
4CH1400DL026A	**4CH1400DL026B**	14,0	14	26,00	83	0,30
4CH1600DK022A	**4CH1600DK022B**	16,0	16	22,00	82	0,30
4CH1600DL032A	**4CH1600DL032B**	16,0	16	32,00	92	0,30
4CH1800DK024A	**4CH1800DK024B**	18,0	18	24,00	84	0,30
4CH1800DL032A	**4CH1800DL032B**	18,0	18	32,00	92	0,30
4CH2000DK026A	**4CH2000DK026B**	20,0	20	26,00	92	0,30
4CH2000DL038A	**4CH2000DL038B**	20,0	20	38,00	104	0,30

NOTE: For application data, please see page Q32.

• Centre cutting.



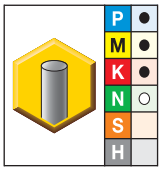




End Mill Tolerances

D1	tolerance e8	D	tolerance h6 + / -
≤ 3	-0,014/-0,028	≤ 3	0/0,006
> 3–6	-0,020/-0,038	> 3–6	0/0,008
> 6–10	-0,025/-0,047	> 6–10	0/0,009
> 10–18	-0,032/-0,059	> 10–18	0/0,011
> 18–30	-0,040/-0,073	> 18–30	0/0,013

4CH..DD • 4 Flute • Metric

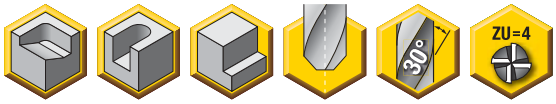


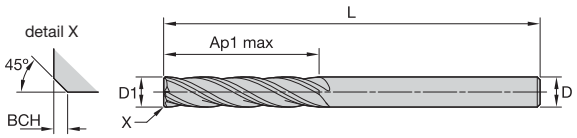
● first choice
○ alternate choice

KC633M	D1	D	length of cut Ap1 max	length L	BCH
4CH0400DD011A	4,0	4	11,00	50	0,10
4CH0500DD013A	5,0	5	13,00	50	0,10
4CH0600DD013A	6,0	6	13,00	57	0,10
4CH0800DD019A	8,0	8	19,00	63	0,20
4CH1000DD022A	10,0	10	22,00	72	0,20
4CH1200DD026A	12,0	12	26,00	83	0,30
4CH1400DD026A	14,0	14	26,00	83	0,30
4CH1600DD032A	16,0	16	32,00	92	0,30
4CH1800DD032A	18,0	18	32,00	92	0,30
4CH2000DD038A	20,0	20	38,00	104	0,30

NOTE: For application data, please see page Q32.

• Centre cutting.



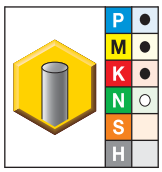


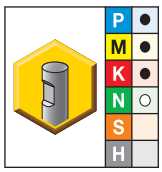


End Mill Tolerances

D1	tolerance e8	D	tolerance h6 + / -
≤ 3	-0,014/-0,028	≤ 3	0/0,006
> 3–6	-0,020/-0,038	> 3–6	0/0,008
> 6–10	-0,025/-0,047	> 6–10	0/0,009
> 10–18	-0,032/-0,059	> 10–18	0/0,011
> 18–30	-0,040/-0,073	> 18–30	0/0,013

4CH..MR-ML-MX • 4 Flute • Metric



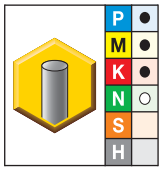


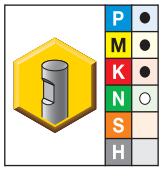
● first choice
○ alternate choice

KC633M	KC633M	D1	D	length of cut Ap1 max	length L	BCH
4CH0200MR006A	–	2,0	3	6,30	38	–
4CH0300MR009A	–	3,0	3	9,50	38	–
4CH0300ML019A	–	3,0	3	19,00	63	–
4CH0300MX025A	–	3,0	3	25,00	75	–
4CH0400MR011A	–	4,0	4	11,00	50	0,10
4CH0400ML019A	–	4,0	4	19,00	63	0,10
4CH0400MX031A	–	4,0	4	31,00	75	0,10
4CH0500MR030A	–	5,0	5	30,00	75	0,10
4CH0600MR016A	–	6,0	6	16,00	50	0,10
4CH0600ML028A	–	6,0	6	28,00	75	0,10
4CH0600MX038A	–	6,0	6	38,00	100	0,10
4CH0800MR020A	–	8,0	8	20,00	50	0,20
4CH0800ML028A	–	8,0	8	28,00	75	0,20
4CH0800MX041A	–	8,0	8	41,00	100	0,20
4CH1000MR022A	–	10,0	10	22,00	72	0,20
4CH1000ML032A	–	10,0	10	32,00	89	0,20
4CH1000MX045A	–	10,0	10	45,00	100	0,20
4CH1200MR025A	4CH1200MR025B	12,0	12	25,00	89	0,30
4CH1200ML045A	4CH1200ML045B	12,0	12	45,00	100	0,30
4CH1200MX075A	4CH1200MX075B	12,0	12	75,00	150	0,30
4CH1400MR032A	4CH1400MR032B	14,0	14	32,00	83	0,30
4CH1400ML050A	4CH1400ML050B	14,0	14	50,00	100	0,30
4CH1400MX075A	4CH1400MX075B	14,0	14	75,00	150	0,30
4CH1600MR032A	4CH1600MR032B	16,0	16	32,00	92	0,30

(continued)

(4CH..MR-ML-MX • 4 Flute • Metric — continued)



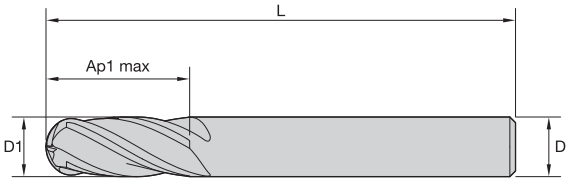


● first choice
○ alternate choice

KC633M	KC633M	D1	D	length of cut Ap1 max	length L	BCH
4CH1600ML056A	**4CH1600ML056B**	16,0	16	56,00	110	0,30
4CH1600MX075A	**4CH1600MX075B**	16,0	16	75,00	150	0,30
4CH1800MR038A	**4CH1800MR038B**	18,0	18	38,00	100	0,30
4CH1800ML060A	**4CH1800ML060B**	18,0	18	60,00	125	0,30
4CH1800MX075A	**4CH1800MX075B**	18,0	18	75,00	150	0,30
4CH2000MR038A	**4CH2000MR038B**	20,0	20	38,00	104	0,30
4CH2000ML056A	**4CH2000ML056B**	20,0	20	56,00	125	0,30
4CH2000MX075A	**4CH2000MX075B**	20,0	20	75,00	150	0,30

NOTE: For application data, please see page Q32.

- Centre cutting.



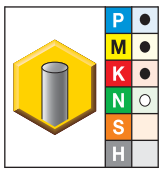


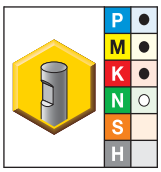


End Mill Tolerances

D1	tolerance e8	D	tolerance h6 + / -
≤ 3	-0,014/-0,028	≤ 3	0/0,006
> 3–6	-0,020/-0,038	> 3–6	0/0,008
> 6–10	-0,025/-0,047	> 6–10	0/0,009
> 10–18	-0,032/-0,059	> 10–18	0/0,011
> 18–30	-0,040/-0,073	> 18–30	0/0,013

4BN..DK-DL • 4 Flute • Ball Nose • Metric





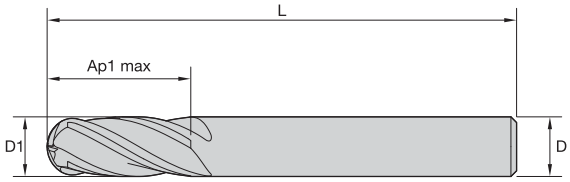
● first choice
○ alternate choice

KC633M	KC633M	D1	D	length of cut Ap1 max	length L
4BN0300DL008A	–	3,0	6	8,00	57
4BN0400DL011A	–	4,0	6	11,00	57
4BN0500DL013A	–	5,0	6	13,00	57
4BN0600DL013A	–	6,0	6	13,00	57
4BN0800DL019A	–	8,0	8	19,00	63
4BN1000DL022A	–	10,0	10	22,00	72
4BN1200DL026A	**4BN1200DL026B**	12,0	12	26,00	83
4BN1400DL026A	–	14,0	14	26,00	83
4BN1600DL032A	**4BN1600DL032B**	16,0	16	32,00	92
4BN1800DL032A	**4BN1800DL032B**	18,0	18	32,00	92
4BN2000DL038A	**4BN2000DL038B**	20,0	20	38,00	104

NOTE: For application data, please see page Q33.

- Centre cutting.



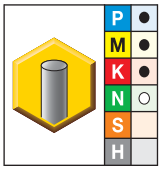




End Mill Tolerances

D1	tolerance e8	D	tolerance h6 + / -
≤ 3	-0,014/-0,028	≤ 3	0/0,006
> 3–6	-0,020/-0,038	> 3–6	0/0,008
> 6–10	-0,025/-0,047	> 6–10	0/0,009
> 10–18	-0,032/-0,059	> 10–18	0/0,011
> 18–30	-0,040/-0,073	> 18–30	0/0,013

4BN..DD • 4 Flute • Ball Nose • Metric

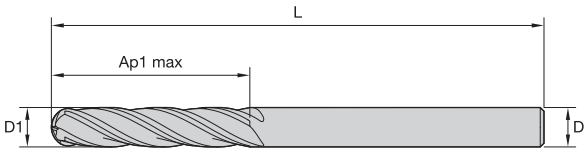


● first choice
○ alternate choice

KC633M	D1	D	length of cut Ap1 max	length L
4BN0400DD011A	4,0	4	11,00	50
4BN0500DD013A	5,0	5	13,00	50
4BN0600DD013A	6,0	6	13,00	57
4BN0800DD019A	8,0	8	19,00	63
4BN1000DD022A	10,0	10	22,00	72
4BN1200DD026A	12,0	12	26,00	83
4BN1400DD026A	14,0	14	26,00	83
4BN1600DD032A	16,0	16	32,00	92
4BN1800DD032A	18,0	18	32,00	92
4BN2000DD038A	20,0	20	38,00	104

NOTE: For application data, please see page Q33.

• Centre cutting.



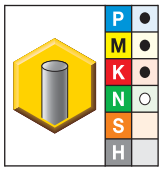




End Mill Tolerances

D1	tolerance e8	D	tolerance h6 + / -
≤ 3	-0,014/-0,028	≤ 3	0/0,006
> 3–6	-0,020/-0,038	> 3–6	0/0,008
> 6–10	-0,025/-0,047	> 6–10	0/0,009
> 10–18	-0,032/-0,059	> 10–18	0/0,011
> 18–30	-0,040/-0,073	> 18–30	0/0,013

4BN..MR-ML • 4 Flute • Ball Nose • Metric



● first choice
○ alternate choice

KC633M	D1	D	length of cut Ap1 max	length L
4BN0300MR020A	3,0	3	20,00	75
4BN0400MR025A	4,0	4	25,00	75
4BN0500MR030A	5,0	5	30,00	75
4BN0600MR030A	6,0	6	30,00	75
4BN0800MR040A	8,0	8	40,00	100
4BN1000MR040A	10,0	10	40,00	100
4BN1200MR025A	12,0	12	25,00	75
4BN1200ML045A	12,0	12	45,00	150
4BN1600MR032A	16,0	16	32,00	89
4BN1800MR038A	18,0	18	38,00	100
4BN2000MR056A	20,0	20	56,00	125

NOTE: For application data, please see page Q33.

GOmill GP • 4CH..DK-MR • 4 Flute • Short • Regular

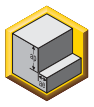




Material Group		Side Milling (A) and Slotting (B)			KC633M			Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 20%.											
		A		B	Cutting Speed — vc m/min			D1 — Diameter											
		ap	ae	ap	min		max	mm	2,0	3,0	4,0	5,0	6,0	8,0	10,0	12,0	14,0	16,0	18,0	20,0
P	0	Ap1 max	0,1 x D	0,5 x D	150	–	200	fz	0,014	0,021	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114
	1	Ap1 max	0,1 x D	0,5 x D	150	–	200	fz	0,014	0,021	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114
	2	Ap1 max	0,1 x D	0,5 x D	140	–	190	fz	0,014	0,021	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114
	3	Ap1 max	0,1 x D	0,5 x D	120	–	160	fz	0,011	0,017	0,023	0,030	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101
	4	Ap1 max	0,1 x D	0,5 x D	90	–	150	fz	0,010	0,016	0,021	0,027	0,033	0,045	0,054	0,062	0,070	0,077	0,083	0,088
M	1	Ap1 max	0,1 x D	0,5 x D	90	–	115	fz	0,011	0,017	0,023	0,030	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101
	2	Ap1 max	0,1 x D	0,5 x D	60	–	80	fz	0,009	0,014	0,019	0,024	0,029	0,040	0,048	0,056	0,063	0,070	0,076	0,081
K	1	Ap1 max	0,1 x D	0,5 x D	120	–	150	fz	0,014	0,021	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114
	2	Ap1 max	0,1 x D	0,5 x D	110	–	140	fz	0,011	0,017	0,023	0,030	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101
N	1	Ap1 max	0,1 x D	0,5 x D	250	–	1000	fz	0,020	0,030	0,040	0,050	0,060	0,080	0,100	0,120	0,140	0,160	0,180	0,200
	2	Ap1 max	0,1 x D	0,5 x D	250	–	750	fz	0,016	0,024	0,032	0,040	0,048	0,064	0,080	0,096	0,112	0,128	0,144	0,160
	4	Ap1 max	0,1 x D	0,5 x D	250	–	750	fz	0,018	0,027	0,036	0,045	0,054	0,072	0,090	0,108	0,126	0,144	0,162	0,180

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters accordingly on >12mm diameter.

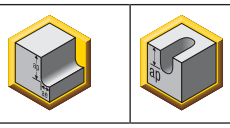
GOmill GP • 4CH..DL-DD-ML-MX • 4 Flute • Long • Extra Long




Material Group		Side Milling (A)		KC633M			Recommended feed per tooth (fz = mm/th) for side milling (A).										
		A		Cutting Speed — vc m/min			D1 — Diameter										
		ap	ae	min		max	mm	3,0	4,0	5,0	6,0	8,0	10,0	12,0	14,0	16,0	18,0	20,0
P	0	Ap1 max	0,1 x D	150	–	200	fz	0,021	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114
	1	Ap1 max	0,1 x D	150	–	200	fz	0,021	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114
	2	Ap1 max	0,1 x D	140	–	190	fz	0,021	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114
	3	Ap1 max	0,1 x D	120	–	160	fz	0,017	0,023	0,030	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101
	4	Ap1 max	0,1 x D	90	–	150	fz	0,016	0,021	0,027	0,033	0,045	0,054	0,062	0,070	0,077	0,083	0,088
M	1	Ap1 max	0,1 x D	90	–	115	fz	0,017	0,023	0,030	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101
	2	Ap1 max	0,1 x D	60	–	80	fz	0,014	0,019	0,024	0,029	0,040	0,048	0,056	0,063	0,070	0,076	0,081
K	1	Ap1 max	0,1 x D	120	–	150	fz	0,021	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114
	2	Ap1 max	0,1 x D	110	–	140	fz	0,017	0,023	0,030	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101
N	1	Ap1 max	0,1 x D	250	–	1000	fz	0,030	0,040	0,050	0,060	0,080	0,100	0,120	0,140	0,160	0,180	0,200
	2	Ap1 max	0,1 x D	250	–	750	fz	0,024	0,032	0,040	0,048	0,064	0,080	0,096	0,112	0,128	0,144	0,160
	4	Ap1 max	0,1 x D	250	–	750	fz	0,027	0,036	0,045	0,054	0,072	0,090	0,108	0,126	0,144	0,162	0,180

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters accordingly on >12mm diameter.

GOmill GP • 4BN..DK-MR • 4 Flute • Ball Nose • Short • Regular

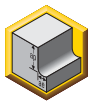




Material Group		Side Milling (A) and Slotting (B)			KC633M			Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 20%.											
		A		B	Cutting Speed — vc m/min			D1 — Diameter											
		ap	ae	ap	min		max	mm	3,0	4,0	5,0	6,0	8,0	10,0	12,0	14,0	16,0	18,0	20,0
P	0	Ap1 max	0,1 x D	0,5 x D	150	–	200	fz	0,021	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114
	1	Ap1 max	0,1 x D	0,5 x D	150	–	200	fz	0,021	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114
	2	Ap1 max	0,1 x D	0,5 x D	140	–	190	fz	0,021	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114
	3	Ap1 max	0,1 x D	0,5 x D	120	–	160	fz	0,017	0,023	0,030	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101
	4	Ap1 max	0,1 x D	0,5 x D	90	–	150	fz	0,016	0,021	0,027	0,033	0,045	0,054	0,062	0,070	0,077	0,083	0,088
M	1	Ap1 max	0,1 x D	0,5 x D	90	–	115	fz	0,017	0,023	0,030	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101
	2	Ap1 max	0,1 x D	0,5 x D	60	–	80	fz	0,014	0,019	0,024	0,029	0,040	0,048	0,056	0,063	0,070	0,076	0,081
K	1	Ap1 max	0,1 x D	0,5 x D	120	–	150	fz	0,021	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114
	2	Ap1 max	0,1 x D	0,5 x D	110	–	140	fz	0,017	0,023	0,030	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101
N	1	Ap1 max	0,1 x D	0,5 x D	250	–	1000	fz	0,030	0,040	0,050	0,060	0,080	0,100	0,120	0,140	0,160	0,180	0,200
	2	Ap1 max	0,1 x D	0,5 x D	250	–	750	fz	0,024	0,032	0,040	0,048	0,064	0,080	0,096	0,112	0,128	0,144	0,160
	4	Ap1 max	0,1 x D	0,5 x D	250	–	750	fz	0,027	0,036	0,045	0,054	0,072	0,090	0,108	0,126	0,144	0,162	0,180

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters accordingly on >12mm diameter.

GOmill GP • 4BN..DL-DD-ML-MX • 4 Flute • Ball Nose • Long • Extra Long

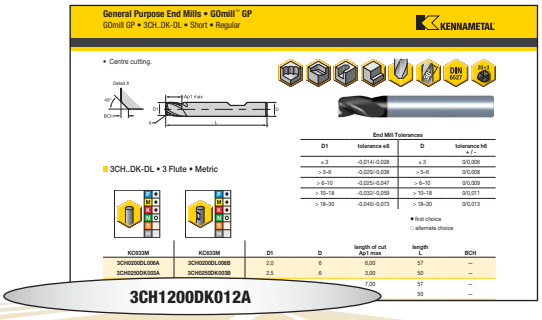



Material Group		Side Milling (A)		KC633M			Recommended feed per tooth (fz = mm/th) for side milling (A).											
		A		Cutting Speed — vc m/min			D1 — Diameter											
		ap	ae	min		max	mm	3,0	4,0	5,0	6,0	8,0	10,0	12,0	14,0	16,0	18,0	20,0
P	0	Ap1 max	0,1 x D	150	–	200	fz	0,021	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114
	1	Ap1 max	0,1 x D	150	–	200	fz	0,021	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114
	2	Ap1 max	0,1 x D	140	–	190	fz	0,021	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114
	3	Ap1 max	0,1 x D	120	–	160	fz	0,017	0,023	0,030	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101
	4	Ap1 max	0,1 x D	90	–	150	fz	0,016	0,021	0,027	0,033	0,045	0,054	0,062	0,070	0,077	0,083	0,088
M	1	Ap1 max	0,1 x D	90	–	115	fz	0,017	0,023	0,030	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101
	2	Ap1 max	0,1 x D	60	–	80	fz	0,014	0,019	0,024	0,029	0,040	0,048	0,056	0,063	0,070	0,076	0,081
K	1	Ap1 max	0,1 x D	120	–	150	fz	0,021	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114
	2	Ap1 max	0,1 x D	110	–	140	fz	0,017	0,023	0,030	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101
N	1	Ap1 max	0,1 x D	250	–	1000	fz	0,030	0,040	0,050	0,060	0,080	0,100	0,120	0,140	0,160	0,180	0,200
	2	Ap1 max	0,1 x D	250	–	750	fz	0,024	0,032	0,040	0,048	0,064	0,080	0,096	0,112	0,128	0,144	0,160
	4	Ap1 max	0,1 x D	250	–	750	fz	0,027	0,036	0,045	0,054	0,072	0,090	0,108	0,126	0,144	0,162	0,180

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters accordingly on >12mm diameter.

How Do Catalogue Numbers Work?

Each character in our catalogue number signifies a specific trait of that product. Use the following key columns and corresponding images to easily identify which attributes apply.



3	CH	1200	DK	012	A
Number of Flutes	End Mill Shape	Cutting Diameter mm	Standard	Ap1 max mm	Shank Style
2 = 2 Flute **3** = 3 Flute **4** = 4 Flute	**CH** = Chamfer Edge **BN** = Ball Nose		**DK** = DIN 6527 Short **DL** = DIN 6527 Long **DD** = DIN 6528 **MS** = Factory Standard Short **MR** = Factory Standard Regular **ML** = Factory Standard Long **MX** = Factory Standard Extra Long		**A** = Plain Shank **B** = Weldon® Shank

Old General Purpose			GOmill GP Replacement		
Order Number	Catalogue Number	Grade	Order Number	Catalogue Number	Grade
2231390	F3AH1200ADK30	KC633M	6146883	3CH1200DK012A	KC633M
2231509	F4AJ1100ADL30	KC633M	no replacement	no replacement	no replacement
2231456	F3AH0400BDL30	KC633M	6146961	3CH0400DL008B	KC633M
1722900	F4AJ2000AWX30	KC625M	5824249	4CH2000MX075A	KC633M
2226743	F2AH1300ADN30	KC633M	no replacement	no replacement	no replacement
1723336	F4AL0600ADL30	KC633M	5824923	4BN0600DL013A	KC633M
2226804	F4AJ1200ADN30	KC633M	5824203	4CH1200DD026A	KC633M
1722852	F4AJ1000AWL30	KC625M	5824234	4CH1000MX045A	KC633M
2231437	F3AH0775BDK30	KC633M	no replacement	no replacement	no replacement
2226803	F4AJ1000ADN30	KC633M	5824202	4CH1000DD022A	KC633M
2231423	F3AH0300BDK30	KC633M	6146891	3CH0300DK004B	KC633M
2231421	F3AH0250BDK30	KC633M	6146890	3CH0250DK003B	KC633M
2231514	F4AJ1600ADL30	KC633M	5824193	4CH1600DL032A	KC633M
1722966	F4AL0400ADL30	KC633M	5824921	4BN0400DL011A	KC633M
2231459	F3AH0500BDL30	KC633M	6146963	3CH0500DL010B	KC633M
1723007	F2AL0200ADL30	KC633M	5874065	2BN0200DL006A	KC633M
2226775	F3AH1000ADN30	KC633M	6146951	3CH1000DL019A	KC633M
1722733	F3AH1600BDL30	KC633M	6146971	3CH1600DL026B	KC633M
1722712	F3AH1200BDL30	KC633M	6146969	3CH1200DL022B	KC633M
2231443	F3AH0970BDK30	KC633M	no replacement	no replacement	no replacement
2231508	F4AJ1000ADL30	KC633M	5824187	4CH1000DL022A	KC633M
1722842	F4AJ1200AWX30	KC625M	5824237	4CH1200MX075A	KC633M
2226774	F3AH0800ADN30	KC633M	6146950	3CH0800DL016A	KC633M
2231510	F4AJ1200ADL30	KC633M	5824189	4CH1200DL026A	KC633M
2231364	F3AH0250ADK30	KC633M	6146871	3CH0250DK003A	KC633M
2231367	F3AH0350ADK30	KC633M	6146874	3CH0350DK004A	KC633M
1722714	F3AH0800BDL30	KC633M	6146967	3CH0800DL016B	KC633M
1722853	F4AJ0800AWL30	KC625M	5824231	4CH0800MX041A	KC633M
1722874	F4AJ1600AWX30	KC625M	5824243	4CH1600MX075A	KC633M
2226780	F4AJ2000ADN30	KC633M	5824207	4CH2000DD038A	KC633M
2226784	F4AJ0550ADN30	KC633M	5824176	4CH0550DL013A	KC633M
2226802	F4AJ0800ADN30	KC633M	5824201	4CH0800DD019A	KC633M
2226783	F4AJ0500ADN30	KC633M	5824199	4CH0500DD013A	KC633M
2226778	F4AJ1600ADN30	KC633M	5824205	4CH1600DD032A	KC633M
1723038	F4AL0300ADN30	KC633M	no replacement	no replacement	no replacement
1722970	F4AL1200ADN30	KC633M	5824936	4BN1200DD026A	KC633M
1723032	F2AL0600ADN30	KC633M	5874174	2BN0600DD010A	KC633M
2231356	F2AH0400BDL30	KC633M	5872948	2CH0400DL008A	KC633M
1722309	F3AH1000ADL30	KC633M	6146951	3CH1000DL019A	KC633M
1722713	F3AH1000BDL30	KC633M	6146968	3CH1000DL019B	KC633M
1722860	F2AH2000AWX30	K600	no replacement	no replacement	no replacement
2226771	F2AH1000ADN30	KC633M	5872974	2CH1000DL019A	KC633M
2226801	F4AJ0600ADN30	KC633M	5824200	4CH0600DD013A	KC633M
1722973	F4AL0600ADN30	KC633M	5824933	4BN0600DD013A	KC633M
1722715	F3AH0600BDL30	KC633M	6146965	3CH0600DL010B	KC633M
2231480	F4AJ0400ADK30	KC633M	5824171	4CH0400DK008A	KC633M
2231504	F4AJ0600ADL30	KC633M	5824178	4CH0600DL013A	KC633M
1723339	F4AL1600ADL30	KC633M	5824928	4BN1600DL032A	KC633M
1722684	F3AH2000BDL30	KC633M	6146973	3CH2000DL032B	KC633M
2231402	F3AH0500ADL30	KC633M	6146946	3CH0500DL010A	KC633M
1722968	F4AL1600ADN30	KC633M	5824959	4BN1600MR032A	KC633M
1722967	F4AL0300ADL30	KC633M	5824720	4BN0300DL008A	KC633M
2226781	F4AJ0400ADN30	KC633M	5824198	4CH0400DD011A	KC633M
2231311	F2AH0250ADL30	KC633M	no replacement	no replacement	no replacement
1722885	F2AH1600AWX30	KC625M	5873046	2CH1600MX075A	KC633M
2226791	F4AJ1300ADN30	KC633M	no replacement	no replacement	no replacement
1722311	F3AH0600ADL30	KC633M	6146948	3CH0600DL010A	KC633M
1330141	F4AJ1200ADL30	KC625M	5824189	4CH1200DL026A	KC633M
1723337	F4AL1000ADL30	KC633M	5824925	4BN1000DL022A	KC633M
1723029	F2AL0300ADL30	KC633M	5874067	2BN0300DL007A	KC633M

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Old General Purpose			GOmill GP Replacement		
Order Number	Catalogue Number	Grade	Order Number	Catalogue Number	Grade
1722855	F4AJ0500AWM30	KC625M	5824225	4CH0500MR030A	KC633M
2226776	F3AH1200ADN30	KC633M	6146952	3CH1200DL022A	KC633M
1200670	F3AH0300ADL30	KC625M	6146942	3CH0300DL007A	KC633M
2231431	F3AH0575BDK30	KC633M	no replacement	no replacement	no replacement
1722306	F3AH2000ADL30	KC633M	6146956	3CH2000DL032A	KC633M
1722310	F3AH0800ADL30	KC633M	6146950	3CH0800DL016A	KC633M
1722965	F4AL0500ADL30	KC633M	5824922	4BN0500DL013A	KC633M
1723208	F4AJ1000ADL30	KC625M	5824187	4CH1000DL022A	KC633M
2226805	F4AJ1400ADN30	KC633M	5824204	4CH1400DD026A	KC633M
2273254	F3AH1800BDL30	KC633M	6146972	3CH1800DL026B	KC633M
2231411	F3AH0900ADL30	KC633M	no replacement	no replacement	no replacement
2226756	F3AH0600ADN30	KC633M	6146948	3CH0600DL010A	KC633M
2231277	F2AH0200ADK30	KC633M	5872943	2CH0200DK003A	KC633M
1723009	F4AL0500ADN30	KC633M	5824932	4BN0500DD013A	KC633M
2231387	F3AH1000ADK30	KC633M	6146882	3CH1000DK011A	KC633M
2226755	F3AH2000ADN30	KC633M	6146956	3CH2000DL032A	KC633M
2231506	F4AJ0800ADL30	KC633M	5824183	4CH0800DL019A	KC633M
1722972	F4AL0800ADN30	KC633M	5824934	4BN0800DD019A	KC633M
2231399	F3AH0400ADL30	KC633M	6146944	3CH0400DL008A	KC633M
1722889	F2AH2000AWX30	KC625M	5873052	2CH2000MX075A	KC633M
1722955	F2AL1000AWL30L400	KC633M	5874199	2BN1000MR045A	KC633M
2226767	F3AH1100ADN30	KC633M	no replacement	no replacement	no replacement
2226753	F3AH1600ADN30	KC633M	6146954	3CH1600DL026A	KC633M
2231503	F4AJ0500ADL30	KC633M	5824175	4CH0500DL013A	KC633M
2226800	F4AJ2000BDL30	KC633M	5824217	4CH2000DL038B	KC633M
1723041	F2AL1200ADN30	KC633M	5874177	2BN1200DD022A	KC633M
2231366	F3AH0300ADK30	KC633M	6146872	3CH0300DK004A	KC633M
1722232	F3AH0300ADN30	KC625M	no replacement	no replacement	no replacement
2231409	F3AH0850ADL30	KC633M	no replacement	no replacement	no replacement
2231405	F3AH0650ADL30	KC633M	no replacement	no replacement	no replacement
1722856	F4AJ0400AWM30	KC625M	5824224	4CH0400MX031A	KC633M
1722854	F4AJ0600AWM30	KC625M	5824227	4CH0600ML028A	KC633M
1722961	F4AL0800AWL30L400	KC633M	5824955	4BN0800MR040A	KC633M
1722971	F4AL1000ADN30	KC633M	5824935	4BN1000DD022A	KC633M
2231493	F4AJ1100ADK30	KC633M	no replacement	no replacement	no replacement
2231489	F4AJ0850ADK30	KC633M	no replacement	no replacement	no replacement
2273253	F3AH1400BDL30	KC633M	6146970	3CH1400DL022B	KC633M
1723042	F2AL1000ADN30	KC633M	5874176	2BN1000DD019A	KC633M
2231312	F2AH0300ADL30	KC633M	5872945	2CH0300DL007A	KC633M
2231382	F3AH0850ADK30	KC633M	no replacement	no replacement	no replacement
1723022	F4AL1000AWL30L400	KC633M	5824956	4BN1000MR040A	KC633M
2231516	F4AJ2000ADL30	KC633M	5824197	4CH2000DL038A	KC633M
2231464	F3AH0700BDL30	KC633M	6146966	3CH0700DL013B	KC633M
2231417	F3AH1400ADL30	KC633M	6146953	3CH1400DL022A	KC633M
1722850	F4AJ1400AWX30	KC625M	5824240	4CH1400MX075A	KC633M
2226795	F4AJ1000BDL30	KC633M	5824187	4CH1000DL022A	KC633M
1723329	F4AL1200ADL30	KC633M	5824926	4BN1200DL026A	KC633M
2231478	F4AJ0300ADK30	KC633M	5824129	4CH0300DK005A	KC633M
1723222	F4AJ0800ADL30	KC625M	5824183	4CH0800DL019A	KC633M
2231418	F3AH1500ADL30	KC633M	no replacement	no replacement	no replacement
1722308	F3AH1200ADL30	KC633M	6146952	3CH1200DL022A	KC633M
2231492	F4AJ1000ADK30	KC633M	5824186	4CH1000DK014A	KC633M
2231484	F4AJ0600ADK30	KC633M	5824177	4CH0600DK010A	KC633M
2231428	F3AH0480BDK30	KC633M	no replacement	no replacement	no replacement
1722872	F4AJ1800AWX30	KC625M	5824246	4CH1800MX075A	KC633M
2231369	F3AH0400ADK30	KC633M	6146875	3CH0400DK005A	KC633M
1806853	F4BL1600BWL20	KC633M	5824964	4BN1600DL032B	KC633M
1723006	F4AL1200AWX30L450	KC633M	5824958	4BN1200ML045A	KC633M
1723030	F2AL0400ADL30	KC633M	5874069	2BN0400DL008A	KC633M
2231476	F4AJ0200ADK30	KC633M	no replacement	no replacement	no replacement

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Old General Purpose			GOmill GP Replacement		
Order Number	Catalogue Number	Grade	Order Number	Catalogue Number	Grade
1722956	F2AL0800AWL30L400	KC633M	5874198	2BN0800MR040A	KC633M
1722960	F4AL2000ADN30	KC633M	5824940	4BN2000DD038A	KC633M
2231474	F3AH1500BDL30	KC633M	no replacement	no replacement	no replacement
2231505	F4AJ0700ADL30	KC633M	5824181	4CH0700DL016A	KC633M
2231393	F3AH1400ADK30	KC633M	6146884	3CH1400DK014A	KC633M
1722883	F4AJ2000AWX30	K600	5824249	4CH2000MX075A	KC633M
2231500	F4AJ2000ADK30	KC633M	5824196	4CH2000DK026A	KC633M
1722213	F4AJ1200ADN30	KC625M	5824189	4CH1200DL026A	KC633M
1722993	F4AL0600AWM30L300	KC633M	5824954	4BN0600MR030A	KC633M
1723027	F2AL0300ADN30	KC633M	no replacement	no replacement	no replacement
2226768	F3AH1300ADN30	KC633M	no replacement	no replacement	no replacement
2231488	F4AJ0800ADK30	KC633M	5824182	4CH0800DK012A	KC633M
2226777	F3AH1400ADN30	KC633M	6146953	3CH1400DL022A	KC633M
2226798	F4AJ1600BDL30	KC633M	5824213	4CH1600DL032B	KC633M
2226770	F2AH0800ADN30	KC633M	5873000	2CH0800DD016A	KC633M
2231370	F3AH0450ADK30	KC633M	6146876	3CH0450DK005A	KC633M
1722285	F4AJ0300ADN30	KC625M	no replacement	no replacement	no replacement
2231375	F3AH0600ADK30	KC633M	6146879	3CH0600DK007A	KC633M
2231372	F3AH0500ADK30	KC633M	6146877	3CH0500DK006A	KC633M
1806781	F4BL1200BWL20	KC633M	5824962	4BN1200DL026B	KC633M
1723035	F2AL0800ADN30	KC633M	5874175	2BN0800DD016A	KC633M
2231394	F3AH1500ADK30	KC633M	no replacement	no replacement	no replacement
2226794	F4AJ0800BDL30	KC633M	5824183	4CH0800DL019A	KC633M
2231403	F3AH0550ADL30	KC633M	6146947	3CH0550DL010A	KC633M
2231412	F3AH0970ADL30	KC633M	no replacement	no replacement	no replacement
2231386	F3AH0970ADK30	KC633M	no replacement	no replacement	no replacement
2231313	F2AH0400ADL30	KC633M	5872948	2CH0400DL008A	KC633M
2231413	F3AH1100ADL30	KC633M	no replacement	no replacement	no replacement
1722862	F4AJ1600AWX30	K600	5824243	4CH1600MX075A	KC633M
2231317	F2AH0600ADL30	KC633M	5872964	2CH0600DL010A	KC633M
2226796	F4AJ1200BDL30	KC633M	5824209	4CH1200DL026B	KC633M
2226786	F4AJ0700ADN30	KC633M	5824181	4CH0700DL016A	KC633M
1723341	F4AL2000ADL30	KC633M	5824930	4BN2000DL038A	KC633M
1723332	F2AL0800ADL30	KC633M	5874163	2BN0800DL016A	KC633M
2231398	F3AH2000ADK30	KC633M	6146888	3CH2000DK020A	KC633M
1723021	F4AL0400ADN30	KC633M	5824931	4BN0400DD011A	KC633M
2231485	F4AJ0650ADK30	KC633M	no replacement	no replacement	no replacement
1722997	F4AL0500AWM30L300	KC633M	5824953	4BN0500MR030A	KC633M
2226792	F4AJ1500ADN30	KC633M	no replacement	no replacement	no replacement
2226772	F2AH1200ADN30	KC633M	5873003	2CH1200DD022A	KC633M
2231288	F2AH0800ADK30	KC633M	no replacement	no replacement	no replacement
2231501	F4AJ0400ADL30	KC633M	5824172	4CH0400DL011A	KC633M
2231365	F3AH0280ADK30	KC633M	no replacement	no replacement	no replacement
2231368	F3AH0380ADK30	KC633M	no replacement	no replacement	no replacement
2231378	F3AH0700ADK30	KC633M	6146880	3CH0700DK008A	KC633M
1722954	F2AL1200AWX30L450	KC633M	no replacement	no replacement	no replacement
2231355	F2AH0300BDL30	KC633M	5872945	2CH0300DL007A	KC633M
2231400	F3AH0450ADL30	KC633M	6146945	3CH0450DL008A	KC633M
1722307	F3AH1600ADL30	KC633M	6146954	3CH1600DL026A	KC633M
2231325	F2AH1500ADL30	KC633M	no replacement	no replacement	no replacement
2231381	F3AH0800ADK30	KC633M	6146881	3CH0800DK009A	KC633M
2231497	F4AJ1500ADK30	KC633M	no replacement	no replacement	no replacement
2226736	F2AH0650ADN30	KC633M	no replacement	no replacement	no replacement
2226762	F3AH0700ADN30	KC633M	no replacement	no replacement	no replacement
1722974	F2AL0300AWM30L200	KC633M	no replacement	no replacement	no replacement
2226760	F3AH0550ADN30	KC633M	no replacement	no replacement	no replacement
2226091	F2AH0600ADN30	KC633M	5872998	2CH0600DD010A	KC633M
2231371	F3AH0480ADK30	KC633M	no replacement	no replacement	no replacement
1722959	F2AL0400AWM30L250	KC633M	no replacement	no replacement	no replacement
2231319	F2AH0800ADL30	KC633M	5872968	2CH0800DL016A	KC633M

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Old General Purpose			GOmill GP Replacement		
Order Number	Catalogue Number	Grade	Order Number	Catalogue Number	Grade
2226799	F4AJ1800BDL30	KC633M	5824215	4CH1800DL032B	KC633M
2231425	F3AH0380BDK30	KC633M	no replacement	no replacement	no replacement
2231415	F3AH1300ADL30	KC633M	no replacement	no replacement	no replacement
2231396	F3AH1600ADK30	KC633M	6146885	3CH1600DK016A	KC633M
1722206	F4AJ0800ADN30	KC625M	5824183	4CH0800DL019A	KC633M
1722957	F2AL0600AWM30L300	KC633M	no replacement	no replacement	no replacement
2226759	F3AH0500ADN30	KC633M	no replacement	no replacement	no replacement
2231441	F3AH0900BDK30	KC633M	no replacement	no replacement	no replacement
2231324	F2AH1400ADL30	KC633M	5873005	2CH1400DD022A	KC633M
1722210	F4AJ1000ADN30	KC625M	5824187	4CH1000DL022A	KC633M
1723010	F2AL0400ADN30	KC633M	5874172	2BN0400DD008A	KC633M
2231435	F3AH0700BDK30	KC633M	6146898	3CH0700DK008B	KC633M
2231449	F3AH1370BDK30	KC633M	no replacement	no replacement	no replacement
2226769	F3AH1500ADN30	KC633M	no replacement	no replacement	no replacement
2231292	F2AH1000ADK30	KC633M	5872972	2CH1000DK011A	KC633M
1722873	F2AH1000AWL30	K600	5873036	2CH1000MX045A	KC633M
1722857	F4AJ0300AWM30	KC625M	5824221	4CH0300MX025A	KC633M
1722898	F2AH1000AWL30	KC625M	5873036	2CH1000MX045A	KC633M
2231419	F3AH1570ADL30	KC633M	no replacement	no replacement	no replacement
2231279	F2AH0300ADK30	KC633M	5872944	2CH0300DK004A	KC633M
2231498	F4AJ1600ADK30	KC633M	5824192	4CH1600DK022A	KC633M
1723034	F2AL0200ADN30	KC633M	no replacement	no replacement	no replacement
1722951	F4AL0400AWM30L250	KC633M	5824952	4BN0400MR025A	KC633M
2231542	F4AJ0400BDL30	KC633M	5824172	4CH0400DL011A	KC633M
2226793	F4AJ0600BDL30	KC633M	5824178	4CH0600DL013A	KC633M
2226757	F3AH0400ADN30	KC633M	no replacement	no replacement	no replacement
1723327	F2AL0600ADL30	KC633M	no replacement	no replacement	no replacement
1723040	F4AL0200ADN30	KC633M	no replacement	no replacement	no replacement
2231284	F2AH0600ADK30	KC633M	5872963	2CH0600DK007A	KC633M
1320063	F4AJ2000ADN30	KC625M	5824197	4CH2000DL038A	KC633M
2231377	F3AH0675ADK30	KC633M	no replacement	no replacement	no replacement
2231389	F3AH1170ADK30	KC633M	no replacement	no replacement	no replacement
2231444	F3AH1000BDK30	KC633M	6146900	3CH1000DK011B	KC633M
2231407	F3AH0700ADL30	KC633M	6146949	3CH0700DL013A	KC633M
1500117	F4AJ1600ADL30	KC625M	5824193	4CH1600DL032A	KC633M
2226789	F4AJ0900ADN30	KC633M	5824185	4CH0900DL019A	KC633M
1722230	F3AH0200ADN30	KC625M	no replacement	no replacement	no replacement
1723342	F4AL0800ADL30	KC633M	5824924	4BN0800DL019A	KC633M
2231477	F4AJ0250ADK30	KC633M	no replacement	no replacement	no replacement
2231315	F2AH0500ADL30	KC633M	5872962	2CH0500DL010A	KC633M
1722886	F2AH1800AWX30	KC625M	5873049	2CH1800MX075A	KC633M
2231482	F4AJ0500ADK30	KC633M	5824174	4CH0500DK009A	KC633M
1722880	F4AJ0400AWM30	K600	5824224	4CH0400MX031A	KC633M
1722953	F4AL0300AWM30L200	KC633M	5824951	4BN0300MR020A	KC633M
2231446	F3AH1170BDK30	KC633M	no replacement	no replacement	no replacement
2231490	F4AJ0900ADK30	KC633M	5824184	4CH0900DK013A	KC633M
2231374	F3AH0575ADK30	KC633M	no replacement	no replacement	no replacement
2231388	F3AH1100ADK30	KC633M	no replacement	no replacement	no replacement
2231468	F3AH0900BDL30	KC633M	no replacement	no replacement	no replacement
1323736	F4AJ0400ADL30	KC625M	5824172	4CH0400DL011A	KC633M
1722877	F2AH0600AWM30	K600	5873026	2CH0600ML028A	KC633M
2231280	F2AH0400ADK30	KC633M	5872947	2CH0400DK005A	KC633M
1722358	F4AJ0200ADK30	KC625M	no replacement	no replacement	no replacement
2226773	F2AH1400ADN30	KC633M	5872978	2CH1400DL022A	KC633M
2231549	F4AJ1500BDL30	KC633M	no replacement	no replacement	no replacement
2231304	F2AH1200ADK30	KC633M	5872975	2CH1200DK012A	KC633M
1722906	F2AH0600AWM30	KC625M	no replacement	no replacement	no replacement
1722204	F4AJ1600ADN30	KC625M	5824193	4CH1600DL032A	KC633M
1806854	F4BL2000BWX20	KC633M	5824966	4BN2000DL038B	KC633M
1723338	F4AL1400ADL30	KC633M	5824927	4BN1400DL026A	KC633M

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Old General Purpose			GOmill GP Replacement		
Order Number	Catalogue Number	Grade	Order Number	Catalogue Number	Grade
1722286	F4AJ0350ADN30	KC625M	no replacement	no replacement	no replacement
1723328	F2AL1600ADL30	KC633M	5874167	2BN1600DL026A	KC633M
2231397	F3AH1800ADK30	KC633M	6146886	3CH1800DK018A	KC633M
1723031	F2AL0500ADL30	KC633M	no replacement	no replacement	no replacement
2231376	F3AH0650ADK30	KC633M	no replacement	no replacement	no replacement
2231467	F3AH0870BDL30	KC633M	no replacement	no replacement	no replacement
1722283	F4AJ0200ADN30	KC625M	no replacement	no replacement	no replacement
2231547	F4AJ1100BDL30	KC633M	no replacement	no replacement	no replacement
2226092	F2AH0400ADN30	KC633M	5872996	2CH0400DD008A	KC633M
2231323	F2AH1200ADL30	KC633M	5872976	2CH1200DL022A	KC633M
2231380	F3AH0775ADK30	KC633M	no replacement	no replacement	no replacement
2231479	F4AJ0350ADK30	KC633M	5824130	4CH0350DL010A	KC633M
2231511	F4AJ1300ADL30	KC633M	no replacement	no replacement	no replacement
2226737	F2AH0700ADN30	KC633M	5872999	2CH0700DD013A	KC633M
2231494	F4AJ1200ADK30	KC633M	5824188	4CH1200DK016A	KC633M
1722888	F2AH0800AWL30	KC625M	5873032	2CH0800MX041A	KC633M
1722287	F4AJ0400ADN30	KC625M	5824198	4CH0400DD011A	KC633M
1722904	F2AH0400AWM30	KC625M	no replacement	no replacement	no replacement
2231470	F3AH1100BDL30	KC633M	no replacement	no replacement	no replacement
1722903	F2AH0300AWM30	KC625M	no replacement	no replacement	no replacement
2226734	F2AH0500ADN30	KC633M	5872997	2CH0500DD010A	KC633M
2226744	F2AH1500ADN30	KC633M	no replacement	no replacement	no replacement
2231454	F3AH1800BDK30	KC633M	6146904	3CH1800DK018B	KC633M
1723164	F4AJ2000ADL30	KC625M	5824197	4CH2000DL038A	KC633M
2231472	F3AH1300BDL30	KC633M	no replacement	no replacement	no replacement
2226088	F2AH1600ADN30	KC633M	5873007	2CH1600DD026A	KC633M
1723213	F4AJ0500ADL30	KC625M	5824175	4CH0500DL013A	KC633M
1723028	F2AL0500ADN30	KC633M	5874173	2BN0500DD010A	KC633M
1722291	F4AJ0600ADN30	KC625M	5824178	4CH0600DL013A	KC633M
2231519	F4AJ0300BDK30	KC633M	5824129	4CH0300DK005A	KC633M
1723212	F4AJ0600ADL30	KC625M	5824178	4CH0600DL013A	KC633M
2226779	F4AJ1800ADN30	KC633M	5824206	4CH1800DD032A	KC633M
1723331	F2AL1200ADL30	KC633M	5874165	2BN1200DL022A	KC633M
2226742	F2AH1100ADN30	KC633M	no replacement	no replacement	no replacement
2226758	F3AH0450ADN30	KC633M	no replacement	no replacement	no replacement
2231289	F2AH0850ADK30	KC633M	no replacement	no replacement	no replacement
2231373	F3AH0550ADK30	KC633M	6146878	3CH0550DK007A	KC633M
2231282	F2AH0500ADK30	KC633M	5872961	2CH0500DK006A	KC633M
1722866	F4AJ0600AWM30	K600	no replacement	no replacement	no replacement
2231426	F3AH0400BDK30	KC633M	6146893	3CH0400DK005B	KC633M
1723165	F4AJ1800ADL30	KC625M	5824195	4CH1800DL032A	KC633M
2231420	F3AH1800ADL30	KC633M	6146955	3CH1800DL026A	KC633M
2231438	F3AH0800BDK30	KC633M	6146899	3CH0800DK009B	KC633M
2226754	F3AH1800ADN30	KC633M	6146955	3CH1800DL026A	KC633M
2231321	F2AH1000ADL30	KC633M	5873002	2CH1000DD019A	KC633M
1722851	F2AH0400AWM30	K600	5873018	2CH0400MX031A	KC633M
2231496	F4AJ1400ADK30	KC633M	5824190	4CH1400DK018A	KC633M
2231544	F4AJ0500BDL30	KC633M	5824175	4CH0500DL013A	KC633M
2033937	F2AH0350ADK30	KC633M	5872946	2CH0350DK004A	KC633M
1722947	F4AL1800ADN30	KC633M	5824939	4BN1800DD032A	KC633M
1723330	F2AL1000ADL30	KC633M	5874164	2BN1000DL019A	KC633M
1722233	F3AH0350ADN30	KC625M	no replacement	no replacement	no replacement
1324459	F2AH1600AWX30	K600	no replacement	no replacement	no replacement
2231309	F2AH1800ADK30	KC633M	5872981	2CH1800DK018A	KC633M
1722289	F4AJ0500ADN30	KC625M	5824199	4CH0500DD013A	KC633M
1722875	F2AH0800AWL30	K600	5873032	2CH0800MX041A	KC633M
2231392	F3AH1370ADK30	KC633M	no replacement	no replacement	no replacement
2231338	F2AH0650BDK30	KC633M	no replacement	no replacement	no replacement
2231384	F3AH0900ADK30	KC633M	no replacement	no replacement	no replacement
2226788	F4AJ0850ADN30	KC633M	no replacement	no replacement	no replacement

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Old General Purpose			GOmill GP Replacement		
Order Number	Catalogue Number	Grade	Order Number	Catalogue Number	Grade
2231331	F2AH0300BDK30	KC633M	5872944	2CH0300DK004A	KC633M
2231429	F3AH0500BDK30	KC633M	6146895	3CH0500DK006B	KC633M
2231305	F2AH1300ADK30	KC633M	no replacement	no replacement	no replacement
1722316	F4AJ1000ADK30	KC625M	5824186	4CH1000DK014A	KC633M
1722969	F4AL1400ADN30	KC633M	5824937	4BN1400DD026A	KC633M
2226766	F3AH0950ADN30	KC633M	no replacement	no replacement	no replacement
1722870	F2AH0300AWM30	K600	5873014	2CH0300MX025A	KC633M
2231318	F2AH0700ADL30	KC633M	5872966	2CH0700DL013A	KC633M
2231465	F3AH0775BDL30	KC633M	no replacement	no replacement	no replacement
1722353	F4AJ0300ADK30	KC625M	5824129	4CH0300DK005A	KC633M
2231330	F2AH0250BDK30	KC633M	no replacement	no replacement	no replacement
2231385	F3AH0950ADK30	KC633M	no replacement	no replacement	no replacement
2226748	F2AH1200BDL30	KC633M	5872986	2CH1200DL022B	KC633M
2231379	F3AH0750ADK30	KC633M	no replacement	no replacement	no replacement
2231546	F4AJ0900BDL30	KC633M	5824185	4CH0900DL019A	KC633M
1722905	F2AH0500AWM30	KC625M	no replacement	no replacement	no replacement
2231327	F2AH1800ADL30	KC633M	5872982	2CH1800DL026A	KC633M
2231455	F3AH2000BDK30	KC633M	6146905	3CH2000DK020B	KC633M
2231278	F2AH0250ADK30	KC633M	no replacement	no replacement	no replacement
2231513	F4AJ1500ADL30	KC633M	no replacement	no replacement	no replacement
2231507	F4AJ0900ADL30	KC633M	5824185	4CH0900DL019A	KC633M
2231432	F3AH0600BDK30	KC633M	6146897	3CH0600DK007B	KC633M
2226765	F3AH0900ADN30	KC633M	no replacement	no replacement	no replacement
1723036	F2AL2000ADN30	KC633M	5874180	2BN2000DD032A	KC633M
2226787	F4AJ0750ADN30	KC633M	no replacement	no replacement	no replacement
1722359	F4AJ0400ADK30	KC625M	5824171	4CH0400DK008A	KC633M
2226090	F2AH2000ADN30	KC633M	5873009	2CH2000DD032A	KC633M
2231404	F3AH0575ADL30	KC633M	no replacement	no replacement	no replacement
2231539	F4AJ1600BDK30	KC633M	5824212	4CH1600DK022B	KC633M
2231450	F3AH1400BDK30	KC633M	6146902	3CH1400DK014B	KC633M
2231427	F3AH0450BDK30	KC633M	6146894	3CH0450DK005B	KC633M
2231439	F3AH0850BDK30	KC633M	no replacement	no replacement	no replacement
2226747	F2AH1000BDL30	KC633M	5872974	2CH1000DL019A	KC633M
1722878	F2AH0500AWM30	K600	no replacement	no replacement	no replacement
2226761	F3AH0650ADN30	KC633M	no replacement	no replacement	no replacement
2226746	F2AH0800BDL30	KC633M	5872968	2CH0800DL016A	KC633M
2231533	F4AJ1000BDK30	KC633M	5824186	4CH1000DK014A	KC633M
1722284	F4AJ0250ADN30	KC625M	no replacement	no replacement	no replacement
2231401	F3AH0480ADL30	KC633M	no replacement	no replacement	no replacement
2231495	F4AJ1300ADK30	KC633M	no replacement	no replacement	no replacement
2231447	F3AH1200BDK30	KC633M	6146901	3CH1200DK012B	KC633M
2226740	F2AH0900ADN30	KC633M	5873001	2CH0900DD016A	KC633M
2226782	F4AJ0450ADN30	KC633M	5824173	4CH0450DL011A	KC633M
1722958	F2AL0500AWM30L300	KC633M	no replacement	no replacement	no replacement
1324457	F2AH1200AWX30	K600	no replacement	no replacement	no replacement
2231353	F2AH2000BDK30	KC633M	5872993	2CH2000DK020B	KC633M
2231515	F4AJ1800ADL30	KC633M	5824195	4CH1800DL032A	KC633M
2231283	F2AH0550ADK30	KC633M	no replacement	no replacement	no replacement
1722864	F4AJ1000AWL30	K600	5824234	4CH1000MX045A	KC633M
2231308	F2AH1600ADK30	KC633M	5872979	2CH1600DK016A	KC633M
2231424	F3AH0350BDK30	KC633M	6146892	3CH0350DK004B	KC633M
2231512	F4AJ1400ADL30	KC633M	5824191	4CH1400DL026A	KC633M
2231410	F3AH0870ADL30	KC633M	no replacement	no replacement	no replacement
1723354	F4AL1200BDL30	KC633M	no replacement	no replacement	no replacement
2231320	F2AH0900ADL30	KC633M	5872971	2CH0900DL016A	KC633M
2231358	F2AH0500BDL30	KC633M	5872962	2CH0500DL010A	KC633M
1722376	F2AH0250ADN30	KC625M	no replacement	no replacement	no replacement
2231517	F4AJ0200BDK30	KC633M	no replacement	no replacement	no replacement
2231408	F3AH0775ADL30	KC633M	no replacement	no replacement	no replacement
1722867	F4AJ0500AWM30	K600	5824225	4CH0500MR030A	KC633M

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Old General Purpose			GOmill GP Replacement		
Order Number	Catalogue Number	Grade	Order Number	Catalogue Number	Grade
2226785	F4AJ0650ADN30	KC633M	5824179	4CH0650DL016A	KC633M
2231360	F2AH0700BDL30	KC633M	5872966	2CH0700DL013A	KC633M
2226797	F4AJ1400BDL30	KC633M	5824211	4CH1400DL026B	KC633M
2231532	F4AJ0950BDK30	KC633M	no replacement	no replacement	no replacement
2226745	F2AH0600BDL30	KC633M	5872964	2CH0600DL010A	KC633M
2231322	F2AH1100ADL30	KC633M	no replacement	no replacement	no replacement
2231306	F2AH1400ADK30	KC633M	5872977	2CH1400DK014A	KC633M
2231461	F3AH0575BDL30	KC633M	no replacement	no replacement	no replacement
2231483	F4AJ0550ADK30	KC633M	no replacement	no replacement	no replacement
2226764	F3AH0850ADN30	KC633M	no replacement	no replacement	no replacement
1722377	F2AH0300ADN30	KC625M	no replacement	no replacement	no replacement
1722869	F4AJ0300AWM30	K600	5824221	4CH0300MX025A	KC633M
2231521	F4AJ0400BDK30	KC633M	5824171	4CH0400DK008A	KC633M
2231486	F4AJ0700ADK30	KC633M	5824180	4CH0700DK011A	KC633M
2231471	F3AH1170BDL30	KC633M	no replacement	no replacement	no replacement
2231462	F3AH0650BDL30	KC633M	no replacement	no replacement	no replacement
2226741	F2AH0950ADN30	KC633M	no replacement	no replacement	no replacement
1200671	F3AH0300BDL30	KC625M	6146959	3CH0300DL007B	KC633M
2231352	F2AH1800BDK30	KC633M	5872991	2CH1800DK018B	KC633M
2231430	F3AH0550BDK30	KC633M	6146896	3CH0550DK007B	KC633M
2231406	F3AH0675ADL30	KC633M	no replacement	no replacement	no replacement
2231285	F2AH0650ADK30	KC633M	no replacement	no replacement	no replacement
2231307	F2AH1500ADK30	KC633M	no replacement	no replacement	no replacement
2226763	F3AH0750ADN30	KC633M	no replacement	no replacement	no replacement
2231337	F2AH0600BDK30	KC633M	5872963	2CH0600DK007A	KC633M
2231538	F4AJ1500BDK30	KC633M	no replacement	no replacement	no replacement
1806780	F4BL1000BWM20	KC633M	no replacement	no replacement	no replacement
2231326	F2AH1600ADL30	KC633M	5872980	2CH1600DL026A	KC633M
2231361	F2AH0900BDL30	KC633M	5872971	2CH0900DL016A	KC633M
2231453	F3AH1600BDK30	KC633M	6146903	3CH1600DK016B	KC633M
1722212	F4AJ1100ADN30	KC625M	no replacement	no replacement	no replacement
1722865	F4AJ0800AWL30	K600	5824231	4CH0800MX041A	KC633M
2226790	F4AJ0950ADN30	KC633M	no replacement	no replacement	no replacement
2231458	F3AH0480BDL30	KC633M	no replacement	no replacement	no replacement
2231541	F4AJ2000BDK30	KC633M	5824216	4CH2000DK026B	KC633M
2231448	F3AH1300BDK30	KC633M	no replacement	no replacement	no replacement
2231343	F2AH0900BDK30	KC633M	5872970	2CH0900DK010A	KC633M
1722647	F4AJ1200ADN30	K600	5824189	4CH1200DL026A	KC633M
1806782	F4BL1400BWL20	KC633M	no replacement	no replacement	no replacement
1722375	F2AH0200ADN30	KC625M	no replacement	no replacement	no replacement
1722217	F4AJ0600ADK30	KC625M	5824177	4CH0600DK010A	KC633M
2231287	F2AH0750ADK30	KC633M	no replacement	no replacement	no replacement
2231345	F2AH1000BDK30	KC633M	5872972	2CH1000DK011A	KC633M
2231535	F4AJ1200BDK30	KC633M	5824208	4CH1200DK016B	KC633M
2231460	F3AH0550BDL30	KC633M	6146964	3CH0550DL010B	KC633M
2231291	F2AH0950ADK30	KC633M	no replacement	no replacement	no replacement
2231310	F2AH2000ADK30	KC633M	5872983	2CH2000DK020A	KC633M
1723209	F4AJ0900ADL30	KC625M	5824185	4CH0900DL019A	KC633M
2226735	F2AH0550ADN30	KC633M	no replacement	no replacement	no replacement
2231422	F3AH0280BDK30	KC633M	no replacement	no replacement	no replacement
2231314	F2AH0450ADL30	KC633M	5872950	2CH0450DL008A	KC633M
2231525	F4AJ0600BDK30	KC633M	5824177	4CH0600DK010A	KC633M
2226739	F2AH0850ADN30	KC633M	no replacement	no replacement	no replacement
2231433	F3AH0650BDK30	KC633M	no replacement	no replacement	no replacement
1723340	F4AL1800ADL30	KC633M	5824929	4BN1800DL032A	KC633M
1569199	F4AJ1200AWX30	K600	5824237	4CH1200MX075A	KC633M
2231286	F2AH0700ADK30	KC633M	5872965	2CH0700DK008A	KC633M
2231395	F3AH1570ADK30	KC633M	no replacement	no replacement	no replacement
2231481	F4AJ0450ADK30	KC633M	5824173	4CH0450DL011A	KC633M
2231522	F4AJ0450BDK30	KC633M	5824173	4CH0450DL011A	KC633M

(continued)

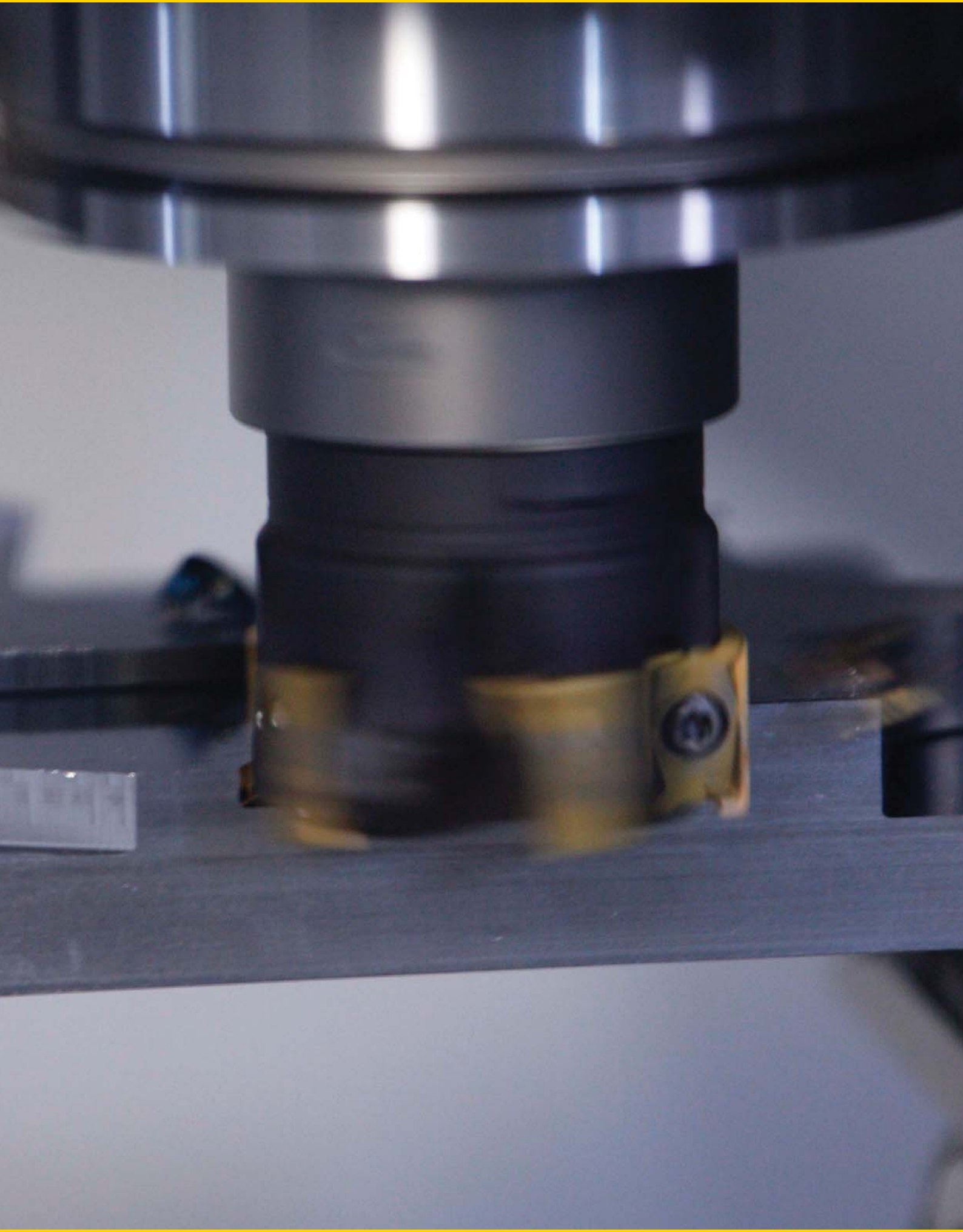
(continued)

Old General Purpose			GOmill GP Replacement		
Order Number	Catalogue Number	Grade	Order Number	Catalogue Number	Grade
2231332	F2AH0350BDK30	KC633M	5872946	2CH0350DK004A	KC633M
2231548	F4AJ1300BDL30	KC633M	no replacement	no replacement	no replacement
1722882	F2AH1200AWX30	KC625M	5873040	2CH1200MX075A	KC633M
1722129	F3AH0250ADN30	KC625M	no replacement	no replacement	no replacement
2231442	F3AH0950BDK30	KC633M	no replacement	no replacement	no replacement
2231303	F2AH1100ADK30	KC633M	no replacement	no replacement	no replacement
2231346	F2AH1100BDK30	KC633M	no replacement	no replacement	no replacement
1723352	F4AL0600BDL30	KC633M	no replacement	no replacement	no replacement
2226733	F2AH0450ADN30	KC633M	no replacement	no replacement	no replacement
2231434	F3AH0675BDK30	KC633M	no replacement	no replacement	no replacement
2231529	F4AJ0800BDK30	KC633M	5824182	4CH0800DK012A	KC633M
2226751	F2AH1800BDL30	KC633M	no replacement	no replacement	no replacement
2231536	F4AJ1300BDK30	KC633M	no replacement	no replacement	no replacement
2231329	F2AH0200BDK30	KC633M	5872943	2CH0200DK003A	KC633M
1200487	F3AH1100BDK30	K600	no replacement	no replacement	no replacement
2231363	F2AH1500BDL30	KC633M	no replacement	no replacement	no replacement
2231349	F2AH1400BDK30	KC633M	5872987	2CH1400DK014B	KC633M
2226738	F2AH0750ADN30	KC633M	no replacement	no replacement	no replacement
1723353	F4AL0800BDL30	KC633M	5824955	4BN0800MR040A	KC633M
2231348	F2AH1300BDK30	KC633M	no replacement	no replacement	no replacement
2231328	F2AH2000ADL30	KC633M	5872984	2CH2000DL032A	KC633M
1723167	F4AJ1400ADL30	KC625M	5824191	4CH1400DL026A	KC633M
2231335	F2AH0500BDK30	KC633M	no replacement	no replacement	no replacement
2231466	F3AH0850BDL30	KC633M	no replacement	no replacement	no replacement
2231457	F3AH0450BDL30	KC633M	6146962	3CH0450DL008B	KC633M
1723358	F4AL1000BDL30	KC633M	no replacement	no replacement	no replacement
2231281	F2AH0450ADK30	KC633M	5872949	2CH0450DK005A	KC633M
2231362	F2AH1100BDL30	KC633M	no replacement	no replacement	no replacement
1723335	F2AL1400ADL30	KC633M	no replacement	no replacement	no replacement
1722335	F4AJ0900ADK30	KC625M	5824184	4CH0900DK013A	KC633M
1996193	F2AL0400AWS00	KC637M	5874172	2BN0400DD008A	KC633M
2231383	F3AH0870ADK30	KC633M	no replacement	no replacement	no replacement
2231316	F2AH0550ADL30	KC633M	no replacement	no replacement	no replacement
2231416	F3AH1370ADL30	KC633M	no replacement	no replacement	no replacement
1722881	F2AH1400AWX30	K600	no replacement	no replacement	no replacement
2231502	F4AJ0450ADL30	KC633M	5824173	4CH0450DL011A	KC633M
2226089	F2AH1800ADN30	KC633M	5873008	2CH1800DD026A	KC633M
2231341	F2AH0800BDK30	KC633M	5872967	2CH0800DK009A	KC633M
1723163	F4AJ1100ADL30	KC625M	no replacement	no replacement	no replacement
1722884	F2AH1400AWX30	KC625M	no replacement	no replacement	no replacement
2231334	F2AH0450BDK30	KC633M	5872949	2CH0450DK005A	KC633M
1722216	F4AJ1500ADN30	KC625M	no replacement	no replacement	no replacement
2231491	F4AJ0950ADK30	KC633M	no replacement	no replacement	no replacement
1723333	F2AL1800ADL30	KC633M	no replacement	no replacement	no replacement
1722443	F2AL0150AWS30	KC635M	no replacement	no replacement	no replacement
2231336	F2AH0550BDK30	KC633M	no replacement	no replacement	no replacement
1722331	F4AJ0800ADK30	KC625M	5824182	4CH0800DK012A	KC633M
2231534	F4AJ1100BDK30	KC633M	no replacement	no replacement	no replacement
2231436	F3AH0750BDK30	KC633M	no replacement	no replacement	no replacement
2226752	F2AH2000BDL30	KC633M	5872994	2CH2000DL032B	KC633M
2231526	F4AJ0650BDK30	KC633M	no replacement	no replacement	no replacement
1722288	F4AJ0450ADN30	KC625M	5824173	4CH0450DL011A	KC633M
2231357	F2AH0450BDL30	KC633M	5872950	2CH0450DL008A	KC633M
2226750	F2AH1600BDL30	KC633M	5872990	2CH1600DL026B	KC633M
2231414	F3AH1170ADL30	KC633M	no replacement	no replacement	no replacement
2231487	F4AJ0750ADK30	KC633M	no replacement	no replacement	no replacement
1722352	F4AJ1200ADK30	KC625M	5824188	4CH1200DK016A	KC633M
2231445	F3AH1100BDK30	KC633M	no replacement	no replacement	no replacement
2231347	F2AH1200BDK30	KC633M	5872985	2CH1200DK012B	KC633M
1200475	F3AH0650BDK30	K600	no replacement	no replacement	no replacement

(continued)

(continued)

Old General Purpose			GOmill GP Replacement		
Order Number	Catalogue Number	Grade	Order Number	Catalogue Number	Grade
2231342	F2AH0850BDK30	KC633M	no replacement	no replacement	no replacement
2231339	F2AH0700BDK30	KC633M	5872965	2CH0700DK008A	KC633M
2231391	F3AH1300ADK30	KC633M	no replacement	no replacement	no replacement
2231537	F4AJ1400BDK30	KC633M	5824210	4CH1400DK018B	KC633M
1722248	F2AH0350ADN30	KC625M	5873015	2CH0350MR012A	KC633M
2231290	F2AH0900ADK30	KC633M	5872970	2CH0900DK010A	KC633M
2231543	F4AJ0450BDL30	KC633M	5824173	4CH0450DL011A	KC633M
2231523	F4AJ0500BDK30	KC633M	5824174	4CH0500DK009A	KC633M
2231545	F4AJ0700BDL30	KC633M	5824181	4CH0700DL016A	KC633M
2231518	F4AJ0250BDK30	KC633M	no replacement	no replacement	no replacement
2231527	F4AJ0700BDK30	KC633M	5824180	4CH0700DK011A	KC633M
1996194	F2AL0500AWS00	KC637M	5874173	2BN0500DD010A	KC633M
1996195	F2AL0600AWS00	KC637M	5874161	2BN0600DL010A	KC633M
1996196	F2AL0800AWM00	KC637M	5874175	2BN0800DD016A	KC633M
1996197	F2AL1000AWM00	KC637M	5874164	2BN1000DL019A	KC633M
1996198	F2AL1200AWL00	KC637M	5874165	2BN1200DL022A	KC633M
2231333	F2AH0400BDK30	KC633M	5872947	2CH0400DK005A	KC633M
2231520	F4AJ0350BDK30	KC633M	5824130	4CH0350DL010A	KC633M
1723037	F2AL1800ADN30	KC633M	no replacement	no replacement	no replacement
2231350	F2AH1500BDK30	KC633M	no replacement	no replacement	no replacement
2231354	F2AH0250BDL30	KC633M	no replacement	no replacement	no replacement
2231359	F2AH0550BDL30	KC633M	no replacement	no replacement	no replacement
2231524	F4AJ0550BDK30	KC633M	no replacement	no replacement	no replacement
2231340	F2AH0750BDK30	KC633M	no replacement	no replacement	no replacement
2231528	F4AJ0750BDK30	KC633M	no replacement	no replacement	no replacement
2231530	F4AJ0850BDK30	KC633M	no replacement	no replacement	no replacement
2231344	F2AH0950BDK30	KC633M	no replacement	no replacement	no replacement
2231440	F3AH0870BDK30	KC633M	no replacement	no replacement	no replacement
2231452	F3AH1570BDK30	KC633M	no replacement	no replacement	no replacement
2231463	F3AH0675BDL30	KC633M	no replacement	no replacement	no replacement
2231469	F3AH0970BDL30	KC633M	no replacement	no replacement	no replacement
2231473	F3AH1370BDL30	KC633M	no replacement	no replacement	no replacement
2231475	F3AH1570BDL30	KC633M	no replacement	no replacement	no replacement
1723334	F2AL2000ADL30	KC633M	5874169	2BN2000DL032A	KC633M
2226749	F2AH1400BDL30	KC633M	5872988	2CH1400DL022B	KC633M
1723343	F4AL1400BDL30	KC633M	5824937	4BN1400DD026A	KC633M
1723168	F4AJ0450ADL30	KC625M	5824173	4CH0450DL011A	KC633M
1722280	F4AJ0500ADK30	KC625M	5824174	4CH0500DK009A	KC633M
1723211	F4AJ0700ADL30	KC625M	5824181	4CH0700DL016A	KC633M
2231531	F4AJ0900BDK30	KC633M	5824184	4CH0900DK013A	KC633M
1722355	F4AJ1400ADK30	KC625M	5824190	4CH1400DK018A	KC633M
1722267	F4AJ1400ADN30	KC625M	5824191	4CH1400DL026A	KC633M
1722863	F4AJ1400AWX30	K600	5824240	4CH1400MX075A	KC633M
1722305	F4AJ1600ADK30	KC625M	5824192	4CH1600DK022A	KC633M
2231499	F4AJ1800ADK30	KC633M	5824194	4CH1800DK024A	KC633M
2231540	F4AJ1800BDK30	KC633M	5824194	4CH1800DK024A	KC633M
1722861	F4AJ1800AWX30	K600	5824246	4CH1800MX075A	KC633M
1192078	F3AH1400ADL30	K600	6146953	3CH1400DL022A	KC633M
2231351	F2AH1600BDK30	KC633M	5872989	2CH1600DK016B	KC633M
2231451	F3AH1500BDK30	KC633M	no replacement	no replacement	no replacement
1723033	F2AL1400ADN30	KC633M	5874178	2BN1400DD022A	KC633M
1723039	F2AL1600ADN30	KC633M	5874179	2BN1600DD026A	KC633M



Indexable Milling

Indexable Milling Introduction R2–R21

Face Milling S1–S150

Shoulder Milling T1–T123

Slot Milling U1–U53

Copy Milling V1–V157

Thread Milling W1–W55

Technical Information X1–X20

Recommended Starting Speeds X22–X37



Indexable Milling Products

Our latest Metalcutting Innovations are designed to deliver higher productivity, longer tool life, and increased application versatility.

For more information about the latest products and services from Kennametal, please contact your Kennametal Representative or Authorised Kennametal Distributor, or visit **kennametal.com**.

FACE MILLS

- Dodeka™ Mini
- Dodeka
- Dodeka MAX™
- Mill 16™
- KSSM 45°
- KSOM™ Mini
- KSOM
- KSSM8+™
- Fix-Perfect™
- HexaCut™
- KSSR™ 84°
- KCFM
- MEGA
- KBDM™
- KSCM™ PCD AluMill™
- Fix-Perfect 90° Aluminium

SHOULDER MILLS

- Mill 4-11™
- Mill 4-15™
- Mill 1-7™
- Mill 1-10™
- Mill 1-14™
- Mill 1-18™
- Mill 1-25™
- 5720VZ
- KSSM™
- KSSM-KSSP, Helical Cutters
- 5230VS





SLOT MILLS

- KTMS™ T-Slot
- KVNS™
- SN
- LN
- KSSM™

COPY MILLS

- 7792VX
- KenFeed™ 2X
- Rodeka™
- KSRM™
- 7713VR
- 5505VX
- KDMB™ and KDMT™
- Z-Axis • Plunge Milling Cutters
- KCRA
- KIPR

INDEXABLE THREAD MILLS

- TM Series
  - TM24
  - TM25
  - TM40
  - TM41
- KTMD U Series
- TMS — Thread Milling System







The Most Advanced Milling Solutions in the Industry

For unsurpassed quality, value, and performance, you can trust Kennametal to provide the most comprehensive line of reliable metalcutting tools. Whatever your indexable milling product requirements, be assured that you will find the appropriate solution in this all-inclusive, easy-to-use guide.

For every milling application, workpiece, or equipment need, we offer the best tools on the market, designed to reduce your machining time, provide superior surface finishes, and exceed your expectations!

Identify material to be machined:

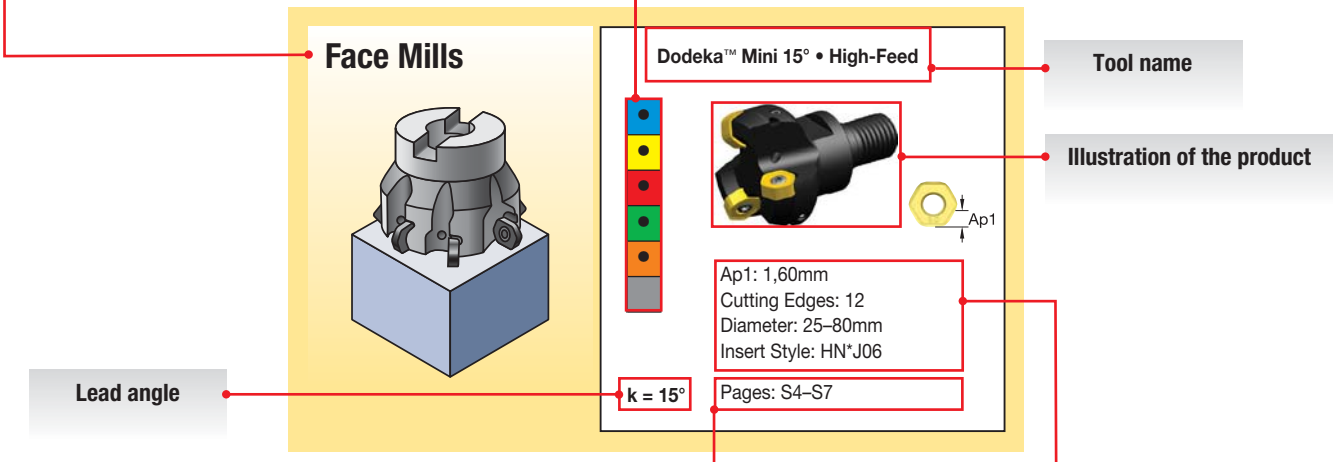
Each tool has a material grid marked with a letter indicating the materials that can be machined.

● first choice
○ alternate choice

P	○	Steel
M	●	Stainless Steel
K		Cast Iron
N		Non-Ferrous
S	○	High-Temp Alloys
H	○	Hardened Materials

Choose your application:

- Face Milling
- Chamfer Milling
- Shoulder Milling
- Slotting
- Copy Milling
- Ceramic Milling
- Thread Milling



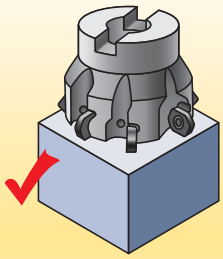
Location of introduction detail, tool bodies, inserts, and cutting data.

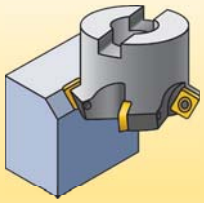
Select tool based on maximum depth of cut and diameter required:

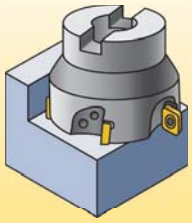
Information is given in this area to provide specific detail as a quick reference.

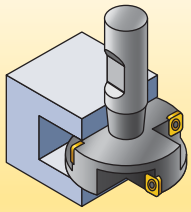
How to Navigate the 2018 Catalogue

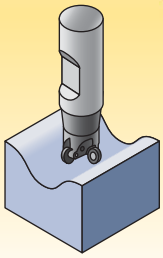
Step 1 • Select Application

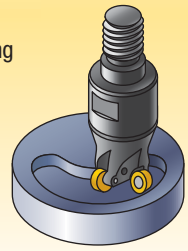

Face Milling

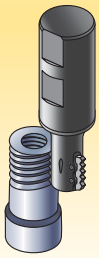

Chamfer Milling


Shoulder Milling (End Milling)


Slotting


Copy Milling


Ceramic Milling

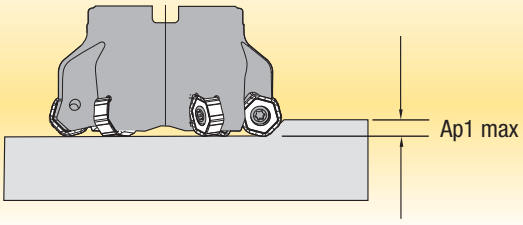

Thread Milling

Step 2 • Select Workpiece Material

● first choice
○ alternate choice

ISO Description			Material Group	
Steel	P	●	P1–P2	Carbon steels
			P3–P4	Alloy steels and tool steels
			P5–P6	Ferritic, martensitic, and PH stainless steels
Stainless Steel	M	●	M1–M2	Austenitic stainless steels
			M3	Duplex stainless steels (ferritic and austenitic mixture)
Cast Iron	K		K1–K2	Grey, ductile, CGI, and malleable cast irons >80 KSI
			K3	Ductile, CGI, and malleable cast irons >80 KSI
Non-Ferrous Materials	N		N1–N2	Aluminium alloys <12.2% Si
			N3	Aluminium alloys >12.2% Si
High-Temp Alloys	S	●	S1–S2	Iron- and cobalt-based heat-resistant alloys
			S3	Nickel-based heat-resistant alloys
			S4	Alpha-Beta titanium alloys
Hardened Materials	H	○	H1	Hardened steels and irons

Step 3 • Select a Maximum Axial Depth of Cut (Ap)



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How to Navigate the 2018 Catalogue *(continued)*

Step 4 • Select Milling Cutter from Application Selector

Face milling 1

Material 2

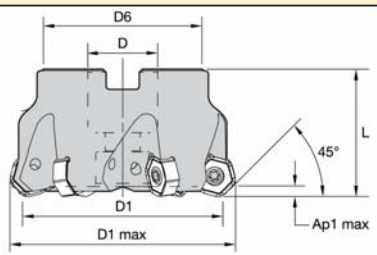


Ap1: 3,2mm
Cutting Edges: 12
Diameter: 25–125mm
Insert Style: HN*J06
Pages: S8–S13

k = 45°

3 Axial depth of cut

Select the Cutter





Dodeka Mini 45° • Shell Mills

order number	catalogue number	D1	D1 max	D	D6	L	Ap1 max	Z	kg	max RPM
4126387	KSHR040A04RS45HN06	40	48,2	22	38	40	3,2	4	0,25	15800
4124313	KSHR040A05RS45HN06	40	48,2	22	38	40	3,2	5	0,25	15800
4126388	KSHR050A04RS45HN06	50	58,2	22	38	40	3,2	4	0,36	12700
4122886	KSHR050A05RS45HN06	50	58,2	22	38	40	3,2	5	0,37	12700
4126389	KSHR050A06RS45HN06	50	58,2	22	38	40	3,2	6	0,36	12700
4122887	KSHR063A04RS45HN06	63	71,2	22	50	40	3,2	4	0,59	10100
4122889	KSHR063A06RS45HN06	63	71,2	22	50	40	3,2	6	0,65	10100
4126390	KSHR063A08RS45HN06	63	71,2	22	50	40	3,2	8	0,64	10100

4

Step 5 • Insert Selection Guide

Insert Selection Guide

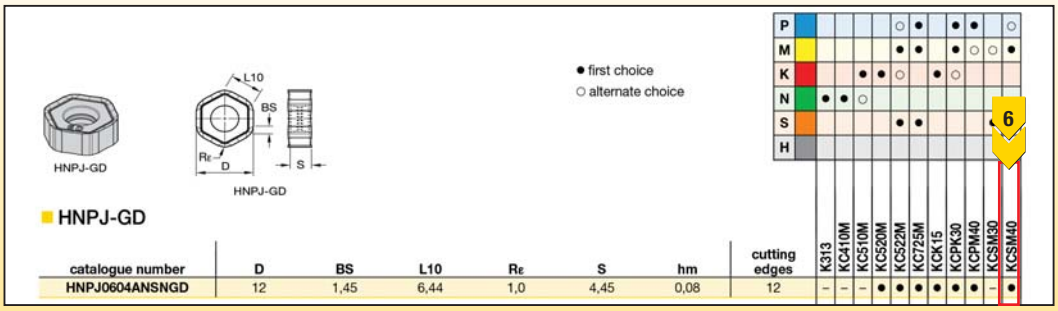
Material Group	Light Machining (Light geometry) wear resistance		General Purpose		Heavy Machining (Strong geometry) toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1 – P2	.E..LD	KCPM40	.S..GD	KCPM40	.S..HD	KCPM40
P3 – P4	.E..LD	KCPK30	.S..GD	KCPK30	.S..HD	KCPK30
P5 – P6	.E..LD	KC725M	.S..GD	KC725M	.S..HD	KCPK30
M1 – M2	.E..LD	KC522M	.S..GD	KCSM40	.S..HD	KCSM40
M3	.E..LD	KCSM40	.S..GD	KCSM40	.S..HD	KCPM40
K1 – K2	.E..LD	KCK15	.S..GD	KCK15	.S..HD	KCK15
K3	.E..LD	KC520M	.S..GD	KC520M	.S..HD	KC520M
N1 – N2	.F..LDJ	KC410M	.F..LDJ	KC410M	.E..LD	KC510M
N3	.F..LDJ	KC410M	.F..LDJ	KC410M	.E..LD	KC510M
S1 – S2	.E..LD	KC725M	.S..GD	KC725M	.S..HD	KC725M
S3	.E..LD	KCSM40	.S..GD	KCSM40	.S..HD	KCSM40
S4	.E..LD	KCSM40	.S..GD	KCSM40	.S..HD	KCSM40
H1	.E..LD	KC510M	.E..LD	KC510M	.E..LD	KC510M

5

(continued)

How to Navigate the 2018 Catalogue *(continued)*

Step 6 • Insert Chart, Providing the Inserts and Grades



HNPJ-GD

catalogue number	D	BS	L10	Rε	S	hm	cutting edges
HNPJ0604ANSNGD	12	1,45	6,44	1,0	4,45	0,08	12

Step 7 • Defining the Feed per Tooth

Geometry (S.GD)
20% radial width of cut, follow arrows for value.
% = radial width of cut (Ae) ÷ cutter diameter (D1)
Using a round or ball nose insert, consider the axial depth of cut; see separate chart on the cutter page.

Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40-100%			
.F..LDJ	0,17	**0,46**	0,79	0,12	**0,33**	0,57	0,09	**0,25**	0,43	0,08	**0,22**	0,37	0,07	**0,20**	0,34	.F..LDJ
.E..LD	0,18	**0,59**	0,99	0,13	**0,43**	0,71	0,10	**0,32**	0,53	0,09	**0,28**	0,46	0,08	**0,25**	0,42	.E..LD
.S..GD	0,33	**0,79**	1,19	0,24	**0,57**	0,86	0,18	**0,43**	0,64	0,16	**0,37**	0,56	0,14	**0,34**	0,51	.S..GD
.S..HD	0,33	**0,84**	1,35	0,24	**0,**	0,97	0,18	**0,45**	0,72	0,16	**0,39**	0,63	0,14	**0,36**	0,57	.S..HD

7

Always consider starting with the "Light Machining" value. Once established, increase the feed per tooth from the chart.
These are minimum values and can be increased when the application has been proven.
Light Machining — Low Feed Rate, High Speed
General Purpose — Normal Feed, Normal Speed
Heavy Machining — Higher Feed, Reduced Speed

Step 8 • Recommended Starting Speeds [m/min]

8

Material Group		SC6525			SP4019			SP6519			KCSM30			K[illegible]40			X400			X500		
P	1	445	**305**	170	380	**275**	170	355	**260**	155	445	**385**	360	–	–	–	310	**230**	145	325	**240**	155
	2	390	**270**	145	330	**240**	145	310	**230**	140	365	**325**	265	–	–	–	275	**205**	125	290	**215**	140
	3	350	**240**	125	295	**210**	125	275	**200**	120	340	**290**	235	–	–	–	240	**180**	115	250	**185**	120
	4	250	**175**	95	230	**160**	95	210	**150**	90	300	**245**	200	–	–	–	180	**130**	85	190	**145**	90
	5	190	**145**	95	180	**130**	85	170	**125**	85	245	**230**	200	205	**175**	145	–	–	–	155	**120**	85
	6	170	**120**	70	155	**110**	60	145	**100**	60	220	**170**	130	180	**130**	95	–	–	–	130	**95**	60
M	1	240	**215**	170	335	**240**	145	325	**235**	140	270	**240**	220	250	**205**	170	–	–	–	300	**220**	140
	2	230	**190**	145	300	**215**	130	280	**205**	125	245	**215**	175	215	**175**	145	–	–	–	265	**190**	120
	3	175	**155**	110	240	**175**	110	235	**170**	100	185	**160**	125	175	**130**	100	–	–	–	215	**155**	95
K	1	470	**325**	175	395	**290**	175	355	**265**	170	–	–	–	–	–	–	–	–	–	310	**265**	205
	2	365	**250**	140	305	**220**	140	290	**210**	130	–	–	–	–	–	–	–	–	–	265	**215**	155
	3	–	–	–	280	**205**	125	265	**190**	120	–	–	–	–	–	–	–	–	–	205	**170**	120
N	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
S	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

NOTE: For starting speed recommendations, please refer to section X22–X37 pages. Kennametal provides starting speed conditions for both wet and dry applications. Fine pitch cutters, such as Mill16™, KSSR™, and HexaCut™, also have separate speed tables provided.

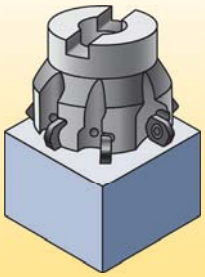
Choose the Application

- Face Milling
- Shoulder Milling
- Slotting
- Copy Milling
- Ceramic Milling
- Thread Milling

● first choice
○ alternate choice

P	Steel
M	Stainless Steel
K	Cast Iron
N	Non-Ferrous
S	High-Temp Alloys
H	Hardened Materials

Face Mills



Dodeka™ Mini 15° • High-Feed



Ap1: 1,60mm
Cutting Edges: 12
Diameter: 25–80mm
Insert Style: HN*J06
k = 15° Pages: S4–S7

Dodeka™ Mini 45°



Ap1: 3,2mm
Cutting Edges: 12
Diameter: 25–125mm
Insert Style: HN*J06
k = 45° Pages: S8–S13

Dodeka™ Mini 60°



Ap1: 4,4mm
Cutting Edges: 12
Diameter: 40–125mm
Insert Style: HN*J06
k = 60° Pages: S14–S16

Dodeka™ • High-Feed • 15°



Ap1: 2,2mm
Cutting Edges: 12
Diameter: 50–160mm
Insert Style: HN*J0905
k = 15° Pages: S17–S19

Dodeka™



Ap1: 4,5mm
Cutting Edges: 12
Diameter: 40–315mm
Insert Style: HN*J0905
k = 45° Pages: S20–S24

Dodeka MAX™



Ap1: 8mm
Cutting Edges: 12
Diameter: 80–315mm
Insert Style: HN*J1307
k = 45° Pages: S25–S27

Mill 16™



Ap1: 5,5mm
Cutting Edges: 16
Diameter: 50–250mm
Split case: 315–500mm
k= 43,5° Insert Style: ON*X0806
Pages: S32–S36

KSSM™ 45°



Ap1: 6,6mm
Cutting Edges: 4
Diameter: 40–160mm
Insert Style: SE.T1404
k= 45° Pages: S41–S43

KSOM™ Mini



Ap1: 3,5mm (8 edges)
Ap2: 9mm (4 edges)
Diameter: 32–160mm
Insert Style: OF*T06
k = 43° Pages: S46–S51

KSOM™



Ap1: 5mm (8 edges)
Ap2: 11mm (4 edges)
Diameter: 63–160mm
Insert Style: OF*T07
k = 43° Pages: S53–S56

KSSM8+™ • IC10



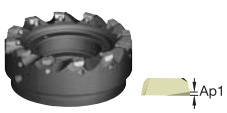
Ap1: 9,16mm
Cutting Edges: 8
Diameter: 50–160mm
Insert Style: SN*J10T3
k= 88° Pages: S60–S61

KSSM8+ • IC12



Ap1: 6mm (-ENLD)
Ap1: 11,86mm (-SNGD)
Cutting Edges: 8
Diameter: 50–160mm
k= 87° Insert Style: SN*J1206
Pages: S62–S64

Fix-Perfect™ • Finisher



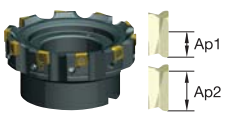
Ap1: 1mm
Cutting Edges: 4
Diameter: 63–250mm
Insert Style: MDHX1004
k = 15° Pages: S68–S70

Fix-Perfect™ 70° • Cast Iron • IC12



Ap1: 5,9mm (8 edges)
Ap2: 9,5mm (4 edges)
Diameter: 50–250mm
Insert Style: SPHX1205
k = 70° Pages: S72–S74

Fix-Perfect™ 90° • Cast Iron • IC12



Ap1: 6mm (8 edges)
Ap2: 10mm (4 edges)
Diameter: 50–200mm
Insert Style: SPHX1205
k = 90° Pages: S76–S78

Fix-Perfect™ 70° • Cast Iron • IC15



Ap1: 6,5mm (8 edges)
Ap2: 12mm (4 edges)
Diameter: 80–250mm
Insert Style: SPHX15T6
k = 70° Pages: S79–S81

(continued)

(Face Mills Application Selection Guide — continued)

Fix-Perfect™ 90° • Cast Iron • IC15



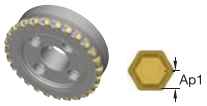
Ap1: 8mm (8 edges)
Ap2: 12mm (4 edges)
Diameter: 80–200mm
Insert Style: SPHX15T6
k = 90° Pages: S82–S84

HexaCut™ 45° • Cast Iron



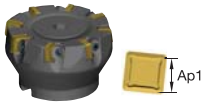
Ap1: 6,5mm
Cutting Edges: 12
Diameter: 80–200mm
Insert Style: HN*0905
k = 45° Pages: S89–S92

HexaCut™ 60° • Cast Iron



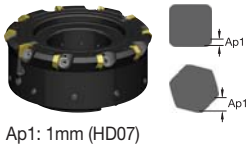
Ap1: 8mm
Cutting Edges: 12
Diameter: 80–200mm
Insert Style: HN*0905
k = 60° Pages: S94–S98

KSSR™ 84°



Ap1: 5mm
Cutting Edges: 8
Diameter: 63–250mm
Insert Style: SNXF1204
k = 84° Pages: S102–S106

KCFM



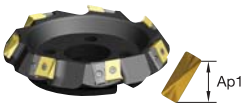
Ap1: 1mm (HD07)
Ap1: 3mm (SD12)
Cutting Edges: 6/4
Diameter: 80–250mm
Insert Style: HDHN07, SDHN12
k = 45° Pages: S110–S112

MEGA 45° • Heavy Duty



Ap1: 17,2mm
Cutting Edges: 4
Diameter: 125–315mm
Insert Style: LNPU24
k = 45° Pages: S116–S117

MEGA 60 • Heavy Duty



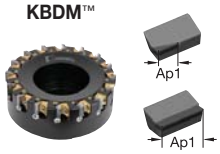
Ap1: 21,4mm
Cutting Edges: 4
Diameter: 125–315mm
Insert Style: LNPU2210
k = 60° Pages: S120–S121

MEGA 90 • Heavy Duty



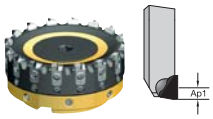
Ap1: 25,5mm
Cutting Edges: 4
Diameter: 125–315mm
Insert Style: LNPU2210
k = 90° Pages: S122–S123

KBDM™



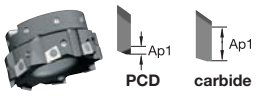
Ap1: 2,5/6,3/12,7mm
Cutting Edges: 1
Diameter: 63–200mm
Insert Style: KSDR10
Pages: S126–S128

KSCM™ AluMill™



Ap1: 3mm
Cutting Edges: 1
Diameter: 63–315mm
k = 90° Pages: S131–S134

Fix-Perfect™ 90° • Aluminium

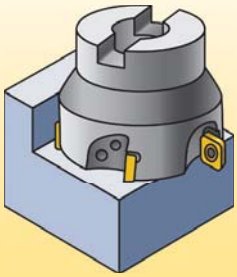


Ap1: 9,5mm (carbide)
Ap1: 2,5–5,2mm (PCD)
Cutting Edges: 4 (carbide)
1 (PCD)
Diameter: 40–315mm
Insert Style: BGHX15L5
k = 90° Pages: S143–S149

● first choice
○ alternate choice

P	Steel
M	Stainless Steel
K	Cast Iron
N	Non-Ferrous
S	High-Temp Alloys
H	Hardened Materials

Shoulder Mills



Mill 4-11™



Ap1: 11mm
Cutting Edges: 4
Diameter: 16–80mm
Insert Style: LN*U1104
k = 90° Pages: T4–T10

Mill 4-15™



Ap1: 15,5mm
Cutting Edges: 4
Diameter: 25–160mm
Insert Style: LN*U15T6
k = 90° Pages: T14–T20

Mill 1-7™



Ap1: 7mm
Cutting Edges: 2
Diameter: 12–20mm
Insert Style: EDPT0703
k = 90° Pages: T24–T25

Mill 1-10™



Ap1: 10mm (carbide)
Ap1: 4mm (PCD)
Cutting Edges: 2
Diameter: 12–100mm
Insert Style: ED*T10T3
k = 90° Pages: T29–T37

Mill 1-10™ Helical



Ap1: up to 45mm
Cutting Edges: 2
Diameter: 20–50mm
Insert Style: ED*T10T3
k = 90° Pages: T38–T44

Mill 1-14™



Ap1: 14mm
Cutting Edges: 2
Diameter: 20–160mm
Insert Style: ED*T1404
k = 90° Page: T47–T54

Mill 1-14™ Helical



Ap1: 27–54mm
Cutting Edges: 2
Diameter: 32–63mm
Insert Style: ED*T1404
k = 90° Pages: T57–T63

Mill 1-18™



Ap1: 18mm
Cutting Edges: 2
Diameter: 25–160mm
Insert Style: ED*T1805
k = 90° Pages: T69–T76

Mill 1-25™



Ap1: 25mm
Cutting Edges: 2
Diameter: 40–100mm
Insert Style: KE*25L5
k = 90° Pages: T79–T83

5720VZ16



Ap: 16mm
Cutting Edges: 2
Diameter: 25–80mm
Insert Style: ZDET16M5
k = 90° Pages: T86–T91

KSSM™ 90° • IC 10mm



Ap1: 6,6mm
Cutting Edges: 4
Diameter: 25–100mm
Insert Style: SP*T10T3
k = 90° Pages: T97–T101

KSSM™ 90° • IC12mm



Ap1: 9,2mm
Cutting Edges: 4
Diameter: 50–200mm
Insert Style: SD*T1204
k = 90° Pages: T102–T106

KSSM™-KSSP • Helical 90° • IC 12mm



Ap1: 32–61mm
Cutting Edges: 4
Diameter: 50–80mm
Insert Style: SD*T1204
k = 90° Pages: T109–T113

5230VS09



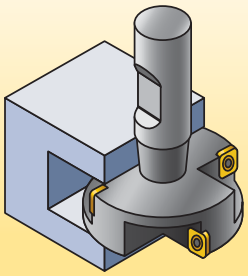
Cutting Edges: 4
Diameter: 50mm
Insert Style: SDHT09T3/ SDMW09T3
k = 90° Pages: T115–T117

5230VS12

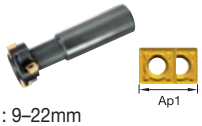


Cutting Edges: 4
Diameter: 63–100mm
Insert Style: SDHT1204/ SDMW1204
k = 90° Pages: T118–T120

Slotting



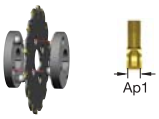
KTMS™ Slotting Cutter



Ap1: 9–22mm
Diameter: 21–50mm
Insert Style: SDMT
Pages: U3–U4

k = 90°

KVNS™ A2™ Slotting Cutters



Ap1: 1,6–4mm
Cutting Edge: 1
Diameter: 63–250mm
Pages: U7–U10

k = 90°

90° SN Slotting Cutters



B min: 4–14mm
Cutting Edges: 4
Diameter: 80–250mm
Insert Style: SNHX
Pages: U13–U15

k = 90°

90° LN Slotting Cutters



B min: 6–12mm
Cutting Edges: 4
Diameter: 80–200mm
Insert Style: LNEU/LNEQ
Pages: U17–U22

k = 90°

KSSM™ Slotting Cutters • IC 10



B min: 14–18mm
Cutting Edges: 4
Diameter: 100–315mm
Insert Style: SP*T10T3
Pages: U25–U37

k = 90°

KSSM™ Slotting Cutters • IC 12



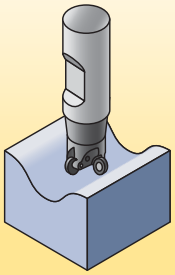
B min: 18–23,3mm
Cutting Edges: 4
Diameter: 125–315mm
Insert Style: SD*T1204
Pages: U38–U52

k = 90°

● first choice
○ alternate choice

P	Steel
M	Stainless Steel
K	Cast Iron
N	Non-Ferrous
S	High-Temp Alloys
H	Hardened Materials

Copy Mills



7792VXP06



Ap: 0,9mm
Cutting Edges: 4
Diameter: 16–35mm
Insert Style: XP*T0603
Pages: V4–V8

7792VXD09



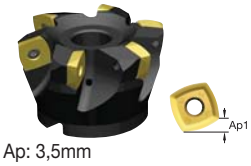
Ap: 1,5mm
Cutting Edges: 4
Diameter: 25–66mm
Insert Style: XD*T0904
Pages: V9–V17

7792VXD12



Ap: 2,5mm
Cutting Edges: 4
Diameter: 32–160mm
Insert Style: XD*T1205
Pages: V18–V26

7792VXE16



Ap: 3,5mm
Cutting Edges: 4
Diameter: 40–160mm
Insert Style: XE*1605
Pages: V27–V32

KenFeed™ 2X Series



HF

Ap1: 1,5mm
Cutting Edges: 6
Diameter: 25–80mm
Insert Style: WOEJ09
Pages: V38–V42

Rodeka™ 10



Ap: 5mm
Cutting Edges: 8
Diameter: 25–80mm
Insert Style: RN*J10
Pages: V46–V52

Rodeka™ IC12



Round

Ap1: 3mm/6mm
Cutting Edges:12/8
Diameter: 32–100mm
Insert Style: RN*J12
Pages: V53–V59

Rodeka 16



Ap: 4mm
Cutting Edges: 12
Diameter: 50–160mm
Insert Style: RN*J16
Pages: V60–V62

Rodeka 12X



Ap: 6mm
Cutting Edges: 8
Diameter: 40–80mm
Insert Style: RNGJ12
Pages: V64–V66

KSRM™ • IC12



Round

Ap1: 6mm
Diameter: 32–100mm
Insert Style: RP*T1204
Pages: V70–V75

KSRM™ • IC16



Round

Ap1: 8mm
Diameter: 40–125mm
Insert Style: RP*T1605
Pages: V77–V80

KSRM™ • IC20



Round

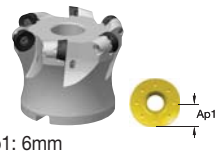
Ap1: 10mm
Diameter: 63–200mm
Insert Style: RCTG2006
Pages: V82–V84

7713VR10



Ap1: 5mm
Diameter: 20–63mm
Insert Style: RP*10
Pages: V87–V92

7713VR12



Ap1: 6mm
Diameter: 25–80mm
Insert Style: RP*12
Pages: V93–V98

5505VX



Ap1: 16–50mm
Diameter: 16–50mm
Insert Style: XPNT
Pages: V101–V108

KDMB™ Ball Nose Platform



Ap1: 3–16mm
Cutting Edges: 1
Diameter: 6–32mm
Insert Style: KDMB
Pages: V111–V127

(continued)

(Copy Mills Application Selection Guide — continued)

KDMT™ Platform • KDMS



Ap1: up to 8mm
Cutting Edges: 1
Diameter: 8–32mm
Insert Style: KDMS
Pages: V128–V134

KDMT™ High Feed



HF

Ap1: up to 8mm
Cutting Edges: 1
Diameter: 6–20mm
Insert Style: KDMT
Pages: V128–V134

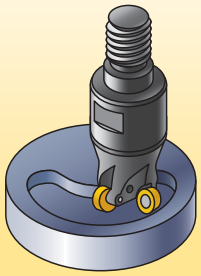
Z-Axis Plunge Mill



k = 88.5°

Ap1: 11mm
Cutting Edges: 4
Diameter: 32–160mm
Insert Style: SD*T1204
Pages: V137–V141

Ceramic Mills



KCRA



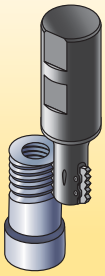
Ap: 6,4mm
Diameter: 40–80mm
Insert Style: RNGN1204
Pages: V146–V149

KIPR



Ap: 6,3mm
Diameter: 16–40mm
Insert Style: RPGN06/ RPGN09/RPGN12
Pages: V153–V157

Thread Mills



Indexable Thread Mills • Parallel and Conical Threads



Inserts: TM24, TM25, TM40, TM41
Diameter: 11,5–52mm
Pages: W4–W27

KTMD U Series



Diameter: 14,8–56mm
Pages: W29–W37

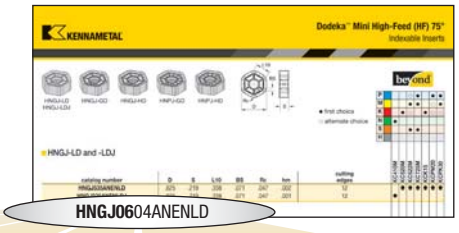
TMS Thread Milling System



Diameter: 9–46mm
Mini Shank: STN10
Normal Shank: STN11, STN16, STN27, STN38
Long Shank: STN16, STN27, STN38
Pages: W39–W47

How Do Catalogue Numbers Work?

Each character in our catalogue number signifies a specific trait of that product. Use the following key columns and corresponding images to easily identify which attributes apply.



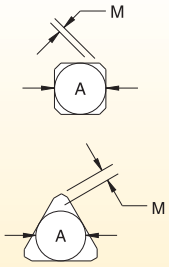
H — Insert Shape

A	Parallelogram 85°	
C	Rhomboid 80°	
E	75°	
H	Hexagon 120°	
L	Rectangular 90°	
O	Octagon 135°	
R	Round —	
S	Square 90°	
T	Triangular 60°	
X	Kennametal Standard Form	

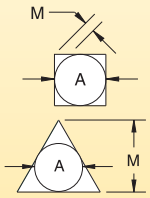
N — Insert Clearance Angle

A	3°
B	5°
C	7°
D	15°
E	20°
F	25°
G	30°
N	0°
P	11°

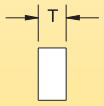
G — Tolerance Class



Indexable inserts with facets/wipers



Indexable inserts with corner radii



Insert thickness

J — Geometry and Clamping Type

06 — Size

A	"L" for shapes C	T	R	O	C	H	E
6,00	–	–	06	–	–	–	–
6,35	06	11	06	02	06	03	06
8,00	–	–	08	–	–	–	–
9,52	09	16	09	04	09	05	09
10,00	–	–	10	–	–	–	–
12,00	–	–	12	–	–	–	–
12,70	12	22	12	05	12	07	13
15,88	15	27	15	06	16	09	16
16,00	–	–	16	–	–	–	–
19,05	19	33	19	07	19	11	19
20,00	–	–	20	–	–	–	–
25,00	–	–	25	–	–	–	–
25,40	25	44	25	10	25	14	26

For shapes A, L, and X, see position #1; use length of leading cutting edge.

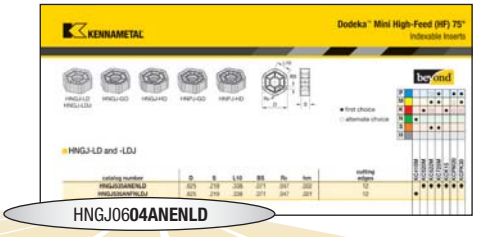
tolerance class	tolerance on "A"	tolerance on "M"	tolerance on "T"	tolerance class	tolerance on "A"	tolerance on "M"	tolerance on "T"
A	0,025	0,005	0,025	J	0,05–0,13*	0,005	0,025
B	0,025	0,005	0,13	K	0,05–0,13*	0,013	0,025
C	0,025	0,013	0,025	L	0,05–0,13*	0,025	0,025
D	0,025	0,013	0,13	M	0,05–0,10*	0,05–0,25*	0,13
E	0,025	0,025	0,025	N	0,05–0,10*	0,05–0,25*	0,025
F	0,013	0,005	0,025	P**	0,038	0,038	0,038
G	0,025	0,025	0,13	U	0,08–0,25*	0,13–0,30*	0,13
H	0,013	0,013	0,025	—	—	—	—

*See table below for tolerances according to insert size and class.
**Kennametal standard only.

A	tolerances on "A"		tolerances on "M"	
	classes J, K, L, M, N	class U	classes M & N	class U
4,76–10,00	0,051	0,076	0,076	0,127
11,11–14,29	0,076	0,127	0,127	0,203
15,00–20,64	0,102	0,178	0,152	0,279
22,00–31,16	0,127	0,254	0,178	0,381
31,75–35,00	0,152	0,254	0,203	0,381

symbol	hole	shape of hole	chipbreaker	shape of insert's section
N	without		without	
R			single sided	
F			double sided	
A	with	cylindrical hole	without	
M			single sided	
G			double sided	
W		partly cylindrical hole, 40–60° countersink	without	
T			single sided	
Q		partly cylindrical hole, 40–60° double countersink	without	
U			double sided	
B		partly cylindrical hole, 70–90° countersink	without	
H			single sided	
C		partly cylindrical hole, 70–90° double countersink	without	
J			double sided	
X	special design			

By referencing this easy-to-use guide, you can identify the correct product to meet your needs.

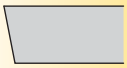


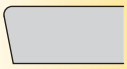
04	AN	E	N	L	D	
Thickness	Corner Configuration	Cutting Edge Form	Insert Hand	Edge Prep Size	Rake Face Angle	Added Info



insert thickness

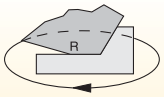
T	
2,38	02
3,18	03
3,97	T3
4,76	04
5,56	05
6,35	06
7,94	07

F  Sharp

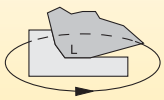
E  Honed

T  T-land

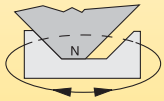
S  Honed T-land



direction of cutter rotation



direction of cutter rotation



direction of cutter rotation

J = Polished rake face

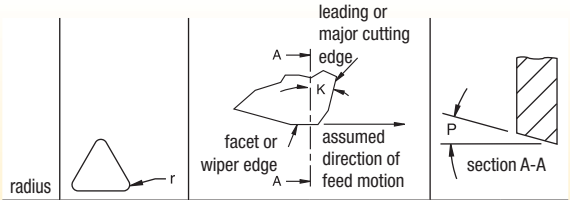
P = Partial T-land

W = Wiper/radiused facet

L = Light — sharp or lightly honed and/or T-land

G = General — medium hone and/or T-land

H = Heavy — large hone and/or T-land



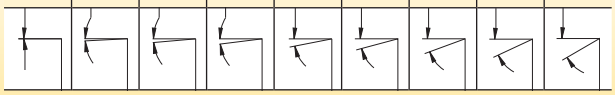
MO	round insert
01	0,1mm
02	0,2mm
04	0,4mm
05	0,5mm
08	0,8mm
10	1,0mm
12	1,2mm
15	1,5mm
16	1,6mm
24	2,4mm
32	3,2mm

If letter is replaced by number(s), refer to table for radius "r".

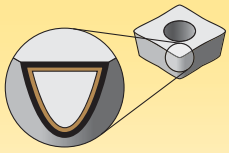
lead angle K	
A	45°
D	60°
E	75°
P	90°

wiper edge clearance P	
A	3°
B	5°
C	7°
D	15°
E	20°
F	25°
G	30°
N	0°
P	11°

N	A	B	C	P	D	E	F	G
0° or less	3°	5°	7°	11°	15°	20°	25°	30°



Nominal or average angle of rake on insert face at leading cutting edge before edge prep and before installation.

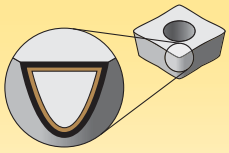


Coatings provide high-speed capability and are engineered for finishing to heavy roughing.

P	Steel
M	Stainless Steel
K	Cast Iron
N	Non-Ferrous
S	High-Temp Alloys
H	Hardened Materials

Grades

Coating	Grade Description	wear resistance ⟷ toughness: 05	10	15	20	25	30	35	40	45
GH1	Uncoated submicron carbide grade with high wear resistance. GH1 is suitable for machining of aluminium and non-ferrous materials. Also a good choice for the finishing of cast iron. This grade can be used both wet and dry and is designed for light and general machining.	K, N	K, N	K, N						
GH2	Uncoated, fine grained carbide grade with good strength. GH2 is suitable for machining of aluminium and non-ferrous materials. Also good choice for cast iron for medium toughness requirements. This grade can be used both wet and dry and is designed for light and general machining.				K, N, S	K, N, S	K, N			
K110M	Uncoated carbide grade K110M is a universal grade for machining non-ferrous material. For use in light and general machining. K110M can be used with or without coolant.		K, N, S	K, N, S	N					
K115M	Uncoated carbide grade. K115M is a premium uncoated grade designed for high edge-wear resistance in non-ferrous and cast iron materials. Recommended to be used with coolant.		K, N	K, N						
K313	Uncoated carbide grade. K313 is suitable for machining cast iron, high-temperature alloys and non-ferrous materials. This grade can be used both wet and dry and is designed for light and general machining.		K, N, S	K, N, S						
KBK50	A high CBN content, PcBN tip brazed onto a carbide insert. Designed to machine at highest speeds and tool life on semi-finishing and finishing cast iron materials.		K	K						
KC410M	PVD, TiB_2 coating on grade KC410M is extremely hard and provides very good wear characteristics at higher cutting speeds. KC410M resists built-up edge, can help reduce burring, and generates excellent surface finishes. The grade is best suited for aluminium with <10% silicon and other non-ferrous materials.		N	N						



Coatings provide high-speed capability and are engineered for finishing to heavy roughing.

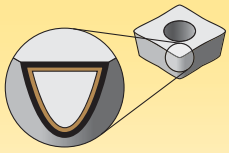
P	Steel
M	Stainless Steel
K	Cast Iron
N	Non-Ferrous
S	High-Temp Alloys
H	Hardened Materials

Preferred grade.

wear resistance ← → **toughness**

Grades

Coating	Grade Description		05	10	15	20	25	30	35	40	45
KC422M	The PVD TiB_2 coating is very wear resistant. Together with hard coating and a tough substrate, this is an excellent combination for medium to roughing applications in aluminium <10% silicon and other non-ferrous materials.	N									
KC505M	Coated carbide with PVD TiAlN. KC505M is a highly wear-resistant grade; primarily used for light maching applications in steel and hardened steels.	P									
		H									
KC510M	Coated carbide grade with a TiAiN coating (PVD). KC510M is a highly wear-resistant grade primarily for use in milling aluminium and high-temperature alloys in light applications. Can also be used for machining of steel and hardened steel.	P									
		N									
		S									
		H									
KC514M	Coated carbide grade with a thicker PVD TiAlN coating. KC514M combines high wear resistance with good toughness. Primarily for light to medium machining of cast irons. This grade can be used both wet and dry.	K									
KC515M	Premium-coated grade K10 substrate with built-in wear resistance and (TiAlN) coating for extended life during finishing applications. Used in finish ball nose and back draft inserts for the die and mould industry. Capable of running at moderate to high cutting speeds.	P									
		M									
		K									
KC520M	Coated carbide grade with TiAlN coating (PVD). KC520M is a carbide grade developed specifically for general machining of ductile cast iron. This grade can be used with or without coolant.	K									
KC522M	Coated carbide grade with a AlTiN (PVD) coating. KC522M is engineered to provide better performance in general machining of high-temperature alloys and stainless steel. KC522M resists breakage and offers improved wear resistance and increased strength.	P									
		M									
		K									
		S									



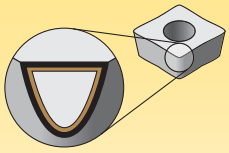
Coatings provide high-speed capability and are engineered for finishing to heavy roughing.

P	Steel
M	Stainless Steel
K	Cast Iron
N	Non-Ferrous
S	High-Temp Alloys
H	Hardened Materials

Preferred grade.

Grades

Coating	Grade Description	wear resistance ← → toughness	05	10	15	20	25	30	35	40	45
KC524M	Coated carbide grade with a thicker PVD TiAlN coating. KC524M combines good wear resistance with high toughness. Primarily for general machining of all cast irons. This grade can be used both wet and dry.	K				■	■	■	■		
KC525M	Coated carbide grade with a TiAlN coating (PVD). New universal carbide grade for milling steel, stainless steel, and high-temperature alloys. KC525M can be used with or without coolant. Primarily for use in light and general machining.	P M S				■ ■ ■	■ ■ ■	■ ■ ■			
KC530M	Premium PVD-coated carbide grade (P40) with a TiAlN coating. Enables extended tool life at moderate feeds and high cutting speeds. First choice for milling in all steels, including die and mould steels. Recommended for use without coolant.	P M					■ ■	■ ■	■		
KC725M	Coated carbide grade with an advanced PVD TiAlN coating. KC725M is a high-performance grade for milling steel, stainless steel, and ductile cast iron. The good thermal shock resistance of the substrate makes this grade ideal for both wet and dry machining. Primarily for use in general and heavy machining.	P M S						■ ■ ■	■ ■ ■	■ ■ ■	
KC735M	PVD/TiN coated carbide grade. This grade offers an unusual combination of high toughness and wear resistance. Even under extreme toughness requirements, it achieves outstanding results in general and heavy-machining applications. Suitable for dry and wet machining.	P M						■ ■	■ ■	■	
KCK15	Coated carbide grade with CVD multilayer coating (TiN/MT TiCN/Al_2O_3) and advanced Beyond™ post-coat treatment. KCK15 is a wear-resistant grade with balanced toughness for general milling of cast irons at higher speeds. Best results in dry, but can also be used wet.	K		■	■	■					
KCK20	A new PVD multilayer AlTiN + AlCrN coated carbide with an excellent combination of wear resistance and coating strength. The KCK20 grade is specifically engineered to maximise coating adhesion and edge strength, making this grade ideal in wet interrupted cutting of gray and ductile irons, and can also be used in dry conditions. It can be used in a wide range of applications, from finishing to roughing, to maximise productivity wherever strength and reliability are needed.	K		■	■	■	■				



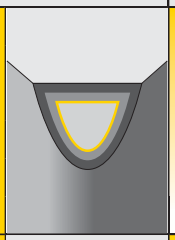
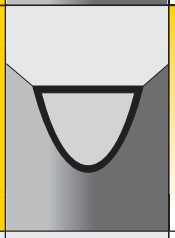
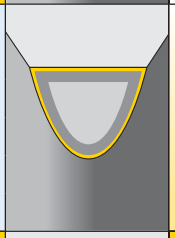
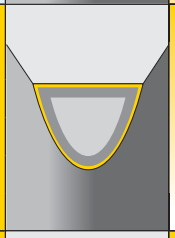
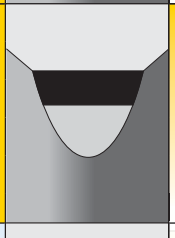
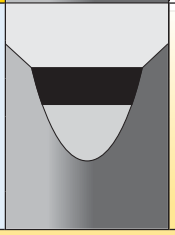
Coatings provide high-speed capability and are engineered for finishing to heavy roughing.

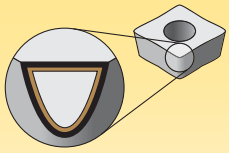
P	Steel
M	Stainless Steel
K	Cast Iron
N	Non-Ferrous
S	High-Temp Alloys
H	Hardened Materials

Preferred grade.

wear resistance ⟷ **toughness**

Grades

Coating		Grade Description		05	10	15	20	25	30	35	40	45
KCPK30		Coated carbide grade with CVD multilayer (TiN/TiCN/Al_2O_3) and advanced Beyond™ post-coat treatment. Substrate is very tough. KCPK30 has a wide application area in general and roughing milling of steels and cast irons. Performs best dry, but can also be used wet.	P					■	■	■	■	
			M									
			K					■	■	■	■	
			N									
			S									
			H									
KCPM40		Coated carbide grade with an advanced PVD TiAlN/AlCrN coating. Tough substrate with excellent capability at higher temperatures. KCPM40™ is the first choice for milling steel and stainless steel. Good thermal shock resistance makes this grade ideal for both wet and dry machining. Primarily for use in general and heavy machining.	P					■	■	■	■	
			M					■	■	■	■	
			K									
			N									
			S									
			H									
KCSM30		Submicron substrate coated with high-performance TiAlN-PVD coating is an excellent choice for titanium, but also high-temperature alloys and stainless with higher speeds for light to medium cuts. First choice for application with thin to medium chip thickness, dry and wet.	P				■	■	■			
			M					■	■	■		
			K									
			N									
			S				■	■	■	■		
			H									
KCSM40		Coated carbide grade with an advanced PVD TiAlN/TiN coating. Premium substrate with newly developed binder composition. KCSM40 is a high-performance grade for titanium, super alloys, and stainless steel. High thermal shock resistance of the substrate makes this grade ideal for wet machining. First choice for roughing and unsuitable cutting conditions.	P									
			M					■	■	■	■	
			K									
			N									
			S					■	■	■	■	
			H									
KD1400		A PCD-tip brazed to a carbide carrier for high-speed machining of non-ferrous materials. KD1400 has excellent chipping resistance with good wear characteristics. Coolant is preferred.	P									
			M									
			K									
			N	■	■	■						
			S									
			H									
KD1410		A PCD-tip brazed to carbide for machining aluminium with a very high silicon content, abrasive non-ferrous materials, and fibre-reinforced plastics. KD1410 can be used at very high cutting speeds, even where good surface finishes are required. This grade can be used both wet or dry but is suggested to use coolant where good surface finishes are required.	P									
			M									
			K									
			N		■	■						
			S									
			H									

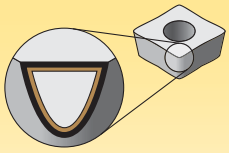


Coatings provide high-speed capability and are engineered for finishing to heavy roughing.

P	Steel
M	Stainless Steel
K	Cast Iron
N	Non-Ferrous
S	High-Temp Alloys
H	Hardened Materials

Grades

Coating	Grade Description	wear resistance ← → toughness	05	10	15	20	25	30	35	40	45
KD1415	PCD-tip brazed to carbide for general machining of aluminium with a low silicon content, non-ferrous heavy metals, and plastics. KD1415™ can be used at high cutting speeds and for continuous cutting, even where outstanding surface finishes are required. KD1415 is suitable for wet and dry machining.	N		■	■						
KD1425	A PCD-tipped brazed to a carbide carrier for high-speed machining of aluminium and other non-ferrous materials. KD1425™ provides superior wear resistance with moderate toughness to resist chipping. Coolant is preferred.	N	■	■	■						
KTPK20	Cermet with PVD-TiAlN/AlCrN multi-layer coating. This tough cermet is primarily used in light and general machining of steel, stainless steels, and cast irons. Performs best dry.	P M K			■ ■ ■	■ ■ ■	■ ■				
KY3500	A ceramic cutting material based on micro-grain Si_3N_4 primarily for use in light to general machining of grey cast iron and ferritic ductile cast iron. Dry machining is preferred while using this grade.	K				■	■	■	■		
KYS30	KYS30™ is the latest in the line of α/βSiAlON grades for general purpose to finish machining of high-temperature alloys. This grade provides excellent wear characteristics, with better toughness and thermal shock resistance than whisker ceramics. KYS30 also gives improved thermal stability.	S				■	■	■			
KYSP30	Combines excellent wear properties, fracture toughness, and thermal shock resistance for general purpose to finish machining of high-temperature alloys. KYSP30 provides superior depth-of-cut notch resistance compared to whisker ceramics.	S					■	■	■		
MP91M	CVD-coated carbide grade with TiN/MT-TiCN/Al_2O_3. Tough substrate in combination with wear resistant for roughing and semi-finishing of steel, cast iron, and hardened materials.	P K H				■ ■	■ ■ ■	■ ■ ■	■ ■ ■		



Coatings provide high-speed capability and are engineered for finishing to heavy roughing.

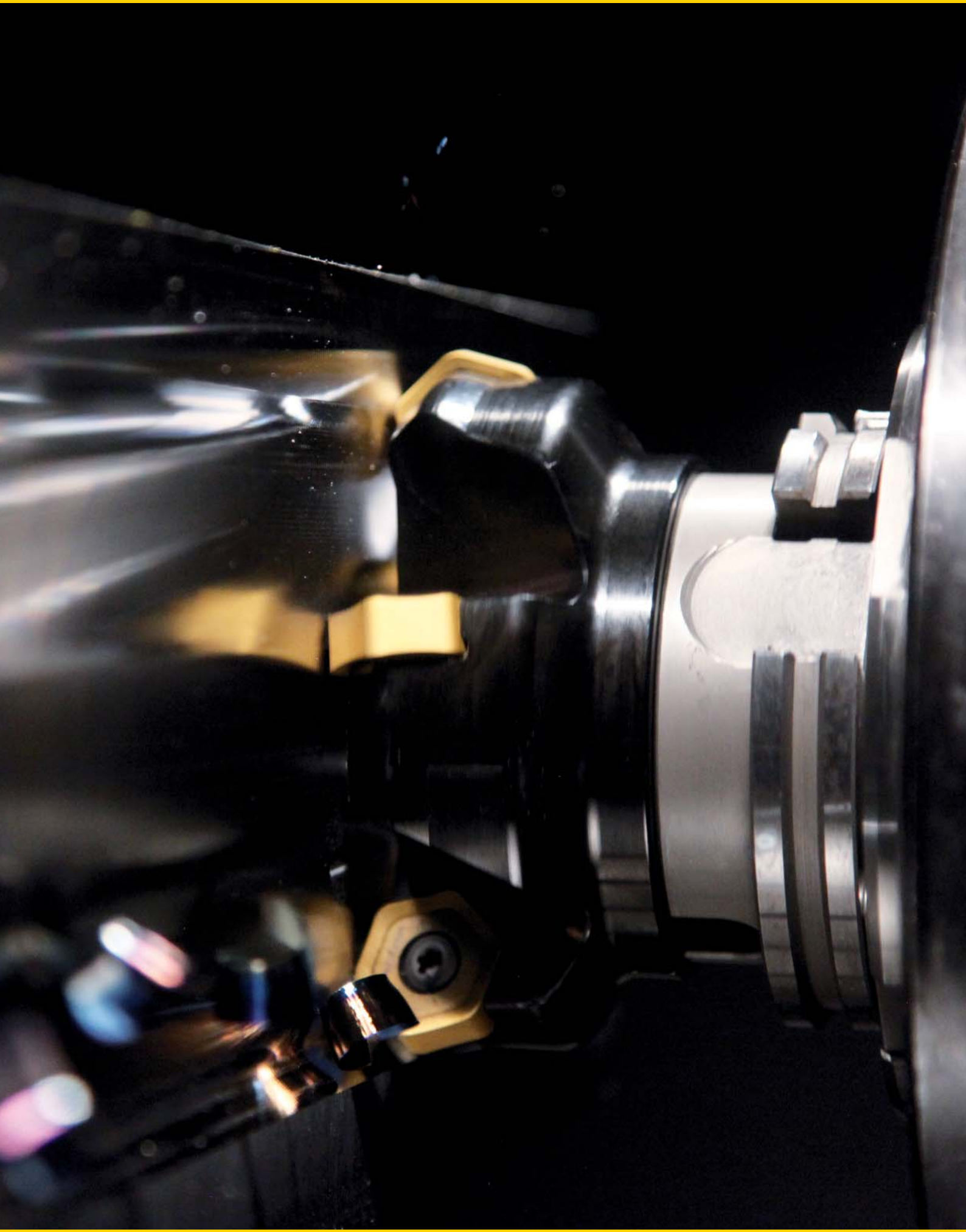
P	Steel
M	Stainless Steel
K	Cast Iron
N	Non-Ferrous
S	High-Temp Alloys
H	Hardened Materials

Preferred grade.

wear resistance ⟷ toughness

Grades

Coating	Grade Description		05	10	15	20	25	30	35	40	45
SC3025	Coated carbide grade with CVD multilayer coating (TiN/TiCN/Al_2O_3). SC3025 is a wear-resistant grade with balanced toughness for general milling of cast irons at higher speeds. Best results when using dry, but can also be used wet.	K									
SC6525	Coated carbide grade with CVD multi-layer (TiN/TiCN/Al_2O_3). Tough substrate with good speed capability. SC6525 has a wide application area in general and roughing milling of steels, stainless steels, and cast irons. Performs best dry, but can also be used wet.	P, M, K									
SP4019	Fine-grained substrate coated with PVD TiAlN nano-composite. First choice for applications with thin to medium chip thickness. This grade works on many workpiece materials, dry and wet.	M, K, N, S, H									
SP6519	Coated carbide grade with PVD TiAlN nano-composite coating on a tough substrate. Primarily for use in general and heavy machining, dry and wet.	P, M, K, N, S, H									
X400	Coated carbide grade with thick PVD TiAlN nanocomposite on X-Grade™ technology substrate. With excellent toughness, good choice for difficult cutting conditions on alloyed and hardened steels. Usable in combination with high feeds.	P, H									
X500	CVD TiN/TiCN/TiN coated carbide on tough substrate (X-Grade™ technology). For difficult applications with heavy impacts, vibrations, or unstable conditions. High stability against thermal cracks. Excellent grade for high-temperature alloys, stainless steels, and titanium.	P, M, S									
X700	PVD TiAlN nano-coating on premium substrate (X-Grade™ technology). Milling of stainless steel, super alloys, and titanium with medium applications.	M, S									



Indexable Milling • Face Milling

Dodeka • Leader in Advanced Face Milling (12 Edges per Insert) S2–S27

Mill 16 • 16-Edged Inserts for Machining Cast Iron Materials S30–S37

KSSM 45° • Conventional Machining S40–S43

KSOM Mini • KSOM • Best in Class-Free Cutting Face Mills S44–S56

KSSM8+ • 8-Edged Double-Sided Face Mills with Lead Angle Close to 90° S58–S64

Fix-Perfect • Cast Iron Rougher and Finisher S66–S85

HexaCut Series • Machining Automotive Components S86–S99

KSSR • Cast iron • Roughing and Finishing 84° Lead S100–S106

KCFM 45° • Cast Iron Finishing Milling S108–S113

MEGA 45 • For True Heavy-Duty Machining S114–S117

MEGA 60 and 90 • For True Heavy-Duty Machining S118–S123

KBDM • PCD Face Milling S124–S129

KSCM AluMill • KSCM PCD AluMill S130–S141

Fix-Perfect Aluminium S142–S150

Dodeka™ Series

Leader in Advanced Face Milling Applications

Primary Application

Dodeka Mini, Dodeka, and Dodeka MAX™ platforms are the most comprehensive face milling boosters on the market today. Twelve true cutting edges per insert mean low cost-per-edge and high productivity. With Beyond™ premium milling grades, achieve up to 30% higher metal removal rates (MRR), 25% lower cutting forces due to soft cutting action, and up to 35% better tool life in light to heavy machining.

Features and Benefits

Dodeka Series • Most comprehensive face milling platform on the market. Providing an excellent cost-per-cutting edge with market leading performance. The Dodeka Series platform will cover all your face milling application needs.

All cutter body variations can be loaded with one insert style.

Dodeka Mini High-Feed 15°
Dodeka High-Feed 15°



12 True Cutting Edges



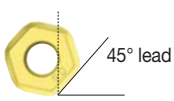
Dodeka Mini **Ap1 max = 1,6mm**
Dodeka **Ap1 max = 2,2mm**

Dodeka Mini HF and Dodeka HF can be loaded with all Dodeka Mini standard inserts, except wiper inserts.

Dodeka Mini 45°
Dodeka 45°
Dodeka MAX 45°



12 True Cutting Edges



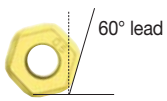
Dodeka Mini **Ap1 max = 3,2mm**
Dodeka **Ap1 max = 4,5mm**
Dodeka MAX **Ap1 max = 8,0mm**

Best-in-class leader in face milling up to Ap1 max = 8mm.

Dodeka Mini 60°



12 True Cutting Edges



Dodeka Mini **Ap1 max = 4,4mm**

Achieve a higher axial depth-of-cut capability up to Ap1 = 4,4mm with standard Dodeka Mini inserts.



Dodeka™ Mini Series

insert size HN.J06
Ap1 max = 4,4mm
pages S4–S16



Dodeka

insert size HN.J0905
Ap1 max = 4,5mm
pages S17–S24



Dodeka MAX™

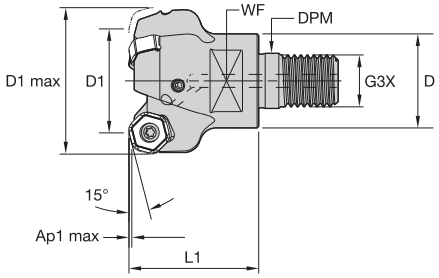
insert size HN.J1307
Ap1 max = 8mm
pages S25–S27

P M K N S

Applicable in most material groups • Excellent results in machining titanium

- Twelve cutting edges per insert.
- High-feed capability.





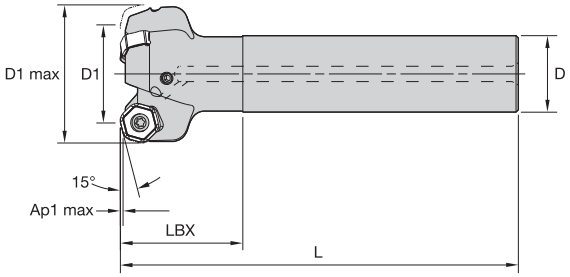


Dodeka Mini High-Feed 15° • Screw-On End Mills

order number	catalogue number	D1	D1 max	D	DPM	G3X	L1	WF	Ap1 max	Z	kg	max RPM
4153687	**KSHRHF025D03M16HN06**	25	38,2	29	17,0	M16	32,0	22	1,6	3	0,16	20000
4153689	**KSHRHF032D04M16HN06**	32	45,2	29	17,0	M16	40,0	22	1,6	4	0,25	17600

- Twelve cutting edges per insert.
- High-feed capability.







Dodeka Mini High-Feed 15° • Cylindrical End Mills

order number	catalogue number	D1	D1 max	D	L	LBX	Ap1 max	Z	kg	max RPM
4153703	**KSHRHF025D03A20HN06L120**	25	38,2	20	120	32	1,6	3	0,31	20000
4153704	**KSHRHF032D03A25HN06L130**	32	45,2	25	130	40	1,6	3	0,52	17600

Spare Parts



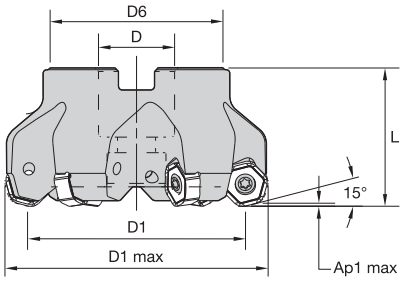


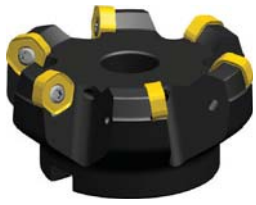


D1	insert screw	Nm	wrench
25	**193.492**	3,5	**170.025**
32	**193.492**	3,5	**170.025**

- Twelve cutting edges per insert.
- High-feed capability.







Dodeka Mini High-Feed 15° • Shell Mills

order number	catalogue number	D1	D1 max	D	D6	L	Ap1 max	Z	kg	max RPM
4153706	**KSHRHF040A05RS15HN06**	40	53,2	22	38	40	1,6	5	0,29	15800
4153707	**KSHRHF050A05RS15HN06**	50	63,1	22	38	40	1,6	5	0,39	12700
4153708	**KSHRHF063A06RS15HN06**	63	76,1	22	50	40	1,6	6	0,67	10100
4153709	**KSHRHF080A08RS15HN06**	80	93,1	27	60	50	1,6	8	1,26	7900

Spare Parts

D1	 insert screw	 Nm	 wrench	 socket-head cap screw
40	**193.492**	3,5	**170.025**	**125.025**
50	**193.492**	3,5	**170.025**	**125.025**
63	**193.492**	3,5	**170.025**	**125.025**
80	**193.492**	3,5	**170.025**	**125.230**



Dodeka Mini High-Feed

First choice for long reach face milling applications or light fixtures.

Chip thinning effect due to lead angle 14,5°. Tremendous enlargement of feed rate and metal removal rate (MRR).

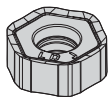
Up to 40% shorter machining cycle time versus conventional milling.

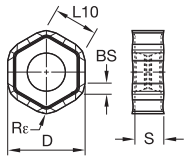
Insert Selection Guide

Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		←	→	toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.E..LD	KCPM40	**.S..GD**	**KCPM40**	.S..HD	KCPM40
P3–P4	.E..LD	KCPK30	**.S..GD**	**KCPK30**	.S..HD	KCPK30
P5–P6	.E..LD	KC725M	**.S..GD**	**KC725M**	.S..HD	KCPK30
M1–M2	.E..LD	KC522M	**.S..GD**	**KCSM40**	.S..HD	KCSM40
M3	.E..LD	KCSM40	**.S..GD**	**KCSM40**	.S..HD	KCPM40
K1–K2	.E..LD	KCK15	**.S..GD**	**KCK15**	.S..HD	KCK15
K3	.E..LD	KC520M	**.S..GD**	**KC520M**	.S..HD	KC520M
N1–N2	.F..LDJ	KC410M	**.F..LDJ**	**KC410M**	.E..LD	KC510M
N3	.F..LDJ	KC410M	**.F..LDJ**	**KC410M**	.E..LD	KC510M
S1–S2	.E..LD	KC725M	**.S..GD**	**KC725M**	.S..HD	KC725M
S3	.E..LD	KCSM40	**.S..GD**	**KCSM40**	.S..HD	KCSM40
S4	.E..LD	KCSM40	**.S..GD**	**KCSM40**	.S..HD	KCSM40
H1	.E..LD	KC510M	**.E..LD**	**KC510M**	.E..LD	KC510M

Indexable Inserts

- First choice for machining aluminium.


HNGJ-LDJ



HNGJ-LDJ

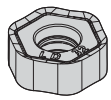
● first choice
○ alternate choice

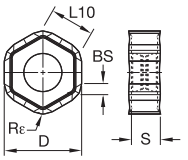
		K313	KC410M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
P						○	●		●	●	○
M						●	●		●	○	●
K				●	●	○		●	○		
N		●	●	○							
S						●	●				●
H											

HNGJ-LDJ

catalogue number	D	BS	L10	Rε	S	hm	cutting edges	K313	KC410M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
HNGJ0604ANFNLDJ	12	1,54	6,44	1,0	4,48	0,02	12	●	●	–	–	–	–	–	–	–	–

- First choice for light machining.


HNGJ-LD



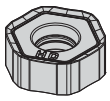
HNGJ-LD

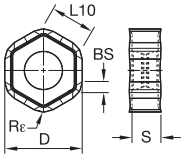
HNGJ-LD

catalogue number	D	BS	L10	Rε	S	hm	cutting edges	K313	KC410M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
HNGJ0604ANENLD	12	1,54	6,44	1,0	4,48	0,04	12	–	–	●	●	●	●	●	●	●	●
HNGJ060432ANENLD	12	–	6,43	3,2	4,48	0,05	12	–	–	–	–	–	●	–	●	–	–

Face Milling

• First choice for high-performance heavy roughing.


HNGJ-HD



HNGJ-HD

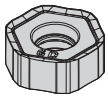
● first choice
○ alternate choice

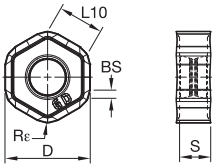
P					○	●		●	●	○			
M					●	●		●	○	●			
K			●	●	○		●	○					
N	●	●	○										
S					●	●				●			
H													

HNGJ-HD

catalogue number	D	BS	L10	Rε	S	hm	cutting edges	K313	KC410M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
HNGJ0604ANSNHD	12	1,45	6,44	1,0	4,40	0,14	12	–	–	–	–	●	–	●	●	●	●

• First choice for general purpose.


HNPJ-GD

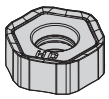


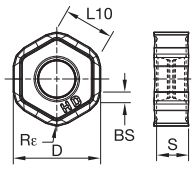
HNPJ-GD

HNPJ-GD

catalogue number	D	BS	L10	Rε	S	hm	cutting edges	K313	KC410M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
HNPJ0604ANSNGD	12	1,45	6,44	1,0	4,45	0,08	12	–	–	–	●	●	●	●	●	●	●

• First choice for heavy roughing.


HNPJ-HD



HNPJ-HD

HNPJ-HD

catalogue number	D	BS	L10	Rε	S	hm	cutting edges	K313	KC410M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
HNPJ0604ANSNHD	12	1,45	6,44	1,0	4,40	0,14	12	–	–	–	●	●	●	●	●	●	●
HNPJ060432ANSNHD	12	–	6,43	3,2	4,42	0,10	12	–	–	–	–	●	●	●	●	●	●

Recommended Starting Feeds

Recommended Starting Feeds [mm]

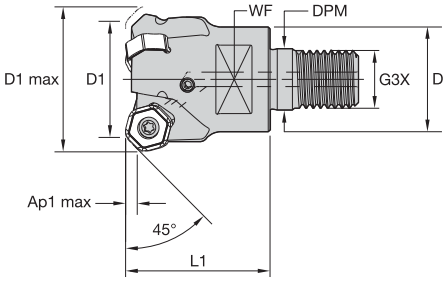
Light Machining	General Purpose	Heavy Machining

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40%–100%			
.F..LDJ	0,45	**1,27**	2,22	0,33	**0,91**	1,57	0,25	**0,68**	1,17	0,21	**0,59**	1,01	0,20	**0,54**	0,93	.F..LDJ
.E..LD	0,51	**1,65**	2,81	0,37	**1,17**	1,97	0,27	**0,87**	1,46	0,24	**0,76**	1,27	0,22	**0,70**	1,16	.E..LD
.S..GD	0,92	**2,22**	3,41	0,66	**1,57**	2,38	0,49	**1,17**	1,75	0,43	**1,01**	1,52	0,39	**0,93**	1,39	.S..GD
.S..HD	0,92	**2,35**	3,89	0,66	**1,67**	2,70	0,49	**1,23**	1,98	0,43	**1,07**	1,72	0,39	**0,98**	1,57	.S..HD

NOTE: Use "Light Machining" values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

- Twelve cutting edges per insert.
- Maximum number of teeth per diameter.
- Productivity booster in all materials.



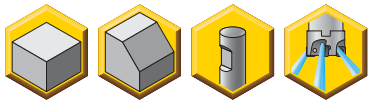


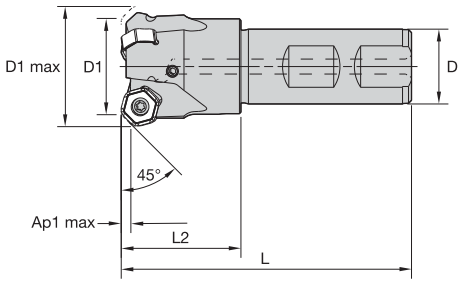


Dodeka Mini 45° • Screw-On End Mills

order number	catalogue number	D1	D1 max	D	DPM	G3X	L1	WF	Ap1 max	Z	kg	max RPM
4125882	**KSHR025D03M16HN06**	25	33,2	29	17,0	M16	32,0	22	3,2	3	0,13	20000
4126343	**KSHR032D03M16HN06**	32	40,2	29	17,0	M16	40,0	22	3,2	3	0,21	17600
4126344	**KSHR032D04M16HN06**	32	40,2	29	17,0	M16	40,0	22	3,2	4	0,21	17600

- Twelve cutting edges per insert.
- Maximum number of teeth per diameter.
- Productivity booster in all materials.







Dodeka Mini 45° • Weldon® End Mills

order number	catalogue number	D1	D1 max	D	L	L2	Ap1 max	Z	kg	max RPM
4126348	**KSHR025D03B20HN06**	25	33,2	20	82	32	3,2	3	0,21	20000
4126349	**KSHR032D03B25HN06**	32	40,2	25	97	40	3,2	3	0,40	17600
4126350	**KSHR032D04B25HN06**	32	40,2	25	97	40	3,2	4	0,41	17600

Spare Parts

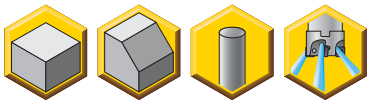


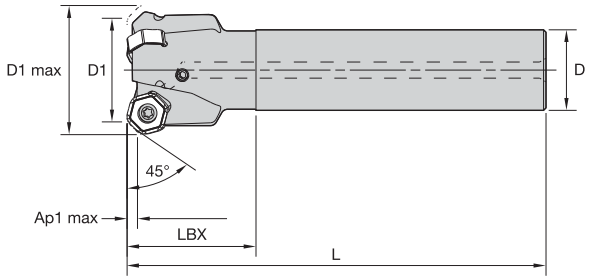




D1	insert screw	Nm	wrench
25	**193.492**	3,5	**170.025**
32	**193.492**	3,5	**170.025**

- Twelve cutting edges per insert.
- Maximum number of teeth per diameter.
- Productivity booster in all materials.







Dodeka Mini 45° • Cylindrical End Mills

order number	catalogue number	D1	D1 max	D	L	LBX	Ap1 max	Z	kg	max RPM
4126351	**KSHR025D02A20HN06L120**	25	33,2	20	120	32	3,2	2	0,28	20000
4126352	**KSHR025D03A20HN06L120**	25	33,2	20	120	32	3,2	3	0,28	20000
4126386	**KSHR025D03A25HN06L200**	25	33,2	25	200	32	3,2	3	0,71	20000
4126383	**KSHR032D03A25HN06L130**	32	40,2	25	130	40	3,2	3	0,50	17600
4126384	**KSHR032D04A25HN06L130**	32	40,2	25	130	40	3,2	4	0,50	17600

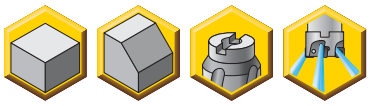
Spare Parts

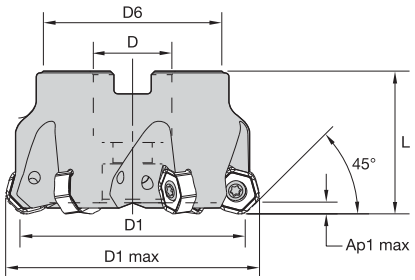


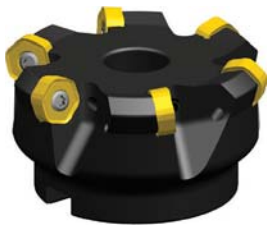


D1	insert screw	Nm	wrench
25	**193.492**	3,5	**170.025**
32	**193.492**	3,5	**170.025**

- Twelve cutting edges per insert.
- Maximum number of teeth per diameter.
- Productivity booster in all materials.







Dodeka Mini 45° • Shell Mills

order number	catalogue number	D1	D1 max	D	D6	L	Ap1 max	Z	kg	max RPM
4126387	KSHR040A04RS45HN06	40	48,2	22	38	40	3,2	4	0,25	15800
4124313	KSHR040A05RS45HN06	40	48,2	22	38	40	3,2	5	0,25	15800
4126388	KSHR050A04RS45HN06	50	58,2	22	38	40	3,2	4	0,36	12700
4122886	KSHR050A05RS45HN06	50	58,2	22	38	40	3,2	5	0,37	12700
4126389	KSHR050A06RS45HN06	50	58,2	22	38	40	3,2	6	0,36	12700
4122887	KSHR063A04RS45HN06	63	71,2	22	50	40	3,2	4	0,59	10100
4122889	KSHR063A06RS45HN06	63	71,2	22	50	40	3,2	6	0,65	10100
4126390	KSHR063A08RS45HN06	63	71,2	22	50	40	3,2	8	0,64	10100
4126391	KSHR080A05RS45HN06	80	88,1	27	60	50	3,2	5	1,13	7900
4126392	KSHR080A08RS45HN06	80	88,1	27	64	50	3,2	8	1,25	7900
4126403	KSHR080A10RS45HN06	80	88,1	27	60	50	3,2	10	1,19	7900
4126404	KSHR100B06RS45HN06	100	108,1	32	80	50	3,2	6	1,73	6300
4126405	KSHR100B09RS45HN06	100	108,1	32	80	50	3,2	9	1,84	6300
4126406	KSHR100B12RS45HN06	100	108,1	32	80	50	3,2	12	1,84	6300
4126407	KSHR125B08RS45HN06	125	133,1	40	90	63	3,2	8	2,87	5050
4126408	KSHR125B12RS45HN06	125	133,1	40	90	63	3,2	12	2,98	5050
4124262	KSHR125B16RS45HN06	125	133,1	40	90	63	3,2	16	3,05	5050

Spare Parts

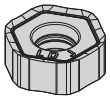


D1	insert screw	Nm	wrench	socket-head cap screw	coolant lock screw assembly	coolant lock screw	coolant shower plate
40	193.492	3,5	170.025	125.025	–	–	–
50	193.492	3,5	170.025	125.025	–	–	–
63	193.492	3,5	170.025	125.025	–	–	–
80	193.492	3,5	170.025	125.230	–	–	–
100	193.492	3,5	170.025	–	MS2189C	–	–
125	193.492	3,5	170.025	–	–	420.200	470.232

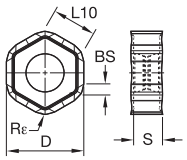
Insert Selection Guide

Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		⟷		toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.E..LD	KCPM40	**.S..GD**	**KCPM40**	.S..HD	KCPM40
P3–P4	.E..LD	KCPK30	**.S..GD**	**KCPK30**	.S..HD	KCPK30
P5–P6	.E..LD	KC725M	**.S..GD**	**KC725M**	.S..HD	KCPK30
M1–M2	.E..LD	KC522M	**.S..GD**	**KCSM40**	.S..HD	KCSM40
M3	.E..LD	KCSM40	**.S..GD**	**KCSM40**	.S..HD	KCPM40
K1–K2	.E..LD	KCK15	**.S..GD**	**KCK15**	.S..HD	KCK15
K3	.E..LD	KC520M	**.S..GD**	**KC520M**	.S..HD	KC520M
N1–N2	.F..LDJ	KC410M	**.F..LDJ**	**KC410M**	.E..LD	KC510M
N3	.F..LDJ	KC410M	**.F..LDJ**	**KC410M**	.E..LD	KC510M
S1–S2	.E..LD	KC725M	**.S..GD**	**KC725M**	.S..HD	KC725M
S3	.E..LD	KCSM40	**.S..GD**	**KCSM40**	.S..HD	KCSM40
S4	.E..LD	KCSM40	**.S..GD**	**KCSM40**	.S..HD	KCSM40
H1	.E..LD	KC510M	**.E..LD**	**KC510M**	.E..LD	KC510M

- First choice for machining aluminium.



HNGJ-LDJ



HNGJ-LDJ

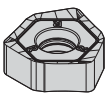
● first choice
○ alternate choice

		K313	KC410M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
P						○	●		●	●	○
M						●	●		●	○	●
K				●	●	○		●	○		
N		●	●	○							
S						●	●				●
H											

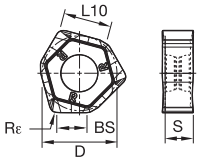
HNGJ-LDJ

catalogue number	D	BS	L10	Rε	S	hm	cutting edges	K313	KC410M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
HNGJ0604ANFNLDJ	12	1,54	6,44	1,0	4,48	0,02	12	●	●	–	–	–	–	–	–	–	–

- Wiper insert for fine finishing aluminium.



Wiper XNGJ *



Wiper XNGJ *

XNGJ-LDJ3W

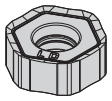
catalogue number	D	BS	L10	Rε	S	hm	cutting edges	K313	KC410M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
XNGJ0604ANFNLDJ3W	12	4,80	7,20	1,6	4,51	0,02	3	–	●	–	–	–	–	–	–	–	–

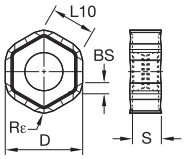
* For wiper insert XNGJ, 3 left-hand (LH) and 3 right-hand (RH) wiper edges per insert.

- First choice for light machining.

● first choice
○ alternate choice

P					○	●		●	●	○	
M					●	●		●	○	●	
K			●	●	○		●	○			
N	●	●	○								
S					●	●					●
H											


HNGJ-LD



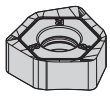
HNGJ-LD

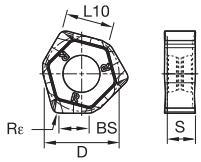
HNGJ-LD

catalogue number	D	BS	L10	Rε	S	hm	cutting edges	K313	KC410M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
HNGJ0604ANENLD	12	1,54	6,44	1,0	4,48	0,04	12	–	–	●	●	●	●	●	●	●	●
HNGJ060432ANENLD	12	–	6,43	3,2	4,48	0,05	12	–	–	–	–	–	●	–	●	–	–

* For wiper insert HNGJ-LD, 3 left-hand (LH) and 3 right-hand (RH) wiper edges per insert.

- Wiper insert for excellent floor finish.


Wiper XNGJ *

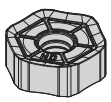


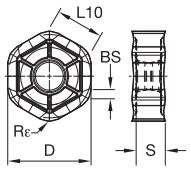
Wiper XNGJ *

XNGJ-LD3W

catalogue number	D	BS	L10	Rε	S	hm	cutting edges	K313	KC410M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
XNGJ0604ANENLD3W	12	4,80	7,20	1,6	4,51	0,05	3	–	–	●	–	●	●	–	–	●	●

* For wiper insert XNGJ, 3 left-hand (LH) and 3 right-hand (RH) wiper edges per insert.


HNGJ-HD

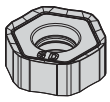


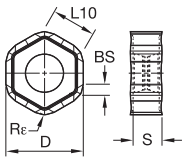
HNGJ-HD

HNGJ-HD

catalogue number	D	BS	L10	Rε	S	hm	cutting edges	K313	KC410M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
HNGJ0604ANSNHD	12	1,45	6,44	1,0	4,40	0,14	12	–	–	–	–	●	–	●	●	●	●

- First choice for general purpose.


HNPJ-GD



HNPJ-GD

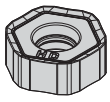
● first choice
○ alternate choice

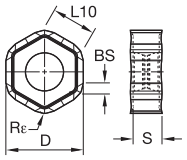
		K313	KC410M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
P					○	●		●	●	○
M					●	●		●	○	●
K				●	●	○		●	○		
N		●	●	○							
S						●	●				●
H											

HNPJ-GD

catalogue number	D	BS	L10	Rε	S	hm	cutting edges	K313	KC410M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
HNPJ0604ANSNGD	12	1,45	6,44	1,0	4,45	0,08	12	–	–	–	●	●	●	●	●	●	●

- First choice for heavy roughing.


HNPJ-HD



HNPJ-HD

HNPJ-HD

catalogue number	D	BS	L10	Rε	S	hm	cutting edges	K313	KC410M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
HNPJ0604ANSNHD	12	1,45	6,44	1,0	4,40	0,14	12	–	–	–	●	●	●	●	●	●	●
HNPJ060432ANSNHD	12	–	6,43	3,2	4,42	0,10	12	–	–	–	–	●	●	●	●	●	●

Recommended Starting Feeds

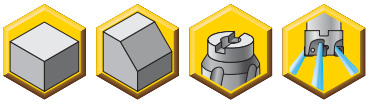
Recommended Starting Feeds [mm]

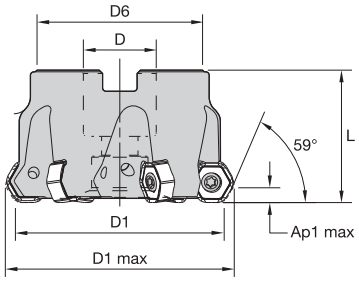
Light Machining	General Purpose	Heavy Machining

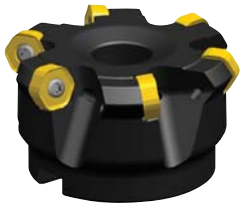
Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.F..LDJ	0,17	**0,46**	0,79	0,12	**0,33**	0,57	0,09	**0,25**	0,43	0,08	**0,22**	0,37	0,07	**0,20**	0,34	.F..LDJ
.E..LD	0,18	**0,59**	0,99	0,13	**0,43**	0,71	0,10	**0,32**	0,53	0,09	**0,28**	0,46	0,08	**0,25**	0,42	.E..LD
.S..GD	0,33	**0,79**	1,19	0,24	**0,57**	0,86	0,18	**0,43**	0,64	0,16	**0,37**	0,56	0,14	**0,34**	0,51	.S..GD
.S..HD	0,33	**0,84**	1,35	0,24	**0,60**	0,97	0,18	**0,45**	0,72	0,16	**0,39**	0,63	0,14	**0,36**	0,57	.S..HD

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

- Twelve cutting edges per insert.
- Higher Ap1 max with standard inserts.
- Productivity booster in all materials.







Dodeka Mini 60° • Shell Mills

order number	catalogue number	D1	D1 max	D	D6	L	Ap1 max	Z	kg	max RPM
4147022	KSHR040A04RS60HN06	40	46,4	22	38	40	4,3	4	0,21	15800
4147713	KSHR040A05RS60HN06	40	46,4	22	38	40	4,3	5	0,21	15800
4147714	KSHR050A04RS60HN06	50	56,4	22	38	40	4,3	4	0,32	12700
4147715	KSHR050A05RS60HN06	50	56,4	22	38	40	4,3	5	0,32	12700
4147716	KSHR063A04RS60HN06	63	69,3	22	50	40	4,3	4	0,57	10100
4147717	KSHR063A06RS60HN06	63	69,3	22	50	40	4,3	6	0,59	10100
4147718	KSHR080A05RS60HN06	80	86,3	27	60	50	4,3	5	1,08	7900
4147719	KSHR080A08RS60HN06	80	86,3	27	60	50	4,3	8	1,15	7900
4147720	KSHR100B06RS60HN06	100	106,3	32	80	50	4,3	6	1,70	6300
4147721	KSHR100B09RS60HN06	100	106,3	32	80	50	4,3	9	1,78	6300
4147722	KSHR125B08RS60HN06	125	131,3	40	90	63	4,3	8	2,92	5050
4147723	KSHR125B12RS60HN06	125	131,3	40	90	63	4,3	12	2,96	5050

Spare Parts



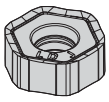
D1	insert screw	Nm	wrench	mounting screw	socket-head cap screw	coolant lock screw assembly	coolant lock screw	coolant shower plate
40	193.492	3,5	170.025	KLSSM22-39-CG	–	–	–	–
50	193.492	3,5	170.025	–	125.025	–	–	–
63	193.492	3,5	170.025	–	125.025	–	–	–
80	193.492	3,5	170.025	–	125.230	–	–	–
100	193.492	3,5	170.025	–	–	MS2189C	–	–
125	193.492	3,5	170.025	–	–	–	420.200	470.232

Insert Selection Guide

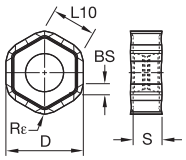
Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		⟷		toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.E..LD	KCPM40	**.S..GD**	**KCPM40**	.S..HD	KCPM40
P3–P4	.E..LD	KCPK30	**.S..GD**	**KCPK30**	.S..HD	KCPK30
P5–P6	.E..LD	KC725M	**.S..GD**	**KC725M**	.S..HD	KCPK30
M1–M2	.E..LD	KC522M	**.S..GD**	**KCSM40**	.S..HD	KCSM40
M3	.E..LD	KCSM40	**.S..GD**	**KCSM40**	.S..HD	KCPM40
K1–K2	.E..LD	KCK15	**.S..GD**	**KCK15**	.S..HD	KCK15
K3	.E..LD	KC520M	**.S..GD**	**KC520M**	.S..HD	KC520M
N1–N2	.F..LDJ	KC410M	**.F..LDJ**	**KC410M**	.E..LD	KC510M
N3	.F..LDJ	KC410M	**.F..LDJ**	**KC410M**	.E..LD	KC510M
S1–S2	.E..LD	KC725M	**.S..GD**	**KC725M**	.S..HD	KC725M
S3	.E..LD	KCSM40	**.S..GD**	**KCSM40**	.S..HD	KCSM40
S4	.E..LD	KCSM40	**.S..GD**	**KCSM40**	.S..HD	KCSM40
H1	.E..LD	KC510M	**.E..LD**	**KC510M**	.E..LD	KC510M

Indexable Inserts

- First choice for machining aluminium.



HNGJ-LDJ



HNGJ-LDJ

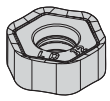
● first choice
○ alternate choice

P						○	●		●	●	○
M						●	●		●	○	●
K				●	●	○		●	○		
N		●	●	○							
S						●	●				●
H											

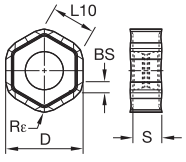
HNGJ-LDJ

catalogue number	D	BS	L10	Rε	S	hm	cutting edges	K313	KC410M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
HNGJ0604ANFNLDJ	12	1,54	6,44	1,0	4,48	0,02	12	●	●	–	–	–	–	–	–	–	–

- First choice for light machining.



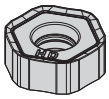
HNGJ-LD

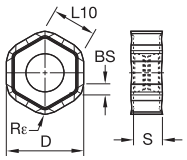


HNGJ-LD

HNGJ-LD

catalogue number	D	BS	L10	Rε	S	hm	cutting edges	K313	KC410M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
HNGJ0604ANENLD	12	1,54	6,44	1,0	4,48	0,04	12	–	–	●	●	●	●	●	●	●	●
HNGJ060432ANENLD	12	–	6,43	3,2	4,48	0,05	12	–	–	–	–	–	●	–	●	–	–


HNGJ-HD



HNGJ-HD

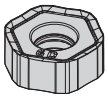
● first choice
○ alternate choice

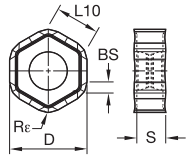
P					○	●		●	●	○			
M						●	●		●	○	●		
K				●	●	○		●	○				
N	●	●	○										
S						●	●				●		
H													

HNGJ-HD

catalogue number	D	BS	L10	Rε	S	hm	cutting edges	K313	KC410M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
HNGJ0604ANSNHD	12	1,45	6,44	1,0	4,40	0,14	12	–	–	–	–	●	–	●	●	●	●

- First choice for general purpose.


HNPJ-GD

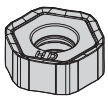


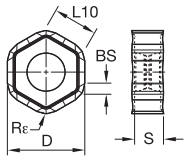
HNPJ-GD

HNPJ-GD

catalogue number	D	BS	L10	Rε	S	hm	cutting edges	K313	KC410M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
HNPJ0604ANSNGD	12	1,45	6,44	1,0	4,45	0,08	12	–	–	–	●	●	●	●	●	●	●

- First choice for heavy roughing.


HNPJ-HD



HNPJ-HD

HNPJ-HD

catalogue number	D	BS	L10	Rε	S	hm	cutting edges	K313	KC410M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
HNPJ0604ANSNHD	12	1,45	6,44	1,0	4,40	0,14	12	–	–	–	●	●	●	●	●	●	●
HNPJ060432ANSNHD	12	–	6,43	3,2	4,42	0,10	12	–	–	–	–	●	●	●	●	●	●

Face Milling

Recommended Starting Feeds

Recommended Starting Feeds [mm]

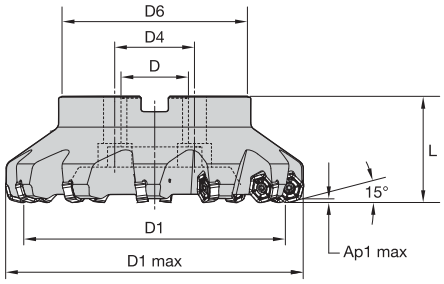
Light Machining	General Purpose	Heavy Machining

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.F..LDJ	0,13	**0,37**	0,64	0,10	**0,27**	0,46	0,07	**0,20**	0,35	0,06	**0,18**	0,30	0,06	**0,16**	0,28	.F..LDJ
.E..LD	0,15	**0,48**	0,81	0,11	**0,35**	0,58	0,08	**0,26**	0,43	0,07	**0,23**	0,38	0,07	**0,21**	0,35	.E..LD
.S..GD	0,27	**0,64**	0,97	0,20	**0,46**	0,70	0,15	**0,35**	0,52	0,13	**0,30**	0,45	0,12	**0,28**	0,42	.S..GD
.S..HD	0,27	**0,68**	1,10	0,20	**0,49**	0,79	0,15	**0,37**	0,59	0,13	**0,32**	0,51	0,12	**0,29**	0,47	.S..HD

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

- High feed rates for rough face milling.
- 2mm depth-of-cut capability.
- Twelve cutting edges per insert.







Dodeka High-Feed 15° • Shell Mills

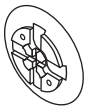
order number	catalogue number	D1	D1 max	D	D4	D6	L	Ap1 max	Z	kg	max RPM
4042332	**KSHRHF50A04RS15HN09**	50	67,9	22	–	38	40	2,2	4	0,41	11400
4042533	**KSHRHF63A05RS15HN09**	63	80,9	22	–	50	40	2,2	5	0,65	8950
4042534	**KSHRHF80A06RS15HN09**	80	97,9	27	–	60	50	2,2	6	1,24	7300
4042535	**KSHRHF100B08RS15HN09**	100	117,9	32	–	80	50	2,2	8	1,89	5900
4042536	**KSHRHF125B09RS15HN09**	125	142,9	40	–	90	63	2,2	9	3,23	4800
4042537	**KSHRHF160C12RS15HN09**	160	177,9	40	67	110	63	2,2	12	5,14	3900

Spare Parts









D1	insert screw	Nm	wrench	socket-head cap screw	coolant lock screw assembly	coolant lock screw	coolant shower plate
50	**193.492**	3,5	**170.025**	**125.025**	–	–	–
63	**193.492**	3,5	**170.025**	**125.025**	–	–	–
80	**193.492**	3,5	**170.025**	**125.230**	–	–	–
100	**193.492**	3,5	**170.025**	–	**MS2189C**	–	–
125	**193.492**	3,5	**170.025**	–	–	**420.200**	**470.232**
160	**193.492**	3,5	**170.025**	–	–	**420.200**	**470.233**

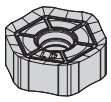
Insert Selection Guide

Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		←	→	toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.E..LD	KCPK30	**.S..GD**	**KCPM40**	.S..HD	KCPM40
P3–P4	.E..LD	KCPK30	**.S..GD**	**KCPK30**	.S..HD	KCPK30
P5–P6	.E..LD	KC725M	**.S..GD**	**KC725M**	.S..HD	KC725M
M1–M2	.E..LD	KCSM40	**.S..GD**	**KCSM40**	.S..HD	KCSM40
M3	.E..LD	KCSM40	**.S..GD**	**KCSM40**	.S..HD	KCSM40
K1–K2	.E..LD	KCK15	**.S..GD**	**KCK15**	.S..HD	KC520M
K3	.E..LD	KC520M	**.S..GD**	**KC520M**	.S..HD	KC520M
N1–N2	.F..LDJ	KC410M	**.F..LDJ**	**KC410M**	.F..LDJ	KC410M
N3	.F..LDJ	KC410M	**.F..LDJ**	**KC410M**	.F..LDJ	KC410M
S1–S2	.E..LD	KC725M	**.S..GD**	**KC725M**	.S..HD	KC725M
S3	.E..LD	KCSM40	**.S..GD**	**KCSM40**	.S..HD	KCSM40
S4	.E..LD	KCSM40	**.S..GD**	**KCSM40**	.S..HD	KCSM40
H1	–	–	–	–	–	KC510M

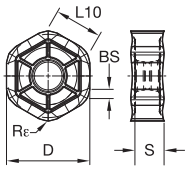
Indexable Inserts

beyond

- First choice for light machining and aluminium.



HNGJ-LD
HNGJ-LDJ



HNGJ-LD
HNGJ-LDJ

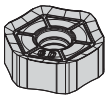
● first choice
○ alternate choice

P			○	●		●	●	○	
M			●	●		●	○	●	
K		●	○		●	○			●
N	●								
S			●	●				●	
H									

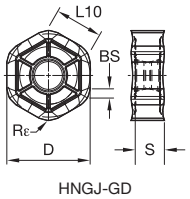
HNGJ-LD and -LDJ

catalogue number	D	BS	L10	Rε	S	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	KY3500
HNGJ0905ANFNLDJ	16	1,80	8,58	1,2	5,56	0,02	12	●	–	–	–	–	–	–	–	–
HNGJ0905ANENLD	16	1,80	8,58	1,2	5,56	0,05	12	–	●	●	●	●	●	–	●	–

- First choice for general purpose.



HNGJ-GD

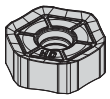


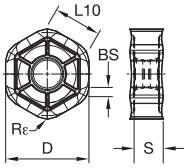
HNGJ-GD

HNGJ-GD

catalogue number	D	BS	L10	Rε	S	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	KY3500
HNGJ0905ANSNGD	16	1,80	8,58	1,2	5,56	0,10	12	–	–	–	●	●	●	●	●	–

- First choice for heavy roughing.


HNGJ-HD



HNGJ-HD

● first choice
○ alternate choice

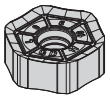
beyond

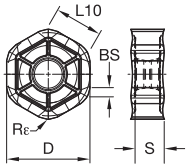
P			○	●		●	●	○	
M			●	●		●	○	●	
K		●	○		●	○			●
N	●								
S			●	●				●	
H									

HNGJ-HD

catalogue number	D	BS	L10	Rε	S	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	KY3500
HNGJ0905ANSNHD	16	1,66	8,59	1,2	5,46	0,17	12	–	●	–	●	●	●	●	●	–
HNGJ090543ANSNHD	16	–	8,50	4,4	5,44	0,20	12	–	●	–	●	●	●	●	●	–

- First choice for general purpose.


HNPJ-GD

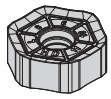


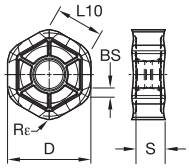
HNPJ-GD

HNPJ-GD

catalogue number	D	BS	L10	Rε	S	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	KY3500
HNPJ0905ANSNGD	16	1,80	8,58	1,2	5,56	0,10	12	–	●	●	●	●	●	●	–	–

- First choice for heavy roughing.


HNPJ-HD



HNPJ-HD

HNPJ-HD

catalogue number	D	BS	L10	Rε	S	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	KY3500
HNPJ0905ANSNHD	16	1,66	8,59	1,2	5,46	0,18	12	–	●	●	●	●	●	●	●	–
HNPJ090543ANSNHD	16	–	8,50	4,3	5,44	0,13	12	–	–	●	●	●	●	●	●	–

Recommended Starting Feeds

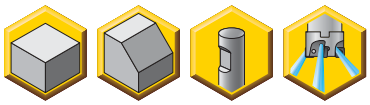
Recommended Starting Feeds [mm]

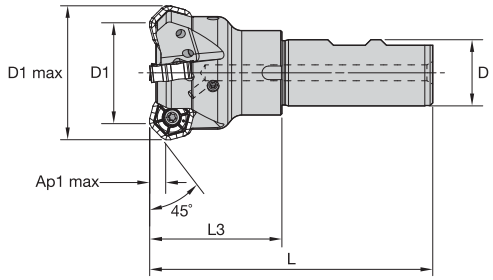
Light Machining	General Purpose	Heavy Machining

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.F..LDJ	0.45	**1.27**	2.22	0.33	**0.91**	1.57	0.25	**0.68**	1.17	0.21	**0.59**	1.01	0.20	**0.54**	0.93	.F..LDJ
.E..LD	0.63	**1.84**	2.81	0.46	**1.31**	1.97	0.34	**0.97**	1.46	0.30	**0.84**	1.27	0.27	**0.77**	1.16	.E..LD
.S..GD	0.92	**2.01**	3.27	0.66	**1.42**	2.29	0.49	**1.06**	1.69	0.43	**0.92**	1.46	0.39	**0.84**	1.34	.S..GD
.S..HD	0.92	**2.35**	3.89	0.66	**1.67**	2.70	0.49	**1.23**	1.98	0.43	**1.07**	1.72	0.39	**0.98**	1.57	.S..HD

NOTE: Use "Light Machining" values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

- Twelve cutting edges per insert.
- Soft cutting action.
- Through tool coolant.







Dodeka 45° • Weldon® End Mills

order number	catalogue number	D1	D1 max	D	L	L3	Ap1 max	Z	kg	max RPM
3324829	**KSHR40D03R50B25SHN09**	40	51,0	25	107	50,00	4,5	3	0,53	15800
3324830	**KSHR40D04R50B25SHN09**	40	51,0	25	107	50,00	4,5	4	0,52	15800

Spare Parts

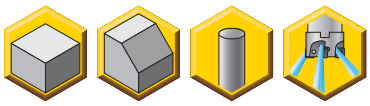


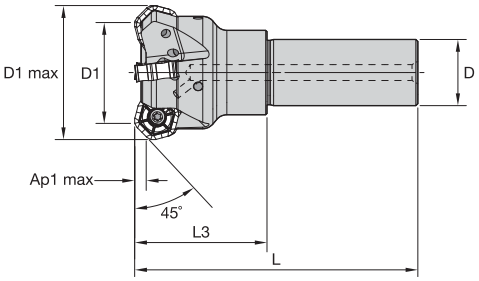




D1	insert screw	Nm	wrench
40	**193.492**	3,5	**170.025**

- Twelve cutting edges per insert.
- Soft cutting action.
- Through tool coolant.







Dodeka 45° • Cylindrical End Mills

order number	catalogue number	D1	D1 max	D	L	L3	Ap1 max	Z	kg	max RPM
3644452	**KSHR40D03R50A25SHN09**	40	51,0	25	107	50	4,5	3	0,53	15800
3645083	**KSHR40D04R50A25SHN09**	40	51,0	25	107	50	4,5	4	0,53	15800

Spare Parts

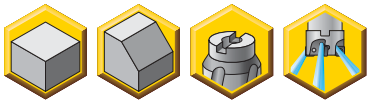




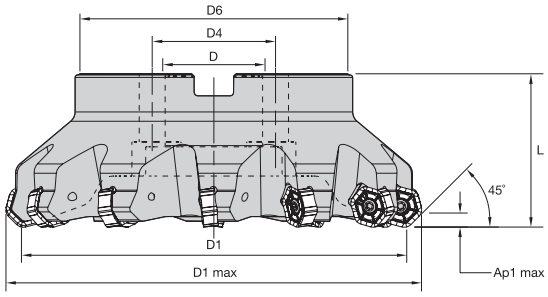


D1	insert screw	Nm	wrench
40	**193.492**	3,5	**170.025**

- Twelve cutting edges per insert.
- Through coolant standard.
- Soft cutting action.







Dodeka 45° • Shell Mills

order number	catalogue number	D1	D1 max	D	D4	D41	D6	L	Ap1 max	Z	kg	max RPM
3647201	KSHR40A04RS45HN09	40	51,0	22	–	–	39	40	4,5	4	0,25	15800
3324831	KSHR50A04RS45HN09	50	61,0	22	–	–	38	40	4,5	4	0,32	12700
3324832	KSHR50A05RS45HN09	50	61,0	22	–	–	38	40	4,5	5	0,33	12700
3749959	KSHR63A05RS45HN09	63	74,0	22	–	–	50	40	4,5	5	0,60	10100
3325163	KSHR63A06RS45HN09	63	74,0	22	–	–	50	40	4,5	6	0,56	10100
3325164	KSHR63A07RS45HN09	63	74,0	22	–	–	50	40	4,5	7	0,57	10100
3749960	KSHR80A05RS45HN09	80	91,0	27	–	–	60	50	4,5	5	1,12	7900
3325165	KSHR80A06RS45HN09	80	91,0	27	–	–	60	50	4,5	6	1,07	7900
3325166	KSHR80A09RS45HN09	80	91,0	27	–	–	60	50	4,5	9	1,11	7900
3749961	KSHR100B06RS45HN09	100	111,0	32	–	–	80	50	4,5	6	1,73	6300
3325167	KSHR100B08RS45HN09	100	111,0	32	–	–	80	50	4,5	8	1,68	6300
3325168	KSHR100B11RS45HN09	100	111,0	32	–	–	80	50	4,5	11	1,73	6300
3749962	KSHR125B08RS45HN09	125	135,9	40	–	–	90	63	4,5	8	2,84	5050
3325169	KSHR125B10RS45HN09	125	135,9	40	–	–	90	63	4,5	10	2,77	5050
3325170	KSHR125B14RS45HN09	125	136,0	40	–	–	90	63	4,5	14	2,86	5050
3750013	KSHR160C10RS45HN09	160	171,0	40	67	–	110	63	4,5	10	4,75	3900
3325171	KSHR160C12RS45HN09	160	171,0	40	67	–	110	63	4,5	12	4,56	3900
3325172	KSHR160C16RS45HN09	160	171,0	40	67	–	110	63	4,5	16	4,70	3900
3587732	KSHR200C16RS45HN09	200	211,0	60	102	–	130	63	4,5	16	6,43	3180
3587753	KSHR250C20RS45HN09	250	261,0	60	102	–	130	63	4,5	20	9,93	2550
3587754	KSHR315C24RS45HN09	315	326,0	60	102	178	230	80	4,5	24	22,90	2020

Spare Parts



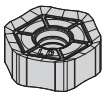
D1	insert screw	Nm	wrench	mounting screw with coolant grooves	low-head cap screw	socket-head cap screw	coolant lock screw assembly	coolant lock screw	coolant shower plate
40	193.492	3,5	170.025	KLSSM22-39-CG	–	–	–	–	–
50	193.492	3,5	170.025	MS2072CG	129.025	–	–	–	–
63	193.492	3,5	170.025	MS1234CG	–	125.025	–	–	–
80	193.492	3,5	170.025	MS2038CG	–	125.230	–	–	–
100	193.492	3,5	170.025	–	–	–	MS2189C	–	–
125	193.492	3,5	170.025	–	–	–	–	420.200	470.232
160	193.492	3,5	170.025	–	–	–	–	420.200	470.233
200	193.492	3,5	170.025	–	–	–	–	–	470.234
250	193.492	3,5	170.025	–	–	–	–	–	470.235
315	193.492	3,5	170.025	–	–	–	–	–	470.236

NOTE: Please order all spare parts separately.

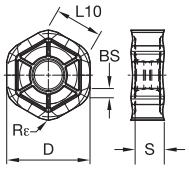
Insert Selection Guide

Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		⟷		toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.E..LD	KCPK30	**.S..GD**	**KCPM40**	.S..HD	KCPM40
P3–P4	.E..LD	KCPK30	**.S..GD**	**KCPK30**	.S..HD	KCPK30
P5–P6	.E..LD	KC725M	**.S..GD**	**KC725M**	.S..HD	KC725M
M1–M2	.E..LD	KCSM40	**.S..GD**	**KCSM40**	.S..HD	KCSM40
M3	.E..LD	KCSM40	**.S..GD**	**KCSM40**	.S..HD	KCSM40
K1–K2	.E..LD	KCK15	**.S..GD**	**KCK15**	.S..HD	KC520M
K3	.E..LD	KC520M	**.S..GD**	**KC520M**	.S..HD	KC520M
N1–N2	.F..LDJ	KC410M	**.F..LDJ**	**KC410M**	.F..LDJ	KC410M
N3	.F..LDJ	KC410M	**.F..LDJ**	**KC410M**	.F..LDJ	KC410M
S1–S2	.E..LD	KC725M	**.S..GD**	**KC725M**	.S..HD	KC725M
S3	.E..LD	KCSM40	**.S..GD**	**KCSM40**	.S..HD	KCSM40
S4	.E..LD	KCSM40	**.S..GD**	**KCSM40**	.S..HD	KCSM40
H1	–	–	**–**	**–**	–	–

- First choice for light machining and aluminium.



HNGJ-LDJ
HNGJ-LD



HNGJ-LDJ
HNGJ-LD

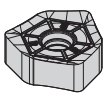
● first choice
○ alternate choice

		KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	KY3500
P				○	●		●	●	○	
M				●	●		●	○	●	
K			●	○		●	○			●
N		●								
S				●	●				●	
H										

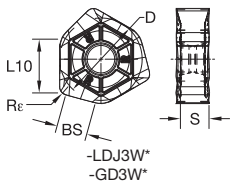
HNGJ-LDJ and -LD

catalogue number	D	BS	L10	Rε	S	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	KY3500
HNGJ0905ANFNLDJ	16	1,80	8,58	1,2	5,56	0,02	12	●	–	–	–	–	–	–	–	–
HNGJ0905ANENLD	16	1,80	8,58	1,2	5,56	0,05	12	–	●	●	●	●	●	–	●	–

- Wiper insert for excellent surface floor finish.



-LDJ3W*
-GD3W*



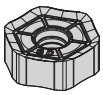
-LDJ3W*
-GD3W*

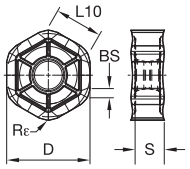
XNGJ-LDJ3W and -GD3W

catalogue number	D	BS	L10	Rε	S	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	KY3500
XNGJ0905ANFNLDJ3W	16	6,00	9,60	1,6	5,51	0,02	3	●	–	–	–	–	–	–	–	–
XNGJ0905ANSNGD3W	16	6,00	9,60	1,6	5,51	0,09	3	–	–	–	●	●	●	–	●	–

*3 left-hand (LH) and 3 right-hand (RH) wiper edges per insert.

- First choice for general purpose.


HNGJ-GD



HNGJ-GD

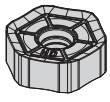
● first choice
○ alternate choice

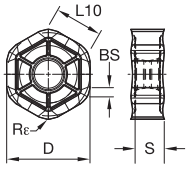
P				○	●		●	●	○	
M				●	●		●	○	●	
K			●	○		●	○			●
N		●								
S				●	●				●	
H										

HNGJ-GD

catalogue number	D	BS	L10	Rε	S	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	KY3500
HNGJ0905ANSNGD	16	1,80	8,58	1,2	5,56	0,10	12	–	–	–	●	●	●	●	●	–

- First choice for heavy roughing.


HNGJ-HD

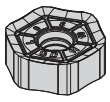


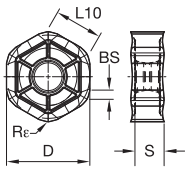
HNGJ-HD

HNGJ-HD

catalogue number	D	BS	L10	Rε	S	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	KY3500
HNGJ0905ANSNHD	16	1,66	8,59	1,2	5,46	0,17	12	–	●	–	●	●	●	●	●	–
HNGJ090543ANSNHD	16	–	8,50	4,4	5,44	0,20	12	–	●	–	●	●	●	●	●	–

- First choice for general purpose.


HNPJ-GD

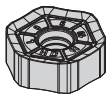


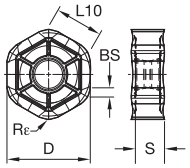
HNPJ-GD

HNPJ-GD

catalogue number	D	BS	L10	Rε	S	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	KY3500
HNPJ0905ANSNGD	16	1,80	8,58	1,2	5,56	0,10	12	–	●	●	●	●	●	●	–	–

- First choice for heavy roughing.


HNPJ-HD



HNPJ-HD

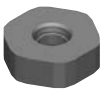
● first choice
○ alternate choice

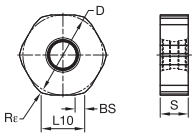
		KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	KY3500
P				○	●		●	●	○	
M				●	●		●	○	●	
K			●	○		●	○			●
N		●								
S				●	●				●	
H										

HNPJ-HD

catalogue number	D	BS	L10	Rε	S	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	KY3500
HNPJ0905ANSNHD	16	1,66	8,59	1,2	5,46	0,18	12	–	●	●	●	●	●	●	●	–
HNPJ090543ANSNHD	16	–	8,50	4,3	5,44	0,13	12	–	–	●	●	●	●	●	●	–

- Ceramic KYON 3500 for machining grey cast iron with high cutting speed.


HNEC-ANSN



HNEC-ANSN

HNEC-ANSN Ceramic Insert

catalogue number	D	BS	L10	Rε	S	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	KY3500
HNEC0905ANSN	16	1,95	9,17	1,2	5,56	0,19	12	–	–	–	–	–	–	–	–	●

Recommended Starting Feeds

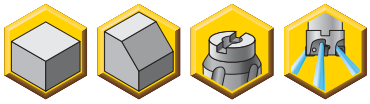
Recommended Starting Feeds [mm]

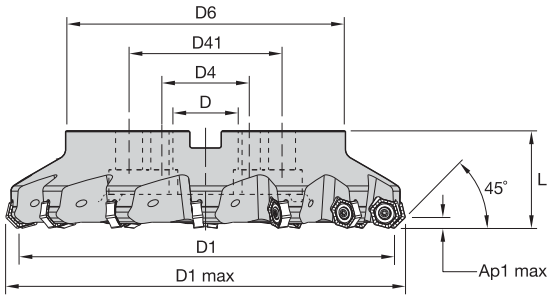
Light Machining	General Purpose	Heavy Machining

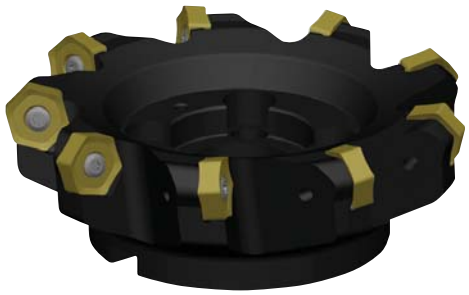
Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.F..LDJ	0,17	**0,46**	0,79	0,12	**0,33**	0,57	0,09	**0,25**	0,43	0,08	**0,22**	0,37	0,07	**0,20**	0,34	.F..LDJ
.E..LD	0,23	**0,66**	0,99	0,17	**0,47**	0,71	0,13	**0,35**	0,53	0,11	**0,31**	0,46	0,10	**0,28**	0,42	.E..LD
.S..GD	0,33	**0,72**	1,15	0,24	**0,52**	0,82	0,18	**0,39**	0,61	0,16	**0,34**	0,54	0,14	**0,31**	0,49	.S..GD
.S..HD	0,33	**0,84**	1,35	0,24	**0,60**	0,97	0,18	**0,45**	0,72	0,16	**0,39**	0,63	0,14	**0,36**	0,57	.S..HD

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

- Twelve cutting edges per insert.
- 25% lower cutting forces.
- Laser-hardened pocket seats.







Dodeka MAX 45° • Shell Mills

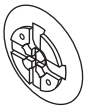
order number	catalogue number	D1	D1 max	D	D4	D41	D6	L	Ap1 max	Z	kg	max RPM
4059463	**KSHR80A04RS45HN13**	80	97,3	27	–	–	60	50	8,0	4	1,26	7900
4060935	**KSHR100B05RS45HN13**	100	117,3	32	–	–	80	50	8,0	5	1,81	6300
4060936	**KSHR125B06RS45HN13**	125	142,3	40	–	–	90	63	8,0	6	3,07	5050
4059485	**KSHR160C09RS45HN13**	160	177,3	40	66,7	–	110	63	8,0	9	4,34	3900
4060912	**KSHR200C10RS45HN13**	200	217,3	60	101,6	–	130	63	8,0	10	6,41	3180
4060937	**KSHR200C12RS45HN13**	200	217,3	60	101,6	–	130	63	8,0	12	6,48	3180
4060933	**KSHR250C12RS45HN13**	250	267,3	60	101,6	–	130	63	8,0	12	10,30	2550
4060938	**KSHR250C14RS45HN13**	250	267,3	60	101,6	–	130	63	8,0	14	10,27	2550
4060934	**KSHR315C14RS45HN13**	315	332,3	60	101,6	177,8	230	80	8,0	14	24,04	2020
4059486	**KSHR315C18RS45HN13**	315	332,3	60	101,6	177,8	230	80	8,0	18	24,62	2020

Spare Parts









D1	insert screw	Nm	Torx Plus wrench	socket-head cap screw	coolant lock screw assembly	coolant lock screw	coolant shower plate
80	**193.531**	8,0	**TTP25**	**125.230**	**–**	**–**	**–**
100	**193.531**	8,0	**TTP25**	**–**	**MS2189C**	**–**	**–**
125	**193.531**	8,0	**TTP25**	**–**	**–**	**420.200**	**470.232**
160	**193.531**	8,0	**TTP25**	**–**	**–**	**420.200**	**470.233**
200	**193.531**	8,0	**TTP25**	**–**	**–**	**–**	**470.234**
250	**193.531**	8,0	**TTP25**	**–**	**–**	**–**	**470.235**
315	**193.531**	8,0	**TTP25**	**–**	**–**	**–**	**470.236**

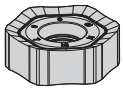
NOTE: Adjustable torque wrench (order number 6197561) and Torx Plus bit (order number 6205892 BTQTP25L90) may be purchased separately in order to ensure proper torque setting.

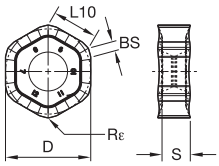
Insert Selection Guide

Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		←	→	toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.E..GD	KCPM40	**.S..GD**	**KCPK30**	.S..HD	KCPM40
P3–P4	.E..GD	KCPK30	**.S..GD**	**KCPK30**	.S..HD	KCPK30
P5–P6	.E..GD	KC725M	**.S..GD**	**KC725M**	.S..HD	KC725M
M1–M2	.E..GD	KC725M	**.S..GD**	**KC725M**	.S..HD	KCSM40
M3	.E..GD	KCPM40	**.S..GD**	**KC725M**	.S..HD	KCSM40
K1–K2	.E..GD	KCK15	**.S..GD**	**KCK15**	.S..HD	KCK15
K3	.E..GD	KCK15	**.S..GD**	**KC520M**	.S..HD	KC725M
N1–N2	–	–	**–**	**–**	–	–
N3	–	–	**–**	**–**	–	–
S1–S2	.E..GD	KC725M	**.S..GD**	**KC725M**	.S..HD	KCSM40
S3	.E..GD	KCPM40	**.S..GD**	**KC725M**	.S..HD	KCSM40
S4	.E..GD	KC725M	**.S..GD**	**KC725M**	.S..HD	KCSM40
H1	–	–	**–**	**–**	–	–

Indexable Inserts

- First choice for light machining.


HNGJ-GD



HNGJ-GD

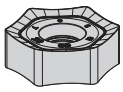
● first choice
○ alternate choice

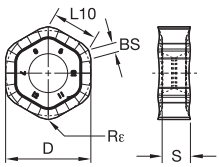
P			●		●	●	○
M			●		○	○	●
K	●		●		●		
N							
S			●				●
H							

HNGJ-GD

catalogue number	D	BS	L10	Rε	S	hm	cutting edges	KC520M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
HNGJ1307ANENGD	22	1,88	12,83	1,2	7,41	0,05	12	–	●	–	●	●	–

- First choice for general purpose.


HNPJ-GD

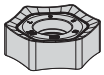


HNPJ-GD

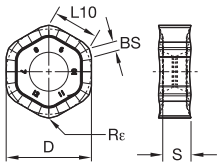
HNPJ-GD

catalogue number	D	L10	Rε	S	hm	cutting edges	KC520M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
HNPJ130720ANSNGD	22	12,83	2,0	7,53	0,13	12	●	●	–	●	–	–

- First choice for heavy roughing.



HNPJ-HD



HNPJ-HD

● first choice
○ alternate choice

P			●		●	●	○
M			●		○	○	●
K	●		●	●	●		
N							
S			●				●
H							

HNPJ-HD

catalogue number	D	BS	L10	Rε	S	hm	cutting edges	KC520M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
HNPJ1307ANSNHD	22	1,88	12,83	1,2	7,31	0,25	12	–	●	●	●	●	●
HNPJ130720ANSNHD	22	–	12,83	2,0	7,42	0,23	12	–	●	–	●	●	–
HNPJ130735ANSNHD	22	–	12,83	3,5	7,33	0,23	12	●	–	●	●	–	–

Recommended Starting Feeds

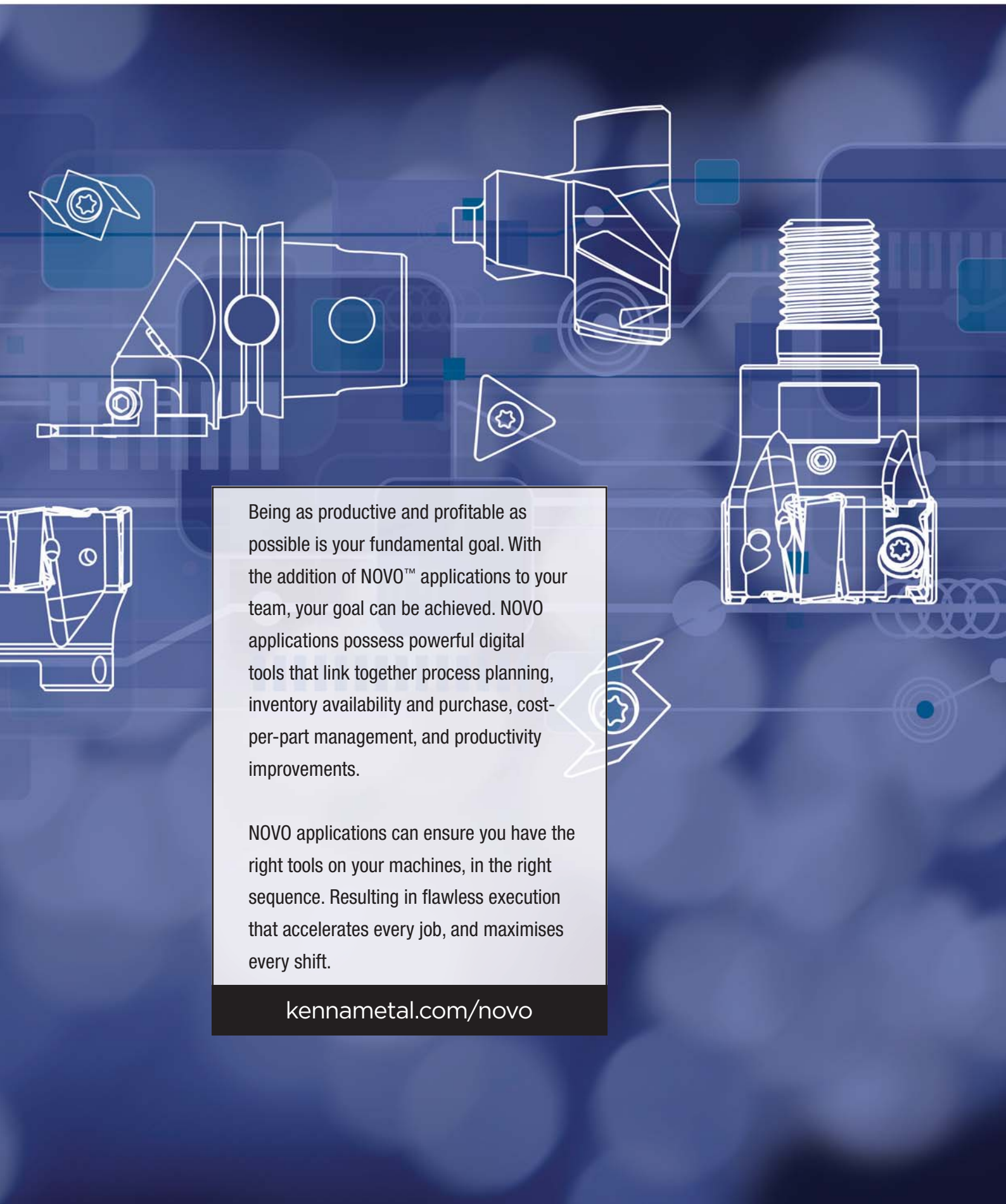
Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.E..GD	0,23	**0,66**	1,16	0,17	**0,47**	0,83	0,13	**0,35**	0,62	0,11	**0,31**	0,54	0,10	**0,28**	0,49	.E..GD
.S..GD	0,33	**0,74**	1,27	0,24	**0,53**	0,91	0,18	**0,40**	0,68	0,16	**0,35**	0,59	0,14	**0,32**	0,54	.S..GD
.S..HD	0,33	**0,84**	1,35	0,24	**0,60**	0,97	0,18	**0,45**	0,72	0,16	**0,39**	0,63	0,14	**0,36**	0,57	.S..HD

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

NOVO KNOWS
ART TO PART TO PROFIT



Being as productive and profitable as possible is your fundamental goal. With the addition of NOVO™ applications to your team, your goal can be achieved. NOVO applications possess powerful digital tools that link together process planning, inventory availability and purchase, cost-per-part management, and productivity improvements.

NOVO applications can ensure you have the right tools on your machines, in the right sequence. Resulting in flawless execution that accelerates every job, and maximises every shift.

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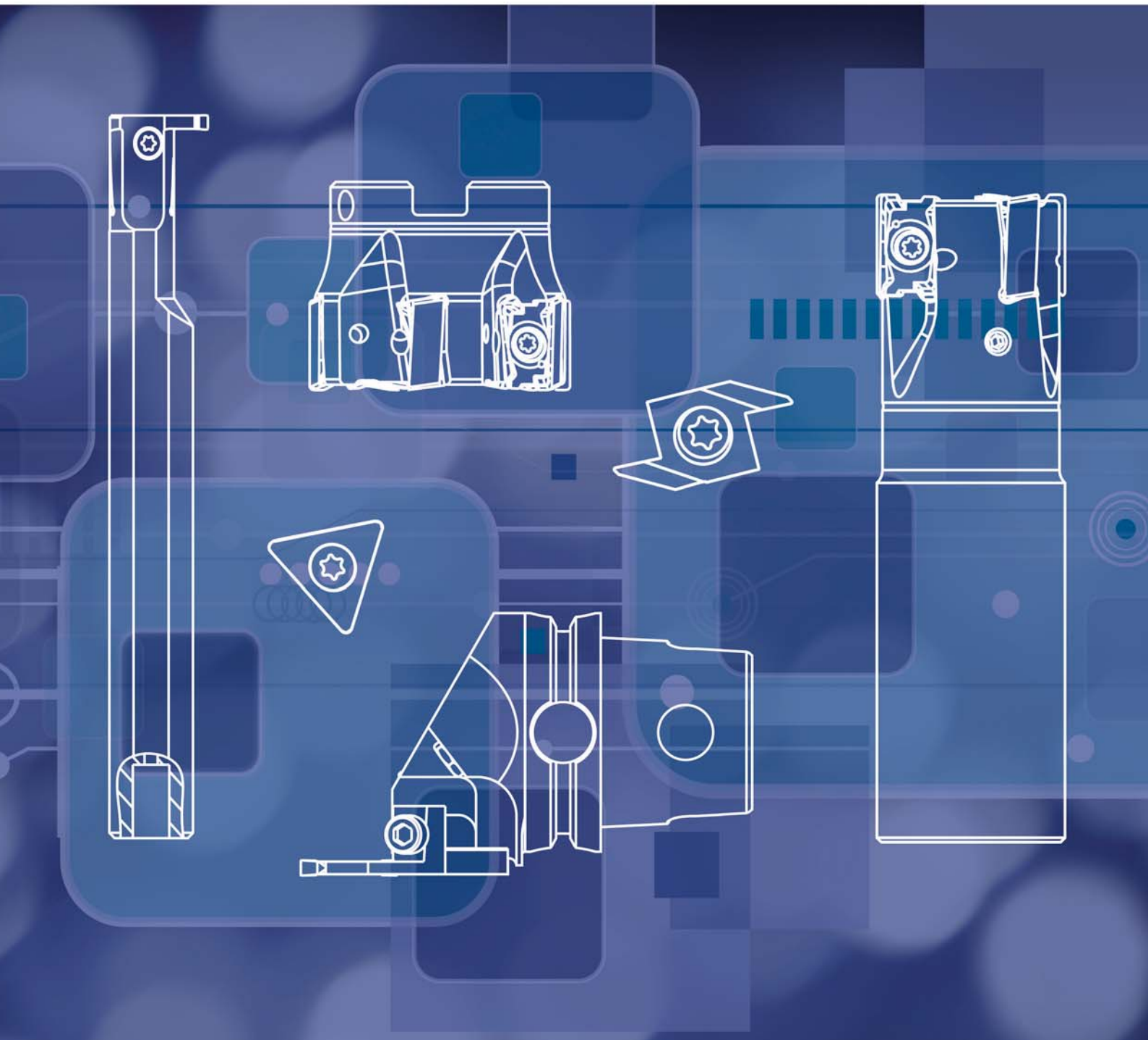

01

THE DIGITAL SOURCE FOR DELIVERING
SMART MACHINING SOLUTIONS

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NOVO™

Mill 16™

Face Mills for Cast Iron Machining.



Screw-On Clamping



Wedge Clamping

Features

- 16 effective cutting edges per insert.
- Ap1 max = 5,5mm.
- Coarse, medium and fine pitch cutters.
- Cutter bodies with pocket seat numbering system.
- Cutter diameter range = 50–250mm.
- High-precision periphery ground inserts.
- Inserts with cutting edge numbering system.
- Lower cutting forces.
- Clearance on second main cutting edge.

Benefits

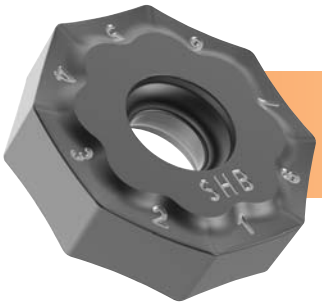
- Low cost per edge to cut cost per part (CPP).
- Perfect fit for most cast iron face milling requirements.
- High feed rates to boost productivity and reduce cycle time.
- Comprehensive standard offering to address most needs of the shop floor.
- Improved axial runout and tool life.
- Very smooth cutting action and lower cutting forces.
- Orientated edge positioning to support axial and radial runout.
- Reliable cutting above Ap1 = 5,5mm addresses castings with varying skin thickness.

Primary Application

The new Mill 16™ series is a specially-made platform for rough milling of components like engine heads and blocks, housings and gear boxes in cast iron materials (CGI, DCI, GCI), and all other cast iron face milling jobs. Best-in-class for machining CGI materials.

Split Case Design

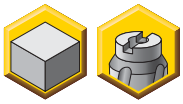


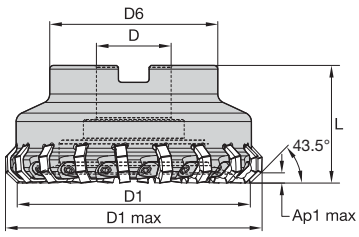


Innovative insert design to reduce cutting forces and increase productivity at lower cost per edge.

- Semi-finishing and light machining
- Medium roughing
- Heavy roughing

- Productivity booster for machining cast iron materials.
- Insert with 16 cutting edges.







Mill 16 • Shell Mills • Wedge Clamping

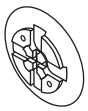
order number	catalogue number	D1	D1 max	D	D6	L	Ap1 max	Z	kg	max RPM
6001972	**MILL16D050Z05ON08W**	50	63	22	50	50	5,5	5	0,61	11300
6001973	**MILL16D063Z06ON08W**	63	76	22	50	50	5,5	6	0,86	9400
6134054	**MILL16D080Z08ON08W**	80	93	27	60	50	5,5	8	1,27	7900
6001974	**MILL16D080Z10ON08W**	80	93	27	60	50	5,5	10	1,18	7900
6134055	**MILL16D100Z10ON08W**	100	113	32	80	50	5,5	10	1,84	6900
6001975	**MILL16D100Z14ON08W**	100	113	32	80	50	5,5	14	1,76	6900
6134056	**MILL16D125Z14ON08W**	125	138	40	90	63	5,5	14	3,26	6000
6001976	**MILL16D125Z18ON08W**	125	138	40	90	63	5,5	18	3,18	6000
6134057	**MILL16D160Z16ON08W**	160	173	40	90	63	5,5	16	4,22	5200
6001977	**MILL16D160Z22ON08W**	160	173	40	90	63	5,5	22	4,11	5200
6134058	**MILL16D200Z20ON08W**	200	213	60	140	63	5,5	20	7,13	4600
6001978	**MILL16D200Z28ON08W**	200	213	60	140	63	5,5	28	6,99	4600
6134059	**MILL16D250Z24ON08W**	250	263	60	140	63	5,5	24	10,70	4000
6017625	**MILL16D250Z34ON08W**	250	263	60	140	63	5,5	34	10,52	4000

Spare Parts







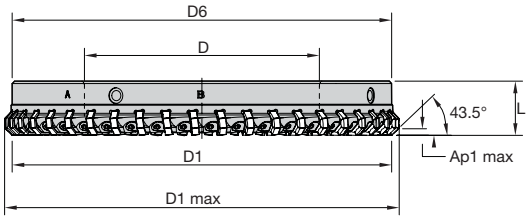





D1	wedge	wedge screw	Nm	wrench	socket-head cap screw with coolant groove	socket-head cap screw with coolant groove	coolant lock screw	coolant shower plate	adjustable torque wrench	bit SW3 for adjustable torque wrench
50	**CW16**	**12748601000**	7,0	**12148044900**	**KLSSM22-39-CG**	**–**	**–**	**–**	**DTQ50140**	**BTQSW3L90**
63	**CW16**	**12748601000**	7,0	**12148044900**	**–**	**MS1242**	**–**	**–**	**DTQ50140**	**BTQSW3L90**
80	**CW16**	**12748601000**	7,0	**12148044900**	**–**	**–**	**–**	**–**	**DTQ50140**	**BTQSW3L90**
100	**CW16**	**12748601000**	7,0	**12148044900**	**–**	**–**	**420.160**	**–**	**DTQ50140**	**BTQSW3L90**
125	**CW16**	**12748601000**	7,0	**12148044900**	**–**	**–**	**420.200**	**470.232**	**DTQ50140**	**BTQSW3L90**
160	**CW16**	**12748601000**	7,0	**12148044900**	**–**	**–**	**420.200**	**470.233**	**DTQ50140**	**BTQSW3L90**
200	**CW16**	**12748601000**	7,0	**12148044900**	**–**	**–**	**–**	**–**	**DTQ50140**	**BTQSW3L90**
250	**CW16**	**12748601000**	7,0	**12148044900**	**–**	**–**	**–**	**–**	**DTQ50140**	**BTQSW3L90**

NOTE: Adjustable torque wrench (order number 6197561) and 3mm hex bit (order number 6205876) may be purchased separately in order to ensure proper torque setting.

- Productivity booster for machining cast iron materials.
- Insert with 16 cutting edges.





Mill 16 • Split Case Design

order number	catalogue number	D1	D1 max	D	D6	L	Ap1 max	Z	kg	max RPM
6152227	MILL16D315Z44ON08WSC *	315	327,6	195	315	45	5,5	44	11,65	3600
6152228	MILL16D355Z48ON08WSC *	355	367,6	230	355	45	5,5	48	13,96	3300
6152229	MILL16D400Z56ON08WSC *	400	412,6	280	400	45	5,5	56	15,62	3100
6152230	MILL16D500Z70ON08WSC *	500	512,6	380	500	45	5,5	70	20,37	2800

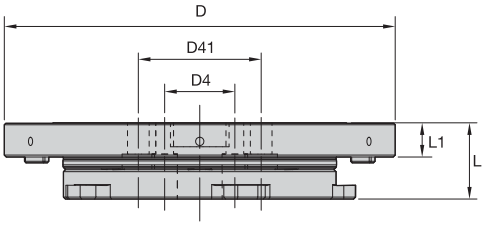
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Spare Parts



D1	wedge	wedge screw	Nm	wrench	adjustable torque wrench	bit SW3 for adjustable torque wrench
315	CW16	12748601000	7,000	12148044900	DTQ50140	BTQSW3L90
355	CW16	12748601000	7,000	12148044900	DTQ50140	BTQSW3L90
400	CW16	12748601000	7,000	12148044900	DTQ50140	BTQSW3L90
500	CW16	12748601000	7,000	12148044900	DTQ50140	BTQSW3L90

NOTE: Adjustable torque wrench (order number 6197561) and 3mm hex bit (order number 6205876) may be purchased separately in order to ensure proper torque setting.





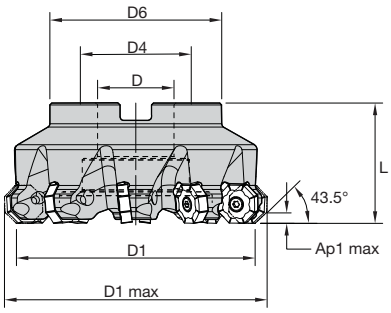
Carrier Flange Assembly

order number	catalogue number	D	D4	D41	L1	L	kg
6152251	D315CFA *	315	102	178	34	78	26,89
6152252	D355CFA *	355	102	178	35	78	37,18
6152253	D400CFA *	400	102	178	35	78	50,95
6152254	D500CFA *	500	102	178	35	78	87,34

NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

- Productivity booster for machining cast iron materials.
- Insert with 16 cutting edges.







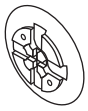
Mill 16 • Screw-On Clamping

order number	catalogue number	D1	D1 max	D	D4	D6	L	Ap1 max	Z	kg	max RPM
6159024	MILL16D050Z04ON08SC	50	62,7	22	–	50	40	5,5	4	0,37	14700
6159025	MILL16D063Z04ON08SC	63	75,0	22	–	50	40	5,5	4	0,55	12200
6159026	MILL16D063Z05ON08SC	63	75,0	22	–	50	40	5,5	5	0,52	12200
6159027	MILL16D080Z05ON08SC	80	92,0	27	–	60	50	5,5	5	1,26	10400
6159028	MILL16D080Z07ON08SC	80	92,0	27	–	60	50	5,5	7	1,23	10400
6159029	MILL16D100Z06ON08SC	100	112,0	32	–	80	50	5,5	6	1,75	9000
6159030	MILL16D100Z08ON08SC	100	112,0	32	–	80	50	5,5	8	1,66	9000
6159061	MILL16D125Z08ON08SC	125	137,0	40	–	90	63	5,5	8	3,20	7800
6159062	MILL16D125Z10ON08SC	125	137,0	40	–	90	63	5,5	10	3,17	7800
6159063	MILL16D160Z10ON08SC	160	172,0	40	67	90	63	5,5	10	4,04	6800
6159064	MILL16D160Z12ON08SC	160	172,0	40	67	90	63	5,5	12	4,10	6800
6159065	MILL16D200Z10ON08SC	200	212,0	60	102	130	63	5,5	10	6,68	6000
6159066	MILL16D200Z14ON08SC	200	212,0	60	102	130	63	5,5	14	6,85	6000
6159067	MILL16D250Z12ON08SC	250	262,0	60	102	130	63	5,5	12	10,94	5300
6159068	MILL16D250Z16ON08SC	250	262,0	60	102	130	63	5,5	16	11,17	5300

Spare Parts





D1	insert screw	Nm	socket-head cap screw	socket-head cap screw with coolant groove	coolant lock screw	coolant shower plate
50	MS2060	4,5	–	KLSSM22-39-CG	–	–
63	MS2060	4,5	–	–	–	–
80	MS2060	4,5	125.230	–	–	–
100	MS2060	4,5	–	–	420.160	–
125	MS2060	4,5	–	–	420.200	470.232
160	MS2060	4,5	–	–	420.200	470.233
200	MS2060	4,5	–	–	–	470.234
250	MS2060	4,5	–	–	–	470.235

Insert Selection Guide

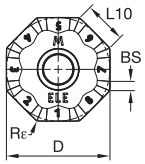
Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		⟷		toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	–	–	–	–	–	–
P3–P4	–	–	–	–	–	–
P5–P6	–	–	–	–	–	–
M1–M2	–	–	–	–	–	–
M3	–	–	–	–	–	–
K1–K2	.E..LE	KC514M	.S..GP	KC514M	.S..HB	KC514M
K3	.E..LE	KCK20	.S..GP	KCK20	.S..HB	KCK15
N1–N2	–	–	–	–	–	–
N3	–	–	–	–	–	–
S1–S2	–	–	–	–	–	–
S3	–	–	–	–	–	–
S4	–	–	–	–	–	–
H1	–	–	–	–	–	–

- ...ANENLE = semi-finishing with improved surface floor finish.
- ...ENLE = light machining.

● first choice
○ alternate choice

P						
M						
K	●	●	●	●	●	
N						
S						
H						


ONGX08-LE



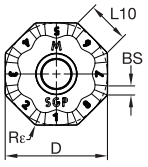
ONGX08-LE

ONGX-LE • High-Precision Periphery Ground

catalogue number	D	S	L10	BS	Rε	hm	KC514M	KCK15	KCK20	KCPK30	KY3500
ONGX080620ENLE	20,00	5,81	8,28	—	2,0	0,05	●	●	●	–	–
ONGX0806ANENLE	20,00	5,81	8,21	1,50	0,8	0,05	●	●	●	–	–

- ...ANSNGP = medium roughing with improved surface floor finish.
- ...SNGP = medium roughing with low cutting forces.


ONGX08-GP



ONGX08-GP

ONGX-GP • High-Precision Periphery Ground

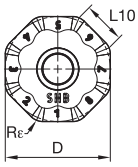
catalogue number	D	S	L10	BS	Rε	hm	KC514M	KCK15	KCK20	KCPK30	KY3500
ONGX080620SNGP	20,00	5,81	8,28	—	2,0	0,16	●	●	●	●	–
ONGX0806ANSNGP	20,00	5,81	8,21	1,50	0,8	0,16	●	●	●	–	–

- First choice for heavy roughing.

● first choice
○ alternate choice

P						
M						
K	●	●	●	●	●	
N						
S						
H						


ONGX08-HB



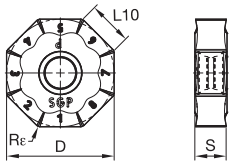
ONGX08-HB

ONGX-HB • High-Precision Periphery Ground

catalogue number	D	S	L10	BS	Rε	hm	KC514M	KCK15	KCK20	KCPK30	KY3500
ONGX080608SNHB	20,00	5,81	8,28	–	0,8	0,18	●	●	–	–	–
ONGX080620SNHB	20,00	5,81	8,28	–	2,0	0,18	●	●	●	●	–
ONGX080630SNHB	20,00	5,81	8,28	–	3,0	0,18	●	●	●	–	–

- Medium roughing with lower cutting forces.


ONPX08-GP



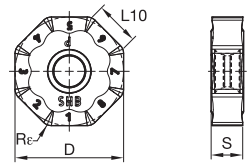
ONPX08-GP

ONPX-GP • Precision Pressed and Sintered to Size

catalogue number	D	S	L10	BS	Rε	hm	KC514M	KCK15	KCK20	KCPK30	KY3500
ONPX080608SNGP	20,00	5,81	8,28	–	0,8	0,16	–	●	●	●	–

- Heavy roughing with regular performance.


ONPX08-HB



ONPX08-HB

ONPX-HB • Precision Pressed and Sintered to Size

catalogue number	D	S	L10	BS	Rε	hm	KC514M	KCK15	KCK20	KCPK30	KY3500
ONPX080620SNHB	20,00	5,81	8,28	–	2,0	0,18	–	●	●	●	–

Recommended Starting Feeds

Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.E..LE	0,23	**0,66**	1,16	0,17	**0,47**	0,83	0,13	**0,35**	0,62	0,11	**0,31**	0,54	0,10	**0,28**	0,49	.E..LE
.S..GP	0,33	**0,74**	1,26	0,24	**0,53**	0,90	0,18	**0,40**	0,67	0,16	**0,35**	0,59	0,14	**0,32**	0,54	.S..GP
.S..HB	0,33	**0,84**	1,35	0,24	**0,60**	0,97	0,18	**0,45**	0,72	0,16	**0,39**	0,63	0,14	**0,36**	0,57	.S..HB

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

User Information

- Only use with indexable inserts ONPX0806**/ONGX0806** (ONPX64**/ONGX64**).
- Only use original Kennametal spare parts as per the current catalogue.

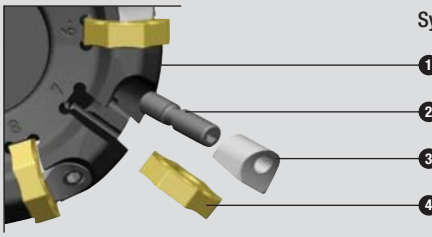


- Maintenance and repair of cutters should only be carried out by Kennametal.
- The tools must only be used in combination with suitable tool adaptors and machine spindles.
- Use only the recommended torque settings when assembling the cutters for use. For further information contact the KMT CAS Team.

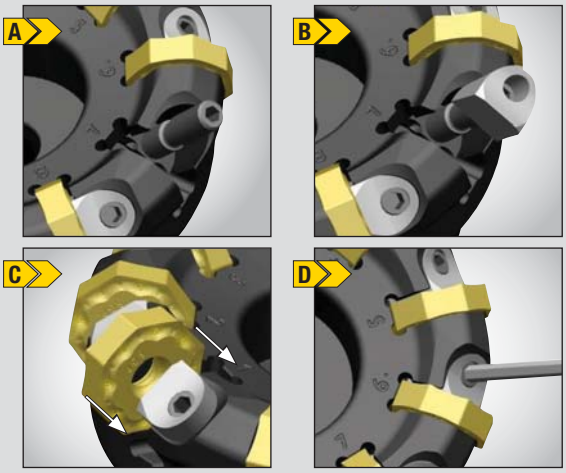
* These assembly instructions relate only to the Kennametal Mill 16 Face Mill family and not to its connection to a spindle or spindle adaptor.

Preparation

- Prior to use, ensure the cutter is thoroughly cleaned and remove all dirt, grease, and anti-corrosive protection.
- Carefully grease the differential screws with copper grease. Ensure the rest of the cutter is clean.
- When loading the inserts into the cutter, please ensure that they are inserted in the clean pocket seat in the correct position.
- Mounting position: The flat side of the clamping wedge sits on top of the insert face. We recommend to mount the inserts by following the insert's edge numbering system for orientated insert seating. Active cutting edges shall all have the same cutting edge number.



Insert Clamping and Adjusting



Pre-setting of Inserts

A. Screw the differential screw (2) into the cutter body (1) by approximately 2 turns using a 3mm hex wrench.

B. Place wedge (3) on differential screw (2) and fasten into the cutter body.

C. Push insert (4) into the pocket seat by hand in the direction shown.

D. Clamp insert (4) with wedge (3) by rotating the differential screw with a clamping force of MA = 2 Nm (18 in/lbs). The differential screw must not stick out of wedge.

E. Repeat steps A–D for all inserts.

Tightening the Inserts

F. Tighten all inserts of the pockets with the wedge using the differential screw with a clamping torque of MA = 7 Nm (62 in/lbs).

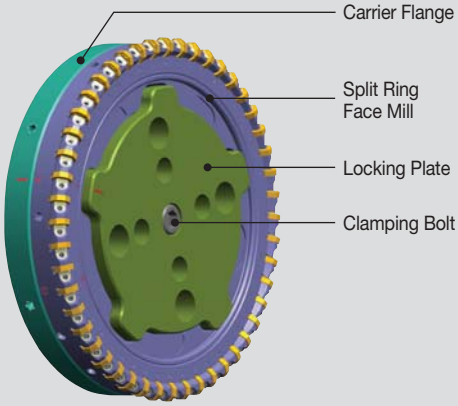
Split Cutter Assembly Instructions

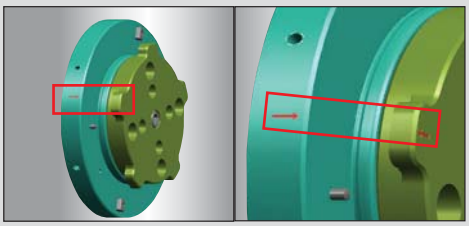
Please read and follow the instructions below for safe and productive application.

User Information

These assembly instructions relate only to Kennametal split-case milling cutters and not to its connection to a spindle or spindle adaptor.

System Components

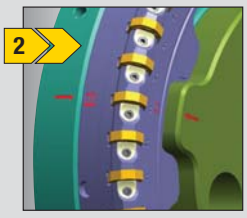




Initial position must be in such a way that the arrows in the carrier flange and locking plate coincide with each other.



Place the split ring face mill over the carrier flange in such a way that arrows in the locking plate and carrier flange coincide with the marking "A" in the cutter.



Turn the cutter ring clockwise from marking "A" to marking "B".



Tighten the clamping bolt with a torque of 100 Nm.

Extended Kennametal Service

Adjustable Torque Wrenches

When working with inserts, it is especially important to use the correct torque. Kennametal offers extended service levels by assuring best tightening with adjustable torque wrenches. Please order separately as needed.

Adjustable torque wrenches • 0,6–5,4 Nm (5.3–47.8 in. lbs)



3641463



3641464

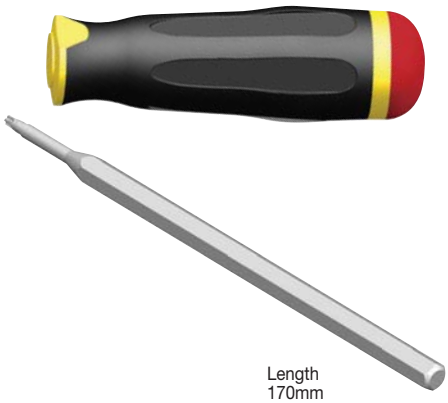


3641465

Order Number	ANSI/ISO Catalogue Number	Description	Nm range	in. lbs range
3641463	**DTQ0615**	Torque control wrench handle	0,7–1,5 Nm	5.4–13.3
3641464	**DTQ1530**	Torque control wrench handle	1,6–3,0 Nm	13.4–26.6
3641465	**DTQ3054**	Torque control wrench handle	3,1–5,4 Nm	26.7–47.8

Blades

Order Number	Description	Drive	Max Torque
3641466	Blade Screw Driver TORX	BTQT6	0,8 Nm
3641467	Blade Screw Driver TORX	BTQT7	1,4 Nm
3641468	Blade Screw Driver TORX	BTQT8	2,4 Nm
3641469	Blade Screw Driver TORX	BTQT9	3,3 Nm
3641470	Blade Screw Driver TORX	BTQT10	4,0 Nm
3641471	Blade Screw Driver TORX	BTQT15	7,0 Nm
3641472	Blade Screw Driver TORX	BTQT20	10,5 Nm
3641473	Blade Screw Driver TORX	BTQT25	20,0 Nm
3641474	Blade Screw Driver TORX PLUS	BTQ6IP	0,9 Nm
3641475	Blade Screw Driver TORX PLUS	BTQ7IP	1,7 Nm
3641476	Blade Screw Driver TORX PLUS	BTQ8IP	2,8 Nm
3641477	Blade Screw Driver TORX PLUS	BTQ9IP	3,6 Nm
3641478	Blade Screw Driver TORX PLUS	BTQ10IP	5,0 Nm



Length 170mm (6.693")

Adjustable torque wrenches • 5–14 Nm (3.7–10.3 in. lbs)

Order Number	ANSI/ISO Catalogue Number	Description
6197561	**DTQ50140**	Torque Wrench Handle 5–14Nm + bitholder
6205876	**BTQSW3L90**	Bit SW3 L=90mm
6205877	**BTQT15L90**	Bit Torx 15 L=90mm
6205878	**BTQT20L90**	Bit Torx 20 L=90mm
6205879	**BTQT25L90**	Bit Torx 25 L=90mm
6205880	**BTQTP15L90**	Bit Torx Plus 15 L=90mm
6205891	**BTQTP20L90**	Bit Torx Plus 20 L=90mm
6205892	**BTQTP25L90**	Bit Torx Plus 25 L=90mm



NOTE: For a complete overview of our screw drivers, bits, torque wrenches, and bit drivers, see pages X2–X3.

Experience the advantages at your Authorised Kennametal Distributor or at **kennametal.com**.

KENNAMETAL®

kennametal.com

KSSM™ 45°

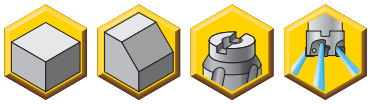
Universal face mill for conventional machining.

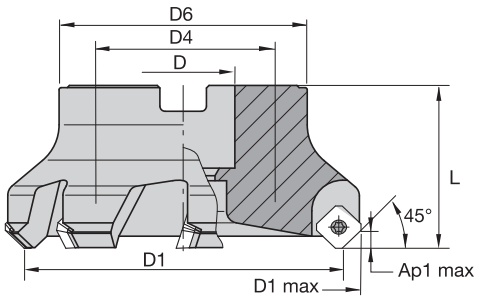


Features and Benefits

- Insert SE.T1404.
- Ap1 max = 6,6mm.
- Four true cutting edges.
- Pocket seat protection with carbide shims.
- Easy handling and rapid insert change.

- Rapid insert changes.
- Carbide shims for pocket protection.







KSSM 45° • Shell Mills

order number	catalogue number	D1	D1 max	D	D4	D6	L	Ap1 max	Z	kg	max RPM
1926850	**40A03RS45SE14EG**	40	54,0	16	–	44	40	6,6	3	0,30	26000
1926812	**50A03RS45SE14EG**	50	63,9	22	–	50	40	6,6	3	0,40	22500
1926900	**50A04RS45SE14EG**	50	63,9	22	–	50	40	6,6	4	0,40	22500
1926899	**63A04RS45SE14EG**	63	76,8	22	–	50	40	6,6	4	0,50	20200
1926897	**63A05RS45SE14EG**	63	76,8	22	–	50	40	6,6	5	0,60	20200
1926894	**80A05RS45SE14EG**	80	93,8	27	–	60	50	6,6	5	1,10	18000
1926893	**80A06RS45SE14EG**	80	93,8	27	–	60	50	6,6	6	1,20	18000
1926926	**100B05RS45SE14EG**	100	113,7	32	–	80	50	6,6	5	1,70	16000
1926925	**100B07RS45SE14EG**	100	113,7	32	–	80	50	6,6	7	1,80	16000
1926924	**125B06RS45SE14EG**	125	138,7	40	–	90	63	6,6	6	2,90	14400
1926911	**125B08RS45SE14EG**	125	138,7	40	–	90	63	6,6	8	3,00	14400
1926909	**160C07RS45SE14EG**	160	173,6	40	67	100	63	6,6	7	4,10	12500
1926908	**160C10RS45SE14EG**	160	173,6	40	67	100	63	6,6	10	4,30	12500

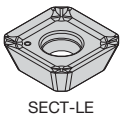
Spare Parts

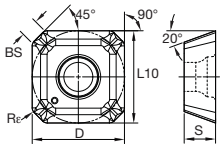
D1	insert screw	Nm	Torx Plus driver	shim	shim screw	hex driver	low-head cap screw	socket-head cap screw
40	**MS2078**	4,0	**DT15IP**	–	–	–	**MS2040**	–
50	**MS2078**	4,0	**DT15IP**	–	–	–	**129.025**	–
63	**MS2078**	4,0	**DT15IP**	–	–	–	**129.025**	–
80	**MS2078**	4,0	**DT15IP**	**SM455**	**SRS3**	**DH35M**	–	**MS2038**
100	**MS2078**	4,0	**DT15IP**	**SM455**	**SRS3**	**DH35M**	–	–
125	**MS2078**	4,0	**DT15IP**	**SM455**	**SRS3**	**DH35M**	–	–
160	**MS2078**	4,0	**DT15IP**	**SM455**	**SRS3**	**DH35M**	–	–

Insert Selection Guide

Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		◄——►		toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.E..GP2	KCPM40	**.E..GB2**	**KCPM40**	.S..GB2	KCPM40
P3–P4	.E..GP2	KCPK30	**.E..GB2**	**KCPK30**	.S..GB2	KCPK30
P5–P6	.E..GP2	KC725M	**.E..GB2**	**KC725M**	.S..GB2	KC725M
M1–M2	.E..LD2	KC725M	**.E..GP2**	**KC725M**	.S..GP2	KC725M
M3	.E..GP2	KCPM40	**.E..GB2**	**KCPM40**	.S..GP2	KCPM40
K1–K2	.E..GP2	KCK15	**.E..GB2**	**KCK15**	.S..GB2	KCK15
K3	.E..GP2	KC520M	**.E..GB2**	**KC520M**	.S..GB2	KC520M
N1–N2	.F..LE	KC410M	**.F..LE**	**KC410M**	.F..LE	KC410M
N3	.F..LE	KC410M	**.F..LE**	**KC410M**	.F..LE	KC410M
S1–S2	.E..LD2	KC725M	**.E..GP2**	**KC725M**	.S..GP2	KC725M
S3	.E..GB2	KC725M	**.S..GP2**	**KC725M**	.S..GB2	KC725M
S4	.E..GB2	KC725M	**.S..GP2**	**KC725M**	.S..GB2	KC725M
H1	–	–	**–**	**–**	–	–

Indexable Inserts


SECT-LE



SECT-LE

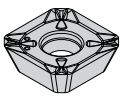
● first choice
○ alternate choice

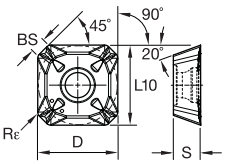
beyond

P				●		●		○	●	
M				●		○	○	●	○	
K			●		●	○		○		●
N		●								
S				●			●	●		
H										

SECT-LE

catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC725M	KCK15	KCPK30	KCSM30	KC522M	KCPM40	KY3500
SECT1404AEFNLE	14,00	4,76	14,00	2,65	1,0	0,02	4	●	–	–	–	–	–	–	–	–


SECT-LD2

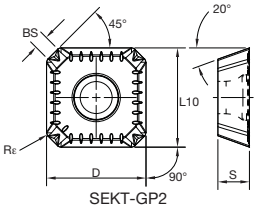


SECT-LD2

SECT-LD2

catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC725M	KCK15	KCPK30	KCSM30	KC522M	KCPM40	KY3500
SECT1404AEENLD2	14,00	4,76	14,00	2,65	1,0	0,04	4	–	–	●	–	–	–	–	–	–


SEKT-GP2

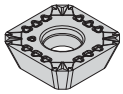


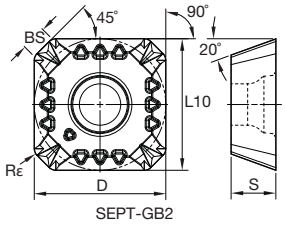
SEKT-GP2

SEKT-GP2

catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC725M	KCK15	KCPK30	KCSM30	KC522M	KCPM40	KY3500
SEKT1404AEENGP2	14,00	4,76	14,00	2,65	1,0	0,05	4	–	●	●	●	●	–	–	●	–
SEKT1404AESNGP2	14,00	4,76	14,00	2,65	1,0	0,11	4	–	●	●	●	●	–	–	●	–

Face Milling


SEPT-GB2



SEPT-GB2

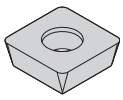
● first choice
○ alternate choice

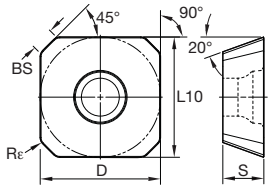
beyond

P			●		●		○	●	
M			●		○	○	●	○	
K		●		●	○		○		●
N	●								
S			●			●	●		
H									

SEPT-GB2

catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC725M	KCK15	KCPK30	KCSM30	KC522M	KCPM40	KY3500
SEPT1404AEENGB2	14,00	4,76	14,00	2,65	1,0	0,08	4	–	–	●	●	●	–	–	●	–
SEPT1404AESNGB2	14,00	4,76	14,00	2,65	1,0	0,13	4	–	–	●	●	●	–	–	●	–

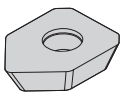

SECW-GN

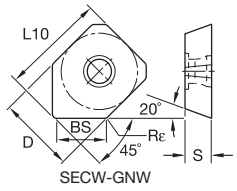


SECW-GN

SECW-GN

catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC725M	KCK15	KCPK30	KCSM30	KC522M	KCPM40	KY3500
SECW1404AESNGN	14,00	4,76	14,00	2,65	1,0	0,16	4	–	–	–	–	–	–	–	–	●


SECW-GNW



SECW-GNW

SECW-GNW

catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC725M	KCK15	KCPK30	KCSM30	KC522M	KCPM40	KY3500
SECW1404AEENGNW	14,00	4,76	8,26	8,26	0,8	0,04	2	–	–	●	–	–	–	–	–	–

Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.F..LE	0,17	**0,59**	0,99	0,12	**0,43**	0,71	0,09	**0,32**	0,53	0,08	**0,28**	0,46	0,07	**0,25**	0,42	.F..LE
.E..LD2	0,17	**0,62**	1,15	0,13	**0,45**	0,82	0,10	**0,34**	0,61	0,08	**0,29**	0,53	0,08	**0,27**	0,49	.E..LD2
.E..LD	0,24	**0,67**	1,17	0,17	**0,48**	0,84	0,13	**0,36**	0,62	0,11	**0,31**	0,54	0,10	**0,29**	0,50	.E..LD
.E..GP	0,17	**0,62**	1,26	0,13	**0,45**	0,90	0,10	**0,34**	0,67	0,08	**0,29**	0,59	0,08	**0,27**	0,54	.E..GP
.E..GP2	0,24	**0,74**	1,27	0,17	**0,53**	0,91	0,13	**0,40**	0,68	0,11	**0,35**	0,59	0,10	**0,32**	0,54	.E..GP2
.E..GB2	0,33	**0,84**	1,35	0,24	**0,60**	0,97	0,18	**0,45**	0,72	0,16	**0,39**	0,63	0,14	**0,36**	0,57	.E..GB2
.S..GP2	0,33	**0,84**	1,35	0,24	**0,60**	0,97	0,18	**0,45**	0,72	0,16	**0,39**	0,63	0,14	**0,36**	0,57	.S..GP2
.S..GB2	0,33	**0,84**	1,35	0,24	**0,60**	0,97	0,18	**0,45**	0,72	0,16	**0,39**	0,63	0,14	**0,36**	0,57	.S..GB2
.S..GN	0,33	**0,84**	1,35	0,24	**0,60**	0,97	0,18	**0,45**	0,72	0,16	**0,39**	0,63	0,14	**0,36**	0,57	.S..GN

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

KSOM™ Mini · KSOM Milling Tools

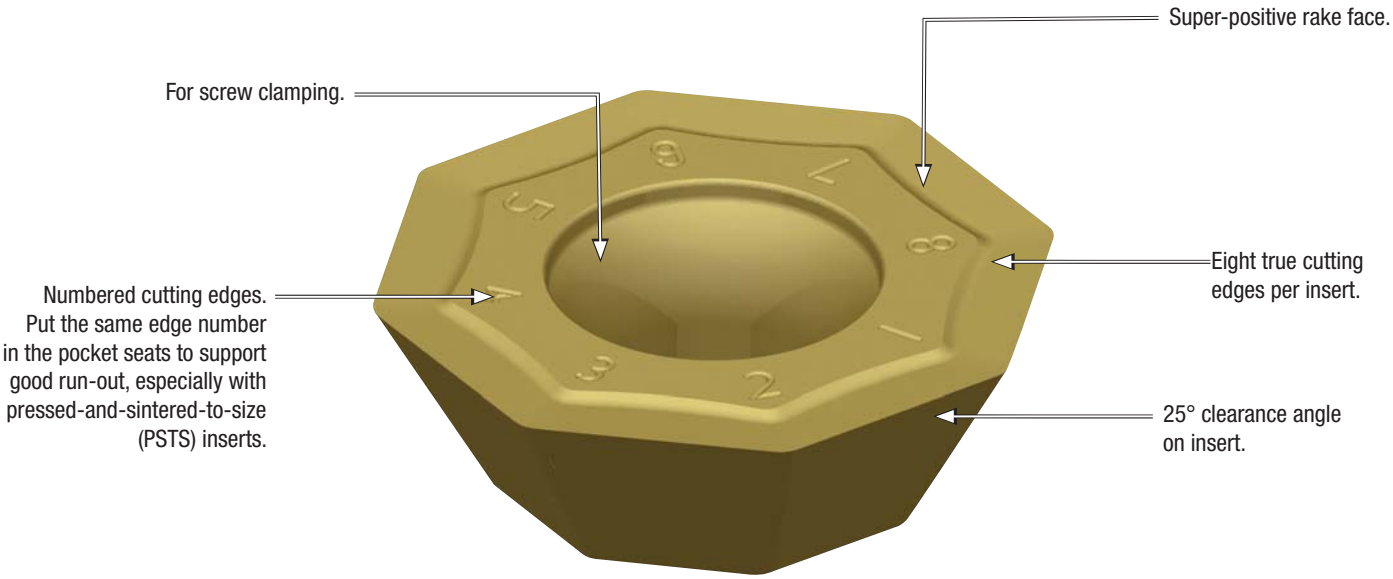
Primary Application

High-positive face mills with eight cutting edges for use in most workpieces materials. Due to its design, face milling, plunging, helical interpolation, and ramping are possible with KSOM mills.

Features and Benefits

- Super-positive rake face for soft cutting action.
- Low cutting forces deliver higher feed capability.
- 25° clearance angle on insert allows excellent free cutting.
- Excellent performance in stainless steel and super alloys.
- First choice solution for machining turbocharger materials like 1.4826, 1.4838, 1.4848, and 1.4849.

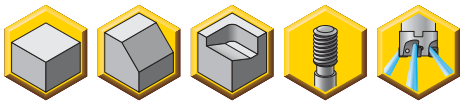


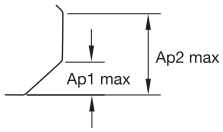


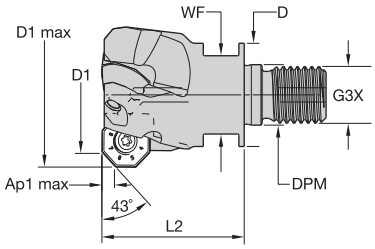
KSOM Mini: insert OF*T06
— Ap1 max = 3,5mm (8 indexes)
— Ap2 max = 9mm (4 indexes)

KSOM insert OF*T07
— Ap1 max = 5mm (8 indexes)
— Ap2 max = 11mm (4 indexes)

- Eight cutting edges per insert.
- Super soft cutting.







Ap1 max = 3,5mm (8 edges)
Ap2 max = 9mm (4 edges); reduce feed rate by 40%



KSOM Mini • Screw-On End Mills

order number	catalogue number	D1	D1 max	D	DPM	G3X	L2	WF	Ap1 max	Z	max ramp angle	kg	max RPM
5358886	**KSOM32Z03M16OF06X**	32	41,1	29	17,0	M16	40	22	3,5	3	11.0°	0,22	19890
5358887	**KSOM40Z04M16OF06X**	40	49,0	29	17,0	M16	40	22	3,5	4	7.5°	0,27	15920

Spare Parts





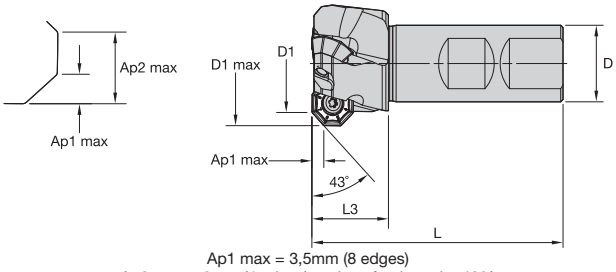


D1	insert screw	Nm	Torx Plus wrench
32	**193.433**	6,0	**TTP15**
40	**193.433**	6,0	**TTP15**

NOTE: Adjustable torque wrench (order number 6197561) and bit TorxPlus15 (order number 6205880) may be purchased separately in order to ensure proper torque setting.

- Super soft cutting.
- Eight cutting edges per insert.







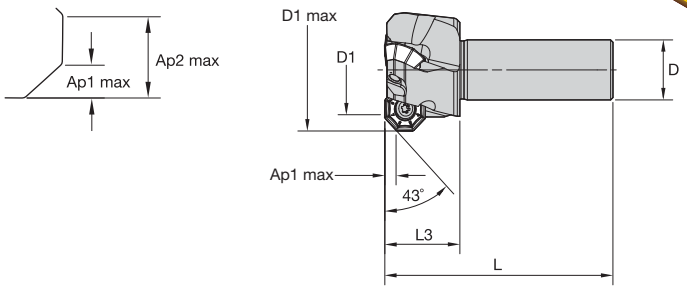
Ap1 max = 3,5mm (8 edges)
Ap2 max = 9mm (4 edges); reduce feed rate by 40%

KSOM Mini • Weldon® End Mills

order number	catalogue number	D1	D1 max	D	L	L3	Ap1 max	Z	max ramp angle	kg	max RPM
3115894	**KSOM32R02B20OF06**	32	41,1	20	76	25	3,5	2	11.0°	0,25	19890
3115893	**KSOM32R03B20OF06**	32	41,1	20	76	25	3,5	3	11.0°	0,23	19890
3115882	**KSOM32R03B25OF06**	32	41,1	25	82	25	3,5	3	11.0°	0,32	19890
3115899	**KSOM40R03B25OF06**	40	49,0	25	82	25	3,5	3	8.0°	0,37	15920
3115898	**KSOM40R04B25OF06**	40	49,0	25	82	25	3,5	4	8.0°	0,37	15920
3115897	**KSOM40R04B32OF06**	40	49,0	32	110	49	3,5	4	8.0°	0,67	15920

- Eight cutting edges per insert.
- Super soft cutting.







Ap1 max = 3,5mm (8 edges)
Ap2 max = 9mm (4 edges); reduce feed rate by 40%

KSOM Mini • Cylindrical End Mills

order number	catalogue number	D1	D1 max	D	L	L3	Ap1 max	Z	max ramp angle	kg	max RPM
3660312	**KSOM32R03A20OF06**	32	41,1	20	76	25	3,5	3	11.0°	0,24	19890
5358888	**KSOM32Z03A32OF06X**	32	41,1	32	90	—	3,5	3	11.0°	0,52	19890

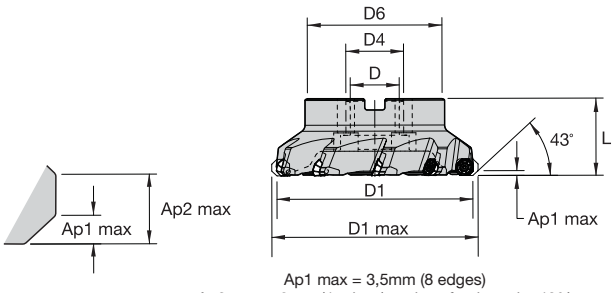
Spare Parts

D1	insert screw	Nm	Torx Plus wrench
32	**193.433**	6,0	**TTP15**
40	**193.433**	6,0	**TTP15**

NOTE: Adjustable torque wrench (order number 6197561) and bit TorxPlus15 (order number 6205880) may be purchased separately in order to ensure proper torque setting.

- Eight cutting edges per insert.
- Super soft cutting.







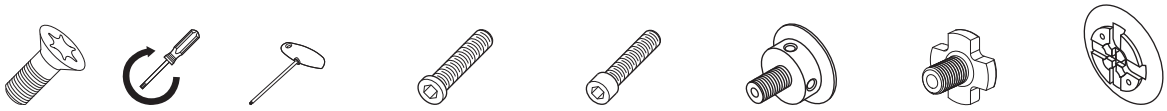
Ap1 max = 3,5mm (8 edges)
Ap2 max = 9mm (4 edges); reduce feed rate by 40%

KSOM Mini • Shell Mills

order number	catalogue number	D1	D1 max	D	D4	D6	L	Ap1 max	Z	max ramp angle	kg	max RPM
5358889	**KSOM40Z04OF06X**	40	49,0	16	–	33	40	3,5	4	8.0°	0,23	15920
3115903	**KSOM50R04OF06**	50	58,9	22	–	38	43	3,5	4	5.0°	0,35	12730
5358930	**KSOM50Z06OF06X**	50	58,8	22	–	42	43	3,5	6	5.0°	0,37	12730
3115905	**KSOM63R05OF06**	63	71,8	22	–	50	43	3,5	5	4.0°	0,62	10110
5358931	**KSOM63Z07OF06X**	63	71,7	22	–	50	43	3,5	7	4.0°	0,61	10110
3115907	**KSOM80R06OF06**	80	88,7	27	–	60	50	3,5	6	3.0°	1,10	7960
5358932	**KSOM80Z09OF06X**	80	88,7	27	–	60	50	3,5	9	3.0°	1,09	7960
3115909	**KSOM100R07OF06**	100	108,6	32	–	80	50	3,5	7	2.0°	1,71	6370
3115908	**KSOM100R10OF06**	100	108,6	32	–	80	50	3,5	10	2.0°	1,75	6370
3115911	**KSOM125R08OF06**	125	133,6	40	–	94	63	3,5	8	2.0°	2,74	5090
3115910	**KSOM125R12OF06**	125	133,6	40	–	94	63	3,5	12	2.0°	2,83	5090
3115913	**KSOM160R10OF06**	160	168,5	40	67	114	63	3,5	10	1.0°	4,30	3980
3115912	**KSOM160R16OF06**	160	168,5	40	67	114	63	3,5	16	1.0°	4,46	3980

NOTE: “X” in the catalogue number stands for improved finishing capabilities.

Spare Parts



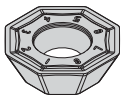
D1	insert screw	Nm	Torx Plus wrench	low-head cap screw	socket-head cap screw	coolant lock screw assembly	coolant lock screw	coolant shower plate
40	**193.433**	6,0	**TTP15**	–	**MS1294**	–	–	–
50	**193.433**	6,0	**TTP15**	**129.025**	–	–	–	–
63	**193.433**	6,0	**TTP15**	–	**125.025**	–	–	–
80	**193.433**	6,0	**TTP15**	–	**125.230**	–	–	–
100	**193.433**	6,0	**TTP15**	–	–	**MS2189C**	–	–
125	**193.433**	6,0	**TTP15**	–	–	–	**420.200**	**470.232**
160	**193.433**	6,0	**TTP15**	–	–	–	**420.200**	**470.233**

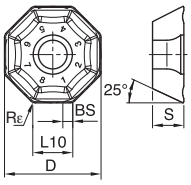
NOTE: Adjustable torque wrench (order number 6197561) and bit TorxPlus 15 (order number 6205880) may be purchased seperately in order to ensure proper torque setting.

Insert Selection Guide

Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		◄———	———►	toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.E..LB	KCPK30	**.E..GB**	**KCPM40**	.S..HB	KCPK30
P3–P4	.E..LB	KCPK30	**.E..GB**	**KCPK30**	.S..HB	KCPK30
P5–P6	.E..LB	KC725M	**.E..GB**	**KC725M**	.S..HB	KC725M
M1–M2	.E..LB	KCSM40	**.E..GB**	**KCSM40**	.S..HB	KCSM40
M3	.E..LB	KCSM40	**.E..GB**	**KCSM40**	.S..HB	KCSM40
K1–K2	.E..LB	KCK15	**.E..GB**	**KC520M**	.E..GB	KCK15
K3	.E..LB	KCPK30	**.E..GB**	**KC520M**	.S..HB	KCPK30
N1–N2	.F..LBJ	KC410M	**.E..LBJ**	**KC422M**	.E..LBJ	KC422M
N3	.F..LBJ	KC410M	**.F..LNJ**	**KC410M**	.F..LNJ	KC410M
S1–S2	.E..LB	KC725M	**.E..GB**	**KC725M**	.S..HB	KC725M
S3	.E..LB	KCSM40	**.E..GB**	**KCSM40**	.S..HB	KCSM40
S4	.E..LB	KCSM40	**.E..GB**	**KCSM40**	.S..HB	KCSM40
H1	–	–	**–**	**–**	–	–

- First choice for machining aluminium with low feed rate.


OF.T-LNJ



OF.T-LNJ

beyond

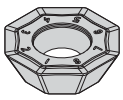
● first choice
○ alternate choice

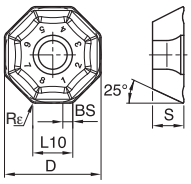
P					○	●		●	●	○
M					●	●		○	○	●
K				●	○		●	○		
N		●	●							
S					●	●				●
H										

OFKT-LNJ

catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
OFKT06L5AFFNLNJ	15	5,00	6,00	–	0,8	0,02	8	●	–	–	–	–	–	–	–	–

- First choice for machining aluminium.


OF.T-LBJ



OF.T-LBJ

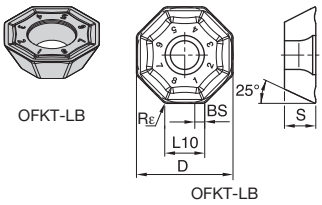
OFKT-LBJ

catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
OFKT06L5AFENLBJ	15	5,00	6,00	–	0,8	0,03	8	–	●	–	–	–	–	–	–	–
OFKT06L5AFFNLBJ	15	5,00	6,00	–	0,8	0,02	8	●	–	–	–	–	–	–	–	–

- First choice for light machining.
- -LB light geometry is the first choice for turbine blade applications.

● first choice
○ alternate choice

P					○	●		●	●	○
M					●	●		○	○	●
K				●	○		●	○		
N	●	●								
S					●	●				●
H										

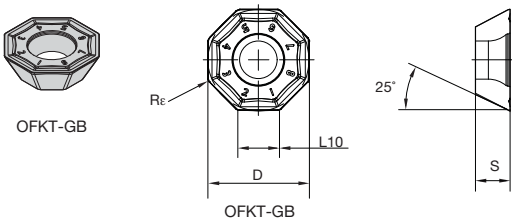


OFKT-LB

OFKT-LB

catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
OFKT06L5AFENLB	15	5,00	6,00	1,23	0,8	0,10	8	–	–	–	●	●	●	●	–	●
OFKT06L5AFSNLB	15	5,00	6,00	1,21	0,8	0,22	8	–	–	●	●	●	–	●	–	–

- First choice for general purpose.
- -GB medium geometry for roughing and finishing operations on all materials.

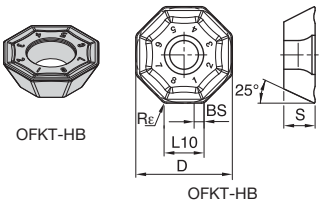


OFKT-GB

OFKT-GB

catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
OFKT06L5AFENGB	15	5,00	6,00	–	0,8	0,15	8	–	–	●	●	●	●	●	●	●

- First choice for heavy roughing.



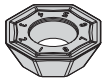
OFKT-HB

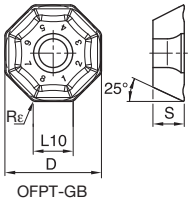
OFKT-HB

catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
OFKT06L5AFSNHB	15	5,00	6,00	–	0,8	0,21	8	–	–	–	●	●	–	●	–	●

- First choice for general purpose.

beyond


OFPT-GB



OFPT-GB

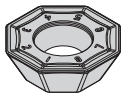
● first choice
○ alternate choice

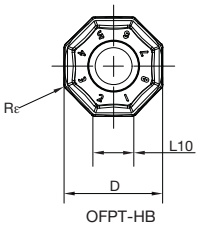
		KC410M	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
P					○	●		●	●	○
M					●	●		○	○	●
K				●	○		●	○		
N		●	●							
S					●	●				●
H										

OFPT-GB

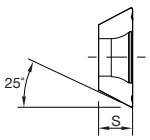
catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
OFPT06L5AFENGB	15	5,00	6,00	–	0,8	0,15	8	–	–	●	–	●	●	●	●	–

- First choice for heavy roughing.
- -HB geometry with the strongest cutting edge is the first choice for roughing operations on steel and cast iron.


OFPT-HB



OFPT-HB



OFPT-HB

catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
OFPT06L5AFSNHB	15	5,00	6,00	–	0,8	0,21	8	–	–	●	–	●	●	●	–	●

Recommended Starting Feeds

Recommended Starting Feeds [mm]

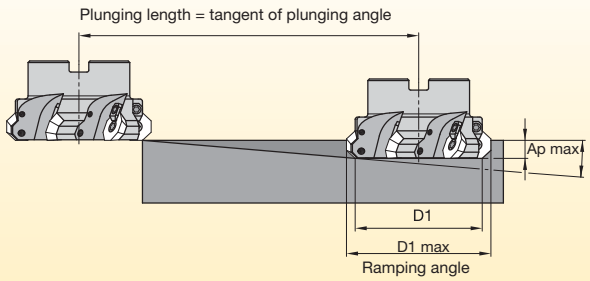
Light Machining	General Purpose	Heavy Machining

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.F..LBJ	0,17	**0,61**	1,03	0,12	**0,44**	0,74	0,09	**0,33**	0,55	0,08	**0,29**	0,48	0,07	**0,26**	0,44	.F..LBJ
.F..LNJ	0,17	**0,61**	1,03	0,12	**0,44**	0,74	0,09	**0,33**	0,55	0,08	**0,29**	0,48	0,07	**0,26**	0,44	.F..LNJ
.E..LBJ	0,17	**0,61**	1,13	0,12	**0,44**	0,81	0,09	**0,33**	0,61	0,08	**0,29**	0,53	0,07	**0,26**	0,48	.E..LBJ
.E..LB	0,34	**0,75**	1,20	0,25	**0,54**	0,86	0,19	**0,40**	0,64	0,16	**0,35**	0,56	0,15	**0,32**	0,51	.E..LB
.S..LB	0,34	**0,73**	1,30	0,25	**0,53**	0,93	0,19	**0,39**	0,69	0,16	**0,34**	0,60	0,15	**0,32**	0,55	.S..LB
.E..GB	0,34	**0,87**	1,39	0,25	**0,62**	1,00	0,19	**0,47**	0,74	0,16	**0,41**	0,65	0,15	**0,37**	0,59	.E..GB
.S..HB	0,34	**0,87**	1,49	0,25	**0,62**	1,07	0,19	**0,47**	0,79	0,16	**0,41**	0,69	0,15	**0,37**	0,63	.S..HB

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

KSOM Mini Application • OF.T06L5

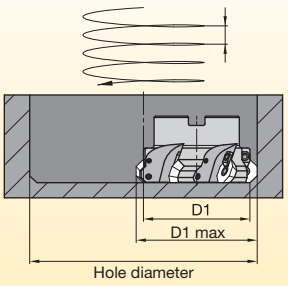
Ramping



Metric version

D1 mm	D1 max mm	max ap mm	ramping angle (°)	ramping length mm
32	41,1	9	11,0	46,3
40	49,0	9	7,5	68,4
50	58,9	9	5,0	102,9
63	71,8	9	3,9	132,0
80	88,7	9	2,9	177,7
100	108,6	9	2,2	234,3
125	133,6	9	1,7	303,2
160	168,5	9	1,3	396,6

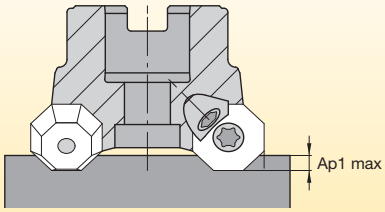
Helical Interpolation



Metric version

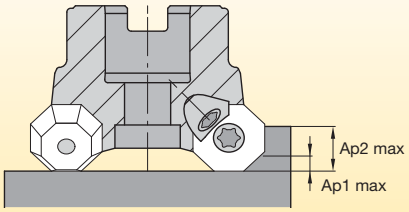
D1 mm	D1 max mm	Hole Diameter min. mm	Hole Diameter max. mm	Ap/Rev. mm
32	41,1	61,7	81,7	4,7
40	49,0	77,5	97,6	4,7
50	58,9	97,4	117,4	4,7
63	71,8	123,3	143,3	4,7
80	88,7	157,2	177,2	4,7
100	108,6	197,2	217,1	4,7
125	133,6	247,1	267,0	4,7
160	168,5	317,1	377,0	4,7

Plunging



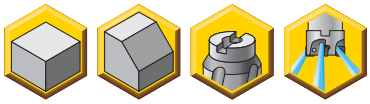
max. plunging depth	mm
Ap1 max	3,2

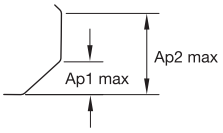
Face Milling

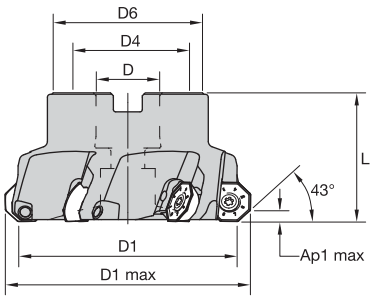


max. DOC Ap	mm	chipload (fz)
Ap1 max	3,5	1 x fz
Ap2 max	9,0	0,6 x fz

- Eight cutting edges per insert.
- Super soft cutting.







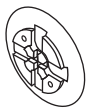


Ap1 max = 3,5mm (8 edges)
Ap2 max = 9mm (4 edges); reduce feed rate by 40%

KSOM • Shell Mills

order number	catalogue number	D1	D1 max	D	D4	D6	L	Ap1 max	Z	max ramp angle	kg	max RPM
3115873	**KSOM63R04OF07**	63	74,3	22	–	50	43	5,0	4	6.0°	0,61	10100
3115582	**KSOM63R05OF07**	63	74,3	22	–	50	43	5,0	5	6.0°	0,55	10100
3115875	**KSOM80R04OF07**	80	91,2	27	–	60	50	5,0	4	4.0°	1,14	7900
3115874	**KSOM80R06OF07**	80	91,2	27	–	60	50	5,0	6	4.0°	1,06	7900
3115877	**KSOM100R05OF07**	100	110,9	32	–	80	50	5,0	5	3.0°	1,66	6300
3115876	**KSOM100R08OF07**	100	110,9	32	–	80	50	5,0	8	3.0°	1,57	6300
3115879	**KSOM125R06OF07**	125	136,0	40	–	90	63	5,0	6	2.0°	2,56	5000
3115878	**KSOM125R10OF07**	125	136,0	40	–	90	63	5,0	10	2.0°	2,68	5000
3115881	**KSOM160R07OF07**	160	170,9	40	67	110	63	5,0	7	2.0°	4,20	3900
3115880	**KSOM160R12OF07**	160	170,9	40	67	110	63	5,0	12	2.0°	4,34	3900

Spare Parts

D1	 insert screw	 Nm	 Torx Plus wrench	 socket-head cap screw	 coolant lock screw assembly	 coolant lock screw	 coolant shower plate
63	**193.409**	6,0	**TTP20**	**125.025**	–	–	–
80	**193.409**	6,0	**TTP20**	**125.230**	–	–	–
100	**193.409**	6,0	**TTP20**	–	**MS2189C**	–	–
125	**193.409**	6,0	**TTP20**	–	–	**420.200**	**470.232**
160	**193.409**	6,0	**TTP20**	–	–	**420.200**	**470.233**

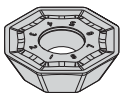
NOTE: Adjustable torque wrench (order number 6197561) and bit TorxPlus 20 (order number 6205891) may be purchased separately in order to ensure proper torque setting.

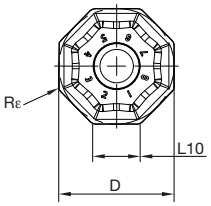
Insert Selection Guide

Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		← →		toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.E..LB	KCPK30	**.E..GB**	**KCPM40**	.S..HB	KCPM40
P3–P4	.E..LB	KCPK30	**.E..GB**	**KCPK30**	.S..HB	KCPK30
P5–P6	.E..LB	KC725M	**.E..GB**	**KC725M**	.S..HB	KC725M
M1–M2	.E..LB	KC725M	**.E..GB**	**KC725M**	.S..HB	KC725M
M3	.E..LB	KCSM40	**.E..GB**	**KCSM40**	.S..HB	KCSM40
K1–K2	.E..LB	KCK15	**.E..GB**	**KC520M**	.S..HB	KCK15
K3	.E..LB	KC520M	**.E..GB**	**KC520M**	.S..HB	KC520M
N1–N2	.F..LNJ	KC410M	**.F..LNJ**	**KC410M**	.F..LNJ	KC410M
N3	.F..LNJ	KC410M	**.F..LNJ**	**KC410M**	.F..LNJ	KC410M
S1–S2	.E..LB	KC725M	**.E..GB**	**KC725M**	.S..HB	KC725M
S3	.E..LB	KCSM40	**.E..GB**	**KCSM40**	.S..HB	KCSM40
S4	.E..LB	KCSM40	**.E..GB**	**KCSM40**	.S..HB	KCSM40
H1	–	–	**–**	**–**	–	–

Indexable Inserts

- First choice for machining aluminium.


OFKT-LNJ



OFKT-LNJ

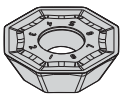
● first choice
○ alternate choice

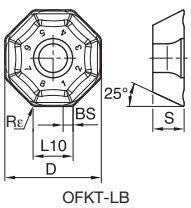
		KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
P				○	●		●	●		○
M				●	●		○	○	○	●
K			●	○		●	○			
N		●								
S				●	●				●	●
H										

OFKT-LNJ

catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
OFKT07L6AFFNLNJ	19	6,00	7,50	–	1,20	0,02	8	●	–	–	–	–	–	–	–	–

- First choice for light machining.


OFKT-LB



OFKT-LB

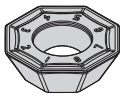
OFKT-LB

catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
OFKT07L6AFENLB	19	6,00	7,50	2,10	1,20	0,10	8	–	–	●	●	–	●	–	–	●
OFKT07L6AFSNLB	19	6,00	7,50	2,10	1,20	0,22	8	–	–	–	●	–	●	–	–	–

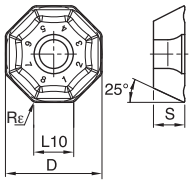
- First choice for general purpose.
- -GB medium geometry for roughing and finishing operations on all materials.

● first choice
○ alternate choice

P			○	●		●	●		○
M			●	●		○	○	○	●
K		●	○		●	○			
N	●								
S			●	●				●	●
H									



OFKT-GB

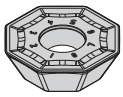


OFKT-GB

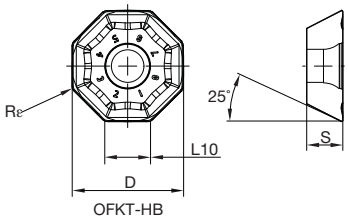
OFKT-GB

catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
OFKT07L6AFENGB	19	6,00	7,50	–	1,20	0,15	8	–	●	●	●	–	●	●	●	●

- First choice for heavy roughing.



OFKT-HB

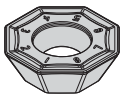


OFKT-HB

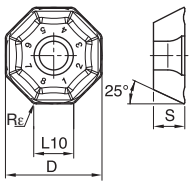
OFKT-HB

catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
OFKT07L6AFSNHB	19	6,00	7,50	–	1,20	0,21	8	–	●	●	●	–	●	●	–	●

- First choice for general purpose.



OFPT-GB

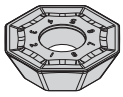


OFPT-GB

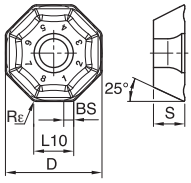
OFPT-GB

catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
OFPT07L6AFENGB	19	6,00	7,50	–	1,20	0,15	8	–	●	●	●	●	●	●	–	–

- First choice for heavy roughing.



OFPT-HB



OFPT-HB

OFPT-HB

catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
OFPT07L6AFSNHB	19	6,00	7,50	–	1,20	0,21	8	–	–	●	●	●	●	–	–	●

Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.F..LNJ	0,17	**0,67**	1,20	0,12	**0,49**	0,86	0,09	**0,36**	0,64	0,08	**0,32**	0,56	0,07	**0,29**	0,51	.F..LNJ
.E..LB	0,34	**0,75**	1,20	0,25	**0,54**	0,86	0,19	**0,40**	0,64	0,16	**0,35**	0,56	0,15	**0,32**	0,51	.E..LB
.S..LB	0,34	**0,73**	1,33	0,25	**0,53**	0,96	0,19	**0,39**	0,71	0,16	**0,34**	0,62	0,15	**0,32**	0,57	.S..LB
.E..GB	0,34	**0,87**	1,40	0,25	**0,62**	1,00	0,19	**0,47**	0,74	0,16	**0,41**	0,65	0,15	**0,37**	0,59	.E..GB
.S..HB	0,34	**0,87**	1,49	0,25	**0,62**	1,07	0,19	**0,47**	0,79	0,16	**0,41**	0,69	0,15	**0,37**	0,63	.S..HB

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

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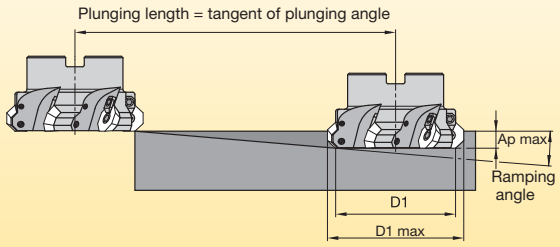
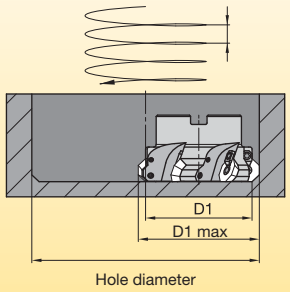
Ramping



Metric version

D1 mm	D1 max mm	Ap max	ramping angle (°)	ramping length mm
63	74,2	9	5,5	121,5
80	91,1	9	4,0	167,3
100	111,0	9	3,0	223,2
125	135,9	9	2,3	291,3
160	170,8	9	1,7	394,2

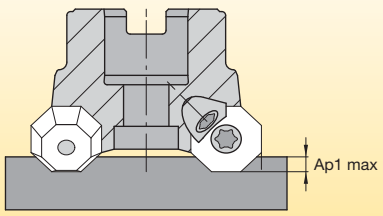
Helical Interpolation



Metric version

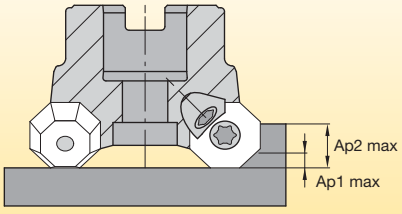
D1 mm	D1 max mm	hole diameter		Ap/rev mm
		min mm	max mm	
63	74,2	122,7	145,0	6,3
80	91,1	156,6	178,0	6,3
100	111,0	196,5	218,7	6,3
125	135,9	246,4	268,7	6,3
160	170,8	316,9	338,6	6,3

Plunging



max plunging depth	mm
Ap1 max	4,2

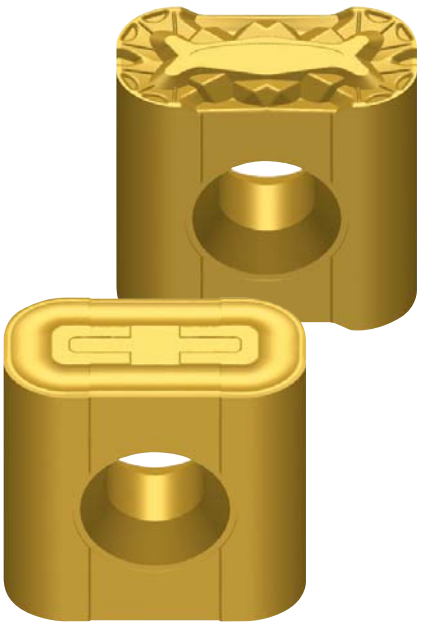
Face Milling



max DOC Ap	mm	chipload (fz)
Ap1 max	5,0	1 x fz
Ap2 max	11,0	0,6 x fz

Kennametal Tools for **Railways** and **Wheel Machining**

Kennametal offers a complete line of tooling for wheel and axle maintenance in railroad shops. All tools incorporate the latest technology for maximum metal removal and higher productivity. They are proven performers in actual use over extended periods of time, under a wide range of operating conditions. Standard off-the-shelf inserts and fewer pieces of hardware reduce inventory and operating costs. Included in this range are tools for reconditioning mounted wheel sets, wheel boring, wheel truing, axle turning, and journal burnishing.



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KSSM8+™ Face Milling Platform

Primary Application

The KSSM8+ platform is a first-choice face milling platform for **versatility** and a **reduced cost per edge**. This platform just got better with the latest pressing technology from Kennametal, which delivers pressed and sintered-to-size (PSTS) inserts ideal for general machining in **cast iron and steel**. With our latest KCPM40™ grade offering, PSTS inserts deliver exceptional performance. Now more than ever, the KSSM8+ platform is the economical solution for applications requiring a **near-90° shoulder**.

Features and Benefits

Features

- Double-sided insert with 8 cutting edges.
- Face mill with close to a 90° shoulder.
  - IC 10 (88° lead)
  - IC 12,7 (87° lead)
- Medium and fine density cutters.
- -LD and -GD geometry inserts.

Benefits

- Maximised number of cutting edges.
- Lower cost-per-edge.
- Reduced power consumption.
- Reduced deformation/chatter.
- Exceptional surface finish.
- Stronger edge for roughing.

Versatile Platform with Multiple Insert Options and Grades

Cost per Edge
Double-sided square inserts,
8 cutting edges.

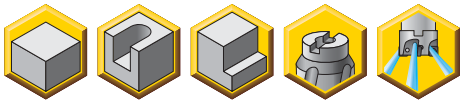


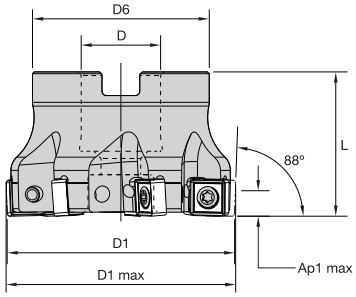


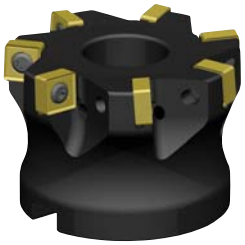
Optimised Cutting Forces
4° axial and 10° radial rake
angles reduce power consumption.

Through Tool Coolant/Air
Directed to the cutting edge
for optimum cooling.

- Eight cutting edges offer a lower cost per edge.
- Soft cutting action with low cutting forces.







KSSM8+ • Shell Mills

order number	catalogue number	D1	D1 max	D	D6	L	Ap1 max	Z	kg	max RPM
5420163	**KSSM88D050Z05SN10**	50,0	50,64	22,00	49,00	40,00	9,16	5	0,36	32900
5420164	**KSSM88D050Z06SN10**	50,0	50,64	22,00	49,00	40,00	9,16	6	0,36	32900
5420165	**KSSM88D063Z05SN10**	63,0	63,64	22,00	49,00	40,00	9,16	5	0,51	28500
5420166	**KSSM88D063Z07SN10**	63,0	63,64	22,00	49,00	40,00	9,16	7	0,52	28500
5420167	**KSSM88D080Z07SN10**	80,0	80,64	27,00	60,00	50,00	9,16	7	1,02	24800
5420168	**KSSM88D080Z09SN10**	80,0	80,64	27,00	60,00	50,00	9,16	9	1,02	24800
5420169	**KSSM88D100Z08SN10**	100,0	100,64	32,00	78,00	50,00	9,16	8	1,72	21900
5420250	**KSSM88D100Z11SN10**	100,0	100,64	32,00	78,00	50,00	9,16	11	1,71	21900

NOTE: Standard milling cutters will accept insert nose radii up to 2mm without modification.

Spare Parts

D1	 insert screw	 Nm	 Torx driver	 socket-head cap screw	 coolant lock screw assembly
50,0	**193.492**	4,0	**DT15**	**–**	**–**
63,0	**193.492**	4,0	**DT15**	**–**	**–**
80,0	**193.492**	4,0	**DT15**	**MS2038**	**–**
100,0	**193.492**	4,0	**DT15**	**–**	**MS2189C**

NOTE: For coolant shower plates (MCC..), only use low-presssure coolant.

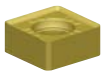
Insert Selection Guide

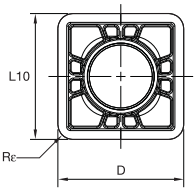
Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		←	→	toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.E..LD	KC725M	**.E..LD**	**KCPK30**	.S..GD	KCPM40
P3–P4	.E..LD	KCPK30	**.S..GD**	**KCPK30**	.S..GD	KCPM40
P5–P6	.E..LD	KC725M	**.S..GD**	**KCPK30**	.S..GD	KCPM40
M1–M2	.E..LD	KC725M	**.E..LD**	**KC725M**	.S..GD	KCPM40
M3	.E..LD	KC725M	**.S..GD**	**KCPK30**	.S..GD	KCPM40
K1–K2	.E..LD	KCK15	**.S..GD**	**KC520M**	.S..GD	KCK15
K3	.E..LD	KC520M	**.S..GD**	**KC520M**	.S..GD	KCK15
N1–N2	–	–	**–**	**–**	–	–
N3	–	–	**–**	**–**	–	–
S1–S2	.E..LD	KC725M	**.E..LD**	**KC725M**	.E..LD	KC725M
S3	.E..LD	KC725M	**.E..LD**	**KC725M**	.S..GD	KCPM40
S4	.E..LD	KC725M	**.E..LD**	**KC725M**	.E..LD	KC725M
H1	–	–	**–**	**–**	–	–

Indexable Inserts

- First choice for light machining of cast iron and steel.
- Low cutting forces.

● first choice
○ alternate choice


SNHJ-LD



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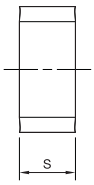
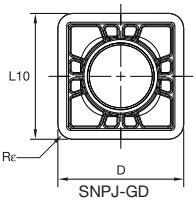


SNHJ-LD

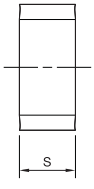
catalogue number	D	S	BS	L10	Rε	hm	cutting edges	KC520M	KC522M	KC725M	KCK15	KCK20	KCPK30	KCPM40	KCSM40
P								○	●	●			●	●	○
M								●	●				○	●	●
K								●	○		●	●	○		
N															
S								●	●					○	●
H															
SNHJ10T308ENLD	10,0	3,98	–	10,00	0,8	0,06	8	●	–	●	●	–	●	–	–
SNHJ10T312ENLD	10,0	3,98	–	10,00	1,2	0,06	8	–	–	●	●	–	–	–	–

- First choice for general purpose machining.


SNPJ-GD



SNPJ-GD



SNPJ-GD

catalogue number	D	S	BS	L10	Rε	hm	cutting edges	KC520M	KC522M	KC725M	KCK15	KCK20	KCPK30	KCPM40	KCSM40
SNPJ10T308SNGD	10,0	3,98	–	10,00	0,8	0,08	8	●	–	–	●	–	●	●	–
SNPJ10T312SNGD	10,0	3,98	–	10,00	1,2	0,08	8	–	–	–	●	–	–	●	–

Recommended Starting Feeds

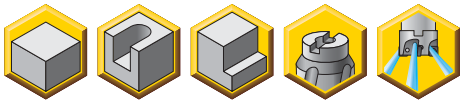
Recommended Starting Feeds [mm]

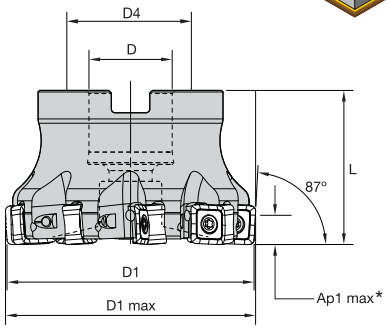
Light Machining	General Purpose	Heavy Machining

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.E..LD	0,18	**0,41**	0,70	0,13	**0,29**	0,51	0,10	**0,22**	0,38	0,08	**0,19**	0,33	0,08	**0,18**	0,30	.E..LD
.S..GD	0,23	**0,51**	0,82	0,17	**0,37**	0,59	0,13	**0,27**	0,44	0,11	**0,24**	0,38	0,10	**0,22**	0,35	.S..GD

NOTE: Use "Light Machining" values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

- Eight cutting edges offer a lower cost per edge.
- Soft cutting action with low cutting forces.





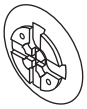


KSSM8+ • Shell Mills

order number	catalogue number	D1	D1 max	D	D4	D6	L	Ap1 max*	Z	kg	max RPM
5419998	**KSSM87D050Z05SN12**	50,0	51,15	22,00	–	49,00	40,00	6	5	0,34	22700
5420110	**KSSM87D063Z05SN12**	63,0	64,15	22,00	–	49,00	40,00	6	5	0,49	19600
5420111	**KSSM87D063Z07SN12**	63,0	64,15	22,00	–	49,00	40,00	6	7	0,49	19600
5420112	**KSSM87D080Z07SN12**	80,0	81,15	27,00	–	60,00	50,00	6	7	1,00	16900
5420113	**KSSM87D080Z09SN12**	80,0	81,15	27,00	–	60,00	50,00	6	9	0,99	16900
5420114	**KSSM87D100Z08SN12**	100,0	101,15	32,00	–	78,00	50,00	6	8	1,65	14800
5420115	**KSSM87D100Z11SN12**	100,0	101,15	32,00	–	78,00	50,00	6	11	1,65	14800
5420116	**KSSM87D125Z09SN12**	125,0	126,15	40,00	–	89,00	63,00	6	9	2,87	13100
5420117	**KSSM87D125Z14SN12**	125,0	126,15	40,00	–	89,00	63,00	6	14	2,85	13100
5420118	**KSSM87D160Z12SN12**	160,0	161,15	40,00	66,70	89,00	63,00	6	12	3,34	11400

NOTE: Standard milling cutters will accept insert nose radii up to 2mm without modification.
*Ap1max. 6mm using insert SNHJ120608ENLD
*Ap1max. 11,86mm using insert SNPJ120608SNGD

Spare Parts

D1	 insert screw	 Nm	 Torx driver	 socket-head cap screw	 coolant lock screw assembly	 coolant shower plate assembly
50,0	**193.492**	4,0	**DT15**	**–**	**–**	**–**
63,0	**193.492**	4,0	**DT15**	**–**	**–**	**–**
80,0	**193.492**	4,0	**DT15**	**MS2038**	**–**	**–**
100,0	**193.492**	4,0	**DT15**	**–**	**MS2189C**	**–**
125,0	**193.492**	4,0	**DT15**	**–**	**MS2187C**	**–**
160,0	**193.492**	4,0	**DT15**	**–**	**–**	**MCCM16001**

NOTE: For coolant shower plates (MCC..), only use low-pressure coolant.

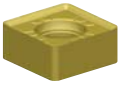
Insert Selection Guide

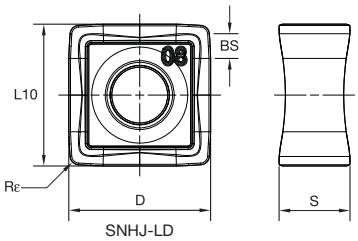
Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		◄———	———►	toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.E..LD	KC725M	**.E..LD**	**KCPK30**	.S..GD	KCPM40
P3–P4	.E..LD	KCPK30	**.S..GD**	**KCPK30**	.S..GD	KCPM40
P5–P6	.E..LD	KCPK30	**.S..GD**	**KCPK30**	.S..GD	KCPM40
M1–M2	.E..LD	KC725M	**.S..GD**	**KC522M**	.S..GD	KCSM40
M3	.E..LD	KC725M	**.S..GD**	**KCPM40**	.S..GD	KCSM40
K1–K2	.E..LD	KC520M	**.E..LD**	**KCK15**	.S..GD	KC520M
K3	.E..LD	KCK15	**.S..GD**	**KC520M**	.S..GD	KCK15
N1–N2	–	–	**–**	**–**	–	–
N3	–	–	**–**	**–**	–	–
S1–S2	.E..LD	KC725M	**.S..GD**	**KCSM40**	.S..GD	KC522M
S3	.E..LD	KC725M	**.S..GD**	**KCSM40**	.S..GD	KCPM40
S4	.E..LD	KC725M	**.S..GD**	**KCSM40**	.S..GD	KC522M
H1	–	–	**–**	**–**	–	–

Indexable Inserts

- First choice for light machining of cast iron and steel.

beyond


SNHJ-LD



SNHJ-LD

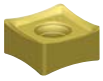
● first choice
○ alternate choice

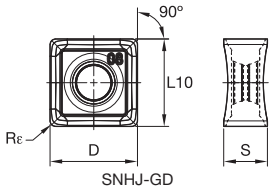
P			○	●			●	●	○
M			●	●			○	●	●
K	●	○		●	●	○			
N									
S			●	●				○	●
H									

SNHJ-LD

catalogue number	D	S	L10	Rε	hm	cutting edges	KC520M	KC522M	KC725M	KCK15	KCK20	KCPK30	KCPM40	KCSM40
SNHJ120608ENLD	12,7	6,35	12,70	0,8	0,06	8	●	–	●	●	–	●	–	–
SNHJ120616ENLD	12,7	6,35	12,70	1,6	0,06	8	●	–	●	●	–	●	–	–

- First choice for high-performance roughing.


SNHJ-GD



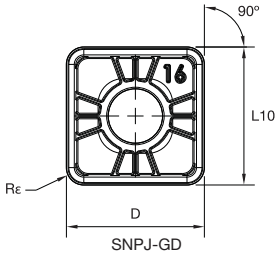
SNHJ-GD

SNHJ-GD

catalogue number	D	S	L10	Rε	hm	cutting edges	KC520M	KC522M	KC725M	KCK15	KCK20	KCPK30	KCPM40	KCSM40
SNHJ120608SNGD	12,7	6,35	12,70	0,8	0,13	8	●	●	–	●	–	●	●	●

- First choice for regular roughing.


SNPJ-GD



● first choice
○ alternate choice

beyond

	KC520M	KC522M	KC725M	KCK15	KCK20	KCPK30	KCPM40	KCSM40
P		○	●			●	●	○
M		●	●			○	●	●
K	●	○		●	●	○		
N								
S		●	●				○	●
H								

SNPJ-GD

catalogue number	D	L10	Rε	S	hm	cutting edges	KC520M	KC522M	KC725M	KCK15	KCK20	KCPK30	KCPM40	KCSM40
SNPJ120608SNGD	12,7	12,70	0,8	4,52	0,13	8	●	–	–	●	–	–	●	–
SNPJ120616SNGD	12,7	12,70	1,6	4,52	0,13	8	–	–	–	●	–	–	●	–

Recommended Starting Feeds

Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.E..LD	0,18	**0,46**	0,82	0,13	**0,33**	0,59	0,10	**0,25**	0,44	0,08	**0,22**	0,38	0,08	**0,20**	0,35	.E..LD
.S..GD	0,23	**0,59**	0,93	0,17	**0,43**	0,67	0,13	**0,32**	0,50	0,11	**0,28**	0,43	0,10	**0,25**	0,40	.S..GD

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

Solution Capabilities

RAIL MILLING

Kennametal customers benefit from the highest service levels, our long-term experience, and application knowledge in the rail milling industry.

- Solutions for all applications in rail and wheel machining.
- Technical support to find the right tools for the application and to learn how to use them the best way.
- Highly productive tooling solutions, including indexable inserts up to eight cutting edges.
- High-performance tools with helix-like partitions and long tool life.
- Solutions available to optimise vibration, performance, and cutting action, depending on the application.



Experience the advantages at your Authorised Kennametal Distributor or at **kennametal.com**.

KENNAMETAL®

kennametal.com

Fix-Perfect™ Cast Iron Rougher and Finisher

Primary Application

Performance booster in machining cast iron materials. Based on workpiece requirements, Fix-Perfect roughers and finishers cover all face and shoulder milling applications when machining cast iron materials with best-in-class productivity. Eight true cutting edges per insert deliver low cost per edge and best cost per part (CPP) ceramic inserts available as standard line items.

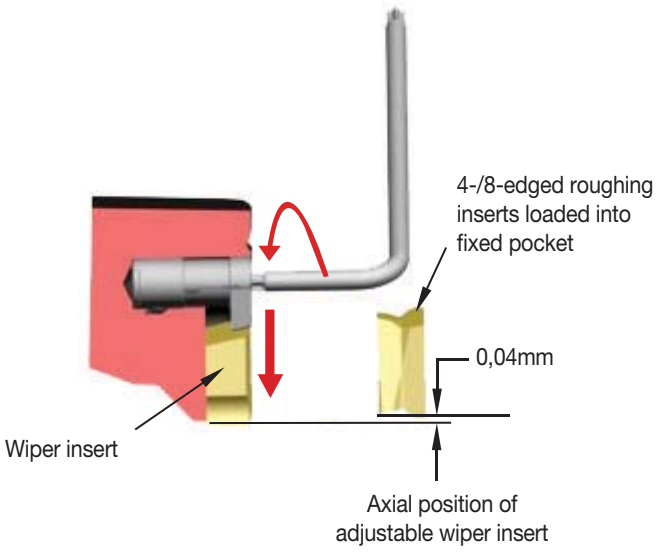
Features and Benefits

Fix-Perfect Cast Iron 70° and 90° Roughing and Finishing in One Tool

- Innovative tangential insert clamping.
- First choice for high feed rates.
- Protection of non-cutting edges.
- Adjustable element for fine finishing with wiper inserts.
- PCBN-tipped wiper inserts available for excellent floor finish.
- Micro-precise runout setup.

Fix-Perfect Cast Iron Finisher Best-in-Class Fine-Finishing Concept

- Rigid and stable cutter design.
- High-precision pocket seat.
- Perfect axial runout without insert adjustment.
- Reliable, excellent floor finish and flatness.
- Easy handling and low-cost cutter setup.





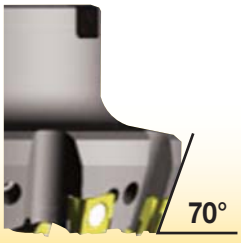
Fix-Perfect™ Finisher



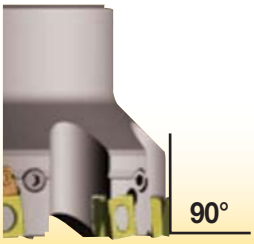
Fix-Perfect Cast Iron

Fix-Perfect Cast Iron 70° and 90°

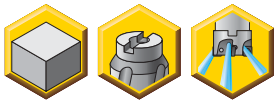
Fix-Perfect 70°

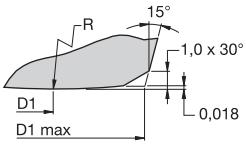


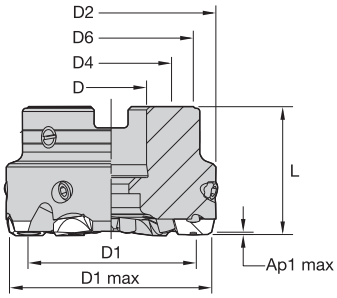
Fix-Perfect 90°



- Perfect axial runout without insert adjustment.
- Excellent floor finish and flatness.
- Easy handling and cutter setup







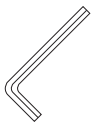


Finishing Face Mills • Shell Mills • Right Hand

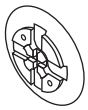
order number	catalogue number	D1	D1 max	D	D2	D4	D6	L	Ap1 max	Z	kg	max RPM
1998359	**63A04RP00MD10CF**	51	63,0	22	65	–	55	40	1,0	4	0,69	20200
1998358	**63A06RP00MD10CF**	51	63,0	22	65	–	55	40	1,0	6	0,72	20200
1893753	**80A06RP00MD10CF**	69	80,0	27	82	–	64	50	1,0	6	1,25	15900
1886327	**80A09RP00MD10CF**	69	80,0	27	82	–	64	50	1,0	9	1,35	15900
1893754	**100B08RP00MD10CF**	89	100,0	32	102	–	84	50	1,0	8	1,85	12750
1886328	**100B12RP00MD10CF**	89	100,0	32	102	–	84	50	1,0	12	2,20	12750
1893755	**125B10RP00MD10CF**	114	125,0	40	127	–	104	63	1,0	10	3,75	10200
1886329	**125B16RP00MD10CF**	114	125,0	40	127	–	104	63	1,0	16	3,85	10200
1893756	**160C12RP00MD10CF**	149	160,0	40	162	66,7	140	63	1,0	12	6,60	7950
1886330	**160C20RP00MD10CF**	149	160,0	40	162	66,7	140	63	1,0	20	6,75	7950
1893757	**200C14RP00MD10CF**	189	200,0	60	202	101,6	180	63	1,0	14	9,70	6350
1886331	**200C24RP00MD10CF**	189	200,0	60	202	101,6	180	63	1,0	24	9,85	6350
1893758	**250C18RP00MD10CF**	235	250,0	60	252	101,6	230	63	1,0	18	16,65	5100
1886332	**250C30RP00MD10CF**	239	250,0	60	252	101,6	230	63	1,0	30	16,85	5100

Spare Parts







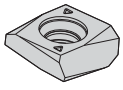


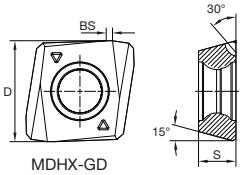
D1 max	clamp stud	clamp screw	hex wrench	Nm	mounting screw	coolant screw	coolant shower plate
63	**410.085**	**420.060**	**170.003**	5,0	**125.025**	**420.104**	–
80	**410.085**	**420.060**	**170.003**	5,0	**125.230**	**420.120**	–
100	**410.085**	**420.060**	**170.003**	5,0	–	**420.160**	–
125	**410.085**	**420.060**	**170.003**	5,0	–	**420.200**	**470.232**
160	**410.085**	**420.060**	**170.003**	5,0	–	**420.200**	**470.233**
200	**410.085**	**420.060**	**170.003**	5,0	–	–	**470.234**
250	**410.085**	**420.060**	**170.003**	5,0	–	–	**470.235**

NOTE: Please order spare parts separately.
For diameters of 125mm and 160mm, use the coolant screw and coolant cap spare parts together.
Torque wrench (DTQ50140, order number 6197561) and 3mm hex bit (BTQSW3L90, order number 6205876) may be purchased separately to ensure proper torque setting.

Insert Selection Guide

Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		◄——►		toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	–	–	–	–	–	–
P3–P4	–	–	–	–	–	–
P5–P6	–	–	–	–	–	–
M1–M2	–	–	–	–	–	–
M3	–	–	–	–	–	–
K1–K2	.F..GD4W	KC520M	**.E..GD4W**	**KC520M**	.E..GD	KC520M
K3	.F..GD4W	KC520M	**.E..GD4W**	**KC520M**	.E..GD	KC520M
N1–N2	–	–	–	–	–	–
N3	–	–	–	–	–	–
S1–S2	–	–	–	–	–	–
S3	–	–	–	–	–	–
S4	–	–	–	–	–	–
H1	–	–	–	–	–	–


MDHX-GD



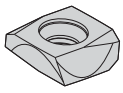
MDHX-GD

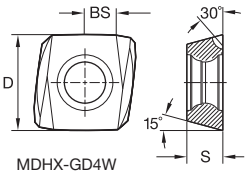
● first choice
○ alternate choice

P						○	●		
M						○	●		
K	●	●	●	○				●	●
N									
S						○	●		
H									

MDHX-GD • Right Hand

catalogue number	D	S	BS	hm	cutting edges	K110M	KC520M	KCK15	KTPK20	KCPK30	KC725M	KB1340	KY3500
MDHX1004ZDERGD	13	4,76	0,80	0,04	4	●	●	–	●	–	–	–	–

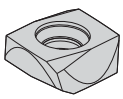

MDHX-GD4W

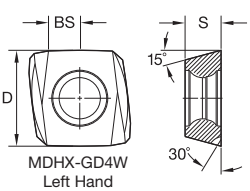


MDHX-GD4W

MDHX-GD4W • Right Hand

catalogue number	D	S	BS	hm	cutting edges	K110M	KC520M	KCK15	KTPK20	KCPK30	KC725M	KB1340	KY3500
MDHX1004ZDERGD4W	13	4,76	4,23	0,04	4	●	●	–	●	–	–	–	–
MDHX1004ZDFRGD4W	13	4,76	4,23	0,02	4	●	●	–	●	–	–	–	–


MDHX-GD4W
Left Hand



MDHX-GD4W
Left Hand

MDHX-GD4W • Left Hand

catalogue number	D	S	BS	hm	cutting edges	K110M	KC520M	KCK15	KTPK20	KCPK30	KC725M	KB1340	KY3500
MDHX1004ZDFLGD4W	13	4,76	4,23	0,02	4	●	●	–	–	–	–	–	–

Recommended Starting Feeds [mm]

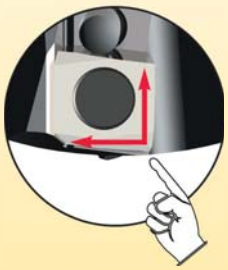
Light Machining	General Purpose	Heavy Machining

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.F..GD4W	0,23	**0,84**	1,41	0,17	**0,60**	1,01	0,13	**0,45**	0,75	0,11	**0,39**	0,66	0,10	**0,36**	0,60	.F..GD4W
.E..GD4W	0,26	**0,93**	1,67	0,19	**0,67**	1,19	0,14	**0,50**	0,88	0,12	**0,44**	0,77	0,11	**0,40**	0,70	.E..GD4W
.E..GD	0,26	**1,03**	1,90	0,19	**0,74**	1,35	0,14	**0,55**	1,00	0,12	**0,48**	0,87	0,11	**0,44**	0,80	.E..GD

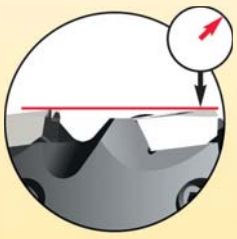
NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

Insert Loading Procedure

1. Clean insert and insert pocket seat.
2. Load insert — push insert against pin and axial pocket wall.
3. Tighten screw to a torque of 5 Nm.
4. Check the axial runout.
5. Do not exceed the maximum recommended RPM.







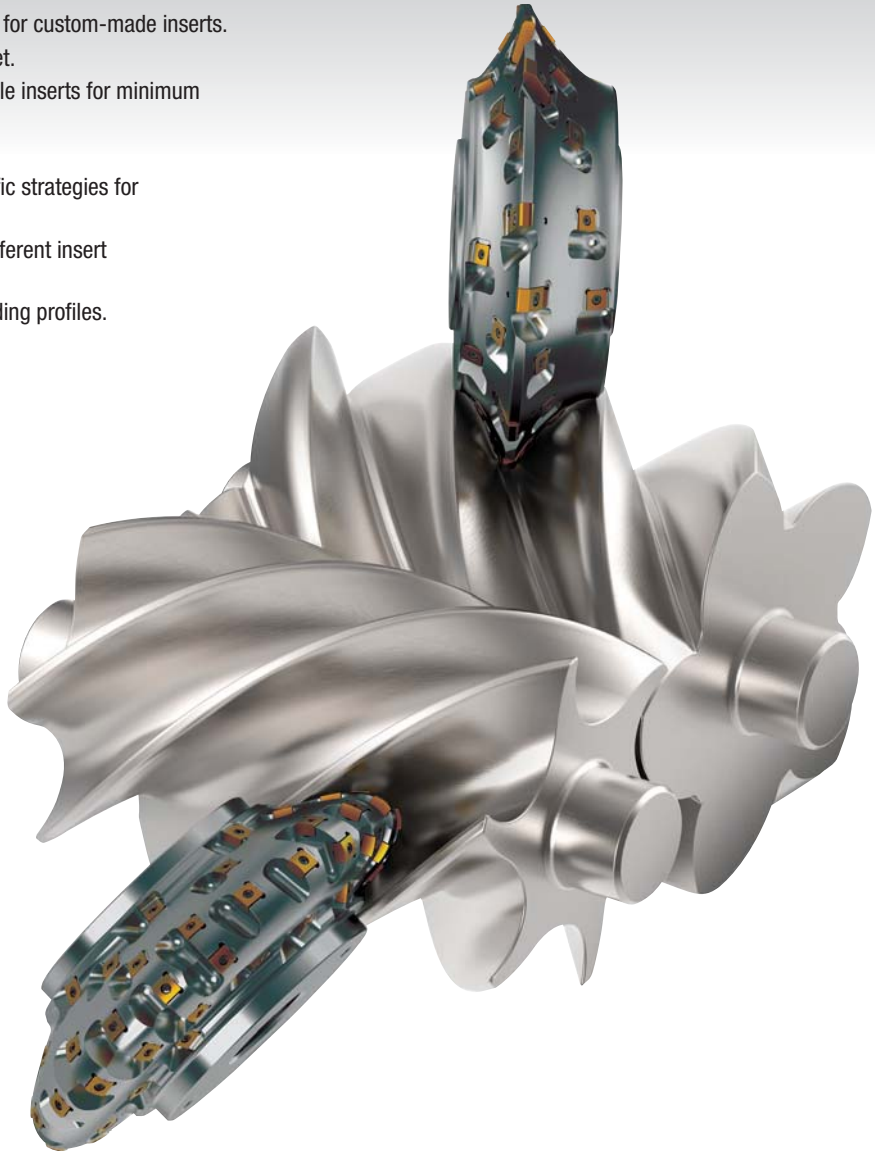
tool diameter (mm)	maximum axial runout	maximum RPM
63	10 µm	20000
80	10 µm	15900
100	10 µm	12750
125	10 µm	10200
160	15 µm	7950
200	15 µm	6350
250	15 µm	5100

Solution Capabilities

SCREW-ROTOR MILLING

Kennametal customers benefit from the highest service levels, our long-term experience, and application knowledge in milling of screw-rotors.

- Faster availability due to standardised processes for custom-made inserts.
- Solutions for all machines currently on the market.
- Very close contour profile with standardised profile inserts for minimum grinding allowance.
- Tools can be used in many different materials.
- Increased productivity through application-specific strategies for optimised milling.
- Smooth cutting action due to multiple rows of different insert alignments for optimum performance.
- Innovative solutions for small rotors with demanding profiles.

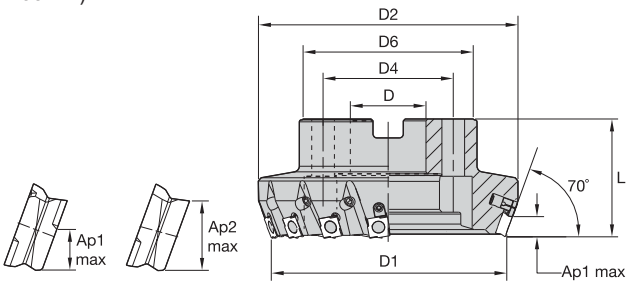


Experience the advantages at your Authorised Kennametal Distributor or at **kennametal.com**.

KENNAMETAL®

kennametal.com

- Eight cutting edges per insert.
- Rough and finish in one operation.
- Tangential mounted inserts deliver higher feed rates.
- Adjustable pockets (D1 = 80–160mm).



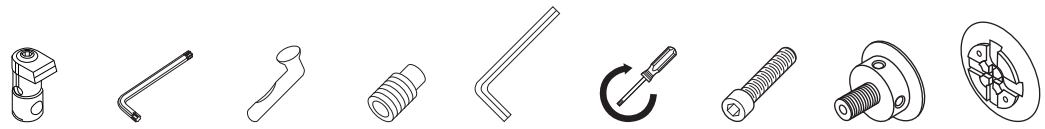
Ap1 max = 5,9mm (8 edges)
Ap2 max = 9,5mm (4 edges), reduce feed rate by 30%



Fix-Perfect 70° • Shell Mills

order number	catalogue number	D1	D	D2	D4	D6	L	Ap1 max	Z	Z ADJ	kg	max RPM
1503027	**50A04RP70SP12CFP**	50	22	62	–	42	43	5,9	4	0	0,50	6300
1887100	**50A05RP70SP12CFP**	50	22	62	–	42	43	5,9	5	0	0,50	6300
1501666	**50A06RP70SP12CFP**	50	22	62	–	42	43	5,9	6	0	0,50	6300
1503029	**63B05RP70SP12CFP**	63	22	75	–	54	40	5,9	5	0	0,70	5000
1887101	**63B07RP70SP12CFP**	63	22	75	–	54	40	5,9	7	0	0,75	5000
1501667	**63B08RP70SP12CFP**	63	22	75	–	54	40	5,9	8	0	0,75	5000
1503038	**80B06RP70SP12C1WFP**	80	27	92	–	64	50	5,9	6	1	1,20	4000
1887102	**80B08RP70SP12C2WFP**	80	27	92	–	64	50	5,9	8	2	1,30	4000
1501668	**80B10RP70SP12CFP**	80	27	92	–	64	50	5,9	10	0	1,30	4000
1503034	**100B08RP70SP12C2WFP**	100	32	112	–	84	50	5,9	8	2	2,00	3200
1887173	**100B12RP70SP12C3WFP**	100	32	112	–	84	50	5,9	12	3	2,10	3200
1501701	**100B14RP70SP12CFP**	100	32	112	–	84	50	5,9	14	0	2,00	3200
1503049	**125B10RP70SP12C2WFP**	125	40	137	–	94	63	5,9	10	2	3,20	2500
1503054	**160C12RP70SP12C3WFP**	160	40	173	66,7	94	63	5,9	12	3	4,20	2000
1887175	**160C18RP70SP12C3WFP**	160	40	173	66,7	94	63	5,9	18	3	4,40	2000
1503057	**200C16RP70SP12C4WFP**	200	60	212	101,6	134	63	5,9	16	4	6,50	1600

Spare Parts

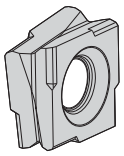


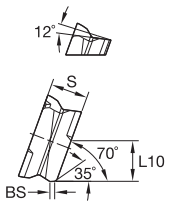
D1	cutting body design	adjusting element	Torx wrench	clamp stud	set screw	hex wrench	Nm	socket-head cap screw	coolant lock screw	coolant shower plate
50	FP	–	–	**410.081**	**121.612**	**170.003**	5,0	**125.025**	**420.100**	–
63	FP	–	–	**410.081**	**121.612**	**170.003**	5,0	–	**420.102**	–
80	WFP	**479.100**	**KT9**	**410.081**	**121.612**	**170.003**	5,0	–	**420.122**	–
80	FP	–	–	**410.081**	**121.612**	**170.003**	5,0	–	**420.122**	–
100	WFP	**479.100**	**KT9**	**410.081**	**121.612**	**170.003**	5,0	–	**420.160**	–
100	FP	–	–	**410.081**	**121.612**	**170.003**	5,0	–	**420.160**	–
125	WFP	**479.100**	**KT9**	**410.081**	**121.612**	**170.003**	5,0	–	**420.200**	**470.232**
160	WFP	**479.100**	**KT9**	**410.081**	**121.612**	**170.003**	5,0	–	**420.200**	**470.233**
200	WFP	**479.100**	**KT9**	**410.081**	**121.612**	**170.003**	5,0	–	–	**470.234**

NOTE: Please order spare parts separately.
For diameters of 125mm and 160mm, use the coolant screw and coolant cap spare parts together.
Torque wrench (DTQ50140, order number 6197561) and 3mm hex bit (BTQSW3L90, order number 6205876) may be purchased separately to ensure proper torque setting.

Insert Selection Guide

Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		←	→	toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	–	–	–	–	–	–
P3–P4	–	–	–	–	–	–
P5–P6	–	–	–	–	–	–
M1–M2	–	–	–	–	–	–
M3	–	–	–	–	–	–
K1–K2	.E..GP	KC520M	**.E..GP**	**KCK15**	.S..GP	KCK15
K3	.E..GP	KC520M	**.E..GP**	**KCK15**	.S..GP	KCK15
N1–N2	–	–	–	–	–	–
N3	–	–	–	–	–	–
S1–S2	–	–	–	–	–	–
S3	–	–	–	–	–	–
S4	–	–	–	–	–	–
H1	–	–	–	–	–	–


SPHX–GP



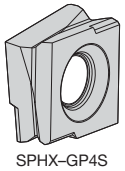
SPHX–GP

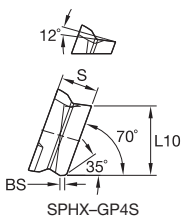
● first choice
○ alternate choice

P								
M								
K	●	●	●	○	○	●	●	
N								
S								
H								

SPHX-GP • Roughing

catalogue number	L10	S	BS	hm	cutting edges	K110M	KC520M	KCK15	KTPK20	KCPK30	KB1340	KY3500
SPHX1205ZCELGP	5,41	5,50	0,70	0,04	8	–	●	●	–	–	–	–
SPHX1205ZCERGP	5,41	5,50	0,70	0,04	8	–	●	●	–	●	–	–
SPHX1205ZCSRGP	5,41	5,50	0,70	0,14	8	–	–	●	–	●	–	–
SPHX1205ZCTLGPK	5,41	5,50	0,70	0,24	8	–	–	–	–	–	–	●
SPHX1205ZCTRGP	5,41	5,50	0,70	0,24	8	–	–	–	●	–	–	–
SPHX1205ZCTRGPK	5,41	5,50	0,70	0,24	8	–	–	–	–	–	–	●

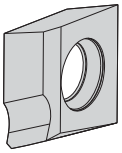

SPHX–GP4S

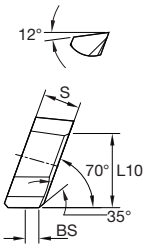


SPHX–GP4S

SPHX-GP4S • Roughing

catalogue number	L10	S	BS	hm	cutting edges	K110M	KC520M	KCK15	KTPK20	KCPK30	KB1340	KY3500
SPHX1205ZCERGP4S	10,04	5,50	0,70	0,04	4	–	–	●	–	–	–	–
SPHX1205ZCTRGP4SK	10,06	5,50	0,70	0,24	4	–	–	–	–	–	–	●


SPHX–W-GN



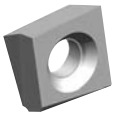
SPHX–W-GN

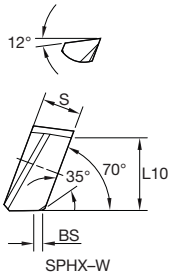
● first choice
○ alternate choice

		K110M	KC520M	KCK15	KTPK20	KCPK30	KB1340	KY3500
P								
M								
K		●	●	●	○	○	●	●
N								
S								
H								

SPHX-W • Finishing • GN

catalogue number	L10	S	BS	hm	cutting edges	K110M	KC520M	KCK15	KTPK20	KCPK30	KB1340	KY3500
SPHX1205ZCERGNT1W	10,00	5,50	2,00	0,02	1	–	–	–	–	–	●	–
SPHX1205ZCFRGN1W	10,00	5,50	2,00	0,02	1	–	●	●	–	–	–	–
SPHX1205ZCFRGN1WK	10,00	5,50	2,00	0,02	1	–	–	–	–	–	–	●


SPHX–W



SPHX–W

SPHX-W • Finishing • GP

catalogue number	L10	S	BS	hm	cutting edges	K110M	KC520M	KCK15	KTPK20	KCPK30	KB1340	KY3500
SPHX1205ZCER-GP1W	10,00	5,50	2,00	0,02	1	–	●	●	–	–	–	–
SPHX1205ZCTR-GP1WK	10,00	5,50	2,00	0,24	1	–	–	–	–	–	–	●

NOTE: SPHX-W: Wiper Facet BS = 2mm.

Face Milling

Recommended Starting Feeds

Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.E..GP	0,14	**0,49**	0,94	0,10	**0,36**	0,68	0,08	**0,27**	0,51	0,07	**0,23**	0,44	0,06	**0,21**	0,40	.E..GP
.T..GP	0,25	**0,63**	1,01	0,18	**0,45**	0,73	0,14	**0,34**	0,54	0,12	**0,30**	0,47	0,11	**0,27**	0,43	.T..GP
.S..GP	0,25	**0,63**	1,01	0,18	**0,45**	0,73	0,14	**0,34**	0,54	0,12	**0,30**	0,47	0,11	**0,27**	0,43	.S..GP

NOTE: Use "Light Machining" values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

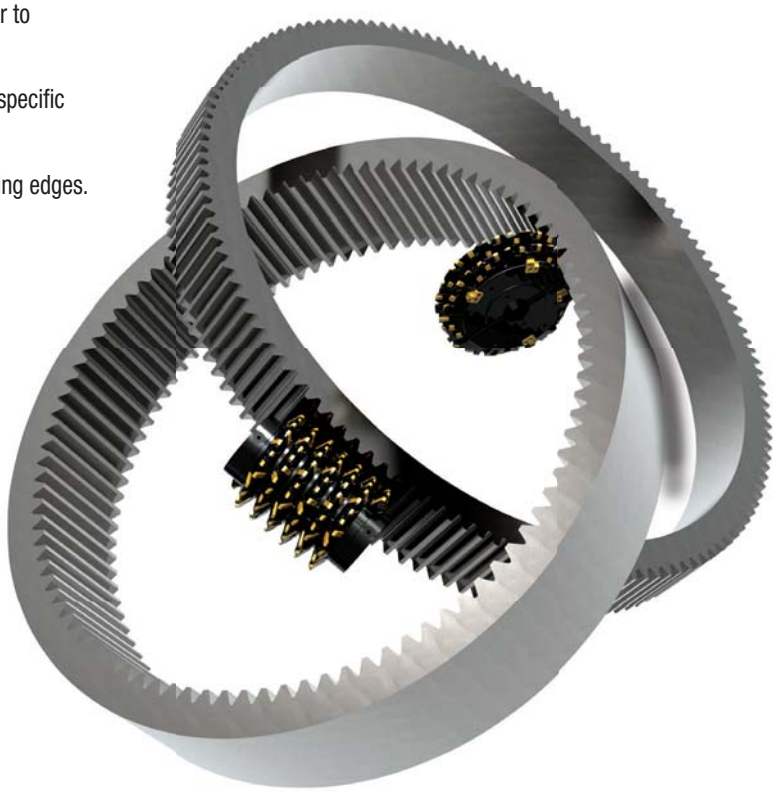
Productivity and Innovation — Powerful Gear Cutting Tools with Optimised Design

Gear Milling

Production requirements for large gears emphasise cost control with improved productivity. Our solutions feature higher cutting speeds, higher feed rates with lower power consumption, and increased productivity by using indexable inserts with up to eight cutting edges.

FEATURES AND BENEFITS

- Optimised cutting division, along with the use of positive cutting insert geometries, ensure low power requirements at higher feed rates.
- Tool wear is minimised by optimising the indexable insert number to achieve smoother cuts and increased productivity.
- Higher cutting speeds achieved through innovative and material-specific tailored cutting materials and geometries.
- Lower tooling costs due to indexable inserts with up to eight cutting edges.
- Easy insert changes made possible by better accessibility.



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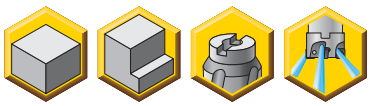
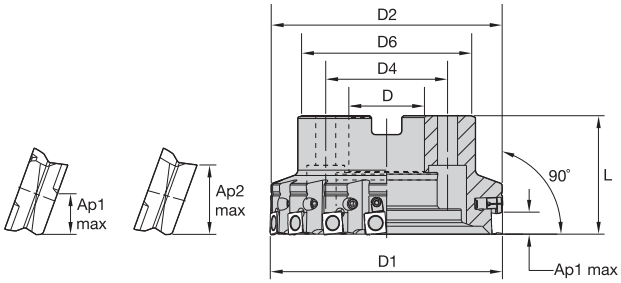
KENNAMETAL®

kennametal.com

- Eight cutting edges per insert.
- Rough and finish in one operation.
- Tangential mounted inserts enable higher feed rates.
- Adjustable pockets (D1 = 80–200mm).





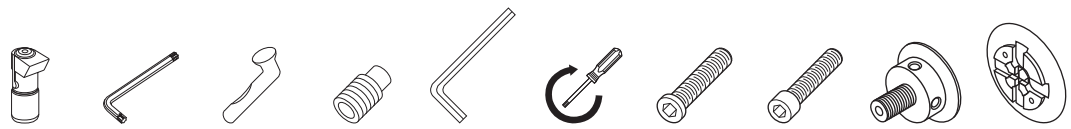
Ap1 max = 6mm (8 edges)
Ap2 max = 10mm (4 edges); reduce feed rate by 30%



Fix-Perfect 90° • Shell Mills

order number	catalogue number	D1	D	D2	D4	D6	L	Ap1 max	Z	Z ADJ	kg	max RPM
1503007	**50A04RP90SP12CFP**	50	22	48	–	41	43	6,0	4	0	0,35	6300
1501652	**50A05RP90SP12CFP**	50	22	48	–	41	43	6,0	5	0	0,36	6300
1503012	**63A06RP90SP12CFP**	63	22	61	–	51	40	6,0	6	0	0,59	5000
1887178	**63A07RP90SP12CFP**	63	22	61	–	51	40	6,0	7	0	0,60	5000
1501653	**63A08RP90SP12CFP**	63	22	61	–	51	40	6,0	8	0	0,60	5000
1503013	**80A06RP90SP12C1WFP**	80	27	79	–	64	50	6,0	6	1	1,12	4000
1887179	**80A08RP90SP12C2WFP**	80	27	79	–	64	50	6,0	8	2	1,15	4000
1501655	**80A10RP90SP12CFP**	80	27	79	–	64	50	6,0	10	0	1,15	4000
1503015	**100B08RP90SP12C2WFP**	100	32	99	–	84	50	6,0	8	2	1,70	3200
1887180	**100B12RP90SP12C3WFP**	100	32	99	–	84	50	6,0	12	3	1,80	3200
1501660	**100B14RP90SP12CFP**	100	32	98	–	84	50	6,0	14	0	1,90	3200
1503018	**125B10RP90SP12C2WFP**	125	40	123	–	94	63	6,0	10	2	2,85	2500
1887181	**125B15RP90SP12C3WFP**	125	40	123	–	94	63	6,0	15	3	3,00	2500
1503021	**160C12RP90SP12C3WFP**	160	40	158	66,7	94	63	6,0	12	3	3,90	2000
1887193	**160C18RP90SP12C3WFP**	160	40	158	66,7	94	63	6,0	18	3	4,00	2000
1503022	**200C16RP90SP12C4WFP**	200	60	199	101,6	134	63	6,0	16	4	6,10	1600
1887194	**200C24RP90SP12C4WFP**	200	60	199	101,6	134	63	6,0	24	4	6,30	1600

Spare Parts

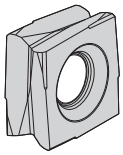


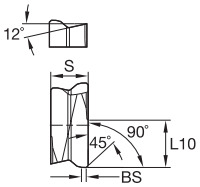
D1	cutting body design	adjusting element	Torx wrench	clamp stud	set screw	hex wrench	Nm	low-head cap screw	socket-head cap screw	coolant lock screw	coolant shower plate
50	FP	–	–	**410.081**	**121.612**	**170.003**	6,0	**129.025**	–	–	–
63	FP	–	–	**410.081**	**121.612**	**170.003**	6,0	–	**125.025**	**420.100**	–
80	WFP	**479.100**	**KT9**	**410.081**	**121.612**	**170.003**	6,0	–	**125.230**	**420.120**	–
80	FP	–	–	**410.081**	**121.612**	**170.003**	6,0	–	**125.230**	**420.120**	–
100	WFP	**479.100**	**KT9**	**410.081**	**121.612**	**170.003**	6,0	–	–	**420.160**	–
100	FP	–	–	**410.081**	**121.610**	**170.003**	6,0	–	–	**420.160**	–
125	WFP	**479.100**	**KT9**	**410.081**	**121.612**	**170.003**	6,0	–	–	**420.200**	**470.232**
160	WFP	**479.100**	**KT9**	**410.081**	**121.612**	**170.003**	6,0	–	–	**420.200**	**470.233**
200	WFP	**479.100**	**KT9**	**410.081**	**121.612**	**170.003**	6,0	–	–	–	**470.234**

NOTE: Please order spare parts separately.
For 125mm and 160mm diameter milling cutters, always use the coolant screw and coolant cap together.
Adjusting element 479.100 includes adjusting element screw 193.300.
Torque wrench (KTW45) and 3mm hex bit (69709922164) may be purchased separately to ensure proper torque setting.
An adjustable torque wrench (order number 6197561) and 3mm hex bit (order number 6205876) may be purchased separately.

Insert Selection Guide

Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		◄——►		toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	–	–	–	–	–	–
P3–P4	–	–	–	–	–	–
P5–P6	–	–	–	–	–	–
M1–M2	–	–	–	–	–	–
M3	–	–	–	–	–	–
K1–K2	.E..GPB	KC520M	**.E..GPB**	**KCK15**	.S..GPB	KCK15
K3	.E..GPB	KC520M	**.E..GPB**	**KCK15**	.S..GPB	KCK15
N1–N2	–	–	–	–	–	–
N3	–	–	–	–	–	–
S1–S2	–	–	–	–	–	–
S3	–	–	–	–	–	–
S4	–	–	–	–	–	–
H1	–	–	–	–	–	–


SPHX-GPB



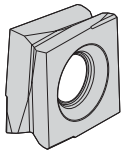
SPHX-GPB

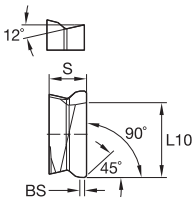
● first choice
○ alternate choice

		K110M	KC520M	KCK15	KTPK20	KCPK30	KC715M	KC725M	KB1340	KY3500
P							○	●		
M							○	●		
K		●	●	●	○	○			●	●
N										
S							○	●		
H										

SPHX-GPB • Roughing

catalogue number	L10	S	BS	hm	cutting edges	K110M	KC520M	KCK15	KTPK20	KCPK30	KC715M	KC725M	KB1340	KY3500
4.81201R011	6,50	5,50	–	0,04	8	–	–	●	–	–	–	–	–	–
SPHX1205PCELGPB	6,57	5,50	0,70	0,02	8	–	–	●	–	–	–	–	–	–
SPHX1205PCERGPB	6,57	5,50	0,70	0,02	8	–	●	●	–	●	–	–	–	–
SPHX1205PCSRGPB	6,57	5,50	0,70	0,14	8	–	–	●	–	●	–	●	–	–
SPHX1205PCTLGPBK	6,57	5,50	0,70	0,24	8	–	–	–	–	–	–	–	–	●
SPHX1205PCTRGPB	6,57	5,50	0,70	0,24	8	–	–	–	●	–	–	–	–	–
SPHX1205PCTRGPBK	6,57	5,50	0,70	0,24	8	–	–	–	–	–	–	–	–	●

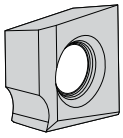

SPHX-GP4S

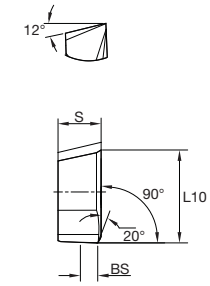


SPHX-GP4S

SPHX-GP4S • Roughing

catalogue number	L10	S	BS	hm	cutting edges	K110M	KC520M	KCK15	KTPK20	KCPK30	KC715M	KC725M	KB1340	KY3500
SPHX1205PCERGP4SB	11,07	5,50	0,70	0,02	4	–	●	●	–	–	–	–	–	–
SPHX1205PCTRGP4SBK	11,08	5,50	0,70	0,24	4	–	–	–	–	–	–	–	–	●


SPHX-GN1WB
SPHX-GN1WBK



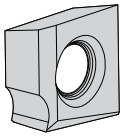
SPHX-GN1WB
SPHX-GN1WBK

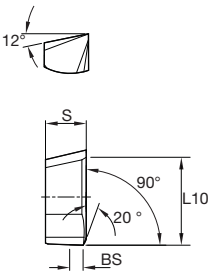
● first choice
○ alternate choice

		K110M	KC520M	KCK15	KTPK20	KCPK30	KC715M	KC725M	KB1340	KY3500
P							○	●		
M							○	●		
K		●	●	●	○	○			●	●
N										
S							○	●		
H										

SPHX-W • Finishing • GN

catalogue number	L10	S	BS	hm	cutting edges	K110M	KC520M	KCK15	KTPK20	KCPK30	KC715M	KC725M	KB1340	KY3500
SPHX1205PCERGN1WB	11,00	5,20	2,00	0,04	1	–	–	–	–	●	–	–	–	–
SPHX1205PCERGNT1WB	12,70	5,50	2,00	0,02	1	–	–	–	–	–	–	–	●	–
SPHX1205PCFLGN1WB	11,00	5,50	2,00	0,02	1	–	–	●	–	–	–	–	–	–
SPHX1205PCFRGN1WB	11,00	5,20	2,00	0,02	1	–	●	●	●	–	–	●	–	–
SPHX1205PCFRGN1WBK	11,00	5,20	2,00	0,02	1	–	–	–	–	–	–	–	–	●


SPHX-GP1WB



SPHX-GP1WB

SPHX-W • Finishing • GP

catalogue number	L10	S	BS	hm	cutting edges	K110M	KC520M	KCK15	KTPK20	KCPK30	KC715M	KC725M	KB1340	KY3500
SPHX1205PCER-GP1WB	11,00	5,50	2,00	0,02	1	–	●	●	–	–	–	–	–	–
SPHX1205PCTR-GP1WBK	11,00	5,50	2,00	0,24	1	–	–	–	–	–	–	–	–	●

Recommended Starting Feeds

Recommended Starting Feeds [mm]

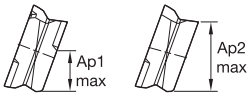
Light Machining	General Purpose	Heavy Machining

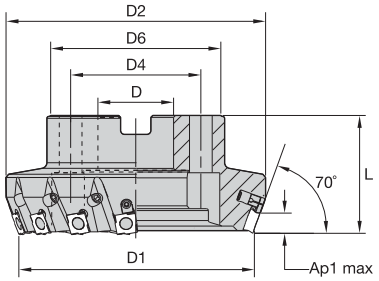
Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.E..GPB	0,12	**0,46**	0,82	0,08	**0,33**	0,59	0,06	**0,25**	0,44	0,06	**0,22**	0,38	0,05	**0,20**	0,35	.E..GPB
.T..GPB	0,23	**0,59**	0,95	0,17	**0,43**	0,68	0,13	**0,32**	0,51	0,11	**0,28**	0,44	0,10	**0,25**	0,41	.T..GPB
.S..GPB	0,23	**0,59**	0,95	0,17	**0,43**	0,68	0,13	**0,32**	0,51	0,11	**0,28**	0,44	0,10	**0,25**	0,41	.S..GPB

NOTE: Use "Light Machining" values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

- Rough and finish in one operation.
- Tangential mounted inserts deliver higher feed rates.
- Eight cutting edges per insert.







Ap1 max = 6,5mm (8 edges)
Ap2 max = 9,5mm (4 edges); reduce feed rate by 30%

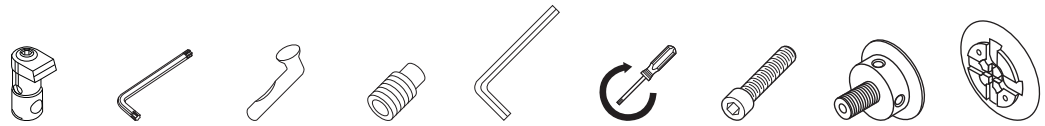


Fix-Perfect 70º • Shell Mills

order number	catalogue number	D1	D	D2	D4	D6	L	Ap1 max	Z	Z ADJ	kg	max RPM
1802594	**80A07RP70SP15C1WFP**	80	27	94	–	64	50	6,5	7	1	1,50	4000
1777661	**100B09RP70SP15C2WFP**	100	32	114	–	84	50	6,5	9	2	2,20	3200
1802595	**125B12RP70SP15C2WFP**	125	40	139	–	94	63	6,5	12	2	3,40	2500
1798199	**160C10RP70SP15C2WFP**	160	40	174	66,7	94	63	6,5	10	2	4,60	2000
1802596	**160C16RP70SP15C4WFP**	160	40	174	66,7	94	63	6,5	16	4	4,80	2000
1798200	**200C12RP70SP15C2WFP** *	200	60	214	101,6	134	63	6,5	12	2	6,90	1600

NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Spare Parts



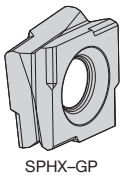
D1	Z	adjusting element	Torx wrench	clamp stud	set screw	hex wrench	Nm	socket-head cap screw	coolant lock screw	coolant shower plate
80	7	**479.100**	**KT9**	**410.084**	**121.616**	**170.003**	5,0	**125.230**	**420.120**	–
100	9	**479.100**	**KT9**	**410.084**	**121.612**	**170.003**	5,0	–	**420.160**	–
125	12	**479.100**	**KT9**	**410.084**	**121.612**	**170.003**	5,0	–	**420.200**	**470.232**
160	10	**479.100**	**KT9**	**410.084**	**121.616**	**170.003**	5,0	–	**420.200**	**470.233**
160	16	**479.100**	**KT9**	**410.084**	**121.612**	**170.003**	5,0	–	**420.200**	**470.233**
200	12	**479.100**	**KT9**	**410.084**	**121.616**	**170.003**	5,0	–	–	**470.234**

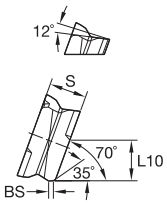
NOTE: Please order spare parts separately.
For 125mm and 160mm diameter milling cutters, always use the coolant screw and coolant cap together.
Adjusting element 479.100 includes adjusting element screw **193.300**.
Torque wrench (DTQ50140,order number 6197561) and 3mm hex bit (BTQSW3L90, order number 6205876) may be purchased separately to ensure proper torque setting.

Insert Selection Guide

Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		← →		toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	–	–	–	–	–	–
P3–P4	–	–	–	–	–	–
P5–P6	–	–	–	–	–	–
M1–M2	–	–	–	–	–	–
M3	–	–	–	–	–	–
K1–K2	.E..GP	KCK15	**.E..GP**	**KCK15**	.E..GP	KCK15
K3	.E..GP	KCK15	**.E..GP**	**KCK15**	.S..GP	KCPK30
N1–N2	–	–	–	–	–	–
N3	–	–	–	–	–	–
S1–S2	–	–	–	–	–	–
S3	–	–	–	–	–	–
S4	–	–	–	–	–	–
H1	–	–	–	–	–	–

Indexable Inserts • SPHX15T6...


SPHX–GP



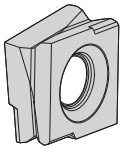
SPHX–GP

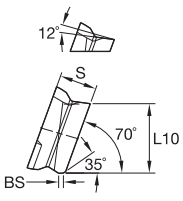
● first choice
○ alternate choice

P								
M								
K	●	●	●	○	○	●	●	
N								
S								
H								

SPHX-GP • Roughing

catalogue number	L10	S	BS	hm	cutting edges	K110M	KC520M	KCK15	KTPK20	KCPK30	KB1340	KY3500
SPHX15T6ZCERGP	6,52	6,60	1,20	0,02	8	–	–	●	–	●	–	–
SPHX15T6ZCSRGP	6,52	6,60	1,20	0,14	8	●	–	–	–	●	–	–
SPHX15T6ZCTRGPK	6,50	6,60	1,20	0,24	8	–	–	–	–	–	–	●

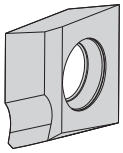

SPHX–GP4S

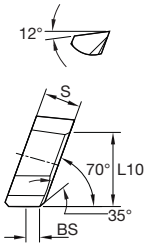


SPHX–GP4S

SPHX-GP4S • Roughing

catalogue number	L10	S	BS	hm	cutting edges	K110M	KC520M	KCK15	KTPK20	KCPK30	KB1340	KY3500
SPHX15T6ZCERGP4S	12,49	6,60	1,20	0,04	4	–	–	●	–	–	–	–
SPHX15T6ZCTRGP4SK	12,51	6,60	1,20	0,24	4	–	–	–	–	–	–	●


SPHX–W-GN



SPHX–W-GN

● first choice
○ alternate choice

		K110M	KC520M	KCK15	KTPK20	KCPK30	KB1340	KY3500
P								
M								
K		●	●	●	○	○	●	●
N								
S								
H								

SPHX-W • Finishing

catalogue number	L10	S	BS	hm	cutting edges	K110M	KC520M	KCK15	KTPK20	KCPK30	KB1340	KY3500
SPHX15T6ZCFRGN1W	11,00	6,60	2,70	0,02	1	–	–	●	–	–	–	–

NOTE: SPHX-W: Wiper Facet BS = 2,7mm.

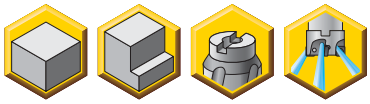
Recommended Starting Feeds [mm]

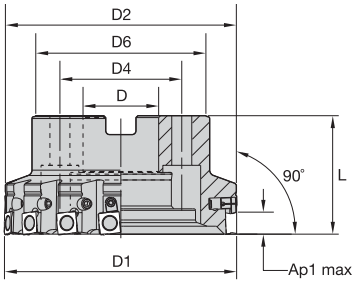
Light Machining	General Purpose	Heavy Machining

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.E..GP	0,12	**0,49**	0,87	0,09	**0,36**	0,62	0,07	**0,27**	0,47	0,06	**0,23**	0,41	0,05	**0,21**	0,37	.E..GP
.S..GP	0,25	**0,63**	1,01	0,18	**0,45**	0,73	0,14	**0,34**	0,54	0,12	**0,30**	0,47	0,11	**0,27**	0,43	.S..GP

NOTE: Use "Light Machining" values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

- Rough and finish in one operation.
- Tangential mounted inserts enable higher feed rates.
- Adjustable pockets (D1 = 80–250mm).
- Eight cutting edges per insert.





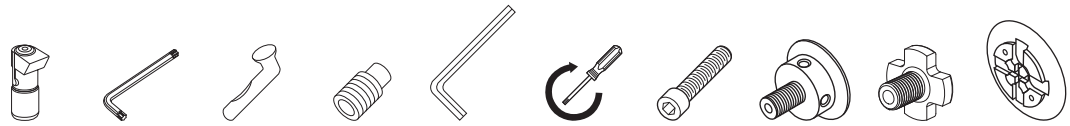
Ap1 max = 8mm (8 edges)
Ap2 max = 12mm (4 edges); reduce feed rate by 30%



Fix-Perfect 90° • Shell Mills

order number	catalogue number	D1	D	D2	D4	D6	L	Ap1 max	Z	Z ADJ	kg	max RPM
1795217	**80A05RP90SP15C1WFP**	80	27	78	–	64	50	8,0	5	1	1,12	4000
1798604	**80A06RP90SP15C1WFP**	80	27	78	–	64	50	8,0	6	1	1,20	4000
1777658	**100B08RP90SP15C2WFP**	100	32	99	–	84	50	8,0	8	2	1,80	3200
1798605	**125B10RP90SP15C2WFP**	125	40	123	–	94	63	8,0	10	2	3,00	2500
1795286	**160C10RP90SP15C2WFP**	160	40	158	66,7	94	63	8,0	10	2	4,10	2000
1795288	**200C12RP90SP15C2WFP**	200	60	198	101,6	134	63	8,0	12	2	6,40	1600

Spare Parts

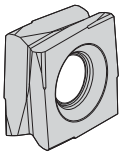


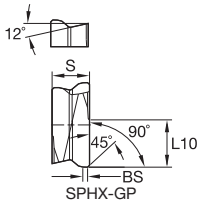
D1	Z	adjusting element	Torx wrench	clamp stud	set screw	hex wrench	Nm	socket-head cap screw	coolant lock screw	mill cutter lock screw	coolant shower plate
80	5	**479.100**	**KT9**	**410.084**	**121.616**	**170.003**	6,0	**125.230**	**420.120**	–	–
80	6	**479.100**	**KT9**	**410.084**	**121.616**	**170.003**	6,0	**125.230**	**420.120**	–	–
100	8	**479.100**	**KT9**	**410.084**	**121.612**	**170.003**	6,0	–	**420.160**	–	–
125	10	**479.100**	**KT9**	**410.084**	**121.612**	**170.003**	6,0	–	–	**420.200**	**470.232**
160	10	**479.100**	**KT9**	**410.084**	**121.616**	**170.003**	6,0	–	–	**420.200**	**470.233**
200	12	**479.100**	**KT9**	**410.084**	**121.616**	**170.003**	6,0	–	–	–	**470.234**

NOTE: Please order spare parts separately.
For 125mm and 160mm diameter milling cutters, the coolant screw and coolant cap should always used together.
Adjusting element 479.100 includes adjusting element screw 193.300.
Adjustable torque wrench (order number 6197561) and 3mm hex bit (order number 6205876) may be purchased separately in order to ensure proper torque setting.

Insert Selection Guide

Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		⟷		toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	–	–	–	–	–	–
P3–P4	–	–	–	–	–	–
P5–P6	–	–	–	–	–	–
M1–M2	–	–	–	–	–	–
M3	–	–	–	–	–	–
K1–K2	.E..GP	KC520M	**.E..GP**	**KCK15**	.E..GP	KCK15
K3	.E..GP	KC520M	**.E..GP**	**KCK15**	.S..GP	KCPK30
N1–N2	–	–	–	–	–	–
N3	–	–	–	–	–	–
S1–S2	–	–	–	–	–	–
S3	–	–	–	–	–	–
S4	–	–	–	–	–	–
H1	–	–	–	–	–	–


SPHX-GP



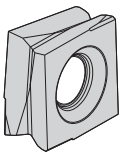
SPHX-GP

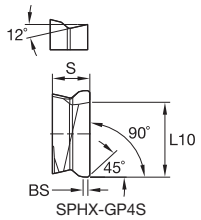
● first choice
○ alternate choice

		K110M	KC520M	KCK15	KTPK20	KCPK30	KC715M	KC725M	KB1340	KY3500
P						○	●		
M						○	●		
K		●	●	●	○	○			●	●
N										
S							○	●		
H										

SPHX-GP • Roughing

catalogue number	L10	S	BS	hm	cutting edges	K110M	KC520M	KCK15	KTPK20	KCPK30	KC715M	KC725M	KB1340	KY3500
SPHX15T6PCERGP	8,15	6,60	1,20	0,02	8	–	–	●	–	●	–	–	–	–
SPHX15T6PCSRGP	8,16	6,60	1,20	0,14	8	–	–	–	–	●	–	–	–	–
SPHX15T6PCTRGPK	8,15	6,60	1,20	0,24	8	–	–	–	–	–	–	–	–	●

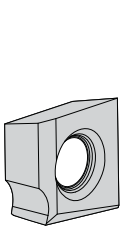

SPHX-GP4S

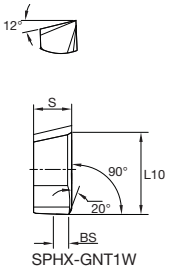


SPHX-GP4S

SPHX-GP4S • Roughing

catalogue number	L10	S	BS	hm	cutting edges	K110M	KC520M	KCK15	KTPK20	KCPK30	KC715M	KC725M	KB1340	KY3500
SPHX15T6PCERGP4S	13,88	6,60	1,20	0,04	4	–	–	●	–	–	–	–	–	–


SPHX-GNT1W



SPHX-GNT1W

● first choice
○ alternate choice

		K110M	KC520M	KCK15	KTPK20	KCPK30	KC715M	KC725M	KB1340	KY3500
P							○	●		
M							○	●		
K		●	●	●	○	○			●	●
N										
S							○	●		
H										

SPHX-W • Finishing

catalogue number	L10	S	BS	hm	cutting edges	K110M	KC520M	KCK15	KTPK20	KCPK30	KC715M	KC725M	KB1340	KY3500
SPHX15T6PCFRGN1W	14,40	6,20	2,70	0,02	1	–	–	●	–	–	–	–	–	–
SPHX15T6PCFRGN1WK	14,40	6,20	2,70	0,02	1	–	–	–	–	–	–	–	–	●
SPHX1205PCERGNT1WB	12,70	5,50	2,00	0,02	1	–	–	–	–	–	–	–	●	–

NOTE: SPHX-W: Wiper Facet BS = 2,7mm.

Recommended Starting Feeds

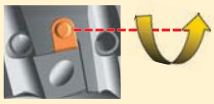
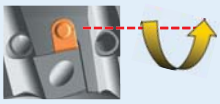
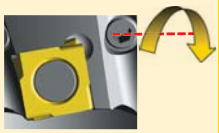
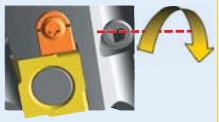
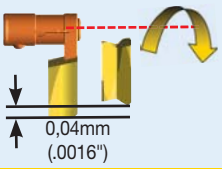
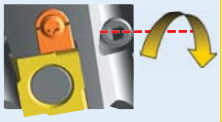
Recommended Starting Feeds [mm]

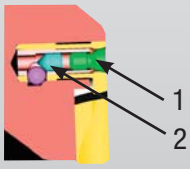
Light Machining	General Purpose	Heavy Machining

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.E..GP	0,12	**0,46**	0,82	0,08	**0,33**	0,59	0,06	**0,25**	0,44	0,06	**0,22**	0,38	0,05	**0,20**	0,35	.E..GP
.S..GP	0,23	**0,59**	0,95	0,17	**0,43**	0,68	0,13	**0,32**	0,51	0,11	**0,28**	0,44	0,10	**0,25**	0,41	.S..GP

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

Introduction to Fitting Cutting Bodies

procedures:	roughing		roughing/finishing	
	 fixed pocket	 adjustable pocket	 fixed pocket	 adjustable pocket
1 Reset adjusting element T x T9	–		–	
2 Insert roughing insert Tighten SW 3 M_{An} = 5 Nm				–
3 Tighten adjusting element gently	–		–	–
4 Insert finishing insert and pre-tighten SW 3 M_{VG} = 1 Nm	–	–	–	
5 The finishing insert is positioned 0,04mm in front of the highest roughing insert	–	–	–	
6 Tighten the finishing insert M_{An} = 5 Nm	–	–	–	



NOTE: This process must be repeated whenever an indexable insert is changed. The ball is loose.

Changing the adjusting element
1. Remove the taper screw①.
2. Loosen the SW 1,5 screw②.
3. Remove the adjusting element.

ATTENTION: The maximum permissible cutting speed of the milling cutter heads is vc max = 1000 m/min. Only use original parts when clamping the indexable inserts.

Next Generation of HexaCut™

Milling Inserts Are Now Available for Roughing and Semi-Finishing of Cast Iron Materials

Primary Application

The Kennametal HexaCut face milling programme is specifically engineered for rough and semi-finish face milling of cast, ductile, and compacted graphite iron. Twelve cutting edges drastically reduce your cost per edge and increase tool life. Shorter setup times and excellent cutter accuracy allow you to apply the HexaCut programme to the most demanding jobs. One ceramic and eight carbide grades with six insert geometries deliver high feed rates and will enable you to reach optimum horsepower.

Features and Benefits

- New insert topographies for existing HexaCut platform with latest cutting edge design.
- Specifically engineered for rough and semi-finish face milling of cast, ductile, and compacted graphite iron.
- Up to 20% better tool life and 10% less power consumption.
- High precision ground on insert IC to achieve a better axial and radial runout.
- First HexaCut roughing insert with integrated wiper facet for better floor finish.



New Standard Insert Offering for HexaCut™ Series

Roughing and semi-finishing of automotive engine blocks and other cast iron face milling operations.



HNHX0905..ENLE
New geometry for semi-finishing and light roughing operations.



HNHX0905ANSNGE
New geometry for roughing; integrated wiper facet for advanced floor finish.

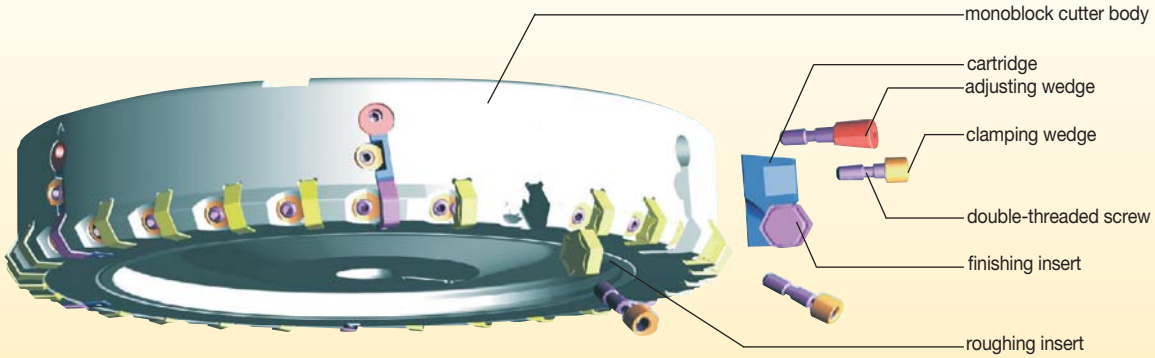


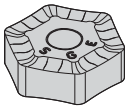
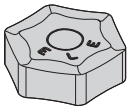
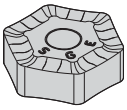
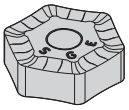
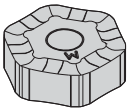
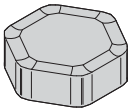
HNHX0905..SNGE
New geometry with improved rake and edge prep design for roughing operations.



HNPX0905..SNGE
New stable geometry for heavy roughing in severe machining conditions.

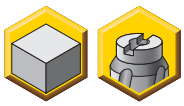
HexaCut 60° Cutter Body Design with Fixed and Adjustable Pocket Seats

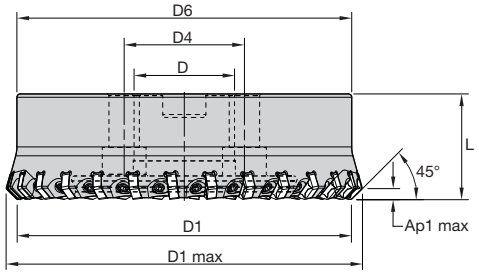


			▼= roughing indexable insert						▼▼ = finishing indexable insert
									
Recommended combination of standard indexable inserts and geometries			HNGX 090516 -SNGE Z = 12	HNHX 090516 - ENLE Z = 12	HNHX 090520 -ENLE Z = 12	HNHX 090520 -SGE Z = 12	HNHX 090530 -SNGE Z = 12	HNHX 0905 -ANSNGE Z = 12	HNGF 090504 -MF Z = 12
Operation	Lead	Ap max							
▼/▼▼	45°	6	■ OR	■ OR	■ OR	■	■	■	
▼	60°	8	■ OR	■ OR	■ OR	■	■		
▼▼	60°	1		■	■ OR	■ OR	■		■
▼/▼▼	60°	8	■ OR	■ OR	■ OR	■	■		

NOTE: Z = number of cutting edges.

- Monoblock cutter design.
- High feed rates.
- CGI milling solution.
- Twelve cutting edges per insert.







HexaCut 45° • Shell Mills • Monoblock Design • Right Hand

order number	catalogue number	D1	D1 max	D	D4	D6	L	Ap1 max	Z	kg	max RPM
2016107	**80A10RF45HN09C**	80	92,8	27	–	80	50	6,5	10	1,60	3900
2016109	**100B14RF45HN09C**	100	112,8	32	–	100	50	6,5	14	2,30	3400
2016111	**125B18RF45HN09C**	125	137,8	40	–	125	63	6,5	18	4,60	3000
2016133	**160C22RF45HN09C**	160	172,8	40	67	160	63	6,5	22	7,40	2600

NOTE: Split case design with adaptor flange for D1 = 250mm and D1 = 315mm can be ordered as preferred custom solution standard.

Spare Parts

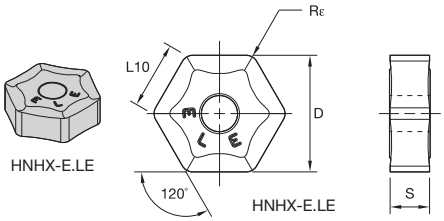
D1	clamp wedge	wrench screw	Nm	wrench 3mm
80	**12748358200**	**12748600900**	7,0	**12148044900**
100	**12748358200**	**12748600900**	7,0	**12148044900**
125	**12748358200**	**12748600900**	7,0	**12148044900**
160	**12748358200**	**12748600900**	7,0	**12148044900**

NOTE: Adjustable torque wrench (order number 6197561) and 3mm hex bit (order number 6205876) may be purchased separately in order to ensure proper torque setting.

Insert Selection Guide

Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		◄——►		toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	–	–	–	–	–	–
P3–P4	–	–	–	–	–	–
P5–P6	–	–	–	–	–	–
M1–M2	–	–	–	–	–	–
M3	–	–	–	–	–	–
K1–K2	.E..LE	KCK15	**.S..GE**	**KCK15**	.S..GE	KCK15
K3	.E..LE	KCK15	**.S..GE**	**KC514M**	.S..GE	KCK15
N1–N2	–	–	–	–	–	–
N3	–	–	–	–	–	–
S1–S2	–	–	–	–	–	–
S3	–	–	–	–	–	–
S4	–	–	–	–	–	–
H1	–	–	–	–	–	–

- For semi-finishing and light roughing operations.



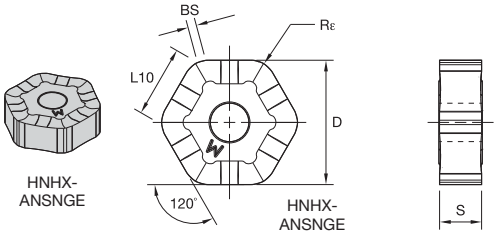
● first choice
○ alternate choice

	KC514M	KCK15	KCK20	KCPK30	KD200	KY3500
P						
M						
K	●	●	●	●	●	●
N						
S						
H						

HNHX-E.LE

catalogue number	D	S	L10	Rε	hm	cutting edges	KC514M	KCK15	KCK20	KCPK30	KD200	KY3500
HNHX090516ENLE	16,20	5,56	9,35	1,6	0,06	12	●	●	–	–	–	–
HNHX090520ENLE	16,20	5,56	9,35	2,0	0,06	12	●	●	–	–	–	–

- Roughing geometry with integrated wiper facet for advanced floor finish.



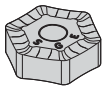
HNHX-ANSNGE

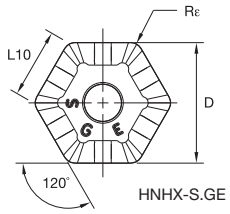
catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC514M	KCK15	KCK20	KCPK30	KD200	KY3500
HNHX0905ANSNGE	16,20	5,56	8,91	1,11	1,2	0,16	12	●	●	–	–	–	–

- Roughing geometry with improved rake design for lower cutting forces.

● first choice
○ alternate choice

P							
M							
K	●	●	●	●	●	●	●
N							
S							
H							


HNHX-S.GE

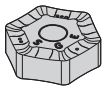


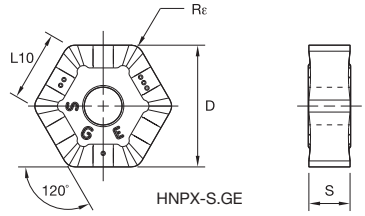
HNHX-S.GE

HNHX-S.GE

catalogue number	D	S	L10	Rε	hm	cutting edges	KC514M	KCK15	KCK20	KCPK30	KD200	KY3500
HNHX090516SNGE	16,20	5,56	9,35	1,6	0,16	12	●	●	–	●	–	–
HNHX090520SNGE	16,20	5,56	9,35	2,0	0,16	12	●	●	–	–	–	–
HNHX090530SNGE	16,20	5,56	9,35	3,0	0,16	12	–	●	–	–	–	–

- Heavy roughing geometry for severe machining conditions.

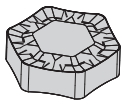

HNPX-S.GE

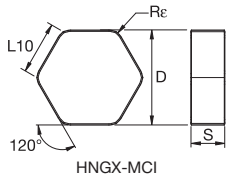


HNPX-S.GE

HNPX-S.GE

catalogue number	D	S	L10	Rε	hm	cutting edges	KC514M	KCK15	KCK20	KCPK30	KD200	KY3500
HNPX090516SNGE	16,20	5,56	9,35	1,6	0,16	12	–	●	–	–	–	–
HNPX090520SNGE	16,20	5,56	9,35	2,0	0,16	12	–	●	–	–	–	–
HNPX090530SNGE	16,20	5,56	9,35	3,0	0,16	12	–	●	–	–	–	–

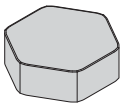

HNGX-MCI

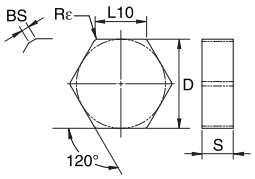


HNGX-MCI

HNGX-MCI

catalogue number	D	S	L10	Rε	hm	cutting edges	KC514M	KCK15	KCK20	KCPK30	KD200	KY3500
HNGX090530MCI	16,20	5,56	9,35	3,0	0,06	12	–	●	–	–	–	–


HNEN-SN



HNEN-SN

● first choice
○ alternate choice

P	
M	
K	● ● ● ● ● ●
N	
S	
H	

HNEN-SN

catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC514M	KCK15	KCK20	KCPK30	KD200	KY3500
HNEN090508MSN	15,88	5,56	9,17	–	0,8	0,20	12	–	–	–	–	–	●
HNEN0905AMSN	15,88	5,65	9,17	–	–	0,20	12	–	–	–	–	–	●
HNEN0905ANSN	15,88	5,65	9,17	–	–	0,20	12	–	–	–	–	●	–
HNEN0905XNSN	16,20	5,56	9,35	1,30	–	0,20	12	–	–	–	–	–	●

Recommended Starting Feeds

Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
...MCI	0,25	**0,65**	1,15	0,18	**0,47**	0,82	0,14	**0,35**	0,61	0,12	**0,31**	0,54	0,11	**0,28**	0,49	...MCI
.E..LE	0,26	**0,64**	1,17	0,19	**0,46**	0,84	0,14	**0,35**	0,63	0,12	**0,30**	0,54	0,11	**0,28**	0,50	.E..LE
.S..GE	0,33	**0,84**	1,35	0,24	**0,60**	0,97	0,18	**0,45**	0,72	0,16	**0,39**	0,63	0,14	**0,36**	0,57	.S..GE
...SN	0,33	**0,84**	1,35	0,24	**0,60**	0,97	0,18	**0,45**	0,72	0,16	**0,39**	0,63	0,14	**0,36**	0,57	...SN

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

Adjustment Instructions

Before Being Used for the First Time

- The milling cutter must be carefully cleaned of anti-corrosive materials, dust, etc.
- The milling cutter should only be washed when all components have been dismantled.
- Only the double-threaded screws of the clamping or adjusting wedge should be lubricated with copper grease; all other components must have clean metallic surfaces.
- A torque wrench is recommended to tighten the double-threaded screws.
- When fitting indexable inserts on the milling cutter, ensure that they are inserted in the correct position in a clean insert seat and that they are held in position during clamping.

For 45° Roughing Mills without Anvils

- The double-threaded screws on the clamping wedges for the indexable inserts are first pre-tightened to approximately 2 Nm and then tightened to a final torque of 7 Nm.

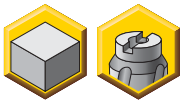
ATTENTION

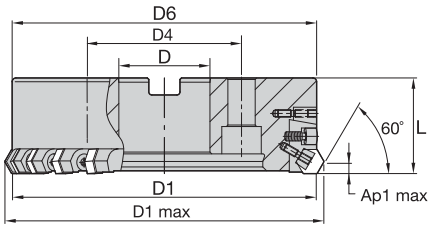
At each tool adjustment the body, indexable inserts, and spare parts must be checked and replaced, if necessary. Before each tool use the double-threaded screws of the indexable inserts and the stops must be tightened in the specified order to a torque of 7 Nm. In addition, even if the cartridges have not been adjusted, the double-threaded screws of the adjusting wedges must be checked to see if these have been tightened to a torque of 3 Nm. If not, they must be re-tightened to this torque.

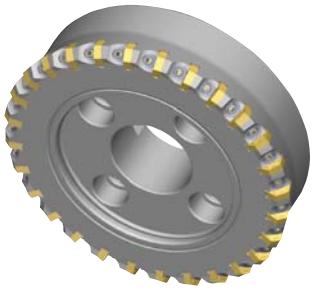
NOTE: The tools must only be used in accordance with their function. We accept no liability for their improper use. Changes of any kind and/or printing errors are not valid grounds for claims.



- Monoblock cutter design.
- High feed rates.
- CGI milling solution.
- Twelve cutting edges per insert.



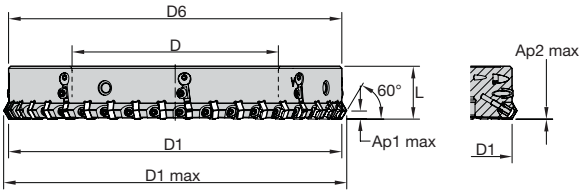




HexaCut 60° Shell Mills • Monoblock Cutter Design with Adjustable Pockets • Right Hand

order number	catalogue number	D1	D1 max	D	D4	D6	L	Ap1 max	Z	Z ADJ	kg	max RPM
2016165	**80A62RF60HN09C**	80	89	27	—	80	50	8,0	8	2	0,80	3900
2016167	**100B82RF60HN09C**	100	109	32	—	100	50	8,0	10	2	2,30	3400
2016169	**125B123RF60HN09C**	125	134	40	—	125	63	8,0	15	3	4,60	3000
2016171	**160C164RF60HN09C**	160	169	40	67	160	63	8,0	20	4	7,20	2600
2016193	**200C205RF60HN09C**	200	209	60	102	200	63	8,0	25	5	11,40	2300
6202331	**250C246RF60HN09C**	250	259	60	102	250	63	—	30	6	18,82	2000

NOTE: Cartridges need to be ordered separately.





HexaCut 60° Shell Mills • Split Case Design

order number	catalogue number	D1	D1 max	D	D6	L	Z	Z ADJ	kg	max RPM
6202333	**315Z328RF60HN09WSC** *	315	324	195	315	50	40	8	13,61	1800

NOTE: For carrier flange assembly order number, please see page S33.
*Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Spare Parts

D1	clamp wedge	axial adjustment wedge	screw	Nm	wrench 3mm
80	**12748358200**	**12748308500**	**12748600900**	7,0	**12148044900**
100	**12748358200**	**12748308500**	**12748600900**	7,0	**12148044900**
125	**12748358200**	**12748308500**	**12748600900**	7,0	**12148044900**
160	**12748358200**	**12748308500**	**12748600900**	7,0	**12148044900**
200	**12748358200**	**12748308500**	**12748600900**	7,0	**12148044900**

NOTE: Adjustable torque wrench (order number 6197561) and 3mm hex bit (order number 6205876) may be purchased separately in order to ensure proper torque setting.

Setup for Roughing:

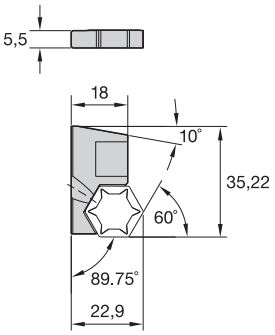
For a cutting depth of <8mm and an achievable surface finish of Ra >3,2.

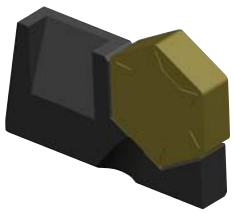
High-performance roughing:
HNHX0905ANSNGE, HNHX090516SNGE, HNHX090520SNGE, HNHX090530SNGE, HNPX090516SNGE, HNPX090520SNGE HNPX090530SNGE, HNEN0905XNSN.

Semi-finishing and light machining:
HNHX090516ENLE, HNHX090520ENLE, HNHX090530ENLE.

Same inserts to be loaded into fixed and adjustable (cartridges) pockets.

Roughing Cartridge





order number	catalogue number
2018164	12748500200

NOTE: Cartridges need to be ordered separately. Number of adjustable pockets (Z ADJ) related to cutting.

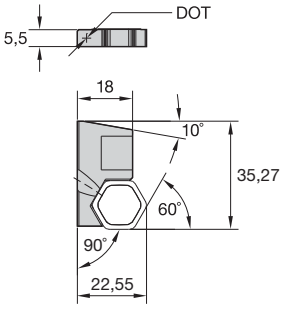
Setup for Finishing:

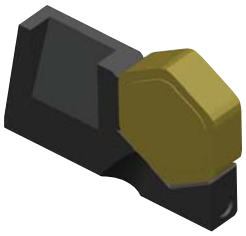
For a cutting depth of <1mm and an achievable surface finish of Ra 1,6.

Semi-finishing insert:
HNHX090520ENLE (loaded into fixed pocket seats).

Finishing wiper insert:
HNGF090504MF, HNGF090512MF (loaded into finishing cartridge).

Finishing Cartridge





order number	catalogue number
2018166	12748500400

NOTE: Cartridges need to be ordered separately. Number of adjustable pockets (Z ADJ) related to cutting.

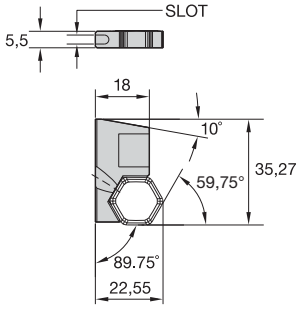
Setup for Finishing Cartridge for Low Axial Cutting Forces: (Reduced Lead Angle to Support Increased Clearance on the Wiper Edge).

For a cutting depth of <1mm and an achievable surface finish of Ra 1,6.

Semi-finishing insert:
HNHX090520ENLE (loaded into fixed pocket seats).

Finishing wiper insert:
HNGF090504MF, HNGF090512MF (loaded into finishing cartridge).

Finishing Cartridge for Low Axial Cutting Forces





order number	catalogue number
2033468	12748503400

NOTE: Cartridges need to be ordered separately. Number of adjustable pockets (Z ADJ) related to cutting.

CBN Cartridge

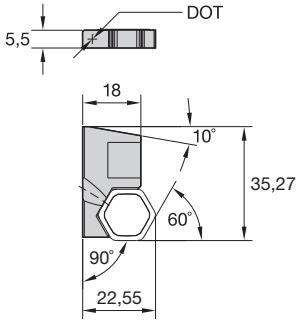
For a cutting depth of <1mm and an achievable surface finish of Ra 1,6.

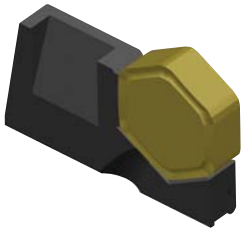
Semi-finishing insert:

HNEN0905AMSN KY3500 (loaded into fixed pocket seats).

Finishing wiper insert:

HNEN905ANSN KD200 (loaded into finishing cartridge).





order number	catalogue number
3400879	12748500500

Insert Selection Guide

Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		◄———	———►	toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	–	–	–	–	–	–
P3–P4	–	–	–	–	–	–
P5–P6	–	–	–	–	–	–
M1–M2	–	–	–	–	–	–
M3	–	–	–	–	–	–
K1–K2	.E..LE	KCK15	**.S..GE**	**KCK15**	.S..GE	KCK15
K3	.E..LE	KCK15	**.S..GE**	**KC514M**	.S..GE	KCK15
N1–N2	–	–	–	–	–	–
N3	–	–	–	–	–	–
S1–S2	–	–	–	–	–	–
S3	–	–	–	–	–	–
S4	–	–	–	–	–	–
H1	–	–	–	–	–	–

Inserts

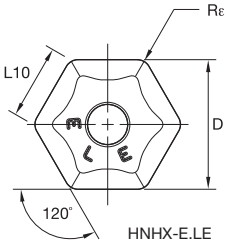
- For semi-finishing and light roughing operations.

● first choice
○ alternate choice

P						
M						
K	●	●	●	●	●	●
N						
S						
H						



HNHX-E.LE

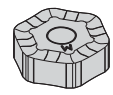


HNHX-E.LE

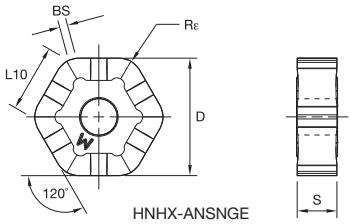
HNHX-E.LE

catalogue number	D	S	L10	Rε	hm	cutting edges	KC514M	KCK15	KCK20	KCPK30	KD200	KY3500
HNHX090516ENLE	16,20	5,56	9,35	1,6	0,06	12	●	●	–	–	–	–
HNHX090520ENLE	16,20	5,56	9,35	2,0	0,06	12	●	●	–	–	–	–

- Roughing geometry with integrated wiper facet for advanced floor finish.



HNHX-ANSNGE



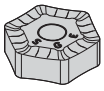
HNHX-ANSNGE

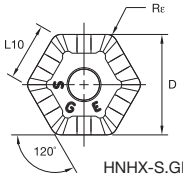
HNHX-ANSNGE

catalogue number	D	S	L10	Rε	hm	cutting edges	KC514M	KCK15	KCK20	KCPK30	KD200	KY3500
HNHX0905ANSNGE	16,20	5,56	8,91	1,2	0,16	12	●	●	–	–	–	–

Face Milling

- Roughing geometry with improved rake design for lower cutting forces.


HNHX-S.GE



HNHX-S.GE

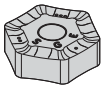
● first choice
○ alternate choice

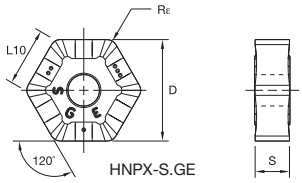
P							
M							
K	●	●	●	●	●	●	
N							
S							
H							

HNHX-S.GE

catalogue number	D	S	L10	Rε	hm	cutting edges	KC514M	KCK15	KCK20	KCPK30	KD200	KY3500
HNHX090516SNGE	16,20	5,56	9,35	1,6	0,16	12	●	●	–	–	–	–
HNHX090520SNGE	16,20	5,56	9,35	2,0	0,16	12	●	●	–	–	–	–
HNHX090530SNGE	16,20	5,56	9,35	3,0	0,16	12	–	●	–	–	–	–

- Heavy roughing geometry for severe machining conditions.

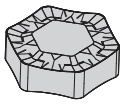

HNPX-S.GE

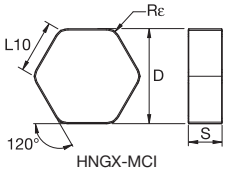


HNPX-S.GE

HNPX-S.GE

catalogue number	D	S	L10	Rε	hm	cutting edges	KC514M	KCK15	KCK20	KCPK30	KD200	KY3500
HNPX090516SNGE	16,20	5,56	9,35	1,6	0,16	12	–	●	–	–	–	–
HNPX090520SNGE	16,20	5,56	9,35	2,0	0,16	12	–	●	–	–	–	–
HNPX090530SNGE	16,20	5,56	9,35	3,0	0,16	12	–	●	–	–	–	–

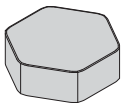

HNGX-MCI

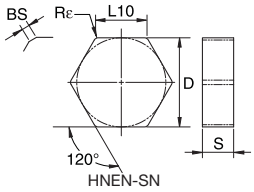


HNGX-MCI

HNGX-MCI

catalogue number	D	S	L10	Rε	hm	cutting edges	KC514M	KCK15	KCK20	KCPK30	KD200	KY3500
HNGX090530MCI	16,20	5,56	9,35	3,0	0,06	12	–	●	–	–	–	–


HNEN-SN



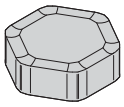
HNEN-SN

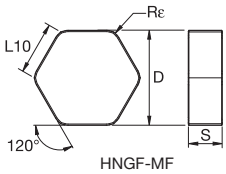
● first choice
○ alternate choice

P	
M	
K	●
N	
S	
H	

HNEN-SN

catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC514M	KCK15	KCK20	KCPK30	KD200	KY3500
HNEN090508MSN	15,88	5,56	9,17	–	0,8	0,20	12	–	–	–	–	–	●
HNEN0905AMSN	15,88	5,65	9,17	–	–	0,20	12	–	–	–	–	–	●
HNEN0905ANSN	15,88	5,65	9,17	–	–	0,20	12	–	–	–	–	●	–
HNEN0905XNSN	16,20	5,56	9,35	1,30	–	0,20	12	–	–	–	–	–	●


HNGF-MF



HNGF-MF

HNGF-MF

catalogue number	D	S	L10	Rε	hm	cutting edges	KC514M	KCK15	KCK20	KCPK30	KD200	KY3500
HNGF090504MF	15,88	5,56	9,16	0,4	0,04	12	●	●	●	–	–	–

Recommended Starting Feeds

Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40%–100%			
...MCI	0,21	**0,53**	0,93	0,15	**0,38**	0,67	0,11	**0,29**	0,50	0,10	**0,25**	0,44	0,09	**0,23**	0,40	...MCI
.E..LE	0,21	**0,52**	0,95	0,15	**0,38**	0,68	0,11	**0,28**	0,51	0,10	**0,25**	0,44	0,09	**0,23**	0,41	.E..LE
.S..GE	0,27	**0,68**	1,10	0,20	**0,49**	0,79	0,15	**0,37**	0,59	0,13	**0,32**	0,51	0,12	**0,29**	0,47	.S..GE
...SN	0,27	**0,68**	1,10	0,20	**0,49**	0,79	0,15	**0,37**	0,59	0,13	**0,32**	0,51	0,12	**0,29**	0,47	...SN

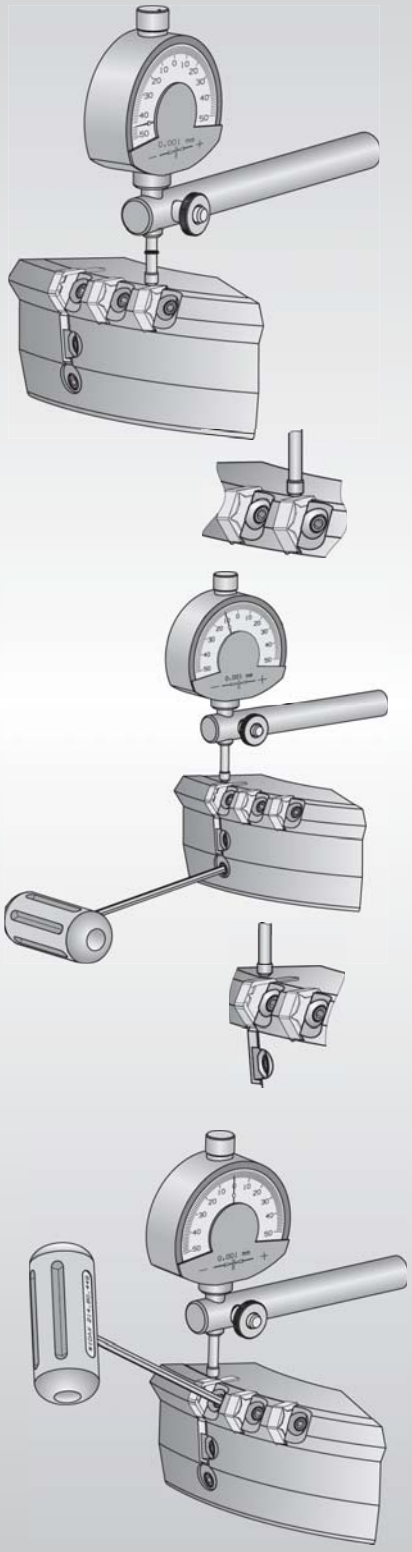
NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

Face Milling

Insert setting procedure

This procedure is to be used on all 60° lead roughing/finishing mills using the unmarked roughing cartridge, the finishing cartridge (marked •) and the corrected edge cartridge (marked ▬). These steps must be followed when adjusting the cutters for finishing inserts.

1. Clean all insert pockets.
2. Mount all wedges and cartridges. Torque the cartridge lock wedge screw to 3 Nm.
3. Mount all inserts, making sure they are seated properly in the pocket, and torque the insert lock wedge screws to 3 Nm.
4. Torque the wedge screws for all fixed pocket inserts to 7 Nm.
5. Loosen the cartridge insert wedge screw and the cartridge lock wedge screw.
6. Pressing the insert into the cartridge pocket, adjust the cartridge to 0,20–0,30mm below the fixed pocket inserts.
7. Torque the insert lock wedge screw and the cartridge lock wedge screw to 3 Nm.
8. Adjust the axial position to 0,03–0,04mm above the fixed pocket inserts.
9. Loosen the cartridge insert lock wedge screws and then re-torque to 3 Nm.
10. Adjust the axial position to the final dimension, 0,04–0,05mm above the highest fixed pocket insert.
11. Torque the insert lock wedge screws and the cartridge lock wedge screws to 7 Nm.
12. Conduct a final check of the axial runout and position.



The KSSR™ 84° Inserts

Primary Application

The Kennametal new line of KSSR 84º inserts are versatile, easy-to-use, and right- or *left-hand neutral, making them ideal for automotive machining operations or any other industry that relies on transfer line manufacturing. Available in carbide and ceramic grades for applications in cast and ductile irons and alloy steels, choose KSSR 84º inserts for all fine and coarse pitch styles.

*Left-hand cutters are available as non-stock standard.

Features and Benefits

KSSR 84° Features

- Available in metric and inch products, diameters from 63–200mm.
- Fine and coarse pitch styles.
- Easy-to-use and to adjust with shorter setup time.
- New wiper inserts in carbide and ceramic will provide excellent surface quality.

Improved Versatility

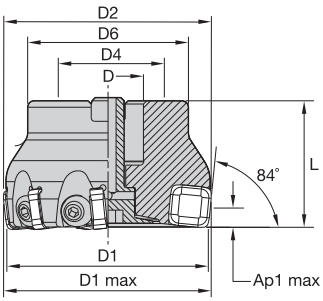
- Proven solution for the automotive segment.
- Right- and *left-hand cutters, ideal for transfer lines.
- Premium grades in carbide and ceramic for applications in cast and ductile irons and alloy steels.
- Inserts are neutral and can be used for right- or left-hand cutting.

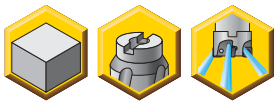


Unrivaled Benefits

- Capability: 5mm maximum depth of cut.
- Excellent accuracy:
  Radial = +/- 0,025mm
  Axial = adjustable +/- 0,002mm
- Inserts have eight true cutting edges.

- Eight cutting edges per insert.
- Fast and easy insert indexing.
- Highest feed rates.
- CGI specialist.



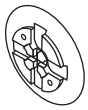




KSSR 84° • Shell Mills • Right Hand • Fixed Pockets

order number	catalogue number	D1	D1 max	D	D2	D4	D6	L	Ap1 max	Z	kg	max RPM
3331277	**63A06RF84SN12B**	63	65,0	22	62	–	50	40	5,0	6	0,61	7600
2465831	**63A09RF84SN12B**	63	65,0	22	64	–	50	40	5,0	9	0,60	7600
3331279	**80A08RF84SN12B**	80	82,0	27	79	–	60	50	5,0	8	1,26	6000
2443937	**80A12RF84SN12B**	80	82,0	27	80	–	60	50	5,0	12	1,25	6000
3120845	**100B10RF84SN12B**	100	102,0	32	99	–	78	50	5,0	10	1,78	4800
2443938	**100B15RF84SN12B**	100	102,0	32	100	–	78	50	5,0	15	1,75	4800
2465832	**125B18RF84SN12B**	125	127,0	40	125	–	89	63	5,0	18	3,10	3800
2466093	**160C24RF84SN12B**	160	162,0	40	160	67	90	63	5,0	24	3,90	3000
2466094	**200C30RF84SN12B**	200	202,0	60	200	102	130	63	5,0	30	6,40	2400

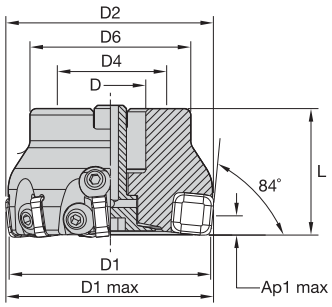
Spare Parts

D1	 clamp wedge	 wedge screw	 Nm	 wrench 3mm	 coolant screw	 coolant shower plate
63	**12748358200**	**12748600900**	7,0	**12148044900**	**420.100**	**–**
80	**12748358200**	**12748600900**	7,0	**12148044900**	**420.120**	**–**
100	**12748358200**	**12748600900**	7,0	**12148044900**	**420.163**	**–**
125	**12748358200**	**12748600900**	7,0	**12148044900**	**420.200**	**470.232**
160	**12748358200**	**12748600900**	7,0	**12148044900**	**420.200**	**470.233**
200	**12748358200**	**12748600900**	7,0	**12148044900**	**–**	**470.234**

NOTE: Coolant screw and coolant cap must be ordered separately.
2466094 and 2466095 are non-stock standard.
Adjustable torque wrench (order number 6197561) and 3mm hex bit (order number 6205876) may be purchased separately in order to ensure proper torque setting.
Left-hand cutters available as non-stock standard.

- High feed rates.
- Excellent floor finish.
- Eight cutting edges per insert.



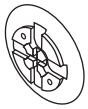




KSSR 84° • Shell Mills • Adjustable Pockets • Right Hand

order number	catalogue number	D1	D1 max	D	D2	D4	D6	L	Ap1 max	Z	Z ADJ	kg	max RPM
4004750	**63A09RF84SN12B1W**	63	65,1	22	62	–	50	40	5,0	9	1	0,67	7600
4004751	**80A12RF84SN12B2W**	80	82,1	27	79	–	60	50	5,0	12	2	1,33	6000
4004752	**100B15RF84SN12B3W**	100	102,1	32	99	–	78	50	5,0	15	3	1,85	4800
4004793	**125B18RF84SN12B3W**	125	127,1	40	123	–	89	63	5,0	18	3	3,20	3800
4004794	**160C24RF84SN12B3W**	160	162,1	40	158	67	90	63	5,0	24	3	4,14	3000

Spare Parts

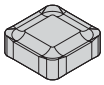
D1	 clamp wedge	 wedge screw	 Nm	 wrench	 coolant lock screw	 coolant shower plate
63	**12748358200**	**12748600900**	7,0	**12148044900**	**420.100**	**–**
80	**12748358200**	**12748600900**	7,0	**12148044900**	**420.120**	**–**
100	**12748358200**	**12748600900**	7,0	**12148044900**	**420.163**	**–**
125	**12748358200**	**12748600900**	7,0	**12148044900**	**420.200**	**470.232**
160	**12748358200**	**12748600900**	7,0	**12148044900**	**420.200**	**470.233**

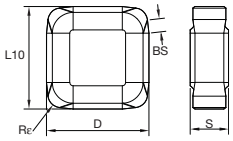
NOTE: Adjustable torque wrench (order number 6197561) and 3mm hex bit (order number 6205876) may be purchased separately in order to ensure proper torque setting.
Left-hand cutters available as non-stock standard.

Insert Selection Guide

Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		◄——►		toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1 – P2	–	–	–	–	–	–
P3 – P4	–	–	–	–	–	–
P5 – P6	–	–	–	–	–	–
M1 – M2	–	–	–	–	–	–
M3	–	–	–	–	–	–
K1 – K2	.E..LD	KCK15	**.S..GP**	**KCK15**	.A..SN	KY3500
K3	.E..LD	KCK20	**.S..GP**	**KCK20**	.S..HE	KCK20
N1 – N2	–	–	–	–	–	–
N3	–	–	–	–	–	–
S1 – S2	–	–	–	–	–	–
S3	–	–	–	–	–	–
S4	–	–	–	–	–	–
H1	–	–	–	–	–	–

Indexable Inserts • KSSR


SNXF-LD



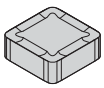
SNXF-LD

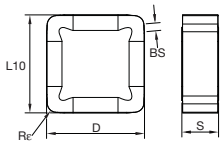
● first choice
○ alternate choice

P	
M	
K	● ● ● ● ● ●
N	
S	
H	

SNXF-LD

catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC514M	KC524M	KCK15	KCK20	KCPK30	KY3500
SNXF120412ENLD	12,70	4,56	12,70	–	1,2	0,06	8	●	●	●	●	●	–
SNXF1204ZNENLD	12,70	4,42	12,70	1,69	1,6	0,06	8	●	●	●	●	●	–


SNXF-GP

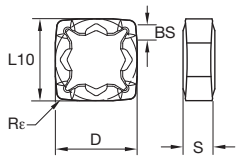


SNXF-GP

SNXF-GP

catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC514M	KC524M	KCK15	KCK20	KCPK30	KY3500
SNXF120412SNGP	12,70	4,68	12,70	–	1,2	0,06	8	●	●	●	●	●	–
SNXF1204ZNSNGP	12,70	4,68	12,70	1,00	1,2	0,07	8	●	●	●	●	●	–

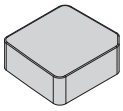

SNXF-HE

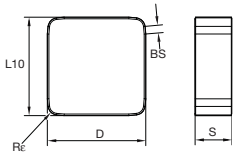


SNXF-HE

SNXF-HE

catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC514M	KC524M	KCK15	KCK20	KCPK30	KY3500
SNXF120412SNHE	12,70	4,66	12,70	–	1,2	0,06	8	–	●	●	●	●	–
SNXF1204ZNSNHE	12,70	4,66	12,70	1,00	1,2	0,06	8	●	–	●	●	●	–


SNXF-SN



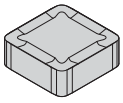
SNXF-SN

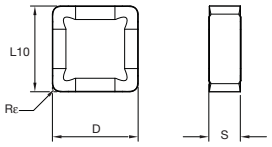
● first choice
○ alternate choice

P							
M							
K	●	●	●	●	●	●	
N							
S							
H							

SNXF-SN

catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC514M	KC524M	KCK15	KCK20	KCPK30	KY3500
SNXF120412AMSN	12,70	4,76	12,70	–	1,2	0,20	8	–	–	–	–	–	●
SNXF1204ZNAMSN	12,70	4,76	12,70	1,00	1,2	0,20	8	–	–	–	–	–	●

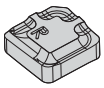

SNPF-GP

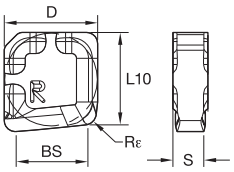


SNPF-GP

SNPF-GP

catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC514M	KC524M	KCK15	KCK20	KCPK30	KY3500
SNPF120412SNGP	12,70	4,76	12,70	–	1,2	0,07	8	–	–	●	–	–	–


XNXF-LDW



XNXF-LDW

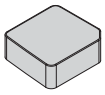
● first choice
○ alternate choice

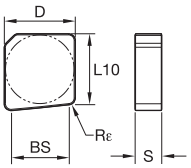
P	
M	
K	●
N	
S	
H	

XNXF-LDW

catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC514M	KC524M	KCK15	KCK20	KCPK30	KY3500
XNXF1204ZNENLDW	12,70	4,42	12,70	9,50	1,6	0,06	2	–	–	●	–	–	–

NOTE: Insert has one left-handed and one right-handed cutting edge.


XNXF-ENW



XNXF-ENW

XNXF-ENW

catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC514M	KC524M	KCK15	KCK20	KCPK30	KY3500
XNXF1204ZNENW	12,70	4,76	12,70	9,50	1,2	0,20	2	–	–	–	–	–	●

Recommended Starting Feeds • 84° Approach Angle

Face Milling

Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.E..LD	0,18	**0,46**	0,82	0,13	**0,33**	0,59	0,10	**0,25**	0,44	0,09	**0,22**	0,39	0,08	**0,20**	0,35	.E..LD
.S..GP	0,20	**0,50**	0,90	0,14	**0,36**	0,65	0,11	**0,27**	0,48	0,09	**0,24**	0,42	0,09	**0,22**	0,39	.S..GP
.S..HE	0,18	**0,51**	0,95	0,13	**0,37**	0,69	0,10	**0,28**	0,51	0,09	**0,24**	0,45	0,08	**0,22**	0,41	.S..HE
.A..SN	0,24	**0,59**	0,95	0,17	**0,43**	0,69	0,13	**0,32**	0,51	0,11	**0,28**	0,45	0,10	**0,26**	0,41	.A..SN

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

KM4X™



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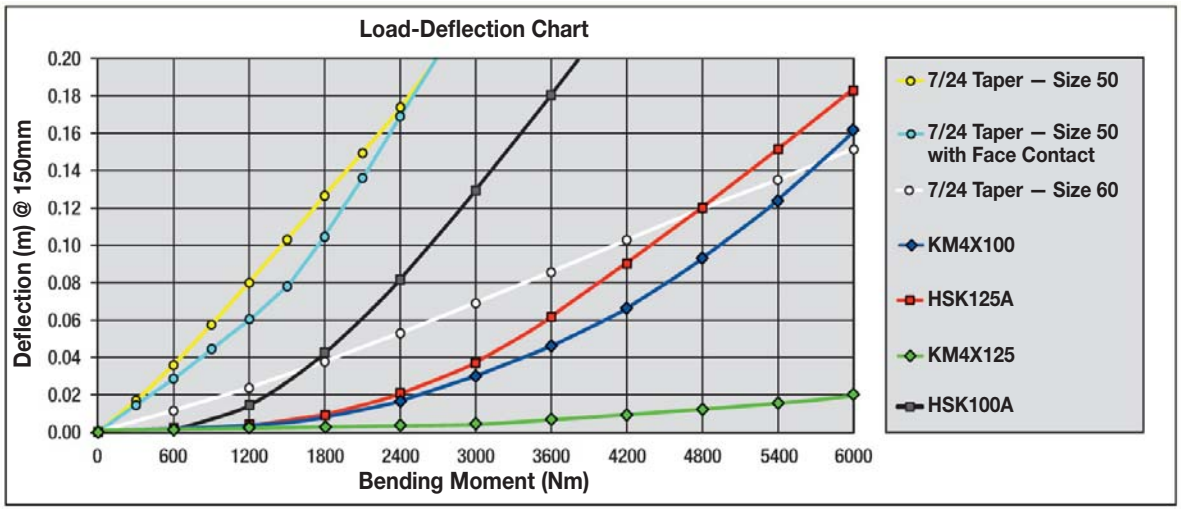
Dramatically increase your metal removal rates when machining high-temperature alloys!

- Run jobs at significantly faster feeds and speeds than what is achievable with other spindle interfaces.
- Unique use of clamping force and interference level increases clamping capability 2 to 3 times.
- Achieve lower cost of ownership, increased throughput, and superior results.



Visit **kennametal.com** or contact your local Authorised Kennametal Distributor.

KENNAMETAL®

kennametal.com

KCFM™ 45

Cast Iron Finishing Milling

KCFM 45 is the latest full-face PcBN technology for milling inserts. These inserts are available in PcBN, ceramic, and carbide grades, with a super-positive geometry available on semi-finisher and wiper style inserts.

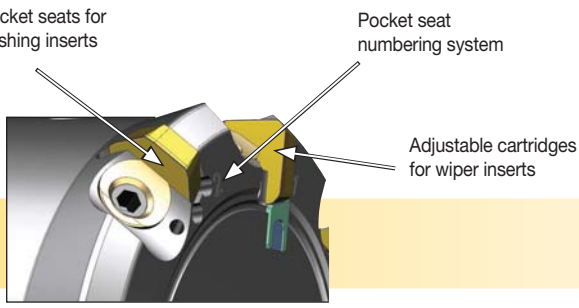
Cutter bodies feature high-precision pocket seats and a pocket seat numbering system to reduce tool setup time.

Features and Benefits

- Super-positive geometry on semi-finisher and wiper inserts.
- New PcBN milling grade KBK50 for fine-finishing cast iron.
- Fixed pocket seats for semi-finishing inserts.
- Adjustable pocket seats for wiper inserts.
- Cartridges available for semi-finishing inserts.
- Low cutting forces to manage vibrations at critical components.
- Significantly reduced machining cycle time and cost per part.
- High precision pocket seats to reduce tool setup time.
- User friendly adjustment for accurate run-out within two microns.
- Only use semi-finishing inserts for lower floor finish requirement.

First choice for easy fine finishing with low cutting forces and excellent tool life.





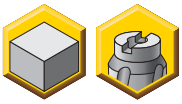
For lower requirement on surface floor finish, it's also an option to load all pocket seats with semi-finishing inserts.

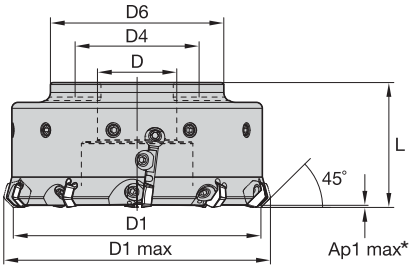
Related cartridge KCFMCA45HD07 is available as standard line item.

Configuration of Semi-Finishing and Wiper Inserts:

Semi-Finishing Insert HDHN07 	Wiper Insert SDHN12 	Dry (D)/Wet (W) Machining
PcBN (KBK50)	PcBN (KBK50)	D
Ceramic (KY3500)	PcPN (KBK50)	D
Carbide (KC514M)	Carbide (KC514M)	D/W

- Lower cutting forces due to positive hexagon inserts.
- Available in PCBN, ceramic, and carbide grades.
- Achieve higher speeds and productivity with ceramic and PCBN grades.
- *Ap1 max = 1mm with wiper finishing cartridge for SD12 inserts.
- *Ap1 max = 3mm with semi-finishing cartridge for HD07 inserts.







KCFM 45 • Shell Mill Cutter

order number	catalogue number	D1	D1 max	D	D4	D6	L	Ap1 max*	Z	Z ADJ	kg	max RPM
6224238	**KCFM080R08HD07W2**	80	90	27	–	81	50	1	6	2	1,68	9600
6224239	**KCFM100R08HD07W2**	100	110	32	–	101	50	1	6	2	2,42	8400
6224240	**KCFM125R10HD07W2**	125	135	40	–	89	63	1	8	2	4,29	7400
6224411	**KCFM160R12HD07W4**	160	170	40	67	90	63	1	8	4	5,83	6500
6224412	**KCFM200R16HD07W4**	200	210	60	102	130	63	1	12	4	8,80	5700
6224413	**KCFM250R24HD07W6**	250	260	60	102	130	63	1	18	6	10,89	5100

NOTE: Cutter bodies only; cartridges need to be ordered separately.
Z = Total number of inserts in the cutter body.
Z ADJ = Number of adjustable cartridges.

Spare Parts

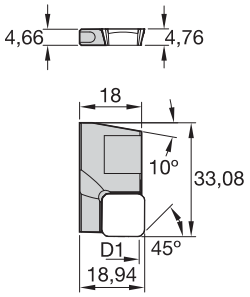


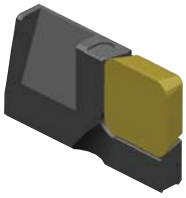




D1	socket-head cap screw	Nm	wrench	wedge	flat point socket set screw
80	**MS1198**	7,0	**12148044900**	**12748358200**	**193.461**
100	**–**	7,0	**12148044900**	**12748358200**	**193.461**
125	**–**	7,0	**12148044900**	**12748358200**	**193.461**
160	**–**	7,0	**12148044900**	**12748358200**	**193.461**
200	**–**	7,0	**12148044900**	**12748358200**	**193.461**
250	**–**	7,0	**12148044900**	**12748358200**	**193.461**

- Lower cutting forces due to positive hexagon inserts.
- Available in PCBN, ceramic, and carbide grades.
- Achieve higher speeds and productivity with ceramic and PCBN grades.
- *Ap1 max = 1mm with wiper finishing cartridge for SD12 inserts.
- *Ap1 max = 3mm with semi-finishing cartridge for HD07 inserts.

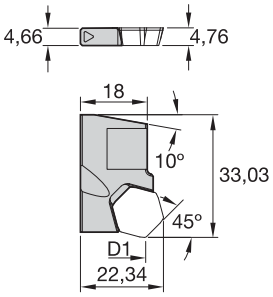


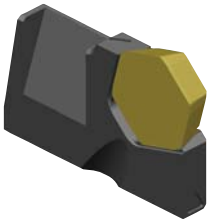


KCFM • Wiper Finishing Cartridge for SD12 Insert

order number	catalogue number	kg
6210836	KCFMCA45SD12C	0,01

NOTE: SD12 can be mounted for fine finishing operations, Ap1 max is 1mm.
Cartridges to be order separately. Number of adjustable pockets (Z ADJ) is related to cutting diameter.





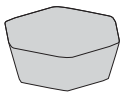
KCFM • Semi-Finishing Cartridge for HD07 insert

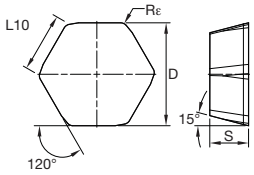
order number	catalogue number	kg
6210837	KCFMCA45HD07	0,02

NOTE: HD07 only inserts can be mounted without the wiper for semi-finishing operations, Ap1 max is 3mm.
Cartridges to be order separately. Number of adjustable pockets (Z ADJ) is related to cutting diameter.

Insert Selection Guide

Material Group	Fine Finishing		Semi-Finishing		Roughing	
	Option 1: CBN	Option 2: Coated Carbide	Option 1: Advanced Material	Option 2: Coated Carbide		
P1–P2	–	–	–	–	–	–
P3–P4	–	–	–	–	–	–
P5–P6	–	–	–	–	–	–
M1–M2	–	–	–	–	–	–
M3	–	–	–	–	–	–
K1–K2	.S..R KBK50	.E..R KC514M	**.S..R KY3500/KBK50**	**.E..R KC514M**	–	–
K3	–	.E..R KC514M	–	**.E..R KC514M**	–	–
N1–N2	–	–	–	–	–	–
N3	–	–	–	–	–	–
S1–S2	–	–	–	–	–	–
S3	–	–	–	–	–	–
S4	–	–	–	–	–	–
H1	–	–	–	–	–	–

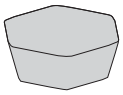


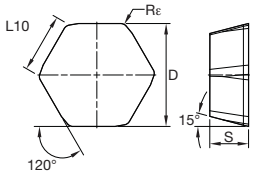


P			
M			
K	●	●	●
N			
S			
H			

KCFM • HDHN07-ER

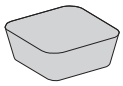
catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC514M	KBK50	KY3500
HDHN070408ER	12,70	4,76	5,20	–	0,8	0,1	6	●	–	–

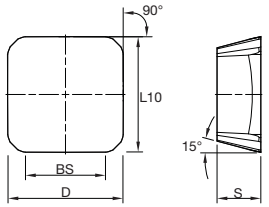




KCFM • HDHN07-SR

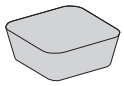
catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC514M	KBK50	KY3500
HDHN070408SR	12,70	4,76	5,20	–	0,8	0,1	6	–	●	●

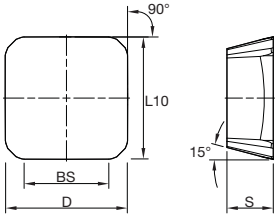




KCFM • SDHN12-EN4W

catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC514M	KBK50	KY3500
SDHN1204ZZEN4W	12,70	4,76	12,60	8,70	–	0,1	4	●	–	–





KCFM • SDHN12-SN4W

catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC514M	KBK50	KY3500
SDHN1204ZZSN4W	12,70	4,76	12,58	8,70	–	0,1	4	–	●	–

Face Milling

Recommended Starting Feeds

Recommended Starting Feeds [mm]

Fine Finishing	Semi-Finishing	Roughing

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
-SR													0,06	**0,12**		-SR
-ER													0,10	**0,18**		-ER

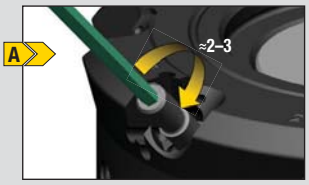
NOTE: Please see pages X22–X37 for recommended starting speeds.

Safety Notes					
					
Read all instructions	Wear eye protection	Inspect and tighten fasteners regularly	Warning: Cutting hazard	Warning: Hot surfaces	Do not exceed Max. RPM



Customer Information Sheet

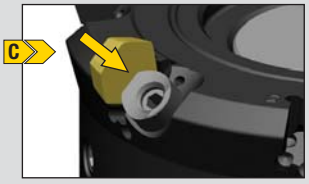
Hexagon Insert Installation



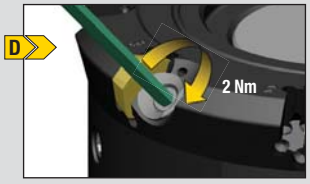
Position the differential screw in the pocket and turn it to approx. 2 to 3 turns with 3mm hex wrench.



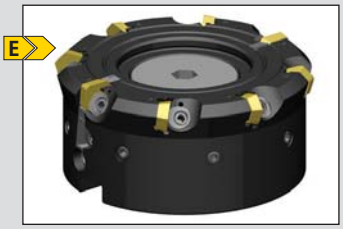
Place the wedge on the screw and fasten it into the cutter body.



Push the insert into the pocket seat by hand in the direction shown.



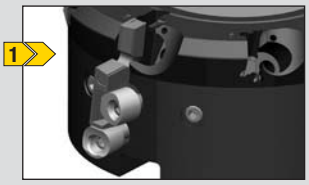
Tighten the screw with a clamping torque of 2 Nm (18 in/lbs). The differential screw must not stick out of wedge.



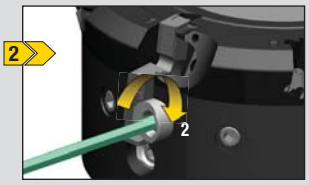
- Repeat steps A–D for all inserts. Max. axial and radial runout must be within 0.03mm (0.0012") and 0.035mm (0.0014").
- **Tighten all the differential screws with a clamping torque of 7 Nm (62 in/lbs).**

NOTE: The cutter comes preloaded with screw and wedge. Steps A and B are only required when it is necessary to change the screw and/or clamp after wear and tear or an accident. Insert changing process starts at step C in normal circumstances.

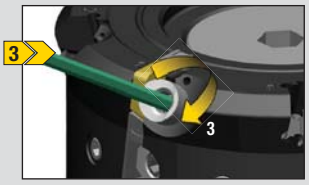
Wiper Insert Installation



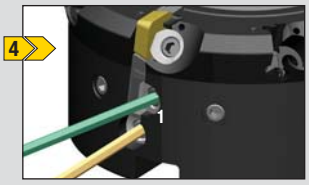
Mount the cartridge in its pocket, similar to steps A and B as shown previously.



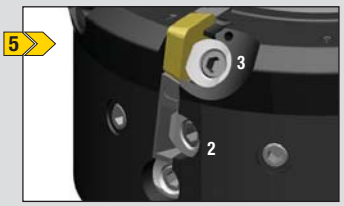
Begin tightening the screw ❷ of the cartridge locking wedge to clamp the cartridge with minimum torque.



Place the insert on the cartridge and begin tightening the screw ❸ to clamp the insert with minimum torque.



Release the height adjusting screw ❶ slightly and adjust the wiper insert's position so that it is 0.03mm (0.0012") above the highest semi-finishing insert.



- The wiper inserts should be clamped in the same way as the hexagon inserts.
- **Tighten the insert screws ❸ and cartridge screw ❷ of wiper pockets to 2 Nm (18 in/lbs) and then to 7 Nm (62 in/lbs).**
- Axial runout measured at the highest point on wiper insert should be ≤ 0.003mm.

NOTE: When the cutter comes preloaded with the screw, wedge, and cartridge, skip steps 1 and 2.
To order a cartridge, use the following numbers:
#6210836 for finishing cartridge SD12.
#6210837 for semi-finishing cartridge HD07.
Number of cartridges will vary based on the diameter of the cutter.

KCFM Do's and Dont's

1



Ap1 ≤ 1mm (0.039")

NOTE: Ap1 max (For wiper insert SDHN12)

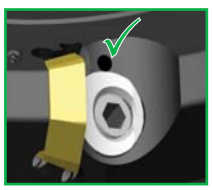


Ap1 > 1mm (0.039")

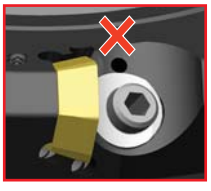
Do not exceed the depth of cut of 1mm (0.039") when the cutter is used with wiper insert.

2









Wedge/screw projecting out of the pocket would reduce the performance.

MEGA 45°

Superior Heavy-Duty Milling

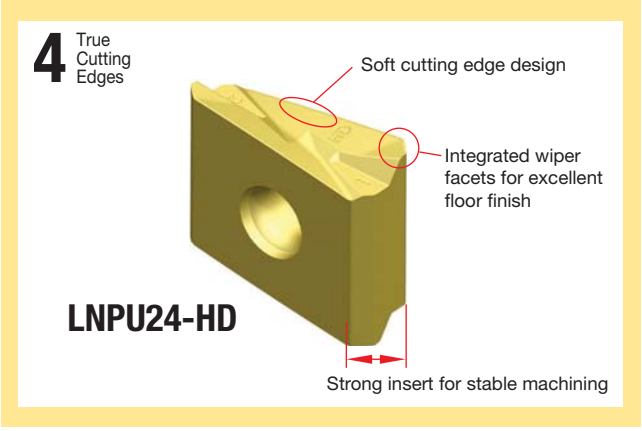
Primary Application

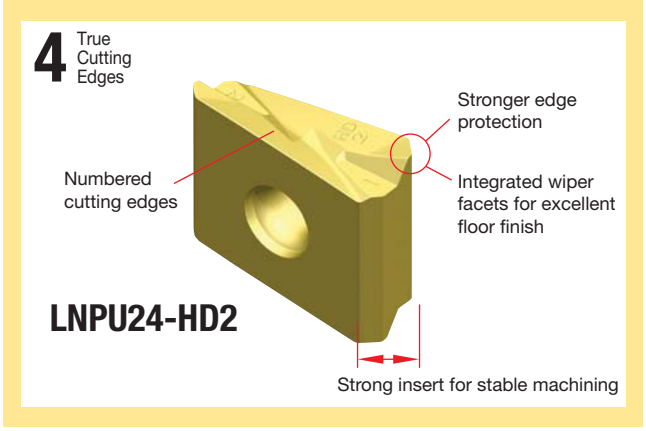
With four true cutting edges per heavy-duty MEGA 45° insert, you are getting the low cost per edge and high productivity you need and have come to expect from Kennametal. The soft cutting edge design enables 30% lower cutting forces, and the carbide shim provides protection to the cutter body. Choose MEGA 45° inserts for all steel and cast iron indexable milling needs.

Features and Benefits

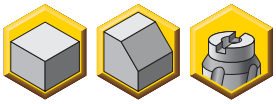
Features	Benefits
• Four true cutting edges per heavy-duty MEGA 45° insert.	• Low cost per edge and high productivity.
• Soft cutting edge design.	• 30% lower cutting forces.
• Up to 30% increased Metal Removal Rates (MRR).	• Performance leader in steel and cast iron materials.
• Carbide pocket shims.	• Excellent cutter body protection.
• Cutting edge numbering system.	• Improved runout for better tool life and floor finish.
• HD2 geometry.	• Stronger edge protection to handle the toughest milling jobs, especially with scale and surfaces with varying thicknesses.

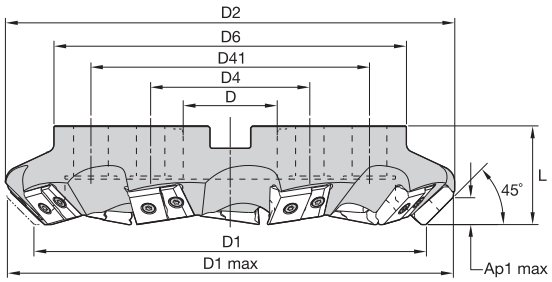


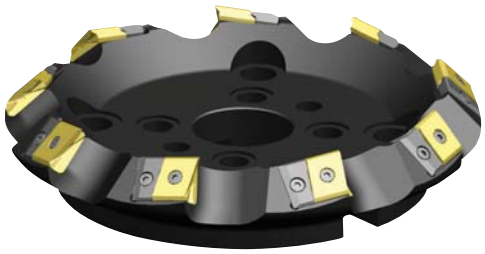

4 True Cutting Edges
Soft cutting edge design
Integrated wiper facets for excellent floor finish
LNPU24-HD
Strong insert for stable machining


4 True Cutting Edges
Stronger edge protection
Numbered cutting edges
Integrated wiper facets for excellent floor finish
LNPU24-HD2
Strong insert for stable machining

- Up to 30% higher Metal Removal Rate (MRR).
- Cutter body protection with carbide shims.





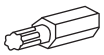


MEGA 45 • Shell Mills

order number	catalogue number	D1	D1 max	D	D2	D4	D41	D6	L	Ap1 max	Z	kg	max RPM
4040931	**MEGA45D125B06LN24**	125	160,3	40	169	–	–	90	63	17,2	6	4,40	12620
4040932	**MEGA45D160C07LN24**	160	195,4	40	201	66,7	–	130	63	17,2	7	6,46	11150
4102923	**MEGA45D200C07LN24**	200	235,4	60	239	101,6	–	160	63	17,2	7	8,41	9970
4102924	**MEGA45D250C09LN24**	250	285,4	60	287	101,6	177,8	225	63	17,2	9	13,54	8920
4040954	**MEGA45D250C11LN24**	250	285,4	60	287	101,6	177,8	225	63	17,2	11	13,97	8920
4102925	**MEGA45D315C10LN24**	315	350,4	60	352	101,6	177,8	225	80	17,2	10	22,57	7950
4040955	**MEGA45D315C13LN24 ***	315	350,4	60	352	101,6	177,8	225	80	17,2	13	23,03	7950

NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Spare Parts

D1	 insert screw	 Nm	 shim	 universal bit torque driver	 drive bit
125	**MS1162**	5,0	**SM-906**	**DTQ3054**	**BTQT25**
160	**MS1162**	5,0	**SM-906**	**DTQ3054**	**BTQT25**
200	**MS1162**	5,0	**SM-906**	**DTQ3054**	**BTQT25**
250	**MS1162**	5,0	**SM-906**	**DTQ3054**	**BTQT25**
315	**MS1162**	5,0	**SM-906**	**DTQ3054**	**BTQT25**

NOTE: Shim screw: MS1162.

Left-handed shim



catalogue number
SM-906LH

NOTE: Left hand inserts and shims available as standard line items. Left hand cutter bodies to be requested as tailor-made custom solutions.
Please refer to the Innovations 2016 Catalogue A-15-04498 (Page D60) for the Insert Selection Guide and Cutting Data Recommendation.

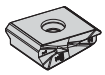
Insert Selection Guide

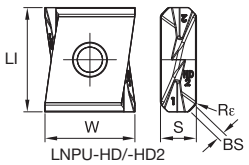
Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		◄——►		toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.S..HD	KC725M	**.S..HD**	**KCPK30**	.S..HD2	KCPM40
P3–P4	.S..HD	KCPK30	**.S..HD2**	**KCPK30**	.S..HD2	KCPM40
P5–P6	.S..HD	KC725M	**.S..HD2**	**KCPK30**	.S..HD2	KCPM40
M1–M2	.S..HD	KC725M	**.S..HD2**	**KCSM40**	.S..HD2	KCPM40
M3	.S..HD	KCPK30	**.S..HD2**	**KCSM40**	.S..HD2	KCPM40
K1–K2	.S..HD	KC520M	**.S..HD**	**KCK15**	.S..HD2	KC520M
K3	.S..HD	KC520M	**.S..HD**	**KCK15**	.S..HD2	KC520M
N1–N2	–	–	–	–	–	–
N3	–	–	–	–	–	–
S1–S2	.S..HD	KC725M	**.S..HD2**	**KCSM40**	.S..HD2	KCSM40
S3	.S..HD	KC725M	**.S..HD2**	**KCPM40**	.S..HD2	KCSM40
S4	.S..HD	KC725M	**.S..HD2**	**KCSM40**	.S..HD2	KCSM40
H1	–	–	–	–	–	–

Indexable Inserts

● first choice
○ alternate choice

P		●		●	●	○
M					○	●
K	●		●	○		
N						
S						●
H						

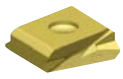

LNPU-HD/-HD2

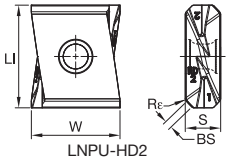


LNPU-HD/-HD2

LNPU-HD/HD2

catalogue number	LI	BS	W	Rε	S	hm	cutting edges	KC520M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
LNPU2410ANSRHD	29,00	2,25	25,02	1,2	10,00	0,23	4	–	●	●	●	–	–
LNPU2410ANSRHD2	29,00	2,25	25,04	1,2	10,00	0,23	4	–	–	–	●	●	●


LNPU-HD2



LNPU-HD2

LNPU-HD2 • Left Hand

catalogue number	LI	BS	W	Rε	S	hm	cutting edges	KC520M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
LNPU2410ANSLHD2	29,00	2,25	25,04	1,2	10,00	0,23	4	–	–	–	●	●	–

Recommended Starting Feeds

Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.S..HD	0,33	**0,83**	1,34	0,24	**0,60**	0,96	0,18	**0,45**	0,71	0,16	**0,39**	0,62	0,14	**0,36**	0,57	.S..HD
.S..HD2	0,33	**0,91**	1,53	0,24	**0,66**	1,09	0,18	**0,49**	0,81	0,16	**0,43**	0,71	0,14	**0,39**	0,65	.S..HD2

NOTE: Use "Light Machining" values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

MEGA 60 and 90

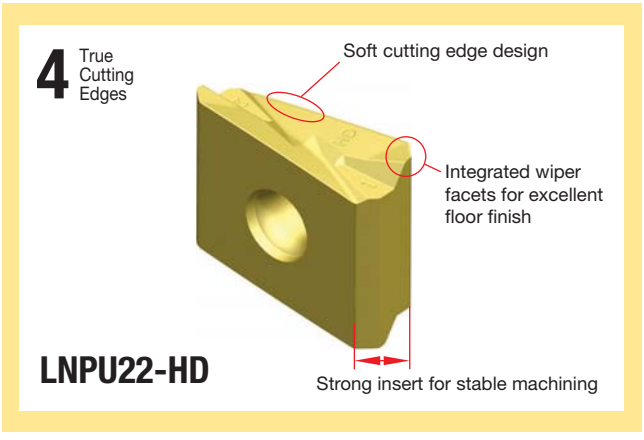
Primary Application

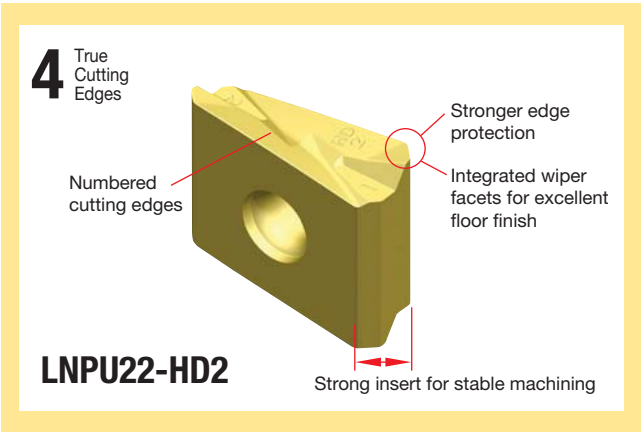
The real performance booster in heavy-duty milling. With four true cutting edges per heavy-duty insert, you are getting the low cost per edge and high productivity you need and have come to expect from Kennametal. The soft cutting edge design enables 30% lower cutting forces, and the carbide shim provides protection to the cutter body. Choose MEGA 60 and MEGA 90 for all steel and cast iron indexable milling needs.

Features and Benefits

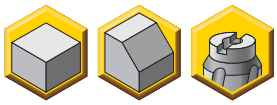
Features	Benefits
• Four true cutting edges per heavy-duty MEGA 60 and 90 insert.	• Low cost per edge and high productivity.
• Soft cutting edge design.	• 30% lower cutting forces.
• Up to 30% increased Metal Removal Rates (MRR).	• Performance leader in steel and cast iron materials.
• Carbide pocket shims.	• Excellent cutter body protection.
• Cutting edge numbering system.	• Improved runout for better tool life and floor finish.
• HD2 geometry.	• Stronger edge protection to handle the toughest milling jobs, especially with scale and surfaces with varying thicknesses.

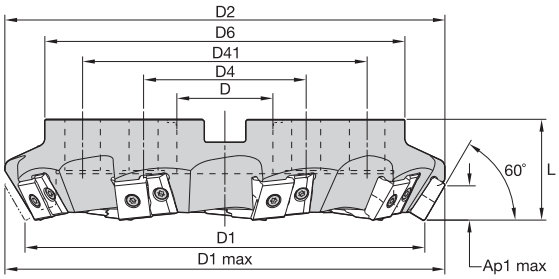



4 True Cutting Edges
Soft cutting edge design
Integrated wiper facets for excellent floor finish
LNPU22-HD
Strong insert for stable machining


4 True Cutting Edges
Stronger edge protection
Numbered cutting edges
Integrated wiper facets for excellent floor finish
LNPU22-HD2
Strong insert for stable machining

- Up to 30% higher Metal Removal Rate (MRR).
- Cutter body protection with carbide shims.



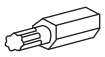




MEGA 60 • Shell Mills

order number	catalogue number	D1	D1 max	D	D2	D4	D41	D6	L	Ap1 max	Z	kg	max RPM
4147458	**MEGA60D125B06LN22**	125	150,0	40	155	–	–	90	63	21,4	6	3,76	11130
4147459	**MEGA60D160C07LN22**	160	184,9	40	190	67	–	130	63	21,4	7	5,73	9830
4147460	**MEGA60D200C07LN22**	200	224,9	60	225	102	–	160	63	21,4	7	8,17	8790
4147461	**MEGA60D200C09LN22**	200	224,9	60	225	102	–	160	63	21,4	9	8,26	8790
4147462	**MEGA60D250C09LN22**	250	274,9	60	275	102	178	225	63	21,4	9	12,93	7870
4147483	**MEGA60D250C11LN22**	250	274,9	60	275	102	178	225	63	21,4	11	13,09	7870
4147484	**MEGA60D315C10LN22**	315	339,9	60	340	102	178	225	80	21,4	10	21,29	7010
4147485	**MEGA60D315C13LN22**	315	339,9	60	340	102	178	225	80	21,4	13	21,39	7010

Spare Parts

D1	 insert screw	 Nm	 shim	 universal bit torque driver	 drive bit
125	**MS1162**	5,0	**SM-906**	**DTQ3054**	**BTQT25**
160	**MS1162**	5,0	**SM-906**	**DTQ3054**	**BTQT25**
200	**MS1162**	5,0	**SM-906**	**DTQ3054**	**BTQT25**
250	**MS1162**	5,0	**SM-906**	**DTQ3054**	**BTQT25**
315	**MS1162**	5,0	**SM-906**	**DTQ3054**	**BTQT25**

NOTE: Shim screw: MS1162.

Left-handed shim



catalogue number
SM-906LH

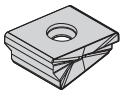
NOTE: Left hand inserts and shims available as standard line items. Left hand cutter bodies to be requested as tailor-made custom solutions.
Please refer to the Innovations 2016 Catalogue A-15-04498 (Page D60) for the Insert Selection Guide and Cutting Data Recommendation.

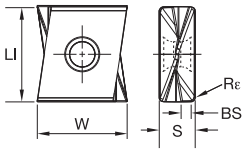
Insert Selection Guide

Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		◄——►		toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.S..HD	KC725M	**.S..HD**	**KCPM40**	.S..HD2	KCPM40
P3–P4	.S..HD	KCPK30	**.S..HD2**	**KCPK30**	.S..HD2	KCPM40
P5–P6	.S..HD	KC725M	**.S..HD2**	**KCPK30**	.S..HD2	KCPM40
M1–M2	.S..HD	KC725M	**.S..HD2**	**KCSM40**	.S..HD2	KCPM40
M3	.S..HD	KCPM40	**.S..HD2**	**KCSM40**	.S..HD2	KCPM40
K1–K2	.S..HD	KC520M	**.S..HD**	**KCK15**	.S..HD2	KC520M
K3	.S..HD	KC520M	**.S..HD**	**KCK15**	.S..HD2	KC520M
N1–N2	–	–	**–**	**–**	–	–
N3	–	–	**–**	**–**	–	–
S1–S2	.S..HD	KC725M	**.S..HD**	**KC725M**	.S..HD2	KCSM40
S3	.S..HD	KCPM40	**.S..HD2**	**KCSM40**	.S..HD2	KCPM40
S4	.S..HD	KC725M	**.S..HD2**	**KCSM40**	.S..HD2	KCSM40
H1	–	–	**–**	**–**	–	–

Inserts

beyond


LNPU-HD/-HD2



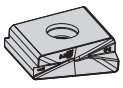
LNPU-HD/-HD2

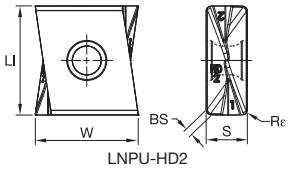
● first choice
○ alternate choice

P			●		●	●	○
M						○	●
K	●		●	○			
N							
S							●
H							

LNPU-HD/-HD2

catalogue number	LI	BS	W	Rε	S	hm	cutting edges	KC520M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
LNPU221012PNSRHD	27	2,31	25,01	1,2	10,00	0,23	4	–	●	●	●	●	–
LNPU221012PNSRHD2	27	2,31	25,00	1,2	10,00	0,23	4	–	–	–	●	●	●


LNPU-HD2



LNPU-HD2

LNPU-HD2 • Left Hand

catalogue number	LI	BS	W	Rε	S	hm	cutting edges	KC520M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
LNPU221012PNSLHD2	27	2,31	25,00	1,2	10,00	0,23	4	●	–	–	●	●	–

Recommended Starting Feeds

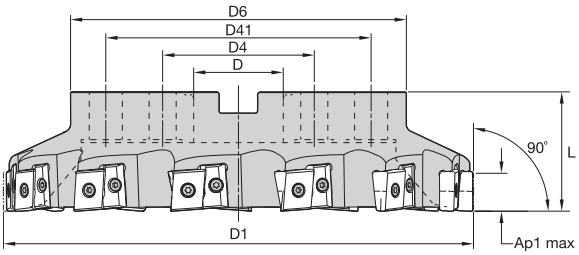
Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40%–100%			
.S..HD	0,27	**0,68**	1,08	0,20	**0,49**	0,78	0,15	**0,37**	0,58	0,13	**0,32**	0,51	0,12	**0,29**	0,46	.S..HD
.S..HD2	0,27	**0,68**	1,21	0,20	**0,49**	0,87	0,15	**0,37**	0,65	0,13	**0,32**	0,56	0,12	**0,29**	0,52	.S..HD2

NOTE: Use "Light Machining" values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

- Up to 30% higher Metal Removal Rate (MRR).
- Cutter body protection with carbide shims.

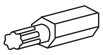




MEGA 90 • Shell Mills

order number	catalogue number	D1	D	D4	D41	D6	L	Ap1 max	Z	kg	max RPM
4129656	**MEGA90D125B06LN22**	125	40	–	–	90	63	25,5	6	3,19	10070
4129657	**MEGA90D160C07LN22**	160	40	67	–	130	63	25,5	7	4,86	8900
4129658	**MEGA90D200C07LN22**	200	60	102	–	160	63	25,5	7	6,85	7960
4129659	**MEGA90D200C09LN22**	200	60	102	–	160	63	25,5	9	6,92	7960
4129660	**MEGA90D250C09LN22**	250	60	102	–	160	63	25,5	9	9,82	7120
4129661	**MEGA90D250C11LN22**	250	60	102	–	160	63	25,5	11	9,95	7120
4129662	**MEGA90D315C10LN22**	315	60	102	178	225	80	25,5	10	17,66	6340
4129664	**MEGA90D315C13LN22**	315	60	102	178	225	80	25,5	13	17,78	6340

Spare Parts

D1	 insert screw	 Nm	 shim	 universal bit torque driver	 drive bit
125	**MS1162**	5,0	**SM-906**	**DTQ3054**	**BTQT25**
160	**MS1162**	5,0	**SM-906**	**DTQ3054**	**BTQT25**
200	**MS1162**	5,0	**SM-906**	**DTQ3054**	**BTQT25**
250	**MS1162**	5,0	**SM-906**	**DTQ3054**	**BTQT25**
315	**MS1162**	5,0	**SM-906**	**DTQ3054**	**BTQT25**

NOTE: Shim screw: MS1162.

Left-handed shim

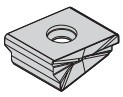


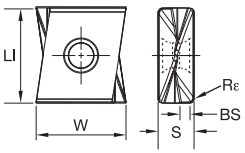
catalogue number
SM-906LH

NOTE: Left hand inserts and shims available as standard line items. Left hand cutter bodies to be requested as tailor-made custom solutions.
Please refer to the Innovations 2016 Catalogue A-15-04498 (Page D60) for the Insert Selection Guide and Cutting Data Recommendation.

Insert Selection Guide

Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		← →		toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.S..HD	KC725M	**.S..HD**	**KCPM40**	.S..HD2	KCPM40
P3–P4	.S..HD	KCPK30	**.S..HD2**	**KCPK30**	.S..HD2	KCPM40
P5–P6	.S..HD	KC725M	**.S..HD2**	**KCPK30**	.S..HD2	KCPM40
M1–M2	.S..HD	KC725M	**.S..HD2**	**KCSM40**	.S..HD2	KCPM40
M3	.S..HD	KCPM40	**.S..HD2**	**KCSM40**	.S..HD2	KCPM40
K1–K2	.S..HD	KC520M	**.S..HD**	**KCK15**	.S..HD2	KC520M
K3	.S..HD	KC520M	**.S..HD**	**KCK15**	.S..HD2	KC520M
N1–N2	–	–	**–**	**–**	–	–
N3	–	–	**–**	**–**	–	–
S1–S2	.S..HD	KC725M	**.S..HD**	**KC725M**	.S..HD2	KCSM40
S3	.S..HD	KCPM40	**.S..HD2**	**KCSM40**	.S..HD2	KCPM40
S4	.S..HD	KC725M	**.S..HD2**	**KCSM40**	.S..HD2	KCSM40
H1	–	–	**–**	**–**	–	–


LNPU-HD/-HD2



LNPU-HD/-HD2

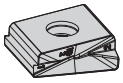
● first choice
○ alternate choice

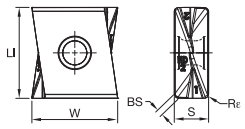
beyond

P			●		●	●	○
M						○	●
K		●		●	○		
N							
S							●
H							

LNPU-HD/-HD2

catalogue number	LI	BS	W	Rε	S	hm	cutting edges	KC520M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
LNPU221012PNSRHD	27	2,31	25,01	1,2	10,00	0,23	4	–	●	●	●	●	–
LNPU221012PNSRHD2	27	2,31	25,00	1,2	10,00	0,23	4	–	–	–	●	●	●


LNPU-HD2



LNPU-HD2

LNPU-HD2 • Left Hand

catalogue number	LI	BS	W	Rε	S	hm	cutting edges	KC520M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
LNPU221012PNSLHD2	27	2,31	25,00	1,2	10,00	0,23	4	●	–	–	●	●	–

Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.S..HD	0,23	**0,59**	0,94	0,17	**0,43**	0,67	0,13	**0,32**	0,50	0,11	**0,28**	0,44	0,10	**0,25**	0,40	.S..HD
.S..HD2	0,23	**0,59**	1,04	0,17	**0,43**	0,75	0,13	**0,32**	0,56	0,11	**0,28**	0,49	0,10	**0,25**	0,45	.S..HD2

NOTE: Use "Light Machining" values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

KBDM PCD Face Mills

Indexable Milling

Application

The new KBDM PCD milling platform is designed and engineered for aluminum face milling applications, targeting automotive requirements.

This proven design delivers consistent performance time and time again, and has done so for 20+ years. KBDM's new look, black anodized aluminum with yellow wedges, gives it a unique appearance. However, it's what is behind the cover that really matters. Performance is key, and KBDM does not disappoint.

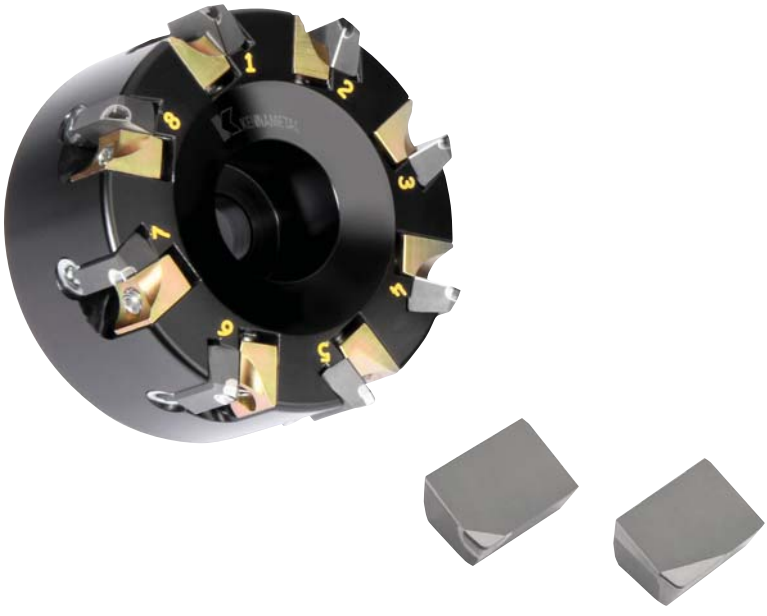


Features and Benefits

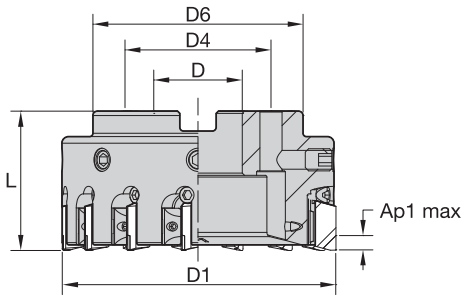
- Cutter bodies manufactured from hard anodised aluminium provide lighter weight and excellent wear and erosion resistance.
- High-density platform geared toward faster machining cycles to help lower overall costs.
- All pockets are adjustable. Very-user friendly for axial adjustment less than 0,005mm, with a total adjustment of 0,8mm.
- Two grades, KD1400™ and KD1425™, provide options in maximising efficiencies based upon application.
- Roughing, semi-finishing, and fine-finishing with one platform.
- Two corner radii — 0,8 and 2,4mm.
- Mini-tip insert for finishing applications.
- All standard inserts have a 1,5mm wiper facet for better surface qualities.
- Full face wiper available as a standard item.

Delivering Customer-Driven Performance for 20+ Years.











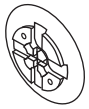
Face Mills

order number	catalogue number	D1	D	D4	D6	L	Z	Z ADJ	kg	max RPM
6044682	**KBDM063SD06**	63	22	–	62	40	6	6	0,45	20000
6044683	**KBDM080SD08**	80	27	–	50	50	8	8	0,63	20000
6044684	**KBDM100SD12**	100	32	–	78	50	12	12	1,13	17320
6044685	**KBDM125SD16**	125	40	–	89	63	16	16	2,00	15500
6044686	**KBDM160SD18**	160	40	–	89	63	18	18	3,20	14150
6044687	**KBDM200SD24**	200	60	102	130	63	24	24	4,21	12240
6207836	**KBDM250SD30**	250	60	102	165	63	30	30	7,32	11000

Spare Parts

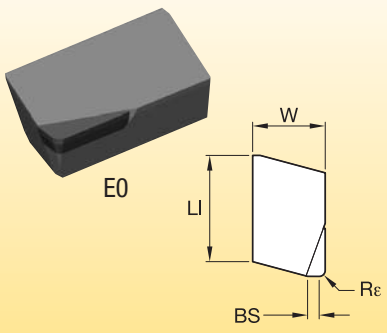




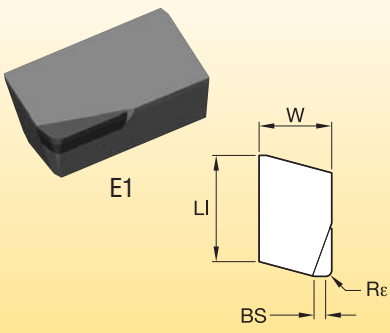


D1	screw	wedge	axial adjusting screw	coolant lock screw	coolant shower plate
63	**LS103**	**HDWM5EUS**	**SWSM515**	**SALS063S**	–
80	**LS103**	**HDWM5EUS**	**SWSM515**	**SALS080**	–
100	**LS103**	**HDWM5EUS**	**SWSM515**	**SALS100**	–
125	**LS103**	**HDWM5EUS**	**SWSM515**	**SALS125**	–
160	**LS103**	**HDWM5EUS**	**SWSM515**	**SALS160**	–
200	**LS103**	**HDWM5EUS**	**SWSM515**	–	**SSP8**
250	**LS103**	**HDWM5EUS**	**SWSM515**	–	–

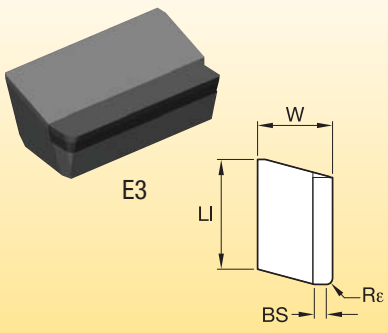
Technical Information • Ap1 max for PCD Inserts



Ap1 max 2,5mm



Ap1 max 6,3mm



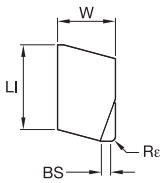
Ap1 max 12,7mm

Insert Selection Guide • KBDM • Metric

Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		← →		toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	–	–	–	–	–	–
P3–P4	–	–	–	–	–	–
P5–P6	–	–	–	–	–	–
M1–M2	–	–	–	–	–	–
M3	–	–	–	–	–	–
K1–K2	–	–	–	–	–	–
K3	–	–	–	–	–	–
N1–N2	.KSDR.....	KD1400	**.KSDR.....**	**KD1400**	.KSDR.....	KD1400
N3	.KSDR.....	KD1400	**.KSDR.....**	**KD1425**	.KSDR.....	KD1425
S1–S2	–	–	–	–	–	–
S3	–	–	–	–	–	–
S4	–	–	–	–	–	–
H1	–	–	–	–	–	–



E0



E0

● first choice
○ alternate choice

P	
M	
K	
N	● ●
S	
H	

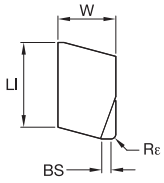
PCD Inserts • KSDR Mini-Tip • E0

catalogue number	LI	W	BS	Rε	hm	KD1400	KD1425
KSDR100031E0W0S	15,85	9,52	—	0,8	0,02	●	●
KSDR100031E0W4S	15,88	9,52	1,52	0,8	0,02	●	●

NOTE: For Mini-tip (E0), Ap1 max = 2,5mm.



E1

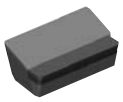


E1

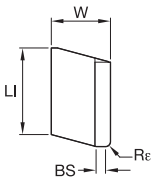
PCD Inserts • KSDR • E1

catalogue number	LI	W	BS	Rε	hm	KD1400	KD1425
KSDR100031E1W4S	15,88	9,52	1,52	0,8	0,02	●	●
KSDR100093E1W4S	15,88	9,52	1,52	2,4	0,02	●	●

NOTE: Ap1 max for standard E1 insert is 6,3mm.



E3



E3

● first choice
○ alternate choice

P			
M			
K			
N		●	●
S			
H			

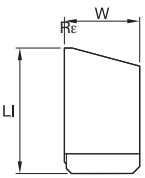
PCD Inserts • KSDR • E3

catalogue number	LI	W	BS	Rε	hm	KD1400	KD1425
KSDR100031E3W4S	15,88	9,52	1,52	0,8	0,02	●	●

NOTE: For Full Edge (E3), Ap1 max = 12,7mm.



KSDR



KSDR

PCD Inserts • KSDR Wiper

catalogue number	LI	W	BS	Rε	hm	KD1400	KD1425
KSDR102S	15,88	9,53	0,89	–	0,02	●	●

Recommended Starting Feeds

Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.KSDR…..	0,12	**0,35**	0,58	0,08	**0,25**	0,42	0,06	**0,19**	0,31	0,06	**0,16**	0,27	0,05	**0,15**	0,25	.KSDR…..

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

PCD Custom Solutions for Indexable Milling

- Diameters up to 550mm.
- Integral shank options, ie, HSK.
- Left-hand rotation.
- Internal coolant capable.
- PCD lengths up to 12,7mm.
- Specific edge preps and nose radii available.



Insert Setting and Fine Adjustment Procedure

Face Mills

- Apply a small amount of lubricant to the following areas:
  - — Pocket area where the wedge slides.
  - — Threads of the inserts locking screw.
  - — Threads of the axial adjustment screw.
- Install inserts applying light torque to the wedge assembly locking screw.
- Turn axial adjustment screw until the cartridge is 0,01–0,015mm below the final set height.
- Tighten the wedge assembly locking screw to 3,5 Nm.
  - — 170.170 — Torque Screwdriver **mm #1138787**.
  - — 170.181 — 1/4" Drive Bit — 4mm Hex **mm #1138857**.
- Repeat for all inserts/pockets before final axial setting.
- Final Setting: Turn the axial adjustment screw moving the PCD insert 0,005µm to the final set height. Repeat for all pockets.



General

- Non-contact gages are preferred.
- Contact gages can be used with the following precautions:
  - — Indicator point must be flat and parallel to the base.
  - — Always approach the PCD insert from the relief angle under the PCD segment.
  - — Do NOT let the indicator drop on the PCD segment.
- Remove all worn PCD insert.
- Clean the pockets of the cutter completely.



KBDM Wiper Setup

- Set Wiper 15–20 microns (0.0006–0.0008") higher than standard PCD inserts. The KSDR102S Wiper is designed to be used only with 0.031 corner radius standard inserts in the other pockets.
- At this setting, the wiper radius will cover 7,1mm (0.28") advancement before another wiper would be needed.
- Wiper radius is 762mm (30.0").
- Ideal setup is to use only 1 wiper to achieve best surface quality. Use when Wt is a requirement.

Example: KBDM200SD24 Face Mill
Feed per tooth: 0,2mm (0.008")
# of inserts: 24
Advancement per revolution:
Metric: 0,2 x 24 = 4,8mm
Inch: 0.008 x 24 = 0.192"
4,8mm < 7,1mm wiper length

NOTE: Large diameter cutters 250mm (10.0") & up would be candidates for more than 1 wiper. Due to more inserts in the cutter, the advancement per revolution might exceed the coverage of 1 wiper.

The KSCM™ AluMill™ System

Primary Application

The KSCM AluMill face milling programme is specifically engineered to deliver best-in-class performance in high-volume aluminium machining operations. Runs at higher speeds with no chatter while still easy to adjust. KD1420™ grade materials provide long tool life, and with the Kennametal Blue Box™ programme for reconditioning worn cartridges, you can reduce inventory costs as well!

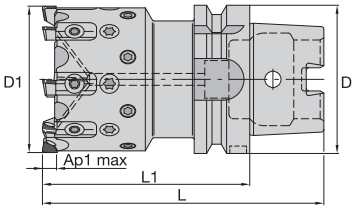
Features and Benefits

- Anti-vibration cutter design.
- Best rigidity for high feed rates.
- Unique dovetail wedge clamping design.
- No radial movement of cartridges.
- Centrifugal force protection cartridge design.
- Integrated chip gash into cartridge.
- Quick setup and easy adjust concept.
- Flexible cartridge configuration.
- No bur cartridges for fine finishing.
- Blue Box™ service.



- Productivity booster in aluminium face milling.
- Rough and finish in one operation.
- Precision balanceable cutter bodies produce mirror-finish surfaces.







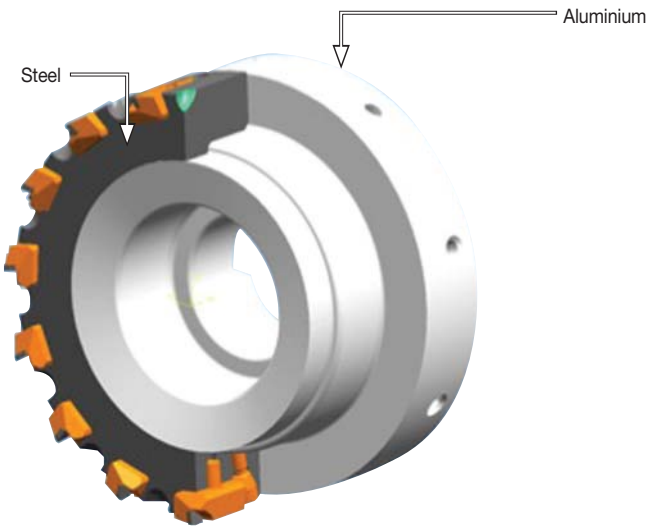
KSCM AluMill • Monoblock HSK63A

order number	catalogue number	CSMS system size	D1	D	L	L1	Ap1 max	Z	Z S	kg	max RPM
2880630	**KSCM63R08CAH63A090**	HSK63A	63	63	122	90	3,0	8	8	1,83	37900

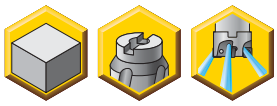
Spare Parts

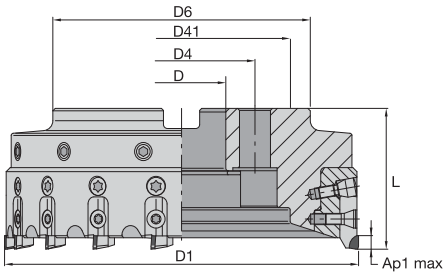
D1	adjusting screw	cartridge screw	drive bit	balancing screw
63	**193.464**	**193.465**	**170.279**	**193.461**

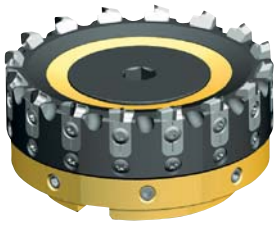
NOTE: Ap1 max is dependent on the cartridge configuration; see the values listed under the cartridges.



- PCD cartridge face mill for high production aluminium face milling.
- Rough and finish in one operation.
- Precision balanceable cutter bodies produce mirror-finish surfaces.







KSCM AluMill • Shell Mills

order number	catalogue number	D1	D	D4	D6	D41	L	Ap1 max	Z	Z ADJ	kg	max RPM
2881349	**KSCM80R10CAB27**	80	27	–	63	–	50	3,0	10	10	1,26	29900
2881352	**KSCM100R12CAB32**	100	32	–	96	–	50	3,0	12	12	1,54	23900
2881505	**KSCM125R16CAB40**	125	40	–	92	–	63	3,0	16	16	2,48	19100
2881509	**KSCM160R18CAB40**	160	40	67	116	–	63	3,0	18	18	3,74	15000
2881510	**KSCM200R24CAB60**	200	60	102	166	–	63	3,0	24	24	5,20	12000
2881511	**KSCM250R30CAB60**	250	60	102	166	–	63	3,0	30	30	7,85	9600

NOTE: Ap1 max is dependent on the cartridge configuration; see the values listed under the cartridges.

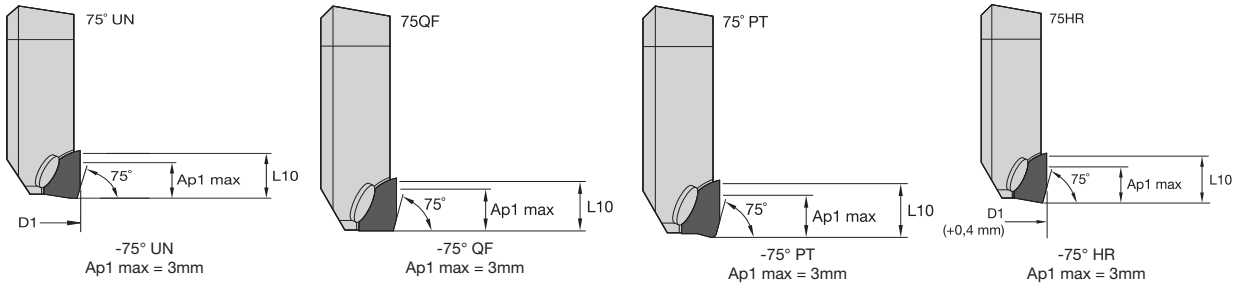
Spare Parts

D1	adjusting screw	cartridge screw	drive bit	coolant lock screw	coolant shower plate	balancing screw
80	**193.464**	**193.465**	**170.279**	**470.269**	**–**	**193.460**
100	**193.464**	**193.465**	**170.279**	**470.270**	**–**	**193.461**
125	**193.464**	**193.465**	**170.279**	**470.271**	**–**	**193.462**
160	**193.464**	**193.465**	**170.279**	**420.200**	**470.272**	**193.462**
200	**193.464**	**193.465**	**170.279**	**–**	**470.273**	**193.462**
250	**193.464**	**193.465**	**170.279**	**–**	**470.274**	**193.463**

NOTE: All cutters are bi-metallic except the 80mm diameter.
Ap1 max is dependent on the cartridge configuration; see the values listed under the cartridges.
Please order KSCM cutters bodies and cartridges separately.

Cartridge Selection Guide

Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		←	→	toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	–	–	–	–	–	–
P3–P4	–	–	–	–	–	–
P5–P6	–	–	–	–	–	–
M1–M2	–	–	–	–	–	–
M3	–	–	–	–	–	–
K1–K2	–	–	–	–	–	–
K3	–	–	–	–	–	–
N1–N2	KCSM…	KD1420	**KCSM…**	**KD1420**	KCSM…	KD1420
N3	KCSM…	KD1420	**KCSM…**	**KD1420**	KCSM…	KD1420
S1–S2	–	–	–	–	–	–
S3	–	–	–	–	–	–
S4	–	–	–	–	–	–
H1	–	–	–	–	–	–



cartridge combination	ratio	max ap	surface quality
UN	—	3	Rz 2–Rz4
UN + QF	3:1	3	Rz 1,5–Rz 2,5
PT + UN	X:1	3	Rz 3,2–Rz 17

● first choice
○ alternate choice

	KD1400	KD1420
P		
M		
K		
N	●	●
S		
H		

KSCM • 75° UN

catalogue number	KRI	L10	hm	KD1400	KD1420
KSCMCA75UN	75°	6,10	0,02	–	●

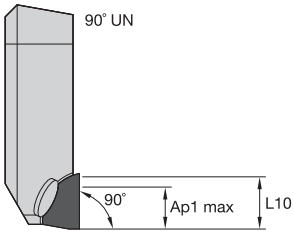
KSCM • 75° QF

catalogue number	KRI	L10	hm	KD1400	KD1420
KSCMCA75QF	75°	6,10	0,02	–	●

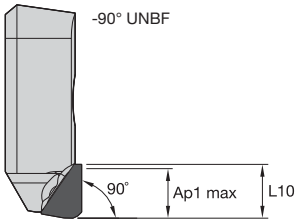
KSCM • 75° PT

catalogue number	KRI	L10	hm	KD1400	KD1420
KSCMCA75PT	75°	6,10	0,02	–	●

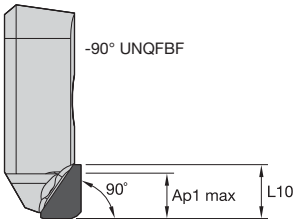
NOTE: KSCMA: Blanks without PCD segment, if cutter is not fully loaded with cartridges.
For low horsepower machines and cutter configurations with less number of effective teeth.



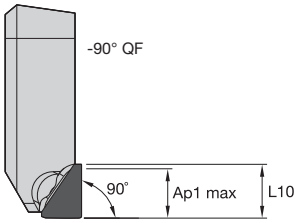
-90° UN
Ap1 MAX = 3mm



-90° UNBF (Bur free)
Ap1 max = 3mm



-90° UNQFBF (Burr free)
Ap1 max = 3mm



-90° QF
Ap1 max = 3mm

cartridge combination	ratio	max ap	surface quality
UN	–	3	Rz 2–Rz4
UN + QF	3:1	3	Rz 1,5–Rz 2,5
PT + UN	X:1	3	Rz 3,2–Rz 17

● first choice
○ alternate choice

P			
M			
K			
N		●	●
S			
H			

KSCM • 90° UN

catalogue number	KRI	L10	hm	KD1400	KD1420
KSCMCA90UN	90°	6,10	0,02	–	●

KSCM • 90° UNBF

catalogue number	KRI	L10	hm	KD1400	KD1420
KSCMA90UNBF	90°	6,20	–	●	●
KSCMCA90UNBF	90°	6,15	0,02	–	●

NOTE: KSCMA90UNBF & KSCMA90QFBF should be the 1st choice solutions for KSCM PCD milling applications.
For setup instructions reference pages S140–S141.

KSCM • 90° QF

catalogue number	KRI	L10	hm	KD1400	KD1420
KSCMCA90QF	90°	6,20	0,02	–	●

KSCM • 90° QFBF

catalogue number	KRI	L10	hm	KD1400	KD1420
KSCMA90QFBF	90°	6,20	–	●	●
KSCMCA90QFBF	90°	6,20	0,02	–	●

NOTE: KSCMA: Blanks without PCD segment, if cutter is not fully loaded with cartridges.
For low horsepower machines and cutter configurations with less number of effective teeth.

Recommended Starting Feeds

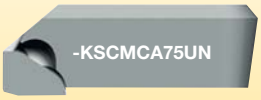
Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining

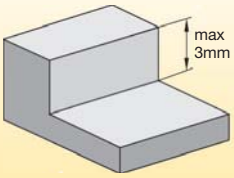
Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
KCSM…	0,12	**0,35**	0,58	0,08	**0,25**	0,42	0,06	**0,19**	0,31	0,06	**0,16**	0,27	0,05	**0,15**	0,25	KCSM…

NOTE: Use "Light Machining" values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

Tool Configuration • Universal Cartridge

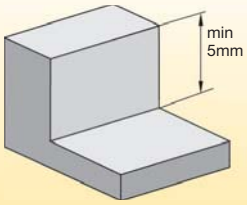


Face milling cutter fitted entirely with universal cartridges.



Depth of Cut:
max 3mm

Surface Quality:
Rz2 - Rz4

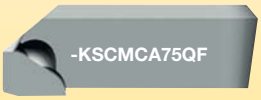


Contouring:
PCD cutting edge length = 5mm

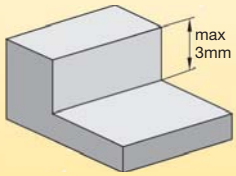
Tool Configuration • Universal Cartridge



+ Finishing Cartridge

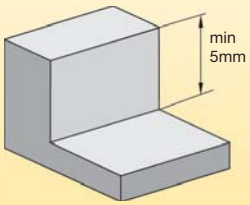


Fitting the face milling cutter with universal and finishing cartridges in a ratio of approximately 3:1.



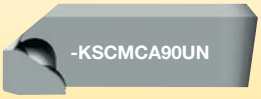
Depth of Cut:
max 3mm

Surface Quality:
Rz1,5 - Rz2,5

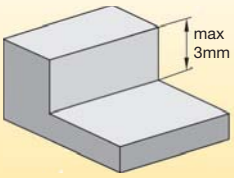


Contouring:
PCD cutting edge length = 5mm

Tool Configuration • Edge Cartridge

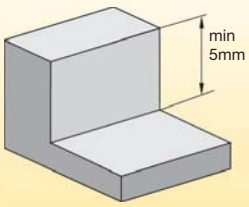


Fitting the face milling cutter entirely with edge cartridges.



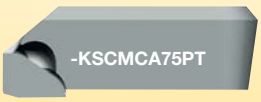
Depth of Cut:
max 3mm

Surface Quality:
Rz2 - Rz4

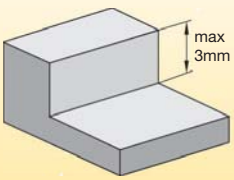


Contouring:
PCD cutting edge length = 5mm

Tool Configuration • Cartridge for Defined Surfaces

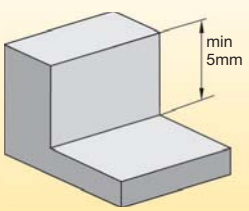


Fitting the face milling cutter entirely with cartridges for defined surfaces.



Depth of Cut:
max 3mm

Surface Quality:
Rz3,2 - Rz17



Contouring:
PCD cutting edge length = 5mm

Tool Configuration • Universal Cartridge, 75° Face Milling







1. Insert cartridges into the body.
2. Screw in the clamping screws (RH), and tighten to 10 Nm.
3. Screw in the adjusting screws (RH), and tighten to 3 Nm.

4. Determine which cartridge is in the highest axial position.
5. By turning the adjusting screws to the right, adjust the remaining cartridges for even running. Max permitted runout error 3 µm.

Tool Configuration • Universal Cartridge + Finishing Cartridge (Ratio Approx. 3:1), 75°







1. Insert universal cartridges at ratio of approximately 4:1 in the body. Make sure they are evenly distributed!
2. Screw in the clamping screws (RH), and tighten to 10 Nm.
3. Screw in the adjusting screws (RH), and tighten to 3 Nm.

4. Determine which cartridge is in the highest axial position.
5. By turning the adjusting screws to the right, adjust the remaining cartridges for even running. Max permitted runout error 3 µm.

6. Insert finishing cartridges as described in Steps 1–5 but with an axial advance of 0,008 +0,002mm. Max permitted runout error of 3 µm with finishing cartridges.

Tool Configuration • Edge Cartridges, 90° Shoulder Milling







1. Insert cartridges into the body.
2. Screw in the clamping screws (RH), and tighten to 10 Nm.
3. Screw in the adjusting screws (RH), and tighten to 3 Nm.

4. Determine which cartridge is in the highest axial position.
5. By turning the adjusting screws to the right, adjust the remaining cartridges for even running. Max permitted runout error 3 µm.

Tool Configuration • Cartridge for Defined Surface, 75°

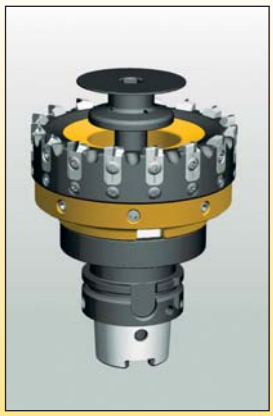


1. Insert cartridges into the body.
2. Screw in the clamping screws (RH), and tighten to 10 Nm.
3. Screw in the adjusting screws (RH), and tighten to 3 Nm.



4. Determine which cartridge is in the highest axial position.
5. By turning the adjusting screws to the right, adjust the remaining cartridges for even running. Max permitted runout error 3 µm.



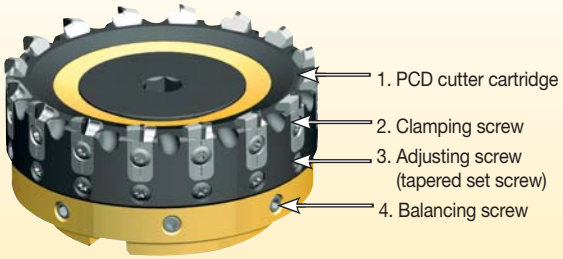


NOTE: The process must be repeated when the cartridges are changed. To dismantle, remove the adjusting element (Part 3), clamping screw (Part 2), and cartridge (Part 1).

Instruction for Mounting the Face Milling Cutter on the Appropriate Toolholder

User Information:

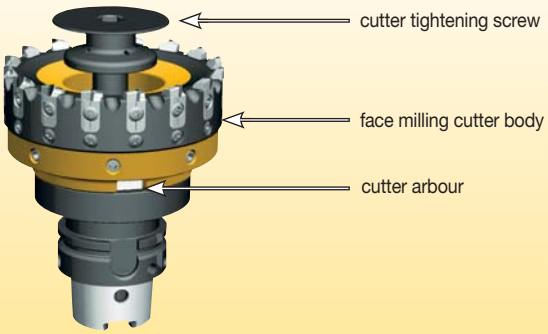
- Tools conform to EN ISO 15641.
- Absolute cleanliness must be observed when assembling the face milling cutter.
- An optimum cutting result will only be achieved by adjusting and balancing the complete tool system (face milling cutter + toolholder).
- Balancing is achieved with the aid of the balancing screws. Quality class G2.5 DIN-ISO 1940.
- The balancing screw must not protrude above the body.
- The balancing and adjustment screws have an adhesive coating according to DIN 267, Part 28. If, after repeated use, the coating is no longer adequate to secure the screws, the screws must be replaced.
- The maximum permitted operating speed (quoted on the tool) must not be exceeded.
- The maximum permitted operating speed is only permitted with clamping systems manufactured by Kennametal in accordance with DIN 69982 Form B with enlarged plane bearing surface. Reduce the operating speed if clamping systems with increased projection length or made by other manufacturers are used.
- Tools and fittings are to be serviced and repaired by Kennametal.
- Screws sealed with lacquer have been adjusted by the manufacturer, and must not be moved.



Instructions for Fitting the Cutter Cartridge • Tool Construction

When mounting the face milling cutter (dimensions similar to DIN 8030 Form B), place the body of the face milling cutter on the arbour. Ensure that the contact faces are clean. Screw in the cutter fastening bolt (RH) and tighten with the appropriate torque.

Tightening torque for the central cutter tightening screw:
M20 (adaptor diameter 40): **250 Nm**
M16 (adaptor diameter 32): **150 Nm**
M12 (adaptor diameter 27): **80 Nm**

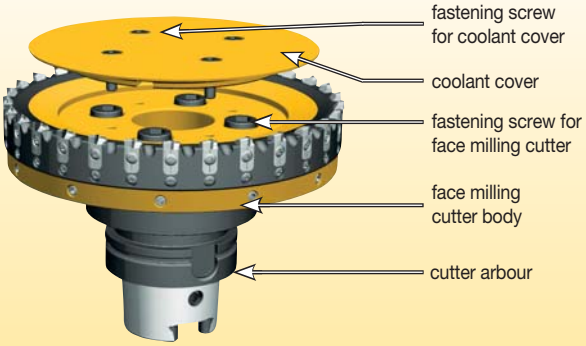


Mounting the Face Milling Cutter (Dimensions Similar to DIN 8030 Form C)

Place the body of the face milling cutter on the arbour. Ensure that the contact faces are clean. Screw in the fastening bolt (RH) and tighten with the appropriate torque. Put the aluminium coolant cover in place and fasten with the Torx fastening screws.

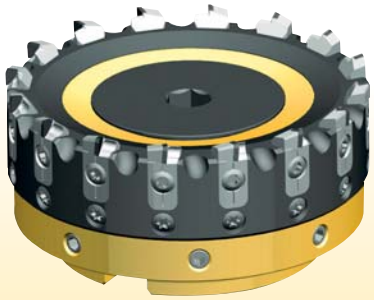
Tightening torque for the face milling cutter fastening screws:
M20: 250 Nm
M16: 110 Nm
M12: 50 Nm

Tightening torque for the coolant cover fastening screws:
M8: 18 Nm



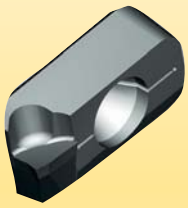
KSCM AluMill
Reconditioning Service

BLUE BOX™
Kennametal



New Supply

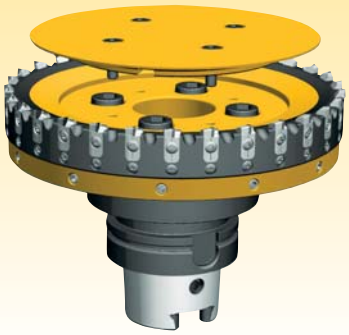
On request, the face mill will be delivered with cartridges already mounted and adjusted.



Service Level • PCD Insert Reconditioning

Reconditioning of PCD cartridges up to three times.

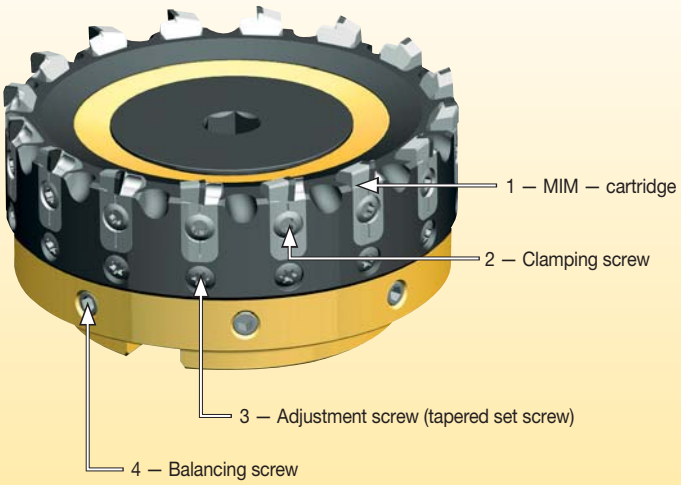
- Tool diameter and length remain constant.



Face mill will be delivered with exchanged cartridges already mounted, adjusted, and balanced.



Tool Design



Information:

- KSCM tools conform to EN ISO 15641.
- Absolute cleanliness is needed when assembling the cutter.
- For optimum results, adjust and balance the complete tool system (face milling cutter + toolholder).
- Balancing is achieved with the aid of balancing screws. Quality class G2.5 DIN-ISO 1940.
- The balancing screw must not protrude above the body. The balancing and adjustment screws have an adhesive coating according to DIN 267, Part 28. After repeated use, the coating may no longer be adequate to secure the screws; the screws must be replaced.
- Do not exceed the maximum operating speed.
- Maximum operating speed is only permitted with clamping systems manufactured by Kennametal in accordance with DIN 69982 Form B with enlarged plane bearing surface. Reduce the operating speed if clamping systems with increased projection length or made by other manufacturers are used.
- Tools and fittings are to be serviced and repaired by Kennametal.
- Screws sealed with lacquer have been adjusted by the manufacturer, and must not be moved.
- A centrifugal force test was done.
- If the tools will be used for HSC, referred to in DIN EN ISO 15641, machines have to fulfill the special safety requirements.

Assembling

1 Lubricate small cove on the MIM cartridge with copper paste of Liqui Moly.



2 Insert universal cartridges at approximate ratio 3:1 into the body. Make sure that they are distributed evenly!

3 Screw in the clamping screws (RH) and tighten to 8 Nm.

4 Screw in the adjusting screws (RH) and tighten to 3 Nm.

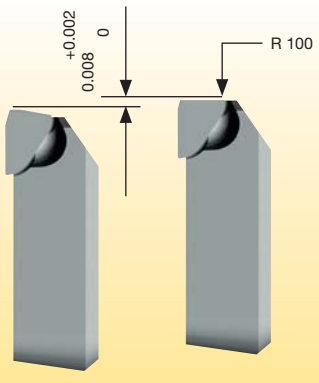


5 Determine which cartridge is in the highest axial position.

6 By turning the adjusting screws to the right, adjust the remaining cartridges for even running. Max permitted runout error 3 µm.



7 Insert finishing cartridges as described in steps 1–6 with an axial advance of 0,008 +0,002mm. Max permitted runout error of 3 µm with finishing cartridges.



NOTE:
- The process must be repeated when the cartridges are changed. To dismantle, remove the adjusting element (Part 3), clamping screw (Part 2), and cartridge (Part 1).
- For special requirements, e.g. surface quality, the configuration and the adjustment of the tool and inserts have to be done in relation with these requirements.
- If spare parts have to be ordered, reference the drawing.

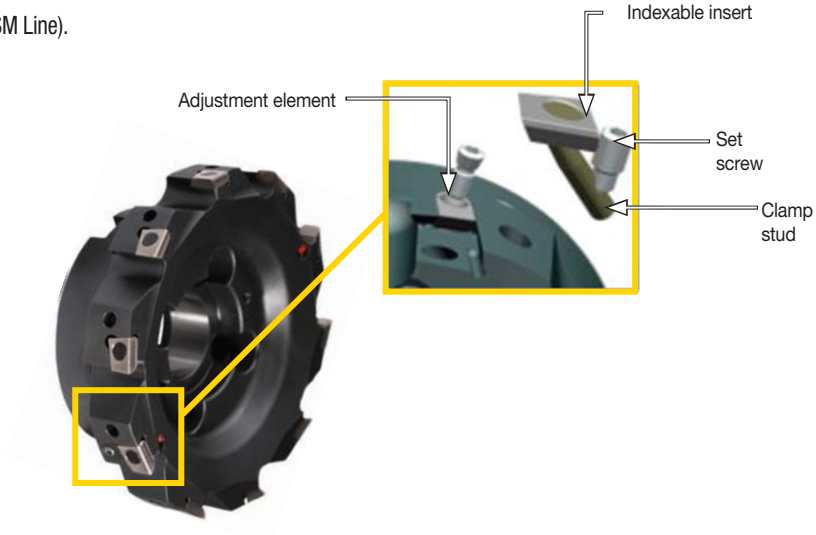
Fix-Perfect™ 90° Aluminium

Primary Application

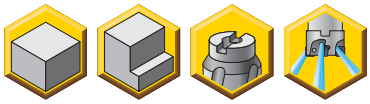
The Fix-Perfect 90° milling cutter is excellent in machining aluminium and non-ferrous materials. The 24° positive rake provides free cutting action while producing superior finishes and flatness.

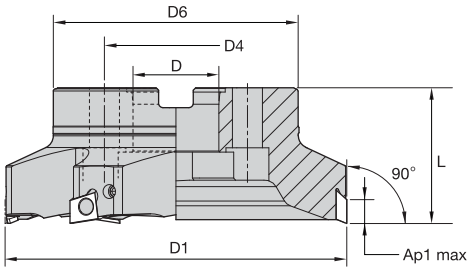
Features and Benefits

- Achieve true 90º shoulder.
- Roughing and finishing in one tool.
- Full safety first insert clamping.
- Easy adjustable pocket seats for fine finishing (PM, HPM, HSM Line).
- Achievable floor surface quality: Ra = 0.5.
- Very soft cutting action.
- Axial depth of cut Ap1 max = 9,5mm.



- Excellent for milling aluminium and non-ferrous materials.
- Good choice for thin wall or poorly fixtured workpieces.
- 24° positive rake provides free cutting action.
- Produces excellent finish and flatness.
- Maximum speed is 2000 m/min.
- All pockets are fixed pockets.





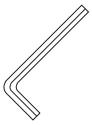


Fix-Perfect • Shell Mills • M Line • Fixed Pockets

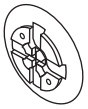
order number	catalogue number	D1	D	D4	D6	L	Ap1 max	Z	kg	max RPM
2210826	**40A02RP90BG15CM**	40	16	–	35	40	9,5	2	0,20	15920
2210827	**50A03RP90BG15CM**	50	22	–	42	40	9,5	3	0,33	12730
2033774	**63A03RP90BG15CM**	63	22	–	51	40	9,5	3	0,49	10110
2210828	**80A03RP90BG15CM**	80	27	–	64	50	9,5	3	1,02	7960
2210829	**100B04RP90BG15CM**	100	32	–	84	50	9,5	4	1,55	6370
2210830	**125B05RP90BG15CM**	125	40	–	94	63	9,5	5	2,54	5090
2210831	**160C06RP90BG15CM**	160	40	66,7	114	63	9,5	6	4,11	3980

Spare Parts





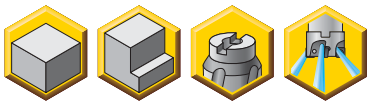


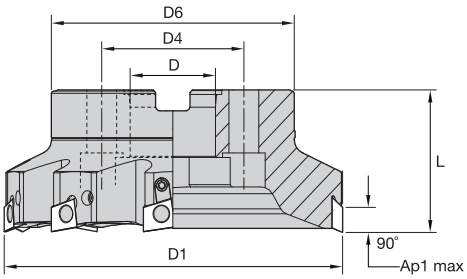


D1	clamp stud	set screw	hex wrench	Nm	socket-head cap screw	coolant lock screw	coolant shower plate
40	**410.083**	**420.060**	**170.003**	5,0	**129.830**	**420.080**	–
50	**410.083**	**420.060**	**170.003**	5,0	**125.025**	**420.100**	–
63	**410.083**	**420.060**	**170.003**	5,0	**125.025**	**420.100**	–
80	**410.083**	**420.060**	**170.003**	5,0	**125.230**	**420.120**	–
100	**410.083**	**420.060**	**170.003**	5,0	–	**420.160**	–
125	**410.083**	**420.060**	**170.003**	5,0	–	**420.200**	**470.232**
160	**410.083**	**420.060**	**170.003**	5,0	–	**420.200**	**470.233**

NOTE: Please order spare parts separately.
For 125mm and 160mm diameter milling cutters, always use the coolant lock screw and coolant cap together. Torque wrench (DTQ50140, order number 6197561) and 3mm hex bit (BTQSW3L90, order number 6205876) may be purchased separately to ensure proper torque setting.

- Produces excellent surface finish and flatness.
- Fixed and adjustable pockets.
- High-speed machining.



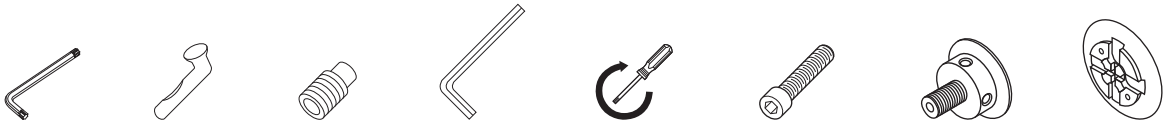




Fix-Perfect • Shell Mills • PM Line • Fixed and Adjustable Pockets

order number	catalogue number	D1	D	D4	D6	L	Ap1 max	Z	Z ADJ	kg	max RPM
1797183	**40A02RP90BG15CPM**	40	16	–	35	40	9,5	2	0	0,21	31830
1758493	**50A03RP90BG15CPM**	50	22	–	42	40	9,5	3	0	0,35	28660
1757331	**63A04RP90BG15C1WPM**	63	22	–	51	40	9,5	4	1	0,52	20210
1758495	**80A05RP90BG15C1WPM**	80	27	–	64	50	9,5	5	1	1,12	15916
1758572	**80A06RP90BG15C2WPM**	80	27	–	64	50	9,5	6	2	1,12	17910
1758496	**100B06RP90BG15C2WPM**	100	32	–	84	50	9,5	6	2	1,68	12732
1758573	**100B08RP90BG15C2WPM**	100	32	–	84	50	9,5	8	2	1,75	12732
1758497	**125B08RP90BG15C2WPM**	125	40	–	94	63	9,5	8	2	2,80	10186
1758574	**125B10RP90BG15C2WPM**	125	40	–	94	63	9,5	10	2	3,05	11460
1758498	**160C10RP90BG15C2WPM**	160	40	66,7	114	63	9,5	10	2	4,64	7958
1758499	**200C12RP90BG15C3WPM**	200	60	101,6	134	63	9,5	12	3	6,00	6366
1758500	**250C16RP90BG15C4WPM**	250	60	101,6	134	63	9,5	16	4	9,37	5093

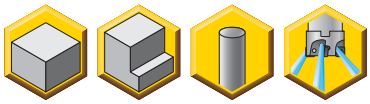
Spare Parts

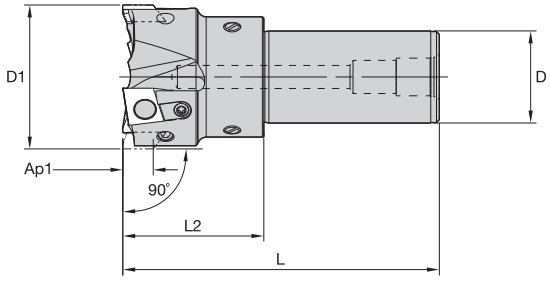


D1	Torx wrench	clamp stud	set screw	hex wrench	Nm	socket-head cap screw	coolant lock screw	coolant shower plate
40	**KT15**	**410.083**	**420.060**	**170.003**	5,0	**129.830**	**420.080**	–
50	**KT15**	**410.083**	**420.060**	**170.003**	5,0	**125.025**	**420.100**	–
63	**KT15**	**410.083**	**420.060**	**170.003**	5,0	**125.025**	**420.100**	–
80	**KT15**	**410.083**	**420.060**	**170.003**	5,0	**125.230**	**420.120**	–
100	**KT15**	**410.083**	**420.060**	**170.003**	5,0	–	**420.160**	–
125	**KT15**	**410.083**	**420.060**	**170.003**	5,0	–	**420.200**	**470.232**
160	**KT15**	**410.083**	**420.060**	**170.003**	5,0	–	**420.200**	**470.233**
200	**KT15**	**410.083**	**420.060**	**170.003**	5,0	–	–	**470.234**
250	**KT15**	**410.083**	**420.060**	**170.003**	5,0	–	–	**470.235**

NOTE: Please order spare parts separately.
For all diameters: adjusting element screw **193.326**.
If the adjusting element needs to be replaced, please return the cutter to the Kennametal Service Center.
For 125mm and 160mm diameter milling cutters, be sure to always use the coolant lock screw and coolant cap together.
Torque wrench (DTQ50140, order number 6197561) and 3mm hex bit (BTQSW3L90, order number 6205876) may be purchased separately to ensure proper torque setting.

- Produces excellent finish and flatness.
- All pockets are adjustable.
- First choice for high-speed machining.







Fix-Perfect • End Mills • HPM Line • All Pockets Adjustable

order number	catalogue number	D1	D	L	L2	Ap1 max	Z	Z ADJ	kg	max RPM
1758580	**50A03R049A32PBG15S3WHPM**	50	32	110	49	9,5	3	3	0,83	25465

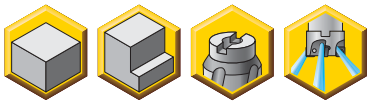
Spare Parts

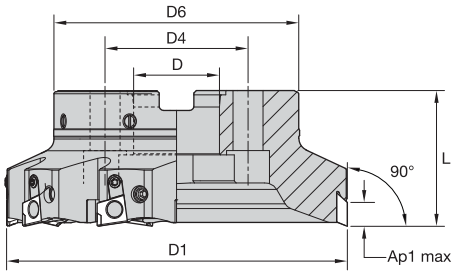


D1	Torx wrench	clamp stud	set screw	hex wrench	balancing screw	Nm
50	**KT15**	**410.083**	**420.060**	**170.003**	**193.337**	5,0

NOTE: Please order spare parts separately.
For all diameters: adjusting element screw **193.326**.
If the adjusting element needs to be replaced, please return the cutter to the Kennametal Service Center.
Torque wrench (DTQ50140, order number 6197561) and 3mm hex bit (BTQSW3L90, order number 6205876) may be purchased separately to ensure proper torque setting.

- Produces excellent finish and flatness.
- All pockets are adjustable.
- First choice for high-speed machining.







Fix-Perfect • Shell Mills • HPM Line • All Pockets Adjustable

order number	catalogue number	D1	D	D4	D6	L	Ap1 max	Z	Z ADJ	kg	max RPM
1758592	**63A04RP90BG15C4WHPM**	63	22	–	51	40	9,5	4	4	0,51	20210
1758593	**80A05RP90BG15C5WHPM**	80	27	–	64	50	9,5	5	5	1,08	15916
1762369	**100B06RP90BG15C6WHPM**	100	32	–	84	50	9,5	6	6	0,70	12732
1762370	**125B08RP90BG15C8WHPM**	125	40	–	94	63	9,5	8	8	1,15	10186
1762451	**160C10RP90BG15C10WHPM**	160	40	66,7	114	63	9,5	10	10	1,77	7959
1982560	**200C12RP90BG15C12WHPM**	200	60	101,6	134	63	9,5	12	12	2,40	6400

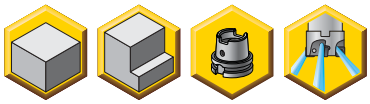
Spare Parts

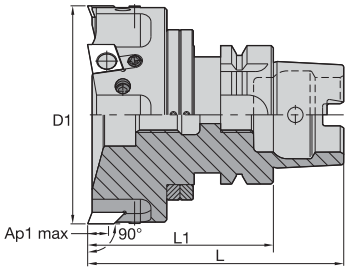


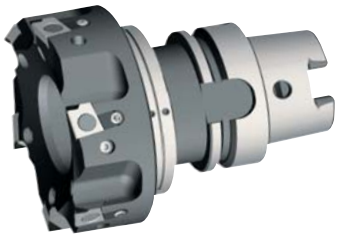
D1	Torx wrench	clamp stud	set screw	hex wrench	Nm	socket-head cap screw	coolant lock screw	coolant shower plate	balancing screw
63	**KT15**	**410.083**	**420.060**	**170.003**	5,0	**125.025**	**420.100**	**–**	**193.337**
80	**KT15**	**410.083**	**420.060**	**170.003**	5,0	**125.230**	**420.120**	**–**	**193.337**
100	**KT15**	**410.083**	**420.060**	**170.003**	5,0	**–**	**420.160**	**–**	**193.337**
125	**KT15**	**410.083**	**420.060**	**170.003**	5,0	**–**	**420.200**	**470.232**	**193.337**
160	**KT15**	**410.083**	**420.060**	**170.003**	5,0	**–**	**420.200**	**470.233**	**193.337**
200	**KT15**	**410.083**	**420.060**	**170.003**	5,0	**–**	**–**	**470.234**	**–**

NOTE: Please order spare parts separately.
For all diameters: adjusting element screw **193.326**.
If the adjusting element needs to be replaced, please return the cutter to the Kennametal Service Center.
Torque wrench (DTQ50140, order number 6197561) and 3mm hex bit (BTQSW3L90, order number 6205876) may be purchased separately to ensure proper torque setting.

- Produces excellent finish and flatness.
- All pockets are adjustable.
- First choice for high-speed machining.



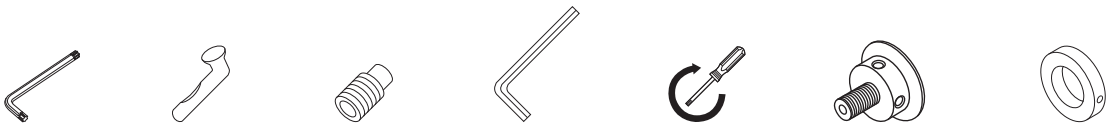




Fix-Perfect • Shell Mills • HSM Line • All Pockets Adjustable

order number	catalogue number	D1	L	L1	Ap1 max	Z	Z ADJ	CSMS system size	kg	max RPM
1782709	**50A03R060S63PBG15S3WHSM**	50	92	60	9,5	3	3	HSK63A	1,00	28660
1782711	**80A05R090S63PBG15S5WHSM**	80	122	90	9,5	5	5	HSK63A	2,12	17910

Spare Parts



D1	Torx wrench	clamp stud	set screw	hex wrench	Nm	coolant lock screw	balance ring
50	**KT15**	**410.083**	**420.060**	**170.003**	5,0	–	–
80	**KT15**	**410.083**	**420.060**	**170.003**	5,0	**420.120**	**SHVBR0635M**

NOTE: Please order spare parts separately.
For all diameters: adjusting element screw **193.326**.
If the adjusting element needs to be replaced, please return the cutter to the Kennametal Service Center.
Torque wrench (DTQ50140, order number 6197561) and 3mm hex bit (BTQSW3L90, order number 6205876) may be purchased separately to ensure proper torque setting.

Insert Selection Guide

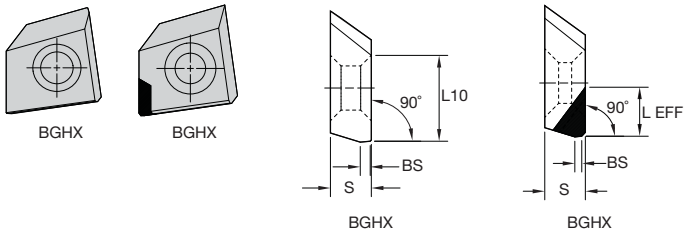
Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		←	→	toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	–	–	–	–	–	–
P3–P4	–	–	–	–	–	–
P5–P6	–	–	–	–	–	–
M1–M2	–	–	–	–	–	–
M3	–	–	–	–	–	–
K1–K2	–	–	–	–	–	–
K3	–	–	–	–	–	–
N1–N2	BGHX...	K110M	**BGHX...**	**KC510M**	BGHX...	KD1415
N3	BGHX...	K110M	**BGHX...**	**KD1410**	BGHX...	KD1410
S1–S2	–	–	–	–	–	–
S3	–	–	–	–	–	–
S4	–	–	–	–	–	–
H1	–	–	–	–	–	–

Indexable Inserts • Fix-Perfect • BGHX15L5...

- Roughing Fix-Perfect inserts for aluminium and non-ferrous materials.
- 9,5mm max depth of cut.
- Two cutting edges.

● first choice
○ alternate choice

		K110M	KC510M	KD1410	KD1415
P					
M					
K					
N		●	●	●	●
S					
H					



Face Milling

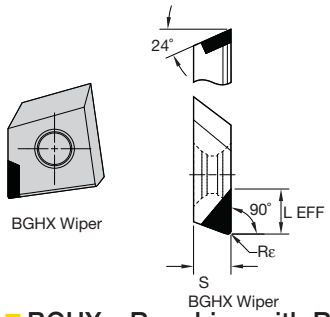
BGHX • Roughing

catalogue number	Leff	L10	S	BS	Rε	hm	cutting edges	K110M	KC510M	KD1410	KD1415
BGHX15L5PCERGGT	5,20	5,20	5,00	0,90	–	0,02	1	–	–	●	●
BGHX15L5PCSRLET	6,00	6,00	5,00	0,90	–	0,02	1	–	–	●	●
BGHX15L5PCTRHET	6,00	6,00	5,00	0,90	–	0,02	1	–	–	●	–
BGHX15L5PCFRGG	–	10,50	5,00	1,22	–	0,02	2	●	●	–	–
BGHX15L5PCTRGG	–	10,50	5,00	1,22	–	0,02	2	●	●	–	–
BGHX15L5PCERGGTM	2,50	–	5,00	1,20	–	0,02	1	–	–	●	–

- Roughing Fix-Perfect inserts for aluminium and non-ferrous materials.
- 9,5mm max depth of cut.
- Two cutting edges.

● first choice
○ alternate choice

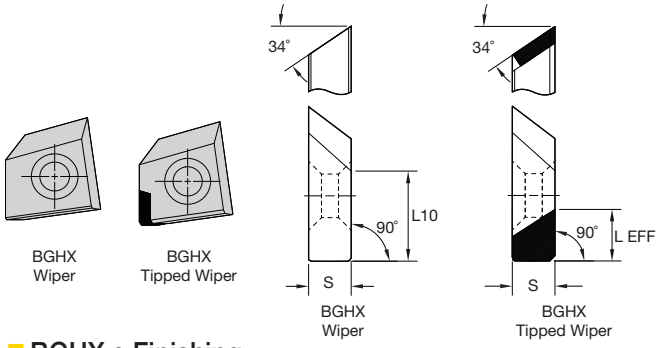
P					
M					
K					
N		●	●	●	●
S					
H					



BGHX • Roughing with Radius

catalogue number	Leff	L10	S	BS	Rε	hm	cutting edges	K110M	KC510M	KD1410	KD1415
BGHX15L504ERGET	5,20	5,20	5,00	–	0,4	0,02	1	–	–	–	●
BGHX15L504PCFRGG	–	10,50	5,00	1,20	0,4	0,02	2	●	–	–	–
BGHX15L508PCFRGG	–	10,50	5,00	1,20	0,8	0,02	2	●	●	–	–
BGHX15L515PCFRGG	–	10,50	5,00	1,20	1,5	0,02	2	●	●	–	–

- Roughing Fix-Perfect inserts for aluminium and non-ferrous materials.
- 9,5mm max depth of cut.
- Two cutting edges.



BGHX • Finishing

catalogue number	Leff	L10	S	BS	Rε	hm	cutting edges	K110M	KC510M	KD1410	KD1415
BGHX15L5PCFRGG1W	–	9,96	5,00	4,00	–	0,02	1	●	●	–	–
BGHX15L5PCTRGG1W	–	9,96	5,00	4,00	–	0,02	1	●	●	–	–
BGHX15L5PCERGGT1W	6,00	–	5,00	2,00	–	0,02	1	–	–	–	●

Recommended Starting Feeds

Recommended Starting Feeds [mm]

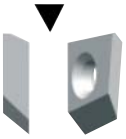
Light Machining	General Purpose	Heavy Machining

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
BGHX...	0,12	**0,35**	0,58	0,08	**0,25**	0,42	0,06	**0,19**	0,31	0,06	**0,16**	0,27	0,05	**0,15**	0,25	BGHX...

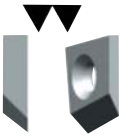
NOTE: Use "Light Machining" values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

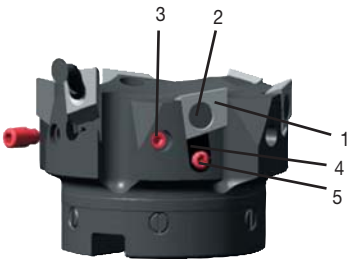
Introduction to Fitting Cutting Bodies

Roughing indexable inserts
BGHX15L5PC..GG.

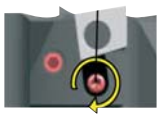
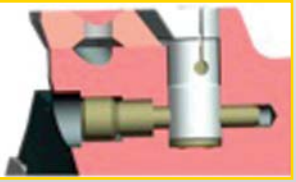
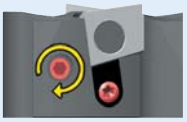


Finishing indexable inserts
BGHX15L5PC..GG.1W



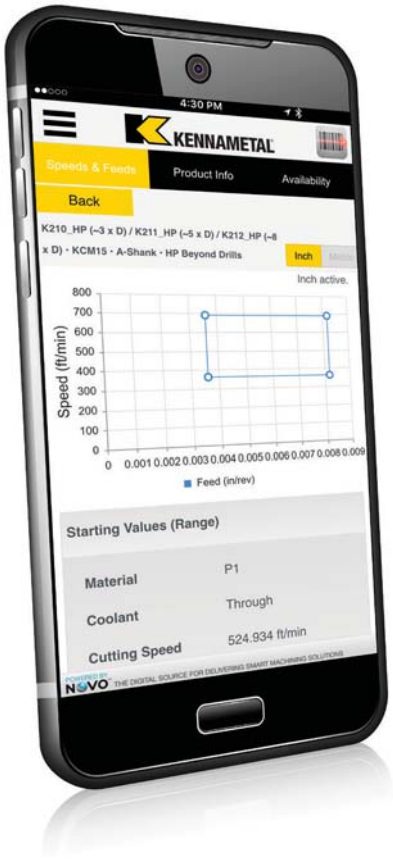


Clean dust, grease, etc., from the insert seat, insert (1), and clamp stud (2).

	PM	HPM/HSM	PM/HPM/HSM
1	Loosen the adjusting element (4).  Loosen the adjusting screw (5).	Loosen the adjusting element (4).  Loosen the adjusting screw (5).	Loosen the adjusting element (4).  Loosen the adjusting screw (5).
2	Insert the indexable inserts and tighten with the clamping screw (3) 5 Nm.  ATTENTION: Ensure that the insert is correctly positioned in the insert seat.	Insert the indexable inserts and pre-tighten with the clamping screw (3) 1,5 Nm.  ATTENTION: Ensure that the insert is correctly positioned in the insert seat. Determine which cutting body is the highest on the axis.	Insert the indexable inserts and pre-tighten with the clamping screw (3) 1,5 Nm.  ATTENTION: Ensure that the insert is correctly positioned in the insert seat. Determine which cutting body is the highest on the axis.
3	Tension the adjusting element (4) by tightening the adjusting screw (5) to the specified torque of 0,5 Nm. 	Extract by 0,02mm the insert that is axially the highest by turning the adjusting screw (5).  Adjust the remaining inserts to the desired runout with maximum travel of the inserts 0,2 Nm.	Adjust the finishing indexable insert(s) to the desired projection, preferably 0,04mm by turning the adjusting screw (5).  ATTENTION: Ensure that the insert is correctly positioned in the insert seat.
4	 **Adjustment element to be replaced by Kennametal Service Center only.**	Clamp the insert by tightening the clamping screw (3) to the specified torque of 5 Nm. 	Clamp the insert by tightening the clamping screw (3) to the specified torque of 5 Nm. 

Mobile App

The Kennametal mobile app makes it easy to access product information, calculators, and much more from iPhone® and Android™ devices.



FEATURES

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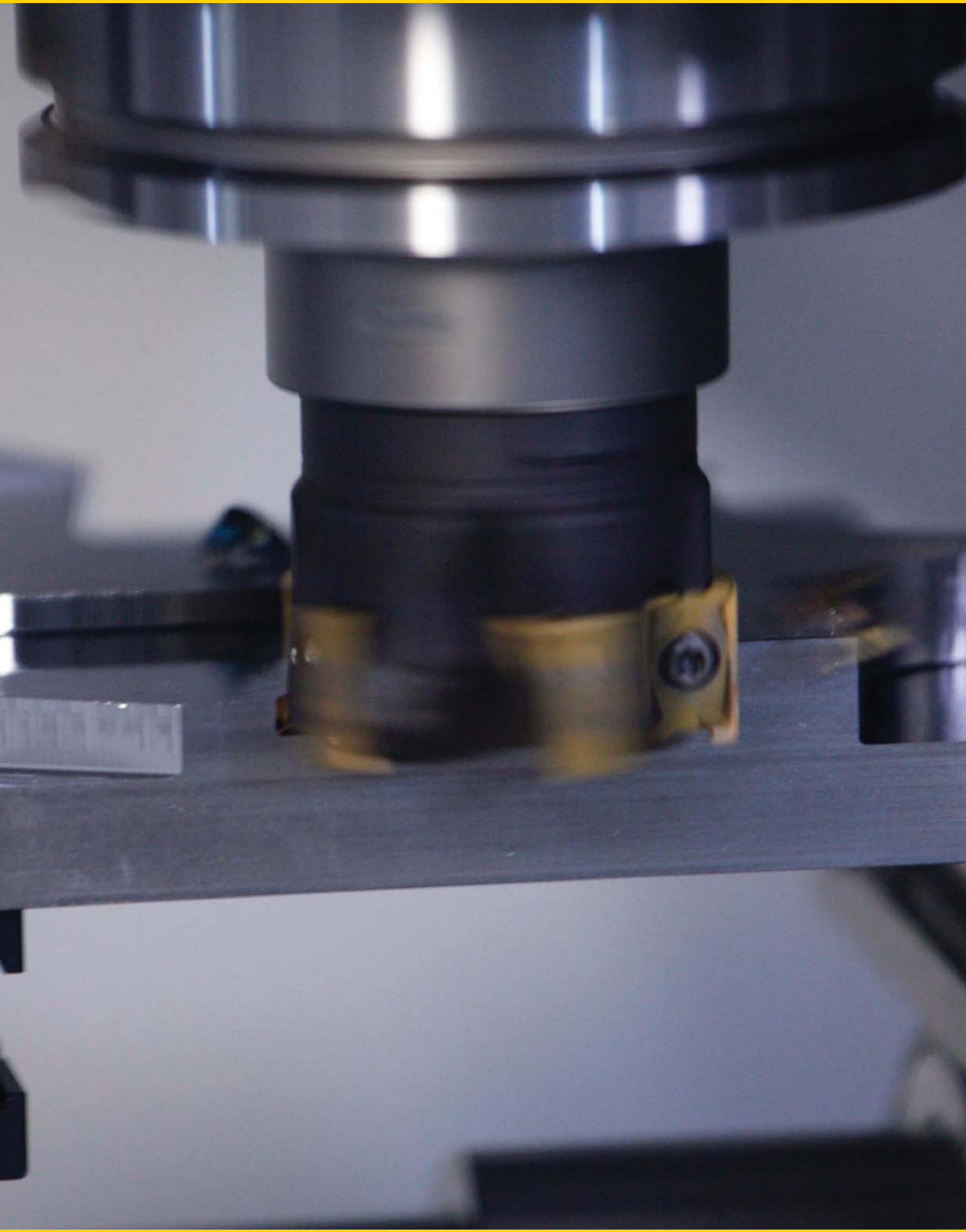


Indexable Milling • Shoulder Milling

Mill 4 • Double-Sided Shoulder Milling T2–T21

Mill 4-11 ..... T2–T11

Mill 4-15 ..... T12–T21

Mill 1 • Single-Sided Shoulder Milling T22–T83

Mill 1-7 ..... T22–T26

Mill 1-10 ..... T28–T44

Mill 1-14 ..... T46–T66

Mill 1-18 ..... T68–T76

Mill 1-25 ..... T78–T83

Stellram 5720VZ16 Series • High-Speed Aluminium Cutting T84–T94

KSSM • Square Shoulder Milling T96–T106

KSSM-KSSP • Helical Square Shoulder Milling T108–T113

Stellram 5230VS Series T114–T123

Mill 4-11™

One tool for all applications.

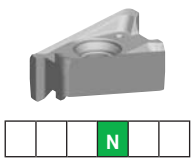
The Mill 4™ series is specially engineered to achieve excellent surface quality and higher metal removal rates in shoulder milling applications. Its unique design allows you to apply the tool in multiple passes (stepping down) with outstanding results.

From roughing to finishing operations, the Mill 4 series is applicable in a wide range of workpiece materials: steel, cast iron, stainless steel, non-ferrous materials, and high-temp alloys.

Features and Benefits

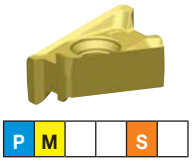
- Double-sided strong insert with 4 cutting edges.
- High positive geometry for lower cutting forces.
- Superior wall and surface finish capabilities.
- “Stepless” solution for multiple-pass operations.
- Comprehensive offering to cover all applications in all material groups.

-ELEJ



For non-ferrous materials.

-EGE



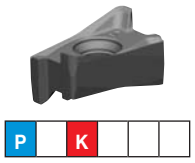
1st choice for stainless steel. Lower cutting forces.

-SGE



First choice for the Mill 4 platform, especially when machining steels.

-SGEM



1st choice for cast iron. Strongest cutting edge.

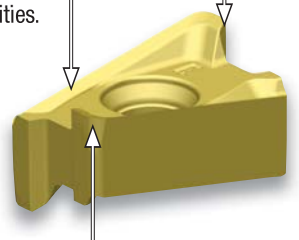
Uneven pocket spacing.

Screw-on, end mills, and shell mill cutter with internal coolant.



Integrated wiper facet for best-in-class floor finisher.

Up to 11mm Ap capabilities.

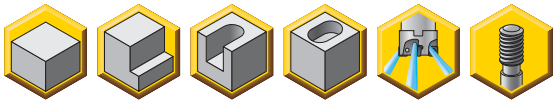


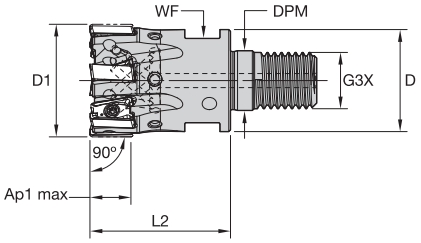
Multiple corner nose radii available from 0,4mm up to 1,6mm.

Double-sided insert with 4 cutting edges.

TP9 insert screw (M3) to provide higher reliability and safe processes.

- One tool for all applications: from roughing to finishing.
- Superior wall and surface finishing capabilities. Best choice for stepping down operations.
- Up to 11mm depth of cut.
- Screw-on cutters provide better rigidity and stability when used with small spindles: BT30, BT40, DV40, HSK50, HSK63, etc.
- Screw-on cutters can be less expensive when compared to cylindrical shank cutters due to their higher flexibility through multiple holder combinations.







Screw-On End Mills

order number	catalogue number	D1	D	DPM	G3X	L2	WF	Ap1 max	Z	kg	max RPM
6136738	**M4D016Z02M08LN11**	16	13	8,5	M8	25	10	11,0	2	0,03	48000
6131682	**M4D020Z03M10LN11**	20	18	10,5	M10	28	15	11,0	3	0,06	40200
6131686	**M4D025Z04M12LN11**	25	21	12,5	M12	40	17	11,0	4	0,10	34300
6136793	**M4D032Z05M16LN11**	32	29	17,0	M16	40	24	11,0	5	0,20	29200
6134187	**M4D032Z06M16LN11**	32	29	17,0	M16	40	24	11,0	6	0,19	29200

Spare Parts

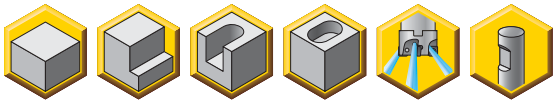


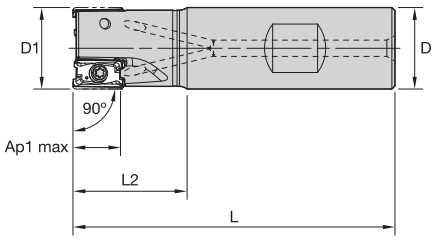




D1	insert screw	Nm	Torx Plus driver
16	**MS2263**	1,5	**DT9IP**
20	**MS2263**	1,5	**DT9IP**
25	**MS2263**	1,5	**DT9IP**
32	**MS2263**	1,5	**DT9IP**

- One tool for all applications: from roughing to finishing.
- Superior wall and surface finishing capabilities.
- Best choice for stepping down operations.
- Up to 11mm depth of cut.







Weldon End Mills

order number	catalogue number	D1	D	L	L2	Ap1 max	Z	kg	max RPM
6131628	**M4D016Z02B16LN11**	16	16	74	25	11,0	2	0,09	48000
6131630	**M4D020Z02B20LN11**	20	20	79	28	11,0	2	0,17	40200
6136740	**M4D020Z03B20LN11**	20	20	79	28	11,0	3	0,16	42000
6131684	**M4D025Z03B25LN11**	25	25	89	32	11,0	3	0,29	34300
6134185	**M4D032Z04B32LN11**	32	32	110	49	11,0	4	0,60	29200
6136795	**M4D040Z05B32LN11**	40	32	110	49	11,0	5	0,66	25400

Spare Parts

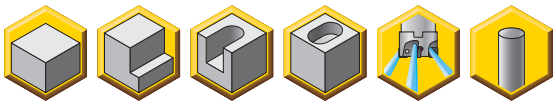


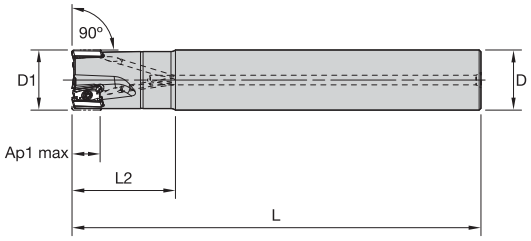




D1	insert screw	Nm	Torx Plus driver
16	**MS2263**	1,5	**DT9IP**
20	**MS2263**	1,5	**DT9IP**
25	**MS2263**	1,5	**DT9IP**
32	**MS2263**	1,5	**DT9IP**
40	**MS2263**	1,5	**DT9IP**

- One tool for all applications: from roughing to finishing.
- Superior wall and surface finishing capabilities.
- Best choice for stepping down operations.
- Up to 11mm depth of cut.







Cylindrical End Mills

order number	catalogue number	D1	D	L	L2	Ap1 max	Z	kg	max RPM
6131627	M4D016Z02A16LN11L090	16	16	90	25	11,0	2	0,12	48000
6136737	M4D016Z02A16LN11L150	16	16	150	25	11,0	2	0,21	48000
6131629	M4D020Z02A20LN11L150	20	20	150	28	11,0	2	0,33	40200
6131681	M4D020Z03A20LN11L090	20	20	90	28	11,0	3	0,21	40200
6136739	M4D020Z03A20LN11L150	20	20	150	28	11,0	3	0,33	40200
6131683	M4D025Z03A25LN11L170	25	25	170	43	11,0	3	0,63	34300
6131685	M4D025Z04A25LN11L100	25	25	100	43	11,0	4	0,33	34300
6136791	M4D025Z04A25LN11L170	25	25	170	43	11,0	4	0,59	34300
6134184	M4D032Z04A32LN11L200	32	32	200	49	11,0	4	1,16	29200
6134186	M4D032Z05A32LN11L110	32	32	110	49	11,0	5	0,61	29200
6136792	M4D032Z05A32LN11L200	32	32	200	49	11,0	5	1,17	29200
6136794	M4D040Z05A32LN11L200	40	32	200	49	11,0	5	1,22	25400

Spare Parts

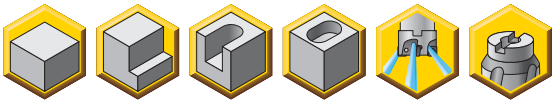


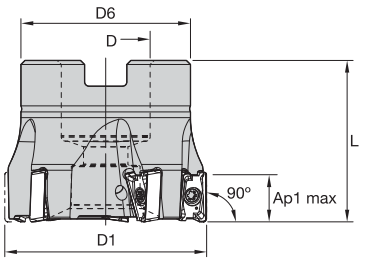


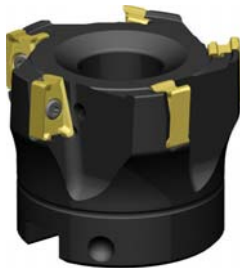


D1	insert screw	Nm	Torx Plus driver
16	MS2263	1,5	DT9IP
20	MS2263	1,5	DT9IP
25	MS2263	1,5	DT9IP
32	MS2263	1,5	DT9IP
40	MS2263	1,5	DT9IP

- One tool for all applications: from roughing to finishing.
- Superior wall and surface finishing capabilities.
- Best choice for stepping down operations.
- Up to 11mm depth of cut.







Shell Mills

order number	catalogue number	D1	D	D6	L	Ap1 max	Z	kg	max RPM
6134188	**M4D040Z04S16LN11**	40	16	37	40	11,0	4	0,23	25400
6134189	**M4D040Z06S16LN11**	40	16	37	40	11,0	6	0,22	25400
6136796	**M4D040Z07S16LN11**	40	16	37	40	11,0	7	0,23	25400
6134190	**M4D050Z05S22LN11**	50	22	42	40	11,0	5	0,31	22300
6134231	**M4D050Z07S22LN11**	50	22	42	40	11,0	7	0,32	22300
6136797	**M4D050Z09S22LN11**	50	22	42	40	11,0	9	0,32	22300
6134232	**M4D063Z06S22LN11**	63	22	50	40	11,0	6	0,56	19500
6134233	**M4D063Z09S22LN11**	63	22	50	40	11,0	9	0,56	19500
6134234	**M4D080Z08S27LN11**	80	27	60	50	11,0	8	1,12	17100
6136798	**M4D080Z10S27LN11**	80	27	60	50	11,0	10	1,11	17100

Spare Parts





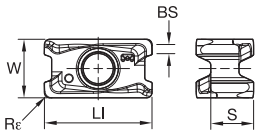

D1	insert screw	Nm	Torx Plus driver	socket-head cap screw
40	**MS2263**	1,5	**DT9IP**	**125.825**
50	**MS2263**	1,5	**DT9IP**	**125.025**
63	**MS2263**	1,5	**DT9IP**	**125.025**
80	**MS2263**	1,5	**DT9IP**	**125.230**

Insert Selection Guide

Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		←	→	toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.E..GE	KCPM40	**.S..GE**	**KCPM40**	.S..GEM	KCPM40
P3–P4	.E..GE	KCPM40	**.S..GE**	**KCPM40**	.S..GEM	KCPM40
P5–P6	.E..GE	KC725M	**.S..GE**	**KC725M**	.S..GEM	KCPM40
M1–M2	.E..GE	KCSM40	**.S..GE**	**KCSM40**	.S..GEM	KC522M
M3	.E..GE	KCPM40	**.S..GE**	**KCPM40**	.S..GEM	KCPM40
K1–K2	.S..GE	KC520M	**.S..GE**	**KCK15**	.S..GEM	KCK15
K3	.S..GE	KC520M	**.S..GE**	**KCK15**	.S..GEM	KC520M
N1–N2	.E..LEJ	KC422M	**.E..LEJ**	**KC422M**	.E..LEJ	KC422M
N3	.E..LEJ	KC422M	**.E..LEJ**	**KC422M**	.E..LEJ	KC422M
S1–S2	.E..GE	KCSM40	**.S..GE**	**KC725M**	.S..GE	KCSM40
S3	.E..GE	KCSM40	**.S..GE**	**KCSM40**	.S..GE	KCSM40
S4	.E..GE	KCSM40	**.S..GE**	**KCSM40**	.S..GE	KCSM40
H1	–	–	**–**	**–**	–	–

Indexable Inserts • Mill 4-11


LNGU11-ELEJ



LNGU11-ELEJ

● first choice
○ alternate choice

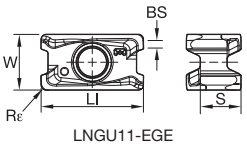
		KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
P				○	●		●	●		○
M				●	●		○	●	○	●
K			●	○		●	○			
N		●								
S				●	●			○	●	●
H										

LNGU11-ELEJ • For Aluminium and Other Non-Ferrous Alloys

catalogue number	LI	S	W	BS	Rε	hm	cutting edges	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
LNGU110404ERLEJ	12,16	4,83	6,60	1,40	0,4	0,04	4	●	–	–	–	–	–	–	–	–
LNGU110408ERLEJ	12,16	4,83	6,60	1,00	0,8	0,04	4	●	–	–	–	–	–	–	–	–

- -EGE is the first choice for stainless steel and high-temp alloys.
- Use -EGE geometry for the highest finishing requirements, in light machining, for all materials.


LNGU11-EGE



LNGU11-EGE

LNGU11-EGE • Precision Ground • For Stainless Steel and High-Temp Alloys

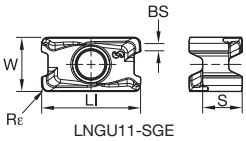
catalogue number	LI	S	W	BS	Rε	hm	cutting edges	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
LNGU110404ERGE	12,16	4,83	6,60	1,40	0,4	0,08	4	–	–	●	●	–	–	●	–	–
LNGU110408ERGE	12,16	4,83	6,60	1,00	0,8	0,08	4	–	–	●	●	–	–	●	●	●
LNGU110412ERGE	12,17	4,83	6,60	0,60	1,2	0,08	4	–	–	●	–	–	–	●	–	●

- -SGE is the universal geometry for Mill 4-11. First choice when machining steel, as well as stainless steel, and high-temp alloys in heavy applications.
- Precision ground insert results in a great versatility for both roughing and finishing operations.

● first choice
○ alternate choice

P			○	●		●	●		○
M			●	●		○	●	○	●
K		●	○		●	○			
N	●								
S			●	●			○	●	●
H									


LNGU11-SGE



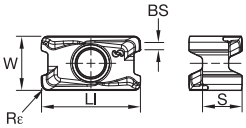
LNGU11-SGE

LNGU11-SGE • Precision Ground • Universal Geometry • General Purpose for Roughing and Finishing Operations

catalogue number	LI	S	W	BS	Rε	hm	cutting edges	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
LNGU110404SRGE	12,16	4,83	6,60	1,40	0,4	0,10	4	–	–	●	–	–	–	●	–	●
LNGU110408SRGE	12,16	4,83	6,60	1,00	0,8	0,10	4	–	–	●	●	●	●	●	–	●

- -SGE is the universal geometry for Mill 4-11. First choice when machining steel, as well as stainless steel and high-temp alloys in heavy applications.
- Precision-pressed insert is a perfect choice for roughing operations with a better cost per edge and great surface quality.


LNPU11-SGE



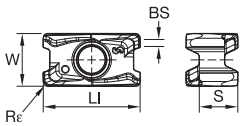
LNPU11-SGE

LNPU11-SGE • Precision Pressed • General Purpose for Roughing and Semi-Finishing Operations

catalogue number	LI	S	W	BS	Rε	hm	cutting edges	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
LNPU110408SRGE	12,10	4,83	6,60	0,90	0,8	0,10	4	–	●	●	●	●	●	●	–	–
LNPU110412SRGE	12,10	4,83	6,60	0,50	1,2	0,10	4	–	●	●	●	●	●	●	–	–
LNPU110416SRGE	12,10	4,83	6,60	0,02	1,6	0,10	4	–	●	●	●	–	●	●	–	–

- -SGEM geometry is the first choice for cast iron machining in medium and heavy applications.
- -M stands for margins, which are used to reinforce the geometry.


LNGU11-SGEM



LNGU11-SGEM

LNGU11-SGEM • Precision Ground • For Cast Iron and Heavy Applications

catalogue number	LI	S	W	BS	Rε	hm	cutting edges	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
LNGU110408SRGEM	12,16	4,83	6,60	0,90	0,8	0,10	4	–	●	●	–	●	●	●	–	–
LNGU110412SRGEM	12,16	4,83	6,60	0,60	1,2	0,10	4	–	●	–	–	●	●	●	–	–
LNGU110416SRGEM	12,16	4,83	6,60	0,10	1,6	0,10	4	–	●	–	–	●	●	●	–	–

Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.E..LEJ	0,13	**0,35**	0,58	0,09	**0,25**	0,42	0,07	**0,19**	0,31	0,06	**0,17**	0,27	0,06	**0,15**	0,25	.E..LEJ
.E..GE	0,23	**0,43**	0,59	0,17	**0,31**	0,43	0,13	**0,23**	0,32	0,11	**0,20**	0,28	0,10	**0,18**	0,25	.E..GE
.S..GE	0,23	**0,46**	0,65	0,17	**0,33**	0,47	0,13	**0,25**	0,35	0,11	**0,22**	0,31	0,10	**0,20**	0,28	.S..GE
.S..GEM	0,23	**0,46**	0,71	0,17	**0,33**	0,51	0,13	**0,25**	0,38	0,11	**0,22**	0,33	0,10	**0,20**	0,30	.S..GEM

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

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Mill 4-11 Starter Kits

Order one of our starting kits and test the performance of our new Mill 4™ platform. The kits are set up to serve the majority of shoulder milling applications, delivered with a cutter body as well as 20 inserts from a premium Kennametal grade.

Detailed order information can be found in the table below.

Order one Mill 4 kit and experience the next level of shoulder milling!



Mill 4-11 Starter Kits • Metric

order number	catalogue number	cutter diameter/ flutes	cutter type	material group	application range	content				
						cutter	quantity	insert	grade	quantity
6213970	M4-11KITD16Z2A16SGEKCPM40	16z2	Cylindrical	P	∇/∇∇	M4D016Z02A16LN11L090	1	LNPU110408SRGE	KCPM40	20
6214071	M4-11KITD20Z2B20SGEKCPM40	20z2	Weldon	P	∇/∇∇	M4D020Z02B20LN11	1	LNPU110408SRGE	KCPM40	20
6214072	M4-11KITD20Z3A20SGEKCPM40	20z3	Cylindrical	P	∇/∇∇	M4D020Z03A20LN11L090	1	LNPU110408SRGE	KCPM40	20
6214073	M4-11KITD25Z3B25SGEKCPM40	25z3	Weldon	P	∇/∇∇	M4D025Z03B25LN11	1	LNPU110408SRGE	KCPM40	20
6214074	M4-11KITD25Z4A25SGEKCPM40	25z4	Cylindrical	P	∇/∇∇	M4D025Z04A25LN11L100	1	LNPU110408SRGE	KCPM40	20
6214075	M4-11KITD32Z4B32SGEKCPM40	32z4	Weldon	P	∇/∇∇	M4D032Z04B32LN11	1	LNPU110408SRGE	KCPM40	20
6214076	M4-11KITD32Z5A32SGEKCPM40	32z5	Cylindrical	P	∇/∇∇	M4D032Z05A32LN11L110	1	LNPU110408SRGE	KCPM40	20
6214077	M4-11KITD40Z4S16SGEKCPM40	40z4	Shell Mill	P	∇/∇∇	M4D040Z04S16LN11	1	LNPU110408SRGE	KCPM40	20
6214078	M4-11KITD40Z6S16SGEKCPM40	40z6	Shell Mill	P	∇/∇∇	M4D040Z06S16LN11	1	LNPU110408SRGE	KCPM40	20
6214079	M4-11KITD50Z5S22SGEKCPM40	50z5	Shell Mill	P	∇/∇∇	M4D050Z05S22LN11	1	LNPU110408SRGE	KCPM40	20
6214080	M4-11KITD50Z7S22SGEKCPM40	50z7	Shell Mill	P	∇/∇∇	M4D050Z07S22LN11	1	LNPU110408SRGE	KCPM40	20
6214081	M4-11KITD63Z9S22SGEKCPM40	63z9	Shell Mill	P	∇/∇∇	M4D063Z09S22LN11	1	LNPU110408SRGE	KCPM40	20
6214082	M4-11KITD16Z2A16EGEKC725M	16z2	Cylindrical	M+S	∇∇/∇∇∇	M4D016Z02A16LN11L090	1	LNGU110408ERGE	KC725M	20
6214083	M4-11KITD20Z2B20EGEKC725M	20z2	Weldon	M+S	∇∇/∇∇∇	M4D020Z02B20LN11	1	LNGU110408ERGE	KC725M	20
6214084	M4-11KITD20Z3A20EGEKC725M	20z3	Cylindrical	M+S	∇∇/∇∇∇	M4D020Z03A20LN11L090	1	LNGU110408ERGE	KC725M	20
6214085	M4-11KITD25Z3B20EGEKC725M	25z3	Weldon	M+S	∇∇/∇∇∇	M4D025Z03B25LN11	1	LNGU110408ERGE	KC725M	20
6214086	M4-11KITD25Z4A25EGEKC725M	25z4	Cylindrical	M+S	∇∇/∇∇∇	M4D025Z04A25LN11L100	1	LNGU110408ERGE	KC725M	20
6214087	M4-11KITD32Z4B32EGEKC725M	32z4	Weldon	M+S	∇∇/∇∇∇	M4D032Z04B32LN11	1	LNGU110408ERGE	KC725M	20
6214088	M4-11KITD32Z5A32EGEKC725M	32z5	Cylindrical	M+S	∇∇/∇∇∇	M4D032Z05A32LN11L110	1	LNGU110408ERGE	KC725M	20
6214089	M4-11KITD40Z4S16EGEKC725M	40z4	Shell Mill	M+S	∇∇/∇∇∇	M4D040Z04S16LN11	1	LNGU110408ERGE	KC725M	20
6214090	M4-11KITD40Z6S16EGEKC725M	40z6	Shell Mill	M+S	∇∇/∇∇∇	M4D040Z06S16LN11	1	LNGU110408ERGE	KC725M	20
6214091	M4-11KITD50Z5S22EGEKC725M	50z5	Shell Mill	M+S	∇∇/∇∇∇	M4D050Z05S22LN11	1	LNGU110408ERGE	KC725M	20
6214092	M4-11KITD50Z7S22EGEKC725M	50z7	Shell Mill	M+S	∇∇/∇∇∇	M4D050Z07S22LN11	1	LNGU110408ERGE	KC725M	20
6214093	M4-11KITD63Z9S22EGEKC725M	63z9	Shell Mill	M+S	∇∇/∇∇∇	M4D063Z09S22LN11	1	LNGU110408ERGE	KC725M	20

∇ Heavy/Roughing
∇∇ Medium
∇∇∇ Light machining/Finishing

Mill 4-15™ • Double-Sided Shoulder Milling

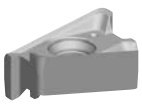
Primary Application

The Mill 4-15 series is specially engineered to achieve excellent surface quality and higher material removal rates in shoulder milling applications. Its unique design enables multiple passes (stepping down) with outstanding results. The Mill 4™ platform is applicable in a wide range of workpiece materials: steel, cast iron, stainless steel, and titanium, from roughing to finishing operations.

Features and Benefits

- Double-sided strong insert with 4 cutting edges.
- High positive geometry for lower cutting forces.
- Superior wall and surface finish capabilities.
- "Stepless" solution. No mismatch when machining walls in different steps.

-EGEJ





For non-ferrous materials.

-EGE





1st choice for stainless steel. Lower cutting forces.

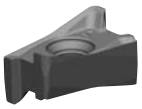
-SGE





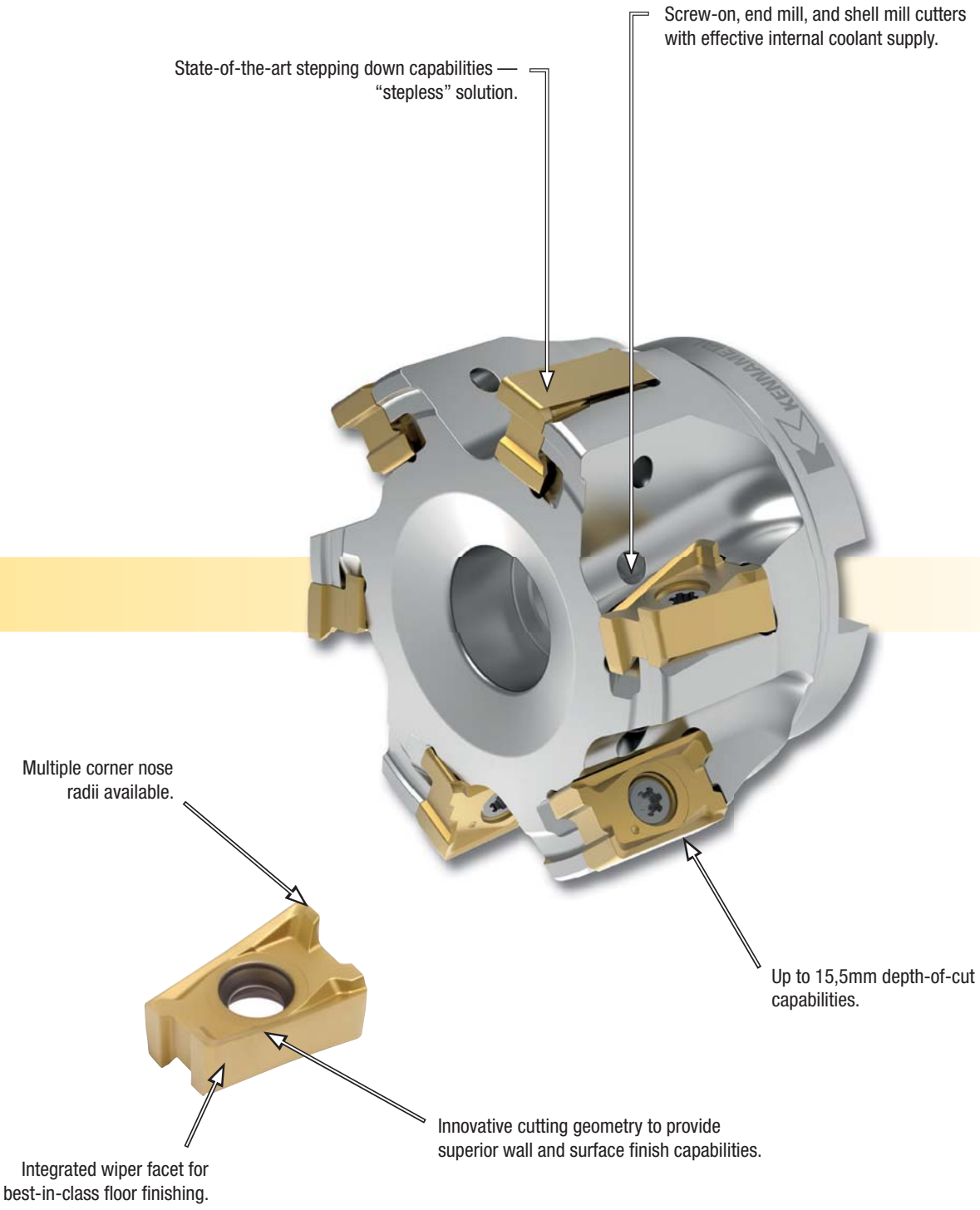
First choice for the Mill 4 platform, especially when machining steels.

-SGEM

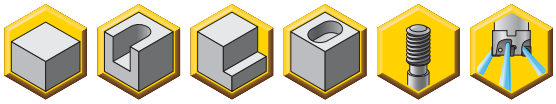


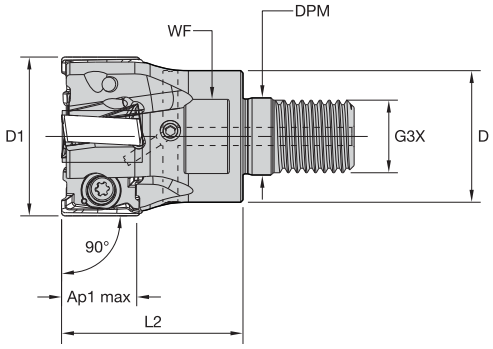


1st choice for cast iron. Strongest cutting edge.


Screw-on, end mill, and shell mill cutters with effective internal coolant supply.
State-of-the-art stepping down capabilities — "stepless" solution.
Multiple corner nose radii available.
Up to 15,5mm depth-of-cut capabilities.
Innovative cutting geometry to provide superior wall and surface finish capabilities.
Integrated wiper facet for best-in-class floor finishing.

- Superior wall and surface finish capabilities.
- True 90° capabilities. Stepless solution when using multiple steps.
- Engineered to run up to 15,5mm depth of cut.
- Effective internal coolant feature, reaching the cutting edge precisely.







Screw-On End Mills

order number	catalogue number	D1	D	DPM	G3X	L2	WF	Ap1 max	Z	kg	max RPM
5531911	**M4D025Z02M12LN15**	25	21	12,5	M12	32	17	15,5	2	0,08	26700
5531912	**M4D032Z03M16LN15**	32	29	17,0	M16	40	24	15,5	3	0,18	22000
5555606	**M4D032Z04M16LN15**	32	29	17,0	M16	40	24	15,5	4	0,18	22000
5528599	**M4D035Z04M16LN15**	35	29	17,0	M16	40	24	15,5	4	0,19	20600
5531913	**M4D040Z05M16LN15**	40	29	17,0	M16	40	24	15,5	5	0,23	18800

Spare Parts

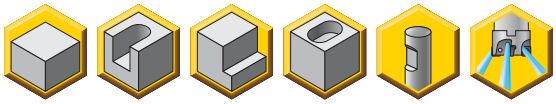


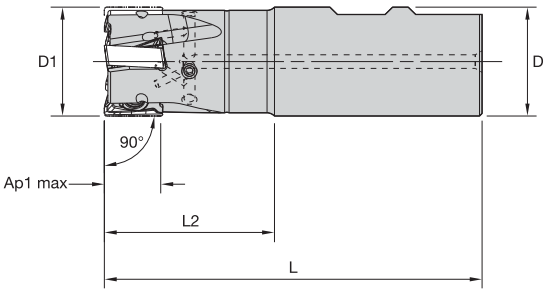




D1	insert screw	Nm	Torx Plus driver
25	**MS-2071**	3,5	**DT15IP**
32	**MS-2071**	3,5	**DT15IP**
35	**MS-2071**	3,5	**DT15IP**
40	**MS-2071**	3,5	**DT15IP**

- Superior wall and surface finish capabilities.
- True 90° capabilities. Stepless solution when using multiple steps.
- Engineered to run up to 15,5mm depth of cut.
- Effective internal coolant feature, reaching the cutting edge precisely.







Weldon End Mills

order number	catalogue number	D1	D	L	L2	Ap1 max	Z	kg	max RPM
5528630	**M4D025Z02B25LN15**	25	25	89	32	15,5	2	0,28	26700
5528631	**M4D032Z03B32LN15**	32	32	111	50	15,5	3	0,58	22000
5531914	**M4D040Z03B32LN15**	40	32	111	50	15,5	3	0,65	18800
5555607	**M4D040Z04B32LN15**	40	32	111	50	15,5	4	0,65	18800

Spare Parts



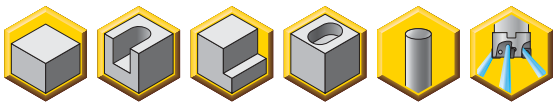


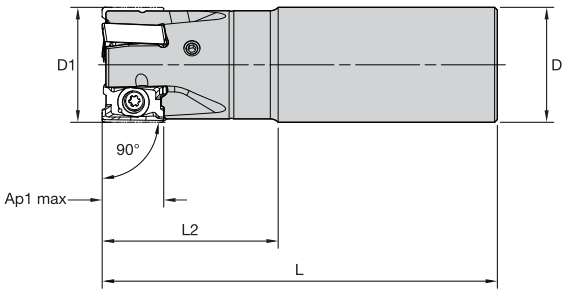


D1	insert screw	Nm	Torx Plus driver
25	**MS-2071**	3,5	**DT15IP**
32	**MS-2071**	3,5	**DT15IP**
40	**MS-2071**	3,5	**DT15IP**

NOTE: Weldon type not recommended for finishing operations.

- Superior wall and surface finish capabilities.
- True 90° capabilities. Stepless solution when using multiple steps.
- Engineered to run up to 15,5mm depth of cut.
- Effective internal coolant feature, reaching the cutting edge precisely.







Cylindrical End Mills

order number	catalogue number	D1	D	L	L2	Ap1 max	Z	kg	max RPM
5531915	**M4D025Z02A25LN15L100**	25	25	100	43	15,5	2	0,28	26700
5531916	**M4D025Z02A25LN15L170**	25	25	170	43	15,5	2	0,58	26700
5531917	**M4D032Z03A32LN15L110**	32	32	110	49	15,5	3	0,58	22000
5531918	**M4D032Z03A32LN15L200**	32	32	200	50	15,5	3	1,14	22000
5555608	**M4D032Z04A32LN15L110**	32	32	110	49	15,5	4	0,58	22000
5555609	**M4D032Z04A32LN15L200**	32	32	200	50	15,5	4	1,14	22000
5531919	**M4D040Z03A32LN15L200**	40	32	200	50	15,5	3	1,21	18800
5555800	**M4D040Z04A32LN15L200**	40	32	200	50	15,5	4	1,20	18800

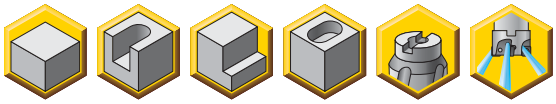
Spare Parts

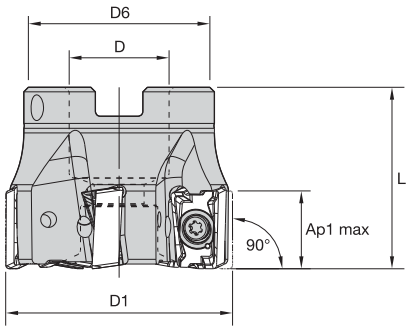


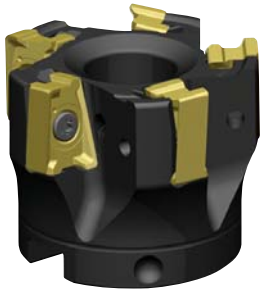


D1	insert screw	Nm	Torx Plus driver
25	**MS-2071**	3,5	**DT15IP**
32	**MS-2071**	3,5	**DT15IP**
40	**MS-2071**	3,5	**DT15IP**

- Superior wall and surface finish capabilities.
- True 90° capabilities. Stepless solution when using multiple steps.
- Engineered to run up to 15,5mm depth of cut.
- Effective internal coolant feature, reaching the cutting edge precisely.







Shell Mills

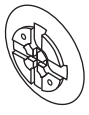
order number	catalogue number	D1	D	D6	L	Ap1 max	Z	kg	max RPM
5528632	M4D040Z04S16LN15	40	16	37	40	15,5	4	0,20	18800
5555801	M4D040Z05S16LN15	40	16	37	40	15,5	5	0,19	18800
5698436	M4D050Z04S22LN15	50	22	42	40	15,5	4	0,28	16300
5528633	M4D050Z05S22LN15	50	22	42	40	15,5	5	0,28	16300
5528634	M4D050Z06S22LN15	50	22	42	40	15,5	6	0,27	16300
5698437	M4D063Z05S22LN15	63	22	50	40	15,5	5	0,50	14200
5528635	M4D063Z06S22LN15	63	22	50	40	15,5	6	0,49	14200
5528636	M4D063Z07S22LN15	63	22	50	40	15,5	7	0,50	14200
5698438	M4D080Z05S27LN15	80	27	60	50	15,5	5	1,03	12300
5528637	M4D080Z07S27LN15	80	27	60	50	15,5	7	1,02	12300
5555802	M4D080Z09S27LN15	80	27	60	50	15,5	9	1,04	12300
5698439	M4D100Z06S32LN15	100	32	80	50	15,5	6	1,58	10900
5528638	M4D100Z08S32LN15	100	32	80	50	15,5	8	1,57	10900
5555803	M4D100Z11S32LN15	100	32	80	50	15,5	11	1,64	10900
5698490	M4D125Z07S40LN15	125	40	90	63	15,5	7	2,96	9600
5555804	M4D125Z09S40LN15	125	40	90	63	15,5	9	2,98	9600
5532000	M4D125Z12S40LN15	125	40	90	63	15,5	12	3,00	9600
5698491	M4D160Z08S40LN15	160	40	110	63	15,5	8	4,67	8400
5555805	M4D160Z12S40LN15	160	40	110	63	15,5	12	4,78	8400
5555806	M4D160Z16S40LN15	160	40	110	63	15,5	16	4,75	8400

Spare Parts









D1	insert screw	Nm	Torx Plus driver	socket-head cap screw	coolant lock screw assembly	coolant lock screw	coolant cap
40	MS-2071	3,5	DT15IP	125.825	–	–	–
50	MS-2071	3,5	DT15IP	125.025	–	–	–
63	MS-2071	3,5	DT15IP	125.025	–	–	–
80	MS-2071	3,5	DT15IP	125.230	–	–	–
100	MS-2071	3,5	DT15IP	–	MS2189C	–	–
125	MS-2071	3,5	DT15IP	–	MS2187C	–	–
160	MS-2071	3,5	DT15IP	–	–	420.200	470.233

NOTE: Coolant lock screw assembly and coolant cap must be ordered separately.

Insert Selection Guide

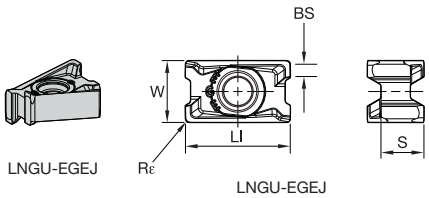
Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		←	→	toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.E..GE	KCPM40	**.S..GE**	**KCPM40**	.S..GEM	KCPM40
P3–P4	.E..GE	KCPM40	**.S..GE**	**KCPK30**	.S..GEM	KCPK30
P5–P6	.E..GE	KC725M	**.S..GE**	**KC725M**	.S..GEM	KCPK30
M1–M2	.E..GE	KCSM40	**.S..GE**	**KCSM40**	.S..GEM	KCPM40
M3	.E..GE	KCPM40	**.S..GE**	**KCPM40**	.S..GEM	KCPM40
K1–K2	.S..GE	KC520M	**.S..GE**	**KCK15**	.S..GEM	KC520M
K3	.S..GE	KC520M	**.S..GE**	**KCK15**	.S..GEM	KC520M
N1–N2	.E..GEJ	KC422M	**.E..GEJ**	**KC422M**	.E..GEJ	KC422M
N3	.E..GEJ	KC422M	**.E..GEJ**	**KC422M**	.E..GEJ	KC422M
S1–S2	.E..GE	KC725M	**.S..GE**	**KC725M**	.S..GE	KC725M
S3	.E..GE	KCSM40	**.S..GE**	**KCSM40**	.S..GE	KCSM40
S4	.E..GE	KCSM40	**.S..GE**	**KCSM40**	.S..GE	KCSM40
H1	–	–	**–**	**–**	–	–

Indexable Inserts • Mill 4-15™

- -EGEJ is the first choice for roughing and finishing of aluminium and other non-ferrous alloys.

● first choice
○ alternate choice

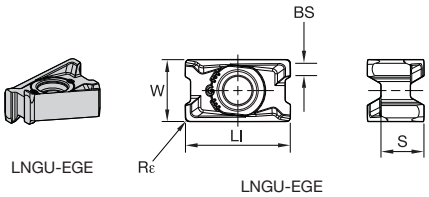
	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
P			○	●		●	●		○
M			●	●		○	●	○	●
K		●	○		●	○			
N	●								
S			●	●				○	●
H									



LNGU15-EGEJ • For Aluminium and Other Non-Ferrous Alloys

catalogue number	LI	S	W	BS	Rε	hm	cutting edges	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
LNGU15T604ERGEJ	17,00	6,96	10,00	2,20	0,4	0,03	4	●	–	–	–	–	–	–	–	–
LNGU15T608ERGEJ	17,00	6,96	10,00	1,80	0,8	0,03	4	●	–	–	–	–	–	–	–	–

- -EGE is the first choice for stainless steel and high-temp alloys.
- Best choice for finishing operations in steels, stainless steels, and high-temp alloys.



LNGU15-EGE • Precision Ground • For Stainless Steel and High-Temp Alloys

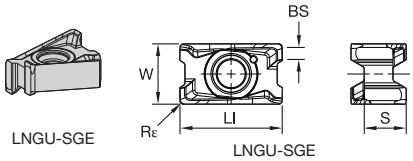
catalogue number	LI	S	W	BS	Rε	hm	cutting edges	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
LNGU15T604ERGE	17,01	6,96	10,00	2,20	0,4	0,08	4	–	–	●	●	–	–	●	●	–
LNGU15T608ERGE	17,01	6,96	10,00	1,80	0,8	0,08	4	–	–	●	●	–	–	●	●	●
LNGU15T612ERGE	17,01	6,96	10,00	1,40	1,2	0,08	4	–	–	●	●	–	–	●	●	●
LNGU15T616ERGE	17,01	6,96	10,00	1,07	1,6	0,08	4	–	–	–	●	–	–	●	●	–

- -SGE is the universal geometry for Mill 4-15.
- First choice when machining steel.
- Suitable for stainless steel and high-temp alloys in medium-heavy applications.

beyond

P			○	●		●	●		○
M			●	●		○	●	○	●
K		●	○		●	○			
N	●								
S			●	●			○	●	●
H									

● first choice
○ alternate choice

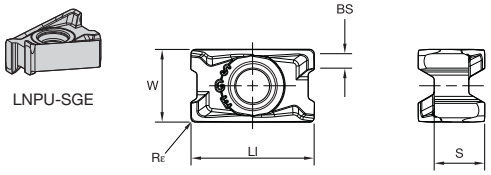


LNGU-SGE
LNGU-SGE

LNGU15-SGE • Precision Ground • For Steel Machining, Finishing, and Light Roughing

catalogue number	LI	S	W	BS	Rε	hm	cutting edges	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
LNGU15T604SRGE	17,00	6,96	10,00	2,20	0,4	0,10	4	–	●	●	●	●	●	–	–	–
LNGU15T608SRGE	17,01	6,96	10,00	1,80	0,8	0,10	4	–	●	●	●	●	●	–	–	●
LNGU15T612SRGE	17,01	6,96	10,00	1,40	1,2	0,10	4	–	●	●	●	●	●	–	–	●
LNGU15T616SRGE	17,01	6,96	10,00	1,07	1,6	0,10	4	–	●	●	●	●	●	–	–	–

- -SGE is the universal geometry for Mill 4-15. First choice when machining steel, as well as stainless steel and high-temp alloys in heavy applications.

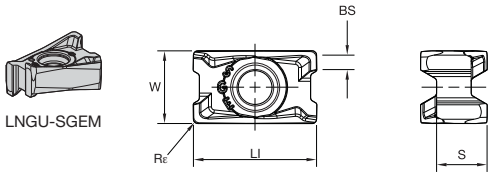


LNPU-SGE
LNPU-SGE

LNPU15-SGE • Precision Pressed • For Steel Machining in Medium-Heavy Roughing

catalogue number	LI	S	W	BS	Rε	hm	cutting edges	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
LNPU15T604SRGE	16,90	6,96	10,00	2,20	0,4	0,10	4	–	●	●	●	●	●	–	–	–
LNPU15T608SRGE	16,90	6,96	10,00	1,80	0,8	0,10	4	–	●	●	●	●	●	●	–	–
LNPU15T612SRGE	16,90	6,96	10,00	1,50	1,2	0,10	4	–	●	●	●	–	●	●	–	–
LNPU15T616SRGE	16,90	6,96	10,00	1,10	1,6	0,10	4	–	–	–	–	–	–	●	–	–
LNPU15T620SRGE	16,92	6,96	10,00	0,70	2,0	0,10	4	–	–	●	●	●	●	●	–	–

- -SGEM geometry is the first choice for cast iron machining in medium and heavy applications.



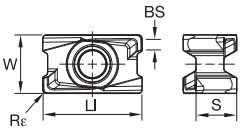
LNGU-SGEM
LNGU-SGEM

LNGU15-SGEM • For Cast Iron Machining

catalogue number	LI	S	W	BS	Rε	hm	cutting edges	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
LNGU15T608SRGEM	17,01	6,96	10,00	1,70	0,8	0,10	4	–	●	–	–	●	●	●	–	–
LNGU15T612SRGEM	17,01	6,96	10,00	1,30	1,2	0,10	4	–	●	–	–	●	–	●	–	–
LNGU15T616SRGEM	17,01	6,96	10,00	0,95	1,6	0,10	4	–	●	–	–	●	●	●	–	–
LNGU15T620SRGEM	17,01	6,96	10,00	0,34	2,0	0,10	4	–	●	–	–	●	●	●	–	–

- H stands for helical.
- Insert specially design to fit in helical cutters (porcupine).


LNGU15-SGEH



LNGU15-SGEH

● first choice
○ alternate choice

		KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
P				○	●		●	●		○
M				●	●		○	●	○	●
K			●	○		●	○			
N		●								
S				●	●			○	●	●
H										

LNGU15-SGEH • For Mill 4-15 Helical Cutters (Porcupine Style)

catalogue number	LI	S	W	BS	Rε	hm	cutting edges	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
LNGU15T608SRGEH	17,01	6,96	10,00	1,80	0,8	0,10	4	–	–	–	–	–	–	–	–	●

Recommended Starting Feeds

Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.E..GEJ	0,12	**0,47**	0,84	0,08	**0,34**	0,60	0,06	**0,26**	0,45	0,06	**0,22**	0,39	0,05	**0,20**	0,36	.E..GEJ
.E..GE	0,23	**0,54**	0,93	0,17	**0,39**	0,67	0,13	**0,29**	0,50	0,11	**0,25**	0,44	0,10	**0,23**	0,40	.E..GE
.S..GE	0,23	**0,59**	0,95	0,17	**0,43**	0,68	0,13	**0,32**	0,51	0,11	**0,28**	0,44	0,10	**0,25**	0,41	.S..GE
.S..GEM	0,23	**0,59**	0,95	0,17	**0,43**	0,68	0,13	**0,32**	0,51	0,11	**0,28**	0,44	0,10	**0,25**	0,41	.S..GEM

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

Mill 4-15 Starter Kits

Order one of our starting kits and test the performance of our new Mill 4 platform. The kits are set up to serve the majority of shoulder milling applications and workpiece materials, delivered with a cutter body as well as 20 inserts from a premium Kennametal grade.



Order one Mill 4™ kit, and experience the next level of shoulder milling!



Detailed order information can be found in the table below:

Mill 4-15 Metric Starter Kits

material group	order number	catalogue number	cutter kit	application range	content				
					cutter	qty	insert	grade	qty
P	5956817	M4KITD25Z02A25SGEKCPM40	D25z2	∇∇	M4D025Z02A25LN15L100	1	LNPU15T608SRGE	KCPM40	20
P	5956818	M4KITD32Z03A32SGEKCPM40	D32z3	∇∇	M4D032Z03A32LN15L110	1	LNPU15T608SRGE	KCPM40	20
P	5956819	M4KITD40Z04S16SGEKCPM40	D40z4	∇∇	M4D040Z04S16LN15	1	LNPU15T608SRGE	KCPM40	20
P	5956820	M4KITD50Z05S22SGEKCPM40	D50z5	∇∇	M4D050Z05S22LN15	1	LNPU15T608SRGE	KCPM40	20
P	5956872	M4KITD50Z06S22SGEKCPM40	D50z6	∇∇	M4D050Z06S22LN15	1	LNPU15T608SRGE	KCPM40	20
P	5956873	M4KITD63Z06S22SGEKCPM40	D63z6	∇∇	M4D063Z06S22LN15	1	LNPU15T608SRGE	KCPM40	20
P	5956874	M4KITD80Z07S27SGEKCPM40	D80z7	∇∇	M4D080Z07S27LN15	1	LNPU15T608SRGE	KCPM40	20
P	5956875	M4KITD100Z08S32SGEKCPM40	D100z8	∇∇	M4D100Z08S32LN15	1	LNPU15T608SRGE	KCPM40	20
M + S	5956876	M4KITD25Z02A25EGEKC725M	D25z2	∇∇∇	M4D025Z02A25LN15L100	1	LNGU15T608ERGE	KC725M	20
M + S	5956877	M4KITD32Z03A32EGEKC725M	D32z3	∇∇∇	M4D032Z03A32LN15L110	1	LNGU15T608ERGE	KC725M	20
M + S	5956878	M4KITD40Z04S16EGEKC725M	D40z4	∇∇∇	M4D040Z04S16LN15	1	LNGU15T608ERGE	KC725M	20
M + S	5956879	M4KITD50Z05S22EGEKC725M	D50z5	∇∇∇	M4D050Z05S22LN15	1	LNGU15T608ERGE	KC725M	20
M + S	5956880	M4KITD50Z06S22EGEKC725M	D50z6	∇∇∇	M4D050Z06S22LN15	1	LNGU15T608ERGE	KC725M	20
M + S	5956891	M4KITD63Z06S22EGEKC725M	D63z6	∇∇∇	M4D063Z06S22LN15	1	LNGU15T608ERGE	KC725M	20
M + S	5956892	M4KITD80Z07S27EGEKC725M	D80z7	∇∇∇	M4D080Z07S27LN15	1	LNGU15T608ERGE	KC725M	20
K	5956893	M4KITD25Z02A25SGEMKC520M	D25z2	∇	M4D025Z02A25LN15L100	1	LNGU15T608SRGEM	KC520M	20
K	5956894	M4KITD32Z03A32SGEMKC520M	D32z3	∇	M4D032Z03A32LN15L110	1	LNGU15T608SRGEM	KC520M	20
K	5956896	M4KITD40Z04S16SGEMKC520M	D40z4	∇	M4D040Z04S16LN15	1	LNGU15T608SRGEM	KC520M	20
K	5956897	M4KITD50Z05S22SGEMKC520M	D50z5	∇	M4D050Z05S22LN15	1	LNGU15T608SRGEM	KC520M	20
K	5956898	M4KITD50Z06S22SGEMKC520M	D50z6	∇	M4D050Z06S22LN15	1	LNGU15T608SRGEM	KC520M	20
K	5956899	M4KITD63Z07S22SGEMKC520M	D63z7	∇	M4D063Z07S22LN15	1	LNGU15T608SRGEM	KC520M	20
K	5956900	M4KITD80Z09S27SGEMKC520M	D80z9	∇	M4D080Z09S27LN15	1	LNGU15T608SRGEM	KC520M	20
K	5956901	M4KITD100Z11S32SGEMKC520M	D100z11	∇	M4D100Z11S32LN15	1	LNGU15T608SRGEM	KC520M	20

∇ Heavy/Roughing
∇∇ Medium
∇∇∇ Light machining/Finishing

Mill 1-7™

Primary Application

Mill 1-7 is engineered for small-component machining and covers multiple applications, including ramping, slotting, and plunging. Mill 1-7 tools provide solutions for roughing and finishing operations in energy, aerospace, and general engineering, where small-diameter end mills are required.



Features and Benefits

- Mill 1-7 inserts enable the use of higher density cutters, providing greater feed and higher metal removal rates.
- Super positive rake provides soft action and low cutting forces for smooth entry and exit from the component. Run at higher feed rates while using less power.
- Inserts are designed with elliptical cutting edges and are optimised for a straight 90° wall.
- Inserts are available in five grades: KC725M™, KCSM30™, KCPM40™, KCPK30™, and KC522M™.
- Ramping, slotting, and plunging capabilities in one platform.



High-Performance Shoulder Mill



20º rake face angle and 13º clearance angle for soft cutting action and reduced cutting forces.

Internal coolant/air supply.

All pockets are machined into heat-treated material, which guarantees runout and pocket strength.

Elliptical edge generates 90º wall.

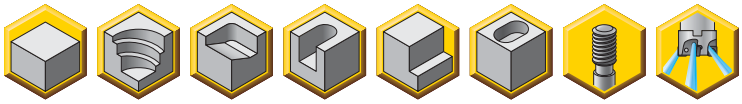
Chip gash designed for excellent chip evacuation.

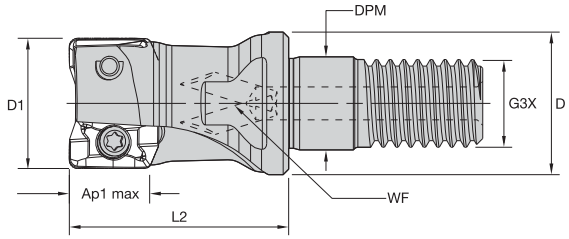
Margin along the main cutting edge and wiper facet for extra strength.

Insert screw: Torx 6.

Increase ramping capability up to 5.5º.

- Mill 90° walls.
- Aggressive ramping rates.
- High-speed machining.
- Ramp, slot, plunge, face, and shoulder milling.







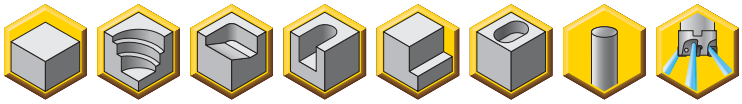
Screw-On End Mills

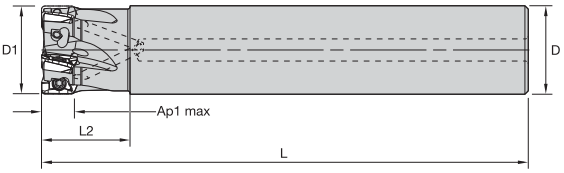
order number	catalogue number	D1	D	DPM	G3X	L2	WF	Ap1 max	Z	max ramp angle	kg	max RPM
5190197	**12A02R020M08ED07**	12	13	8,5	M8	20	10	7,0	2	5.2°	0,02	64510

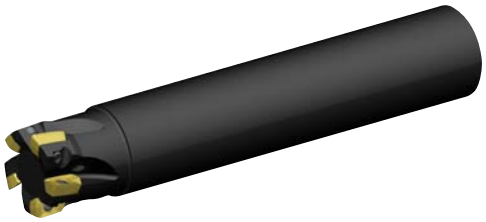
Spare Parts

D1	insert screw	Nm	Torx wrench
12	**12148006000**	0,5	**FT6**

- Mill 90° walls.
- Aggressive ramping rates.
- High-speed machining.
- Ramp, slot, plunge, face, and shoulder milling.







Cylindrical End Mills

order number	catalogue number	D1	D	L	L2	Ap1 max	Z	max ramp angle	kg	max RPM
5190190	**12A02R018A12ED07**	12	12	100	18	7,0	2	5.2°	0,08	64510
5190191	**16A03R020A16ED07**	16	16	100	20	7,0	3	2.9°	0,14	55790
5190192	**20A05R020A20ED07**	20	20	110	20	6,9	5	2.0°	0,24	49860

Spare Parts

D1	insert screw	Nm	Torx wrench
12	**12148006000**	0,5	**FT6**
16	**12148006000**	0,5	**FT6**
20	**12148006000**	0,5	**FT6**

Insert Selection Guide

Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		◄——►		toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.S..GE	KC725M	**.S..GE**	**KCPK30**	.S..GE	KCPM40
P3–P4	.S..GE	KC725M	**.S..GE**	**KCPK30**	.S..GE	KCPM40
P5–P6	.S..GE	KC725M	**.S..GE**	**KCPK30**	.S..GE	KCPM40
M1–M2	.S..GE	KC522M	**.S..GE**	**KC725M**	.S..GE	KCPM40
M3	.S..GE	KC725M	**.S..GE**	**KCPK30**	.S..GE	KCPM40
K1–K2	.S..GE	KCPK30	**.S..GE**	**KCPK30**	.S..GE	KCPK30
K3	.S..GE	KCPK30	**.S..GE**	**KCPK30**	.S..GE	KCPK30
N1–N2	–	–	**–**	**–**	–	–
N3	–	–	**–**	**–**	–	–
S1–S2	.S..GE	KC522M	**.S..GE**	**KC725M**	.S..GE	KC725M
S3	.S..GE	KC725M	**.S..GE**	**KC725M**	.S..GE	KCPM40
S4	.S..GE	KC522M	**.S..GE**	**KC725M**	.S..GE	KC725M
H1	–	–	**–**	**–**	–	–

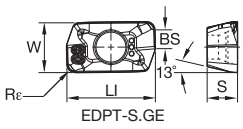
Indexable Inserts

- Medium roughing and semi-finishing.
- Solution for austenitic stainless steel and super alloys.
- Medium feed rates.
- PSTS — Precision Pressed and Sintered to Size.
- Ap1 max = 7mm.

● first choice
○ alternate choice

		KC522M	KC725M	KCPK30	KCSM30	KCPM40
P		○	●	●		●
M		●	●	○	○	○
K		○		○		
N						
S		●	●		●	
H		●				


EDPT-S.GE



EDPT-S.GE

EDPT-S.GE

catalogue number	Ll	S	W	BS	Rε	hm	cutting edges	KC522M	KC725M	KCPK30	KCSM30	KCPM40
EDPT070308PDSRGE	8,19	2,80	4,69	1,70	0,8	0,09	2	●	●	●	●	●

Recommended Starting Feeds

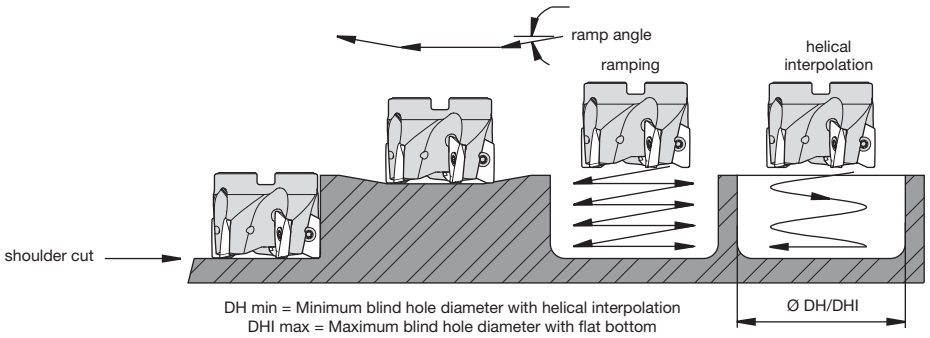
Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.S..GE	0,23	**0,47**	0,69	0,17	**0,34**	0,50	0,13	**0,26**	0,37	0,11	**0,22**	0,32	0,10	**0,20**	0,30	.S..GE

NOTE: Use "Light Machining" values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

Application Examples



cutting diameter	max ramp angle to non-cutting corner tangent	DH min (min hole diameter)	DHI min (min flat-bottomed hole diameter)	max diameter (no flat bottom)
12	5,49°	14,62	21,43	24
16	2,92°	22,52	28,04	32
20	2,01°	30,51	36,49	40

Mill 1-7	
max ADOC	6,98
fz	0,10–0,68
hm	0,09

Titanium and Stainless Steel Machining with New Milling Grade KCSM40™



Achieving maximum metal removal rates with highly engineering solutions from Kennametal.

- Ideal for roughing and semi-finishing operations.
- Available for the following milling series:
  - Mill 1™
  - Mill 4™
  - Dodeka™
  - MEGA™
  - KSOM™
  - NGE
  - KSSM™
  - KSSM8+™
  - Rodeka™
  - 5230 Series
  - 7713 Series
  - 7792 Series
- This new carbide substrate provides toughness and fatigue resistance, minimising the tendency for thermal cracking.
- The new coating provides high hot hardness and high abrasive resistance for unmatched tool life.
- KCSM40 milling grade is the first choice for high metal removal jobs in titanium structural aerospace components.
- Proven solution for various stainless steel applications, like machining automotive turbo chargers.

Visit kennametal.com or contact your local Authorised Kennametal Distributor.

KENNAMETAL®

kennametal.com

Mill 1-10™

High-Performance Shoulder Milling Platform

Primary Application

The multifunctional Mill 1-10 platform works with all tool materials in shoulder, ramp, slot, plunge, and helical milling with one insert style to improve productivity and reduce inventory and machining costs. The super positive cutting rake, soft cutting action, and low cutting forces enable higher feed rates and spindle protection. Innovative insert and cutter body designs offer improved ramping capabilities.



Features and Benefits

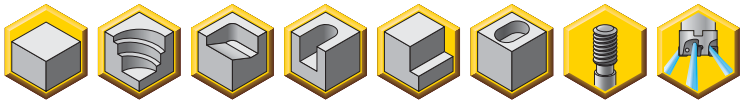
Versatility

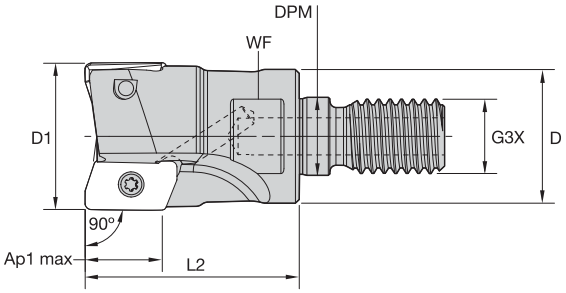
- Works with all tool materials.
- Capable of shoulder, ramp, plunge, and helical milling.
- Internal coolant and air supply.

Advantages

- Optimised soft cutting edge.
- Elliptical edge generates 90° wall.
- Increased ramping capability due to state of the art insert and cutter body design.
- Innovative chip gash design for excellent chip evacuation and perfect cutter body stability.
- All pockets are machined into heat-treated materials, guaranteeing best-in-class runout and pocket strength.
- Inserts feature innovative margin along the main cutting edge, corner nose radius, and wiper facet for perfect edge stability.

- Ramping capable for all Mill 1-10.
- Generates superior surface finish.
- Mill 90° walls.
- High RPM capabilities.







Screw-On End Mills

order number	catalogue number	D1	D	DPM	G3X	L2	WF	Ap1 max	Z	max ramp angle	kg	max RPM
3745708	**16A02R025M08ED10**	16	13	8,5	M8	25	10	10,1	2	9.5°	0,02	50100
3745709	**20A02R028M10ED10**	20	18	10,5	M10	28	15	10,1	2	6.0°	0,04	44800
3745710	**20A03R028M10ED10**	20	18	10,5	M10	28	15	10,1	3	6.0°	0,05	44800
3745711	**25A03R032M12ED10**	25	21	12,5	M12	32	17	10,0	3	4.0°	0,09	40000
3745712	**25A04R032M12ED10**	25	21	12,5	M12	32	17	10,0	4	4.0°	0,08	40000
3745723	**32A04R040M16ED10**	32	29	17,0	M16	40	24	10,0	4	2.8°	0,19	35400
3745724	**32A05R040M16ED10**	32	29	17,0	M16	40	24	10,0	5	2.8°	0,19	35400
3745725	**40A06R040M16ED10**	40	29	17,0	M16	40	24	9,9	6	2.0°	0,23	31600
3745726	**42A06R040M16ED10**	42	29	17,0	M16	40	24	9,9	6	1.8°	0,23	30900

Spare Parts



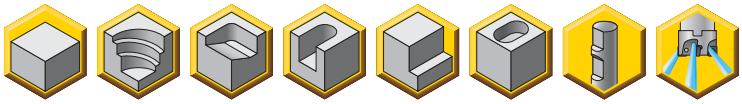


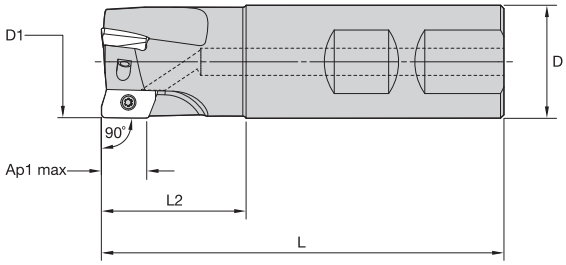


D1	insert screw	Nm	Torx wrench
16	**MS2205**	1,0	**F7IP**
20	**MS2205**	1,0	**F7IP**
25	**MS2205**	1,0	**F7IP**
32	**MS2205**	1,0	**F7IP**
40	**MS2205**	1,0	**F7IP**
42	**MS2205**	1,0	**F7IP**

NOTE: Standard milling cutters will accept insert nose radii up to 2mm without modification.

- Aggressive ramping rates.
- Generates superior surface finish.
- Mill 90° walls.
- High RPM capabilities.







Weldon® End Mills

order number	catalogue number	D1	D	L	L2	Ap1 max	Z	max ramp angle	kg	max RPM
3744633	**16A02R025B16ED10**	16	16	74	25	10,1	2	9.5°	0,09	50100
3744634	**20A02R028B20ED10**	20	20	79	28	10,1	2	6.0°	0,15	44800
3744635	**20A03R028B20ED10**	20	20	79	28	10,1	3	6.0°	0,15	44800
3744636	**25A03R032B25ED10**	25	25	89	32	10,0	3	4.0°	0,28	40000
3744637	**25A04R032B25ED10**	25	25	89	32	10,0	4	4.0°	0,28	40000
3744638	**32A04R040B32ED10**	32	32	101	40	10,0	4	2.8°	0,53	35400
3744639	**32A05R040B32ED10**	32	32	101	40	10,0	5	2.8°	0,53	35400

Spare Parts



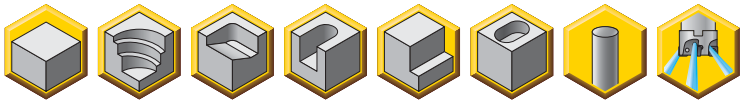


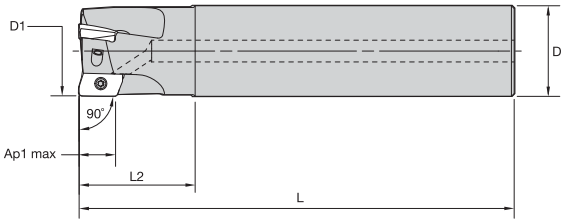


D1	insert screw	Nm	Torx Plus driver
16	**MS2205**	1,0	**DT7IP**
20	**MS2205**	1,0	**DT7IP**
25	**MS2205**	1,0	**DT7IP**
32	**MS2205**	1,0	**DT7IP**

NOTE: Standard milling cutters will accept insert nose radii up to 2mm without modification.

- Aggressive ramping rates.
- Generates superior surface finish.
- Mill 90° walls.
- High RPM capabilities.







Cylindrical End Mills

order number	catalogue number	D1	D	L	L2	Ap1 max	Z	max ramp angle	kg	max RPM
3744538	**12A01R020A16ED10**	12	16	90	20	10,3	1	11.5°	0,12	57800
3744539	**16A02R025A16ED10**	16	16	100	25	10,1	2	9.5°	0,13	50100
3744540	**20A02R028A20ED10**	20	20	110	28	10,1	2	6.0°	0,23	44800
3744541	**20A03R028A20ED10**	20	20	110	28	10,1	3	6.0°	0,22	44800
3744542	**25A03R032A25ED10**	25	25	120	32	10,0	3	4.0°	0,40	40000
3744613	**25A04R032A25ED10**	25	25	120	32	10,0	4	4.0°	0,40	40000
3744614	**32A04R040A32ED10**	32	32	130	40	10,0	4	2.8°	0,72	35400
3744615	**32A05R040A32ED10**	32	32	130	40	10,0	5	2.8°	0,71	35400

Spare Parts



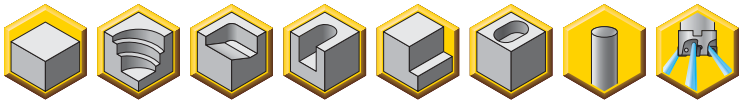


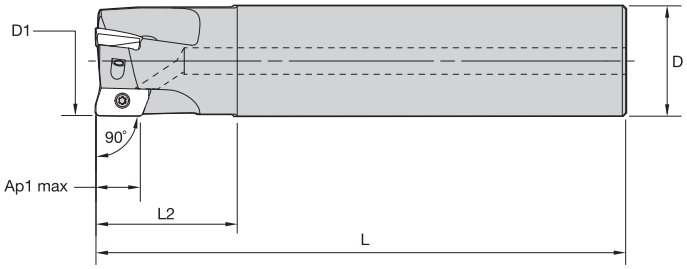


D1	insert screw	Nm	Torx Plus driver
12	**MS2205**	1,0	**DT7IP**
16	**MS2205**	1,0	**DT7IP**
20	**MS2205**	1,0	**DT7IP**
25	**MS2205**	1,0	**DT7IP**
32	**MS2205**	1,0	**DT7IP**

NOTE: Standard milling cutters will accept insert nose radii up to 2mm without modification.

- Aggressive ramping rates.
- Generates superior surface finish.
- Mill 90° walls.
- High RPM capabilities.







Cylindrical End Mills • Long Length

order number	catalogue number	D1	D	L	L2	Ap1 max	Z	max ramp angle	kg	max RPM
3744616	**16A02R025A16ED10-170**	16	16	170	25	10,1	2	9.5°	0,23	50100
3744617	**16A02R025A16ED10R31-170**	16	16	170	25	9,7	2	8.0°	0,23	50100
3744618	**18A02R028A16ED10-170**	18	16	170	28	10,1	2	7.5°	0,24	47200
3744619	**20A02R032A20ED10-170**	20	20	170	32	10,1	2	6.0°	0,37	44800
3744620	**20A02R032A20ED10R31-170**	20	20	170	32	9,8	2	4.5°	0,37	44800
3744621	**20A03R032A20ED10-170**	20	20	170	32	10,1	3	6.0°	0,36	44800
3744622	**20A03R032A20ED10R31-170**	20	20	170	32	9,8	3	4.5°	0,36	44800
3744623	**22A03R032A20ED10-170**	22	20	170	32	10,1	3	5.0°	0,37	42700
3744624	**25A03R040A25ED10-200**	25	25	200	40	10,0	3	4.0°	0,69	40000
3744625	**25A03R040A25ED10R31-200**	25	25	200	40	9,8	3	3.0°	0,69	40000
3744626	**25A04R040A25ED10-200**	25	25	200	40	10,0	4	4.0°	0,68	40000
3744627	**25A04R040A25ED10R31-200**	25	25	200	40	9,8	4	3.0°	0,68	40000
3744628	**28A04R040A25ED10-200**	28	25	200	40	10,0	4	3.3°	0,71	37800
3744629	**32A04R048A32ED10-200**	32	32	200	48	10,0	4	2.8°	1,14	35400
3744630	**32A04R048A32ED10R31-200**	32	32	200	48	9,7	4	2.0°	1,13	35400
3744631	**32A05R048A32ED10-200**	32	32	200	48	10,0	5	2.8°	1,13	35400
3744632	**32A05R048A32ED10R31-200**	32	32	200	48	9,7	5	2.0°	1,13	35400

Spare Parts



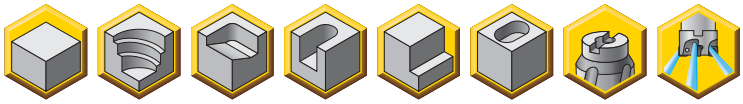


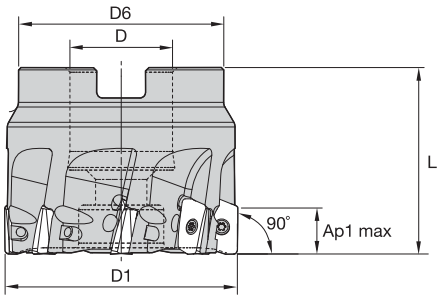


D1	insert screw	Nm	Torx Plus driver
16	**MS2205**	1,0	**DT7IP**
18	**MS2205**	1,0	**DT7IP**
20	**MS2205**	1,0	**DT7IP**
22	**MS2205**	1,0	**DT7IP**
25	**MS2205**	1,0	**DT7IP**
28	**MS2205**	1,0	**DT7IP**
32	**MS2205**	1,0	**DT7IP**

NOTE: Standard milling cutters will accept insert nose radii up to 2mm without modification.
"R31" in catalogue number designates factory-relieved tool which accepts inserts with nose radii > 2mm.

- Aggressive ramping rates.
- Generates superior surface finish.
- Mill 90° walls.
- High RPM capabilities.







Shell Mills

order number	catalogue number	D1	D	D6	L	Ap1 max	Z	max ramp angle	kg	max RPM
3745674	**40A04RS90ED10D**	40	16	37	40	9,9	4	2.0°	0,25	31600
3745675	**40A06RS90ED10D**	40	16	37	40	9,9	6	2.0°	0,24	31600
3745676	**50A05RS90ED10D**	50	22	44	40	9,9	5	1.5°	0,38	28300
3745677	**50A08RS90ED10D**	50	22	44	40	9,9	8	1.5°	0,36	28300
3745678	**63A06RS90ED10D**	63	22	44	40	9,9	6	1.0°	0,54	25200
3745679	**63A09RS90ED10D**	63	22	44	40	9,9	9	1.0°	0,53	25200
3745680	**80A08RS90ED10D**	80	27	60	50	9,9	8	.8°	1,26	22400
3745681	**80A10RS90ED10D**	80	27	60	50	9,9	10	.8°	1,25	22400
3745682	**100B08RS90ED10D**	100	32	80	50	9,9	8	.5°	1,88	20000
3745703	**100B12RS90ED10D**	100	32	80	50	9,9	12	.5°	1,85	20000

Spare Parts






D1	insert screw	Nm	Torx Plus driver	socket-head cap screw
40	**MS2205**	1,0	**DT7IP**	**–**
50	**MS2205**	1,0	**DT7IP**	**–**
63	**MS2205**	1,0	**DT7IP**	**MS1234**
80	**MS2205**	1,0	**DT7IP**	**MS2038**
100	**MS2205**	1,0	**DT7IP**	**–**

NOTE: Standard milling cutters will accept insert nose radii up to 2mm without modification.

Insert Selection Guide

Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		◄——►		toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.E..LD	KCPM40	**.S..GD**	**KCPM40**	.E..HD	KCPM40
P3–P4	.E..LD	KCPK30	**.S..GD**	**KCPK30**	.E..HD	KCPK30
P5–P6	.E..LD	KC725M	**.S..GD**	**KC725M**	.E..HD	KC725M
M1–M2	.E..LD	KCSM40	**.S..GD**	**KC725M**	.E..HD	KCSM40
M3	.E..LD	KCSM40	**.S..GD**	**KCPM40**	.E..HD	KCSM40
K1–K2	.E..LD	KCK15	**.S..GD**	**KCK15**	.E..HD	KCK15
K3	.E..LD	KC520M	**.S..GD**	**KC520M**	.E..HD	KC520M
N1–N2	.F..LDJ	KC410M	**.E..LDJ**	**KC422M**	.E..LD	KC510M
N3	.F..LDJ	KC410M	**.F..LDJ**	**KC410M**	.F..LDJ	KC410M
S1–S2	.E..LD	KC725M	**.S..GD**	**KC725M**	.E..HD	KC725M
S3	.E..LD	KCSM40	**.S..GE**	**KCSM40**	.E..HD	KCSM40
S4	.E..LD	KCSM40	**.S..GE**	**KCSM40**	.E..HD	KCSM40
H1	.E..LD	KC510M	–	–	–	–

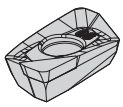
Indexable Inserts

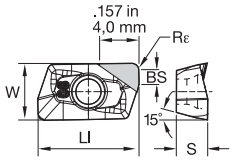
- Roughing and finishing of aluminium and non-ferrous alloys.
- Suitable for wet and dry machining.
- High precision.
- PCD inserts for long tool life.
- Ap1 max = 10mm.

● first choice
○ alternate choice

beyond

	K313	KC410M	KC422M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40	KD1410
P				○		○	●		●	●		○	
M						●	●		○	○	○	●	
K				●	●	○		●	○				
N	●	●	●	○									●
S						●	●				●	●	
H													


EDCT-PCD



EDCT-PCD

EDCT-PCD

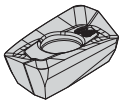
catalogue number	LI	S	W	BS	Rε	hm	cutting edges	K313	KC410M	KC422M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40	KD1410
EDCT10T304PDFR-PCD	12,04	3,75	6,75	2,10	0,4	0,02	1	–	–	–	–	–	–	–	–	–	–	–	–	●
EDCT10T308PDFR-PCD	12,05	3,75	6,74	1,71	0,8	0,02	1	–	–	–	–	–	–	–	–	–	–	–	–	●

- Roughing and finishing of aluminium alloys.
- Periphery ground and polished rake face.
- Perfect floor surface finish.
- Ap1 max = 10mm.

● first choice
○ alternate choice

beyond

P				○		○	●		●	●		○		
M						●	●		○	○	○	●		
K				●	●	○		●	○					
N	●	●	●	○									●	
S						●	●				●	●		
H														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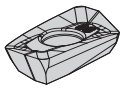
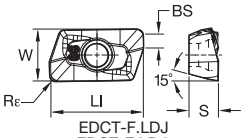

EDCT-E.LDJ



EDCT-F.LDJ
EDCT-E.LDJ

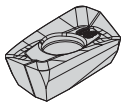
EDCT-F.LDJ

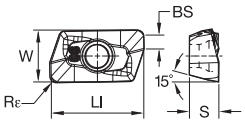
catalogue number	LI	S	W	BS	Rε	hm	cutting edges	K313	KC410M	KC422M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40	KD1410
EDCT10T302PDFRLDJ	12,05	3,75	6,75	2,29	0,2	0,02	2	–	●	–	–	–	–	–	–	–	–	–	–	–
EDCT10T304PDFRLDJ	12,05	3,75	6,75	1,98	0,4	0,02	2	–	●	–	–	–	–	–	–	–	–	–	–	–
EDCT10T308PDFRLDJ	12,05	3,75	6,74	1,70	0,8	0,02	2	–	●	–	–	–	–	–	–	–	–	–	–	–
EDCT10T312PDFRLDJ	12,06	3,75	6,74	1,30	1,2	0,02	2	–	●	–	–	–	–	–	–	–	–	–	–	–
EDCT10T316PDFRLDJ	12,06	3,75	6,74	0,90	1,6	0,02	2	–	●	–	–	–	–	–	–	–	–	–	–	–
EDCT10T320PDFRLDJ	12,06	3,75	6,73	0,49	2,0	0,02	2	–	●	–	–	–	–	–	–	–	–	–	–	–
EDCT10T331PDFRLDJ	11,52	3,75	6,71	–	3,1	0,02	2	–	●	–	–	–	–	–	–	–	–	–	–	–

EDCT-E.LDJ

catalogue number	LI	S	W	BS	Rε	hm	cutting edges	K313	KC410M	KC422M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40	KD1410
EDCT10T304PDERLDJ	12,05	3,75	6,75	1,98	0,4	0,03	2	–	–	●	–	–	–	–	–	–	–	–	–	–
EDCT10T308PDERLDJ	12,05	3,75	6,74	1,70	0,8	0,03	2	–	–	●	–	–	–	–	–	–	–	–	–	–
EDCT10T316PDERLDJ	12,06	3,75	6,74	0,90	1,6	0,03	2	–	–	●	–	–	–	–	–	–	–	–	–	–
EDCT10T320PDERLDJ	12,06	3,75	6,73	0,49	2,0	0,03	2	–	–	●	–	–	–	–	–	–	–	–	–	–
EDCT10T324PDERLDJ	12,06	3,75	6,73	0,11	2,4	0,03	2	–	–	●	–	–	–	–	–	–	–	–	–	–

- Finishing and high-precision applications.
- Light machining.
- 15° positive rake angle.
- Perfect floor surface finish.
- Ap1 max = 10mm.


EDCT-LD

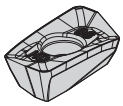


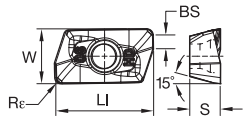
EDCT-LD

EDCT-LD

catalogue number	LI	S	W	BS	Rε	hm	cutting edges	K313	KC410M	KC422M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40	KD1410
EDCT10T302PDERLD	12,04	3,75	6,75	2,29	0,2	0,04	2	–	–	–	–	–	–	●	–	●	–	–	–	–
EDCT10T304PDERLD	12,05	3,75	6,75	1,98	0,4	0,04	2	–	–	–	–	●	●	●	–	●	–	–	–	–
EDCT10T308PDERLD	12,05	3,75	6,74	1,70	0,8	0,04	2	–	–	–	●	●	●	●	●	●	●	–	●	–
EDCT10T312PDERLD	12,06	3,75	6,74	1,30	1,2	0,04	2	–	–	–	–	–	●	●	–	–	–	–	●	–
EDCT10T316PDERLD	12,06	3,75	6,74	0,90	1,6	0,04	2	–	–	–	–	–	●	●	–	●	–	–	●	–
EDCT10T320PDERLD	12,06	3,75	6,73	0,49	2,0	0,04	2	–	–	–	–	–	–	●	–	●	–	–	–	–
EDCT10T324PDERLD	12,06	3,75	6,73	0,11	2,4	0,04	2	–	–	–	–	–	●	●	–	–	–	–	●	–
EDCT10T331PDERLD	11,52	3,75	6,71	–	3,1	0,04	2	–	–	–	–	–	–	●	–	●	–	–	●	–

- Medium roughing and semi-finishing.
- Medium feed rates.
- PSTS — Precision Pressed and Sintered to Size.
- Ap1 max = 10mm.


EDPT-E.HD



EDPT-E.HD

● first choice
○ alternate choice

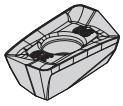
beyond

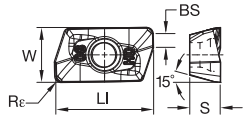
P					○		○	●		●	●		○		
M							●	●		○	○	○	●		
K					●	●	○		●	○					
N	●	●	●	○											●
S							●	●				●	●		
H															

EDPT-E..HD

catalogue number	LI	S	W	BS	Rε	hm	cutting edges	K313	KC410M	KC422M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40	KD1410
EDPT10T304PDERHD	12,05	3,75	6,75	2,07	0,4	0,08	2	–	–	–	–	●	●	●	●	●	●	–	–	–
EDPT10T308PDERHD	12,05	3,75	6,74	1,70	0,8	0,08	2	–	–	–	–	●	●	●	●	●	●	–	●	–
EDPT10T310PDERHD	12,05	3,75	6,74	1,49	1,0	0,08	2	–	–	–	–	–	●	●	●	●	–	–	–	–
EDPT10T312PDERHD	12,06	3,75	6,74	1,30	1,2	0,08	2	–	–	–	–	●	●	●	–	●	●	–	●	–
EDPT10T316PDERHD	12,06	3,75	6,74	0,90	1,6	0,08	2	–	–	–	–	–	●	●	–	●	●	●	●	–
EDPT10T320PDERHD	12,06	3,75	6,74	0,49	2,0	0,08	2	–	–	–	–	–	–	●	–	●	●	–	●	–
EDPT10T324PDERHD	12,06	3,75	6,74	0,11	2,4	0,08	2	–	–	–	–	–	–	●	–	●	–	–	●	–
EDPT10T331PDERHD	11,52	3,75	6,71	–	3,1	0,08	2	–	–	–	–	–	●	●	–	●	–	–	●	–

- Medium roughing and semi-finishing.
- Solution for austenitic stainless steel and super alloys.
- Medium feed rates.
- PSTS — Precision Pressed and Sintered to Size.
- Ap1 max = 10mm.


EDPT-S.GE

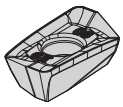


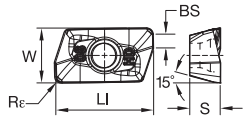
EDPT-S.GE

EDPT-S.GE

catalogue number	LI	S	W	BS	Rε	hm	cutting edges	K313	KC410M	KC422M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40	KD1410
EDPT10T304PDSRGE	12,04	3,75	6,75	2,08	0,4	0,14	2	–	–	–	–	–	●	●	–	●	●	–	–	–
EDPT10T308PDSRGE	12,05	3,75	6,74	1,70	0,8	0,14	2	–	–	–	–	–	●	●	–	●	●	–	●	–
EDPT10T312PDSRGE	12,05	3,75	6,74	1,30	1,2	0,14	2	–	–	–	–	–	●	●	–	●	–	–	●	–
EDPT10T316PDSRGE	12,06	3,75	6,74	0,90	1,6	0,14	2	–	–	–	–	–	●	●	–	●	–	–	●	–
EDPT10T331PDSRGE	11,51	3,75	6,71	–	3,1	0,14	2	–	–	–	–	–	●	●	–	●	–	–	●	–

- Heavy roughing applications.
- High feed rates.
- All material groups.
- PSTS — Precision Pressed and Sintered to Size.
- Ap1 max = 10mm.


EDPT-S.GD



EDPT-S.GD

EDPT-S.GD

catalogue number	LI	S	W	BS	Rε	hm	cutting edges	K313	KC410M	KC422M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40	KD1410
EDPT10T304PDSRGD	12,05	3,75	6,75	2,07	0,4	0,13	2	–	–	–	–	–	–	●	●	●	–	–	–	–
EDPT10T308PDSRGD	12,05	3,75	6,74	1,70	0,8	0,13	2	–	–	–	–	●	–	●	●	●	●	–	–	–
EDPT10T312PDSRGD	12,06	3,75	6,74	1,30	1,2	0,13	2	–	–	–	–	●	–	●	●	●	–	–	–	–
EDPT10T316PDSRGD	12,06	3,75	6,74	0,90	1,6	0,13	2	–	–	–	–	–	–	●	–	●	–	–	–	–

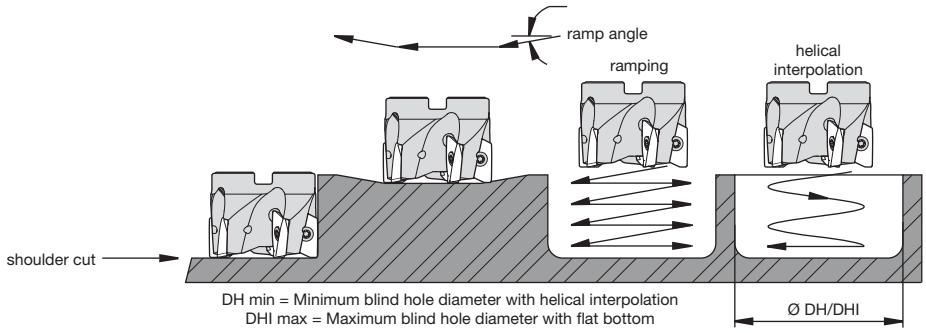
Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.F..LDJ	0,12	**0,35**	0,58	0,08	**0,25**	0,42	0,06	**0,19**	0,31	0,06	**0,16**	0,27	0,05	**0,15**	0,25	.F..LDJ
.F..-PCD	0,12	**0,35**	0,58	0,08	**0,25**	0,42	0,06	**0,19**	0,31	0,06	**0,16**	0,27	0,05	**0,15**	0,25	.F..-PCD
.E..LDJ	0,12	**0,35**	0,58	0,08	**0,25**	0,42	0,06	**0,19**	0,32	0,06	**0,16**	0,28	0,05	**0,15**	0,25	.E..LDJ
.E..LD	0,12	**0,35**	0,57	0,09	**0,25**	0,41	0,07	**0,19**	0,31	0,06	**0,17**	0,27	0,05	**0,15**	0,25	.E..LD
.S..GE	0,23	**0,46**	0,70	0,17	**0,33**	0,51	0,13	**0,25**	0,38	0,11	**0,22**	0,33	0,10	**0,20**	0,30	.S..GE
.S..GD	0,23	**0,47**	0,71	0,17	**0,34**	0,51	0,13	**0,25**	0,38	0,11	**0,22**	0,33	0,10	**0,20**	0,30	.S..GD
.E..HD	0,23	**0,51**	0,82	0,17	**0,37**	0,59	0,13	**0,28**	0,44	0,11	**0,24**	0,38	0,10	**0,22**	0,35	.E..HD

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

Application Data

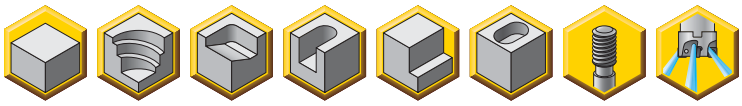


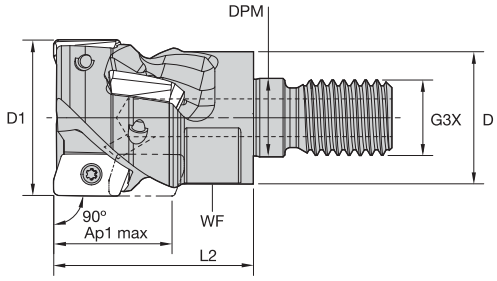
Application Examples

insert style	cutting diameter	max ramp angle to non-cutting corner tangent	max ramp angle to steel body interference	DH min (min hole diameter)	DHI min (min flat-bottomed hole diameter)	max diameter (no flat bottom)
Mill-1, 10mm	12	not recommended	not recommended	not recommended	not recommended	not recommended
Mill-1, 10mm	16	9,7°	12,3°	19,50	28,73	32
Mill-1, 10mm	18	7,6°	9,6°	23,29	32,68	63
Mill-1, 10mm	20	6,2°	8,6°	27,25	36,63	40
Mill-1, 10mm	22	5,2°	7,0°	31,25	40,63	44
Mill-1, 10mm	25	4,2°	5,3°	37,26	46,62	50
Mill-1, 10mm	28	3,5°	4,3°	43,26	52,62	56
Mill-1, 10mm	32	2,8°	3,3°	51,27	60,62	64
Mill-1, 10mm	40	2,0°	2,3°	67,30	76,61	80
Mill-1, 10mm	42	1,9°	2,1°	71,32	80,60	82
Mill-1, 10mm	50	1,5°	1,6°	87,53	96,86	100
Mill-1, 10mm	63	1,2°	1,2°	113,54	122,86	126
Mill-1, 10mm	80	0,9°	0,9°	147,54	156,85	160
Mill-1, 10mm	100	0,7°	0,7°	187,54	196,85	200

NOTE: Max ramp angle decreases as nose radius increases.

- Aggressive ramping rates.
- Generates superior surface finish.
- Mill 90° walls.







Screw-On Helical End Mills

order number	catalogue number	D1	D	DPM	G3X	L2	WF	Ap1 max	Z	Z U	max ramp angle	kg	max RPM
3773810	**M1H20J02R28M10ED10C4**	20	18	10,5	M10	32	15	18,9	4	2	6.0°	0,49	37100
3773811	**M1H25J02R32M12ED10C4**	25	21	12,5	M12	32	17	18,8	4	2	4.0°	0,07	33200
3773813	**M1H32J03R40M16ED10C6**	32	29	17,0	M16	40	24	18,7	6	3	2.8°	0,18	29300

Spare Parts



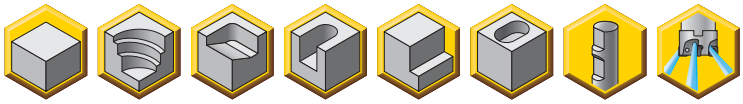


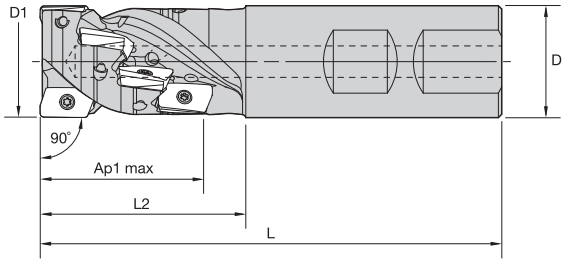


D1	insert screw	Nm	Torx wrench
20	**MS2205**	1,0	**F7IP**
25	**MS2205**	1,0	**F7IP**
32	**MS2205**	1,0	**F7IP**

NOTE: Standard milling cutters will accept insert nose radii up to 2mm without modification.

- Aggressive ramping rates.
- Generates superior surface finish.
- Mill 90° walls.







Weldon® Helical End Mills

order number	catalogue number	D1	D	L	L2	Ap1 max	Z	Z U	max ramp angle	kg	max RPM
3773118	**M1H20J02R36B20ED10C6**	20	20	87	36	27,7	6	2	6.0°	0,34	37100
3773119	**M1H25J02R46B25ED10C8**	25	25	103	46	36,4	8	2	4.0°	0,31	33200
3773120	**M1H32J02R54B32ED10C10**	32	32	115	54	44,8	10	2	2.8°	0,56	29300
3773121	**M1H32J03R54B32ED10C15**	32	32	115	54	44,8	15	3	2.8°	0,53	29300

NOTE: Standard milling cutters will accept insert nose radii up to 2mm without modification.

Spare Parts

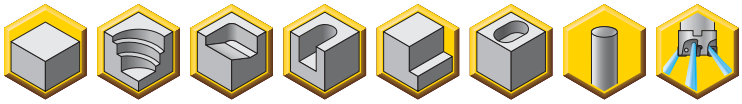


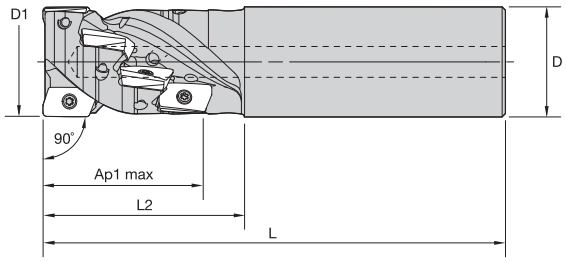




D1	insert screw	Nm	Torx Plus driver
20	**MS2205**	1,0	**DT7IP**
25	**MS2205**	1,0	**DT7IP**
32	**MS2205**	1,0	**DT7IP**

- Aggressive ramping rates.
- Generates superior surface finish.
- Mill 90° walls.







Cylindrical Helical End Mills

order number	catalogue number	D1	D	L	L2	Ap1 max	Z	Z U	max ramp angle	kg	max RPM
3773806	**M1H20J02R28A20ED10C4**	20	20	110	28	18,9	4	2	6.0°	0,48	37100
3773122	**M1H20J02R36A20ED10C6**	20	20	90	36	27,7	6	2	6.0°	0,36	37100
3773807	**M1H25J02R28A25ED10C4**	25	25	120	28	18,8	4	2	4.0°	0,38	33200
3773803	**M1H25J02R46A25ED10C8**	25	25	105	46	36,4	8	2	4.0°	0,30	33200
3773808	**M1H32J02R28A32ED10C4**	32	32	130	28	18,7	4	2	2.8°	0,72	29300
3773809	**M1H32J03R28A32ED10C6**	32	32	130	28	18,7	6	3	2.8°	0,71	29300
3773805	**M1H32J03R54A32ED10C15**	32	32	115	54	44,8	15	3	2.8°	0,53	29300

NOTE: Standard milling cutters will accept insert nose radii up to 2mm without modification.

Spare Parts

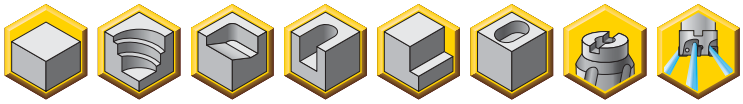


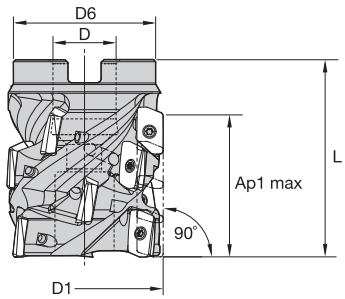




D1	insert screw	Nm	Torx Plus driver
20	**MS2205**	1,0	**DT7IP**
25	**MS2205**	1,0	**DT7IP**
32	**MS2205**	1,0	**DT7IP**

- Aggressive ramping rates.
- Generates superior surface finish.
- Mill 90° walls.







Helical Shell Mills

order number	catalogue number	D1	D	D6	L	Ap1 max	Z	Z U	max ramp angle	kg	max RPM
3773814	**M1H40T03R50A16ED10C12**	40	16	37	50	35,9	12	3	2.0°	0,27	26200
3773815	**M1H40T05R50A16ED10C20**	40	16	37	50	35,9	20	5	2.0°	0,26	26200
3773816	**M1H50T03R60A22ED10C15**	50	22	44	60	44,3	15	3	1.5°	0,62	23400
3773817	**M1H50T05R60A22ED10C25**	50	22	44	60	44,3	25	5	1.5°	0,55	23400

NOTE: Standard milling cutters will accept insert nose radii up to 2mm without modification.

Spare Parts





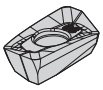

D1	insert screw	Nm	Torx Plus driver	socket-head cap screw
40	**MS2205**	1,0	**DT7IP**	**MS1340**
50	**MS2205**	1,0	**DT7IP**	**MS1558**

Insert Selection Guide

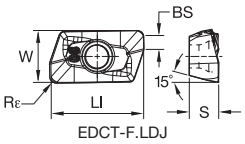
Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		◄——►		toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.E..LD	KCPM40	**.S..GD**	**KCPM40**	.E..HD	KCPM40
P3–P4	.E..LD	KCPK30	**.S..GD**	**KCPK30**	.E..HD	KCPK30
P5–P6	.E..LD	KC725M	**.S..GD**	**KC725M**	.E..HD	KC725M
M1–M2	.E..LD	KCSM40	**.S..GD**	**KC725M**	.E..HD	KCSM40
M3	.E..LD	KCSM40	**.S..GD**	**KCPM40**	.E..HD	KCSM40
K1–K2	.E..LD	KCK15	**.S..GD**	**KCK15**	.E..HD	KCK15
K3	.E..LD	KC520M	**.S..GD**	**KC520M**	.E..HD	KC520M
N1–N2	.F..LDJ	KC410M	**.E..LDJ**	**KC422M**	.E..LD	KC510M
N3	.F..LDJ	KC410M	**.F..LDJ**	**KC410M**	.F..LDJ	KC410M
S1–S2	.E..LD	KC725M	**.S..GD**	**KC725M**	.E..HD	KC725M
S3	.E..LD	KCSM40	**.S..GE**	**KCSM40**	.E..HD	KCSM40
S4	.E..LD	KCSM40	**.S..GE**	**KCSM40**	.E..HD	KCSM40
H1	.E..LD	KC510M	–	–	–	–

Indexable Inserts

- Periphery ground and polished rake face.
- Roughing and finishing of aluminium alloys.
- Perfect floor surface finish.



EDCT-F.LDJ



EDCT-F.LDJ

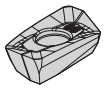
● first choice
○ alternate choice

	K313	KC410M	KC422M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
P				○		○	●		●	●		○
M						●	●		○	○	○	●
K				●	●	○		●	○			
N	●	●	●	○								
S						●	●				●	●
H												

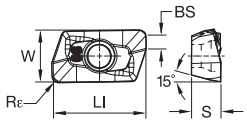
EDCT-F.LDJ

catalogue number	LI	S	W	BS	Rε	hm	cutting edges	K313	KC410M	KC422M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EDCT10T302PDFRLDJ	12,05	3,75	6,75	2,29	0,2	0,02	2	–	●	–	–	–	–	–	–	–	–	–	–
EDCT10T304PDFRLDJ	12,05	3,75	6,75	1,98	0,4	0,02	2	–	●	–	–	–	–	–	–	–	–	–	–
EDCT10T308PDFRLDJ	12,05	3,75	6,74	1,70	0,8	0,02	2	–	●	–	–	–	–	–	–	–	–	–	–
EDCT10T312PDFRLDJ	12,06	3,75	6,74	1,30	1,2	0,02	2	–	●	–	–	–	–	–	–	–	–	–	–
EDCT10T316PDFRLDJ	12,06	3,75	6,74	0,90	1,6	0,02	2	–	●	–	–	–	–	–	–	–	–	–	–
EDCT10T320PDFRLDJ	12,06	3,75	6,73	0,49	2,0	0,02	2	–	●	–	–	–	–	–	–	–	–	–	–
EDCT10T331PDFRLDJ	11,52	3,75	6,71	—	3,1	0,02	2	–	●	–	–	–	–	–	–	–	–	–	–

- Periphery ground.
- Roughing and finishing.
- Perfect floor surface finish.



EDCT-E.LDJ



EDCT-E.LDJ

beyond

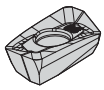
P				○		○	●		●	●		○
M						●	●		○	○	○	●
K				●	●	○		●	○			
N	●	●	●	○								
S						●	●				●	●
H												

● first choice
○ alternate choice

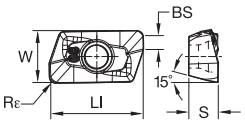
EDCT-E.LDJ

catalogue number	LI	S	W	BS	Rε	hm	cutting edges	K313	KC410M	KC422M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EDCT10T304PDERLDJ	12,05	3,75	6,75	1,98	0,4	0,03	2	–	–	●	–	–	–	–	–	–	–	–	–
EDCT10T308PDERLDJ	12,05	3,75	6,74	1,70	0,8	0,03	2	–	–	●	–	–	–	–	–	–	–	–	–
EDCT10T316PDERLDJ	12,06	3,75	6,74	0,90	1,6	0,03	2	–	–	●	–	–	–	–	–	–	–	–	–
EDCT10T320PDERLDJ	12,06	3,75	6,73	0,49	2,0	0,03	2	–	–	●	–	–	–	–	–	–	–	–	–
EDCT10T324PDERLDJ	12,06	3,75	6,73	0,11	2,4	0,03	2	–	–	●	–	–	–	–	–	–	–	–	–

- Finishing and high precision applications.
- Light machining.
- 15° positive rake angle.
- Perfect floor surface finish.
- Ap1 max = 10mm.



EDCT-LD

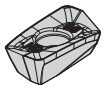


EDCT-LD

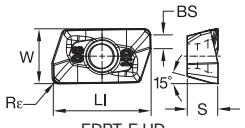
EDCT-LD

catalogue number	LI	S	W	BS	Rε	hm	cutting edges	K313	KC410M	KC422M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EDCT10T302PDERLD	12,04	3,75	6,75	2,29	0,2	0,04	2	–	–	–	–	–	–	●	–	●	–	–	–
EDCT10T304PDERLD	12,05	3,75	6,75	1,98	0,4	0,04	2	–	–	–	–	●	●	●	–	●	–	–	–
EDCT10T308PDERLD	12,05	3,75	6,74	1,70	0,8	0,04	2	–	–	–	●	●	●	●	●	●	–	–	–
EDCT10T312PDERLD	12,06	3,75	6,74	1,30	1,2	0,04	2	–	–	–	–	–	●	●	–	–	–	–	–
EDCT10T316PDERLD	12,06	3,75	6,74	0,90	1,6	0,04	2	–	–	–	–	–	●	●	–	●	–	–	–
EDCT10T320PDERLD	12,06	3,75	6,73	0,49	2,0	0,04	2	–	–	–	–	–	●	●	–	●	–	–	–
EDCT10T324PDERLD	12,06	3,75	6,73	0,11	2,4	0,04	2	–	–	–	–	–	●	●	–	–	–	–	–
EDCT10T331PDERLD	11,52	3,75	6,71	–	3,1	0,04	2	–	–	–	–	–	–	–	–	●	–	–	–

- Medium roughing and semi-finishing.
- Medium feed rates.
- PSTS — Precision Pressed and Sintered to Size.
- Ap1 max = 10mm.



EDPT-E.HD



EDPT-E.HD

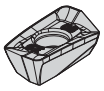
EDPT-E.HD

catalogue number	LI	S	W	BS	Rε	hm	cutting edges	K313	KC410M	KC422M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EDPT10T304PDERHD	12,05	3,75	6,75	2,07	0,4	0,08	2	–	–	–	–	●	●	●	●	●	–	–	–
EDPT10T308PDERHD	12,05	3,75	6,74	1,70	0,8	0,08	2	–	–	–	–	●	●	●	●	●	–	–	–
EDPT10T310PDERHD	12,05	3,75	6,74	1,49	1,0	0,08	2	–	–	–	–	–	●	●	●	●	–	–	–
EDPT10T312PDERHD	12,06	3,75	6,74	1,30	1,2	0,08	2	–	–	–	–	●	●	●	–	●	–	–	–
EDPT10T316PDERHD	12,06	3,75	6,74	0,90	1,6	0,08	2	–	–	–	–	–	●	●	–	●	–	–	–
EDPT10T320PDERHD	12,06	3,75	6,74	0,49	2,0	0,08	2	–	–	–	–	–	–	●	–	●	–	–	–
EDPT10T324PDERHD	12,06	3,75	6,74	0,11	2,4	0,08	2	–	–	–	–	–	–	●	–	●	–	–	–
EDPT10T331PDERHD	11,52	3,75	6,71	–	3,1	0,08	2	–	–	–	–	–	●	●	–	●	–	–	–

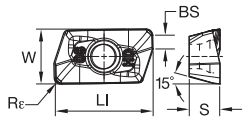
- Medium roughing and semi-finishing.
- Solution for austenitic stainless steel and super alloys.
- Medium feed rates.
- PSTS — Precision Pressed and Sintered to Size.
- Ap1 max = 10mm.

● first choice
○ alternate choice

		K313	KC410M	KC422M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
P					○		○	●		●	●		○
M							●	●		○	○	○	●
K					●	●	○		●	○			
N		●	●	●	○								
S							●	●				●	●
H													



EDPT-S.GE

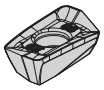


EDPT-S.GE

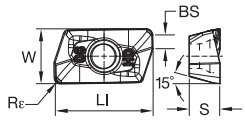
EDPT-S.GE

catalogue number	LI	S	W	BS	Rε	hm	cutting edges	K313	KC410M	KC422M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EDPT10T304PDSRGE	12,04	3,75	6,75	2,08	0,4	0,14	2	–	–	–	–	–	●	●	–	●	–	–	–
EDPT10T308PDSRGE	12,05	3,75	6,74	1,70	0,8	0,14	2	–	–	–	–	–	●	●	–	●	–	–	–
EDPT10T312PDSRGE	12,05	3,75	6,74	1,30	1,2	0,14	2	–	–	–	–	–	●	●	–	●	–	–	–
EDPT10T316PDSRGE	12,06	3,75	6,74	0,90	1,6	0,14	2	–	–	–	–	–	●	●	–	●	–	–	–
EDPT10T331PDSRGE	11,51	3,75	6,71	–	3,1	0,14	2	–	–	–	–	–	●	●	–	●	–	–	–

- Heavy roughing applications.
- High feed rates.
- All material groups.
- PSTS — Precision Pressed and Sintered to Size.
- Ap1 max = 10mm.



EDPT-S.GD



EDPT-S.GD

EDPT-S.GD

catalogue number	LI	S	W	BS	Rε	hm	cutting edges	K313	KC410M	KC422M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EDPT10T304PDSRGD	12,05	3,75	6,75	2,07	0,4	0,13	2	–	–	–	–	–	–	●	●	●	–	–	–
EDPT10T308PDSRGD	12,05	3,75	6,74	1,70	0,8	0,13	2	–	–	–	–	●	–	●	●	●	●	–	–
EDPT10T312PDSRGD	12,06	3,75	6,74	1,30	1,2	0,13	2	–	–	–	–	●	–	●	●	●	–	–	–
EDPT10T316PDSRGD	12,06	3,75	6,74	0,90	1,6	0,13	2	–	–	–	–	–	–	●	–	●	–	–	–

Recommended Starting Feeds

Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.F..LDJ	0,12	**0,35**	0,58	0,08	**0,25**	0,42	0,06	**0,19**	0,31	0,06	**0,16**	0,27	0,05	**0,15**	0,25	.F..LDJ
.F..-PCD	0,12	**0,35**	0,58	0,08	**0,25**	0,42	0,06	**0,19**	0,31	0,06	**0,16**	0,27	0,05	**0,15**	0,25	.F..-PCD
.E..LDJ	0,12	**0,35**	0,58	0,08	**0,25**	0,42	0,06	**0,19**	0,32	0,06	**0,16**	0,28	0,05	**0,15**	0,25	.E..LDJ
.E..LD	0,12	**0,35**	0,57	0,09	**0,25**	0,41	0,07	**0,19**	0,31	0,06	**0,17**	0,27	0,05	**0,15**	0,25	.E..LD
.S..GE	0,23	**0,46**	0,70	0,17	**0,33**	0,51	0,13	**0,25**	0,38	0,11	**0,22**	0,33	0,10	**0,20**	0,30	.S..GE
.S..GD	0,23	**0,47**	0,71	0,17	**0,34**	0,51	0,13	**0,25**	0,38	0,11	**0,22**	0,33	0,10	**0,20**	0,30	.S..GD
.E..HD	0,23	**0,51**	0,82	0,17	**0,37**	0,59	0,13	**0,28**	0,44	0,11	**0,24**	0,38	0,10	**0,22**	0,35	.E..HD

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

Flange Mount Adaptors



For HARVI™ Ultra Helical Cutters

HARVI ultra helical cutters can be used with our flange mount adaptors to create a powerful combination on nearly all spindle connections on the market.

Our flange mount adaptors enable the same cutting tool to be easily adapted to different machine spindle connections.

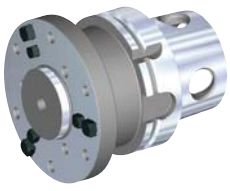
The Portfolio Features:


CV


DV


BT


HSK


KM4X™

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KENNAMETAL®

kennametal.com

Mill 1-14™

Primary Application

The Mill 1-14 series is a versatile, functional cutter system for a range of cutting tasks. Mill 1-14 cutters can be used for profiling, slotting, ramping, helical interpolation, circular interpolation, and other milling applications. It's a single tool with multi-functional benefits. Mill 1-14 inserts are specially designed to add cutting versatility. Innovative micro-geometry features contribute greatly to enhanced performance, various rake angles, negative T-land, and small hone. Results include significantly reduced cycle times and lower cutting forces. Test results in producing 90º walls have proven excellent with the GD2 geometry.



Features and Benefits

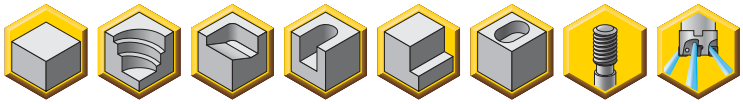
Features

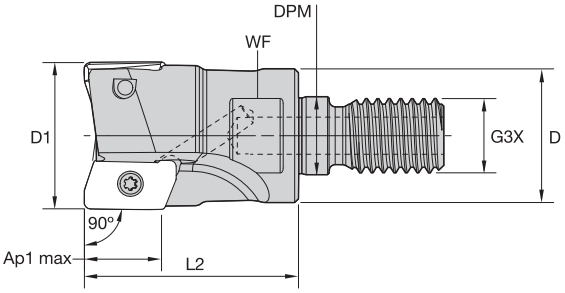
- Insert geometries and grades for most workpiece materials.
- Insert radii from 0,15mm up to 4mm.
- Axial depth of cut up to 14mm.
- Beyond™ grade technology.

Benefits

- Easy cutting action, even on entry and exiting the workpiece.
- Polished geometry for aluminium machining.
- Slotting, profiling, ramping, helical interpolation, and plunging.

- Aggressive ramping rates.
- Generates superior surface finish.
- Mill 90° walls.
- High RPM capabilities.







Screw-On End Mills

order number	catalogue number	D1	D	DPM	G3X	L2	WF	Ap1 max	Z	max ramp angle	kg	max RPM
2968370	**20A02R035M10SED14**	20	18	10,5	M10	35	15	14,6	2	16.6°	0,05	47500
2968371	**25A02R035M12SED14**	25	21	12,5	M12	35	17	14,5	2	10.5°	0,08	39700
3345679	**25A03R035M12SED14**	25	21	12,5	M12	35	17	14,5	3	10.5°	0,08	39700
2968372	**32A03R040M16SED14**	32	29	17,0	M16	40	22	14,4	3	6.8°	0,17	33300
3345680	**32A04R040M16SED14**	32	29	17,0	M16	40	22	14,4	4	6.8°	0,18	33300
2968373	**40A04R040M16SED14**	40	29	17,0	M16	40	22	14,3	4	4.8°	0,23	28700
3345681	**40A05R040M16SED14**	40	29	17,0	M16	40	22	14,3	5	4.8°	0,23	28700

NOTE: Standard milling cutters will accept insert nose radii up to 2mm without modification.

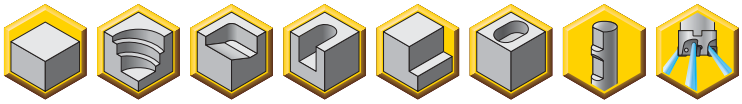
Spare Parts

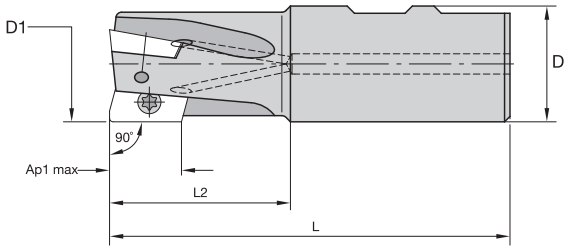




D1	insert screw	Nm	Torx Plus driver
20	**MS2167**	2,3	**DT9IP**
25	**MS2166**	2,3	**DT9IP**
32	**MS2166**	2,3	**DT9IP**
40	**MS2166**	2,3	**DT9IP**

- Aggressive ramping rates.
- Generates superior surface finish.
- Mill 90° walls.
- High RPM capabilities.







Weldon® End Mills

order number	catalogue number	D1	D	L	L2	Ap1 max	Z	max ramp angle	kg	max RPM
2622232	**20A02R039B20SED14**	20	20	90	39	14,7	2	16.6°	0,17	47500
2623937	**25A02R044B25SED14**	25	25	101	44	14,6	2	10.7°	0,31	39700
2478640	**25A03R044B25SED14**	25	25	101	44	14,6	3	10.5°	0,30	39700
2623938	**32A03R050B32SED14**	32	32	111	50	14,5	3	6.8°	0,55	33300
2478642	**32A04R050B32SED14**	32	32	111	50	14,5	4	6.8°	0,56	33300
2623939	**40A04R050B32SED14**	40	32	111	50	14,3	4	4.8°	0,71	28700
2623933	**40A05R050B32SED14**	40	32	111	50	14,3	5	4.8°	0,71	28700

NOTE: Standard milling cutters will accept insert nose radii up to 2mm without modification.

Spare Parts

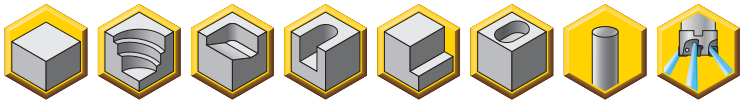


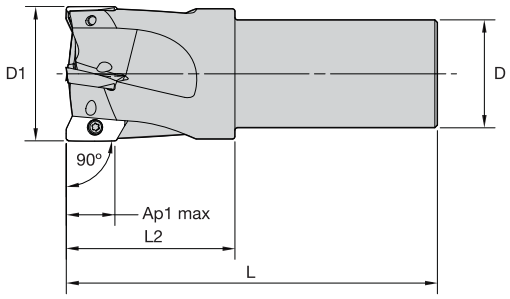




D1	insert screw	Nm	Torx Plus driver
20	**MS2167**	2,3	**DT9IP**
25	**MS2166**	2,3	**DT9IP**
32	**MS2166**	2,3	**DT9IP**
40	**MS2166**	2,3	**DT9IP**

- Aggressive ramping rates.
- Generates superior surface finish.
- Mill 90° walls.
- High RPM capabilities.







Cylindrical End Mills

order number	catalogue number	D1	D	L	L2	Ap1 max	Z	max ramp angle	kg	max RPM
3345674	**20A02R039A20SED14**	20	20	90	39	14,7	2	16.6°	0,17	47500
2968363	**20A02R050A20SED14-170**	20	20	170	50	14,7	2	16.6°	0,34	47500
3345675	**25A02R044A25SED14**	25	25	100	44	14,6	2	10.5°	0,31	39700
2968367	**25A02R050A25SED14-170**	25	25	170	50	14,6	2	10.5°	0,56	39700
3345676	**25A03R044A25SED14**	25	25	100	44	14,6	3	10.5°	0,31	39700
2968364	**25A03R050A25SED14-170**	25	25	170	50	14,6	3	10.5°	0,56	39700
3345677	**32A03R050A25SED14**	32	25	107	50	14,6	3	6.8°	0,39	33300
3345678	**32A04R050A25SED14**	32	25	107	50	14,6	4	6.8°	0,41	33300
3348765	**32A03R050A32SED14**	32	32	110	50	14,5	3	6.8°	0,55	33300
2968368	**32A03R050A32SED14-200**	32	32	200	50	14,6	3	6.8°	1,10	33300
3348766	**32A04R050A32SED14**	32	32	110	50	14,5	4	6.8°	0,56	33300
2968365	**32A04R050A32SED14-200**	32	32	200	50	14,6	4	6.8°	1,11	33300
3348767	**40A04R050A32SED14**	40	32	110	50	14,5	4	4.8°	0,71	28700
2968369	**40A04R050A32SED14-200**	40	32	200	50	14,4	4	4.8°	1,26	28700
3348768	**40A05R050A32SED14**	40	32	110	50	14,5	5	4.8°	0,70	28700
2968366	**40A05R050A32SED14-200**	40	32	200	50	14,4	5	4.8°	1,25	28700

NOTE: Standard milling cutters will accept insert nose radii up to 2mm without modification.
"R" in catalogue number designates factory-relieved tool for insert radii greater than 2mm.

Spare Parts

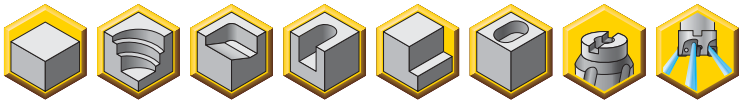


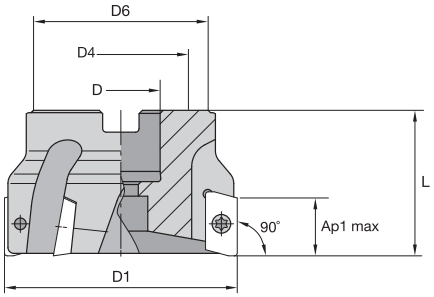


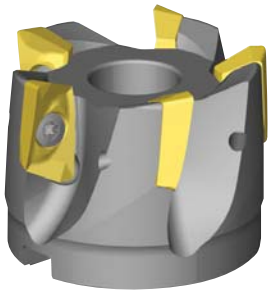


D1	insert screw	Nm	Torx Plus driver
20	**MS2167**	2,3	**DT9IP**
25	**MS2166**	2,3	**DT9IP**
32	**MS2166**	2,3	**DT9IP**
40	**MS2166**	2,3	**DT9IP**

- Aggressive ramping rates.
- Generates superior surface finish.
- Mill 90° walls.
- High RPM capabilities.







Shell Mills

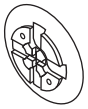
order number	catalogue number	D1	D	D4	D6	L	Ap1 max	Z	max ramp angle	kg	max RPM
2623940	**40A04RS90ED14D**	40	16	–	37	40	14,3	4	4.8°	0,21	28700
2623934	**40A05RS90ED14D**	40	16	–	37	40	14,3	5	4.8°	0,21	28700
2623941	**50A05RS90ED14D**	50	22	–	45	40	14,0	5	3.5°	0,30	25000
2478686	**50A06RS90ED14D**	50	22	–	45	40	14,0	6	3.5°	0,29	25000
2623942	**63A06RS90ED14D**	63	22	–	50	40	14,0	6	2.5°	0,49	21800
2478689	**63A07RS90ED14D**	63	22	–	50	40	14,0	7	2.5°	0,48	21800
2623963	**80A07RS90ED14D**	80	27	–	60	50	14,0	7	1.9°	1,00	19000
2478690	**80A09RS90ED14D**	80	27	–	60	50	14,0	9	1.9°	1,00	19000
2623964	**100A08RS90ED14D**	100	32	–	80	50	14,2	8	1.5°	1,80	16800
2623935	**100A10RS90ED14D**	100	32	–	80	50	14,2	10	1.5°	1,81	16800
2510390	**125B09RS90ED14D**	125	40	–	90	63	14,1	9	1.2°	2,64	14900
2623936	**125B12RS90ED14D**	125	40	–	90	63	14,1	12	1.2°	2,66	14900
2623965	**160C11RS90ED14D**	160	40	66,7	100	63	14,1	11	.9°	3,64	13100

NOTE: Standard milling cutters will accept insert nose radii up to 2mm without modification.

Spare Parts





D1	insert screw	Nm	Torx Plus driver	mounting screw	lock screw	coolant shower plate
40	**MS2166**	2,3	**DT9IP**	**MS1294**	–	–
50	**MS2166**	2,3	**DT9IP**	–	–	–
63	**MS2166**	2,3	**DT9IP**	–	–	–
80	**MS2166**	2,3	**DT9IP**	**MS2038**	–	–
100	**MS2166**	2,3	**DT9IP**	**MS1559**	–	–
125	**MS2166**	2,3	**DT9IP**	–	**420.200**	**470.232**
160	**MS2166**	2,3	**DT9IP**	–	**420.200**	**470.233**

Insert Selection Guide

Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		←	→	toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.E..GD	KCPM40	**.S..GD2**	**KCPM40**	.E..HD2	KCPM40
P3–P4	.E..GD	KCPM40	**.S..GD2**	**KCPK30**	.E..HD2	KCPK30
P5–P6	.E..GD	KC725M	**.S..GD2**	**KC725M**	.E..HD2	KC725M
M1–M2	.E..LD	KC522M	**.E..GD**	**KCSM40**	.E..HD2	KC522M
M3	.E..GD	KCSM40	**.S..GD2**	**KCPM40**	.E..HD2	KCPM40
K1–K2	.S..GD2	KC520M	**.E..HD2**	**KC520M**	.E..HD2	KCK15
K3	.S..GD2	KC520M	**.E..HD2**	**KC520M**	.E..HD2	KCK15
N1–N2	.F..LDJ	KC410M	**.F..LDJ**	**KC410M**	.E..LDJ	KC422M
N3	.F..LDJ	KC410M	**.F..LDJ**	**KC410M**	.F..LDJ	KC410M
S1–S2	.E..GD	KC725M	**.S..GD2**	**KC725M**	.E..HD2	KC725M
S3	.E..GD	KCSM40	**.S..GD2**	**KC725M**	.E..HD2	KC725M
S4	.E..GD	KCSM40	**.S..GD2**	**KC725M**	.E..HD2	KC522M
H1	–	–	**–**	**–**	–	–

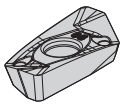
Indexable Inserts

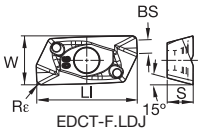
- Roughing and finishing of aluminium alloys.
- Periphery ground and polished rake face.
- Perfect floor surface finish.
- Ap1 max = 14mm.

beyond

● first choice
○ alternate choice

	KC410M	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
P				○	●		●	●		○
M				●	●		○	○	○	●
K			●	○		●	○			
N	●	●								
S				●	●				●	●
H										


EDCT-F.LDJ



EDCT-F.LDJ

EDCT-F.LDJ

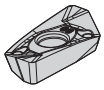
catalogue number	LI	S	W	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EDCT140402PDFRLDJ	17,46	4,50	8,49	3,14	0,2	0,02	2	●	–	–	–	–	–	–	–	–	–
EDCT140404PDFRLDJ	17,46	4,50	8,49	2,95	0,4	0,02	2	●	–	–	–	–	–	–	–	–	–
EDCT140408PDFRLDJ	17,47	4,50	8,48	2,56	0,8	0,02	2	●	–	–	–	–	–	–	–	–	–
EDCT140412PDFRLDJ	17,47	4,50	8,46	2,17	1,2	0,02	2	●	–	–	–	–	–	–	–	–	–
EDCT140416PDFRLDJ	17,49	4,50	8,45	1,77	1,6	0,02	2	●	–	–	–	–	–	–	–	–	–
EDCT140431PDFRLDJ	17,50	4,50	8,40	0,26	3,1	0,02	2	●	–	–	–	–	–	–	–	–	–
EDCT140440PDFRLDJ	16,53	4,50	8,34	–	4,0	0,02	2	●	–	–	–	–	–	–	–	–	–

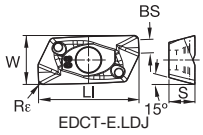
- Roughing and finishing of aluminium alloys.
- Periphery ground and polished rake face.
- Perfect floor surface finish.
- Ap1 max = 14mm.

● first choice
○ alternate choice

beyond

		KC410M	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
P					○	●		●	●		○
M					●	●		○	○	○	●
K				●	○		●	○			
N		●	●								
S					●	●				●	●
H											


EDCT-E.LDJ

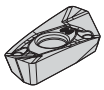


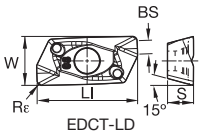
EDCT-E.LDJ

EDCT-E.LDJ

catalogue number	LI	S	W	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EDCT140404PDERLDJ	17,46	4,50	8,49	2,95	0,4	0,03	2	–	●	–	–	–	–	–	–	–	–
EDCT140408PDERLDJ	17,47	4,50	8,48	2,56	0,8	0,03	2	–	●	–	–	–	–	–	–	–	–
EDCT140424PDERLDJ	17,50	4,50	8,42	0,99	2,4	0,03	2	–	●	–	–	–	–	–	–	–	–

- Finishing and high-precision applications.
- Light machining.
- 15° positive rake angle.
- Perfect floor surface finish.
- Ap1 max = 14mm.


EDCT-LD

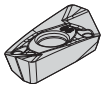


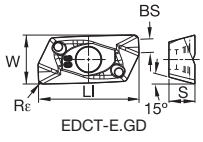
EDCT-LD

EDCT-LD

catalogue number	LI	S	W	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EDCT140404PDERLD	17,46	4,50	8,49	2,95	0,4	0,04	2	–	–	–	●	–	–	–	–	–	–
EDCT140408PDERLD	17,47	4,50	8,48	2,56	0,8	0,04	2	–	–	–	●	–	–	–	–	–	–
EDCT140412PDERLD	17,48	4,50	8,46	2,17	1,2	0,04	2	–	–	–	●	–	–	–	–	–	–
EDCT140416PDERLD	17,49	4,50	8,45	1,77	1,6	0,04	2	–	–	–	●	–	–	–	–	–	–
EDCT140431PDERLD	17,50	4,50	8,40	0,26	3,1	0,04	2	–	–	–	●	–	–	–	–	–	–

- Light machining and finishing applications.
- Periphery ground for high-precision machining.
- Medium hone for increased edge protection.
- Ap1 max = 14mm.


EDCT-E.GD



EDCT-E.GD

EDCT-E.GD

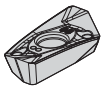
catalogue number	LI	S	W	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EDCT140404PDERGD	17,46	4,50	8,49	2,95	0,4	0,05	2	–	–	–	–	●	–	–	●	–	–
EDCT140408PDERGD	17,47	4,50	8,48	2,56	0,8	0,05	2	–	–	–	–	●	–	–	●	–	●
EDCT140412PDERGD	17,48	4,50	8,46	2,17	1,2	0,05	2	–	–	–	–	●	–	–	–	–	●
EDCT140416PDERGD	17,49	4,50	8,45	1,77	1,6	0,05	2	–	–	–	–	●	–	–	–	–	●
EDCT140431PDERGD	17,50	4,50	8,40	0,26	3,1	0,05	2	–	–	–	–	●	–	–	–	–	●

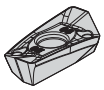
- Medium roughing and semi-finishing.
- Medium feed rates.
- PSTS — Precision Pressed and Sintered to Size.
- Ap1 max = 14mm.

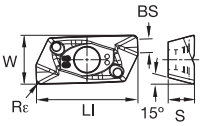
beyond

P				○	●		●	●		○
M				●	●		○	○	○	●
K			●	○		●	○			
N	●	●								
S				●	●				●	●
H										

● first choice
○ alternate choice


EDPT-E.HD


EDPT-E.HD2



EDPT-E.HD
EDPT-E.HD2

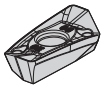
EDPT-E.HD

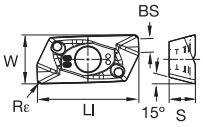
catalogue number	LI	S	W	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EDPT140404PDERHD	17,46	4,50	8,39	2,95	0,4	0,08	2	–	–	●	●	●	●	●	●	–	–
EDPT140408PDERHD	17,47	4,50	8,38	2,56	0,8	0,08	2	–	–	●	●	●	●	●	●	–	●
EDPT140412PDERHD	17,48	4,50	8,36	2,16	1,2	0,08	2	–	–	●	●	●	●	●	●	–	●
EDPT140416PDERHD	17,49	4,50	8,36	1,77	1,6	0,08	2	–	–	–	●	●	●	●	●	●	●
EDPT140420PDERHD	17,49	4,50	8,35	1,37	2,0	0,08	2	–	–	–	●	●	–	●	–	–	●
EDPT140424PDERHD	17,50	4,50	8,32	0,99	2,4	0,08	2	–	–	–	●	●	–	●	●	–	●
EDPT140431PDERHD	17,51	4,50	8,30	0,26	3,1	0,08	2	–	–	–	●	●	–	●	–	●	●
EDPT140440PDERHD	16,53	4,50	8,26	–	4,0	0,08	2	–	–	–	●	●	–	●	–	●	●

EDPT-E.HD2

catalogue number	LI	S	W	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EDPT140408PDERHD2	17,47	4,50	8,38	2,56	0,8	0,06	2	–	–	–	●	●	●	●	●	–	–

- Medium roughing and semi-finishing.
- Solution for austenitic stainless steel and super alloys.
- Medium feed rates.
- PSTS — Precision Pressed and Sintered to Size.
- Ap1 max = 14mm.


EDPT-S.GE



EDPT-S.GE

EDPT-S.GE

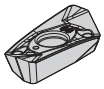
catalogue number	LI	S	W	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EDPT140404PDSRGE	17,43	4,45	8,20	2,80	0,4	0,14	2	–	–	–	●	●	–	●	–	–	–
EDPT140408PDSRGE	17,44	4,45	8,17	2,39	0,8	0,14	2	–	–	–	●	●	–	●	●	–	●
EDPT140412PDSRGE	17,44	4,45	8,14	1,98	1,2	0,14	2	–	–	–	●	●	–	●	–	–	●
EDPT140416PDSRGE	17,45	4,45	8,12	1,58	1,6	0,14	2	–	–	–	●	●	–	●	–	–	●
EDPT140431PDSRGE	17,46	4,45	8,07	0,13	3,1	0,14	2	–	–	–	–	●	–	●	–	–	●

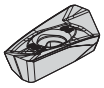
- Heavy roughing applications.
- High feed rates.
- All material groups.
- PSTS — Precision Pressed and Sintered to Size.
- Ap1 max = 14mm.

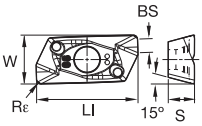
● first choice
○ alternate choice

beyond

P					○	●		●	●		○
M					●	●		○	○	○	●
K				●	○		●	○			
N	●	●									
S					●	●				●	●
H											


EDPT-S.GD


EDPT-S.GD2



EDPT-S.GD
EDPT-S.GD2

EDPT-S.GD

catalogue number	LI	S	W	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EDPT140408PDSRGD	17,47	4,50	8,37	2,55	0,8	0,11	2	–	–	●	–	●	–	●	●	–	●
EDPT140412PDSRGD	17,48	4,50	8,36	2,17	1,2	0,11	2	–	–	●	–	●	–	●	●	–	●
EDPT140416PDSRGD	17,49	4,50	8,35	1,77	1,6	0,11	2	–	–	●	–	●	–	●	●	–	●

EDPT-S.GD2

catalogue number	LI	S	W	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EDPT140408PDSRGD2	17,47	4,50	8,37	2,61	0,8	0,11	2	–	–	●	–	●	–	●	●	–	–

Recommended Starting Feeds

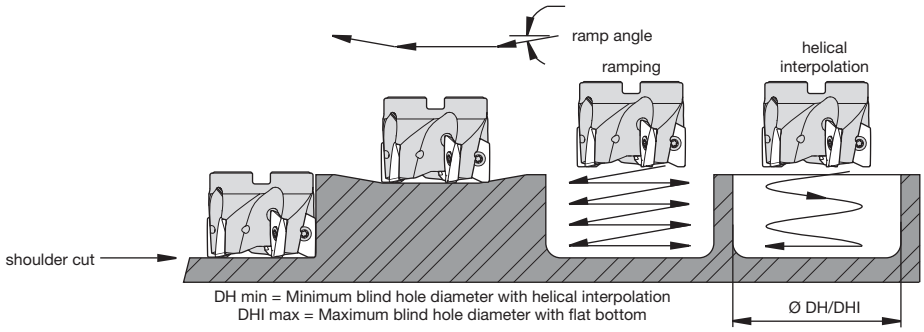
Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.F..LDJ	0,12	**0,46**	0,82	0,08	**0,33**	0,59	0,06	**0,25**	0,44	0,06	**0,22**	0,38	0,05	**0,20**	0,35	.F..LDJ
.E..LDJ	0,12	**0,47**	0,82	0,08	**0,34**	0,59	0,06	**0,26**	0,44	0,06	**0,22**	0,39	0,05	**0,20**	0,35	.E..LDJ
.E..LD	0,12	**0,46**	0,81	0,09	**0,33**	0,58	0,07	**0,25**	0,43	0,06	**0,22**	0,38	0,05	**0,20**	0,35	.E..LD
.E..GD	0,17	**0,52**	0,89	0,12	**0,38**	0,64	0,09	**0,28**	0,48	0,08	**0,24**	0,42	0,07	**0,22**	0,38	.E..GD
.S..GE	0,23	**0,51**	0,89	0,17	**0,37**	0,64	0,13	**0,27**	0,48	0,11	**0,24**	0,42	0,10	**0,22**	0,38	.S..GE
.S..GD	0,23	**0,50**	0,88	0,17	**0,36**	0,63	0,13	**0,27**	0,47	0,11	**0,24**	0,41	0,10	**0,22**	0,38	.S..GD
.S..GD2	0,23	**0,50**	0,88	0,17	**0,36**	0,63	0,13	**0,27**	0,47	0,11	**0,24**	0,41	0,10	**0,22**	0,38	.S..GD2
.E..HD	0,23	**0,59**	0,95	0,17	**0,43**	0,68	0,13	**0,32**	0,51	0,11	**0,28**	0,44	0,10	**0,25**	0,41	.E..HD
.E..HD2	0,21	**0,59**	0,95	0,15	**0,43**	0,68	0,11	**0,32**	0,51	0,10	**0,28**	0,44	0,09	**0,25**	0,41	.E..HD2

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

Application Examples



insert style	cutting diameter	max ramp angle	DH min (min hole diameter)	DHI min (min flat-bottomed hole diameter)	max diameter
Mill 1-14	20	16°	23,74	35,62	40
Mill 1-14	25	11°	33,75	44,44	50
Mill 1-14	32	7°	47,80	59,79	64
Mill 1-14	40	5°	63,76	75,22	80
Mill 1-14	40	5°	64,00	75,47	80
Mill 1-14	50	4°	83,96	96,05	100
Mill 1-14	63	3°	109,93	121,47	126
Mill 1-14	80	2°	143,91	155,47	160
Mill 1-14	100	1°	183,89	199,47	200
Mill 1-14	125	1°	233,88	245,47	250
Mill 1-14	160	1°	303,88	315,47	320

NOTE: Max ramp angle decreases as nose radius increases.

Mill 1-14™
Helical Cutters

Primary Application

Mill 1-14 helical cutters will increase axial depth of cut. Designed with axial support pins for added stability, the Mill 1-14 helical cutters feature essential Load-Optimised Insert Spacing™ (LOIS) technology. LOIS dramatically minimises unwanted vibrations and fluctuations in power requirements, resulting in a much smoother-sounding cut. Up to nine different coolant nozzle diameters enable tailoring to suit each machine tool, providing remarkably consistent, focused coolant flow.



Features and Benefits

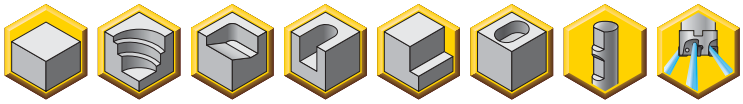
Functions

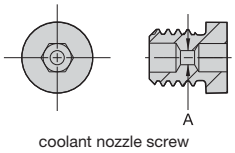
- Improves axial depth of cut better than standard end mills due to the positioning of inserts in helical configuration.
- Up to nine different coolant nozzle diameters tailored to suit each machine tool.
- One tool that offers features common to end mills, but rarely seen on a helical cutter: Helical ramping from solid, slotting, contouring, ramping, and plunging.

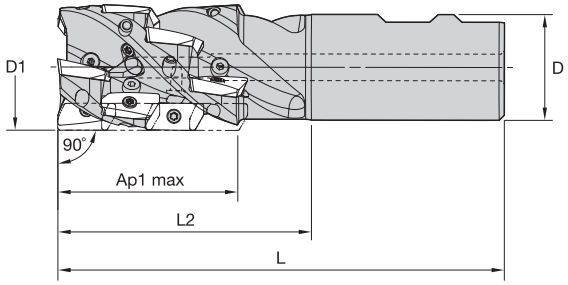
Benefits

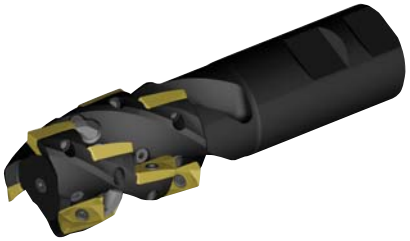
- Increases depth of cut.
- Consistent, focused coolant flow.
- Built for performance, accuracy, and versatility.

- Aggressive ramping rates.
- Generates superior surface finish.
- Mill 90° walls.
- Axial support pins.
- Unique coolant nozzles.









Helical Weldon® End Mills • Slot and Profile

order number	catalogue number	D1	D	L	L2	Ap1 max	Z	Z U	max ramp angle	kg	max RPM
3742932	**M1H32J2R50B32S90ED14C4**	32	32	111	50	27,8	4	2	6.8°	0,52	31100
3743033	**M1H40J3R50B32S90ED14C6**	40	32	111	50	27,5	6	3	4.8°	0,59	28400
3743034	**M1H40J3R65B32S90ED14C9**	40	32	126	65	40,8	9	3	4.8°	0,66	28400
3743035	**M1H40J3R80B32S90ED14C12**	40	32	141	80	54,0	12	3	4.8°	0,73	28400
3743038	**M1H50J3R80B40S90ED14C12**	50	40	151	80	53,5	12	3	3.5°	1,30	24600

NOTE: Standard milling cutters will accept insert nose radii up to 2mm without modification.

Spare Parts







D1	insert screw	Nm	Torx Plus driver	pin	coolant nozzle screw
32	**MS2148**	2,3	**DT9IP**	**ASPM07001802**	**MS2191C20**
40	**MS2148**	2,3	**DT9IP**	**ASPM07001802**	**MS2191C20**
50	**MS2148**	2,3	**DT9IP**	**ASPM07001802**	**MS2191C20**

Helical Weldon Mills • Profile Only

order number	catalogue number	D1	D	L	Ap1 max	Z	Z U	max ramp angle	kg	max RPM
5085631	**M1H40J4R80B32S90ED14C12**	40	32	141	40,8	12	4	4.8°	0,75	28400

Spare Parts







D1	insert screw	Nm	Torx Plus driver	pin	coolant nozzle screw
40	**MS2148**	2,3	**DT9IP**	**ASPM07001802**	**MS2191C20**

Optional Coolant Nozzle Screw



order number	catalogue number	A
3400611	MS2191C00	–
3400612	MS2191C06	0,6
3400613	MS2191C08	0,8
3400616	MS2191C12	1,2
3400617	MS2191C14	1,4
3400618	MS2191C16	1,6
3400619	MS2191C18	1,8
3400620	MS2191C20	2,0

Coolant Nozzle Key

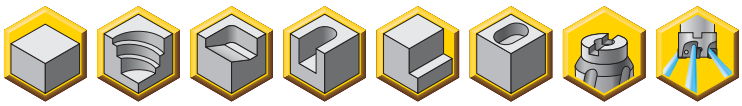


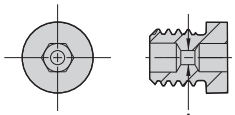


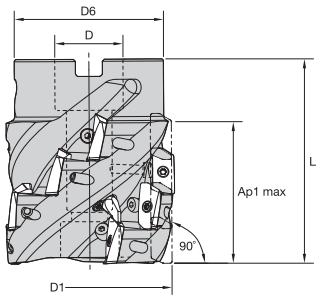
order number	catalogue number	drive size
1993552	THW2M	2 MM

NOTE: Check the spare parts table for the coolant hole size that is incorporated in the cutters.
If you need an alternative, there are eight other variants to choose from to increase or decrease the pressure.
Example: MS2191C12 is a 1,20mm hole. All coolant nozzles are interchangeable with the original that is supplied with the cutter.
This gives flexibility with coolant flow.

- Aggressive ramping rates.
- Generates superior surface finish.
- Mill 90° walls.
- Axial support pins.
- Unique coolant nozzles.









Helical Shell Mills • Slot and Profile

order number	catalogue number	D1	D	D6	L	Ap1 max	Z	Z U	max ramp angle	kg	max RPM
3743036	M1H50T3R50A22S90ED14C6	50	22	46	50	27,3	6	3	3.5°	0,43	24600
3743037	M1H50T3R65A22S90ED14C9	50	22	46	65	40,4	9	3	3.5°	0,57	24600
3743039	M1H63T3R50A27S90ED14C6	63	27	60	50	26,9	6	3	2.5°	0,76	22000
3743040	M1H63T3R65A27S90ED14C9	63	27	60	65	39,9	9	3	2.5°	1,00	22000
3743042	M1H63T3R75A27S90ED14C12	63	27	60	75	52,8	12	3	2.5°	1,16	22000
3743041	M1H63T4R65A27S90ED14C12	63	27	60	65	39,9	12	4	2.5°	0,97	22000

NOTE: Standard milling cutters will accept insert nose radii up to 2mm without modification.

Spare Parts



order number	D1	insert screw	Nm	Torx Plus driver	pin	socket-head cap screw	coolant nozzle screw
3743036	50	MS2148	2,3	DT9IP	ASPM07001802	MS1235	MS2191C20
3743037	50	MS2148	2,3	DT9IP	ASPM07001802	MS1233	MS2191C16
3743039	63	MS2148	2,3	DT9IP	ASPM07001802	MS1198	MS2191C20
3743040	63	MS2148	2,3	DT9IP	ASPM07001802	MS1238	MS2191C20
3743042	63	MS2148	2,3	DT9IP	ASPM07001802	MS1433	MS2191C16
3743041	63	MS2148	2,3	DT9IP	ASPM07001802	MS1238	MS2191C16

Helical Shell Mills • Profile Only

order number	catalogue number	D1	D	D6	L	Ap1 max	Z	Z U	max ramp angle	kg	max RPM
3831819	**M1H63T5R75A27S90ED14C20**	63	27	60	75	52,8	20	5	2.0°	1,06	22000

Spare Parts

D1	insert screw	Nm	Torx Plus driver	pin	socket-head cap screw	coolant nozzle screw
63	**MS2148**	2,3	**DT9IP**	**ASPM07001802**	**MS1433**	**MS2191C12**

NOTE: Standard milling cutters will accept insert nose radii up to 2mm without modification.

Optional Coolant Nozzle Screw



order number	catalogue number	A
3400611	**MS2191C00**	–
3400612	**MS2191C06**	0,6
3400613	**MS2191C08**	0,8
3400616	**MS2191C12**	1,2
3400617	**MS2191C14**	1,4
3400618	**MS2191C16**	1,6
3400619	**MS2191C18**	1,8
3400620	**MS2191C20**	2,0

Coolant Nozzle Key





order number	catalogue number	drive size
1993552	**THW2M**	2 MM

NOTE: Check the spare parts table for the coolant hole size that is incorporated in the cutters.
If you need an alternative, there are eight other variants to choose from to increase or decrease the pressure.
Example: MS2191C12 is a 1,20m m hole. All coolant nozzles are interchangeable with the original that is supplied with the cutter.
This gives flexibility with coolant flow.

Insert Selection Guide

Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		◄——►		toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.E..GD	KCPM40	**.S..GD2**	**KCPM40**	.E..HD2	KCPM40
P3–P4	.E..GD	KCPM40	**.S..GD2**	**KCPK30**	.E..HD2	KCPK30
P5–P6	.E..GD	KC725M	**.S..GD2**	**KC725M**	.E..HD2	KC725M
M1–M2	.E..LD	KC522M	**.E..GD**	**KCSM40**	.E..HD2	KC522M
M3	.E..GD	KCSM40	**.S..GD2**	**KCPM40**	.E..HD2	KCPM40
K1–K2	.S..GD2	KC520M	**.E..HD2**	**KC520M**	.E..HD2	KCK15
K3	.S..GD2	KC520M	**.E..HD2**	**KC520M**	.E..HD2	KCK15
N1–N2	.F..LDJ	KC410M	**.F..LDJ**	**KC410M**	.E..LDJ	KC422M
N3	.F..LDJ	KC410M	**.F..LDJ**	**KC410M**	.F..LDJ	KC410M
S1–S2	.E..GD	KC725M	**.S..GD2**	**KC725M**	.E..HD2	KC725M
S3	.E..GD	KCSM40	**.S..GD2**	**KC725M**	.E..HD2	KC725M
S4	.E..GD	KCSM40	**.S..GD2**	**KC725M**	.E..HD2	KC522M
H1	–	–	**–**	**–**	–	–

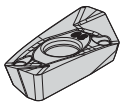
Indexable Inserts

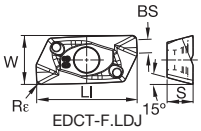
- Roughing and finishing of aluminium alloys.
- Periphery ground and polished rake face.
- Perfect floor surface finish.
- Ap1 max = 14mm.

beyond

● first choice
○ alternate choice

		KC410M	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
P					○	●		●	●		○
M					●	●		○	○	○	●
K				●	○		●	○			
N		●	●								
S					●	●				●	●
H											


EDCT-F.LDJ



EDCT-F.LDJ

EDCT-F.LDJ

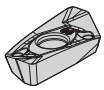
catalogue number	LI	S	W	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EDCT140402PDFRLDJ	17,46	4,50	8,49	3,14	0,2	0,02	2	●	–	–	–	–	–	–	–	–	–
EDCT140404PDFRLDJ	17,46	4,50	8,49	2,95	0,4	0,02	2	●	–	–	–	–	–	–	–	–	–
EDCT140408PDFRLDJ	17,47	4,50	8,48	2,56	0,8	0,02	2	●	–	–	–	–	–	–	–	–	–
EDCT140412PDFRLDJ	17,47	4,50	8,46	2,17	1,2	0,02	2	●	–	–	–	–	–	–	–	–	–
EDCT140416PDFRLDJ	17,49	4,50	8,45	1,77	1,6	0,02	2	●	–	–	–	–	–	–	–	–	–
EDCT140431PDFRLDJ	17,50	4,50	8,40	0,26	3,1	0,02	2	●	–	–	–	–	–	–	–	–	–
EDCT140440PDFRLDJ	16,53	4,50	8,34	–	4,0	0,02	2	●	–	–	–	–	–	–	–	–	–

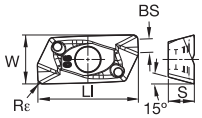
- Roughing and finishing of aluminium alloys.
- Periphery ground and polished rake face.
- Perfect floor surface finish.
- Ap1 max = 14mm.

beyond

● first choice
○ alternate choice

P					○	●		●	●		○
M					●	●		○	○	○	●
K				●	○		●	○			
N	●	●									
S					●	●				●	●
H											


EDCT-E.LDJ

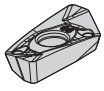


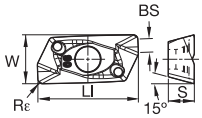
EDCT-E.LDJ

EDCT-E.LDJ

catalogue number	LI	S	W	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EDCT140404PDERLDJ	17,46	4,50	8,49	2,95	0,4	0,03	2	–	●	–	–	–	–	–	–	–	–
EDCT140408PDERLDJ	17,47	4,50	8,48	2,56	0,8	0,03	2	–	●	–	–	–	–	–	–	–	–
EDCT140424PDERLDJ	17,50	4,50	8,42	0,99	2,4	0,03	2	–	●	–	–	–	–	–	–	–	–

- Finishing and high-precision applications.
- Light machining.
- 15° positive rake angle.
- Perfect floor surface finish.
- Ap1 max = 14mm.


EDCT-LD

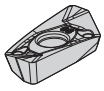


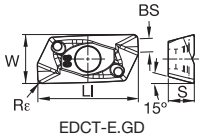
EDCT-LD

EDCT-LD

catalogue number	LI	S	W	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EDCT140404PDERLD	17,46	4,50	8,49	2,95	0,4	0,04	2	–	–	–	●	–	–	–	–	–	–
EDCT140408PDERLD	17,47	4,50	8,48	2,56	0,8	0,04	2	–	–	–	●	–	–	–	–	–	–
EDCT140412PDERLD	17,48	4,50	8,46	2,17	1,2	0,04	2	–	–	–	●	–	–	–	–	–	–
EDCT140416PDERLD	17,49	4,50	8,45	1,77	1,6	0,04	2	–	–	–	●	–	–	–	–	–	–
EDCT140431PDERLD	17,50	4,50	8,40	0,26	3,1	0,04	2	–	–	–	●	–	–	–	–	–	–

- Light machining and finishing applications.
- Periphery ground for high-precision machining.
- Medium hone for increased edge protection.
- Ap1 max = 14mm.


EDCT-E.GD

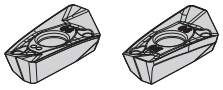


EDCT-E.GD

EDCT-E.GD

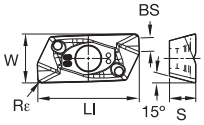
catalogue number	LI	S	W	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EDCT140404PDERGD	17,46	4,50	8,49	2,95	0,4	0,05	2	–	–	–	–	●	–	–	●	–	–
EDCT140408PDERGD	17,47	4,50	8,48	2,56	0,8	0,05	2	–	–	–	–	●	–	–	●	–	●
EDCT140412PDERGD	17,48	4,50	8,46	2,17	1,2	0,05	2	–	–	–	–	●	–	–	–	–	●
EDCT140416PDERGD	17,49	4,50	8,45	1,77	1,6	0,05	2	–	–	–	–	●	–	–	–	–	●
EDCT140431PDERGD	17,50	4,50	8,40	0,26	3,1	0,05	2	–	–	–	–	●	–	–	–	–	●

- Medium roughing and semi-finishing.
- Medium feed rates.
- PSTS — Precision Pressed and Sintered to Size.
- Ap1 max = 14mm.



EDPT-E.HD

EDPT-E.HD2



EDPT-E.HD
EDPT-E.HD2

● first choice
○ alternate choice

beyond

		KC410M	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
P					○	●		●	●		○
M					●	●		○	○	○	●
K				●	○		●	○			
N		●	●								
S					●	●				●	●
H											

EDPT-E.HD

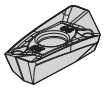
catalogue number	LI	S	W	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EDPT140404PDERHD	17,46	4,50	8,39	2,95	0,4	0,08	2	–	–	●	●	●	●	●	●	–	–
EDPT140408PDERHD	17,47	4,50	8,38	2,56	0,8	0,08	2	–	–	●	●	●	●	●	●	–	●
EDPT140412PDERHD	17,48	4,50	8,36	2,16	1,2	0,08	2	–	–	●	●	●	●	●	●	–	●
EDPT140416PDERHD	17,49	4,50	8,36	1,77	1,6	0,08	2	–	–	–	●	●	●	●	●	●	●
EDPT140420PDERHD	17,49	4,50	8,35	1,37	2,0	0,08	2	–	–	–	●	●	–	●	–	–	●
EDPT140424PDERHD	17,50	4,50	8,32	0,99	2,4	0,08	2	–	–	–	●	●	–	●	●	–	●
EDPT140431PDERHD	17,51	4,50	8,30	0,26	3,1	0,08	2	–	–	–	●	●	–	●	–	●	●
EDPT140440PDERHD	16,53	4,50	8,26	—	4,0	0,08	2	–	–	–	●	●	–	●	–	●	●

- For improved 90° wall capabilities.

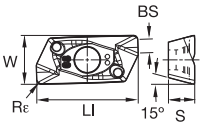
EDPT-E.HD2

catalogue number	LI	S	W	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EDPT140408PDERHD2	17,47	4,50	8,38	2,56	0,8	0,06	2	–	–	–	●	●	●	●	●	–	–

- Medium roughing and semi-finishing.
- Solution for austenitic stainless steel and super alloys.
- Medium feed rates.
- PSTS — Precision Pressed and Sintered to Size.
- Ap1 max = 14mm.



EDPT-S.GE



EDPT-S.GE

EDPT-S.GE

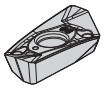
catalogue number	LI	S	W	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EDPT140404PDSRGE	17,43	4,45	8,20	2,80	0,4	0,14	2	–	–	–	●	●	–	●	–	–	–
EDPT140408PDSRGE	17,44	4,45	8,17	2,39	0,8	0,14	2	–	–	–	●	●	–	●	●	–	●
EDPT140412PDSRGE	17,44	4,45	8,14	1,98	1,2	0,14	2	–	–	–	●	●	–	●	–	–	●
EDPT140416PDSRGE	17,45	4,45	8,12	1,58	1,6	0,14	2	–	–	–	●	●	–	●	–	–	●
EDPT140431PDSRGE	17,46	4,45	8,07	0,13	3,1	0,14	2	–	–	–	–	●	–	●	–	–	●

- Heavy roughing applications.
- High feed rates.
- All material groups.
- PSTS — Precision Pressed and Sintered to Size.
- Ap1 max = 14mm.

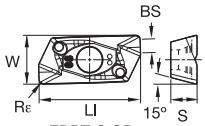
beyond

● first choice
○ alternate choice

		KC410M	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
P					○	●		●	●		○
M					●	●		○	○	○	●
K				●	○		●	○			
N		●	●								
S					●	●				●	●
H											



EDPT-S.GD

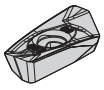


EDPT-S.GD

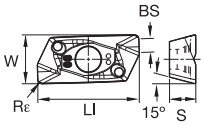
EDPT-S.GD

catalogue number	LI	S	W	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EDPT140408PDSRGD	17,47	4,50	8,37	2,55	0,8	0,11	2	–	–	●	–	●	–	●	●	–	●
EDPT140412PDSRGD	17,48	4,50	8,36	2,17	1,2	0,11	2	–	–	●	–	●	–	●	●	–	●
EDPT140416PDSRGD	17,49	4,50	8,35	1,77	1,6	0,11	2	–	–	●	–	●	–	●	●	–	●

- Heavy roughing applications.
- High feed rates.
- All material groups.
- PSTS — Precision Pressed and Sintered to Size.
- Ap1 max = 14mm.



EDPT-S.GD2



EDPT-S.GD2

EDPT-S.GD2

catalogue number	LI	S	W	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EDPT140408PDSRGD2	17,47	4,50	8,37	2,61	0,8	0,11	2	–	–	●	–	●	–	●	●	–	–

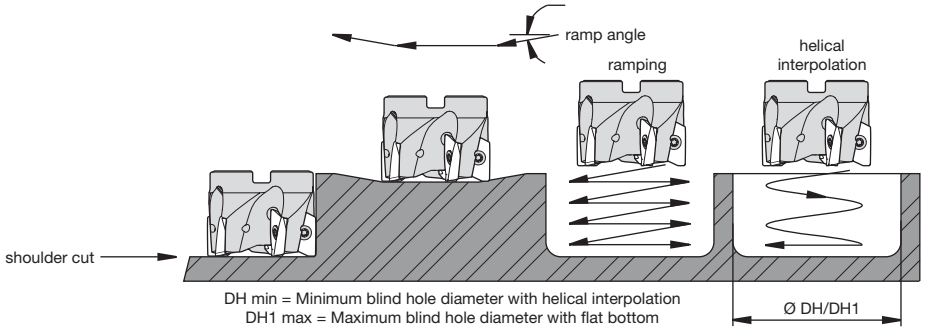
Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.F..LDJ	0,12	**0,46**	0,82	0,08	**0,33**	0,59	0,06	**0,25**	0,44	0,06	**0,22**	0,38	0,05	**0,20**	0,35	.F..LDJ
.E..LDJ	0,12	**0,47**	0,82	0,08	**0,34**	0,59	0,06	**0,26**	0,44	0,06	**0,22**	0,39	0,05	**0,20**	0,35	.E..LDJ
.E..LD	0,12	**0,46**	0,81	0,09	**0,33**	0,58	0,07	**0,25**	0,43	0,06	**0,22**	0,38	0,05	**0,20**	0,35	.E..LD
.E..GD	0,17	**0,52**	0,89	0,12	**0,38**	0,64	0,09	**0,28**	0,48	0,08	**0,24**	0,42	0,07	**0,22**	0,38	.E..GD
.S..GE	0,23	**0,51**	0,89	0,17	**0,37**	0,64	0,13	**0,27**	0,48	0,11	**0,24**	0,42	0,10	**0,22**	0,38	.S..GE
.S..GD	0,23	**0,50**	0,88	0,17	**0,36**	0,63	0,13	**0,27**	0,47	0,11	**0,24**	0,41	0,10	**0,22**	0,38	.S..GD
.S..GD2	0,23	**0,50**	0,88	0,17	**0,36**	0,63	0,13	**0,27**	0,47	0,11	**0,24**	0,41	0,10	**0,22**	0,38	.S..GD2
.E..HD	0,23	**0,59**	0,95	0,17	**0,43**	0,68	0,13	**0,32**	0,51	0,11	**0,28**	0,44	0,10	**0,25**	0,41	.E..HD
.E..HD2	0,21	**0,59**	0,95	0,15	**0,43**	0,68	0,11	**0,32**	0,51	0,10	**0,28**	0,44	0,09	**0,25**	0,41	.E..HD2

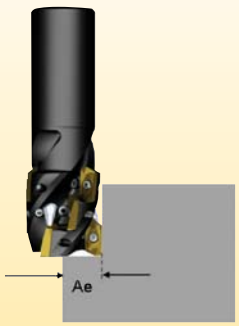
NOTE: Use "Light Machining" values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

Application Examples

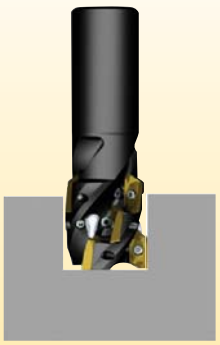


insert style	cutting diameter	max ramp angle	min hole diameter (DH min)	max flat-bottom hole diameter (DH1 max)	max diameter
Mill 1-14	32	5.4°	47,80	59,79	64
Mill 1-14	40	3.8°	64,00	75,47	80
Mill 1-14	50	2.7°	83,96	96,05	100
Mill 1-14	63	1.9°	109,93	121,47	126

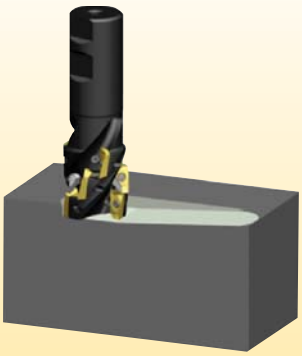
Best Machining Practices



Contouring/Profiling
ae = up to 50% of cutter Ø. This can be used with or without coolant/air blast, depending on materials being machined.



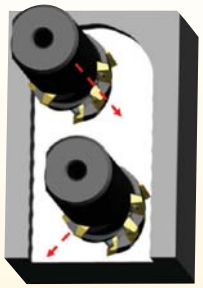
Slotting
Full width cutting or profiling over 50% of the cutter Ø. It is suggested to use coolant or air blast to evacuate chips. If necessary, reduce coolant nozzle hole size, which adds more pressure, and the chip is forced out of the chip gash.



Ramping
Only machine to the depth of the first insert. Observe the ramping angles given in the catalogue.

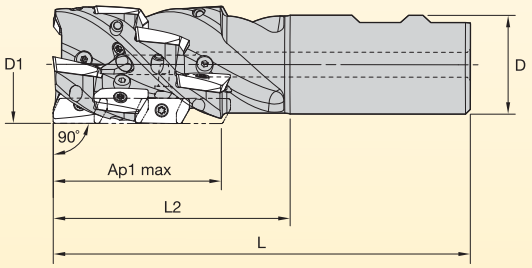
Slotting by Plunging

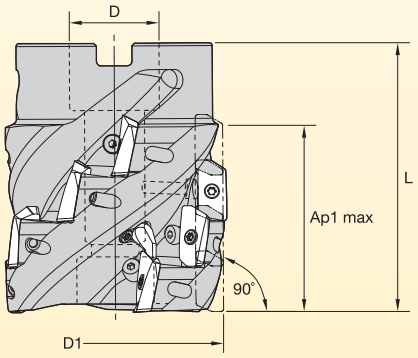
Slot with the alternate side method, alternating the cuts from side to side. This will enable the cutter to move away from the material prior to moving back up in the Z-axis. The cutter will not be in contact with the workpiece. Follow the direction of the arrows. Move 3 axes simultaneously into the centre of the slot. Maximum step over 8,0mm (0.315").



With multiple Z-axis passes, when the final depth is achieved, move straight back up in the Z-axis, then repeat at the next step over.







	catalogue number	order number	D1	ZU[1]	Z	Mtg.[2]	D	L2	L	Ap1 max	max Ra[3]	max CR[4]	max RPM
Inch Cutters	M1HR125E14W125Z2L200C4	3732889	1.25	2	4	W	1.25	2.00	4.28	1.09	5.4°	0.094	31100
	M1HR150E14W125Z3L200C6	3732890	1.50	3	6	W	1.25	2.00	4.28	1.09	4.0°	0.094	28400
	M1HR150E14W125Z3L250C9	3732891	1.50	3	9	W	1.25	2.50	4.78	1.61	4.0°	0.094	28400
	M1HR150E14W125Z3L300C12	3732892	1.50	3	12	W	1.25	3.00	5.28	2.13	4.0°	0.094	28400
	M1HR200E14S075Z3L200C6	3732933	2.00	3	6	S	0.75	–	2.00	1.07	2.6°	0.094	24600
	M1HR200E14S075Z3L250C9	3732934	2.00	3	9	S	0.75	–	2.50	1.59	2.6°	0.094	24600
	M1HR200E14W150Z3L300C12	3732935	2.00	3	12	W	1.50	3.00	5.69	2.10	2.6°	0.094	24600
	M1HR250E14S100Z3L250C9	3732937	2.50	3	9	S	1.00	–	2.50	1.57	1.9°	0.062	22000
	M1HR250E14S100Z4L250C12	3732938	2.50	4	12	S	1.00	–	2.50	1.57	1.9°	0.062	22000
	[5] M1HR250E14S100Z3L300C12	3732939	2.50	3	12	S	1.00	–	3.00	2.07	1.9°	0.062	22000

Metric Cutters	M1H32J2R50B32S90ED14C4	3742932	32	2	4	W	32	50	111	27,8	5,4°	2,4	31100
	M1H40J3R50B32S90ED14C6	3743033	40	3	6	W	32	50	111	27,6	3,8°	2,4	28400
	M1H40J3R65B32S90ED14C9	3743034	40	3	9	W	32	65	126	40,8	3,8°	2,4	28400
	M1H40J4R80B32S90ED14C12	5085631	40	4	12	W	32	80	141	40,8	3,8°	2,5	28400
	M1H40J3R80B32S90ED14C12	3743035	40	3	12	W	32	80	141	54,0	3,8°	2,4	28400
	M1H50T3R50A22S90ED14C6	3743036	50	3	6	S	22	–	50	27,3	2,7°	2,4	24600
	M1H50T3R65A22S90ED14C9	3743037	50	3	9	S	22	–	65	40,4	2,7°	2,4	24600
	M1H50J3R80B40S90ED14C12	3743038	63	3	12	W	40	80	151	53,5	1,9°	2,4	24600
	M1H63T3R50A27S90ED14C6	3743039	63	3	6	S	27	–	50	27,0	1,9°	1,6	22000
	M1H63T3R65A27S90ED14C9	3743040	63	3	9	S	27	–	65	39,9	1,9°	1,6	22000
	M1H63T4R65A27S90ED14C12	3743041	63	4	12	S	27	–	65	39,9	1,9°	1,6	22000
	M1H63T3R75A27S90ED14C12	3743042	63	3	12	S	27	–	75	52,8	1,9°	1,6	22000
	[5] M1H63T5R75A27S90ED14C20	3831819	63	5	20	S	27	–	75	52,8	1,9°	1,6	22000

[1] Number of effective flutes.
[2] Mounting style: W = Weldon®; S = Shell Mill.
[3] Max ramp angle when radial depth of cut exceeds 8mm (.31")
[4] Max insert corner radius allowed in first row without cutter body modification.
[5] Recommended for profiling applications only.

Profile, Slot, and Ramp

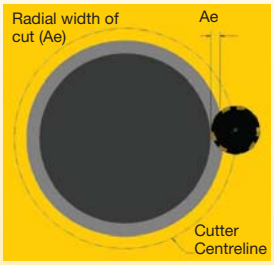
When taking a cut that equals up to 50% of the cutter diameter, you can operate without coolant, unless your material is coolant-dependent. When using more than 50% of the cutter diameter, there is a need to have coolant through the nozzles, or an air blast through the nozzles. This will assist with chip evacuation. Please use the feed table when taking a small percentage of the cutter diameter. This will improve the volume of material removed. To achieve a superior surface finish on the base, adjust the feed to suit the finish required.

When using this cutter for plunging, the maximum suggested step over is 3,30mm (.130"). Always try to move the cutter and insert away from the material when retracting in the Z-axis. This can be done when employing the alternate cut method (zig zag method). Use a 3-axis move to get all axes moving at the same time, suggest 0,25mm (.010").

When machining a conventional slot, you have to move straight up in the Z-axis.

Circular and Helical Interpolation

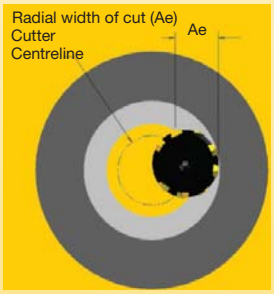
External



When profiling around the external part of a component, it is important to increase the feed rate. This will maintain the chip thickness value.
The programmed feed rate needs to be calculated at the cutter centreline.

For external profiling, adjust the feed rate for feed at the cutter centreline.
Increase the feed rate for external profiling.

Internal



When machining inside a component profile, the area of contact is larger.
The feed rate needs to be at the centreline, and the feed rate needs to be slower.

For internal profiling, adjust the feed rate for feed at the cutter centreline.
This will effectively reduce the feed rate as the distance traveled is less than the peripheral distance.

Cutting Data

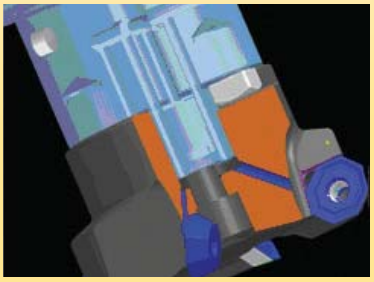
Reference pages X22–X37 for speed tables. Reference platform pages for feed data.
Each insert has an average chip thickness value that will enable you to determine the feed per tooth.

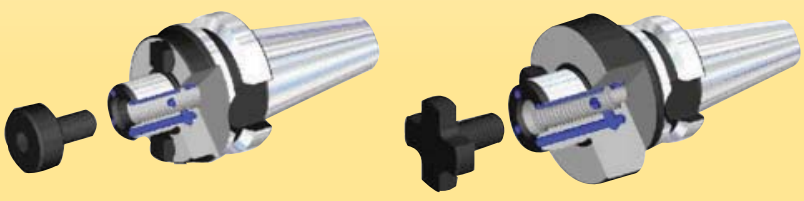
Please remember when using less than 50% of the cutter diameter, the feed rate will need to be increased.
Failure to do so will result in premature insert failure. Running too slowly will reduce tool life.

Spare Parts

Please make sure all the spare parts in the cutters are fully tightened prior to using the product. Shell mill cutters no longer have coolant grooved bolts. We now have adaptors that will enable the coolant to be fed through the adaptor pilot diameter.

True Through Coolant Shell Mill Adaptors





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Mill 1-18™

Primary Application

The Mill 1-18 series is a versatile, functional cutter system for a range of cutting tasks. Mill 1-18 cutters can be used for profiling, slotting, ramping, helical interpolation, plunging, and other milling applications. It's a single tool with multi-functional benefits. Mill 1-18 inserts are specially designed to add cutting versatility, especially for larger axial depths of cut. Results include significantly reduced cycle times and lower cutting forces.



Features and Benefits

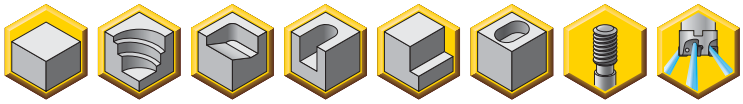
Features

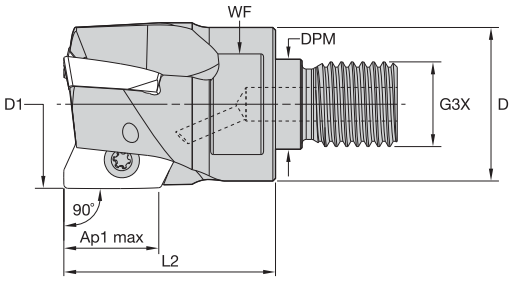
- Inserts for larger axial depth of cut.
- Inserts radii up to 6,35mm.
- Axial depth of cut up to 18mm.
- Cutter diameters up to 160mm.
- Beyond™ grade technology.

Benefits

- Slotting, profiling, ramping, helical interpolation, and plunging.
- Angled screw for insert retention.
- Insert geometries and grades for most workpiece materials.

- Aggressive ramping rates.
- Generates superior surface finish.
- Mill 90° walls.
- High RPM capabilities.







Screw-On End Mills

order number	catalogue number	D1	D	DPM	G3X	L2	WF	Ap1 max	Z	max ramp angle	kg	max RPM
3349690	**25A02R035M12SED18**	25	21	12,5	M12	35	17	18,0	2	17.3°	0,08	37380
3349691	**32A02R040M16SED18**	32	29	17,0	M16	40	24	18,0	2	10.8°	0,17	32140
3349692	**32A03R040M16SED18**	32	29	17,0	M16	40	24	18,0	3	10.8°	0,16	32140
3349773	**40A03R040M16SED18**	40	29	17,0	M16	40	24	17,8	3	7.4°	0,21	28220
3349774	**40A04R040M16SED18**	40	29	17,0	M16	40	24	17,8	4	7.4°	0,20	28220

NOTE: Standard milling cutters will accept insert nose radii up to 2mm without modification.

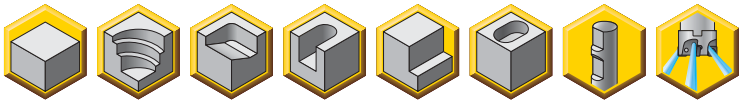
Spare Parts

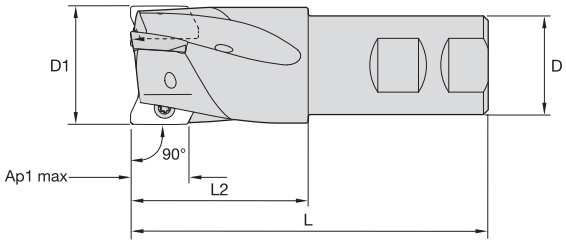




D1	insert screw	Nm	Torx Plus driver
25	**MS2126**	4,0	**DT15IP**
32	**MS2126**	4,0	**DT15IP**
40	**MS2126**	4,0	**DT15IP**

- Aggressive ramping rates.
- Generates superior surface finish.
- Mill 90° walls.
- High RPM capabilities.







Weldon® End Mills

order number	catalogue number	D1	D	L	L2	Ap1 max	Z	max ramp angle	kg	max RPM
2390446	**25A02R044B25SED18**	25	25	100	44	18,0	2	17.3°	0,29	37380
2390448	**32A03R050B32SED18**	32	32	110	50	18,0	3	10.8°	0,52	32140
2417191	**40A03R050B32SED18**	40	32	110	50	17,8	3	7.4°	0,66	28220
2390450	**40A04R050B32SED18**	40	32	110	50	17,4	4	7.4°	0,63	28220

NOTE: Standard milling cutters will accept insert nose radii up to 2mm without modification.

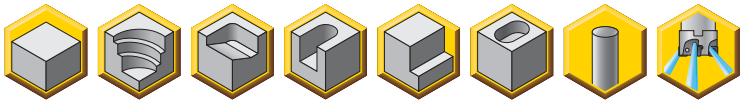
Spare Parts

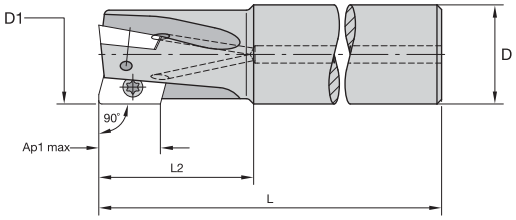




D1	insert screw	Nm	Torx Plus driver
25	**MS2126**	4,0	**DT15IP**
32	**MS2126**	4,0	**DT15IP**
40	**MS2126**	4,0	**DT15IP**

- Aggressive ramping rates.
- Generates superior surface finish.
- Mill 90° walls.
- High RPM capabilities.







Cylindrical End Mills

order number	catalogue number	D1	D	L	L2	Ap1 max	Z	max ramp angle	kg	max RPM
3349685	**25A02R044A25SED18**	25	25	100	44	18,0	2	17.3°	0,29	37380
2963873	**25A02R044A25SED18-150**	25	25	150	44	18,0	2	17.3°	0,47	37380
2613785	**25A02R050A25SED18-170**	25	25	170	50	18,0	2	17.3°	0,54	37380
3349689	**32A03R050A25SED18**	32	25	107	50	18,0	3	10.8°	0,37	32140
2613788	**32A02R050A32SED18-200**	32	32	200	50	17,0	2	10.8°	1,10	32140
3349686	**32A03R050A32SED18**	32	32	110	50	17,0	3	10.8°	0,52	32140
2613786	**32A03R050A32SED18-200**	32	32	200	50	17,0	3	10.8°	1,07	32140
2963874	**34A03R050A32SED18-250**	34	32	250	50	18,0	3	9.8°	1,40	31210
2613789	**40A03R050A32SED18-200**	40	32	200	50	17,4	3	7.4°	1,20	28220
2963875	**40A03R050A32SED18-250**	40	32	250	50	17,4	3	7.4°	1,50	28220
3349688	**40A04R050A32SED18**	40	32	110	50	17,4	4	7.4°	0,64	28220
2613787	**40A04R050A32SED18-200**	40	32	200	50	17,4	4	7.4°	1,18	28220
2963876	**40A04R050A32SED18-250**	40	32	250	50	17,4	4	7.4°	1,48	28220

NOTE: Standard milling cutters will accept insert nose radii up to 2mm without modification.

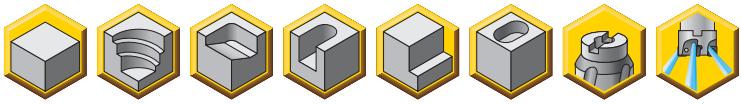
Spare Parts

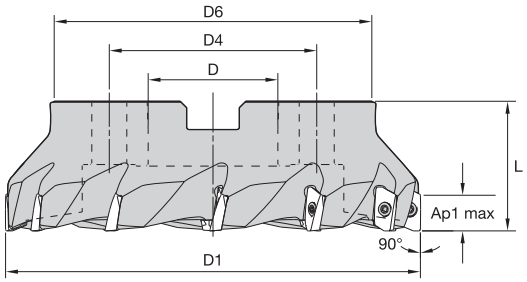




D1	insert screw	Nm	Torx Plus driver
25	**MS2126**	4,0	**DT15IP**
25	**MS2126**	4,0	**DT15IP**
32	**MS2126**	4,0	**DT15IP**
40	**MS2126**	4,0	**DT15IP**
40	**MS2126**	4,0	**DT15IP**

- Aggressive ramping rates.
- Generates superior surface finish.
- Mill 90° walls.
- High RPM capabilities.







Shell Mills

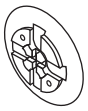
order number	catalogue number	D1	D	D4	D6	L	Ap1 max	Z	max ramp angle	kg	max RPM
2417185	**50A04RS90ED18D**	50	22	–	45	40	17,7	4	5.3°	0,27	24890
2417183	**50A05RS90ED18D**	50	22	–	45	40	17,7	5	5.3°	0,28	24890
2417186	**63A05RS90ED18D**	63	22	–	50	40	17,6	5	3.8°	0,45	21910
2390483	**63A06RS90ED18D**	63	22	–	50	40	17,6	6	3.8°	0,48	21910
2417187	**80A06RS90ED18D**	80	27	–	60	50	17,4	6	2.8°	0,96	19270
2417184	**80A07RS90ED18D**	80	27	–	60	50	17,4	7	2.8°	0,99	19270
2417188	**100A07RS90ED18D**	100	32	–	80	50	17,4	7	2.1°	1,75	17120
2390485	**100A08RS90ED18D**	100	32	–	80	50	17,4	8	2.1°	1,77	17120
2417189	**125B08RS90ED18D**	125	40	–	90	63	17,4	8	1.7°	2,57	15230
2390486	**125B09RS90ED18D**	125	40	–	90	63	17,4	9	1.7°	2,61	15230
2417190	**160C10RS90ED18D**	160	40	66,7	100	63	17,4	10	1.3°	3,90	13400
2390487	**160C12RS90ED18D**	160	40	66,7	100	63	17,4	12	1.3°	3,90	13400

NOTE: Standard milling cutters will accept insert nose radii up to 2mm without modification.

Spare Parts





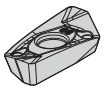
D1	insert screw	Nm	Torx Plus wrench	mounting screw	mill cutter lock screw	coolant cap
50	**MS2126**	4,0	**DT15IP**	–	–	–
63	**MS2126**	4,0	**DT15IP**	–	–	–
80	**MS2126**	4,0	**DT15IP**	**MS2038**	–	–
100	**MS2126**	4,0	**DT15IP**	**MS1559**	–	–
125	**MS2126**	4,0	**DT15IP**	–	**420.200**	**470.232**
160	**MS2126**	4,0	**DT15IP**	–	**420.200**	**470.233**

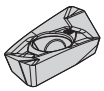
Insert Selection Guide

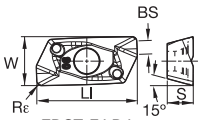
Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		⟷		toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.E..GD	KCPM40	**.S..GD**	**KCPM40**	.E..HD	KCPM40
P3–P4	.E..GD	KCPK30	**.S..GD**	**KCPK30**	.E..HD	KCPK30
P5–P6	.E..GD	KC725M	**.S..GD**	**KC725M**	.E..HD	KC725M
M1–M2	.E..GD	KCSM40	**.S..GD**	**KCSM40**	.E..HD	KCSM40
M3	.E..GD	KCPM40	**.S..GD**	**KCPM40**	.E..HD	KCPM40
K1–K2	.E..GD	KC520M	**.E..GD**	**KC520M**	.S..GD	KCK15
K3	.E..GD	KC520M	**.S..GD**	**KCK15**	.E..HD	KCPK30
N1–N2	.F..LDJ	KC410M	**.E..LDJ**	**KC422M**	.E..LDJ	KC422M
N3	.F..LDJ	KC410M	**.F..LDJ**	**KC410M**	.F..LDJ	KC410M
S1–S2	.E..GD	KC725M	**.S..GD**	**KC725M**	.E..HD	KC725M
S3	.E..GD	KCSM40	**.S..GD**	**KCSM40**	.E..HD	KCSM40
S4	.E..GD	KCSM40	**.S..GD**	**KCSM40**	.E..HD	KCSM40
H1	–	–	**–**	**–**	–	–

Indexable Inserts

- Light edge prep for reduced cutting forces.
- Periphery ground for high-precision machining.
- Light machining and finish applications.
- Ap1 max = 18mm.


EDCT-F.LDJ


EDCT-E.LDJ



EDCT-F.LDJ
EDCT-E.LDJ

● first choice
○ alternate choice

beyond

	KC410M	KC422M	KC520M	KC522M	KC525M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
P				○		●		●	●		○
M				●	●	●		○	○	○	●
K			●	○			●	○			
N	●	●									
S				●	●	●				●	●
H											

EDCT-F.LDJ

catalogue number	LI	S	W	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC525M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EDCT180504PDFRLDJ	21,75	5,50	10,98	3,07	0,4	0,02	2	●	–	–	–	–	–	–	–	–	–	–
EDCT180508PDFLLDJ	21,76	5,50	10,97	2,69	0,8	0,02	2	●	–	–	–	–	–	–	–	–	–	–
EDCT180508PDFRLDJ	21,76	5,50	10,97	2,69	0,8	0,02	2	●	–	–	–	–	–	–	–	–	–	–
EDCT180512PDFRLDJ	21,77	5,50	10,97	2,29	1,2	0,02	2	●	–	–	–	–	–	–	–	–	–	–
EDCT180516PDFRLDJ	21,78	5,50	10,96	1,90	1,6	0,02	2	●	–	–	–	–	–	–	–	–	–	–
EDCT180520PDFRLDJ	21,79	5,50	10,95	1,49	2,0	0,02	2	●	–	–	–	–	–	–	–	–	–	–
EDCT180524PDFRLDJ	21,79	5,50	10,93	1,11	2,4	0,02	2	●	–	–	–	–	–	–	–	–	–	–
EDCT180532PDFRLDJ	21,79	5,50	10,91	0,32	3,2	0,02	2	●	–	–	–	–	–	–	–	–	–	–
EDCT180540PDFRLDJ	20,78	5,50	10,87	–	4,0	0,02	2	●	–	–	–	–	–	–	–	–	–	–
EDCT180548PDFRLDJ	20,20	5,50	10,83	–	4,8	0,02	2	●	–	–	–	–	–	–	–	–	–	–
EDCT180550PDFRLDJ	19,95	5,50	10,81	–	5,0	0,02	2	●	–	–	–	–	–	–	–	–	–	–
EDCT180564PDFRLDJ	18,72	5,50	10,73	–	6,4	0,02	2	●	–	–	–	–	–	–	–	–	–	–

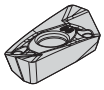
EDCT-E.LDJ

catalogue number	LI	S	W	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC525M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EDCT180508PDERLDJ	21,76	5,50	10,97	2,69	0,8	0,03	2	–	●	–	–	–	–	–	–	–	–	–
EDCT180512PDERLDJ	21,77	5,50	10,97	2,29	1,2	0,03	2	–	●	–	–	–	–	–	–	–	–	–
EDCT180516PDERLDJ	21,78	5,50	10,96	1,90	1,6	0,03	2	–	●	–	–	–	–	–	–	–	–	–
EDCT180524PDERLDJ	21,79	5,50	10,93	1,11	2,4	0,03	2	–	●	–	–	–	–	–	–	–	–	–
EDCT180532PDERLDJ	21,79	5,50	10,91	0,32	3,2	0,03	2	–	●	–	–	–	–	–	–	–	–	–
EDCT180564PDERLDJ	18,72	5,50	10,73	–	6,4	0,03	2	–	●	–	–	–	–	–	–	–	–	–

- Heavy roughing applications.
- High feed rates.
- All material groups.
- PSTS — Precision Pressed and Sintered to Size.
- Ap1 max = 14mm.

● first choice
○ alternate choice

P				○		●		●	●		○		
M				●	●	●		○	○	○	●		
K			●	○			●	○					
N	●	●											
S				●	●	●				●	●		
H													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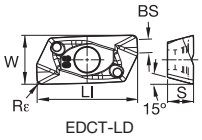
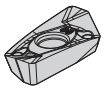


EDCT-LD

EDCT-LD

catalogue number	LI	S	W	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC525M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EDCT180508PDERLD	21,76	5,50	10,97	2,69	0,8	0,05	2	–	–	–	●	–	–	–	–	–	–	–
EDCT180516PDERLD	21,78	5,50	10,96	1,90	1,6	0,05	2	–	–	–	●	–	–	–	–	–	–	–
EDCT180532PDERLD	21,79	5,50	10,91	0,32	3,2	0,05	2	–	–	–	●	–	–	–	–	–	–	–
EDCT180540PDERLD	20,78	5,50	10,87	–	4,0	0,05	2	–	–	–	●	–	–	–	–	–	–	–
EDCT180548PDERLD	20,20	5,50	10,83	–	4,8	0,05	2	–	–	–	●	–	–	–	–	–	–	–
EDCT180564PDERLD	18,72	5,50	10,73	–	6,4	0,05	2	–	–	–	●	–	–	–	–	–	–	–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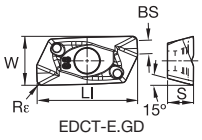
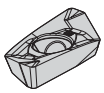


EDCT-E.GD

EDCT-E.GD

catalogue number	LI	S	W	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC525M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EDCT180504PDERGD	21,75	5,50	10,98	3,07	0,4	0,09	2	–	–	–	–	–	●	–	–	●	–	–
EDCT180508PDERGD	21,76	5,50	10,97	2,69	0,8	0,09	2	–	–	–	–	–	●	–	–	●	–	–
EDCT180512PDERGD	21,77	5,50	10,97	2,29	1,2	0,09	2	–	–	–	–	–	●	–	–	●	–	–

- PSTS — Precision Pressed and Sintered to Size.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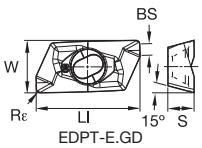
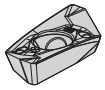


EDPT-E.GD

EDPT-E.GD

catalogue number	LI	S	W	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC525M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EDPT180508PDERGD	21,76	5,50	10,97	2,69	0,8	0,09	2	–	–	●	–	–	●	–	●	●	–	●
EDPT180512PDERGD	21,77	5,50	11,00	2,29	1,2	0,09	2	–	–	–	–	–	●	–	–	●	–	–
EDPT180516PDERGD	21,78	5,50	10,94	1,90	1,6	0,09	2	–	–	–	●	–	●	–	●	●	–	●
EDPT180524PDERGD	21,79	5,50	10,93	1,11	2,4	0,09	2	–	–	–	–	–	●	–	–	–	–	–
EDPT180532PDERGD	21,79	5,50	10,91	0,32	3,2	0,09	2	–	–	●	●	–	●	–	●	–	–	●
EDPT180548PDERGD	20,20	5,50	10,83	–	4,8	0,09	2	–	–	–	–	–	●	–	–	–	–	●
EDPT180564PDERGD	18,79	5,50	10,73	–	6,4	0,09	2	–	–	–	●	–	●	–	●	–	–	●

- Medium roughing and semi-finishing.
- Medium feed rates.
- PSTS — Precision Pressed and Sintered to Size.
- Ap1 max = 18mm.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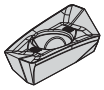
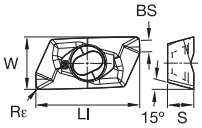

EDPT-S.GE



EDPT-E.HD
EDPT-S.GE

● first choice
○ alternate choice

beyond

P				○		●		●	●		○		
M				●	●	●		○	○	○	●		
K			●	○			●	○					
N	●	●											
S				●	●	●				●	●		
H													

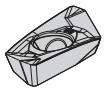
EDPT-E.HD

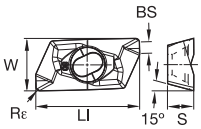
catalogue number	LI	S	W	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC525M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EDPT180508PDERHD	21,77	5,50	10,89	2,69	0,8	0,08	2	–	–	–	–	–	●	–	●	●	–	●
EDPT180512PDERHD	21,77	5,50	10,88	2,29	1,2	0,08	2	–	–	–	–	–	●	–	●	–	–	●
EDPT180516PDERHD	21,78	5,50	10,87	1,90	1,6	0,08	2	–	–	–	–	–	●	–	●	●	–	●
EDPT180532PDERHD	21,79	5,50	10,83	0,31	3,2	0,08	2	–	–	–	–	–	●	–	●	●	–	●
EDPT180540PDERHD	20,92	5,50	10,77	–	4,0	0,08	2	–	–	–	–	–	●	–	–	–	–	●
EDPT180548PDERHD	20,16	5,50	10,75	–	4,8	0,08	2	–	–	–	–	–	●	–	●	–	–	●
EDPT180564PDERHD	18,79	5,50	10,66	–	6,4	0,08	2	–	–	–	–	–	●	–	●	–	–	–

EDPT-S.GE

catalogue number	LI	S	W	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC525M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EDPT180508PDSRGE	21,73	5,45	10,70	2,42	0,8	0,14	2	–	–	–	●	–	●	–	●	–	–	●
EDPT180512PDSRGE	21,77	5,45	10,68	2,00	1,2	0,14	2	–	–	–	●	–	–	–	●	–	–	●
EDPT180516PDSRGE	21,74	5,45	10,66	1,59	1,6	0,14	2	–	–	–	–	–	–	–	–	–	–	●
EDPT180532PDSRGE	21,75	5,45	10,62	0,07	3,2	0,14	2	–	–	–	–	–	–	–	●	–	–	●

- Heavy roughing applications.
- High feed rates.
- All material groups.
- PSTS — Precision Pressed and Sintered to Size.
- Ap1 max = 18mm.


EDPT-S.GD



EDPT-S.GD

EDPT-S.GD

catalogue number	LI	S	W	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC525M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EDPT180508PDSRGD	21,76	5,50	10,90	2,69	0,8	0,15	2	–	–	–	–	–	●	●	●	●	–	●
EDPT180512PDSRGD	21,77	5,50	10,89	2,29	1,2	0,15	2	–	–	–	–	–	●	●	●	●	–	●
EDPT180516PDSRGD	21,78	5,50	10,88	1,90	1,6	0,15	2	–	–	–	–	–	●	–	●	●	–	●
EDPT180532PDSRGD	21,79	5,50	10,83	0,32	3,2	0,15	2	–	–	–	–	–	●	–	●	–	–	●
EDPT180548PDSRGD	20,20	5,49	10,75	–	4,8	0,13	2	–	–	–	–	–	–	–	–	–	–	●
EDPT180564PDSRGD	18,77	5,50	10,64	–	6,4	0,13	2	–	–	–	–	–	●	–	–	–	–	●

Recommended Starting Feeds [mm]

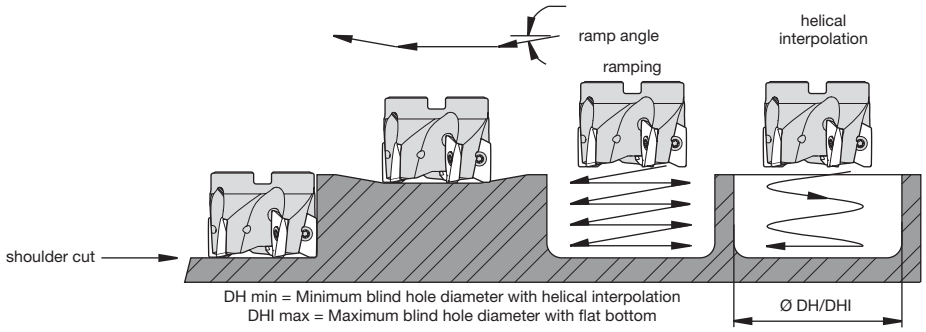
Light Machining	General Purpose	Heavy Machining

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.F..LDJ	0,12	**0,46**	0,82	0,08	**0,33**	0,59	0,06	**0,25**	0,44	0,06	**0,22**	0,38	0,05	**0,20**	0,35	.F..LDJ
.E..LDJ	0,12	**0,45**	0,80	0,08	**0,33**	0,58	0,06	**0,24**	0,43	0,06	**0,21**	0,38	0,05	**0,20**	0,35	.E..LDJ
.E..LD	0,17	**0,47**	0,82	0,12	**0,34**	0,59	0,09	**0,26**	0,44	0,08	**0,22**	0,38	0,07	**0,20**	0,35	.E..LD
.E..GD	0,23	**0,52**	0,89	0,17	**0,37**	0,64	0,13	**0,28**	0,48	0,11	**0,24**	0,42	0,10	**0,22**	0,38	.E..GD
.S..GE	0,23	**0,51**	0,89	0,17	**0,37**	0,64	0,13	**0,27**	0,48	0,11	**0,24**	0,42	0,10	**0,22**	0,38	.S..GE
.S..GD	0,23	**0,51**	0,89	0,17	**0,37**	0,64	0,13	**0,28**	0,48	0,11	**0,24**	0,41	0,10	**0,22**	0,38	.S..GD
.E..HD	0,23	**0,59**	0,95	0,17	**0,43**	0,68	0,13	**0,32**	0,51	0,11	**0,28**	0,44	0,10	**0,25**	0,41	.E..HD

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

Application Data

Application Examples



insert style	cutting diameter	max ramp angle	DH min (min hole diameter)	DHI min (min flat-bottomed hole diameter)	max diameter (no flat bottom)
Mill-1, 18mm	25	17°	29,24	45,84	50
Mill-1, 18mm	32	11°	42,98	59,84	64
Mill-1, 18mm	40	8°	58,92	75,84	80
Mill-1, 18mm	50	5°	78,88	95,84	100
Mill-1, 18mm	63	4°	104,86	121,84	126
Mill-1, 18mm	80	3°	139,02	156,5	160
Mill-1, 18mm	100	2°	179,00	196,5	200
Mill-1, 18mm	125	2°	228,98	246,5	250
Mill-1, 18mm	160	1°	298,98	316,5	320

NOTE: Max ramp angle decreases as nose radius increases.



Carbide Recycling

Help preserve and protect our planet!

It's easy for your company to be environmentally conscious with the Kennametal Carbide Recycling Programme.

By sending us your used carbide tools, you help preserve and protect the environment and ensure that these products are recycled responsibly. Kennametal accepts any coated or non-coated carbide items, including inserts, drills, reamers, and taps.

By using the Kennametal Carbide Recycling Programme, you will receive:

- A partner who cares about a sustainable environment.
- Easy-to-use web portal to value your used carbide.
- Access to our popular Green Box™ options for carbide collection.
- Systematic and efficient disposal of carbide materials.
- Improved profitability.

Programme is not currently available in all geographical areas.
For more information, please visit **kennametal.com/carbiderecycling**.

KENNAMETAL®

kennametal.com

Mill 1-25™

Primary Application

Also known as Mill1 Max, the Mill 1-25 cutter is made specifically for aluminium machining, but can also be used when machining cast iron. High-feed capabilities enable routing applications with an axial depth of cut of up to 25mm.



Features and Benefits

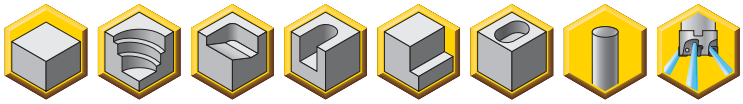
Functions

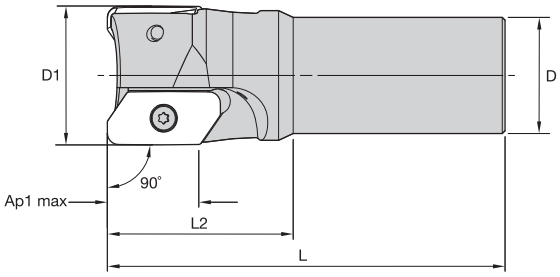
- Strong, thick inserts over 5,2mm thick.
- Axial depth of cut up to 25mm.
- Cylindrical, monoblock/HSK63A, and shell mills.

Benefits

- Made for machining aluminium, but also used for machining cast iron.
- High-feed capability for routing applications.
- Balanced-by-design — if running over 10,000 RPM, balance the cutter assembly.

- Roughing and finishing of aluminium alloys.
- Aggressive ramping angles.
- High-speed capability.
- Ap1 max = 25mm.







Cylindrical End Mills

order number	catalogue number	D1	D	L	L2	Ap1 max	Z	max ramp angle	kg	max RPM
2649569	**40A02R50A32SKE25**	40	32	111	50	25,0	2	15.0°	0,61	24300
2479504	**40A02R80A32SKE25**	40	32	141	80	25,0	2	15.0°	0,86	24300
2649571	**50A02R100A32SKE25**	50	32	161	100	24,9	2	10.0°	1,43	20600
2500741	**50A03R80A32SKE25**	50	32	141	80	24,9	3	10.0°	1,10	20600

NOTE: Standard milling cutters will accept insert nose radii up to 2mm without modification.

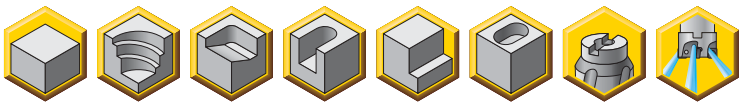
Spare Parts

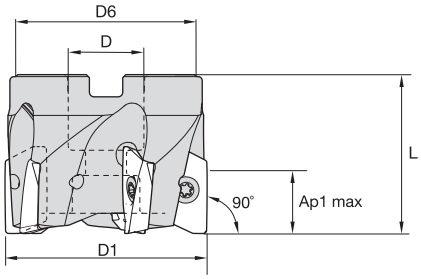


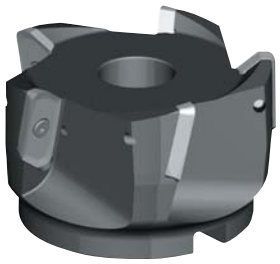


D1	insert screw	Nm	Torx driver
40	**MS1374**	3,9	**DT15**
50	**MS1374**	3,9	**DT15**

- Roughing and finishing of aluminium alloys.
- Aggressive ramping angles.
- High-speed capability.
- Ap1 max = 25mm.
- Insert screws should be changed when inserts are changed.







Shell Mills

order number	catalogue number	D1	D	D6	L	Ap1 max	Z	max ramp angle	kg	max RPM
2878139	**52A02RS90KE25**	52	22	49	58	24,8	2	9.5°	0,50	20000
2954527	**63A02RS90KE25**	63	22	50	55	24,7	2	7.0°	0,69	17600
2954528	**63A03RS90KE25**	63	22	50	55	24,7	3	7.0°	0,59	17600

NOTE: Standard milling cutters will accept insert nose radii up to 2mm without modification.

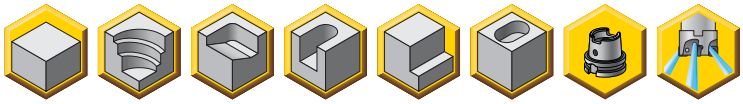
Spare Parts

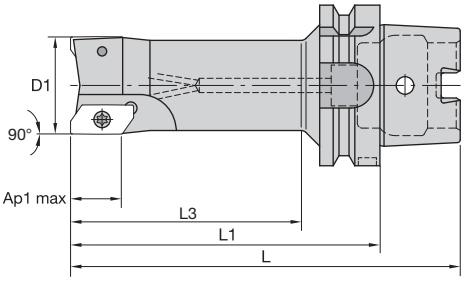





D1	insert screw	Nm	Torx driver	socket-head cap screw with coolant groove
52	**MS1374**	3,9	**DT15**	**MS1235CG**
63	**MS1374**	3,9	**DT15**	**MS1242CG**

- Roughing and finishing of aluminium alloys.
- Aggressive ramping angles.
- All integral shank tools are balanced to G2.5 at 10.000 RPM.
- High-speed capability.
- Ap1 max = 25mm.
- Replace insert screws when inserts are changed.







Monoblocks • HSK63A

order number	catalogue number	shank taper	D1	L	L1	L2	Ap1 max	Z	max ramp angle	kg	max RPM
2880434	**40A02R110S63SKE25**	HSK63A	40	142	110	77,65	25,0	2	15.0°	1,17	24300
2880439	**50A03R140S63SKE25**	HSK63A	50	172	140	114,00	24,9	3	10.0°	1,81	20600

NOTE: Standard milling cutters will accept insert nose radii up to 2mm without modification.

Spare Parts






D1	insert screw	Nm	Torx driver	balancing screw
40	**MS1374**	3,9	**DT15**	**KUAM27**
50	**MS1374**	3,9	**DT15**	**KUAM27**

Insert Selection Guide

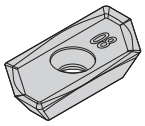
Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		◄——►		toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	–	–	–	–	–	–
P3–P4	–	–	–	–	–	–
P5–P6	–	–	–	–	–	–
M1–M2	–	–	–	–	–	–
M3	–	–	–	–	–	–
K1–K2	–	–	–	–	–	–
K3	–	–	–	–	–	–
N1–N2	.E..LDJ	KC410M	**.E..LDJ**	**KC410M**	.E..LDJ	KC410M
N3	.E..LDJ	KC410M	**.E..LDJ**	**KC410M**	.E..LDJ	KC410M
S1–S2	–	–	–	–	–	–
S3	–	–	–	–	–	–
S4	–	–	–	–	–	–
H1	–	–	–	–	–	–

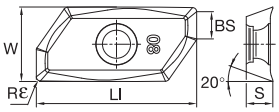
Indexable Inserts • KE...25L5

- Roughing and finishing of aluminium alloys.
- Periphery ground for accuracy and consistency.
- Radiused cutting edge minimises lap lines.
- Wiper facet with large radius for better floor surface finish.
- Ap1 max = 25mm.

● first choice
○ alternate choice

P	
M	
K	
N	●
S	
H	


KEGT-LDJ

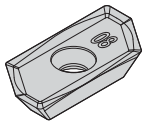


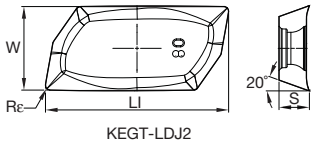
KEGT-LDJ

KEGT-LDJ

catalogue number	LI	S	W	BS	Rε	hm	cutting edges	KC410M
KEGT25L508PEERLDJ	31,39	5,21	14,59	5,34	0,8	0,03	2	●
KEGT25L512PEERLDJ	31,47	5,21	14,60	4,94	1,2	0,03	2	●
KEGT25L516PEERLDJ	31,47	5,21	14,60	4,55	1,6	0,03	2	●
KEGT25L520PEERLDJ	31,47	5,21	14,60	4,15	2,0	0,03	2	●
KEGT25L531PEERLDJ	31,47	5,21	14,60	3,06	3,1	0,03	2	●
KEGT25L540PEERLDJ	31,47	5,21	14,60	2,16	4,0	0,03	2	●
KEGT25L550PEERLDJ	31,47	5,21	14,60	1,14	5,0	0,03	2	●
KEGT25L564PEERLDJ	29,99	5,21	14,60	–	6,4	0,03	2	●

- -LDJ specifically designed for machining aluminium.
- Corner radii range 0,80–6,40mm.


KEGT-LDJ2



KEGT-LDJ2

● first choice
○ alternate choice

P	
M	
K	
N	●
S	
H	

KEGT-LDJ2

catalogue number	LI	S	W	BS	Rε	hm	cutting edges	KC410M
KEGT25L516PEERLDJ2	31,39	5,21	14,59	–	1,6	0,03	2	●

Recommended Starting Feeds

Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.E..LDJ	0,12	**0,56**	1,05	0,08	**0,40**	0,76	0,06	**0,30**	0,56	0,06	**0,26**	0,49	0,05	**0,24**	0,45	.E..LDJ
.E..LDJ2	0,12	**0,56**	1,05	0,08	**0,40**	0,76	0,06	**0,30**	0,56	0,06	**0,26**	0,49	0,05	**0,24**	0,45	.E..LDJ2

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

Stellram® 5720VZ16 Series

Taking extreme high-speed aluminium machining to the highest level.



Features and Benefits

- Specially designed for machining pockets and profiles on aluminium and aluminium alloys.
- The 5720VZ16 series is designed, manufactured, and tested in accordance with EN ISO 15641:2001 to ensure maximum stability in high-speed applications.
- The internal coolant enables better chip evacuation and higher feed rates.
- The pockets are reinforced to enable for heavy feeding and safe ramping during machining. These features increase tool life and productivity.
- Excellent tools for thin-walled machining due to very low cutting pressure.
- Twelve different insert radii are available, each with the same cutting depth capacity of 16mm.
- Cylindrical shank and HSK63A integral shanks are designed and balanced to G6.3 at 30,000 RPM for diameters up to 50mm. Diameter larger than 50mm are balanced to G6.3 at 24,000 RPM.

Monoblock cutters with HSK63A are available as standard in diameters 25, 32, 40, and 50mm.

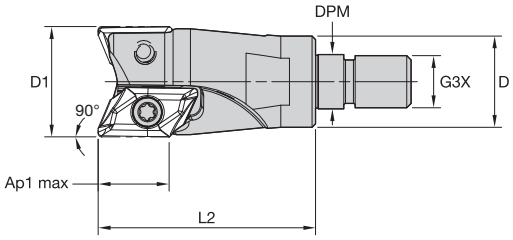
The Stellram® 5720VZ16 cutters are our latest design for high metal removal in aluminium applications.



Maximum ap = 16mm
Diameter Range = 25–80mm

- High-speed profiling and pocketing aluminium alloy components in the aerospace industry.
- Maximum stability in high-speed applications.
- Through-tool coolant allows better chip evacuation and higher feed rates.







Screw-On End Mills

order number	catalogue number	D1	D	DPM	G3X	L2	Ap1 max	Z	max ramp angle	kg	max RPM
5672893	**5720VZ16SA025Z2R50**	25	21	12,50	M12	50	16	2	14.5°	0,12	50000
5672894	**5720VZ16SA032Z2R50**	32	29	17,00	M16	50	16	2	11.4°	0,21	41500
5673238	**5720VZ16SA032Z3R50**	32	29	17,00	M16	50	16	3	11.4°	0,21	41500

NOTE: It is important to change the screw each time the insert is changed to ensure the highest security.
A dynamometric key and the right torque value are important, also.

Spare Parts





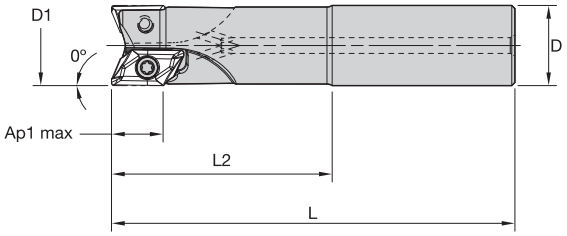


D1	insert screw	Nm	Torx driver
25	**DP5009A**	6,0	**TP20**
32	**DP5009A**	6,0	**TP20**

NOTE: Adjustable torque wrench (order number 6197561) and Torx Plus 20 bit (order number 6205891) may be purchased separately in order to ensure proper torque setting.

- High-speed profiling and pocketing aluminium alloy components in the aerospace industry.
- Maximum stability in high-speed applications.
- Through-tool coolant allows better chip evacuation and higher feed rates.







Cylindrical End Mills

order number	catalogue number	D1	D	L	L2	Ap1 max	Z	max ramp angle	kg	max RPM
5672892	**5720VZ16CA025Z2R75**	25	25	131	75	16	2	14.5°	0,41	50000
5672271	**5720VZ16CA032Z2R75**	32	32	135	75	16	2	11.4°	0,71	41500
5681115	**5720VZ16CA032Z3R75**	32	32	135	75	16	3	11.4°	0,64	41500

NOTE: It is important to change the screw each time the insert is changed to ensure the highest security. A dynamometric key and the right torque value are important, also.

Spare Parts





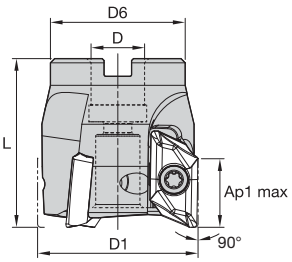


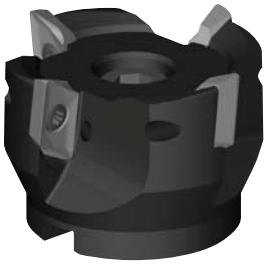
D1	insert screw	Nm	Torx driver
25	**DP5009A**	6,0	**TP20**
32	**DP5009A**	6,0	**TP20**

NOTE: Adjustable torque wrench (order number 6197561) and Torx Plus 20 bit (order number 6205891) may be purchased separately in order to ensure proper torque setting.

- High-speed profiling and pocketing aluminium alloy components in the aerospace industry.
- Maximum stability in high-speed applications.
- Through-tool coolant allows better chip evacuation and higher feed rates.







Shell Mills • Coarse and Medium Pitch

order number	catalogue number	D1	D	D6	L	Ap1 max	Z	max ramp angle	kg	max RPM
5673490	**5720VZ16-A040Z3R**	40	16	32	45	16	3	7.6°	0,21	36500
5672869	**5720VZ16-A050Z03R**	50	22	45	45	16	3	7.9°	0,35	30000
5673174	**5720VZ16-A050Z04R**	50	22	45	45	16	4	7.9°	0,28	30000
5672870	**5720VZ16-A063Z4R**	63	22	50	45	16	4	5.9°	0,52	26000
5673528	**5720VZ16-A063Z5R**	63	22	50	45	16	5	5.9°	0,48	26000
5673616	**5720VZ16-A080Z04R**	80	27	55	50	16	4	4.4°	0,91	23000
5673316	**5720VZ16-A080Z5R**	80	27	55	50	16	5	4.4°	0,85	23000

NOTE: It is important to change the screw each time the insert is changed to ensure the highest security. A dynamometric key and the right torque value are important, also.

Spare Parts



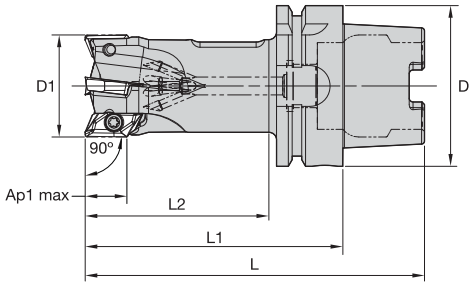



D1	insert screw	Nm	Torx driver	socket-head cap screw
40	**DP5009A**	6,0	**TP20**	**M8 1.25 X 25 SHCS**
50	**DP5009A**	6,0	**TP20**	**M10 1.5 X 25 SHCS**
63	**DP5009A**	6,0	**TP20**	**M10 1.5 X 25 SHCS**
80	**DP5009A**	6,0	**TP20**	**M12 X 1.75 X 30 SHCS**

NOTE: Adjustable torque wrench (order number 6197561) and Torx Plus 20 bit (order number 6205891) may be purchased separately in order to ensure proper torque setting.

- Providing solutions for the aerospace and aluminium industries' requirements for high-power and high-speed spindles.
- Specifically reinforced for highest metal removal rates for depths of cut ≤16mm.
- Locking system ensures operation safety and accuracy.
- Thin-walled machining for airframe components.







Monoblocks • HSK63A

order number	catalogue number	D1	D	L	L1	L2	Ap1 max	Z	max ramp angle	kg	max RPM*
6087904	**5720VZ16HA025Z2R75**	25	63	133	101	75	16	2	14.5°	0,81	51000
5672766	**5720VZ16HA032Z3R75**	32	63	133	101	75	16	3	11.4°	0,92	41500
5673629	**5720VZ16HA040Z4R75**	40	63	133	101	75	16	4	7.8°	1,09	35000
6160117	**5720VZ16HA050Z4R75**	50	63	133	101	75	16	4	7.9°	1,41	30000

*Max RPM as per ISO 15641
NOTE: It is important to change the screw each time the insert is changed to ensure the highest security. A dynamometric key and the right torque value are important, also.

Spare Parts







insert screw	Nm	driver
DP5009A	6,0	**TP20**

NOTE: Adjustable torque wrench (order number 6197561) and Torx Plus 20 bit (order number 6205891) may be purchased separately in order to ensure proper torque setting.

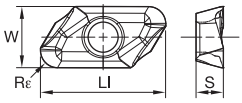
Insert Selection Guide

Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		⟷		toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	–	–	–	–	–	–
P3–P4	–	–	–	–	–	–
P5–P6	–	–	–	–	–	–
M1–M2	–	–	–	–	–	–
M3	–	–	–	–	–	–
K1–K2	–	–	–	–	–	–
K3	–	–	–	–	–	–
N1–N2	.F..721	GH1	**.F..721**	**GH1**	.F..721	GH1
N3	.F..721	GH1	**.F..721**	**GH1**	.F..721	GH1
S1–S2	–	–	–	–	–	–
S3	–	–	–	–	–	–
S4	–	–	–	–	–	–
H1	–	–	–	–	–	–

Milling Inserts


ZDET-FR721


ZDET-ER721



ZDET-FR721
ZDET-ER721

● first choice
○ alternate choice

P		
M		
K		○
N		●
S		
H		

ZDET-FR721 • Sharp edge preparation for finishing applications.

catalogue number	LI	W	S	Resultant WorkPiece Radius mm	hm	cutting edges	GH1
ZDET16M5PDFR721	22,92	11,25	5,00	0,3	0,02	2	●
ZDET16M504FR721	23,02	11,25	5,00	0,4	0,02	2	●
ZDET16M508FR721	23,02	11,25	5,00	0,8	0,02	2	●
ZDET16M512FR721	23,02	11,25	5,00	1,2	0,02	2	●
ZDET16M516FR721	23,02	11,25	5,00	1,6	0,02	2	●
ZDET16M520FR721	23,02	11,25	5,00	2,0	0,02	2	●
ZDET16M525FR721	23,02	11,25	5,00	2,5	0,02	2	●
ZDET16M530FR721	23,02	11,25	5,00	3,0	0,02	2	●
ZDET16M532FR721	23,02	11,25	5,00	3,2	0,02	2	●
ZDET16M540FR721	23,02	11,25	5,00	4,0	0,02	2	●
ZDET16M550FR721	23,02	11,25	5,00	5,0	0,02	2	●
ZDET16M560FR721	23,02	11,25	5,00	6,0	0,02	2	●

ZDET-ER721 • Honed edge preparation for roughing applications. Apply under unstable conditions.

catalogue number	LI	W	S	Resultant WorkPiece Radius mm	hm	cutting edges	GH1
ZDET16M525ER721	23,02	11,25	5,00	2,5	0,03	2	●
ZDET16M530ER721	23,02	11,25	5,00	3,0	0,03	2	●
ZDET16M540ER721	23,02	11,25	5,00	4,0	0,03	2	●

NOTE: Inserts will be delivered with two screws. Because of heavy force to the screw, it is important to change the screw when changing the insert.

Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
...FR721	0,12	**0,51**	0,93	0,08	**0,37**	0,67	0,06	**0,28**	0,50	0,06	0,24	0,44	0,05	**0,22**	0,40	...FR721
...ER721	0,12	**0,51**	0,93	0,08	**0,37**	0,67	0,06	**0,28**	0,50	0,06	0,24	0,44	0,05	**0,22**	0,40	...ER721

NOTE: Use “Light Machining” values as starting feed rate.
% = ae/Dc * 100 (ae = radial depth of cut, Dc = cutting diameter)
Please see pages X22–X37 for recommended starting speeds.

5720VZ16 Ramp Angle

cutter diameter	Insert ZDET16M5...721								
	PDFR–R1,20	R1,60	R2,00	R2,50	R3,00	R3,20	R4,00	R5,00	R6,00
25,0	14,50	17,30	9,40	9,60	18,80	18,90	9,00	11,20	7,30
32,0	11,40	11,90	11,90	12,20	12,40	12,40	13,10	13,80	13,40
40,0	7,60	7,80	7,80	8,00	8,10	8,10	8,50	8,80	9,10
50,0	7,90	7,20	7,30	7,90	7,60	7,60	8,90	9,00	9,25
63,0	5,90	5,40	5,50	5,80	5,60	5,60	6,90	6,60	6,65
80,0	4,40	4,00	4,10	4,30	4,20	4,20	5,10	4,80	4,90

5720VZ16 Possible Maximum ap Slotting

Possible Max ap Slotting		
diameter	number of inserts	ap max
25	2	7,50
32	2	11,00
32	3	6,00
40	3	9,00
50	3	11,00
50	4	9,00
63	4	11,00
63	5	9,00
80	4	11,00
80	5	11,00

NOTE: Ap max depending on:
Cutter diameter, rigidity of the cutter, rigidity of the machine, and size of the flute.

5720VZ16 Possible Metal Removal

Possible Metal Removal Calculated with 24,000 RPM		
cutter diameter	ZU	Q cm^3/min
25	2	1560
32	2	3226
32	3	2056
40	3	5184
50	3	7921
50	4	8641
63	4	13307
63	5	13609
80	4	16898
80	5	21123

NOTE: The chart above shows total metal removal capacity (based on 24,000 RPM) by cutter diameter and number of teeth.
The maximum RPM is engraved on the cutter bodies.

Machinability by Materials • Aluminium

Alloy Group	Alloy Designation	Chemical Composition Limits (WT%)											
		Cu	Si	Fe	Mn	Mg	Zn	Cr	Ti	Pb	Bi	Al	Others
Al	1050	0.05	0.25	0.40	0.50	0.05	0.05	–	–	–	–	99.50min	–
	1100	0.05–0.20	Si+Fe 1.00 max	–	0.05	–	0.10	–	–	–	–	99.00min	–
AlCu	2011	5.00–6.00	0.40	0.70	–	–	0.30	–	–	0.20	0.60	remaining	–
	2014	3.90–5.00	0.50–1.20	0.70	0.40–1.20	0.20–0.80	0.25	0.10	0.15	–	–	remaining	–
	2017	3.50–4.50	0.20–0.80	0.70	0.40–1.00	0.40–0.80	0.25	0.10	0.15	–	–	remaining	–
	2024	3.80–4.90	0.50	0.50	0.30–0.90	1.20–1.80	0.25	0.10	0.15	–	–	remaining	–
	2218	3.50–4.50	0.90	1	0.20	1.20–1.80	0.25	0.10	–	–	–	remaining	Ni1.7–2.3
	2224	3.80–4.40	0.12	0.15	0.30–0.90	1.20–1.80	0.25	0.10	0.15	–	–	remaining	–
AlMn	3003	0.05–0.20	0.60	0.70	1.00–1.50	–	0.10	–	–	–	–	remaining	–
AlSi	4032	0.50–1.30	11.00–13.50	1	–	0.80–1.30	0.25	0.10	–	–	–	remaining	Ni0.5–1.3
AlMg	5052	0.10	0.25	0.40	0.10	2.20–2.80	0.10	0.15–0.35	–	–	–	remaining	–
	–	–	–	–	–	–	–	–	–	–	–	–	H34
	5056	0.10	0.30	0.40	0.05–0.20	4.50–5.60	0.10	0.05–0.20	–	–	–	remaining	–
	–	–	–	–	–	–	–	–	–	–	–	–	H32
	5083	0.10	0.40	0.40	0.40–1.00	4.00–4.90	0.25	0.05–0.25	0.15	–	–	remaining	–
	5086	0.10	0.40	0.50	0.20–0.70	3.50–4.50	0.25	0.05–0.25	0.15	–	–	remaining	–
	–	–	–	–	–	–	–	–	–	–	–	–	H116
AlMgSi	6061	0.15–0.40	0.40–0.80	0.70	0.15	0.80–1.20	0.25	0.04–0.35	0.15	–	–	remaining	–
	6063	0.10	0.20–0.60	0.35	0.10	0.45–0.90	0.10	0.10	0.10	–	–	remaining	–
	6070	0.15–0.40	1.00–1.70	0.50	0.40–1.00	0.50–1.20	0.25	0.10	0.15	–	–	remaining	–
	6151	0.35	0.60–1.20	1	0.20	0.45–0.80	0.25	0.15–0.35	0.15	–	–	remaining	–
	6262	0.15–0.40	0.40–0.80	0.70	0.15	0.80–1.20	0.25	0.04–0.14	0.15	0.40	0.70	remaining	–
	6351	0.10	0.70–1.30	0.50	0.40–0.80	0.40–0.80	0.20	–	0.20	–	–	remaining	–
	6463	0.20	0.20–0.60	0.15	0.05	0.45–0.90	0.05	–	–	–	–	remaining	–
AlZn	7001	1.60–2.60	0.35	0.40	0.20	2.60–3.40	6.80–8.00	0.18–0.35	0.20	–	–	remaining	–
	7003	0.20	0.30	0.35	0.30	0.50–1.00	5.00–6.50	0.20	0.20	–	–	remaining	Zr0.05–0.25
	7050	2.00–2.60	0.12	0.15	0.10	1.90–2.60	5.70–6.70	0.04	0.06	–	–	remaining	Zr0.08–0.15
	7075	1.20–2.00	0.40	0.50	0.30	2.10–2.90	5.10–6.10	0.18–0.28	0.20	–	–	remaining	–
	7178	1.60–2.40	0.40	0.50	0.30	2.40–3.10	6.30–7.30	0.18–0.35	0.20	–	–	remaining	–
	7475	1.20–1.90	0.10	0.12	0.06	1.90–2.60	5.20–6.20	0.18–0.25	0.06	–	–	remaining	–

(continued)

Machinability

A Excellent
B Good-to-Excellent
C Good
D Not Good

$Vc = \pi \times D \times n/1000$ m/min = mm x RPM

D: Tool diameter, N: RPM, Vc: Cutting speed, $\pi = 3.1416$

Choose a cutting speed in the range of values, compatible with the cutter max rotation capacity (engraved on the body) and your spindle stability.

(Machinability by Materials • Aluminium — continued)

	Typical Tremper	Rm (Mpa)	Machinability Chip Formation	Machinability	Typical Applications	vc m/min min–max	fz mm/Z max
	H14	105	D	A	• Chemical equipment. • Sheet metal work. • Coiled tube.	600–3000	0,2
	H14	90	D	A			
	T3	310	A	A	• Screw machine products. • Tuck frame. • Aircraft structure. • Jet engine impellers. • Aircraft engine • Cylinder heads.	400–2500	0,25
	T6	430	B	A			
	T4	390	B	A			
	T4	465	B	A			
	T72	331	B	B			
	–	–	A	A			
	H14	140	D	B	• Cooking utensils. • Chemical equipment.	200–2500	0,20
	T6	379	B	D	• Pistons.	200–1000	0,18
	H14	260	C	A	• Architectural. • Cable sheeting. • Welded pressure vessels. • Hydraulic tubes. • Transportation equipment.	400–3000	0,25
	–	–	–	–			
	H12	300	C	A			
	–	–	–	–			
	H112	335	C	A			
	H32	300	C	A			
	–	–	–	–			
	T6	300	C	B	• Heavy-duty structure. • Furniture. • Architectural. • Heavy-duty welded structure. • Pipeline. • Heat sink.	400–2500	0,20
	T5	200	C	B			
	T6	379	C	C			
	T6	–	C	C			
	T9	400	B	B			
	T6	310	D	C			
	T6	241	C	B			
	O	–	B	A	• High-strength structure. • Aircraft structure.	400–3000	0,25
	T5	400	B	A			
	T73	530	B	A			
	T6	570	B	A			
	T6	600	B	A			
	T61	565	B	A			

Recommendations for High Speed Machining at 8,000 RPM or above

- Check spindle condition:
  - Runout
  - Clamping of the attachment in traction
  - Marking and cleanliness
- Check that the tool is suitable for the required use.
- Inserts must be locked positively in the pocket and secured using the torx screw provided. The screw must be torqued to the correct value as indicated in the charts on the product pages.
- Because of heavy force to the screw, it is important to change the screw when changing the insert.
- Check the balancing of the assembled tool: cutter body, inserts, and attachment.
- Before start up, note the maximum RPM engraved on the tool. The maximum RPM is linked to a precise balancing value.
- Ensure that the field of application of the tool shown in our technical documents and technological parameters is observed:

A_e (mm)	width of cut, lateral engagement (radial)
a_p (mm)	Axial depth of cut
f_z (mm/tooth)	Feed per tooth
n (RPM)	revolutions per minute

Kennametal cannot accept responsibility for misuse of this product due to:

- Non-observance of the above instructions
- Machine without casing
- Incorrect clamping of workpieces
- No safety device on the machine
- Any misuse or incorrect clamping

The optimum rotation must be determined by condition of the spindle.
The spindle must be rigid to run at these higher RPMs.

Under no circumstances must any attempt be made to repair this tool.
The only permitted maintenance is the indexing or replacement of the inserts.

When assembling the cutter to a Shrink Fit holder, the maximum protrusion cannot exceed 10% of the reach of tool.

Balancing:

- Cylindrical shank and HSK63A integral shanks are designed and balanced to G6.3 at 30,000 RPM for diameters up to 50mm. Diameter larger than 50mm are balanced to G6.3 at 24,000 RPM.
- Cylindrical shank tools mounted in a Shrink Fit holder or any other chuck mill holder + inserts + screws must be re-inspected for balance as an assembly by the end-user when at or exceeding 8,000 RPM. End-user must balance the assembly at a G6.3 at 30,000 RPM maximum.
- Shell mill and modular head cutters are not balanced. These tools must be re-inspected for balance as an assembly, cutter + inserts + screws, by the end-user for high speed machining at 8,000 RPM or above. End-user must balance the assembly at a G6.3 value minimum.
- Balancing requires removing some material by drilling or milling operations. To avoid making modular heads weaker, limit these operations by avoiding high RPM. It is not recommended to remove material by drilling operation.
- For each new modular head added to the same extension, re-balance the assembly. For each new shell mill installed on the same toolholder, re-balance the assembly.

Tighten the modular head to the extension; with lubricant, apply the torque value of:

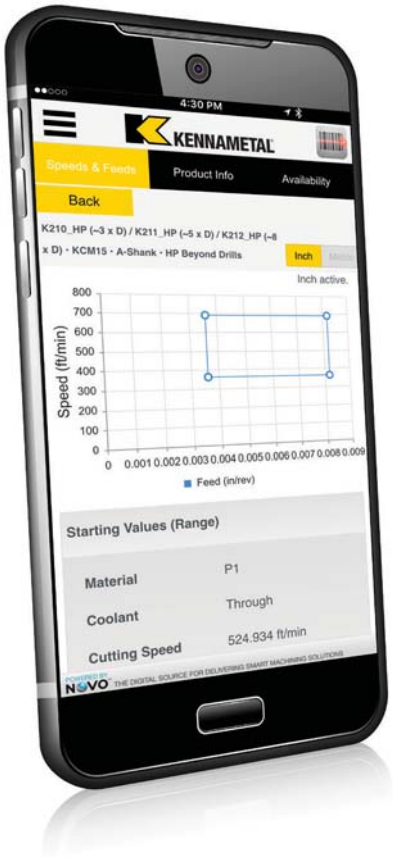
Thread sizes (mm)	Torque Values Nm
M6	10
M8	30
M10	50
M12	80
M16	110

Tighten the bolt between the shell mill and toolholder; with lubricant, apply the torque value of:

Thread sizes (mm)	Cutter Bore Size (mm)	Torque Values Nm
M6	13	10
M8	16	30
M10	22	50
M12	27	80
M16	32	110
M20	40	120

Mobile App

The Kennametal mobile app makes it easy to access product information, calculators, and much more from iPhone® and Android™ devices.



FEATURES

Scan a Kennametal tool package barcode or search a product catalogue number to access complete product information.

Product information includes tool image, dimensions, grades, and product highlights.

View product availability at global locations.

Get speed and feed information in inch and metric values for all metalcutting products.

View tech tips for helpful solutions to common machining questions.

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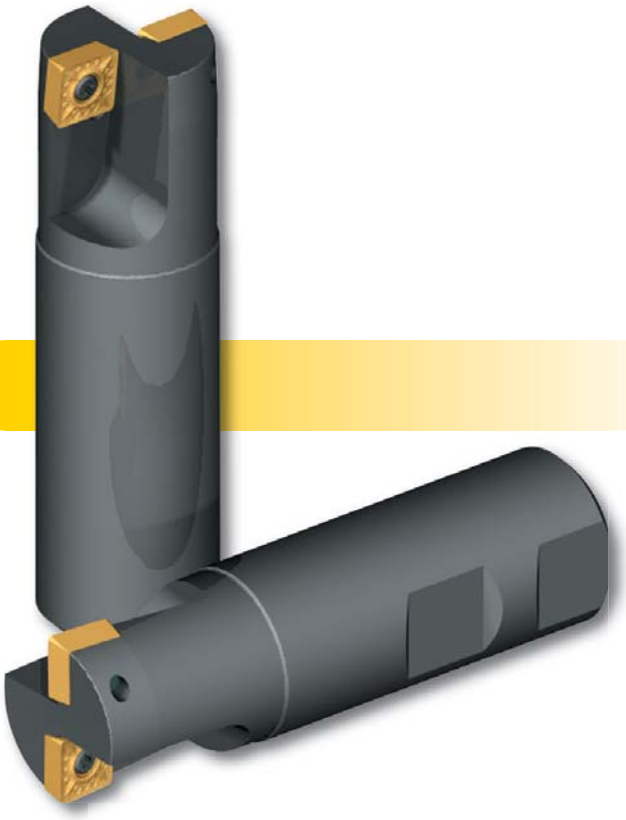
KSSM™ Platform

Primary Application

The Kennametal KSSM platform is a versatile solution providing three insert sizes that cover a wide range of applications: face milling, shoulder milling, slotting, profiling, and Z-axis (plunge milling).



Features and Benefits

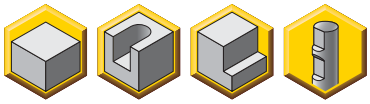
KSSM IC 10 Inserts

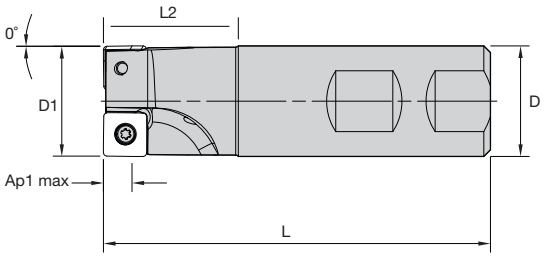
- Four cutting edges.
- Excellent surface finishes.
- Low power requirements.

KSSM IC 12 Inserts

- Four cutting edges.
- Excellent surface finishes.
- Low power requirements.
- Increased depth of cut.

- Mill 90° walls.
- Excellent surface finishes.
- Low power requirements.
- Four cutting edges per insert.







Weldon® End Mills

order number	catalogue number	D1	D	L	L2	Ap1 max	Z	kg	max RPM
1981679	**25A02R039B25SSP10G**	25	25	96	39	6,6	2	0,30	37100
1981788	**32A03R039B32SSP10G**	32	32	100	39	6,6	3	0,50	33200
1981790	**40A04R049B32SSP10G**	40	32	110	49	6,6	4	0,70	30300

NOTE: Standard milling cutters will accept insert nose radii up to 2mm without modification.

Spare Parts

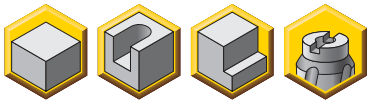


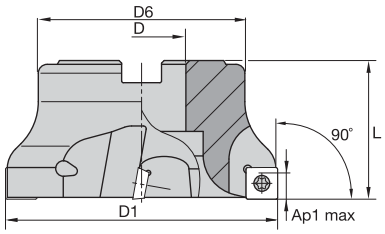




D1	insert screw	Nm	Torx Plus driver
25	**MS2148**	1,5	**DT9IP**
32	**MS2148**	1,5	**DT9IP**
40	**MS2148**	1,5	**DT9IP**

- Mill 90° walls.
- Excellent surface finishes.
- Low power requirements.
- Four cutting edges per insert.







Shell Mills

order number	catalogue number	D1	D	D6	L	Ap1 max	Z	kg	max RPM
1981677	**50A05RS90SP10DG**	50	22	47	40	6,6	5	0,40	26300
1981678	**63A06RS90SP10DG**	63	22	50	40	6,6	6	0,50	23500
1981853	**80A08RS90SP10DG**	80	27	60	50	6,6	8	1,10	21450
1981854	**100B10RS90SP10DG**	100	32	80	50	6,6	10	1,70	18600

NOTE: Standard milling cutters will accept insert nose radii up to 2mm without modification.

Spare Parts






D1	insert screw	Nm	Torx Plus driver	mounting screw
50	**MS2148**	1,5	**DT9IP**	**–**
63	**MS2148**	1,5	**DT9IP**	**–**
80	**MS2148**	1,5	**DT9IP**	**MS1556**
100	**MS2148**	1,5	**DT9IP**	**–**

Insert Selection Guide

Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		←	→	toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.E..LD2	KCPM40	**.E..GB2**	**KCPM40**	.S..GB2	KCPK30
P3–P4	.E..LD2	KCPM40	**.E..GB2**	**KCPK30**	.S..GB2	KCPK30
P5–P6	.E..LD2	KC725M	**.E..GB2**	**KC725M**	.S..GB2	KC725M
M1–M2	.E..LD2	KC725M	**.E..GB2**	**KC725M**	.S..GB2	KC725M
M3	.E..LD2	KCPM40	**.E..GB2**	**KCPM40**	.S..GB2	KC725M
K1–K2	.E..LD2	KC520M	**.E..GB2**	**KCK15**	.S..GB2	KCK15
K3	.E..LD2	KC520M	**.E..GB2**	**KC520M**	.S..GB2	KC520M
N1–N2	.F..LE	KC410M	**.F..LE**	**KC410M**	.F..LD	KC510M
N3	.F..LE	KC410M	**.F..LE**	**KC410M**	.F..LE	KC410M
S1–S2	.E..LD2	KC725M	**.E..GB2**	**KC725M**	.S..GB2	KC725M
S3	.E..LD2	KCPM40	**.E..GB2**	**KCPM40**	.S..GB2	KC725M
S4	.E..LD2	KC725M	**.E..GB2**	**KC725M**	.S..GB2	KC725M
H1	.F..LD	KC510M	–	–	–	–

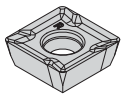
Indexable Inserts • SP.T10T3

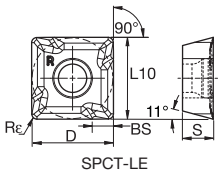
- Aluminium workpiece materials.
- Precision ground.
- 20° rake face.
- Four cutting edges.

beyond

● first choice
○ alternate choice

	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40	KTPK20	KY3500
P			○	●		●	●		○		
M			●	●		○	○	○	●		
K		●	○		●	○				●	●
N	●		○								
S			●	●				●	●		
H			○								


SPCT-LE

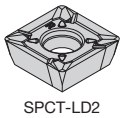


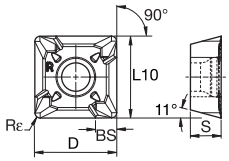
SPCT-LE

SPCT-LE

catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40	KTPK20	KY3500
SPCT10T304PPFLLE	10,00	3,97	10,00	2,70	0,4	0,02	4	●	–	–	–	–	–	–	–	–	–	–
SPCT10T304PPFRLE	10,00	3,97	10,00	2,70	0,4	0,02	4	●	–	–	–	–	–	–	–	–	–	–
SPCT10T3PPFLLE	10,00	3,97	10,00	2,70	0,8	0,02	4	●	–	–	–	–	–	–	–	–	–	–
SPCT10T3PPFRLE	10,00	3,97	10,00	2,70	0,8	0,02	4	●	–	–	–	–	–	–	–	–	–	–
SPCT10T312PPFRLE	10,00	3,97	10,00	2,70	1,2	0,02	4	●	–	–	–	–	–	–	–	–	–	–
SPCT10T320FNLE	10,00	3,97	10,00	–	2,0	0,02	4	●	–	–	–	–	–	–	–	–	–	–

- Light and finish machining.
- Precision ground.
- 15° rake face.
- Four cutting edges.


SPCT-LD2



SPCT-LD2

beyond

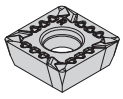
P			○	●		●	●		○			
M			●	●		○	○	○	●			
K		●	○		●	○				●	●	
N	●		○									
S			●	●				●	●			
H			○									

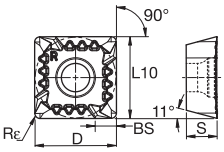
● first choice
○ alternate choice

SPCT-LD2

catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40	KTPK20	KY3500
SPCT10T304PPELLD2	10,00	3,97	10,00	2,70	0,4	0,04	4	–	–	–	●	–	–	–	–	–	–	–
SPCT10T304PPERLD2	10,00	3,97	10,00	2,70	0,4	0,04	4	–	–	–	●	–	–	–	–	–	–	–
SPCT10T3PPELLD2	10,00	3,97	10,00	2,70	0,8	0,04	4	–	–	–	●	–	–	–	–	–	–	–
SPCT10T3PPERLD2	10,00	3,97	10,00	2,70	0,8	0,04	4	–	●	–	●	–	–	●	–	–	–	–
SPCT10T312PPELLD2	10,00	3,97	10,00	2,70	1,2	0,04	4	–	–	–	●	–	–	–	–	–	–	–
SPCT10T312PPERLD2	10,00	3,97	10,00	2,70	1,2	0,04	4	–	–	–	●	–	–	–	–	–	–	–
SPCT10T316ENLD2	10,00	3,97	10,00	–	1,6	0,04	4	–	–	–	●	–	–	–	●	–	–	–
SPCT10T320ENLD2	10,00	3,97	10,00	–	2,0	0,04	4	–	–	–	●	–	–	–	–	–	–	–

- Medium machining.
- Precision ground.
- 5° rake face.
- Four cutting edges.


SPET-GB2

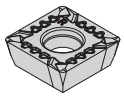


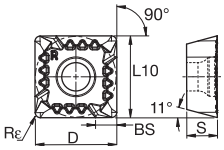
SPET-GB2

SPET-GB2

catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40	KTPK20	KY3500
SPET10T304PPELGB2	10,00	3,97	10,00	2,70	0,4	0,08	4	–	–	–	●	●	●	–	–	–	–	–
SPET10T304PPERGB2	10,00	3,97	10,00	2,70	0,4	0,08	4	–	–	–	●	●	●	–	–	–	–	–
SPET10T3PPELGB2	10,00	3,97	10,00	2,70	0,8	0,08	4	–	●	–	●	●	●	–	–	–	–	–
SPET10T3PPERGB2	10,00	3,97	10,00	2,70	0,8	0,08	4	–	●	–	●	●	●	●	–	–	–	–
SPET10T3PPSLGB2	10,00	3,97	10,00	2,70	0,8	0,13	4	–	–	–	●	–	●	–	–	–	–	–
SPET10T3PPSRGB2	10,00	3,97	10,00	2,70	0,8	0,13	4	–	●	–	●	●	●	–	–	–	–	–

- Medium machining.
- PSTS — Precision Pressed and Sintered to Size.
- 5° rake face.
- Four cutting edges.


SPPT-GB2



SPPT-GB2

● first choice
○ alternate choice

beyond

	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40	KTPK20	KY3500
P			○	●		●	●		○		
M			●	●		○	○	○	●		
K		●	○		●	○				●	●
N	●		○								
S			●	●				●	●		
H			○								

SPPT-GB2

catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40	KTPK20	KY3500
SPPT10T3PPERGB2	10,00	3,97	10,00	2,70	0,8	0,08	4	–	–	–	–	●	●	–	–	–	–	–
SPPT10T3PPSRGB2	10,00	3,97	10,00	2,70	0,8	0,13	4	–	–	–	–	●	●	–	–	–	●	–

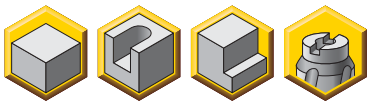
Recommended Starting Feeds [mm]

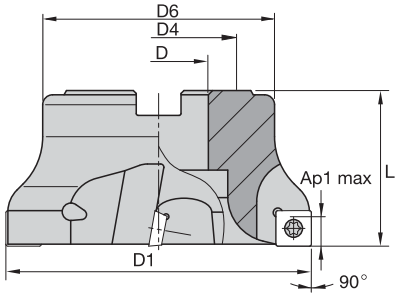
Light Machining	General Purpose	Heavy Machining

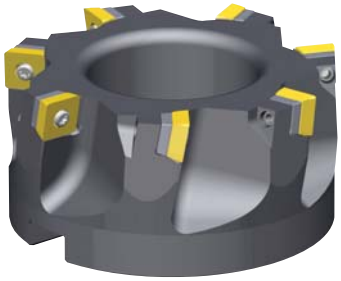
Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.F..LE	0,12	**0,42**	0,70	0,08	**0,30**	0,50	0,06	**0,23**	0,38	0,06	**0,20**	0,33	0,05	**0,18**	0,30	.F..LE
.F..LD	0,12	**0,42**	0,70	0,08	**0,30**	0,50	0,06	**0,23**	0,38	0,06	**0,20**	0,33	0,05	**0,18**	0,30	.F..LD
.E..LD2	0,12	**0,46**	0,81	0,09	**0,33**	0,58	0,07	**0,25**	0,43	0,06	**0,22**	0,38	0,05	**0,20**	0,35	.E..LD2
.E..LD	0,17	**0,47**	0,82	0,12	**0,34**	0,59	0,09	**0,26**	0,44	0,08	**0,22**	0,38	0,07	**0,20**	0,35	.E..LD
.E..GB2	0,23	**0,53**	0,89	0,17	**0,38**	0,64	0,13	**0,29**	0,48	0,11	**0,25**	0,41	0,10	**0,23**	0,38	.E..GB2
.S..GB	0,23	**0,59**	0,95	0,17	**0,43**	0,68	0,13	**0,32**	0,51	0,11	**0,28**	0,44	0,10	**0,25**	0,41	.S..GB
.S..GB2	0,23	**0,59**	0,95	0,17	**0,43**	0,68	0,13	**0,32**	0,51	0,11	**0,28**	0,44	0,10	**0,25**	0,41	.S..GB2
.S..GN	0,23	**0,59**	0,95	0,17	**0,43**	0,68	0,13	**0,32**	0,51	0,11	**0,28**	0,44	0,10	**0,25**	0,41	.S..GN

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

- Mill 90° walls.
- Excellent surface finishes.
- Low power requirements.
- Four cutting edges per insert.







Shell Mills

order number	catalogue number	D1	D	D4	D6	L	Ap1 max	Z	kg	max RPM
1926939	**50A03RS90SD12DG**	50	22	–	45	40	9,2	3	0,30	20600
1926938	**50A04RS90SD12DG**	50	22	–	46	40	9,2	4	0,30	20600
1926936	**63A04RS90SD12DG**	63	22	–	50	40	9,2	4	0,50	18300
1926933	**63A05RS90SD12DG**	63	22	–	50	40	9,2	5	0,50	18300
1926901	**80A05RS90SD12DG**	80	27	–	60	50	9,2	5	1,00	16300
1926898	**80A06RS90SD12DG**	80	27	–	60	50	9,2	6	1,00	16300
1926841	**100B06RS90SD12DG**	100	32	–	80	50	9,2	6	1,60	14600
1926840	**100B08RS90SD12DG**	100	32	–	80	50	9,2	8	1,70	14600
1926839	**125B07RS90SD12DG**	125	40	–	90	63	9,2	7	2,80	13000
1926837	**125B10RS90SD12DG**	125	40	–	90	63	9,2	10	2,90	13000
1926836	**160C08RS90SD12DG**	160	40	67	100	63	9,2	8	4,30	11500
1926983	**160C12RS90SD12DG**	160	40	67	100	63	9,2	12	4,40	11500
1926942	**200C11RS90SD12DG**	200	60	102	130	63	9,2	11	6,80	10300
1926941	**200C14RS90SD12DG**	200	60	102	130	63	9,2	14	6,83	10300

NOTE: Standard milling cutters will accept insert nose radii up to 2mm without modification.

Spare Parts










D1	insert screw	Nm	Torx Plus driver	shim	shim screw	hex driver	low-head cap screw	socket-head cap screw
50	**MS2078**	4,0	**DT15IP**	–	–	–	–	–
63	**MS2078**	4,0	**DT15IP**	–	–	–	**129.025**	–
80	**MS2078**	4,0	**DT15IP**	**SM449**	**SRS3**	**DH35M**	–	**MS2038**
100	**MS2078**	4,0	**DT15IP**	**SM449**	**SRS3**	**DH35M**	–	–
125	**MS2078**	4,0	**DT15IP**	**SM449**	**SRS3**	**DH35M**	–	–
160	**MS2078**	4,0	**DT15IP**	**SM449**	**SRS3**	**DH35M**	–	–
200	**MS2078**	4,0	**DT15IP**	**SM449**	**SRS3**	**DH35M**	–	–

Insert Selection Guide

Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		◄———	———►	toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.E..LD2	KCPM40	**.E..GB2**	**KCPM40**	.S..GB2	KCPM40
P3–P4	.E..LD2	KCPM40	**.E..GB2**	**KCPK30**	.S..GB2	KCPK30
P5–P6	.E..LD2	KC725M	**.E..GB2**	**KC725M**	.S..GB2	KC725M
M1–M2	.E..LD2	KCSM40	**.E..GB2**	**KCSM40**	.S..GB2	KCSM40
M3	.E..LD2	KCPM40	**.E..GB2**	**KCPM40**	.S..GB2	KCPM40
K1–K2	.E..LD2	KC520M	**.E..GB2**	**KCK15**	.S..GB2	KCK15
K3	.E..LD2	KC520M	**.E..GB2**	**KC520M**	.S..GB2	KC520M
N1–N2	.F..LE	KC410M	**.F..LE**	**KC410M**	.F..LE	KC410M
N3	.F..LE	KC410M	**.F..LE**	**KC410M**	.F..LE	KC410M
S1–S2	.E..LD2	KC725M	**.E..GB2**	**KC725M**	.S..GB2	KC725M
S3	.E..LD2	KCSM40	**.E..GB2**	**KCSM40**	.S..GB2	KCSM40
S4	.E..LD2	KCSM40	**.E..GB2**	**KCSM40**	.S..GB2	KCSM40
H1	–	–	**–**	**–**	–	–

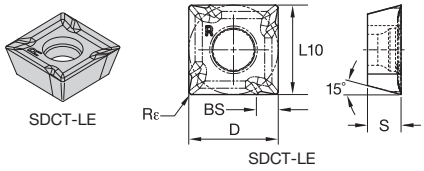
Indexable Inserts • SD.T1204

- Aluminium workpiece materials.
- Precision ground.
- 20° rake face.
- Four cutting edges.

beyond

● first choice
○ alternate choice

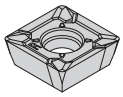
		KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40	KY3500
P				○	●		●	●		○	
M				●	●		○	○	○	●	
K			●	○		●	○				●
N		●		○							
S				●	●				●	●	
H				○							

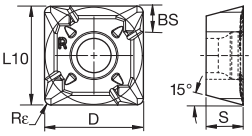


SDCT-LE

catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40	KY3500
SDCT120404PDFLLE	12,70	4,76	12,70	2,70	0,4	0,02	4	●	–	–	–	–	–	–	–	–	–
SDCT120404PDFRLE	12,70	4,76	12,70	2,70	0,4	0,02	4	●	–	–	–	–	–	–	–	–	–
SDCT1204PDFLLE	12,70	4,76	12,70	2,70	0,8	0,02	4	●	–	–	–	–	–	–	–	–	–
SDCT1204PDFRLE	12,70	4,76	12,70	2,70	0,8	0,02	4	●	–	–	–	–	–	–	–	–	–
SDCT120412PDFLLE	12,70	4,76	12,70	2,70	1,2	0,02	4	●	–	–	–	–	–	–	–	–	–
SDCT120412PDFRLE	12,70	4,76	12,70	2,70	1,2	0,02	4	●	–	–	–	–	–	–	–	–	–
SDCT120416FNLE	12,70	4,76	12,70	–	1,6	0,02	4	●	–	–	–	–	–	–	–	–	–
SDCT120420FNLE	12,70	4,76	12,70	–	2,0	0,02	4	●	–	–	–	–	–	–	–	–	–
SDCT120424FNLE	12,70	4,76	12,70	–	2,4	0,02	4	●	–	–	–	–	–	–	–	–	–
SDCT120432FNLE	12,70	4,76	12,70	–	3,2	0,02	4	●	–	–	–	–	–	–	–	–	–

- Light and finish machining.
- Precision ground.
- 15° rake face.
- Four cutting edges.


SDCT-LD2



SDCT-LD2

● first choice
○ alternate choice

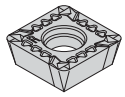
beyond

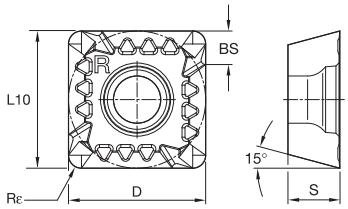
P				○	●		●	●		○	
M				●	●		○	○	○	●	
K			●	○		●	○				●
N		●		○							
S				●	●					●	●
H				○							

SDCT-LD2

catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40	KY3500
SDCT120404PDELLD2	12,70	4,76	12,70	2,70	0,4	0,04	4	–	–	–	●	–	–	–	–	–	–
SDCT120404PDERLD2	12,70	4,76	12,70	2,93	0,4	0,04	4	–	–	–	●	–	–	–	–	–	–
SDCT1204PDELLD2	12,70	4,76	12,70	3,32	0,8	0,04	4	–	–	–	●	–	–	–	–	–	–
SDCT1204PDERLD2	12,70	4,76	12,70	3,32	0,8	0,04	4	–	●	–	●	–	–	●	–	●	–
SDCT120412PDELLD2	12,70	4,76	12,70	3,05	1,2	0,04	4	–	–	–	●	–	–	–	–	–	–
SDCT120412PDERLD2	12,70	4,76	12,70	3,05	1,2	0,04	4	–	–	–	●	–	–	–	–	●	–
SDCT120416ENLD2	12,70	4,76	12,70	–	1,6	0,04	4	–	–	–	●	–	–	–	–	●	–
SDCT120420ENLD2	12,70	4,76	12,70	–	2,0	0,04	4	–	–	–	●	–	–	–	–	–	–
SDCT120424ENLD2	12,70	4,76	12,70	–	2,4	0,04	4	–	–	–	●	–	–	–	–	–	–
SDCT120432ENLD2	12,70	4,76	12,70	–	3,2	0,04	4	–	–	●	●	–	–	–	●	●	–
SDCT120464ENLD2	12,70	4,76	12,70	–	6,3	0,04	2	–	–	–	●	–	–	–	–	●	–

- Medium machining.
- Precision ground.
- 5° rake face.
- Four cutting edges.


SDET-GB2



SDET-GB2

SDET-GB2

catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40	KY3500
SDET1204PDELGB2	12,70	4,76	12,70	3,32	0,8	0,08	4	–	●	–	●	●	●	–	–	–	–
SDET1204PDERGB2	12,70	4,76	12,70	3,32	0,8	0,08	4	–	●	–	●	●	●	●	–	●	–
SDET1204PDSLGB2	12,70	4,76	12,70	3,32	0,8	0,13	4	–	–	–	●	–	●	–	–	–	–
SDET1204PDSRGB2	12,70	4,76	12,70	3,32	0,8	0,13	4	–	●	–	●	●	●	●	–	–	–
SDET120412PDELGB2	12,70	4,76	12,70	3,05	1,2	0,08	4	–	●	–	●	●	–	–	–	–	–
SDET120412PDERGB2	12,70	4,76	12,70	3,05	1,2	0,08	4	–	●	–	●	●	●	●	–	–	–
SDET120416SNGB2	12,70	4,76	12,70	–	1,6	0,13	4	–	●	–	●	●	●	–	–	–	–
SDET120420SNGB2	12,70	4,76	12,70	–	2,0	0,13	4	–	●	–	●	●	●	●	–	–	–
SDET120424SNGB2	12,70	4,76	12,70	–	2,4	0,13	4	–	–	–	●	●	●	–	–	–	–
SDET120432SNGB2	12,70	4,76	12,70	–	3,2	0,13	4	–	●	–	●	●	●	–	–	–	–
SDET120432XENGB2	12,70	4,76	12,70	–	3,2	0,08	2	–	–	–	●	–	–	–	–	–	–
SDET120464SNGB2	12,70	4,76	12,70	–	6,4	0,13	2	–	–	–	–	–	●	–	–	–	–

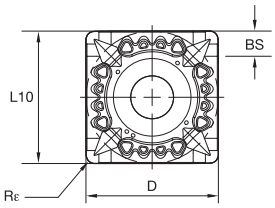
- Medium machining.
- Precision ground.
- 5° rake face.
- Four cutting edges.

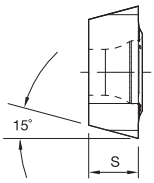
● first choice
○ alternate choice

beyond

P				○	●		●	●		○		
M				●	●		○	○	○	●		
K			●	○		●	○					●
N	●			○								
S				●	●					●	●	
H				○								


SDET-GB

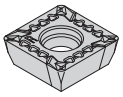


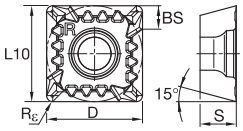


SDET-GB

SDET-GB

catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40	KY3500
SDET1204PDERGB	12,70	4,76	12,70	2,56	0,8	0,08	4	–	●	–	–	–	–	–	–	●	–
SDET1204PDSRGB	12,70	4,76	12,70	2,56	0,8	0,15	4	–	–	–	●	–	●	●	●	●	–
SDET120412PDERGB	12,70	4,76	12,70	2,19	1,2	0,08	4	–	–	–	●	–	–	●	–	●	–
SDET120412PDSRGB	12,70	4,76	12,70	2,16	1,2	0,15	4	–	–	–	●	–	–	–	–	●	–
SDET120416ENGB	12,70	4,76	12,70	–	1,6	0,08	4	–	–	–	–	–	–	–	–	●	–
SDET120416SNGB	12,70	4,76	12,70	–	1,6	0,15	4	–	–	–	●	–	–	–	–	●	–
SDET120424ENGB	12,70	4,76	12,70	–	2,4	0,08	4	–	–	–	●	–	–	–	–	●	–
SDET120424SNGB	12,70	4,76	12,70	–	2,4	0,15	4	–	–	–	●	–	–	–	–	●	–
SDET120432ENGB	12,70	4,76	12,70	–	3,2	0,08	4	–	–	–	●	–	–	–	–	●	–
SDET120432SNGB	12,70	4,76	12,70	–	3,2	0,15	4	–	–	–	–	–	–	–	–	●	–
SDET120448ENGB	12,70	4,76	12,70	–	4,8	0,08	2	–	–	–	●	–	–	–	–	●	–
SDET120448SNGB	12,70	4,76	12,70	–	4,8	0,15	2	–	–	–	●	–	–	–	–	●	–
SDET120464ENGB	12,70	4,76	12,70	–	6,4	0,08	2	–	–	–	●	–	–	–	–	●	–
SDET120464SNGB	12,70	4,76	12,70	–	6,4	0,15	2	–	–	–	●	–	●	–	●	●	–


SDPT-GB2



SDPT-GB2

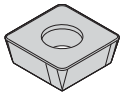
SDPT-GB2

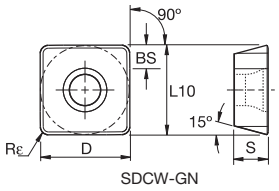
catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40	KY3500
SDPT1204PDERGB2	12,70	4,76	12,70	2,70	0,8	0,08	4	–	–	–	●	●	●	●	–	●	–
SDPT1204PDSRGB2	12,70	4,76	12,70	2,70	0,8	0,13	4	–	–	–	●	●	●	●	–	●	–

- Heavy machining.
- Precision ground.
- 0° rake face flat top.
- Four cutting edges.

● first choice
○ alternate choice

		KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40	KY3500
P				○	●		●	●		○	
M				●	●		○	○	○	●	
K			●	○		●	○				●
N		●		○							
S				●	●				●	●	
H				○							


SDCW-GN



SDCW-GN

SDCW-GN

catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40	KY3500
SDCW1204PDSRGN	12,70	4,76	12,70	2,53	0,8	0,16	4	–	–	–	–	–	–	–	–	–	●
SDCW120412PDSRGN	12,70	4,76	12,70	3,05	1,2	0,16	4	–	–	–	–	–	–	–	–	–	●

Recommended Starting Feeds

Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.F..LE	0,12	**0,42**	0,74	0,08	**0,30**	0,54	0,06	**0,23**	0,40	0,06	**0,20**	0,35	0,05	**0,18**	0,32	.F..LE
.E..LD	0,17	**0,47**	0,82	0,12	**0,34**	0,59	0,09	**0,26**	0,44	0,08	**0,22**	0,38	0,07	**0,20**	0,35	.E..LD
.E..LD2	0,12	**0,46**	0,81	0,09	**0,33**	0,58	0,07	**0,25**	0,43	0,06	**0,22**	0,38	0,05	**0,20**	0,35	.E..LD2
.E..GB	0,23	**0,53**	0,89	0,17	**0,38**	0,64	0,13	**0,29**	0,48	0,11	**0,25**	0,41	0,10	**0,23**	0,38	.E..GB
.E..GB2	0,23	**0,53**	0,89	0,17	**0,38**	0,64	0,13	**0,29**	0,48	0,11	**0,25**	0,41	0,10	**0,23**	0,38	.E..GB2
.S..GB	0,23	**0,59**	0,95	0,17	**0,43**	0,68	0,13	**0,32**	0,51	0,11	**0,28**	0,44	0,10	**0,25**	0,41	.S..GB
.S..GB2	0,23	**0,59**	0,95	0,17	**0,43**	0,68	0,13	**0,32**	0,51	0,11	**0,28**	0,44	0,10	**0,25**	0,41	.S..GB2
.S..GN	0,23	**0,59**	0,95	0,17	**0,43**	0,68	0,13	**0,32**	0,51	0,11	**0,28**	0,44	0,10	**0,25**	0,41	.S..GN

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

Leader in Advanced Face Milling Applications

Dodeka™ Mini



The Dodeka Mini series is the most comprehensive face milling booster on the market today and offers fast, accurate indexing — with only one screw!

It is the first choice for long-reach face milling applications, or light fixtures with up to 40% shorter machining cycle time. With a standard offering of 15°, 45°, and 60° in combination with Beyond™ premium milling grades, expect up to 35% better tool life in light to heavy machining.

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KSSM-KSSP Helical

Primary Application

KSSM-KSSP helical cutters were originally developed and proven for the aerospace industry, but are now available for all industries. The proprietary variable rake design minimises vibration and chatter.



Features and Benefits

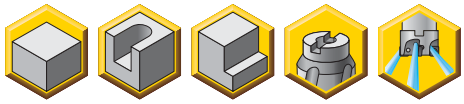
Features

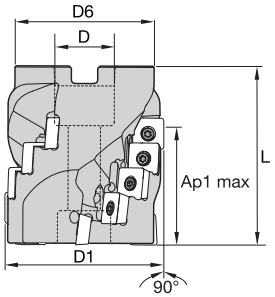
- Patented HARVI™ technology.
- Progressive helical rakes.
- Unique coolant supply.

Benefits

- Increased tool life in titanium.
- Increased metal removal rates.
- Lower power consumption.
- Ensures chip evacuation, even on exotic materials.

- Patented HARVI™ technology.
- Progressive helical rakes.
- Increased Metal Removal Rates (MRR).
- Excellent surface finishes.
- Low power requirements.
- Four cutting edges per insert.







Shell Mills • Standard Pitch

order number	catalogue number	D1	D	D6	L	Ap1 max	Z	Z U	kg	max RPM
2400693	**50A3RS90SD12L32**	50	22	44	55	32,4	9	3	0,46	16400
2400694	**63A3RS90SD12L50**	63	27	55	70	51,2	15	3	1,00	14600
2400695	**80A4RS90SD12L61**	80	32	70	80	61,6	24	4	2,13	12950

Spare Parts






D1	insert screw	Nm	socket-head cap screw	Torx wrench
50	**MS1273**	4,0	**MS1235**	**TT15**
63	**MS1273**	4,0	**MS1238**	**TT15**
80	**MS1273**	4,0	**MS1241**	**TT15**

NOTE: Maximum nose radii of lead insert is 2,4mm for 50mm diameter cutter.
All subsequent inserts up the flutes should have a maximum nose radius of 0,8mm to avoid lap lines.
Standard milling cutters will accept insert nose radii up to 2mm without modification.

Insert Selection Guide

Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		◄——►		toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.E..LD2	KCPM40	**.E..GB2**	**KCPM40**	.S..GB2	KCPM40
P3–P4	.E..LD2	KCPM40	**.E..GB2**	**KCPK30**	.S..GB2	KCPK30
P5–P6	.E..LD2	KC725M	**.E..GB2**	**KC725M**	.S..GB2	KC725M
M1–M2	.E..LD2	KCSM40	**.E..GB2**	**KCSM40**	.S..GB2	KCSM40
M3	.E..LD2	KCPM40	**.E..GB2**	**KCPM40**	.S..GB2	KCPM40
K1–K2	.E..LD2	KC520M	**.E..GB2**	**KCK15**	.S..GB2	KCK15
K3	.E..LD2	KC520M	**.E..GB2**	**KC520M**	.S..GB2	KC520M
N1–N2	.F..LE	KC410M	**.F..LE**	**KC410M**	.F..LE	KC410M
N3	.F..LE	KC410M	**.F..LE**	**KC410M**	.F..LE	KC410M
S1–S2	.E..LD2	KC725M	**.E..GB2**	**KC725M**	.S..GB2	KC725M
S3	.E..LD2	KCSM40	**.E..GB2**	**KCSM40**	.S..GB2	KCSM40
S4	.E..LD2	KCSM40	**.E..GB2**	**KCSM40**	.S..GB2	KCSM40
H1	–	–	**–**	**–**	–	–

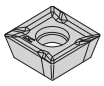
Indexable Inserts • SD.T1204

- Aluminium workpiece materials.
- Precision ground.
- 20° rake face.
- Four cutting edges.

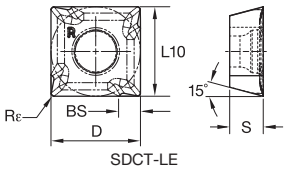
beyond

		KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40	KY3500
P				○	●		●	●		○	
M				●	●		○	○	○	●	
K			●	○		●	○				●
N		●		○							
S				●	●				●	●	
H				○							

● first choice
○ alternate choice



SDCT-LE



SDCT-LE

SDCT-LE

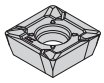
catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40	KY3500
SDCT120404PDFLLE	12,70	4,76	12,70	2,70	0,4	0,02	4	●	–	–	–	–	–	–	–	–	–
SDCT120404PDFRLE	12,70	4,76	12,70	2,70	0,4	0,02	4	●	–	–	–	–	–	–	–	–	–
SDCT1204PDFLLE	12,70	4,76	12,70	2,70	0,8	0,02	4	●	–	–	–	–	–	–	–	–	–
SDCT1204PDFRLE	12,70	4,76	12,70	2,70	0,8	0,02	4	●	–	–	–	–	–	–	–	–	–
SDCT120412PDFLLE	12,70	4,76	12,70	2,70	1,2	0,02	4	●	–	–	–	–	–	–	–	–	–
SDCT120412PDFRLE	12,70	4,76	12,70	2,70	1,2	0,02	4	●	–	–	–	–	–	–	–	–	–
SDCT120416FNLE	12,70	4,76	12,70	–	1,6	0,02	4	●	–	–	–	–	–	–	–	–	–
SDCT120420FNLE	12,70	4,76	12,70	–	2,0	0,02	4	●	–	–	–	–	–	–	–	–	–
SDCT120424FNLE	12,70	4,76	12,70	–	2,4	0,02	4	●	–	–	–	–	–	–	–	–	–
SDCT120432FNLE	12,70	4,76	12,70	–	3,2	0,02	4	●	–	–	–	–	–	–	–	–	–

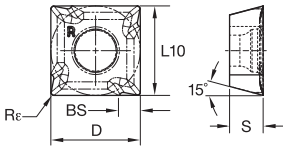
- Light and finish machining.
- Precision ground.
- 15° rake face.
- Four cutting edges.

beyond

P			○	●		●	●		○	
M			●	●		○	○	○	●	
K		●	○		●	○				●
N	●		○							
S			●	●				●	●	
H			○							

● first choice
○ alternate choice


SDCT-LD2

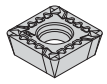


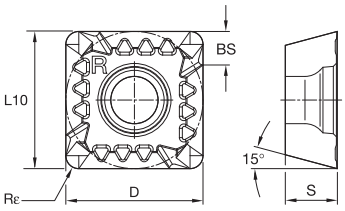
SDCT-LD2

SDCT-LD2

catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40	KY3500
SDCT120404PDELLD2	12,70	4,76	12,70	2,70	0,4	0,04	4	–	–	–	●	–	–	–	–	–	–
SDCT120404PDERLD2	12,70	4,76	12,70	2,93	0,4	0,04	4	–	–	–	●	–	–	–	–	–	–
SDCT1204PDELLD2	12,70	4,76	12,70	3,32	0,8	0,04	4	–	–	–	●	–	–	–	–	–	–
SDCT1204PDERLD2	12,70	4,76	12,70	3,32	0,8	0,04	4	–	●	–	●	–	–	●	–	●	–
SDCT120412PDELLD2	12,70	4,76	12,70	3,05	1,2	0,04	4	–	–	–	●	–	–	–	–	–	–
SDCT120412PDERLD2	12,70	4,76	12,70	3,05	1,2	0,04	4	–	–	–	●	–	–	–	–	●	–
SDCT120416ENLD2	12,70	4,76	12,70	–	1,6	0,04	4	–	–	–	●	–	–	–	–	●	–
SDCT120420ENLD2	12,70	4,76	12,70	–	2,0	0,04	4	–	–	–	●	–	–	–	–	–	–
SDCT120424ENLD2	12,70	4,76	12,70	–	2,4	0,04	4	–	–	–	●	–	–	–	–	–	–
SDCT120432ENLD2	12,70	4,76	12,70	–	3,2	0,04	4	–	–	●	●	–	–	–	●	●	–
SDCT120464ENLD2	12,70	4,76	12,70	–	6,3	0,04	2	–	–	–	●	–	–	–	–	●	–

- Medium machining.
- Precision ground.
- 5° rake face.
- Four cutting edges.


SDET-GB2

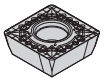


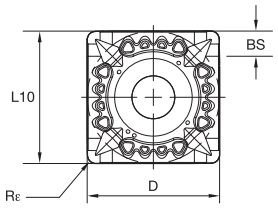
SDET-GB2

SDET-GB2

catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40	KY3500
SDET1204PDELGB2	12,70	4,76	12,70	3,32	0,8	0,08	4	–	●	–	●	●	●	–	–	–	–
SDET1204PDERGB2	12,70	4,76	12,70	3,32	0,8	0,08	4	–	●	–	●	●	●	●	–	●	–
SDET1204PDSLGB2	12,70	4,76	12,70	3,32	0,8	0,13	4	–	–	–	●	–	●	–	–	–	–
SDET1204PDSRGB2	12,70	4,76	12,70	3,32	0,8	0,13	4	–	●	–	●	●	●	●	–	–	–
SDET120412PDELGB2	12,70	4,76	12,70	3,05	1,2	0,08	4	–	●	–	●	●	–	–	–	–	–
SDET120412PDERGB2	12,70	4,76	12,70	3,05	1,2	0,08	4	–	●	–	●	●	●	●	–	–	–
SDET120416SNGB2	12,70	4,76	12,70	–	1,6	0,13	4	–	●	–	●	●	●	–	–	–	–
SDET120420SNGB2	12,70	4,76	12,70	–	2,0	0,13	4	–	●	–	●	●	●	●	–	–	–
SDET120424SNGB2	12,70	4,76	12,70	–	2,4	0,13	4	–	–	–	●	●	●	–	–	–	–
SDET120432SNGB2	12,70	4,76	12,70	–	3,2	0,13	4	–	●	–	●	●	●	–	–	–	–
SDET120432XENGB2	12,70	4,76	12,70	–	3,2	0,08	2	–	–	–	●	–	–	–	–	–	–
SDET120464SNGB2	12,70	4,76	12,70	–	6,4	0,13	2	–	–	–	–	–	●	–	–	–	–

- Medium machining.
- Precision ground.
- 5° rake face.
- Four cutting edges.


SDET-GB



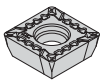
SDET-GB

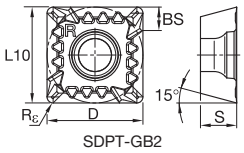
● first choice
○ alternate choice

P				○	●		●	●		○	
M				●	●		○	○	○	●	
K			●	○		●	○				●
N		●		○							
S				●	●					●	●
H				○							

SDET-GB

catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40	KY3500
SDET1204PDERGB	12,70	4,76	12,70	2,56	0,8	0,08	4	–	●	–	–	–	–	–	–	●	–
SDET1204PDSRGB	12,70	4,76	12,70	2,56	0,8	0,15	4	–	–	–	●	–	●	●	●	●	–
SDET120412PDERGB	12,70	4,76	12,70	2,19	1,2	0,08	4	–	–	–	●	–	–	●	–	●	–
SDET120412PDSRGB	12,70	4,76	12,70	2,16	1,2	0,15	4	–	–	–	●	–	–	–	–	●	–
SDET120416ENGB	12,70	4,76	12,70	–	1,6	0,08	4	–	–	–	–	–	–	–	–	●	–
SDET120416SNGB	12,70	4,76	12,70	–	1,6	0,15	4	–	–	–	●	–	–	–	–	●	–
SDET120424ENGB	12,70	4,76	12,70	–	2,4	0,08	4	–	–	–	●	–	–	–	–	●	–
SDET120424SNGB	12,70	4,76	12,70	–	2,4	0,15	4	–	–	–	●	–	–	–	–	●	–
SDET120432ENGB	12,70	4,76	12,70	–	3,2	0,08	4	–	–	–	●	–	–	–	–	●	–
SDET120432SNGB	12,70	4,76	12,70	–	3,2	0,15	4	–	–	–	–	–	–	–	–	●	–
SDET120448ENGB	12,70	4,76	12,70	–	4,8	0,08	2	–	–	–	●	–	–	–	–	●	–
SDET120448SNGB	12,70	4,76	12,70	–	4,8	0,15	2	–	–	–	●	–	–	–	–	●	–
SDET120464ENGB	12,70	4,76	12,70	–	6,4	0,08	2	–	–	–	●	–	–	–	–	●	–
SDET120464SNGB	12,70	4,76	12,70	–	6,4	0,15	2	–	–	–	●	–	●	–	●	●	–


SDPT-GB2

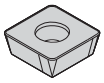


SDPT-GB2

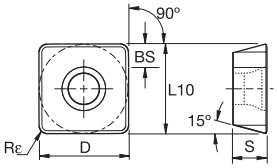
SDPT-GB2

catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40	KY3500
SDPT1204PDERGB2	12,70	4,76	12,70	2,70	0,8	0,08	4	–	–	–	●	●	●	●	–	●	–
SDPT1204PDSRGB2	12,70	4,76	12,70	2,70	0,8	0,13	4	–	–	–	●	●	●	●	–	●	–

- Heavy machining.
- Precision ground.
- 0° rake face flat top.
- Four cutting edges.



SDCW-GN



SDCW-GN

● first choice
○ alternate choice

		KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40	KY3500
P				○	●		●	●		○	
M				●	●		○	○	○	●	
K			●	○		●	○				●
N		●		○							
S				●	●				●	●	
H				○							

SDCW-GN

catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40	KY3500
SDCW1204PDSRGN	12,70	4,76	12,70	2,53	0,8	0,16	4	–	–	–	–	–	–	–	–	–	●
SDCW120412PDSRGN	12,70	4,76	12,70	3,05	1,2	0,16	4	–	–	–	–	–	–	–	–	–	●

Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.F..LE	0,12	**0,42**	0,74	0,08	**0,30**	0,54	0,06	**0,23**	0,40	0,06	**0,20**	0,35	0,05	**0,18**	0,32	.F..LE
.E..LD	0,17	**0,47**	0,82	0,12	**0,34**	0,59	0,09	**0,26**	0,44	0,08	**0,22**	0,38	0,07	**0,20**	0,35	.E..LD
.E..LD2	0,12	**0,46**	0,81	0,09	**0,33**	0,58	0,07	**0,25**	0,43	0,06	**0,22**	0,38	0,05	**0,20**	0,35	.E..LD2
.E..GB	0,23	**0,53**	0,89	0,17	**0,38**	0,64	0,13	**0,29**	0,48	0,11	**0,25**	0,41	0,10	**0,23**	0,38	.E..GB
.E..GB2	0,23	**0,53**	0,89	0,17	**0,38**	0,64	0,13	**0,29**	0,48	0,11	**0,25**	0,41	0,10	**0,23**	0,38	.E..GB2
.S..GB	0,23	**0,59**	0,95	0,17	**0,43**	0,68	0,13	**0,32**	0,51	0,11	**0,28**	0,44	0,10	**0,25**	0,41	.S..GB
.S..GB2	0,23	**0,59**	0,95	0,17	**0,43**	0,68	0,13	**0,32**	0,51	0,11	**0,28**	0,44	0,10	**0,25**	0,41	.S..GB2
.S..GN	0,23	**0,59**	0,95	0,17	**0,43**	0,68	0,13	**0,32**	0,51	0,11	**0,28**	0,44	0,10	**0,25**	0,41	.S..GN

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

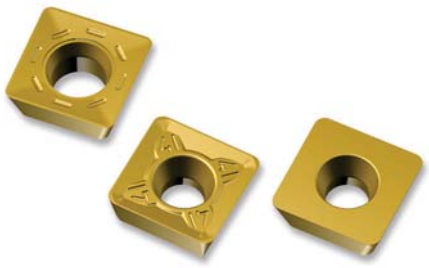
5230VS • High Performance Long-Edge Milling Cutters

The Stellram® **5230VS09** and **5230VS12** cutter series is perfectly suited for profiling and full slotting. Designed for high material removal rates in titanium and high-temperature alloys. Several applications have achieved metal removal rates of up to two times greater than the previous operating cutting parameters. The advanced chevron design ensures that one cutting point is always in contact with the material during entrance and exit. This provides optimum harmonic stability resulting in maximum tool life and a 30% improvement in surface finish. A generous flute capacity, coupled with each cutting edge having its own coolant jet, ensures excellent chip evacuation. This works to enhance surface finish and increases metal removal rates for a higher level of productivity.

The advanced 5230VS series is ideal for rough machining of steel, alloyed steel, stainless steel, and particularly for titanium and high-temperature alloys.

Features and Benefits

- Insert positioning provides smooth, progressive penetration and cutting action for extended tool life.
- Individual coolant jets to each insert provides constant chip evacuation and temperature stability in the cutting zone.
- The advanced chevron design improves stability and lowers power consumption, increasing tool life up to two times greater than comparable cutter in today's market.
- Proven versatility in wide application area in titanium and high-temperature alloys increasing productivity.



5230VS

5230VS09:

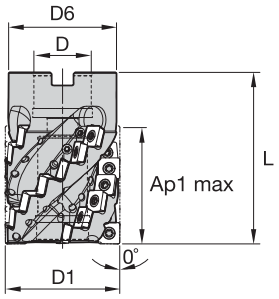
(a_p max is determined by selection of cutter diameter)
Diameter range and maximum a_p= 50mm diameter with a_p 51mm or 80mm

5230VS12:

(a_p max is determined by selection of cutter diameter)
Diameter range and maximum a_p= 63mm diameter with a_p 57mm or 94mm
80mm diameter with a_p 65mm or 110mm
100mm diameter with a_p 76mm or 133mm

- High material removal rates in titanium and high-temperature alloys.
- Chevron design improves stability and lowers power consumption.
- Insert positioning provide smooth progressive penetration and cutting action for extended tool life.
- Individual coolant jets to each insert provide constant chip evacuation and temperature stability in the cutting zone.





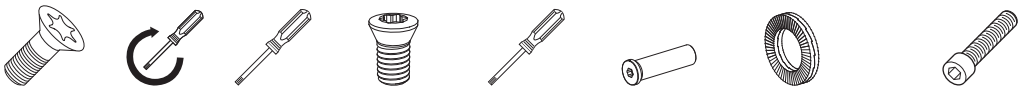


Shell Mills

order number	catalogue number	D1	D	D6	L	Ap1 max	Ap2 max	Z	Z U
5672876	**5230VS09-A050Z4R51**	50	27	48	76	51	44	28	4
5673801	**5230VS09-A050Z4R80**	50	27	48	106	80	—	44	4

NOTE: Ap2 max is the max Ap for slotting.

Spare Parts

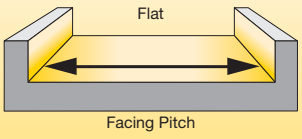


order number	D1	insert screw	Nm	Torx driver	coolant control screw	Torx driver	steel coolant plug	nord lock washer	socket-head cap screw
5672876	50	**F3508T**	2,1	**T15**	**F3006T**	**T9**	**SB3413**	**NLW-0.375**	**M12 X 1.75 X 30 SHCS**
5673801	50	**F3508T**	2,1	**T15**	**F3006T**	**T9**	**SB3621**	**NLW-0.375**	**M12 X 1.75 X 30 SHCS**

NOTE: 59–74 ft. lbs. change to 80–100 Nm.
25 ft. lbs. change to 34 Nm.

5230VS09 Technical Information (mm)

Product		Dimension					
EDP	**Item Description**	Facing Pitch	Ramping Angle°	Helical Hole min.–max.		a_p max Helical/Linear	Max RPM
031419	**5230VS09-A050Z4R51**	50	–	–	–	–	32500
031603	**5230VS09-A050Z4R80**	50	–	–	–	–	32500



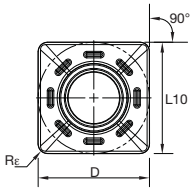
Insert Selection Guide

Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		◄——►		toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.E..422	SP6519	**.E..423**	**SP6519**	.E..41	SP6519
P3–P4	.E..423	SP6519	**.E..41**	**MP91M**	...TN	MP91M
P5–P6	.E..423	SP6519	**.E..41**	**SP6519**	...TN	SP6519
M1–M2	.E..422	KCSM40	**.E..423**	**KCSM40**	.E..41	KCSM40
M3	.E..423	KCSM40	**.E..41**	**KCSM40**	...TN	KCSM40
K1–K2	–	–	–	–	–	–
K3	–	–	–	–	–	–
N1–N2	–	–	–	–	–	–
N3	–	–	–	–	–	–
S1–S2	.E..422	X500	**.E..423**	**X500**	.E..41	X500
S3	.E..422	KCSM40	**.E..423**	**KCSM40**	.E..41	KCSM40
S4	.E..423	X500	**.E..41**	**X500**	...TN	X500
H1	–	–	–	–	–	–

Milling Inserts



SDHT09-422



SDHT09-422

● first choice
○ alternate choice

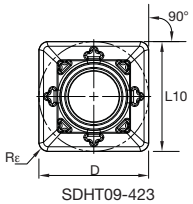
P	○	●	○	○	
M	●		●	●	
K		●	○		
N					
S	●		●	●	
H		○			

SDHT09-422

catalogue number	D	L10	S	Rε	hm	cutting edges	KCSM40	MP91M	SP6519	X500
SDHT09T308EN422	9,53	9,53	3,97	0,8	0,03	4	●	–	●	●
SDHT09T3AEEN422	9,53	9,53	3,97	—	0,05	4	–	–	●	–



SDHT09-423



SDHT09-423

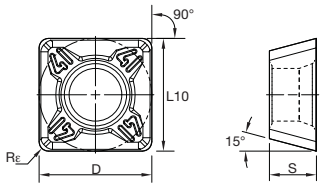
SDHT09-423

catalogue number	D	L10	S	Rε	hm	cutting edges	KCSM40	MP91M	SP6519	X500
SDHT09T308EN423	9,53	9,53	3,97	0,8	0,04	4	●	–	●	●

Shoulder Milling



SDMT09-41



SDMT09-41

● first choice
○ alternate choice

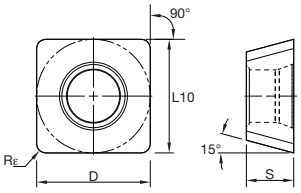
		KCSM40	MP91M	SP6519	X500
P		○	●	○	○
M		●		●	●
K			●	○	
N					
S		●		●	●
H			○		

SDMT09-41

catalogue number	D	L10	S	Rε	hm	cutting edges	KCSM40	MP91M	SP6519	X500
SDMT09T308EN41	9,52	9,52	3,97	0,8	0,05	4	●	●	●	●



SDMW09-TN



SDMW09-TN

SDMW09-TN

catalogue number	D	L10	S	Rε	hm	cutting edges	KCSM40	MP91M	SP6519	X500
SDMW09T308TN	9,53	9,53	3,96	0,8	0,11	4	●	–	–	–

Recommended Starting Feeds [mm]

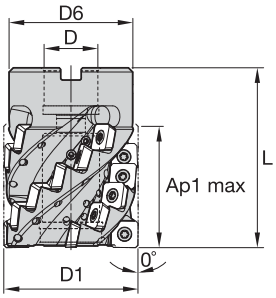
Light Machining	General Purpose	Heavy Machining

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.E..422	0,12	**0,47**	0,75	0,08	**0,34**	0,54	0,06	**0,26**	0,41	0,06	**0,22**	0,35	0,05	**0,20**	0,32	.E..422
.E..423	0,13	**0,46**	0,74	0,09	**0,33**	0,54	0,07	**0,25**	0,40	0,06	**0,22**	0,35	0,06	**0,20**	0,32	.E..423
.E..41	0,16	**0,52**	0,82	0,12	**0,38**	0,59	0,09	**0,28**	0,44	0,08	**0,25**	0,38	0,07	**0,23**	0,35	.E..41
...TN	0,23	**0,59**	0,89	0,17	**0,43**	0,64	0,13	**0,32**	0,48	0,11	**0,28**	0,41	0,10	**0,25**	0,38	...TN

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

- High material removal rates in titanium and high-temperature alloys.
- Chevron design improves stability and lowers power consumption.
- Insert positioning provides smooth progressive penetration and cutting action for extended tool life.
- Individual coolant jets to each insert provides constant chip evacuation and temperature stability in the cutting zone.





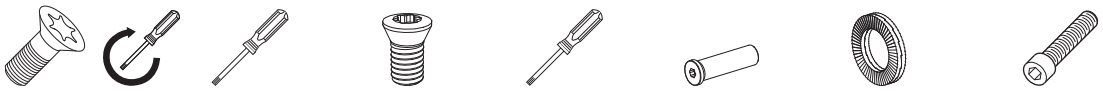


Shell Mills

order number	catalogue number	D1	D	D6	L	Ap1 max	Ap2 max	Z	Z U
5672864	**5230VS12-A063Z4R57**	63	27	58	85	57	52	24	4
5673167	**5230VS12-A063Z4R94**	63	27	58	124	94	—	40	4
5672883	**5230VS12-A080Z5R65**	80	32	74	95	65	60	35	5
5673236	**5230VS12-A080Z5R110**	80	32	74	143	110	—	60	5
5673742	**5230VS12-A100Z6R76**	100	40	94	106	76	70	48	6
5673169	**5230VS12-A100Z6R133**	100	40	94	165	133	—	84	6

NOTE: Ap2 max is the max Ap for slotting.

Spare Parts

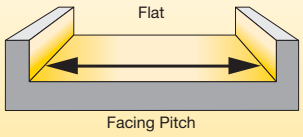


D1	Z	insert screw	Nm	Torx driver	coolant control screw	Torx driver	steel coolant plug	nord lock washer	socket-head cap screw
63	24	**F4011T**	3,1	**T20**	**F3006T**	**T9**	**SB3229**	**NLW-0.375**	**M12 X 1.75 X 30 SHCS**
63	40	**F4011T**	3,1	**T20**	**F3006T**	**T9**	**SB3230**	**NLW-0.375**	**M12 X 1.75 X 30 SHCS**
80	35	**F4011T**	3,1	**T20**	**F3006T**	**T9**	**SB3231**	**NLW12SP**	**M16 X 2 X 40 SHCS**
80	60	**F4011T**	3,1	**T20**	**F3006T**	**T9**	**SB3232**	**NLW12SP**	**M16 X 2 X 40 SHCS**
100	48	**F4011T**	3,1	**T20**	**F3006T**	**T9**	**SB3233**	**NLW-16SP**	**M20 X 2.5 X 50 SHCS**
100	84	**F4011T**	3,1	**T20**	**F3006T**	**T9**	**SB3234**	**NLW-16SP**	**M20 X 2.5 X 50 SHCS**

NOTE: Tighten mounting bolt on 63mm cutters to 80–100 Nm, 80mm cutters to 110–150 Nm, and 100mm cutters to 120–180 Nm.
Tighten steel coolant plug to 34 Nm for 63mm cutters and 61 Nm for 80 and 100mm cutters.

5230VS12 Technical Information (mm)

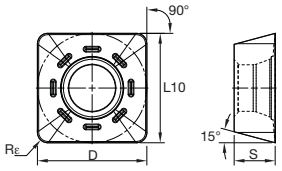
Product		Dimension					
EDP	**Item Description**	Facing Pitch	Ramping Angle°	Helical Hole min.–max.		a_p max Helical/Linear	Max RPM
31228	**5230VS12-A063Z4R57**	63	–	–	–	–	21000
31229	**5230VS12-A063Z4R94**	63	–	–	–	–	21000
31604	**5230VS12-A080Z5R65**	80	–	–	–	–	18500
31605	**5230VS12-A080Z5R110**	80	–	–	–	–	18500
31232	**5230VS12-A100Z6R76**	100	–	–	–	–	16000
31233	**5230VS12-A100Z6R133**	100	–	–	–	–	16000



Insert Selection Guide

Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		◄——►		toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.E..422	SP6519	**.E..41**	**SP6519**	.E..423	SP6519
P3–P4	.E..41	MP91M	**.E..423**	**SP6519**	...TN	SP6519
P5–P6	.E..41	SP6519	**.E..423**	**SP6519**	...TN	SP6519
M1–M2	.E..422	KCSM40	**.E..41**	**KCSM40**	.E..423	KCSM40
M3	.E..41	KCSM40	**.E..423**	**KCSM40**	...TN	KCSM40
K1–K2	–	–	–	–	–	–
K3	–	–	–	–	–	–
N1–N2	–	–	–	–	–	–
N3	–	–	–	–	–	–
S1–S2	.E..422	KCSM40	**.E..41**	**KCSM40**	.E..423	KCSM40
S3	.E..41	KCSM40	**.E..423**	**KCSM40**	...TN	KCSM40
S4	.E..41	X500	**.E..423**	**X500**	...TN	X500
H1	–	–	–	–	–	–


SDHT12-422



SDHT12-422

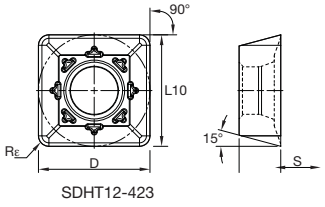
● first choice
○ alternate choice

P	○	●	○	○	
M	●		●	●	
K		●	○		
N					
S	●		●	●	
H		○			

SDHT12-422

catalogue number	D	L10	S	Rε	hm	cutting edges	KCSM40	MP91M	SP6519	X500
SDHT120412EN422	12,70	12,70	4,75	1,2	0,05	4	●	–	●	●


SDHT12-423

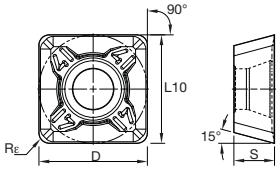


SDHT12-423

SDHT12-423

catalogue number	D	L10	S	Rε	hm	cutting edges	KCSM40	MP91M	SP6519	X500
SDHT120412EN423	12,70	12,70	4,75	1,2	0,06	4	●	–	●	●


SDMT12-41



SDMT12-41

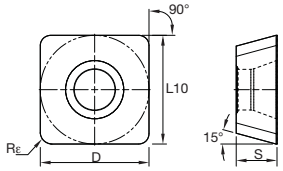
● first choice
○ alternate choice

		KCSM40	MP91M	SP6519	X500
P		○	●	○	○
M		●		●	●
K			●	○	
N					
S		●		●	●
H			○		

SDMT12-41

catalogue number	D	L10	S	Rε	hm	cutting edges	KCSM40	MP91M	SP6519	X500
SDMT120412EN41	12,70	12,70	4,75	1,2	0,05	4	●	●	●	●


SDMW12-TN



SDMW12-TN

SDMW12-TN

catalogue number	D	L10	S	Rε	hm	cutting edges	KCSM40	MP91M	SP6519	X500
SDMW120412TN	12,70	12,70	4,76	1,2	0,06	4	●	–	●	–

Recommended Starting Feeds

Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.E..422	0,16	**0,52**	0,87	0,12	**0,38**	0,63	0,09	**0,28**	0,47	0,08	**0,25**	0,41	0,07	**0,23**	0,38	.E..422
.E..41	0,16	**0,52**	0,87	0,12	**0,38**	0,63	0,09	**0,28**	0,47	0,08	**0,25**	0,41	0,07	**0,23**	0,38	.E..41
.E..423	0,20	**0,59**	0,95	0,14	**0,43**	0,68	0,11	**0,32**	0,51	0,09	**0,28**	0,44	0,08	**0,25**	0,41	.E..423
...TN	0,20	**0,59**	0,95	0,14	**0,43**	0,68	0,11	**0,32**	0,51	0,09	**0,28**	0,44	0,08	**0,25**	0,41	...TN

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

Calculation of the average chip thickness in relation with the a_e (Radial Engagement) if a_e is less than 50% of diameter.

Formula: Programme Feed Rate (f_z)

$$f_z = h_m \times \sqrt{\frac{d}{a_e}}$$

h_m = Average chip thickness
a_e = Radial engagement
f_z = Feed per tooth
d = Cutter diameter

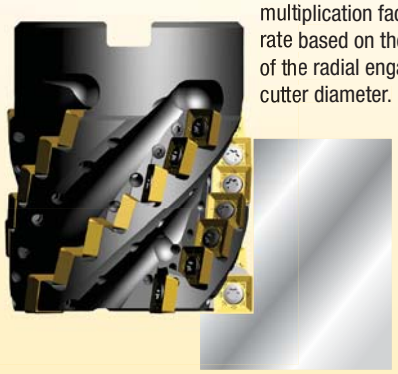
Formula: Average Chip Thickness (h_m)

$$h_m = f_z \times \sqrt{\frac{a_e}{d}}$$

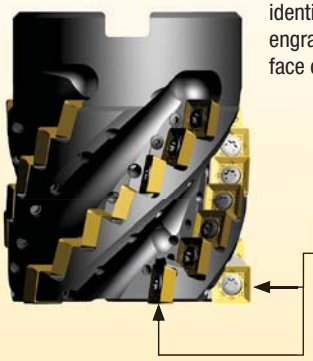
h_m Correction Coefficient Chart

Cutter Ø 50mm			Cutter Ø 63mm			Cutter Ø 80mm			Cutter Ø 100mm		
ae%	ae (mm)	Coefficient Factor	ae%	ae (mm)	Coefficient Factor	ae%	ae (mm)	Coefficient Factor	ae%	ae (mm)	Coefficient Factor
5	2,50	2,30	5	3,15	2,30	5	4,00	2,30	5	5,00	2,30
10	5,00	1,66	10	6,30	1,66	10	8,00	1,66	10	10,00	1,66
15	7,5	1,40	15	9,45	1,40	15	12,00	1,40	15	15,00	1,40
20	10,00	1,25	20	12,60	1,25	20	16,00	1,25	20	20,00	1,25
25	12,50	1,16	25	15,75	1,16	25	20,00	1,16	25	25,00	1,16
35	17,50	1,05	35	22,05	1,05	35	28,00	1,05	35	35,00	1,05
50–100	25,00–50,00	1,00	50–100	31,50–63,00	1,00	50–100	40,00–80,00	1,00	50–100	50,00–100,00	1,00

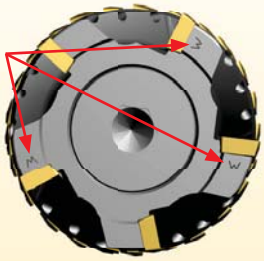
Example: A 50mm diameter cutter using 5,00mm radial engagement (a_e) = 10% of the cutter diameter. At 10%, your coefficient is 1,66 (see above table); therefore you must multiply your feed rate by 1,66 for correcting the feed for profiling.



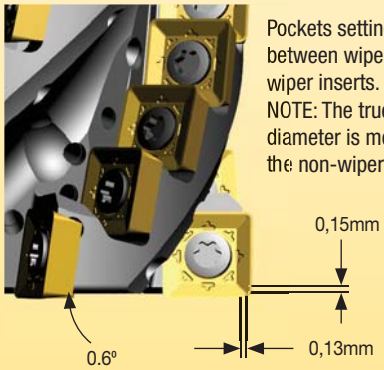
The chart above shows the multiplication factor for the feed rate based on the percentage of the radial engagement of the cutter diameter.



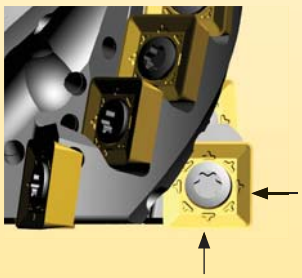
Wiper pockets are identified with a W engraved on the face of the body.



The 5230VS cutter series is designed with wiper pockets which provide a much better face surface finish. The non-wiper pockets generate the 90° corner. The same inserts can be utilised in all pockets.



Pockets setting difference between wiper and non-wiper inserts.
NOTE: The true cutter diameter is measured at the non-wiper pockets.



Non-wiper pocket positions are set back and square to axis to give a true 90° approach.

Wiper pocket positions are in front and angled to allow facing.

Cutter diameter (mm)	Number of Wiper Inserts
50	2
63	2
80	3
100	3

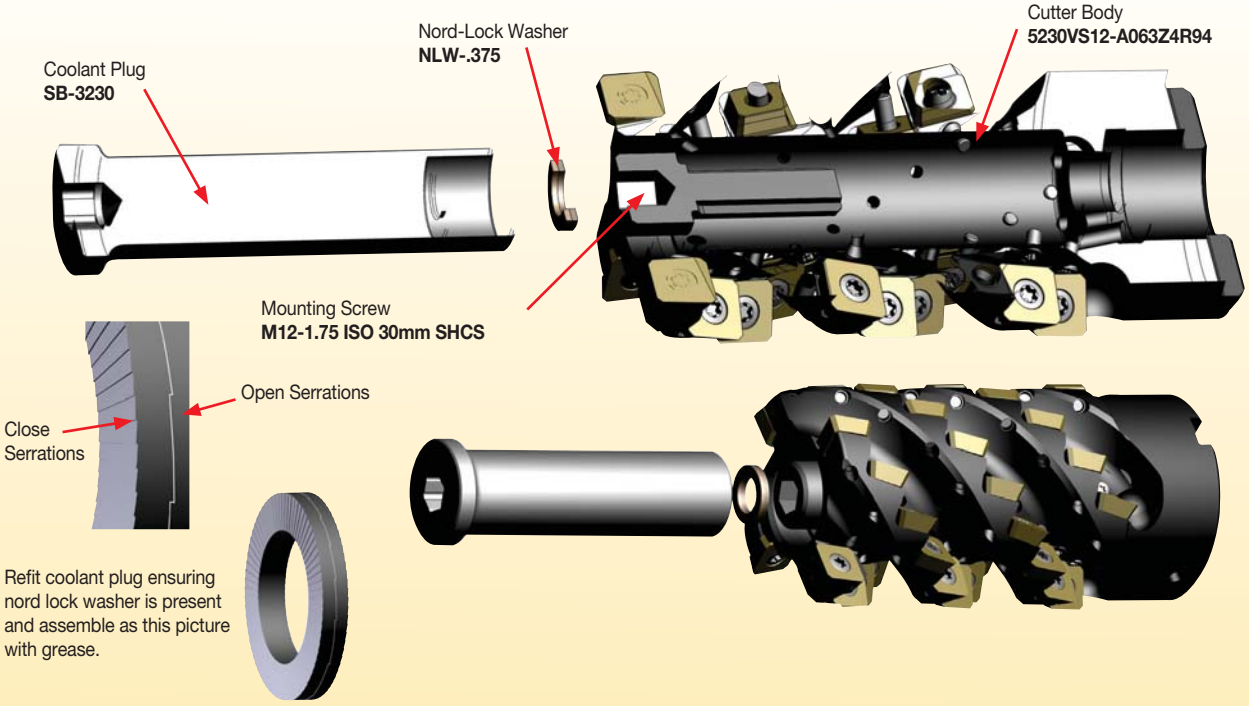
5230VS09 and 5230VS12 Fitting Instructions for Shell Mill Cutters

NOTE: All Shell Mill 5230VS09 and 5230VS12 chevron porcupine cutters are supplied assembled with mounting bolt, nord-lock washer, and steel coolant plug.



Please follow the instructions below to disassemble the cutter, attach the cutter to a shell mill adaptor, and reassemble coolant plug. It is very important to use the proper torque when reassembling the cutter with the mounting bolt, nord-lock washer, and coolant plug.

Example of cutter: 5230VS12-A063Z4R94 assembly



1. Remove coolant plug. *(NOTE: Ensure the nord-lock washer is retained to the bottom of the coolant plug.)*
2. Fit the cutter body to the shell mill adaptor and secure using the mounting bolt supplied with the cutter.
   NOTE: The mounting bolt must be properly torqued to the specific torque setting shown in Detail 1 on page T123.
3. Refit coolant plug ensuring nord-lock washer is present and in the proper location on the bottom of the coolant plug. A small amount of grease can be used to hold the nord-lock washer in place.
4. Tighten coolant plug with specific torque setting shown in Detail 2 on page T123.
5. NOTE: If axial depth of cut (a_p) is less then maximum a_p of cutter, then **F3006T** coolant control screws supplied separately can be used to block coolant holes forcing more coolant to the front of the cutter. If these screws are used, please secure with loctite or similar product.

Torque values for mounting bolts

Excessive condition is when long reach extensions are required or when cutting parameters are elevated to extreme parameters.

5230VS09	Detail 1			Detail 2	
Cutter	Mounting Bolt Description	Torque Values in Nm for Mounting Bolt		Coolant Plug Description	Coolant Plug tightening Nm
		Normal Condition	Excessive Condition		
5230VS09-A050Z4R51	M12-1.75 ISO x 30mm SHCS	80	100	SB-3413	34
5230VS09-A050Z4R80				SB-3621	

5230VS12	Detail 1			Detail 2	
Cutter	Mounting Bolt Description	Torque Values in Nm for Mounting Bolt		Coolant Plug Description	Coolant Plug tightening Nm
		Normal Condition	Excessive Condition		
5230VS12-A063Z4R57	M12-1.75 ISO x 30mm SHCS	80	100	SB-3229	34
5230VS12-A063Z4R94				SB-3230	
5230VS12-A080Z5R65	M16-2 ISO x 40mm SHCS	110	150	SB-3231	61
5230VS12-A080Z5R110				SB-3232	
5230VS12-A100Z6R76	M20-2.5 ISO x 50mm SHCS	120	180	SB-3233	61
5230VS12-A100Z6R133				SB-3234	

Mounting Bolt Hex Keys

M12 = Hex Key Size 10
M16 = Hex Key Size 14
M20 = Hex Key Size 17



Indexable Milling • Slot Milling

KTMS • T-Slot Platform U2–U5

KVNS • Very-Narrow Slotting Platform U6–U10

SN • Popular Square Inserted Cutter U12–U15

LN • Adjustable Width Cutter System U16–U22

KSSM10 • Neutral, Right-, and Left-Hand Cutters, 10mm IC U24–U37

KSSM12 • Neutral, Right-, and Left-Hand Cutters, 12mm IC U38–U53

KTMS™ Slotting Cutter

Primary Application

KTMS slotting cutters produce “T” slots in machine beds as well as small radial depths of cut for machining shallow radial slots. There is always a need to prepare the slot before using this type of cutter — preparation is the key to success.

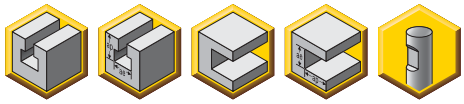
See the technical information for information about the pre-machining on page U5.

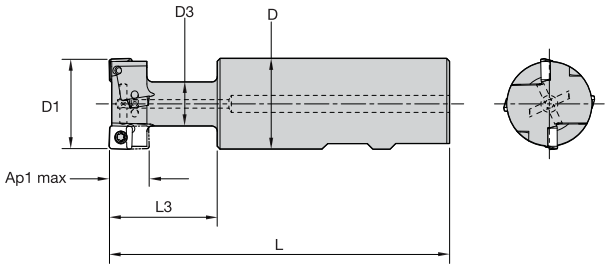


Features and Benefits

- Only available in metric dimensions.
- Slot widths from 9–22mm.
- Three different insert sizes.
- Preparing the component before slotting is the key to success.
- Prepare workpiece with a slot.
- Honed insert edges.
- Feed rates between 0,10–0,15mm; lower feed rates will induce vibration.
- Use air flow to evacuate chips.
- Always start the cutting process with a new cutting edge.

- Prepare workpiece with a slot.
- Honed insert edges.
- Feed rates between 0,10–0,15mm; lower feed rates will induce vibration.
- Use air flow to evacuate chips.
- Always start the cutting process with a new cutting edge.





KTMS • T-Slot Cutter with Through Coolant • Metric

order number	catalogue number	D1	D	D3	L	L3	Ap1 max	Z	Z U	insert 1	kg
3577119	**KTMS21S25SD06H**	21	25	11	109	29	9,0	2	1	SDMT060304EGG	0,35
3577121	**KTMS25S25SD06H**	25	25	13	112	32	11,0	4	2	SDMT060304EGG	0,36
3577133	**KTMS32S32SD08H**	32	32	16	120	38	14,0	4	2	SDMT080308EGG	0,60
3577135	**KTMS40S32SD12H**	40	32	21	130	50	18,0	4	2	SDMT120408EGG	0,66
3577137	**KTMS50S32SD12H**	50	32	27	140	60	22,0	4	2	SDMT120408EGG	0,85

Spare Parts





D1	insert screw	Nm	Torx driver
21	**MS2206**	1,2	**DT8**
25	**MS2206**	1,2	**DT8**
32	**MS2207**	2,0	**DT10**
40	**MS2208**	3,5	**DT15**
50	**MS2208**	3,5	**DT15**

Insert Selection Guide

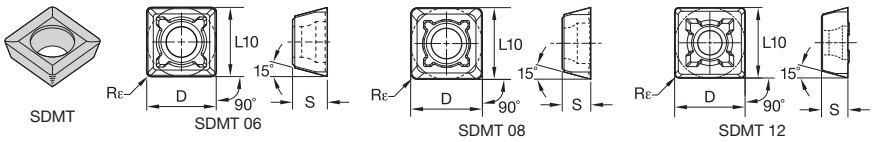
Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		◄——►		toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	..EGG	KC735M	..EGG	**KC735M**	..EGG	KC735M
P3–P4	..EGG	KC735M	..EGG	**KC735M**	..EGG	KC735M
P5–P6	..EGG	KC735M	..EGG	**KC735M**	..EGG	KC735M
M1–M2	–	–	–	–	–	–
M3	–	–	–	–	–	–
K1–K2	..EGG	KC505M	**..EGG**	**KC505M**	..EGG	KC505M
K3	..EGG	KC505M	**..EGG**	**KC505M**	..EGG	KC505M
N1–N2	–	–	–	–	–	–
N3	–	–	–	–	–	–
S1–S2	–	–	–	–	–	–
S3	–	–	–	–	–	–
S4	–	–	–	–	–	–
H1	–	–	–	–	–	–

Indexable Insert • T-Slot Cutters SDMT • EGG

- Honed insert edges.
- Four cutting edges.

● first choice
○ alternate choice

P		●	●
M			
K	●		
N			
S			
H			



SDMT-EGG

catalogue number	D	S	L10	Rε	hm	cutting edges	KC505M	KC730M	KC735M
SDMT060304EGG	6,35	3,18	6,35	0,4	0,06	4	–	●	●
SDMT080308EGG	8,00	3,18	8,00	0,8	0,06	4	●	●	●
SDMT120408EGG	12,70	4,76	12,70	0,8	0,06	4	●	●	●

Recommended Starting Feeds

Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.06..EGG	0,20	**0,46**	0,70	0,14	**0,33**	0,50	0,11	**0,25**	0,38	0,09	**0,22**	0,33	0,08	**0,20**	0,30	.06..EGG
.08..EGG	0,20	**0,53**	0,82	0,14	**0,38**	0,59	0,11	**0,29**	0,44	0,09	**0,25**	0,39	0,08	**0,23**	0,35	.08..EGG
.12..EGG	0,20	**0,59**	0,92	0,14	**0,43**	0,66	0,11	**0,32**	0,50	0,09	**0,28**	0,43	0,08	**0,25**	0,40	.12..EGG

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

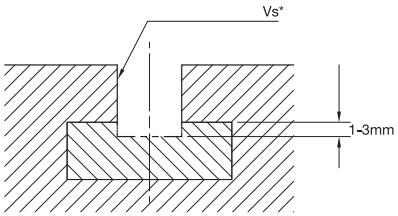


Fig. 1

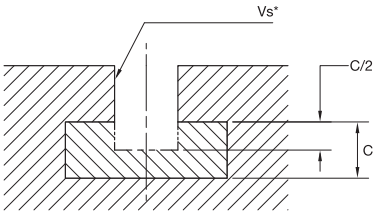


Fig. 2

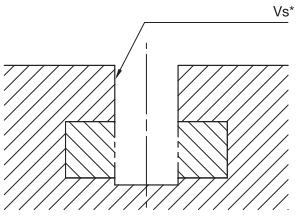
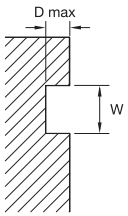


Fig. 3



Side Slotting

Steel

- Machining a vertical slot, depth to be kept at a minimum as shown in Figure 1.
- If the depth is greater than Figure 1, chip evacuation problems could occur.
- Vibrations could occur when the T-slot cutter diameter increases; use Figure 1 as the starting point.
- If chattering is a concern, adopt the Figure 2 solution.

Cast Iron

- Fewer problems with chip evacuation and reduced cutting forces enable deeper vertical slots as shown in Figures 2 and 3.
- Air blast is recommended to disperse the chips; this can be used for steel and cast iron.

Cutting Data Table • Slotting

	material type	catalogue number	cutting conditions vc (m/min)	feed per tooth (mm)	Vs*
P	carbon steel/ alloy steel	KTMS21S25SD06H	120	0,10	Figure 1
		KTMS25S25SD06H	120	0,10	Figure 1
		KTMS32S32SD08H	100	0,10	Figure 1
		KTMS40S32SD12H	80	0,15	Figure 2
		KTMS50S32SD12H	not recommended due to frequent chattering		
K	cast iron	KTMS21S25SD06H	120	0,12	Figure 1, 2, 3
		KTMS25S25SD06H	120	0,12	Figure 1, 2, 3
		KTMS32S32SD08H	120	0,12	Figure 1, 2, 3
		KTMS40S32SD12H	120	0,12	Figure 2,3
		KTMS50S32SD12H	120	0,15	Figure 3

* Vs = Vertical slot preparation for T-slot.

Side Slot Machining

side slot dimension catalogue number	W -0.1 / -0.3 mm	D max mm
KTMS21S25SD06H	9	4,4
KTMS25S25SD06H	11	5,4
KTMS32S32SD08H	14	6,9
KTMS40S32SD12H	18	8,9
KTMS50S32SD12H	22	10,9

NOTE: KTMS T-slot is available to side slot as per drawing.

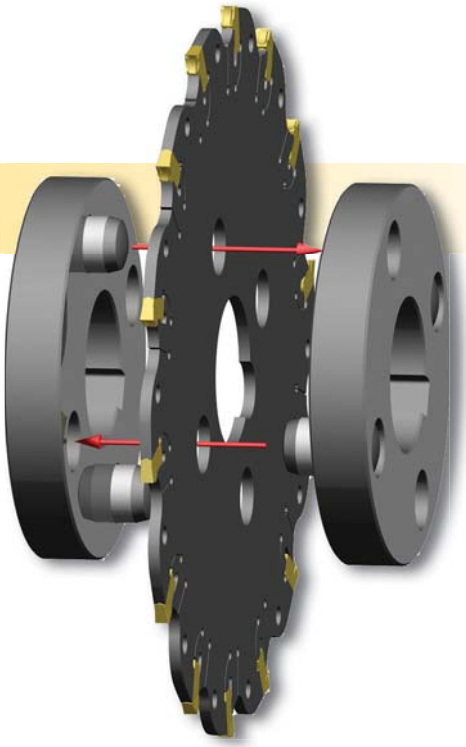
Cutting Data • Side Machining

	material type	catalogue number	cutting conditions vc (m/min)	n (RPM)	feed per tooth (mm)
P	carbon steel/ alloy steel	KTMS21S25SD06H	120	1820	0,10
		KTMS25S25SD06H	120	1530	0,10
		KTMS32S32SD08H	120	1190	0,10
		KTMS40S32SD12H	120	960	0,10
		KTMS50S32SD12H	120	760	0,10
K	cast iron	KTMS21S25SD06H	150	2270	0,12
		KTMS25S25SD06H	150	1910	0,12
		KTMS32S32SD08H	150	1490	0,12
		KTMS40S32SD12H	150	1190	0,15
		KTMS50S32SD12H	150	960	0,15

KVNS™ Slotting Cutter

Primary Application

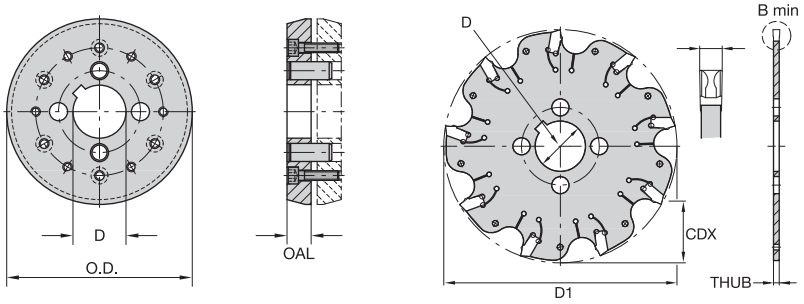
The KVNS slotting cutter enables diameters from 63–250mm and insert widths from 1,6–4mm. It is a perfect solution for small groove widths, grades, and geometries and suits most materials. Drive rings and support rings are available; use these items to get the maximum support for the cutter body.



Features and Benefits

- Slot widths from 1,6–4mm.
- Grades and geometries to suit most workpiece materials.
- Positive chipforming inserts are standard.
- Self-clamping inserts.
- Self-clamping insert seat with fixed stop.
- Excellent for all flat-bottom slotting and cut-off operations.
- Two drive hubs are required for each cutter body, except when using two drive supports.
- Drive rings and support rings available, must be ordered separately (in pairs).

- Positive chip forming inserts are standard.
- Self-clamping insert seat with fixed stop.
- Excellent for all flat-bottom slotting and cut-off operations.
- Two drive rings required for each cutter body (must be ordered separately, in pairs).





A2 • Cutting Width 1,6mm



order number	catalogue number	D1	D	B min	CDX	THUB	Z	max RPM	insert 1	drive ring	kg
1246114	**4.97060116**	63	16	1,6	15,0	1,3	5	5100	3.90016___	**1177888**	0,03
1246122	**4.97080116**	80	16	1,6	21,0	1,3	7	4000	3.90016___	**1247091**	0,04
1246131	**4.97101116**	100	22	1,6	27,0	1,3	9	3200	3.90016___	**1247085**	0,07
1246138	**4.97123116**	125	32	1,6	35,0	1,3	11	2600	3.90016___	**1247087**	0,10

A2 • Cutting Width 2,2mm



order number	catalogue number	D1	D	B min	CDX	THUB	Z	max RPM	insert 1	drive ring	kg
1246124	**4.97080122**	80	16	2,2	21,0	1,8	7	4000	3.90022___	**1247091**	**0,05**
1246132	**4.97101122**	100	22	2,2	27,0	1,8	9	3200	3.90022___	**1247085**	**0,08**
1246140	**4.97123122**	125	32	2,2	35,0	1,8	11	2600	3.90022___	**1247087**	**0,12**
1246147	**4.97164122**	160	40	2,2	40,0	1,8	14	2000	3.90022___	**1247082**	**0,30**

A2 • Cutting Width 3mm

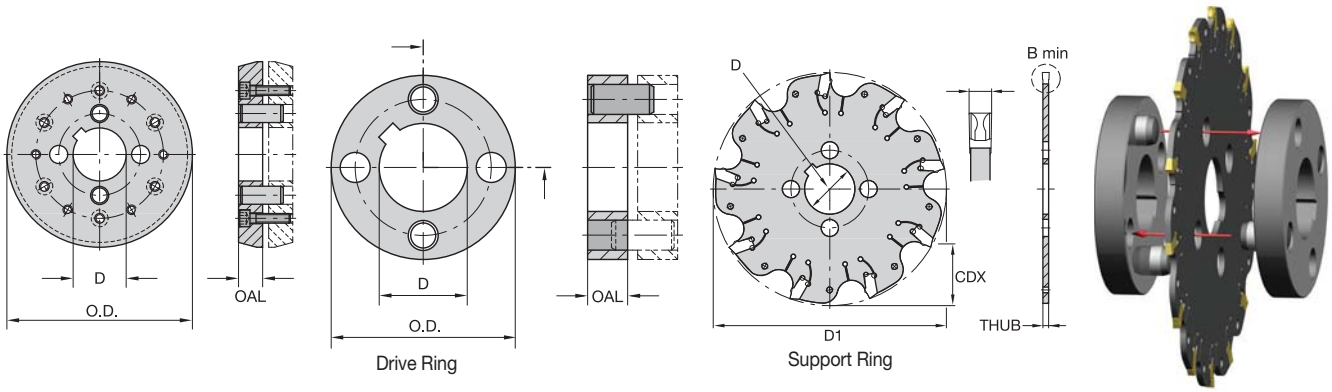


order number	catalogue number	D1	D	B min	CDX	THUB	Z	max RPM	insert 1	drive ring	kg
1246118	**4.97060130**	63	16	3,0	15,0	2,4	4	5100	3.90030___	**1247088**	0,05
1246126	**4.97080130**	80	16	3,0	21,0	2,4	6	4000	3.90030___	**1247091**	0,08
1246134	**4.97101130**	100	22	3,0	27,0	2,4	9	3200	3.90030___	**1247085**	0,13
1246142	**4.97123130**	125	32	3,0	35,0	2,4	11	2600	3.90030___	**1247087**	0,20
1246149	**4.97164130**	160	40	3,0	40,0	2,4	14	2000	3.90030___	**1247082**	0,35
1246153	**4.97204130**	200	40	3,0	60,0	2,4	19	1600	3.90030___	**1247082**	0,50
1246157	**4.97254130**	250	40	3,0	85,0	2,4	24	1300	3.90030___	**1247082**	0,80

A2 • Cutting Width 4mm



order number	catalogue number	D1	D	B min	CDX	THUB	Z	max RPM	insert 1	drive ring	kg
1246120	**4.97060140**	63	16	4,0	15,0	3,4	4	5100	3.90040___	**1247088**	0,06
1246129	**4.97080140**	80	16	4,0	21,0	3,4	6	4000	3.90040___	**1247091**	0,10
1246136	**4.97101140**	100	22	4,0	27,0	3,4	9	3200	3.90040___	**1247085**	0,15
1246145	**4.97123140**	125	32	4,0	35,0	3,4	11	2600	3.90040___	**1247087**	0,25
1246150	**4.97164140**	160	40	4,0	40,0	3,4	14	2000	3.90040___	**1247082**	0,40
1246154	**4.97204140**	200	40	4,0	60,0	3,4	19	1600	3.90040___	**1247082**	0,65



Drive Rings



order number	D1	O.D.	OAL	bore size	drive ring	kg
1177888	63	32	8	16	**460.889**	0,03
1247088	63	32	8	16	**460.898**	0,04
1247091	80	38	8	16	**460.899**	0,06
1247085	100	46	10	22	**460.890**	0,10
1247087	125	55	10	32	**460.897**	0,12
1247082	160	80	12	40	**460.888**	0,34
1247082	200	80	12	40	**460.888**	0,34
1247082	250	80	12	40	**460.888**	0,34

Support Rings



D1	order number	support ring	bore size	CDX	O.D.	OAL	clamp screw	Allen key	Allen key size	kg
200	**1247080**	**460.887**	40	30	140	12	**125.616**	**170.005**	5mm	1,15
250	**1247080**	**460.887**	40	55	140	12	**125.616**	**170.005**	5mm	1,15
250	**1247078**	**460.886**	40	30	190	12	**125.616**	**170.005**	5mm	2,35

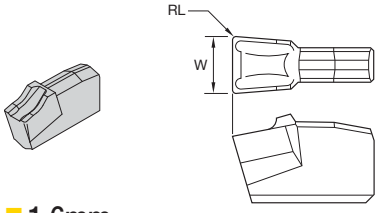
NOTE: For CDX value, refer to drive ring and support ring tables.
Insert wrench 170.183 (order code 1124601) must be ordered separately

Insert Selection Guide

Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		←	→	toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.S..GD	KC735M	**.S..GD**	**KCPK30**	.S..GB	KCPK30
P3–P4	.S..GD	KC735M	**.S..GD**	**KCPK30**	.S..GB	KCPK30
P5–P6	.S..GD	KC735M	**.S..GB**	**KCPK30**	.S..GB	KCPK30
M1–M2	.S..GD	KC735M	**.S..GD**	**KCPK30**	.S..GB	KCPK30
M3	.S..GD	KCPK30	**.S..GB**	**KCPK30**	.S..GB	KCPK30
K1–K2	.S..GD	KCPK30	**.S..GD**	**KCPK30**	.S..GB	KCPK30
K3	.S..GD	KCPK30	**.S..GD**	**KCPK30**	.S..GB	KCPK30
N1–N2	.E..GD	KMF	**.E..GD**	**KMF**	.E..GD	KMF
N3	.E..GD	KMF	**.E..GD**	**KMF**	.E..GD	KMF
S1–S2	.E..GD	KMF	**.E..GD**	**KMF**	.E..GD	KMF
S3	.E..GD	KMF	**.E..GD**	**KMF**	.E..GD	KMF
S4	.E..GD	KMF	**.E..GD**	**KMF**	.E..GD	KMF
H1	–	–	**–**	**–**	–	–

Indexable Inserts • KVNS A2

- Very narrow slotting/slitting operations.
- Positive chipforming insert geometry.



● first choice
○ alternate choice

	KC735M	KCPK30	KMF
P	○	●	
M	●	○	
K		○	
N			●
S	●		●
H			

1,6mm

catalogue number	W	RL	hm	KC735M	KCPK30	KMF
3.90016ECGD	1,60	0,15	0,08	–	–	●
3.90016SNGB	1,60	0,15	0,08	●	●	–
3.90016SNGD	1,60	0,15	0,08	●	●	–

2,2mm

catalogue number	W	RL	hm	KC735M	KCPK30	KMF
3.90022ECGD	2,20	0,20	0,08	–	–	●
3.90022SNGB	2,20	0,20	0,08	●	●	–
3.90022SNGD	2,25	0,20	0,08	●	●	–

3mm

catalogue number	W	RL	hm	KC735M	KCPK30	KMF
3.90030ECGD	3,05	0,20	0,08	–	–	●
3.90030SNGB	3,05	0,20	0,08	●	●	–
3.90030SNGD	3,05	0,20	0,08	●	●	–

4mm

catalogue number	W	RL	hm	KC735M	KCPK30	KMF
3.90040ECGD	4,05	0,20	0,08	–	–	●
3.90040SNGB	4,05	0,20	0,08	●	●	–
3.90040SNGD	4,05	0,20	0,08	●	●	–

Recommended Starting Feeds [mm]

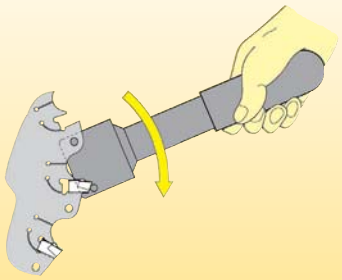
Light Machining	General Purpose	Heavy Machining

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.E..GD	0,23	**0,41**	0,63	0,17	**0,29**	0,46	0,13	**0,22**	0,34	0,11	**0,19**	0,30	0,10	**0,18**	0,27	.E..GD
.S..GD	0,23	**0,46**	0,71	0,17	**0,33**	0,51	0,13	**0,25**	0,38	0,11	**0,22**	0,33	0,10	**0,20**	0,30	.S..GD
.S..GB	0,23	**0,46**	0,74	0,17	**0,33**	0,54	0,13	**0,25**	0,40	0,11	**0,22**	0,35	0,10	**0,20**	0,32	.S..GB

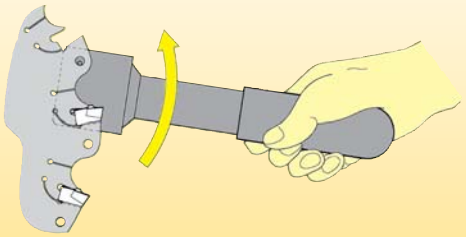
NOTE: Use “Light Machining” values as starting feed rate.
% = ae/Dc * 100 (ae = radial depth of cut, Dc = cutting diameter)
Please see pages X22–X37 for recommended starting speeds.

Slotting Cutters • Technical Information

Secure clamping self-clamping insert seat for maximum machining safety



Using the assembly wrench:
Fitting the insert



Removing the insert

- Exact position of the insert guaranteed by the positive stop.
- Maximum possible insert repeatability with dual positive prism clamping.
- Powerful, secure clamping guarantees high peripheral speeds.

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SN Slotting Cutter

Primary Application

SN slotting cutters are perfect for deeper applications that require the cutting load to be shared from one insert to the other. Provides groove widths from 4–14mm and cutter diameters from 80–250mm as well as an economical way to achieve balanced cutting.

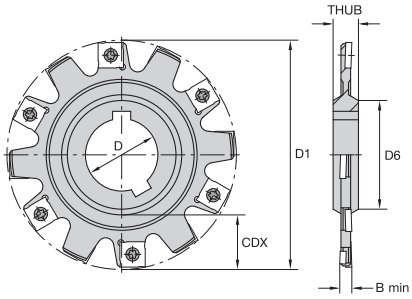


Features and Benefits

- Cutters available in arbour mount.
- Inserts with four indexes.
- Staggered key ways in mounting bore, used for multiple ganged cutters.
- Slot width 4–14mm.
- Three insert geometries available: -GP, -GE, and -T.
- Requires only one spare part.

- 4–14mm slot widths range.
- Four indexes per insert.
- Three chip formers available.
- Two keyways for staggered mounting.
- Requires only one spare part.







SN • Arbour Mount • Full-Side Cutting

order number	catalogue number	D1	D	D6	B min	CDX	THUB	Z	Z S	insert 1	kg
1244389	**4.96082-204**	80	27	45	4,0	15	12,0	10	5	SNHX1102___	0,30
1191306	**4.96102-204**	100	27	45	4,0	25	12,0	12	6	SNHX1102___	0,40
1244398	**4.96102-205**	100	27	45	5,0	25	12,0	12	6	SNHX11T3___	0,40
1244368	**4.96102-206**	100	27	45	6,0	25	12,0	10	5	SNHX1203___	0,40
1244370	**4.96124-204**	125	40	58	4,0	30	12,0	14	7	SNHX1102___	0,50
1244371	**4.96124-205**	125	40	58	5,0	30	12,0	14	7	SNHX11T3___	0,60
1244374	**4.96124-210**	125	40	58	10,0	30	12,0	12	6	SNHX12L5___	0,80
1244375	**4.96124-212**	125	40	58	12,0	30	12,0	12	4	SNHX12L5___	0,90
1244394	**4.96164-204**	160	40	68	4,0	44	12,0	18	9	SNHX1102___	0,90
1244376	**4.96164-205**	160	40	68	5,0	44	12,0	18	9	SNHX11T3___	0,90
1244379	**4.96164-210**	160	40	68	10,0	44	12,0	16	8	SNHX12L5___	1,40
1244395	**4.96205-208**	200	50	72	8,0	62	12,0	18	6	SNHX1203___	1,80
1244385	**4.96255-206**	250	50	72	6,0	86	12,0	24	12	SNHX1203___	4,20
1244386	**4.96255-208**	250	50	72	8,0	86	12,0	24	8	SNHX1203___	4,50

Spare Parts







order number	D1	B min	insert screw	Nm	Torx driver
1244389	80	4	**192.529**	1,0	**170.023**
1191306	100	4	**192.529**	1,0	**170.023**
1244398	100	5	**192.530**	1,0	**170.023**
1244368	100	6	**192.531**	3,0	**170.025**
1244370	125	4	**192.529**	1,0	**170.023**
1244371	125	5	**192.530**	1,0	**170.023**
1244374	125	10	**192.532**	3,0	**170.025**
1244375	125	12	**192.532**	3,0	**170.025**
1244394	160	4	**192.529**	1,0	**170.023**
1244376	160	5	**192.530**	1,0	**170.023**
1244379	160	10	**192.532**	3,0	**170.025**
1244395	200	8	**192.531**	3,0	**170.025**
1244385	250	6	**192.531**	3,0	**170.025**
1244386	250	8	**192.531**	3,0	**170.025**

Insert Selection Guide

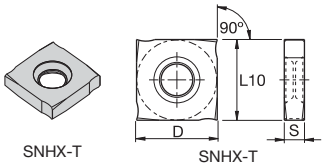
Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		◄——►		toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.T..GP	KCPM40	**.T..GP**	**KCPM40**	..T	KCPM40
P3–P4	.T..GP	KCPK30	**.T..GP**	**KCPM40**	..T	KCPM40
P5–P6	.T..GP	KCPK30	**..T**	**KCPK30**	..T	KCPM40
M1–M2	.T..GP	KC725M	**.T..GP**	**KC725M**	..T	KC725M
M3	.T..GP	KCPM40	**.T..GP**	**KCPM40**	..T	KCPM40
K1–K2	..T	KC520M	**..T**	**KC520M**	..T	KC520M
K3	.T..GP	KCPK30	**.T..GP**	**KCPK30**	..T	KCPK30
N1–N2	.F..GE	KC510M	**.F..GE**	**KC510M**	.T..GP	K110M
N3	.T..GP	K110M	**.T..GP**	**K110M**	.T..GP	K110M
S1–S2	.T..GP	KC725M	**.T..GP**	**KC725M**	..T	KC725M
S3	.T..GP	KCPM40	**.T..GP**	**KCPM40**	..T	KCPM40
S4	.T..GP	KC725M	**..T**	**KC725M**	..T	KC725M
H1	.F..GE	KC510M	**–**	**–**	–	–

Indexable Inserts • SNHX-T • SNHX-NGE

- Medium to heavy machining.
- With T-land geometry.
- Four cutting edges.

● first choice
○ alternate choice

P			●		●	●	●
M					●	○	○
K		○	●	●		○	
N		●	○				
S					●		
H							

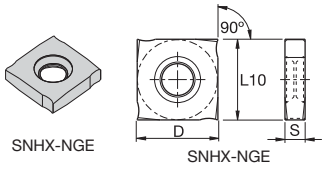


SNHX-T SNHX-T

SNHX-T

catalogue number	D	S	L10	hm	cutting edges	K110M	KC510M	KC520M	KC725M	KCPK30	KCPM40
SNHX1102T	11,00	2,30	11,00	0,16	4	–	–	–	●	–	●
SNHX1103T	11,00	2,70	11,00	0,16	4	–	–	–	●	●	●
SNHX1203T	12,70	3,20	12,70	0,16	4	–	–	–	●	–	●
SNHX1204T	12,70	4,00	12,70	0,11	4	–	–	–	●	–	–
SNHX12045T	12,70	4,50	12,70	0,11	4	–	–	–	●	–	–
SNHX1205T	12,70	5,40	12,70	0,11	4	–	–	–	●	–	–

- Positive geometry for lighter machining.
- Four cutting edges.



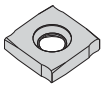
SNHX-NGE SNHX-NGE

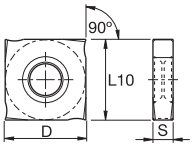
SNHX-NGE

catalogue number	D	S	L10	hm	cutting edges	K110M	KC510M	KC520M	KC725M	KCPK30	KCPM40
SNHX11T3PZFNGE	11,00	2,70	11,00	0,05	4	–	●	–	–	–	–
SNHX1203PZFNGE	12,70	3,20	12,70	0,04	4	–	●	–	–	–	–
SNHX12L5PZFNGE	12,70	5,40	12,70	0,04	4	●	●	–	–	–	–

Slot Milling

- Four cutting edges.
- High-feed capabilities up to 55 HRC.


SNHX-NGP



SNHX-NGP

● first choice
○ alternate choice

		K110M	KC510M	KC520M	KC725M	KCPK30	KCPM40
P		●		●		●	●	●
M						●	○	○
K		○	●	●		○	
N		●	○				
S						●		
H								

SNHX-NGP

catalogue number	D	S	L10	hm	cutting edges	K110M	KC510M	KC520M	KC725M	KCPK30	KCPM40
SNHX1102PZTNGP	11,00	2,30	11,00	0,14	4	●	–	–	●	●	●
SNHX11T3PZTNGP	11,00	2,70	11,00	0,14	4	–	–	–	●	–	●
SNHX1203PZTNGP	12,70	3,20	12,70	0,14	4	●	–	–	●	●	●
SNHX12L4PZTNGP	12,70	4,00	12,70	0,14	4	–	–	–	–	●	–
SNHX12L5PZTNGP	12,70	5,40	12,70	0,14	4	●	–	–	●	●	–

Recommended Starting Feeds

Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.F..GE	0,13	**0,42**	0,70	0,09	**0,30**	0,50	0,07	**0,23**	0,38	0,06	**0,20**	0,33	0,06	**0,18**	0,30	.F..GE
.T..GP	0,23	**0,47**	0,70	0,17	**0,34**	0,50	0,13	**0,25**	0,38	0,11	**0,22**	0,33	0,10	**0,20**	0,30	.T..GP
..T	0,23	**0,56**	0,82	0,17	**0,40**	0,59	0,13	**0,30**	0,44	0,11	**0,26**	0,38	0,10	**0,24**	0,35	..T

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

LN Slotting Cutter

Primary Application

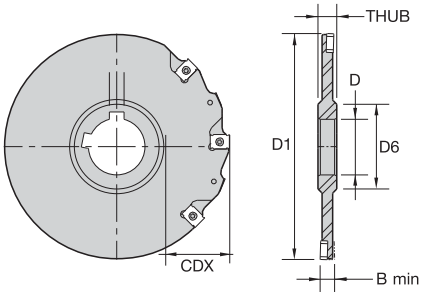
LN slotting cutters offer arbour and shell mill cutter options, groove widths from 6–13mm, and cutter diameters from 80–160mm. Easy to adjust radially in 0,50mm increments.



Features and Benefits

- Cutter available in arbour and shell mounts.
- Groove width 6–13mm.
- Groove width can be increased by 0,5mm or 1mm. Please consult the chart “Technical Information: Possible Insert Combinations”.
  NOTE: This involves changing inserts and insert screws.
- Easy width adjustment through insert thickness.
- Staggered internal keys.
- Positive chip grooves.
- Full side cutting.
- Neutral and positive chip forming inserts are standard.
- Four insert cutting edges.
- Requires only one spare part.

- 6–13mm slot width range.
- Easy width adjustment through insert thickness.
- Full side cutting.
- Neutral and positive chip forming inserts are standard.
- Four insert cutting edges.
- Two keyways for staggered mounting.
- Requires only one spare part.
- Base slot angle: 2°
- Maximum slot width tolerance: +/- 0,05mm



Side Two Insert



LN • Arbour Mount • Full-Side Cutting

order number	catalogue number	D1	D	D6	B min	CDX	THUB	Z	Z S	insert 1	kg
1131438	**80F08NS90LN12N06**	80	27	44	6	16	12,0	8	4	LNE_1235___	0,30
1131447	**80F08NS90LN12N08**	80	27	44	8	16	12,0	8	4	LNE_1245___	0,35
1150508	**100G10NS90LN12N06**	100	32	52	6	22	12,0	10	5	LNE_1235___	0,40
1130249	**100G10NS90LN12N08**	100	32	52	8	22	12,0	10	5	LNE_1245___	0,50
1130477	**125H12NS90LN12N06**	125	40	63	6	30	12,0	12	6	LN__1235	0,70
1130615	**160H16NS90LN12N06**	160	40	63	6	46	12,0	16	8	LNE_1235___	1,10
1130595	**160H15NS90LN12N10**	160	40	63	10	46	12,0	15	5	LNE_1245	1,60
1130608	**160H15NS90LN12N12**	160	40	63	12	46	12,0	15	5	LNE_1255___	1,60
1150527	**200J18NS90LN12N08 ***	200	50	75	8	60	12,0	18	9	LNE_1245___	2,00

NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

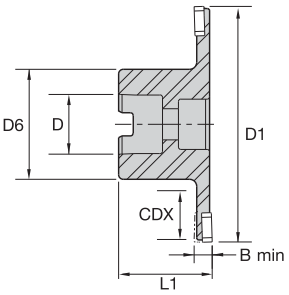
Spare Parts

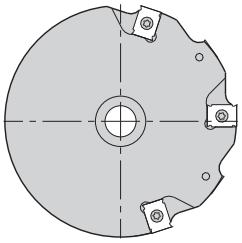




order number	D1	B min	insert screw	Nm	Torx driver
1131438	80	6	**MS1280**	3,0	**DT15**
1131447	80	8	**MS1282**	3,0	**DT15**
1150508	100	6	**MS1280**	3,0	**DT15**
1130249	100	8	**MS1282**	3,0	**DT15**
1130477	125	6	**MS1280**	3,0	**DT15**
1130615	160	6	**MS1280**	3,0	**DT15**
1130595	160	10	**MS1282**	3,0	**DT15**
1130608	160	12	**MS1284**	3,0	**DT15**
1150527	200	8	**MS1282**	3,0	**DT15**

- 6–11mm slot width range.
- Easy width adjustment through insert thickness.
- Right-hand and full-side cutting versions.
- Neutral and positive chip forming inserts are standard.
- Four insert cutting edges.
- Requires only one spare part.
- Base slot angle: 2°.
- Maximum slot width tolerance: +/- 0,05mm.







LN • Shell Mount • Full-Side Cutting

order number	catalogue number	D1	D	D6	B min	CDX	L1	Z	Z U	insert 1	kg
1131463	**80Y08RS90LN12N06**	80	22	40	6	16,00	50,0	8	4	LNE_1235___	0,65
1131472	**80Y08RS90LN12N08**	80	22	40	8	16,00	50,0	8	4	LNE_1245___	0,75
1130277	**100Y10RS90LN12N06**	100	27	50	6	22,00	50,0	10	5	LNE_1235___	1,00
1130283	**100Y10RS90LN12N08**	100	27	50	8	22,00	50,0	10	5	LNE_1245___	1,20
1130506	**125Y12RS90LN12N10**	125	40	70	10	26,00	50,0	12	4	LNE_1245___	1,50
1150511	**160Y16RS90LN12N06**	160	40	70	6	43,00	50,0	16	8	LNE_1235___	1,85
1150513	**160Y16RS90LN12N08**	160	40	70	8	43,00	50,0	16	8	LNE_1245___	2,15
1150524	**160Y15RS90LN12N10**	160	40	70	10	43,00	50,0	15	5	LNE_1245___	2,45

Spare Parts







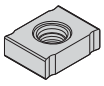
order number	D1	B min	insert screw	Nm	Torx driver
1131463	80	6	**MS1280**	3,0	**DT15**
1131472	80	8	**MS1282**	3,0	**DT15**
1130277	100	6	**MS1280**	3,0	**DT15**
1130283	100	8	**MS1282**	3,0	**DT15**
1130506	125	10	**MS1282**	3,0	**DT15**
1150511	160	6	**MS1280**	3,0	**DT15**
1150513	160	8	**MS1282**	3,0	**DT15**
1150524	160	10	**MS1282**	3,0	**DT15**

Insert Selection Guide

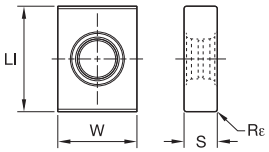
Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		←	→	toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	LNE..	KCPM40	**LNE..**	**KCPM40**	.S..GP	KCPM40
P3–P4	LNE..	KCPK30	**LNE..**	**KCPM40**	.S..GP	KCPM40
P5–P6	LNE..	KC725M	**.S..GP**	**KC725M**	.S..GP	KCPM40
M1–M2	LNE..	KC725M	**LNE..**	**KC725M**	.S..GP	KC725M
M3	LNE..	KC725M	**LNE..**	**KCPM40**	.S..GP	KCPM40
K1–K2	LNE..	KC520M	**LNE..**	**KCK15**	LNE..	KCK15
K3	LNE..	KC520M	**LNE..**	**KCK15**	LNE..	KCPK30
N1–N2	–	–	**–**	**–**	–	–
N3	–	–	**–**	**–**	–	–
S1–S2	LNE..	KC725M	**LNE..**	**KC725M**	.S..GP	KC725M
S3	LNE..	KC725M	**LNE..**	**KCPM40**	.S..GP	KCPM40
S4	LNE..	KC725M	**.S..GP**	**KC725M**	.S..GP	KC725M
H1	–	–	**–**	**–**	–	–

Slotting Mills • 90° LN Slot LNEU

- Light machining.
- Four cutting edges.



LNEU-R



LNEU-R

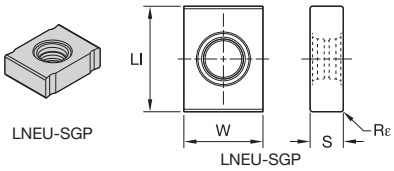
● first choice
○ alternate choice

P			●		●	●
M			●		○	○
K		●		●	○	
N						
S			●			
H						

LNEU-R

catalogue number	LI	W	S	Rε	hm	cutting edges	KC520M	KC725M	KCK15	KCPK30	KCPM40
LNEU1235R03 4	12,70	9,52	3,50	0,3	0,05	4	●	●	–	–	●
LNEU1240R03 4	12,70	9,52	4,00	0,3	0,05	4	●	●	–	–	●
LNEU1245R04	12,70	9,52	4,50	0,4	0,05	4	●	●	–	●	●
LNEU1250R04	12,70	9,52	5,00	0,4	0,04	4	–	●	–	–	–
LNEU1250R04	12,70	9,52	5,00	0,4	0,05	4	–	–	–	–	●
LNEU1255R04	12,70	9,52	5,50	0,4	0,04	4	–	●	–	–	●
LNEU1260R04	12,70	9,52	6,00	0,4	0,04	4	–	●	–	–	●
LNEU1240R08 4	12,70	9,52	4,00	0,8	0,04	4	●	●	–	–	●
LNEU1245R08	12,70	9,52	4,50	0,8	0,04	4	●	●	–	–	●
LNEU1250R08	12,70	9,52	5,00	0,8	0,04	4	–	●	–	–	–
LNEU1250R08	12,70	9,52	5,00	0,8	0,05	4	–	–	–	–	●
LNEU1255R08	12,70	9,52	5,50	0,8	0,04	4	●	●	–	–	●
LNEU1240R16 4	12,70	9,52	4,00	1,6	0,04	4	–	●	–	–	–
LNEU1245R16	12,70	9,52	4,50	1,6	0,04	4	●	●	–	–	–
LNEU1255R16	12,70	9,52	5,50	1,6	0,04	4	–	●	–	–	–
LNEU1245R32	12,70	9,52	4,50	3,2	0,04	4	●	●	–	–	–
LNEU1255R32	12,70	9,52	5,50	3,2	0,04	4	–	●	–	–	–

- Four cutting edges.
- Medium machining with chip groover.



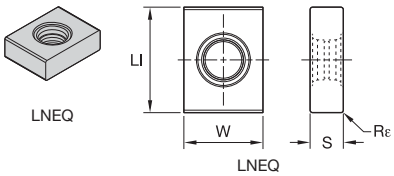
● first choice
○ alternate choice

P			●		●	●
M			●		○	○
K		●		●	○	
N						
S			●			
H						

LNEU-SGP

catalogue number	LI	W	S	Rε	hm	cutting edges	KC520M	KC725M	KCK15	KCPK30	KCPM40
LNEU1235R03SGP 4	12,70	9,52	3,50	0,3	0,09	4	–	●	–	–	–
LNEU1240R03SGP 4	12,70	9,52	4,00	0,3	0,09	4	–	●	–	–	–
LNEU1245R04SGP	12,70	9,52	4,50	0,4	0,09	4	–	●	–	–	–
LNEU1250R04SGP	12,70	9,52	5,00	0,4	0,09	4	–	●	–	–	–
LNEU1245R08SGP	12,70	9,52	4,50	0,8	0,09	4	–	●	–	–	●
LNEU1250R08SGP	12,70	9,52	5,00	0,8	0,09	4	–	●	–	–	–
LNEU1245R16SGP	12,70	9,52	4,50	1,6	0,09	4	–	●	–	–	–

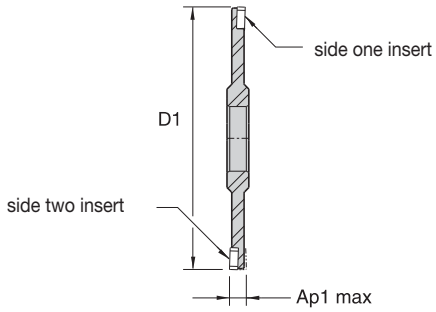
- Very strong geometry for roughing application.
- Four cutting edges.



LNEQ

catalogue number	LI	W	S	Rε	hm	cutting edges	KC520M	KC725M	KCK15	KCPK30	KCPM40
LNEQ1235R03 4	12,70	9,52	3,50	0,3	0,05	4	–	●	●	–	–
LNEQ1240R03 4	12,70	9,52	4,00	0,3	0,05	4	–	●	–	●	–
LNEQ1245R04	12,70	9,52	4,50	0,4	0,05	4	●	●	●	●	–
LNEQ1250R04	12,70	9,52	5,00	0,4	0,05	4	–	–	●	–	–
LNEQ1255R04	12,70	9,52	5,50	0,4	0,05	4	–	●	●	–	–
LNEQ1260R04	12,70	9,52	6,00	0,4	0,05	4	–	●	●	–	●

- LNEx narrow slotting 6–13mm slot width.
- Utilises wider inserts in standard cutters.
- Cutting width of this unique LNEx insert style for narrow slotting cutters can be adjusted.
- The width can be increased in increments of 0,5mm or 1mm.
- Refer to the insert combination in the table below for insert and screw selection.

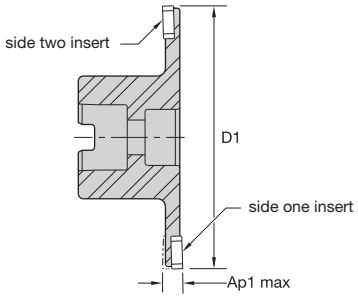


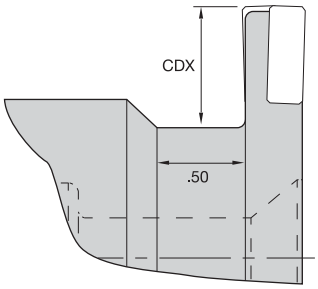
LN Slotting Cutter Widths: Adjust Width by Changing Inserts and Screws • Arbour Mount

catalogue number	D1	Ap1 max	Ap1 max (new)	side one insert*	screw**	side two insert*	screw**
80F08NS90LN12NO6	80	6	6.5	LNE1235	MS-1281	LNE1240	MS-2267
80F08NS90LN12NO6	80	6	7	LNE1240	MS-2267	LNE1240	MS-2267
80F08NS90LN12NO8	80	8	8.5	LNE1245	MS-1282	LNE1250	MS-1283
80F08NS90LN12NO8	80	8	9	LNE1250	MS-1283	LNE1250	MS-1283
100G10NS90LN12N06	100	6	6.5	LNE1235	MS-1281	LNE1240	MS-2267
100G10NS90LN12N06	100	6	7	LNE1240	MS-2267	LNE1240	MS-2267
100G10NS90LN12N08	100	8	8.5	LNE1245	MS-1282	LNE1250	MS-1283
100G10NS90LN12N08	100	8	9	LNE1250	MS-1283	LNE1250	MS-1283
125H12NS90LN12N06	125	6	6.5	LNE1235	MS-1281	LNE1240	MS-2267
125H12NS90LN12N06	125	6	7	LNE1240	MS-2267	LNE1240	MS-2267
125H12NS90LN12N10	125	10	10.5	LNE1245	MS-1282	LNE1250	MS-1283
125H12NS90LN12N10	125	10	11	LNE1250	MS-1283	LNE1250	MS-1283
160H16NS90LN12N06	160	6	6.5	LNE1235	MS-1281	LNE1240	MS-2267
160H16NS90LN12N06	160	6	7	LNE1240	MS-2267	LNE1240	MS-2267
160H16NS90LN12N08	160	8	8.5	LNE1245	MS-1282	LNE1250	MS-1283
160H16NS90LN12N08	160	8	9	LNE1250	MS-1283	LNE1250	MS-1283
160H15NS90LN12N10	160	10	10.5	LNE1245	MS-1282	LNE1250	MS-1283
160H15NS90LN12N10	160	10	11	LNE1250	MS-1283	LNE1250	MS-1283
160H15NS90LN12N12	160	12	12.5	LNE1255	MS-1284	LNE1260	MS-1285
160H15NS90LN12N12	160	12	13	LNE1260	MS-1285	LNE1260	MS-1285
200J18NS90LN12N06	200	6	6.5	LNE1235	MS-1281	LNE1240	MS-2267
200J18NS90LN12N06	200	6	7	LNE1240	MS-2267	LNE1240	MS-2267
200J18NS90LN12N08	200	8	8.5	LNE1245	MS-1282	LNE1250	MS-1283
200J18NS90LN12N08	200	8	9	LNE1250	MS-1283	LNE1250	MS-1283
200J18NS90LN12N10	200	10	10.5	LNE1245	MS-1282	LNE1250	MS-1283
200J18NS90LN12N10	200	10	11	LNE1250	MS-1283	LNE1250	MS-1283
200J18NS90LN12N12	200	12	12.5	LNE1255	MS-1284	LNE1260	MS-1285
200J18NS90LN12N12	200	12	13	LNE1260	MS-1285	LNE1260	MS-1285

* Caution: Variation in cutting width range limited to one size (thickness) greater than the standard insert thickness.
** When changing to a wider insert thickness, use the necessary longer screw; see chart for detail.
NOTE: When cutters have 3 rows of inserts, the above table only refers to the outer insert on both sides of the cutter.
When using inserts with a radius of 2,40mm or greater there is a need to modify the insert pocket; modify to 2.50 x 45° chamfer.

- LNEx narrow slotting 6–11mm slot width.
- Utilises wider inserts in standard cutters.
- Cutting width of this unique LNEx insert style for narrow slotting cutters can be adjusted.
- The width can be increased in increments of 0,5mm or 1mm.
- Refer to the insert combinations in the table below for insert selection.





LN Slotting Cutter Widths: Adjust Width by Changing Inserts and Screws • Shell Mill

catalogue number	D1	Ap1 max	Ap1 max (new)	side one insert*	screw**	side two insert*	screw**
80Y08RS90LN12N06	80	6	6.5	LNE1235	MS-1280	LNE1240	MS-1281
80Y08RS90LN12N06	80	6	7	LNE1240	MS-1281	LNE1240	MS-1281
80Y08RS90LN12N08	80	8	8.5	LNE1245	MS-1282	LNE1250	MS-1283
80Y08RS90LN12N08	80	8	9	LNE1250	MS-1283	LNE1250	MS-1283
100Y10RS90LN12N06	100	6	6.5	LNE1235	MS-1280	LNE1240	MS-1281
100Y10RS90LN12N06	100	6	7	LNE1240	MS-1281	LNE1240	MS-1281
100Y10RS90LN12N08	100	8	8.5	LNE1245	MS-1282	LNE1250	MS-1283
100Y10RS90LN12N08	100	8	9	LNE1250	MS-1283	LNE1250	MS-1283
125Y12RS90LN12N10	125	10	10.5	LNE1245	MS-1282	LNE1250	MS-1283
125Y12RS90LN12N10	125	10	11	LNE1250	MS-1283	LNE1250	MS-1283
160Y16RS90LN12N06	160	6	6.5	LNE1235	MS-1280	LNE1240	MS-1281
160Y16RS90LN12N06	160	6	7	LNE1240	MS-1281	LNE1240	MS-1281
160Y16RS90LN12N08	160	8	8.5	LNE1245	MS-1282	LNE1250	MS-1283
160Y16RS90LN12N08	160	8	9	LNE1250	MS-1283	LNE1250	MS-1283
160Y16RS90LN12N10	160	10	10.5	LNE1245	MS-1282	LNE1250	MS-1283
160Y16RS90LN12N10	160	10	11	LNE1250	MS-1283	LNE1250	MS-1283

Example: Cutting Width of 6,50mm

catalogue number	D1	Ap1 max	Ap1 max (new)	side one insert*	screw**	side two insert*	screw**
80Y08RS90LN12N06	80	6	6.5	LNE1235	MS-1280	LNE1240	MS-1281

* Caution: Variation in cutting width range limited to one size (thickness) greater than the standard insert thickness.
** When changing to a wider insert thickness, use the necessary longer screw; see chart for detail.
NOTE: When cutters have 3 rows of inserts, the above table only refers to the outer insert on both sides of the cutter.
When using inserts with a radii of 2,40mm or greater there is a need to modify the insert pocket; modify to 2.50 x 45° chamfer.

Recommended Starting Feeds

Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
...	0,17	**0,47**	0,70	0,12	**0,34**	0,50	0,09	**0,26**	0,38	0,08	**0,22**	0,33	0,07	**0,20**	0,30	...
.S..GP	0,23	**0,52**	0,81	0,17	**0,37**	0,58	0,13	**0,28**	0,43	0,11	**0,24**	0,38	0,10	**0,22**	0,35	.S..GP

NOTE: Use "Light Machining" values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

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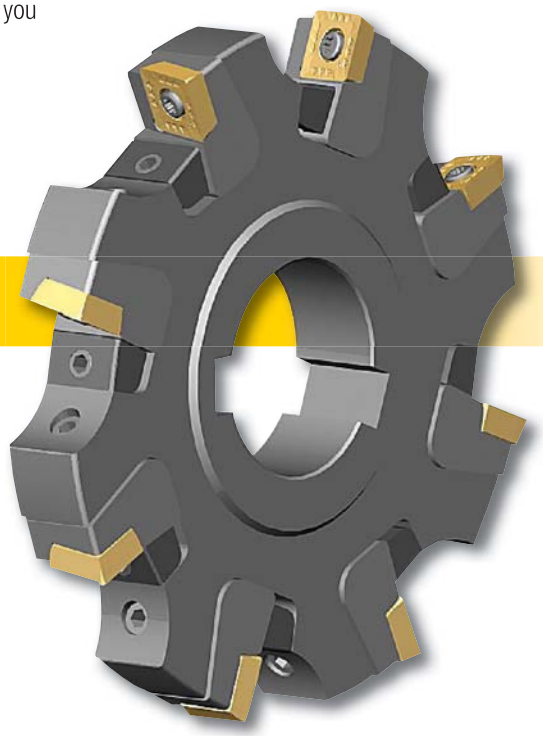
KSSM™ Slotting Cutter

Primary Application

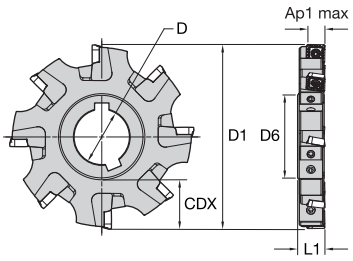
Cutters available in fixed and adjustable groove widths: Cutters available in arbour and shell mounts, as well as in fixed and adjustable groove widths, with insert grades and geometries for most materials, KSSM fixed-width slotting cutters are a cost effective solution for the general engineering market. Very precise adjustments to achieve consistent widths are possible with the variable width and enable you to change the tool from right hand to left hand with a change of cartridge.



Features and Benefits

- Cutters available in arbour and shell mounts, as well as in fixed and adjustable groove widths.
- Maximum groove widths:
  - Fixed cutters IC 10: 9,1mm and 15,8mm.
  - Fixed cutters IC 12: 11,7mm and 19,8mm.
  - Adjustable cutters IC 10: 14–18mm.
  - Adjustable cutters IC 12: 18–23,30mm.
- Rapid adjustment mechanism.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Faceted inserts for superior surface finish.
- Cutter diameter range is 100–315mm.
- Insert corner radii from 0,4–6,35mm.

- Right-hand and left-hand cutters with 9,1mm width of cut.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Various radii available.
- Faceted inserts for superior surface finishes.





Arbour Mount • 10mm IC • Right Hand

order number	catalogue number	D1	D	D6	CDX	L1	Ap1 max	Z	Z S	max RPM	kg
3330528	**100G10RP90SP10 ***	100	32	46,8	26,3	16,0	9,1	10	10	17200	0,54
3330531	**125H11RP90SP10 ***	125	40	54,8	34,8	16,0	9,1	11	11	15400	0,86
3330974	**160H11RP90SP10**	160	40	54,8	52,6	16,0	9,1	11	11	13660	1,57
3330977	**200J13RP90SP10**	200	50	68,8	65,3	16,0	9,1	13	13	12200	2,56

NOTE: For superior surface finish, use right-hand inserts.
*Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Arbour Mount • 10mm IC • Left Hand

order number	catalogue number	D1	D	D6	CDX	L1	Ap1 max	Z	Z S	max RPM	kg
3330975	**160H11LP90SP10**	160	40	54,8	52,6	16,0	9,1	11	11	13660	1,57
3330978	**200J13LP90SP10**	200	50	68,8	65,3	16,0	9,1	13	13	12200	2,56

NOTE: For superior surface finish, use left-hand inserts.
Insert radii ≥1,6mm (.062") has no facet.

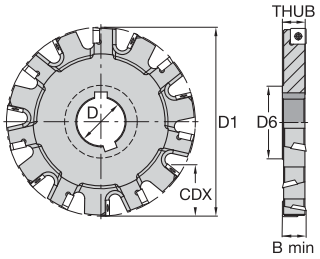
Spare Parts





D1	insert screw	Nm	Torx Plus driver
100	**MS2148**	2,0	**DT9IP**
125	**MS2148**	2,0	**DT9IP**
160	**MS2148**	2,0	**DT9IP**
200	**MS2148**	2,0	**DT9IP**

- Neutral (full slotting) cutters.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Wide choice of insert radii.
- Faceted inserts for superior surface finishes.





Arbour Mount • 10mm IC • Neutral (Full Slotting)

order number	catalogue number	D1	D	D6	CDX	THUB	B min	Z	Z S	max RPM	kg
3330527	**100G10NP90SP10N16K ***	100	32	46,8	26,4	13,9	15,83	10	5	17200	0,46
3330530	**125H12NP90SP10N16K**	125	40	54,8	34,9	13,9	15,83	12	6	15400	0,76
3330973	**160H12NP90SP10N16K**	160	40	54,8	52,2	13,9	15,83	12	6	13660	1,40
3330976	**200J14NP90SP10N16K**	200	50	68,8	65,2	13,9	15,83	14	7	12200	2,26

NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Spare Parts

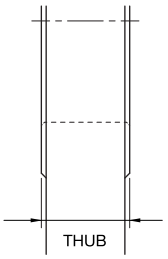


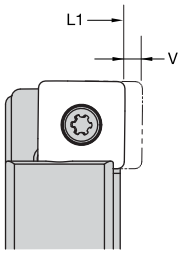


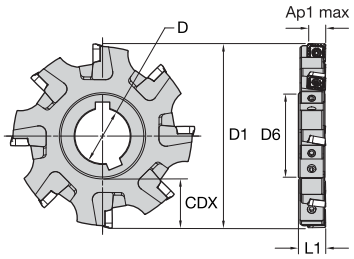
D1	insert screw	Nm	Torx Plus driver
100	**MS2148**	2,0	**DT9IP**
125	**MS2148**	2,0	**DT9IP**
160	**MS2148**	2,0	**DT9IP**
200	**MS2148**	2,0	**DT9IP**

NOTE: For superior surface finish, use right- and left-hand inserts.
Insert radii ≥1,6mm (.062") has no facet.

- Rapid adjustment and setting via unique cam adjustment mechanism.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Wide choice of insert radii.
- Two keyways for staggered mounting.
- Wiper insert facets for superior surface finishes.







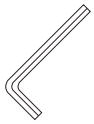


Arbour Mount • Half-Side Cutting • Right Hand

order number	catalogue number	D1	D	D6	CDX	L1	THUB	V	Ap1 max	Z	Z S	max RPM	kg
2442596	**100G06RK90SP10N14K**	100	32	46,8	25,9	13,9	13,9	1,0	9,1	6	6	17250	0,50
2442602	**125H08RK90SP10N14K**	125	40	54,8	34,4	13,9	13,9	1,0	9,1	8	8	15450	0,80
2443456	**160H10RK90SP10N14K**	160	40	54,8	51,9	13,9	13,9	1,0	9,1	10	10	13650	1,50

Spare Parts





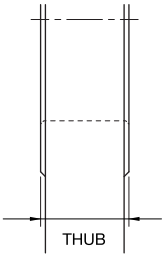


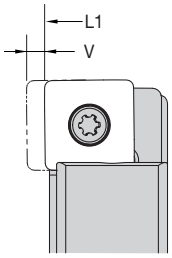


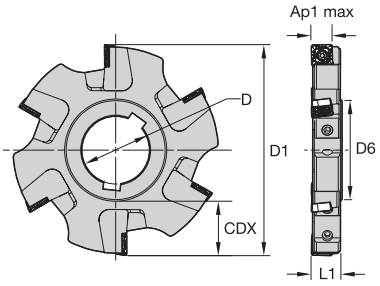


D1	cartridge right-hand	wedge	cam pin wrench	insert screw	Nm	Torx Plus wrench	cam pin	wedge wrench	wedge screw
100	**RK90SP1014**	**W14**	**MW25**	**MS2148**	2,0	**TTP9**	**CP1416**	**THW3M**	**STCM32**
125	**RK90SP1014**	**W14**	**MW25**	**MS2148**	2,0	**TTP9**	**CP1416**	**THW3M**	**STCM11**
160	**RK90SP1014**	**W14**	**MW25**	**MS2148**	2,0	**TTP9**	**CP1416**	**THW3M**	**STCM11**

- Rapid adjustment and setting via unique cam adjustment mechanism.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Wide choice of insert radii.
- Two keyways for staggered mounting.
- Wiper insert facets for superior surface finishes.









Arbour Mount • Half-Side Cutting • Left Hand

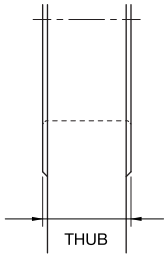
order number	catalogue number	D1	D	D6	CDX	L1	THUB	V	Ap1 max	Z	Z S	max RPM	kg
2442597	**100G06LK90SP10N14K**	100	32	46,8	25,9	13,9	13,9	1,0	9,1	6	6	17250	0,50
2443457	**160H10LK90SP10N14K**	160	40	54,8	51,9	13,9	13,9	1,0	9,1	10	10	13650	1,50

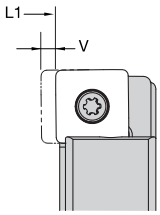
Spare Parts

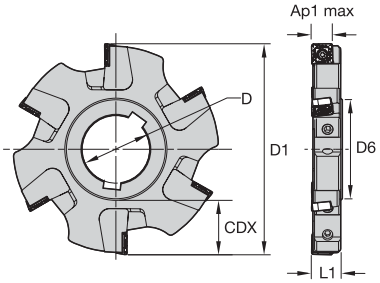


D1	cartridge left-hand	wedge	cam pin wrench	insert screw	Nm	Torx Plus wrench	cam pin	wedge wrench	wedge screw
100	**LK90SP1014**	**W14**	**MW25**	**MS2148**	2,0	**TTP9**	**CP1416**	**THW3M**	**STCM32**
160	**LK90SP1014**	**W14**	**MW25**	**MS2148**	2,0	**TTP9**	**CP1416**	**THW3M**	**STCM11**

- Rapid adjustment and setting via unique cam adjustment mechanism.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Wide choice of insert radii.
- Two keyways for staggered mounting.
- Wiper insert facets for superior surface finishes.









Arbour Mount • Half-Side Cutting • Left Hand

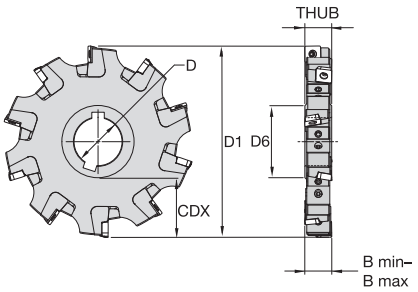
order number	catalogue number	D1	D	D6	CDX	L1	THUB	V	Ap1 max	Z	Z S	max RPM	kg
2443484	**200J14LK90SP10N16K**	200	50	68,8	64,9	15,9	15,9	1,0	9,1	14	14	12200	2,80
2443505	**250J18LK90SP10N16K**	250	50	68,8	89,9	15,9	15,9	1,0	9,1	18	18	10900	4,70

Spare Parts



D1	cartridge left-hand	wedge	cam pin wrench	insert screw	Nm	Torx Plus wrench	cam pin	wedge wrench	wedge screw
200	**LK90SP1016**	**W16**	**MW25**	**MS2148**	2,0	**TTP9**	**CP1416**	**THW3M**	**STCM11**
250	**LK90SP1016**	**W16**	**MW25**	**MS2148**	2,0	**TTP9**	**CP1416**	**THW3M**	**STCM11**

- Rapid adjustment and setting via unique cam adjustment mechanism.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Wide choice of insert radii.
- Two keyways for staggered mounting.
- Wiper insert facets for superior surface finishes.

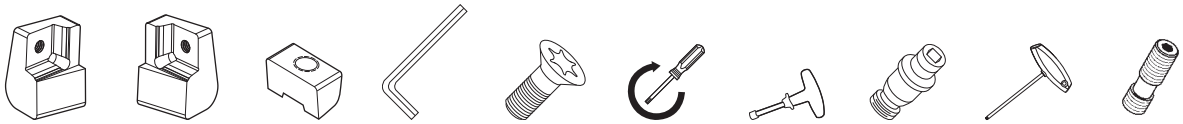




Arbour Mount Slotting Cutter • 14–16mm Adjustment Range

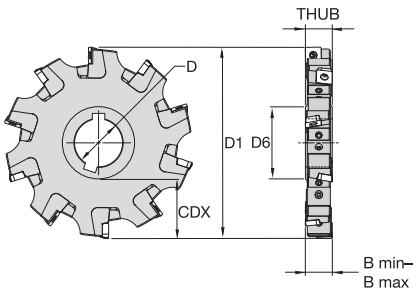
order number	catalogue number	D1	D	D6	CDX	THUB	B min	B max	Z	Z S	max RPM	kg
2442595	**100G06NK90SP10N14K**	100	32	46,8	25,9	13,9	14	16	6	3	17250	0,50
2442601	**125H08NK90SP10N14K**	125	40	54,8	34,4	13,9	14	16	8	4	15450	0,80
2443455	**160H10NK90SP10N14K**	160	40	54,8	51,9	13,9	14	16	10	5	13650	1,50
2443479	**200J14NK90SP10N14K**	200	50	68,8	64,9	13,9	14	16	14	7	12200	2,40

Spare Parts



D1	cartridge left-hand	cartridge right-hand	wedge	cam pin wrench	insert screw	Nm	Torx Plus wrench	cam pin	wedge wrench	wedge screw
100	**LK90SP1014**	**RK90SP1014**	**W14**	**MW25**	**MS2148**	2,0	**TTP9**	**CP1416**	**THW3M**	**STCM32**
125	**LK90SP1014**	**RK90SP1014**	**W14**	**MW25**	**MS2148**	2,0	**TTP9**	**CP1416**	**THW3M**	**STCM11**
160	**LK90SP1014**	**RK90SP1014**	**W14**	**MW25**	**MS2148**	2,0	**TTP9**	**CP1416**	**THW3M**	**STCM11**
200	**LK90SP1014**	**RK90SP1014**	**W14**	**MW25**	**MS2148**	2,0	**TTP9**	**CP1416**	**THW3M**	**STCM11**

- Rapid adjustment and setting via unique cam adjustment mechanism.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Wide choice of insert radii.
- Two keyways for staggered mounting.
- Wiper insert facets for superior surface finishes.

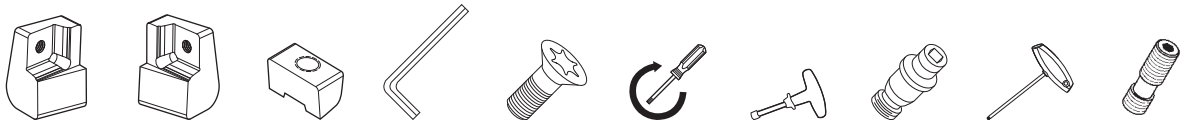




Arbour Mount Slotting Cutter • 16–18mm Adjustment Range

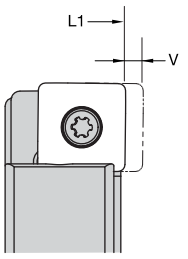
order number	catalogue number	D1	D	D6	CDX	THUB	B min	B max	Z	Z S	max RPM	kg
2443434	**125H08NK90SP10N16K**	125	40	54,8	34,4	15,9	16	18	8	4	15450	1,00
2443458	**160H10NK90SP10N16K**	160	40	54,8	51,9	15,9	16	18	10	5	13650	1,80
2443503	**250J18NK90SP10N16K**	250	50	68,8	89,9	15,9	16	18	18	9	10900	4,70
2443521	**315K20NK90SP10N16K**	315	60	83,8	114,9	15,9	16	18	20	10	9700	7,70

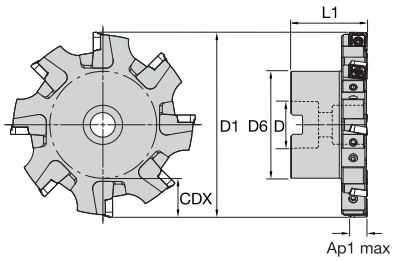
Spare Parts



D1	cartridge left-hand	cartridge right-hand	wedge	cam pin wrench	insert screw	Nm	Torx Plus wrench	cam pin	wedge wrench	wedge screw
125	**LK90SP1016**	**RK90SP1016**	**W16**	**MW25**	**MS2148**	2,0	**TTP9**	**CP1416**	**THW3M**	**STCM11**
160	**LK90SP1016**	**RK90SP1016**	**W16**	**MW25**	**MS2148**	2,0	**TTP9**	**CP1416**	**THW3M**	**STCM11**
250	**LK90SP1016**	**RK90SP1016**	**W16**	**MW25**	**MS2148**	2,0	**TTP9**	**CP1416**	**THW3M**	**STCM11**
315	**LK90SP1016**	**RK90SP1016**	**W16**	**MW25**	**MS2148**	2,0	**TTP9**	**CP1416**	**THW3M**	**STCM11**

- Rapid adjustment and setting via unique cam adjustment mechanism.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Wide choice of insert radii.
- Wiper insert facets for superior surface finishes.







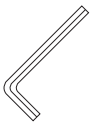
Shell Mount • Half-Side Cutting • Right Hand

order number	catalogue number	D1	D	D6	CDX	L1	V	Ap1 max	Z	Z S	max RPM	kg
2442599	**100Y06RK90SP10N14K** *	100	27	48,0	24,4	50,8	1,0	9,1	6	6	17250	0,90
2443444	**125Y08RK90SP10N14K**	125	32	58,0	31,9	50,8	1,0	9,1	8	8	15450	1,40
2443468	**160Y10RK90SP10N14K**	160	40	70,0	43,4	50,8	1,0	9,1	10	10	13650	2,00

NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Spare Parts





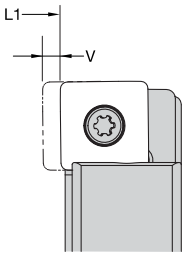


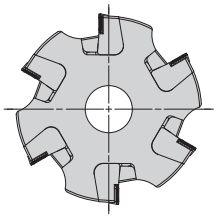


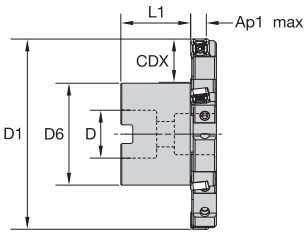



D1	cartridge right-hand	wedge	cam pin wrench	insert screw	Nm	Torx Plus wrench	cam pin	wedge wrench	wedge screw	socket-head cap screw
100	**RK90SP1014**	**W14**	**MW25**	**MS2148**	2,0	**TTP9**	**CP1416**	**THW3M**	**STCM11**	**MS1556**
125	**RK90SP1014**	**W14**	**MW25**	**MS2148**	2,0	**TTP9**	**CP1416**	**THW3M**	**STCM11**	**MS1559**
160	**RK90SP1014**	**W14**	**MW25**	**MS2148**	2,0	**TTP9**	**CP1416**	**THW3M**	**STCM11**	**–**

- Rapid adjustment and setting via unique cam adjustment mechanism.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Wide choice of insert radii.
- Wiper insert facets for superior surface finishes.





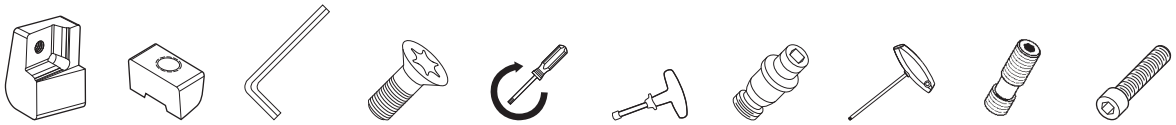




Shell Mount • Half-Side Cutting • Left Hand

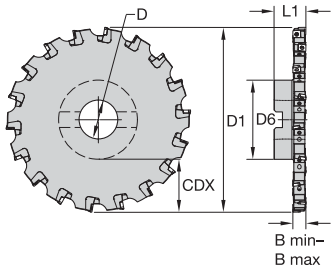
order number	catalogue number	D1	D	D6	CDX	L1	V	Ap1 max	Z	Z S	max RPM	kg
2442600	**100Y06LK90SP10N14K**	100	27	48,0	24,4	36,8	1,0	9,1	6	6	17250	0,90
2443445	**125Y08LK90SP10N14K**	125	32	58,0	31,9	36,8	1,0	9,1	8	8	15450	1,40
2443469	**160Y10LK90SP10N14K**	160	40	70,0	43,4	36,8	1,0	9,1	10	10	13650	2,00
2443493	**200Y14LK90SP10N14K**	200	40	90,0	53,4	36,8	1,0	9,1	14	14	12200	3,70

Spare Parts



D1	cartridge left-hand	wedge	cam pin wrench	insert screw	Nm	Torx Plus wrench	cam pin	wedge wrench	wedge screw	socket-head cap screw
100	**LK90SP1014**	**W14**	**MW25**	**MS2148**	2,0	**TTP9**	**CP1416**	**THW3M**	**STCM11**	**MS1556**
125	**LK90SP1014**	**W14**	**MW25**	**MS2148**	2,0	**TTP9**	**CP1416**	**THW3M**	**STCM11**	**MS1559**
160	**LK90SP1014**	**W14**	**MW25**	**MS2148**	2,0	**TTP9**	**CP1416**	**THW3M**	**STCM11**	–
200	**LK90SP1014**	**W14**	**MW25**	**MS2148**	2,0	**TTP9**	**CP1416**	**THW3M**	**STCM11**	–

- Rapid adjustment and setting via unique cam adjustment mechanism.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Wide choice of insert radii.
- Wiper insert facets for superior surface finishes.





Shell Mount Slotting Cutters • 14–16mm Adjustment Range

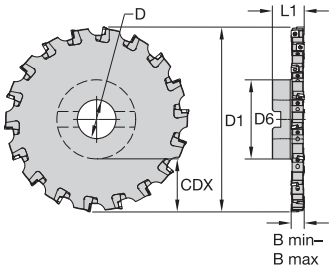
order number	catalogue number	D1	D	D6	CDX	L1	V	B min	B max	Z	Z S	max RPM	kg
2442598	**100Y06NK90SP10N14K**	100	27	48,0	24,4	50,8	1,0	14	16	6	3	17250	0,90
2443443	**125Y08NK90SP10N14K**	125	32	58,0	31,9	50,8	1,0	14	16	8	4	15450	1,40
2443467	**160Y10NK90SP10N14K**	160	40	70,0	43,4	50,8	1,0	14	16	10	5	13650	2,00
2443491	**200Y14NK90SP10N14K**	200	40	90,0	53,4	50,8	1,0	14	16	14	7	12200	3,70

Spare Parts



D1	cartridge left-hand	cartridge right-hand	wedge	cam pin wrench	insert screw	Nm	Torx Plus wrench	cam pin	wedge wrench	wedge screw	socket-head cap screw
100	**LK90SP1014**	**RK90SP1014**	**W14**	**MW25**	**MS2148**	2,0	**TTP9**	**CP1416**	**THW3M**	**STCM11**	**MS1556**
125	**LK90SP1014**	**RK90SP1014**	**W14**	**MW25**	**MS2148**	2,0	**TTP9**	**CP1416**	**THW3M**	**STCM11**	**MS1559**
160	**LK90SP1014**	**RK90SP1014**	**W14**	**MW25**	**MS2148**	2,0	**TTP9**	**CP1416**	**THW3M**	**STCM11**	–
200	**LK90SP1014**	**RK90SP1014**	**W14**	**MW25**	**MS2148**	2,0	**TTP9**	**CP1416**	**THW3M**	**STCM11**	–

- Rapid adjustment and setting via unique cam adjustment mechanism.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Wide choice of insert radii.
- Wiper insert facets for superior surface finishes.



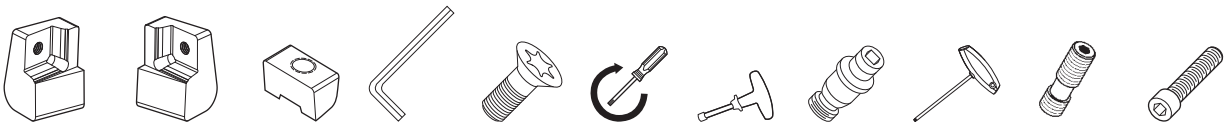


Shell Mount Slotting Cutters • 16–18mm Adjustment Range

order number	catalogue number	D1	D	D6	CDX	L1	V	B min	B max	Z	Z S	max RPM	kg
2443446	**125Y08NK90SP10N16K ***	125	32	58,0	31,9	50,8	1,0	16	18	8	4	15450	1,60
2443470	**160Y10NK90SP10N16K**	160	40	70,0	43,4	50,8	1,0	16	18	10	5	13650	2,20
2443494	**200Y14NK90SP10N16K ***	200	40	90,0	53,4	50,8	1,0	16	18	14	7	12200	4,10
2443512	**250Y18NK90SP10N16K**	250	60	130,0	58,4	50,8	1,0	16	18	18	9	10900	6,40
2443530	**315Y20NK90SP10N16K**	315	60	130,0	90,9	50,8	1,0	16	18	20	10	9700	9,50

NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Spare Parts



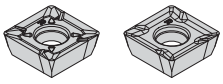
D1	cartridge left-hand	cartridge right-hand	wedge	cam pin wrench	insert screw	Nm	Torx Plus wrench	cam pin	wedge wrench	wedge screw	socket-head cap screw
125	**LK90SP1016**	**RK90SP1016**	**W16**	**MW25**	**MS2148**	2,0	**TTP9**	**CP1416**	**THW3M**	**STCM11**	**MS1559**
160	**LK90SP1016**	**RK90SP1016**	**W16**	**MW25**	**MS2148**	2,0	**TTP9**	**CP1416**	**THW3M**	**STCM11**	**–**
200	**LK90SP1016**	**RK90SP1016**	**W16**	**MW25**	**MS2148**	2,0	**TTP9**	**CP1416**	**THW3M**	**STCM11**	**–**
250	**LK90SP1016**	**RK90SP1016**	**W16**	**MW25**	**MS2148**	2,0	**TTP9**	**CP1416**	**THW3M**	**STCM11**	**–**
315	**LK90SP1016**	**RK90SP1016**	**W16**	**MW25**	**MS2148**	2,0	**TTP9**	**CP1416**	**THW3M**	**STCM11**	**–**

Insert Selection Guide

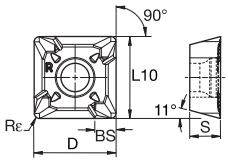
Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		◄——►		toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.E..LD2	KCPM40	**.E..GB2**	**KCPM40**	.S..GB2	KCPK30
P3–P4	.E..LD2	KCPM40	**.E..GB2**	**KCPK30**	.S..GB2	KCPK30
P5–P6	.E..LD2	KC725M	**.E..GB2**	**KC725M**	.S..GB2	KC725M
M1–M2	.E..LD2	KC725M	**.E..GB2**	**KC725M**	.S..GB2	KC725M
M3	.E..LD2	KCPM40	**.E..GB2**	**KCPM40**	.S..GB2	KC725M
K1–K2	.E..LD2	KC520M	**.E..GB2**	**KCK15**	.S..GB2	KCK15
K3	.E..LD2	KC520M	**.E..GB2**	**KC520M**	.S..GB2	KC520M
N1–N2	.F..LE	KC410M	**.F..LE**	**KC410M**	.F..LE	KC410M
N3	.F..LE	KC410M	**.F..LE**	**KC410M**	.F..LE	KC410M
S1–S2	.E..LD2	KC725M	**.E..GB2**	**KC725M**	.S..GB2	KC725M
S3	.E..LD2	KCPM40	**.E..GB2**	**KCPM40**	.S..GB2	KC725M
S4	.E..LD2	KC725M	**.E..GB2**	**KC725M**	.S..GB2	KC725M
H1	–	–	**–**	**–**	–	–

Indexable Inserts for KSSM™ SP.T10T3...

- Light-duty insert.
- Four cutting edges.



SPCT-LD2 SPCT-LE



SPCT-LD2
SPCT-LE

● first choice
○ alternate choice

		KC410M	KC520M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KTPK20
P				●		●	●		
M				●		○	○	○	
K			●		●	○	○		●
N		●							
S								●	
H									

SPCT-LD2

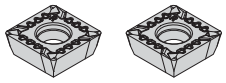
catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KTPK20
SPCT10T304PPELLD2	10	3,97	10,00	2,70	0,4	0,04	4	–	–	●	–	–	–	–	–
SPCT10T304PPERLD2	10	3,97	10,00	2,70	0,4	0,04	4	–	–	●	–	–	–	–	–
SPCT10T3PPELLD2	10	3,97	10,00	2,70	0,8	0,04	4	–	–	●	–	–	–	–	–
SPCT10T3PPERLD2	10	3,97	10,00	2,70	0,8	0,04	4	–	●	●	–	–	●	–	–
SPCT10T312PPELLD2	10	3,97	10,00	2,70	1,2	0,04	4	–	–	●	–	–	–	–	–
SPCT10T312PPERLD2	10	3,97	10,00	2,70	1,2	0,04	4	–	–	●	–	–	–	–	–
SPCT10T316ENLD2	10	3,97	10,00	–	1,6	0,04	4	–	–	●	–	–	–	●	–
SPCT10T320ENLD2	10	3,97	10,00	–	2,0	0,04	4	–	–	●	–	–	–	–	–

- Light-duty insert.
- Four cutting edges.

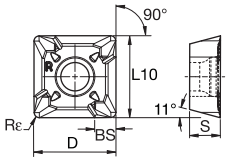
SPCT-LE

catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KTPK20
SPCT10T304PPFLLE	10	3,97	10,00	2,70	0,4	0,02	4	●	–	–	–	–	–	–	–
SPCT10T304PPFRLE	10	3,97	10,00	2,70	0,4	0,02	4	●	–	–	–	–	–	–	–
SPCT10T3PPFLLE	10	3,97	10,00	2,70	0,8	0,02	4	●	–	–	–	–	–	–	–
SPCT10T3PPFRLE	10	3,97	10,00	2,70	0,8	0,02	4	●	–	–	–	–	–	–	–
SPCT10T312PPFRLE	10	3,97	10,00	2,70	1,2	0,02	4	●	–	–	–	–	–	–	–
SPCT10T320FNLE	10	3,97	10,00	–	2,0	0,02	4	●	–	–	–	–	–	–	–

- Medium to heavy machining.
- Four cutting edges.



SPET-GB2 SPPT-GB2



SPET-GB2
SPPT-GB2

● first choice
○ alternate choice

		KC410M	KC520M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KTPK20
P				●		●	●		
M				●		○	○	○	
K			●		●	○	○		●
N		●							
S								●	
H									

SPET-GB2

catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KTPK20
SPET10T304PPELGB2	10	3,97	10,00	2,70	0,4	0,08	4	–	–	●	●	●	–	–	–
SPET10T304PPERGB2	10	3,97	10,00	2,70	0,4	0,08	4	–	–	●	●	●	–	–	–
SPET10T3PPELGB2	10	3,97	10,00	2,70	0,8	0,08	4	–	●	●	●	●	–	–	–
SPET10T3PPERGB2	10	3,97	10,00	2,70	0,8	0,08	4	–	●	●	●	●	●	–	–
SPET10T3PPSLGB2	10	3,97	10,00	2,70	0,8	0,13	4	–	–	●	–	●	–	–	–
SPET10T3PPSRGB2	10	3,97	10,00	2,70	0,8	0,13	4	–	●	●	●	●	–	–	–

- Four cutting edges.

SPPT-GB2

catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KTPK20
SPPT10T3PPERGB2	10	3,97	10,00	2,70	0,8	0,08	4	–	–	–	●	●	–	–	–
SPPT10T3PPSRGB2	10	3,97	10,00	2,70	0,8	0,13	4	–	–	–	●	●	–	–	●

Recommended Starting Feeds

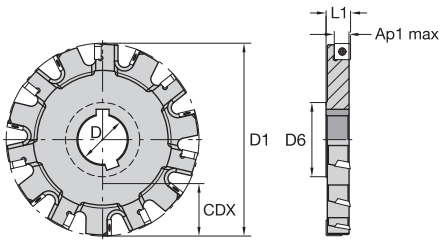
Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.F..LE	0,12	**0,42**	0,70	0,08	**0,30**	0,50	0,06	**0,23**	0,38	0,06	**0,20**	0,33	0,05	**0,18**	0,30	.F..LE
.F..LD	0,12	**0,42**	0,70	0,08	**0,30**	0,50	0,06	**0,23**	0,38	0,06	**0,20**	0,33	0,05	**0,18**	0,30	.F..LD
.E..LD2	0,12	**0,46**	0,81	0,09	**0,33**	0,58	0,07	**0,25**	0,43	0,06	**0,22**	0,38	0,05	**0,20**	0,35	.E..LD2
.E..LD	0,17	**0,47**	0,82	0,12	**0,34**	0,59	0,09	**0,26**	0,44	0,08	**0,22**	0,38	0,07	**0,20**	0,35	.E..LD
.E..GB2	0,23	**0,53**	0,89	0,17	**0,38**	0,64	0,13	**0,29**	0,48	0,11	**0,25**	0,41	0,10	**0,23**	0,38	.E..GB2
.S..GB	0,23	**0,59**	0,95	0,17	**0,43**	0,68	0,13	**0,32**	0,51	0,11	**0,28**	0,44	0,10	**0,25**	0,41	.S..GB
.S..GB2	0,23	**0,59**	0,95	0,17	**0,43**	0,68	0,13	**0,32**	0,51	0,11	**0,28**	0,44	0,10	**0,25**	0,41	.S..GB2
.S..GN	0,23	**0,59**	0,95	0,17	**0,43**	0,68	0,13	**0,32**	0,51	0,11	**0,28**	0,44	0,10	**0,25**	0,41	.S..GN

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

- Right- and left-hand cutters.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Wide choice of insert radii.
- Faceted inserts for superior surface finishes.





Arbour Mount • 12mm IC • Right Hand

order number	catalogue number	D1	D	D6	CDX	L1	Ap1 max	Z	Z S	max RPM	kg
3330984	**160H12RP90SD12**	160	40	54,8	52,6	20,0	11,7	12	12	9170	1,96
3330987	**200J14RP90SD12**	200	50	68,8	65,6	20,0	11,7	14	14	8210	3,18
3330990	**250J16RP90SD12 ***	250	50	68,8	90,6	20,0	11,7	16	16	7300	5,29

NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Arbour Mount • 12mm IC • Left Hand

order number	catalogue number	D1	D	D6	CDX	L1	Ap1 max	Z	Z S	max RPM	kg
3330985	**160H12LP90SD12**	160	40	54,8	52,6	20,0	11,7	12	12	9170	1,96
3330988	**200J14LP90SD12**	200	50	68,8	65,6	20,0	11,7	14	14	8210	3,18
3330991	**250J16LP90SD12 ***	250	50	68,8	90,6	20,0	11,7	16	16	7300	5,29

NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Spare Parts

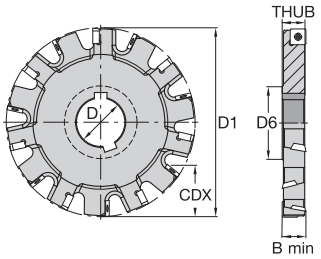




D1	insert screw	Nm	Torx Plus driver
160	**MS2078**	4,0	**DT15IP**
200	**MS2078**	4,0	**DT15IP**
250	**MS2078**	4,0	**DT15IP**

NOTE: For superior surface finish, use left-hand inserts.
Insert radii ≥1,6mm (.062") has no facet.

- Neutral (full slotting) cutters.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Faceted inserts for superior surface finishes.





Arbour Mount • 12mm IC • Neutral (Full Slotting)

order number	catalogue number	D1	D	D6	CDX	THUB	B min	Z	Z S	max RPM	kg
3330983	**160H14NP90SD12N20K**	160	40	54,8	52,2	17,9	19,8	14	7	9170	1,85
3330986	**200J18NP90SD12N20K**	200	50	68,8	65,2	17,9	19,8	18	9	8210	3,11
3330989	**250J22NP90SD12N20K**	250	50	68,8	90,4	17,9	19,8	22	11	7300	5,14

Spare Parts

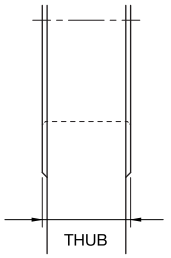


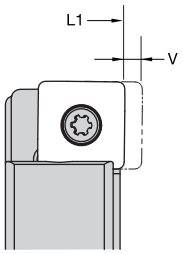


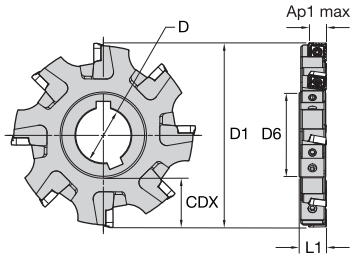
D1	insert screw	Nm	Torx Plus driver
160	**MS2078**	4,0	**DT15IP**
200	**MS2078**	4,0	**DT15IP**
250	**MS2078**	4,0	**DT15IP**

NOTE: For superior surface finish, use left-hand inserts.
Insert radii ≥1,6mm (.062") has no facet.

- Rapid adjustment and setting via unique cam adjustment mechanism.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Wide choice of insert radii.
- Two keyways for staggered mounting.
- Wiper insert facets for superior surface finishes.









Arbour Mount • Half-Side Cutting • Right Hand

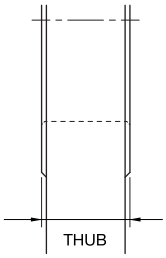
order number	catalogue number	D1	D	D6	CDX	L1	THUB	V	Ap1 max	Z	Z S	max RPM	kg
2443438	**125H08RK90SD12N18K**	125	40	54,8	34,0	18,1	18,2	1,3	11,7	8	8	10350	1,00
2443462	**160H10RK90SD12N18K**	160	40	54,8	51,5	18,1	18,2	1,3	11,7	10	10	9150	1,80

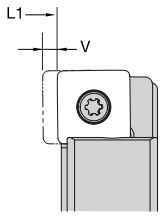
Spare Parts

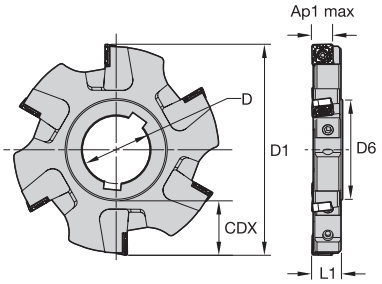


D1	cartridge right-hand	wedge	cam pin wrench	insert screw	Nm	Torx Plus wrench	cam pin	wedge wrench	wedge screw
125	**RK90SD1218**	**W18**	**MW3**	**MS2077**	4,0	**TTP15**	**CP1820**	**THW3M**	**STCM11**
160	**RK90SD1218**	**W18**	**MW3**	**MS2077**	4,0	**TTP15**	**CP1820**	**THW3M**	**STCM11**

- Rapid adjustment and setting via unique cam adjustment mechanism.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Wide choice of insert radii.
- Two keyways for staggered mounting.
- Wiper insert facets for superior surface finishes.









Arbour Mount • Half-Side Cutting • Left Hand

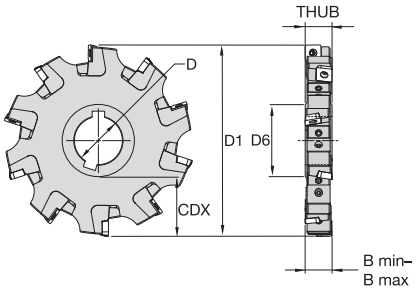
order number	catalogue number	D1	D	D6	CDX	L1	THUB	V	Ap1 max	Z	Z S	max RPM	kg
2443439	**125H08LK90SD12N18K**	125	40	54,8	34,0	18,1	18,2	1,3	11,7	8	8	10350	1,00
2443463	**160H10LK90SD12N18K**	160	40	54,8	51,5	18,1	18,2	1,3	11,7	10	10	9150	1,80
2443526	**315K18LK90SD12N18K**	315	60	83,8	114,5	18,1	18,2	1,3	11,7	18	18	6500	8,40

Spare Parts



D1	cartridge left-hand	wedge	cam pin wrench	insert screw	Nm	Torx Plus wrench	cam pin	wedge wrench	wedge screw
125	**LK90SD1218**	**W18**	**MW3**	**MS2077**	4,0	**TTP15**	**CP1820**	**THW3M**	**STCM11**
160	**LK90SD1218**	**W18**	**MW3**	**MS2077**	4,0	**TTP15**	**CP1820**	**THW3M**	**STCM11**
315	**LK90SD1218**	**W18**	**MW3**	**MS2077**	4,0	**TTP15**	**CP1820**	**THW3M**	**STCM11**

- Rapid adjustment and setting via unique cam adjustment mechanism.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Wide choice of insert radii.
- Two keyways for staggered mounting.
- Wiper insert facets for superior surface finishes.



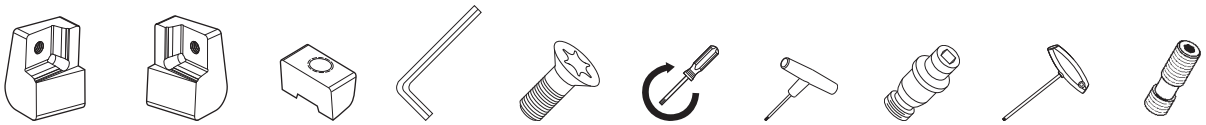


Arbour Mount Slotting Cutter • 18–20,7mm Adjustment Range

order number	catalogue number	D1	D	D6	B min	B max	CDX	THUB	Z	Z S	max RPM	kg
2443437	**125H08NK90SD12N18K**	125	40	54,8	18	20,7	34,0	18,2	8	4	10350	1,00
2443461	**160H10NK90SD12N18K**	160	40	54,8	18	20,7	51,5	18,2	10	5	9150	1,80
2443485	**200J14NK90SD12N18K**	200	50	68,8	18	20,7	64,5	18,2	14	7	8200	3,00
2443506	**250J16NK90SD12N18K ***	250	50	68,8	18	20,7	89,5	18,2	16	8	7350	5,00
2443524	**315K18NK90SD12N18K**	315	60	83,8	18	20,7	114,5	18,2	18	9	6500	8,40

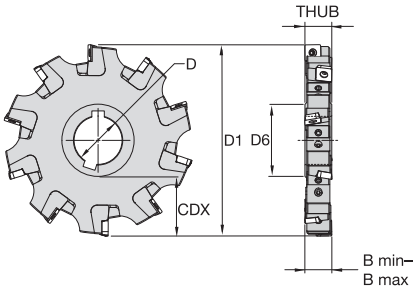
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Spare Parts



D1	cartridge left-hand	cartridge right-hand	wedge	cam pin wrench	insert screw	Nm	Torx Plus wrench	cam pin	wedge wrench	wedge screw
125	**LK90SD1218**	**RK90SD1218**	**W18**	**MW3**	**MS2077**	4,0	**TTP15**	**CP1820**	**THW3M**	**STCM11**
160	**LK90SD1218**	**RK90SD1218**	**W18**	**MW3**	**MS2077**	4,0	**TTP15**	**CP1820**	**THW3M**	**STCM11**
200	**LK90SD1218**	**RK90SD1218**	**W18**	**MW3**	**MS2077**	4,0	**TTP15**	**CP1820**	**THW3M**	**STCM11**
250	**LK90SD1218**	**RK90SD1218**	**W18**	**MW3**	**MS2077**	4,0	**TTP15**	**CP1820**	**THW3M**	**STCM11**
315	**LK90SD1218**	**RK90SD1218**	**W18**	**MW3**	**MS2077**	4,0	**TTP15**	**CP1820**	**THW3M**	**STCM11**

- Rapid adjustment and setting via unique cam adjustment mechanism.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Wide choice of insert radii.
- Two keyways for staggered mounting.
- Wiper insert facets for superior surface finishes.



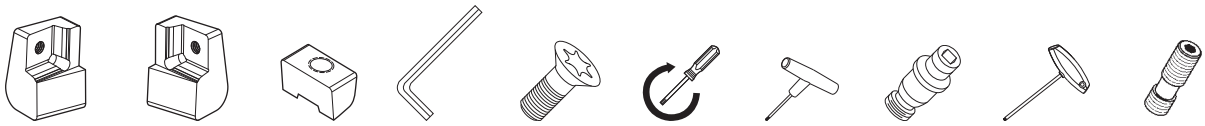


Arbour Mount Slotting Cutter • 20,7–23,3mm Adjustment Range

order number	catalogue number	D1	D	D6	B min	B max	CDX	THUB	Z	Z S	max RPM	kg
2443440	**125H08NK90SD12N20K**	125	40	54,8	20,7	23,3	34,0	20,8	8	4	10350	1,20
2443464	**160H10NK90SD12N20K ***	160	40	54,8	20,7	23,3	51,5	20,8	10	5	9150	2,10
2443488	**200J14NK90SD12N20K ***	200	50	68,8	20,7	23,3	64,5	20,8	14	7	8200	3,50
2443527	**315K18NK90SD12N20K**	315	60	83,8	20,7	23,3	114,5	20,8	18	9	6500	9,70

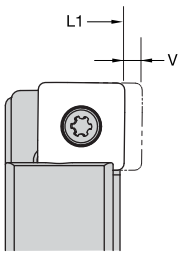
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

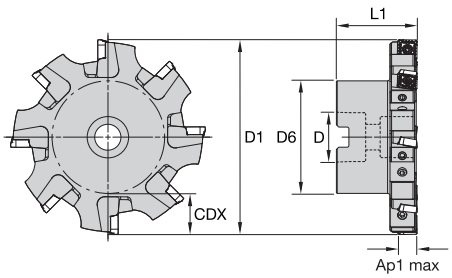
Spare Parts



D1	cartridge left-hand	cartridge right-hand	wedge	cam pin wrench	insert screw	Nm	Torx Plus wrench	cam pin	wedge wrench	wedge screw
125	**LK90SD1220**	**RK90SD1220**	**W20**	**MW3**	**MS2077**	4,0	**TTP15**	**CP1820**	**THW3M**	**STCM11**
160	**LK90SD1220**	**RK90SD1220**	**W20**	**MW3**	**MS2077**	4,0	**TTP15**	**CP1820**	**THW3M**	**STCM11**
200	**LK90SD1220**	**RK90SD1220**	**W20**	**MW3**	**MS2077**	4,0	**TTP15**	**CP1820**	**THW3M**	**STCM11**
315	**LK90SD1220**	**RK90SD1220**	**W20**	**MW3**	**MS2077**	4,0	**TTP15**	**CP1820**	**THW3M**	**STCM11**

- Rapid adjustment and setting via unique cam adjustment mechanism.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Wide choice of insert radii.
- Wiper insert facets for superior surface finishes.



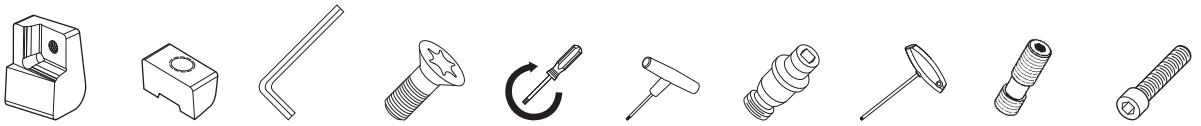




Shell Mount • Half-Side Cutting • Right Hand

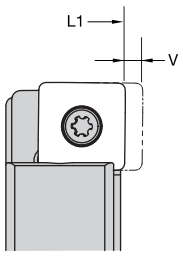
order number	catalogue number	D1	D	D6	CDX	L1	V	Ap1 max	Z	Z S	max RPM	kg
2443450	**125Y08RK90SD12N18K**	125	32	58,0	31,9	51,0	1,3	11,7	8	8	10350	1,60

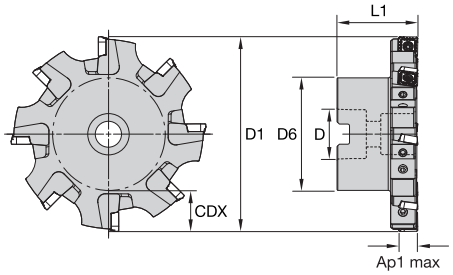
Spare Parts



D1	cartridge right-hand	wedge	cam pin wrench	insert screw	Nm	Torx Plus wrench	cam pin	wedge wrench	wedge screw	socket-head cap screw
125	**RK90SD1218**	**W18**	**MW3**	**MS2077**	4,0	**TTP15**	**CP1820**	**THW3M**	**STCM11**	**MS1559**

- Rapid adjustment and setting via unique cam adjustment mechanism.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Wide choice of insert radii.
- Wiper insert facets for superior surface finishes.



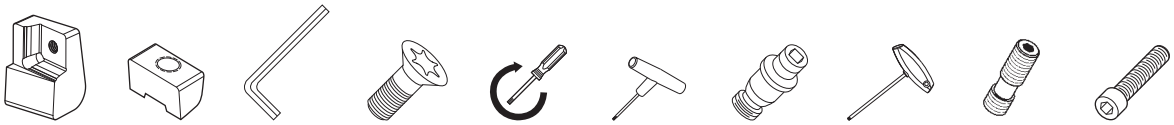




Shell Mount • Half-Side Cutting • Right Hand

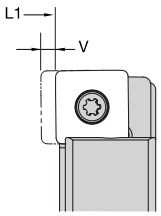
order number	catalogue number	D1	D	D6	CDX	L1	V	Ap1 max	Z	Z S	max RPM	kg
2443453	**125Y08RK90SD12N20K**	125	32	58,0	31,9	51,0	1,3	11,7	8	8	10350	1,70

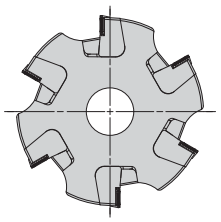
Spare Parts

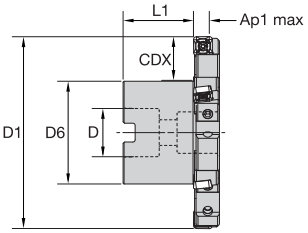


D1	cartridge right-hand	wedge	cam pin wrench	insert screw	Nm	Torx Plus wrench	cam pin	wedge wrench	wedge screw	socket-head cap screw
125	**RK90SD1220**	**W20**	**MW3**	**MS2077**	4,0	**TTP15**	**CP1820**	**THW3M**	**STCM11**	**MS1559**

- Rapid adjustment and setting via unique cam adjustment mechanism.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Wide choice of insert radii.
- Wiper insert facets for superior surface finishes.







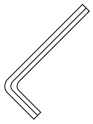


Shell Mount • Half-Side Cutting • Left Hand

order number	catalogue number	D1	D	D6	CDX	L1	V	Ap1 max	Z	Z S	max RPM	kg
2443451	**125Y08LK90SD12N18K**	125	32	58,0	31,9	33,0	1,3	11,7	8	8	10350	1,60
2443475	**160Y10LK90SD12N18K**	160	40	70,0	43,4	33,0	1,3	11,7	10	10	9150	2,30

Spare Parts





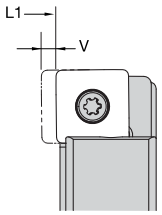


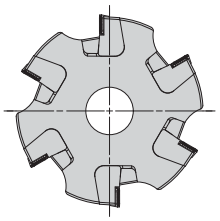


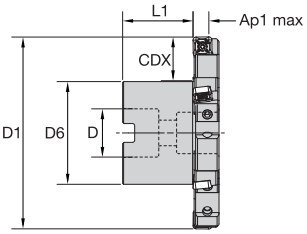



D1	cartridge left-hand	wedge	cam pin wrench	insert screw	Nm	Torx Plus wrench	cam pin	wedge wrench	wedge screw	socket-head cap screw
125	**LK90SD1218**	**W18**	**MW3**	**MS2077**	4,0	**TTP15**	**CP1820**	**THW3M**	**STCM11**	**MS1559**
160	**LK90SD1218**	**W18**	**MW3**	**MS2077**	4,0	**TTP15**	**CP1820**	**THW3M**	**STCM11**	**–**

- Rapid adjustment and setting via unique cam adjustment mechanism.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Wide choice of insert radii.
- Wiper insert facets for superior surface finishes.







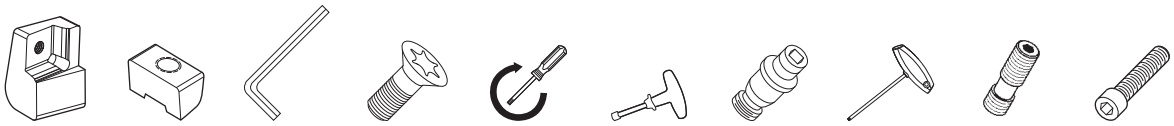


Shell Mount • Half-Side Cutting • Left Hand

order number	catalogue number	D1	D	D6	CDX	L1	V	Ap1 max	Z	Z S	max RPM	kg
2443454	**125Y08LK90SD12N20K**	125	32	58,0	31,9	30,4	1,3	11,7	8	8	10350	1,70
2443502	**200Y14LK90SD12N20K ***	200	40	90,0	53,4	30,4	1,3	11,7	14	14	8200	4,60

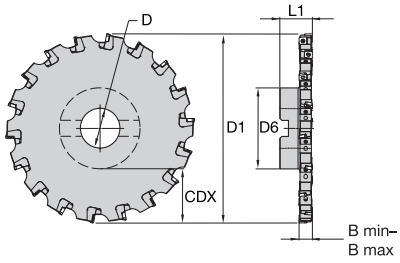
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Spare Parts



D1	cartridge left-hand	wedge	cam pin wrench	insert screw	Nm	Torx Plus wrench	cam pin wrench	wedge wrench	wedge screw	socket-head cap screw
125	**LK90SD1220**	**W20**	**MW3**	**MS2077**	4,0	**TTP15**	**CP1820**	**THW3M**	**STCM11**	**MS1559**
200	**LK90SD1220**	**W20**	**MW3**	**MS2077**	4,0	**TTP15**	**CP1820**	**THW3M**	**STCM11**	**–**

- Rapid adjustment and setting via unique cam adjustment mechanism.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Wide choice of insert radii.
- Wiper insert facets for superior surface finishes.



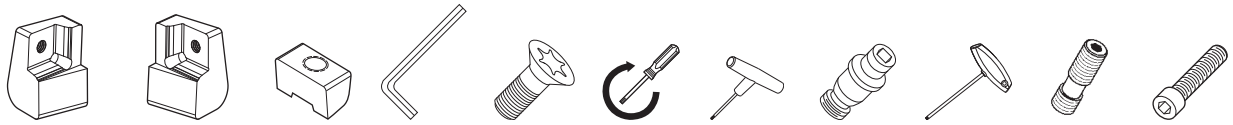


Shell Mount • Slotting Width • 18–20,7mm Adjustment Range

order number	catalogue number	D1	D	D6	B min	B max	CDX	L1	Z	Z S	max RPM	kg
2443449	**125Y08NK90SD12N18K**	125	32	58,0	18	20,7	31,9	51,0	8	4	10350	1,60
2443473	**160Y10NK90SD12N18K**	160	40	70,0	18	20,7	43,4	51,0	10	5	9150	2,30
2443515	**250Y16NK90SD12N18K** *	250	60	130,0	18	20,7	58,4	51,0	16	8	7350	6,70
2443536	**315Y18NK90SD12N18K** *	315	60	130,0	18	20,7	90,9	51,0	18	9	6500	10,04

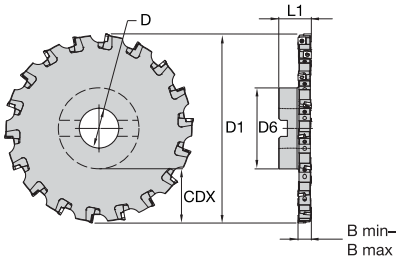
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Spare Parts



D1	cartridge left-hand	cartridge right-hand	wedge	cam pin wrench	insert screw	Nm	Torx Plus wrench	cam pin	wedge wrench	wedge screw	socket-head cap screw
125	**LK90SD1218**	**RK90SD1218**	**W18**	**MW3**	**MS2077**	4,0	**TTP15**	**CP1820**	**THW3M**	**STCM11**	**MS1559**
160	**LK90SD1218**	**RK90SD1218**	**W18**	**MW3**	**MS2077**	4,0	**TTP15**	**CP1820**	**THW3M**	**STCM11**	**–**
250	**LK90SD1218**	**RK90SD1218**	**W18**	**MW3**	**MS2077**	4,0	**TTP15**	**CP1820**	**THW3M**	**STCM11**	**–**
315	**LK90SD1218**	**RK90SD1218**	**W18**	**MW3**	**MS2077**	4,0	**TTP15**	**CP1820**	**THW3M**	**STCM11**	**–**

- Rapid adjustment and setting via unique cam adjustment mechanism.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Wide choice of insert radii.
- Wiper insert facets for superior surface finishes.

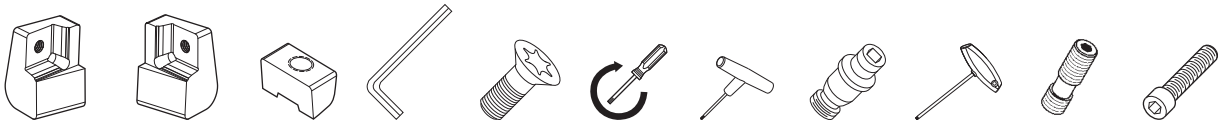




Shell Mount • Slotting Width • 20,7–23,3mm Adjustment Range

order number	catalogue number	D1	D	D6	B min	B max	CDX	L1	Z	Z S	max RPM	kg
2443452	**125Y08NK90SD12N20K**	125	32	58,0	20,7	23,3	31,9	51,0	8	4	10350	1,70
2443476	**160Y10NK90SD12N20K**	160	40	70,0	20,7	23,3	43,4	51,0	10	5	9150	2,50
2443500	**200Y14NK90SD12N20K**	200	40	90,0	20,7	23,3	53,4	51,0	14	7	8200	4,60
2443518	**250Y16NK90SD12N20K**	250	60	130,0	20,7	23,3	58,4	51,0	16	8	7350	7,30
2443533	**315Y18NK90SD12N20K**	315	60	130,0	20,7	23,3	90,9	51,0	18	9	6500	11,30

Spare Parts



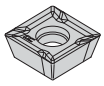
D1	cartridge left-hand	cartridge right-hand	wedge	cam pin wrench	insert screw	Nm	Torx Plus wrench	cam pin	wedge wrench	wedge screw	socket-head cap screw
125	**LK90SD1220**	**RK90SD1220**	**W20**	**MW3**	**MS2077**	4,0	**TTP15**	**CP1820**	**THW3M**	**STCM11**	**MS1559**
160	**LK90SD1220**	**RK90SD1220**	**W20**	**MW3**	**MS2077**	4,0	**TTP15**	**CP1820**	**THW3M**	**STCM11**	**–**
200	**LK90SD1220**	**RK90SD1220**	**W20**	**MW3**	**MS2077**	4,0	**TTP15**	**CP1820**	**THW3M**	**STCM11**	**–**
250	**LK90SD1220**	**RK90SD1220**	**W20**	**MW3**	**MS2077**	4,0	**TTP15**	**CP1820**	**THW3M**	**STCM11**	**–**
315	**LK90SD1220**	**RK90SD1220**	**W20**	**MW3**	**MS2077**	4,0	**TTP15**	**CP1820**	**THW3M**	**STCM11**	**–**

Insert Selection Guide

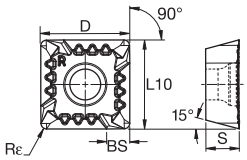
Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		◄——►		toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.E..LD2	KCPM40	**.E..GB2**	**KCPM40**	.S..GB2	KCPM40
P3–P4	.E..LD2	KCPM40	**.E..GB2**	**KCPK30**	.S..GB2	KCPK30
P5–P6	.E..LD2	KC725M	**.E..GB2**	**KC725M**	.S..GB2	KC725M
M1–M2	.E..LD2	KCSM40	**.E..GB2**	**KCSM40**	.S..GB2	KCSM40
M3	.E..LD2	KCPM40	**.E..GB2**	**KCPM40**	.S..GB2	KCPM40
K1–K2	.E..LD2	KC520M	**.E..GB2**	**KCK15**	.S..GB2	KCK15
K3	.E..LD2	KC520M	**.E..GB2**	**KC520M**	.S..GB2	KC520M
N1–N2	.F..LE	KC410M	**.F..LE**	**KC410M**	.F..LE	KC410M
N3	.F..LE	KC410M	**.F..LE**	**KC410M**	.F..LE	KC410M
S1–S2	.E..LD2	KC725M	**.E..GB2**	**KC725M**	.S..GB2	KC725M
S3	.E..LD2	KCSM40	**.E..GB2**	**KCSM40**	.S..GB2	KCSM40
S4	.E..LD2	KCSM40	**.E..GB2**	**KCSM40**	.S..GB2	KCSM40
H1	–	–	**–**	**–**	–	–

Indexable Inserts • KSSM SD.T1204...

- Light-duty insert.
- Four cutting edges.



SDCT-LE



SDCT-LE

● first choice
○ alternate choice

P				○	●		●	●		○
M				●	●		○	○	○	●
K			●	○		●	○			
N		●								
S				●	●				●	●
H										

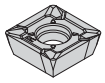
SDCT-LE

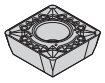
catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
SDCT120404PDFLLE	12,70	4,76	12,70	2,70	0,4	0,02	4	●	–	–	–	–	–	–	–	–
SDCT120404PDFRLE	12,70	4,76	12,70	2,70	0,4	0,02	4	●	–	–	–	–	–	–	–	–
SDCT1204PDFLLE	12,70	4,76	12,70	2,70	0,8	0,02	4	●	–	–	–	–	–	–	–	–
SDCT1204PDFRLE	12,70	4,76	12,70	2,70	0,8	0,02	4	●	–	–	–	–	–	–	–	–
SDCT120412PDFLLE	12,70	4,76	12,70	2,70	1,2	0,02	4	●	–	–	–	–	–	–	–	–
SDCT120412PDFRLE	12,70	4,76	12,70	2,70	1,2	0,02	4	●	–	–	–	–	–	–	–	–
SDCT120416FNLE	12,70	4,76	12,70	–	1,6	0,02	4	●	–	–	–	–	–	–	–	–
SDCT120420FNLE	12,70	4,76	12,70	–	2,0	0,02	4	●	–	–	–	–	–	–	–	–
SDCT120424FNLE	12,70	4,76	12,70	–	2,4	0,02	4	●	–	–	–	–	–	–	–	–
SDCT120432FNLE	12,70	4,76	12,70	–	3,2	0,02	4	●	–	–	–	–	–	–	–	–

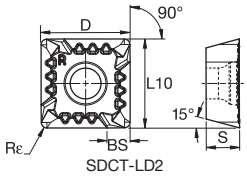
- Light and finish machining.
- Precision ground.
- 15° rake face.
- Four cutting edges.

P				○	●		●	●		○
M				●	●		○	○	○	●
K			●	○		●	○			
N	●									
S				●	●				●	●
H										

● first choice
○ alternate choice


SDCT-LD2


SDET-GB



SDCT-LD2
SDET-GB

SDCT-LD2

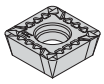
catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
SDCT120404PDELLD2	12,70	4,76	12,70	2,70	0,4	0,04	4	–	–	–	●	–	–	–	–	–
SDCT120404PDERLD2	12,70	4,76	12,70	2,93	0,4	0,04	4	–	–	–	●	–	–	–	–	–
SDCT1204PDELLD2	12,70	4,76	12,70	3,32	0,8	0,04	4	–	–	–	●	–	–	–	–	–
SDCT1204PDERLD2	12,70	4,76	12,70	3,32	0,8	0,04	4	–	●	–	●	–	–	●	–	●
SDCT120412PDELLD2	12,70	4,76	12,70	3,05	1,2	0,04	4	–	–	–	●	–	–	–	–	–
SDCT120412PDERLD2	12,70	4,76	12,70	3,05	1,2	0,04	4	–	–	–	●	–	–	–	–	●
SDCT120416ENLD2	12,70	4,76	12,70	–	1,6	0,04	4	–	–	–	●	–	–	–	–	●
SDCT120420ENLD2	12,70	4,76	12,70	–	2,0	0,04	4	–	–	–	●	–	–	–	–	–
SDCT120424ENLD2	12,70	4,76	12,70	–	2,4	0,04	4	–	–	–	●	–	–	–	–	–
SDCT120432ENLD2	12,70	4,76	12,70	–	3,2	0,04	4	–	–	●	●	–	–	–	●	●
SDCT120464ENLD2	12,70	4,76	12,70	–	6,3	0,04	2	–	–	–	●	–	–	–	–	●

- Medium machining.
- Precision ground.
- 5° rake face.
- Four cutting edges.

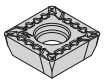
SDET-GB

catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
SDET1204PDERGB	12,70	4,76	12,70	2,56	0,8	0,08	4	–	●	–	–	–	–	–	–	●
SDET1204PDSRGB	12,70	4,76	12,70	2,56	0,8	0,15	4	–	–	–	●	–	●	●	●	●
SDET120412PDERGB	12,70	4,76	12,70	2,19	1,2	0,08	4	–	–	–	●	–	–	●	–	●
SDET120412PDSRGB	12,70	4,76	12,70	2,16	1,2	0,15	4	–	–	–	●	–	–	–	–	●
SDET120416ENGB	12,70	4,76	12,70	–	1,6	0,08	4	–	–	–	–	–	–	–	–	●
SDET120416SNGB	12,70	4,76	12,70	–	1,6	0,15	4	–	–	–	●	–	–	–	–	●
SDET120424ENGB	12,70	4,76	12,70	–	2,4	0,08	4	–	–	–	●	–	–	–	–	●
SDET120424SNGB	12,70	4,76	12,70	–	2,4	0,15	4	–	–	–	●	–	–	–	–	●
SDET120432ENGB	12,70	4,76	12,70	–	3,2	0,08	4	–	–	–	●	–	–	–	–	●
SDET120432SNGB	12,70	4,76	12,70	–	3,2	0,15	4	–	–	–	–	–	–	–	–	●
SDET120448ENGB	12,70	4,76	12,70	–	4,8	0,08	2	–	–	–	●	–	–	–	–	●
SDET120448SNGB	12,70	4,76	12,70	–	4,8	0,15	2	–	–	–	●	–	–	–	–	●
SDET120464ENGB	12,70	4,76	12,70	–	6,4	0,08	2	–	–	–	●	–	–	–	–	●
SDET120464SNGB	12,70	4,76	12,70	–	6,4	0,15	2	–	–	–	●	–	●	–	●	●

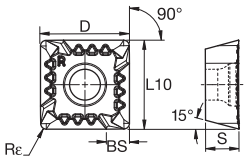
- Medium machining.
- Precision ground.
- 5° rake face.
- Four cutting edges.



SDET-GB2



SDPT-GB2



SDET-GB2
SDPT-GB2

● first choice
○ alternate choice

P			○	●		●	●		○
M			●	●		○	○	○	●
K		●	○		●	○			
N	●								
S			●	●				●	●
H									

SDET-GB2

catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
SDET1204PDELGB2	12,70	4,76	12,70	3,32	0,8	0,08	4	–	●	–	●	●	●	–	–	–
SDET1204PDERGB2	12,70	4,76	12,70	3,32	0,8	0,08	4	–	●	–	●	●	●	●	–	●
SDET1204PDSLGB2	12,70	4,76	12,70	3,32	0,8	0,13	4	–	–	–	●	–	●	–	–	–
SDET1204PDSRGB2	12,70	4,76	12,70	3,32	0,8	0,13	4	–	●	–	●	●	●	●	–	–
SDET120412PDELGB2	12,70	4,76	12,70	3,05	1,2	0,08	4	–	●	–	●	●	–	–	–	–
SDET120412PDERGB2	12,70	4,76	12,70	3,05	1,2	0,08	4	–	●	–	●	●	●	●	–	–
SDET120416SNGB2	12,70	4,76	12,70	–	1,6	0,13	4	–	●	–	●	●	●	–	–	–
SDET120420SNGB2	12,70	4,76	12,70	–	2,0	0,13	4	–	●	–	●	●	●	●	–	–
SDET120424SNGB2	12,70	4,76	12,70	–	2,4	0,13	4	–	–	–	●	●	●	–	–	–
SDET120432SNGB2	12,70	4,76	12,70	–	3,2	0,13	4	–	●	–	●	●	●	–	–	–
SDET120432XENGB2	12,70	4,76	12,70	–	3,2	0,08	2	–	–	–	●	–	–	–	–	–
SDET120464SNGB2	12,70	4,76	12,70	–	6,4	0,13	2	–	–	–	–	–	●	–	–	–

- Medium machining.
- Precision ground.
- 5° rake face.
- Four cutting edges.

SDPT-GB2

catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
SDPT1204PDERGB2	12,70	4,76	12,70	2,70	0,8	0,08	4	–	–	–	●	●	●	●	–	●
SDPT1204PDSRGB2	12,70	4,76	12,70	2,70	0,8	0,13	4	–	–	–	●	●	●	●	–	●

Recommended Starting Feeds

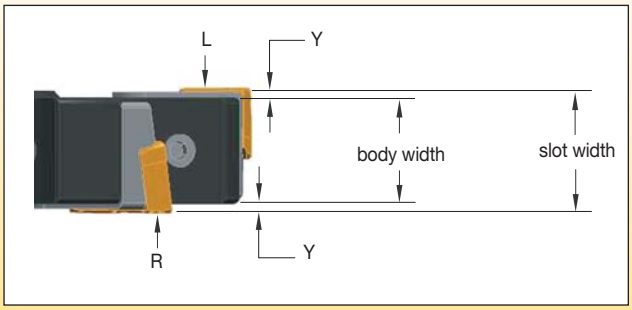
Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.F..LE	0,12	**0,42**	0,74	0,08	**0,30**	0,54	0,06	**0,23**	0,40	0,06	**0,20**	0,35	0,05	**0,18**	0,32	.F..LE
.E..LD	0,17	**0,47**	0,82	0,12	**0,34**	0,59	0,09	**0,26**	0,44	0,08	**0,22**	0,38	0,07	**0,20**	0,35	.E..LD
.E..LD2	0,12	**0,46**	0,81	0,09	**0,33**	0,58	0,07	**0,25**	0,43	0,06	**0,22**	0,38	0,05	**0,20**	0,35	.E..LD2
.E..GB	0,23	**0,53**	0,89	0,17	**0,38**	0,64	0,13	**0,29**	0,48	0,11	**0,25**	0,41	0,10	**0,23**	0,38	.E..GB
.E..GB2	0,23	**0,53**	0,89	0,17	**0,38**	0,64	0,13	**0,29**	0,48	0,11	**0,25**	0,41	0,10	**0,23**	0,38	.E..GB2
.S..GB	0,23	**0,59**	0,95	0,17	**0,43**	0,68	0,13	**0,32**	0,51	0,11	**0,28**	0,44	0,10	**0,25**	0,41	.S..GB
.S..GB2	0,23	**0,59**	0,95	0,17	**0,43**	0,68	0,13	**0,32**	0,51	0,11	**0,28**	0,44	0,10	**0,25**	0,41	.S..GB2
.S..GN	0,23	**0,59**	0,95	0,17	**0,43**	0,68	0,13	**0,32**	0,51	0,11	**0,28**	0,44	0,10	**0,25**	0,41	.S..GN

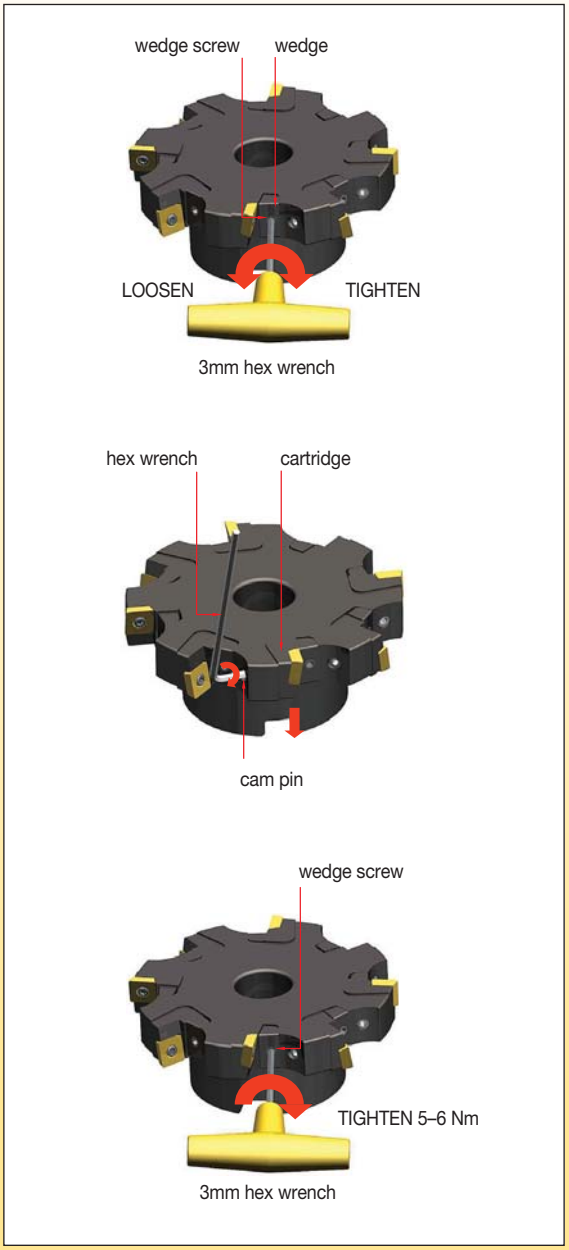
NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

KSSM Slot Width Adjustment Instructions

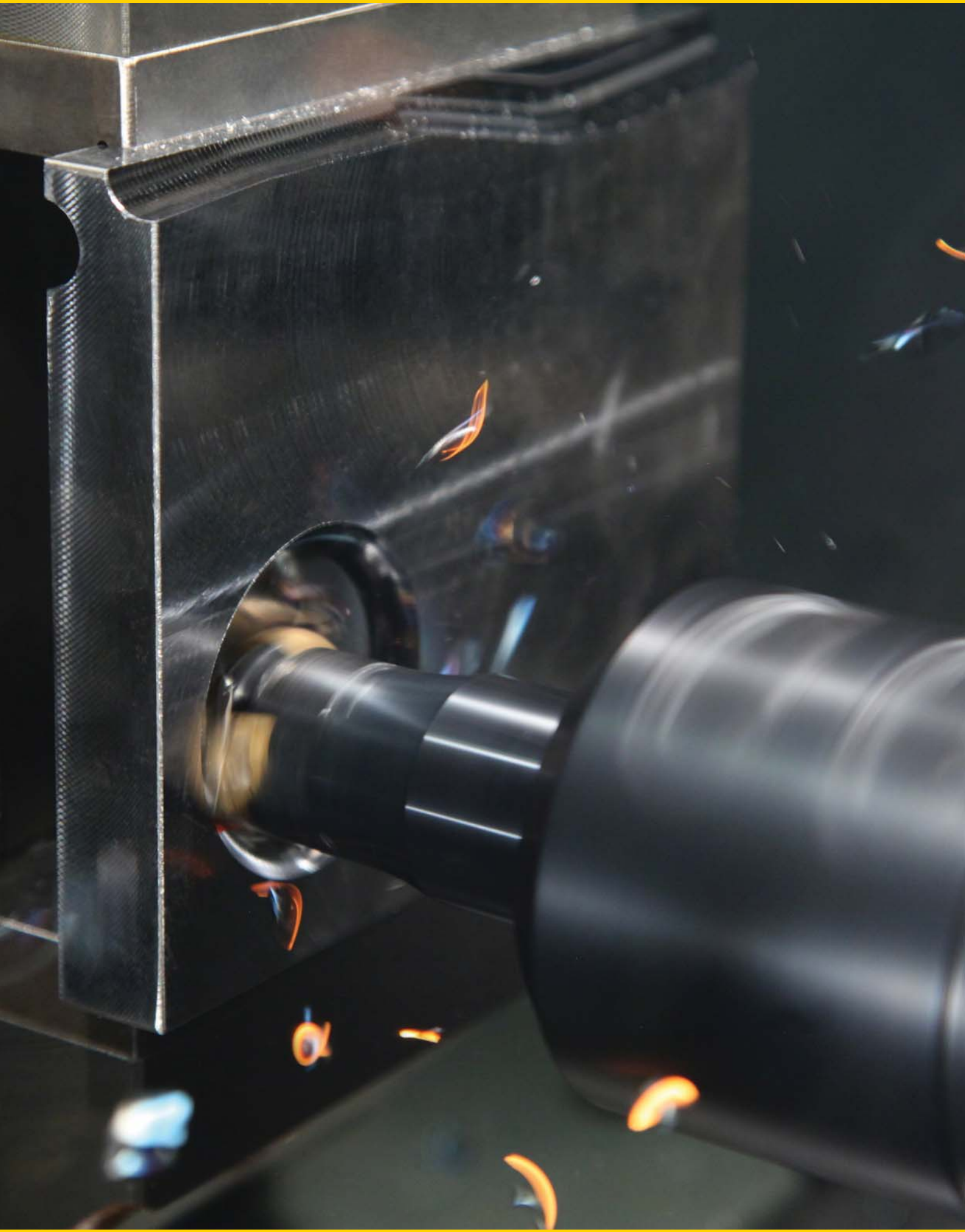


1. Measure body width at pocket 1 (per stamp on tool body) behind cartridge.
2. Zero tool presetter at pocket 1 behind cartridge.
3. Move presetter over the insert and set distance Y. Y= (Desired Slot Width-Body Width)/2
4. Zero over insert at starting pocket (pocket 1).
5. Adjust remaining cartridges on the same side.
6. Return to starting pocket and start with step 2 for opposite side of cutter.

KSSM Cartridge Adjustment Instructions



1. Insert 3mm hex wrench into STCM Screw.
2. Rotate 3mm hex wrench anti-clockwise to loosen wedge.
3. Rotate 3mm hex wrench clockwise to lightly tighten STCM screw to approximately 1 Nm, so the wedge is touching the cartridge and cutterbody. This creates some slight resistance against the cartridge during the adjustment.
4. Insert hex wrench into cam pin behind cartridge.
5. Rotate wrench to adjust cartridge to desired position.
6. For best accuracy, back cam pin off, so you can feel it is not touching the sides of the slot in the back of the cartridge.
7. Remove wrench from cam pin.
8. Insert 3mm hex wrench into STCM screw.
9. Tighten STCM screw to 5,1–6,2 Nm prior to using the cutter. Kennametal torque wrench KTW45 or alternate torque wrench should be used.
10. Double check cartridge position to assure no movement.



Indexable Milling • Copy Milling

Stellram 7792VX • High-Feed Series V2–V35

KenFeed 2X • Double-Sided High-Feed Milling Cutters V36–V43

Rodeka • Double-Sided Round Inserts V44–V66

Rodeka 10 ..... V46–V52

Rodeka 12 ..... V53–V59

Rodeka 16 ..... V60–V62

Rodeka 12X V63–V66

KSRM • Round Inserts, Specially Developed for Titanium and Stainless Steel V68–V85

Stellram 7713VR • Round Inserts V86–V99

Stellram 7713VR10 ..... V87–V92

Stellram 7713VR12 ..... V93–V99

Stellram 5505VX V100–V108

KDMB • KDMT • KDMS V110–V135

Z-Axis V136–V143

KCRA • Double-Sided Ceramic Round Inserts V144–V150

KIPR V152–V157

Stellram® 7792 High-Feed Series

Indexable Milling

The 7792 cutter series has been designed for high-feed milling applications with superior surface generation. 7792VX cutters are designed for a wide range of applications, including facing, pocketing, ramping, helical interpolation, and plunging. They are capable of machining all materials, including steel, stainless steel, cast iron, and high-temperature and aluminium alloys.



Features and Benefits

- The 7792VX high-feed cutters are the best solution for reducing cycle times or removing the maximum amount of material in the shortest time.
- New ultra-fine pitch cutters further increase metal removal rates, especially in high-temp alloys.
- The unique design and insert positioning help to achieve up to 5x higher feed rates than other cutters on the market.
- When used in long (extended) toolholders, 7792VX cutters absorb vibrations and greatly reduce instability and tool deflection.
- Integrated wiper facet for improved surface finish: 16 Ra (1,6µ) when used at <0,5 mm/z.



7792VXP06:
Maximum ap = 0,90mm
Diameter Range = 16–35mm

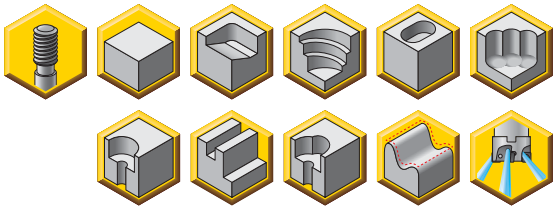
7792VXD09:
Maximum ap = 1,50mm
Diameter Range = 25–66mm

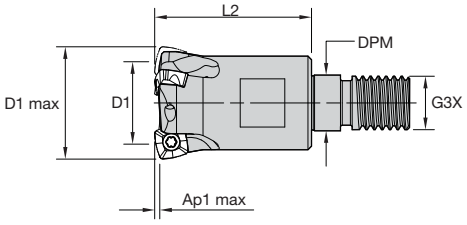
7792VXD12:
Maximum ap = 2,50mm
Diameter Range = 32–160mm

7792VXE16:
Maximum ap = 3,50mm
Diameter Range = 40–160mm

NOTE: Larger diameter shell mill fixation cutters with interchangeable cartridges are available.

- Ultra-fine pitch cutters available to increase material removal rates, especially on high-temp alloys.
- Positive design to support lower cutting forces and long overhang usage.
- Ramping and plunge milling capabilities.
- Screw-on cutters provide better rigidity and stability when used with small spindels: BT30, BT40, DV40, HSK50, HSK63, etc.
- Screw-on cutters can be less expensive when compared to cylindrical shank cutters due to their higher flexibility through multiple holder combinations.







7792VXP06 Modular Head • Screw-On

order number	catalogue number	D1 max	D1	L2	G3X	DPM	Ap1 max	Z U
5681105	**7792VXP06SA016Z2R25**	16	8	25	M8	8,50	0,90	2
5665820	**7792VXP06SA020Z2R35**	20	12	35	M10	10,50	0,90	2
5681122	**7792VXP06SA020Z3R35**	20	12	35	M10	10,50	0,90	3
5665964	**7792VXP06SA025Z3R35**	25	17	35	M12	12,50	0,90	3
5667023	**7792VXP06SA025Z4R35**	25	17	35	M12	12,50	0,90	4
5660062	**7792VXP06SA032Z5R43**	32	24	43	M16	17,00	0,90	5
6024320	**7792VXP06SA035Z6R43**	35	27	43	M16	17,00	0,90	6

Spare Parts



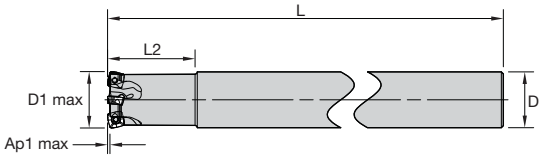


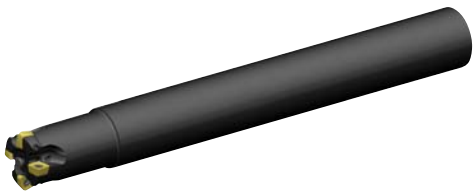
catalogue number	insert screw	Nm	Torx driver
7792VXP06SA016Z2R25	**FP2506T**	0,8	**TP7**
7792VXP06SA020Z2R35	**FP2506T**	0,8	**TP7**
7792VXP06SA020Z3R35	**FP2506T**	0,8	**TP7**
7792VXP06SA025Z3R35	**FP2507T**	0,8	**TP7**
7792VXP06SA025Z4R35	**FP2507T**	0,8	**TP7**
7792VXP06SA032Z5R43	**FP2507T**	0,8	**TP7**
7792VXP06SA035Z6R43	**FP2507T**	0,8	**TP7**

NOTE: For further application recommendation, please see technical information on pages V33–V35.

- Ultra-fine pitch cutters available to increase material removal rates, especially on high-temp alloys.
- Positive design to support lower cutting forces and long overhang usage.
- Ramping and plunge milling capabilities.







7792VXP06 Cylindrical Shank

order number	catalogue number	D1 max	D	D1	L	L2	Ap1 max	Z U
5673240	**7792VXP06CA016Z2R140**	16	16	8	188	25	0,90	2
5673237	**7792VXP06CA020Z3R154**	20	20	12	200	32	0,90	3
5666409	**7792VXP06CA025Z4R154**	25	25	16	210	40	0,90	4
5681124	**7792VXP06CA032Z5R190**	32	32	24	250	40	0,90	5

Spare Parts

catalogue number	 insert screw	 Nm	 Torx driver
7792VXP06CA016Z2R140	**FP2506T**	0,8	**TP7**
7792VXP06CA020Z3R154	**FP2506T**	0,8	**TP7**
7792VXP06CA025Z4R154	**FP2507T**	0,8	**TP7**
7792VXP06CA032Z5R190	**FP2507T**	0,8	**TP7**

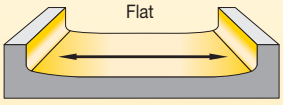
NOTE: For further application recommendation, please see technical information on pages V33–V35.

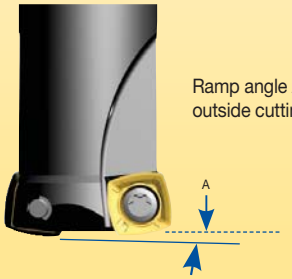
Technical Information (mm)

order number	catalogue number	dimension						
		facing pitch	ramping angle	helical hole min–max		ap max helical/ linear	a_e max plunging	max RPM
5673240	7792VXP06CA016Z2R140	7,60	5,9	22	30	0,60	3,00	65000
5673237	7792VXP06CA020Z3R154	11,60	3,4	30	38	0,60	3,00	57000
5666409	7792VXP06CA025Z4R154	16,60	2,2	40	48	0,60	3,00	49000
5681124	7792VXP06CA032Z5R190	23,60	1,4	54	62	0,60	3,00	41500
5681105	7792VXP06SA016Z2R25	7,60	5,9	22	30	0,60	3,00	65000
5665820	7792VXP06SA020Z2R35	11,6	3,4	30	38	0,60	3,00	57000
5681122	7792VXP06SA020Z3R35	11,6	3,4	30	38	0,60	3,00	57000
5665964	7792VXP06SA025Z3R35	16,60	2,8	40	48	0,60	3,00	49000
5667023	7792VXP06SA025Z4R35	16,60	2,2	40	48	0,60	3,00	49000
5660062	7792VXP06SA032Z5R43	23,60	1,4	54	62	0,60	3,00	41500
6024320	7792VXP06SA035Z6R43	23,60	1,3	60	68	0,60	3,00	37500


Helical Interpolation


Plunging





Ramp angle A uses one outside cutting edge only.

A = max ramp angle utilising full-face contact.

Inserts

Insert Selection Guide • IC 06

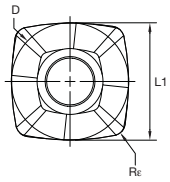
Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		← →		toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	...D41	SC6525	**...D41**	**SC6525**	...D41	X400
P3–P4	…D	KC522M	**…D**	**KC522M**	…D	KCPM40
P5–P6	...D41	SP6519	**...D41**	**X500**	...D41	X500
M1–M2	...D41	SP6519	**...D41**	**KCSM40**	...D41	KCSM40
M3	...D41	SP6519	**...D41**	**KCSM40**	...D41	KCSM40
K1–K2	…D	KC510M	**…D**	**KCPK30**	…D	KCPK30
K3	…D	KC510M	**…D**	**KCPK30**	…D	KCPK30
N1–N2	–	–	**–**	**–**	–	–
N3	–	–	**–**	**–**	–	–
S1–S2	...D41	SP6519	**...D41**	**KCSM40**	...D41	KCSM40
S3	...D41	SP6519	**...D41**	**KCSM40**	...D41	KCSM40
S4	...D41	SP6519	**...D41**	**KCSM40**	...D41	KCSM40
H1	…D	KC510M	**…D**	**KC510M**	…D	KCPM40

● first choice
○ alternate choice

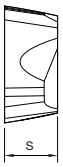
		KC510M	KC522M	KCPK30	KCPM40	KCSM40	SC6525	SP6519	X400	X500
P		○	○	●	●	○	●	○	●	○
M			●	○	○	●		●		●
K		●	○	○			●	○		
N		○								
S			●			●		●		●
H									○	



XPLT06-D41



XPLT06-D41



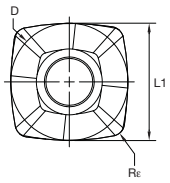
XPLT06-D41 • First choice for machining stainless steel and high-temp alloys

catalogue number	D	LI	S	Rε	hm	RT	KC510M	KC522M	KCPK30	KCPM40	KCSM40	SC6525	SP6519	X400	X500
XPLT060308ERD41	7,00	7,00	3,17	0,8	0,04	1,37	–	–	–	–	–	●	●	●	●

NOTE: RT is the theoretical radius to be used for CAD/CAM programming.



XPPT-D41



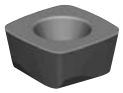
XPPT-D41



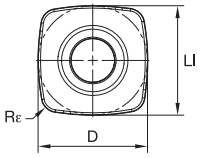
XPPT-D41 • Precision pressed insert. General purpose in soft steels, stainless steels, and high-temp alloys.

catalogue number	D	LI	S	Rε	hm	RT	KC510M	KC522M	KCPK30	KCPM40	KCSM40	SC6525	SP6519	X400	X500
XPPT060308ERD41	7,00	7,00	3,17	0,8	0,04	1,37	–	–	–	–	●	–	–	–	–

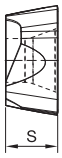
NOTE: RT is the theoretical radius to be used for CAD/CAM programming.



XPPW-06-D



XPPW-06-D



XPPW-06-D • Precision pressed insert; improved cost per edge. Reinforced geometry. Particularly suitable for high strength steels, hardened materials, and cast iron.

catalogue number	D	LI	S	Rε	hm	RT	KC510M	KC522M	KCPK30	KCPM40	KCSM40	SC6525	SP6519	X400	X500
XPPW060310SRD	7,00	7,00	3,18	1,0	0,15	1,54	●	●	●	●	–	–	–	–	–

NOTE: RT is the theoretical radius to be used for CAD/CAM programming.

Recommended Starting Feeds [mm] • High-Feed

Light Machining	General Purpose	Heavy Machining

At 0,90 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.E..D41	0,37	**1,06**	1,89	0,27	**0,73**	1,24	0,20	**0,53**	0,89	0,17	**0,46**	0,77	0,16	**0,42**	0,70	.E..D41
.S..D	0,68	**1,46**	2,35	0,48	**0,98**	1,49	0,36	**0,71**	1,07	0,31	**0,62**	0,92	0,28	**0,56**	0,84	.S..D

At 0,70 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.E..D41	0,42	**1,21**	2,20	0,30	**0,83**	1,41	0,22	**0,60**	1,01	0,19	**0,52**	0,87	0,18	**0,48**	0,79	.E..D41
.S..D	0,78	**1,68**	2,79	0,55	**1,12**	1,71	0,40	**0,81**	1,21	0,35	**0,70**	1,04	0,32	**0,64**	0,94	.S..D

At 0,60 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.E..D41	0,46	**1,32**	2,43	0,32	**0,89**	1,53	0,24	**0,65**	1,09	0,21	**0,56**	0,94	0,19	**0,52**	0,85	.E..D41
.S..D	0,84	**1,84**	3,12	0,59	**1,21**	1,85	0,43	**0,87**	1,30	0,38	**0,75**	1,12	0,34	**0,69**	1,02	.S..D

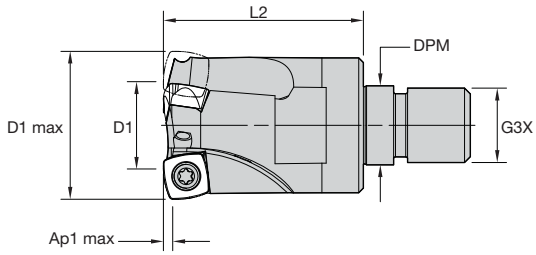
Feed Rate Guide • Plunging • IC 06 • fz [mm/tooth]

Insert Geometry	Programmed Feed per Tooth (fz) Max 3mm insert engagement (ae radial engagement)			Insert Geometry
.E..D41	0,06	**0,15**	0,25	.E..D41
.S..D	0,10	**0,20**	0,30	.S..D

NOTE: For further details about using the 7792VX series in plunging operations, please see page V33.
Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

- Ultra-fine pitch cutters available to increase material removal rates, especially on high-temp alloys.
- Positive design to support lower cutting forces and long overhang usage.
- Ramping and plunge milling capabilities.
- Screw-on cutters provide better rigidity and stability when used with small spindels: BT30, BT40, DV40, HSK50, HSK63, etc.
- Screw-on cutters can be less expensive when compared to cylindrical shank cutters due to their higher flexibility through multiple holder combinations.







7792VXD09 Modular Head • Screw-On

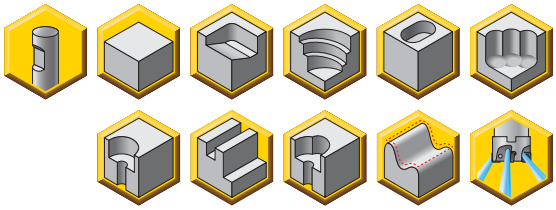
order number	catalogue number	D1 max	D1	L2	G3X	DPM	Ap1 max	Z U
5667916	**7792VXD09SA025Z2R35**	25	12	35	M12	12,50	1,50	2
6024361	**7792VXD09SA025Z3R35**	25	12	35	M12	12,50	1,50	3
5660448	**7792VXD09SA032Z3R43**	32	19	43	M16	17,00	1,50	3
6024362	**7792VXD09SA032Z4R43**	32	19	43	M16	17,00	1,50	4
5673503	**7792VXD09SA035Z3R43**	35	22	43	M16	17,00	1,50	3
6024363	**7792VXD09SA035Z4R43**	35	22	43	M16	17,00	1,50	4
6024365	**7792VXD09SA042Z5R43**	42	29	43	M16	17,00	1,50	5

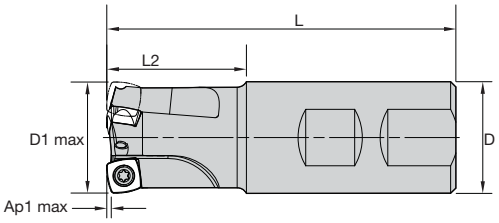
Spare Parts

catalogue number	 insert screw	 Nm	 Torx driver
7792VXD09SA025Z2R35	**F3508T**	2,1	**T15**
7792VXD09SA025Z3R35	**F3508T**	2,1	**TB15**
7792VXD09SA032Z3R43	**F3510T**	2,1	**T15**
7792VXD09SA032Z4R43	**F3508T**	2,1	**T15**
7792VXD09SA035Z3R43	**F3510T**	2,1	**T15**
7792VXD09SA035Z4R43	**F3510T**	2,1	**T15**
7792VXD09SA042Z5R43	**F3510T**	2,1	**T15**

NOTE: For further application recommendation, please see technical information on pages V33–V35.

- Ultra-fine pitch cutters available to increase material removal rates, especially on high-temp alloys.
- Positive design to support lower cutting forces and long overhang usage.
- Ramping and plunge milling capabilities.







7792VXD09 Weldon® Shank

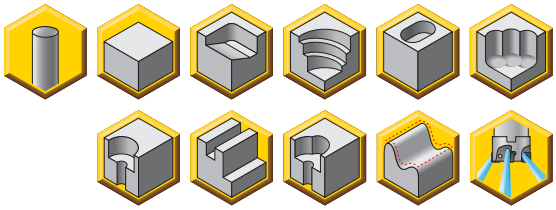
order number	catalogue number	D1 max	D	D1	L	L2	Ap1 max	Z U
5657893	**7792VXD09WA025Z2R**	25	25	12	96	40	1,50	2
5658074	**7792VXD09WA032Z3R**	32	32	19	100	40	1,50	3

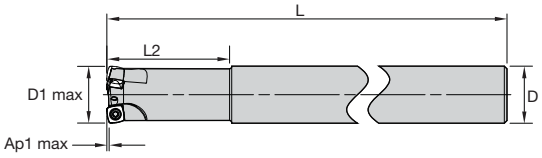
Spare Parts

catalogue number	 insert screw	 Nm	 Torx driver
7792VXD09WA025Z2R	**F3508T**	2,1	**T15**
7792VXD09WA032Z3R	**F3510T**	2,1	**T15**

NOTE: For further application recommendation, please see technical information on pages V33–V35.

- Ultra-fine pitch cutters available to increase material removal rates, especially on high-temp alloys.
- Positive design to support lower cutting forces and long overhang usage.
- Ramping and plunge milling capabilities.







7792VXD09 Cylindrical Shank

order number	catalogue number	D1 max	D	D1	L	L2	Ap1 max	Z U
5659947	**7792VXD09CA025Z2R50**	25	25	12	200	50	1,50	2
6024366	**7792VXD09CA025Z3R50**	25	25	12	200	50	1,50	3
5661016	**7792VXD09CA032Z3R70**	32	32	19	250	70	1,50	3
6024367	**7792VXD09CA032Z4R70**	32	32	19	250	70	1,50	4

Spare Parts



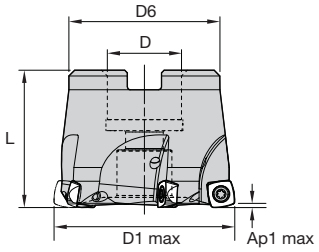


catalogue number	insert screw	Nm	Torx driver
7792VXD09CA025Z2R50	**F3508T**	2,1	**T15**
7792VXD09CA025Z3R50	**F3508T**	2,1	**TB15**
7792VXD09CA032Z3R70	**F3510T**	2,1	**T15**
7792VXD09CA032Z4R70	**F3510T**	2,1	**T15**

NOTE: For further application recommendation, please see technical information on pages V33–V35.

- Ultra-fine pitch cutters available to increase material removal rates, especially on high-temp alloys.
- Positive design to support lower cutting forces and long overhang usage.
- Ramping and plunge milling capabilities.







7792VXD09 Shell Mill

order number	catalogue number	D1 max	D	D1	D6	L	Ap1 max	Z U
5656727	7792VXD09-A040Z3R	40	16	27	36	32	1,50	3
5657234	7792VXD09-A040Z4R	40	16	27	36	32	1,50	4
5667475	7792VXD09-A040Z5R	40	16	27	36	32	1,50	5
5656914	7792VXD09-A050Z5R	50	22	37	46	40	1,50	5
5656377	7792VXD09-A050Z6R	50	22	37	46	40	1,50	6
6024368	7792VXD09-A050Z7R	50	22	37	45	40	1,50	7
6024369	7792VXD09-A052Z5R	52	22	39	45	40	1,50	5
6024370	7792VXD09-A052Z6R	52	22	39	45	40	1,50	6
6024371	7792VXD09-A052Z7R	52	22	39	45	40	1,50	7
6024372	7792VXD09-A063Z5R	63	22	50	42	40	1,50	5
6024373	7792VXD09-A063Z6R	63	22	50	42	40	1,50	6
6024374	7792VXD09-A063Z9R	63	22	50	45	40	1,50	9
6024375	7792VXD09-A066Z5R	66	27	53	55	50	1,50	5
6024376	7792VXD09-A066Z6R	66	27	53	55	50	1,50	6
6024377	7792VXD09-A066Z9R	66	27	53	55	50	1,50	9

Spare Parts



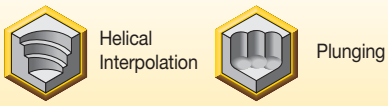


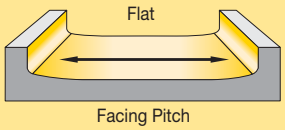

catalogue number	insert screw	Nm	Torx driver	mounting screw
7792VXD09-A040Z3R	F3510T	2,1	T15	M8 1.25 X 25 SHCS
7792VXD09-A040Z4R	F3510T	2,1	T15	M8 1.25 X 25 SHCS
7792VXD09-A040Z5R	F3510T	2,1	T15	M8 1.25 X 25 SHCS
7792VXD09-A050Z5R	F3510T	2,1	T15	M10 1.5 X 25 SHCS
7792VXD09-A050Z6R	F3510T	2,1	T15	M10 1.5 X 25 SHCS
7792VXD09-A050Z7R	F3510T	2,1	TB15	M10 1.5 X 25 SHCS
7792VXD09-A052Z5R	F3510T	2,1	T15	M10 1.5 X 25 SHCS
7792VXD09-A052Z6R	F3510T	2,1	T15	M10 1.5 X 25 SHCS
7792VXD09-A052Z7R	F3510T	2,1	TB15	M10 1.5 X 25 SHCS
7792VXD09-A063Z5R	F3510T	2,1	T15	M10 1.5 X 25 SHCS
7792VXD09-A063Z6R	F3510T	2,1	T15	M10 1.5 X 25 SHCS
7792VXD09-A063Z9R	F3510T	2,1	TB15	M10 1.5 X 25 SHCS
7792VXD09-A066Z5R	F3510T	2,1	T15	M12 X 1.75 X 30 SHCS
7792VXD09-A066Z6R	F3510T	2,1	T15	M12 X 1.75 X 30 SHCS
7792VXD09-A066Z9R	F3510T	2,1	TB15	M12 X 1.75 X 30 SHCS

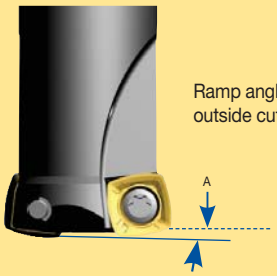
NOTE: For further application recommendation, please see technical information on pages V33–V35.

Technical Information (mm)

order number	catalogue number	dimension						max RPM
		facing pitch	ramping angle	helical hole min–max		ap max helical/ linear	a_e max plunging	
5657893	7792VXD09WA025Z2R	11,75	2,8	34	48	1,00	6,00	48500
5658074	7792VXD09WA032Z3R	18,75	1,5	48	62	1,00	6,00	40500
5659947	7792VXD09CA025Z2R50	11,75	2,8	34	48	1,00	6,00	48500
6024366	7792VXD09CA025Z3R50	11,75	2,8	34	48	1,00	6,00	48500
5661016	7792VXD09CA032Z3R70	18,75	1,5	48	62	1,00	6,00	40500
6024367	7792VXD09CA032Z4R70	18,75	1,5	48	62	1,00	6,00	40500
5656727	7792VXD09-A040Z3R	26,75	0,8	64	78	1,00	6,00	34500
5657234	7792VXD09-A040Z4R	26,75	0,8	64	78	1,00	6,00	34500
5667475	7792VXD09-A040Z5R	26,75	0,8	64	78	1,00	6,00	34500
5656914	7792VXD09-A050Z5R	36,75	0,7	84	98	1,00	6,00	30000
5656377	7792VXD09-A050Z6R	36,75	0,7	84	98	1,00	6,00	29500
6024368	7792VXD09-A050Z7R	36,75	0,7	84	98	1,00	6,00	30000
6024369	7792VXD09-A052Z5R	38,75	0,7	88	102	1,00	6,00	29500
6024370	7792VXD09-A052Z6R	38,75	0,7	88	102	1,00	6,00	29500
6024371	7792VXD09-A052Z7R	38,75	0,7	88	102	1,00	6,00	29500
6024372	7792VXD09-A063Z5R	49,75	0,5	88	102	1,00	6,00	26000
6024373	7792VXD09-A063Z6R	49,75	0,5	88	102	1,00	6,00	26000
6024374	7792VXD09-A063Z8R	49,75	0,5	88	102	1,00	6,00	26000
6024375	7792VXD09-A066Z5R	52,75	0,5	116	130	1,00	6,00	25500
6024376	7792VXD09-A066Z6R	52,75	0,5	116	130	1,00	6,00	25500
6024377	7792VXD09-A066Z9R	52,75	0,5	116	130	1,00	6,00	25500
5667916	7792VXD09SA025Z2R35	11,75	2,8	34	48	1,00	6,00	48500
6024361	7792VXD09SA025Z3R35	11,75	2,8	34	48	1,00	6,00	48500
5660448	7792VXD09SA032Z3R43	18,75	1,5	48	62	1,00	6,00	40500
6024362	7792VXD09SA032Z4R43	18,75	1,5	48	62	1,00	6,00	40500
6024363	7792VXD09SA035Z4R43	21,75	1,3	54	68	1,00	6,00	37500
6024365	7792VXD09SA042Z5R43	28,75	1,0	68	82	1,00	6,00	34000







Ramp angle A uses one outside cutting edge only.

A = max ramp angle utilising full face contact.

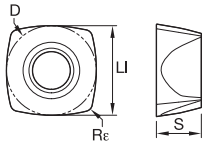
Insert Selection Guide • IC 09

Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		←	→	toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	…GP	KC522M	**…GP**	**KCPM40**	…GP	KCPM40
P3–P4	…GP	KC522M	**…D**	**KC522M**	…D	KCPM40
P5–P6	...D411	SP6519	**...D411**	**X500**	...D41	X500
M1–M2	...D411	SP6519	**...D41**	**KCSM40**	...D41	KCSM40
M3	...D411	SP6519	**...D41**	**KCSM40**	...D41	KCSM40
K1–K2	…D	KCK15	**…D**	**KCK15**	…D	KCPK30
K3	…D	KCPK30	**…D**	**KCPK30**	…D	KCPK30
N1–N2	...D721	GH2	**...D721**	**GH2**	...D721	GH2
N3	...D721	GH2	**...D721**	**GH2**	...D721	GH2
S1–S2	...D411	SP6519	**...D411**	**KCSM40**	...D41	KCSM40
S3	...D411	SP6519	**...D411**	**KCSM40**	...D41	KCSM40
S4	...D411	SP6519	**...D411**	**KCSM40**	...D41	KCSM40
H1	…D	KC510M	**…D**	**KC510M**	…D	KCPM40

Milling Inserts



XDLT09-D721



XDLT09-D721

● first choice
○ alternate choice

	GH2	KC510M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	SC3025	SC6525	SP6519	X400	X500
P		○	○	●		●	●	○		●	○	●	○
M			●	●		○	○	●			●		●
K	○	●	○		●	○			●	●	○		
N	●	○											
S			●	●				●			●		●
H												○	

XDLT09-D721 • First choice for non-ferrous alloys

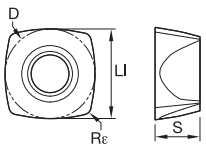
catalogue number	D	LI	S	Rε	hm	RT	GH2	KC510M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	SC3025	SC6525	SP6519	X400	X500
XDLT090408ERD721	9,53	9,53	4,75	0,8	0,04	2,01	●	–	–	–	–	–	–	–	–	–	–	–	–

NOTE: RT is the theoretical radius to be used for CAD/CAM programming.

• First choice for machining stainless steel and high-temp alloys.



XDLT09...D41



XDLT09...D41

XDLT09-D41 • General purpose in soft steels. Best fit for face milling, slotting operation

catalogue number	D	LI	S	Rε	hm	RT	GH2	KC510M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	SC3025	SC6525	SP6519	X400	X500
XDLT090408ERD41	9,53	9,53	4,76	0,8	0,05	2,01	–	–	–	–	–	–	–	–	–	●	●	–	●

NOTE: RT is the theoretical radius to be used for CAD/CAM programming.

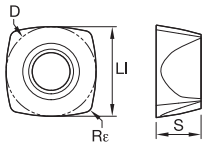
- First choice for machining stainless steel and high-temp alloys.

● first choice
○ alternate choice

		GH2	KC510M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	SC3025	SC6525	SP6519	X400	X500
P			○	○	●		●	●	○		●	○	●	○
M					●	●		○	○	●			●		●
K		○	●	○			●	○			●	●	○		
N		●	○												
S					●	●				●			●		●
H														○	



XDPT09...D41



XDPT09...D41

XDPT09-D41 • Precision pressed. General purpose in soft steels. Best fit for face milling, slotting operation

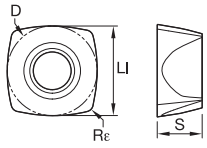
catalogue number	D	LI	S	Rε	hm	RT	GH2	KC510M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	SC3025	SC6525	SP6519	X400	X500
XDPT090408ERD41	9,53	9,53	4,76	0,8	0,05	2,01	–	–	–	–	–	–	–	●	–	●	●	–	●

NOTE: RT is the theoretical radius to be used for CAD/CAM programming.

- Geometry similar to D41, but with higher corner nose protection for heavier applications.



XDLT09...D411



XDLT09...D411

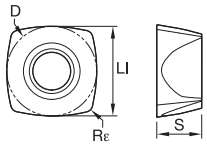
XDLT09-D411 • General purpose in stainless steel and high-temp alloys. Best fit for pocketing and profiling operations in general, also in combination with long overhangs

catalogue number	D	LI	S	Rε	hm	RT	GH2	KC510M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	SC3025	SC6525	SP6519	X400	X500
XDLT090412ERD411	9,53	9,53	4,75	1,2	0,05	2,27	–	–	–	–	–	–	–	–	–	–	●	–	●

NOTE: RT is the theoretical radius to be used for CAD/CAM programming.



XDPT-D411



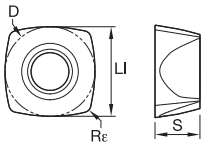
XDPT-D411

XDPT-D411 • Precision pressed. General purpose in stainless steel and high-temp alloys. Best for pocketing and profiling operations in general, also in combination with long overhangs

catalogue number	D	LI	S	Rε	hm	RT	GH2	KC510M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	SC3025	SC6525	SP6519	X400	X500
XDPT090412ERD411	9,53	9,53	4,76	1,2	0,05	2,27	–	–	–	–	–	–	–	●	–	–	–	–	–

NOTE: RT is the theoretical radius to be used for CAD/CAM programming.


XDPW09-D



XDPW09-D

● first choice
○ alternate choice

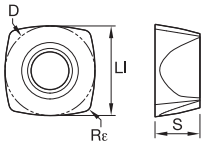
		GH2	KC510M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	SC3025	SC6525	SP6519	X400	X500
P			○	○	●		●	●	○		●	○	●	○
M					●	●		○	○	●			●		●
K		○	●	○		●	○				●	●	○		
N		●	○												
S					●	●				●			●		●
H														○	

XDPW09-D • Precision pressed. First choice for roughing alloyed steel and cast iron

catalogue number	D	LI	S	Rε	hm	RT
XDPW090412SRD	9,52	9,52	4,76	1,2	0,10	2,27

NOTE: RT is the theoretical radius to be used for CAD/CAM programming.


XDLW09...D



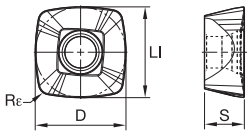
XDLW09...D

XDLW09-D • First choice for roughing alloyed steel and cast iron

catalogue number	D	LI	S	Rε	hm	RT
XDLW090408SRD	9,53	9,53	4,76	0,8	0,10	2,01

NOTE: RT is the theoretical radius to be used for CAD/CAM programming.


XDPT09-GP



XDPT09-GP

XDPT09-GP • Precision pressed. General use on alloyed steels. Good balance across all machining situations.

catalogue number	D	LI	S	Rε	hm	RT
XDPT090412SRGP	9,53	9,53	4,76	1,2	0,22	0,67

NOTE: RT is the theoretical radius to be used for CAD/CAM programming.

Recommended Starting Feeds [mm] • High-Feed

Light Machining	General Purpose	Heavy Machining

At 1,50 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.E..D721	0,30	**0,96**	1,69	0,22	**0,68**	1,18	0,16	**0,51**	0,87	0,14	**0,44**	0,75	0,13	**0,40**	0,69	.E..D721
.E..D41	0,38	**1,10**	1,69	0,27	**0,78**	1,18	0,20	**0,58**	0,87	0,18	**0,50**	0,75	0,16	**0,46**	0,69	.E..D41
.E..D411	0,38	**1,10**	1,69	0,27	**0,78**	1,18	0,20	**0,58**	0,87	0,18	**0,50**	0,75	0,16	**0,46**	0,69	.E..D411
.S..D	0,55	**1,21**	1,99	0,39	**0,86**	1,38	0,29	**0,63**	1,01	0,25	**0,55**	0,88	0,23	**0,50**	0,80	.S..D
.S..GP	0,55	**1,22**	2,01	0,39	**0,86**	1,39	0,29	**0,64**	1,02	0,25	**0,55**	0,89	0,23	**0,51**	0,81	.S..GP

At 1,10 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.E..D721	0,35	**1,12**	1,98	0,25	**0,79**	1,37	0,19	**0,59**	1,01	0,16	**0,51**	0,87	0,15	**0,47**	0,80	.E..D721
.E..D41	0,44	**1,28**	1,98	0,32	**0,90**	1,37	0,24	**0,67**	1,01	0,21	**0,58**	0,87	0,19	**0,53**	0,80	.E..D41
.E..D411	0,44	**1,28**	1,98	0,32	**0,90**	1,37	0,24	**0,67**	1,01	0,21	**0,58**	0,87	0,19	**0,53**	0,80	.E..D411
.S..D	0,64	**1,42**	2,35	0,45	**1,00**	1,61	0,34	**0,74**	1,18	0,30	**0,64**	1,02	0,27	**0,59**	0,93	.S..D
.S..GP	0,64	**1,42**	2,37	0,45	**1,00**	1,63	0,34	**0,74**	1,19	0,30	**0,64**	1,03	0,27	**0,59**	0,94	.S..GP

At 0,90 Axial Depth of Cut (ap)

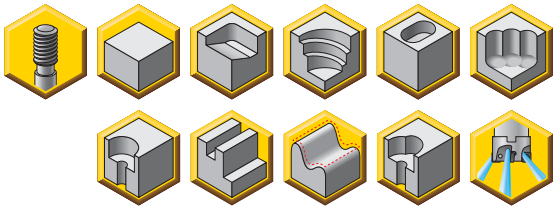
Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.E..D721	0,39	**1,24**	2,20	0,28	**0,88**	1,52	0,21	**0,65**	1,11	0,18	**0,56**	0,96	0,17	**0,52**	0,88	.E..D721
.E..D41	0,48	**1,42**	2,20	0,35	**1,00**	1,52	0,26	**0,74**	1,11	0,23	**0,64**	0,96	0,21	**0,59**	0,88	.E..D41
.E..D411	0,48	**1,42**	2,20	0,35	**1,00**	1,52	0,26	**0,74**	1,11	0,23	**0,64**	0,96	0,21	**0,59**	0,88	.E..D411
.S..D	0,70	**1,57**	2,61	0,50	**1,10**	1,78	0,37	**0,81**	1,30	0,33	**0,71**	1,12	0,30	**0,64**	1,03	.S..D
.S..GP	0,70	**1,58**	2,65	0,50	**1,11**	1,80	0,37	**0,82**	1,31	0,33	**0,71**	1,14	0,30	**0,65**	1,04	.S..GP

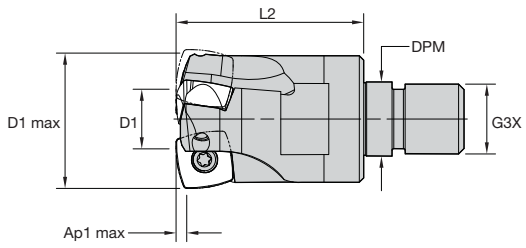
Feed Rate Guide • Plunging • IC 09 • fz [mm/tooth]

Insert Geometry	Programmed Feed per Tooth (fz) Max 6mm insert engagement (ae radial engagement)			Insert Geometry
.E..D721	0,06	**0,18**	0,30	.E..D721
.E..D41	0,07	**0,20**	0,30	.E..D41
.E..D411	0,07	**0,20**	0,30	.E..D411
.S..D	0,10	**0,22**	0,35	.S..D
.S..GP	0,10	**0,22**	0,35	.S..GP

NOTE: For further details about using the 7792VX series in plunging operations, please see page V33.
Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

- Ultra-fine pitch cutters available to increase material removal rates, especially on high-temp alloys.
- Positive design to support lower cutting forces and long overhang usage.
- Ramping and plunge milling capabilities.
- Screw-on cutters provide better rigidity and stability when used with small spindels: BT30, BT40, DV40, HSK50, HSK63, etc.
- Screw-on cutters can be less expensive when compared to cylindrical shank cutters due to their higher flexibility through multiple holder combinations.







7792VXD12 Modular Head • Screw-On

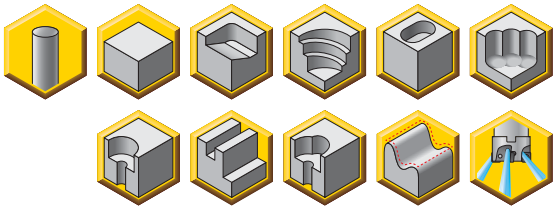
order number	catalogue number	D1 max	D1	L2	G3X	DPM	Ap1 max	Z U
5659132	**7792VXD12SA032Z2R43**	32	11	43	M16	17,00	2,50	2
6025280	**7792VXD12SA032Z3R43**	32	14	43	M16	17,00	2,50	3
6025561	**7792VXD12SA035Z3R43**	35	17	43	M16	17,00	2,50	3
6025562	**7792VXD12SA042Z4R43**	42	24	43	M16	17,00	2,50	4

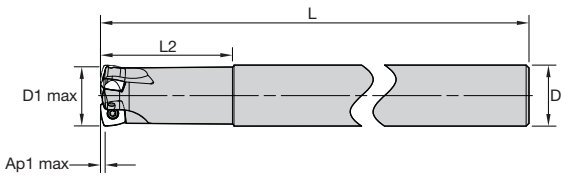
Spare Parts

catalogue number	 insert screw	 Nm	 Torx driver
7792VXD12SA032Z2R43	**D4010T**	3,1	**T15**
7792VXD12SA032Z3R43	**D4010T**	3,1	**T15**
7792VXD12SA035Z3R43	**D4010T**	3,1	**T15**
7792VXD12SA042Z4R43	**D4010T**	3,1	**T15**

NOTE: For further application recommendation, please see technical information on pages V33–V35.

- Ultra-fine pitch cutters available to increase material removal rates, especially on high-temp alloys.
- Positive design to support lower cutting forces and long overhang usage.
- Ramping and plunge milling capabilities.







7792VXD12 Cylindrical Shank

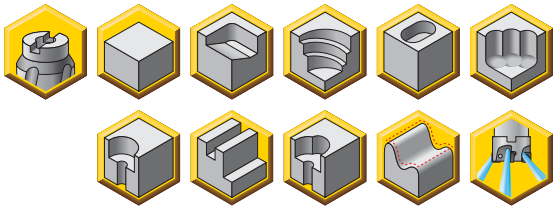
order number	catalogue number	D1 max	D	D1	L	L2	Ap1 max	Z U
5661017	7792VXD12CA032Z2R70	32	32	11	250	70	2,50	2
6025563	7792VXD12CA032Z3R70	32	32	14	250	70	2,50	3

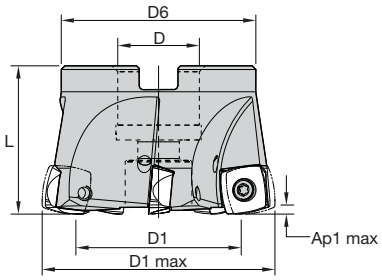
Spare Parts

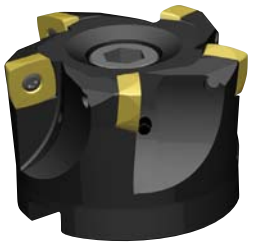
catalogue number	insert screw	Nm	Torx driver
7792VXD12CA032Z2R70	D4010T	3,1	T15
7792VXD12CA032Z3R70	D4010T	3,1	T15

NOTE: For further application recommendation, please see technical information on pages V33–V35.

- Ultra-fine pitch cutters available to increase material removal rates, especially on high-temp alloys.
- Positive design to support lower cutting forces and long overhang usage.
- Ramping and plunge milling capabilities.







7792VXD12 Shell Mill • Coarse, Medium, and Fine Pitch

order number	catalogue number	D1 max	D	D1	D6	L	Ap1 max	Z U
6025272	7792VXD12-A040Z4R	40	22	22	38	40	2,50	4
5673504	7792VXD12-A050Z4R	50	22	32	48	40	2,50	4
6025273	7792VXD12-A050Z6R	50	22	32	45	40	2,50	6
5656728	7792VXD12-A052Z3R	52	22	34	48	40	2,50	3
5666187	7792VXD12-A052Z4R	52	22	34	48	40	2,50	4
5656383	7792VXD12-A052Z5R	52	22	34	48	40	2,50	5
6025274	7792VXD12-A052Z6R	52	22	34	45	40	2,50	6
5656729	7792VXD12-A063Z4R	63	22	45	53	40	2,50	4
5657235	7792VXD12-A063Z5R	63	22	45	53	40	2,50	5
6025275	7792VXD12-A063Z7R	63	22	45	45	40	2,50	7
5660064	7792VXD12-A066Z4R	66	27	48	58	45	2,50	4
5660065	7792VXD12-A066Z5R	66	27	48	58	45	2,50	5
6025276	7792VXD12-A066Z7R	66	27	48	50	45	2,50	7
5656730	7792VXD12-A080Z5R	80	27	62	55	50	2,50	5
5667478	7792VXD12-A080Z8R	80	27	62	55	50	2,50	8
6025277	7792VXD12-A080Z10R	80	27	62	55	50	2,50	10
5667834	7792VXD12-A100Z6R	100	32	82	82	50	2,50	6
5666144	7792VXD12-A100Z9R	100	32	82	82	50	2,50	9
6025278	7792VXD12-A100Z11R	100	32	82	68	50	2,50	11
5656380	7792VXD12-A125Z8R	125	40	107	82	63	2,50	8
5665943	7792VXD12-A125Z11R	125	40	107	82	63	2,50	11
6025279	7792VXD12-A125Z13R	125	40	107	80	63	2,50	13
5659130	7792VXD12-160Z7R	160	40	142	110	63	2,50	7

NOTE: No through coolant for cutters where D1 max = 160mm.

(continued)

(continued)

Spare Parts

catalogue number	 insert screw	 Nm	 Torx driver	 mounting screw	 mounting screw
7792VXD12-A040Z4R	D4010T	3,1	T15	–	KLSSM22-39-CG
7792VXD12-A050Z4R	D4012T	3,1	T15	M10 1.5 X 25 SHCS	–
7792VXD12-A050Z6R	D4010T	3,1	TB15	M10 1.5 X 25 SHCS	–
7792VXD12-A052Z3R	D4012T	3,1	T15	M10 1.5 X 25 SHCS	–
7792VXD12-A052Z4R	D4012T	3,1	T15	M10 1.5 X 25 SHCS	–
7792VXD12-A052Z5R	D4010T	3,1	T15	M10 1.5 X 25 SHCS	–
7792VXD12-A052Z6R	D4010T	3,1	TB15	M10 1.5 X 25 SHCS	–
7792VXD12-A063Z4R	D4012T	3,1	T15	M10 1.5 X 25 SHCS	–
7792VXD12-A063Z5R	D4012T	3,1	T15	M10 1.5 X 25 SHCS	–
7792VXD12-A063Z7R	D4010T	3,1	TB15	M10 1.5 X 25 SHCS	–
7792VXD12-A066Z4R	D4012T	3,1	T15	M12 X 1.75 X 30 SHCS	–
7792VXD12-A066Z5R	D4012T	3,1	T15	M12 X 1.75 X 30 SHCS	–
7792VXD12-A066Z7R	D4010T	3,1	TB15	M12 X 1.75 X 30 SHCS	–
7792VXD12-A080Z5R	D4012T	3,1	T15	M12 X 1.75 X 30 SHCS	–
7792VXD12-A080Z8R	D4012T	3,1	T15	M12 X 1.75 X 30 SHCS	–
7792VXD12-A080Z10R	D4010T	3,1	TB15	M12 X 1.75 X 30 SHCS	–
7792VXD12-A100Z6R	D4012T	3,1	T15	M16 X 2 X 40 SHCS	–
7792VXD12-A100Z9R	D4012T	3,1	T15	M16 X 2 X 40 SHCS	–
7792VXD12-A100Z11R	D4010T	3,1	TB15	M16 X 2 X 40 SHCS	–
7792VXD12-A125Z8R	D4012T	3,1	T15	M20 X 2.5 X 50 SHCS	–
7792VXD12-A125Z11R	D4012T	3,1	T15	M20 X 2.5 X 50 SHCS	–
7792VXD12-A125Z13R	D4010T	3,1	TB15	M20 X 2.5 X 50 SHCS	–
7792VXD12-160Z7R	D4012T	3,1	T15	–	–

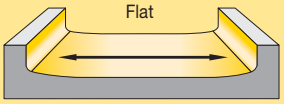
NOTE: For further application recommendation, please see technical information on pages V33–V35.

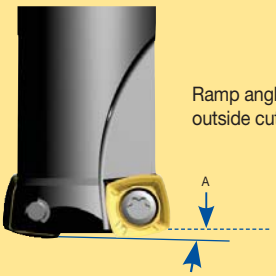
Technical Information (mm)

order number	catalogue number	dimension						max RPM
		facing pitch	ramping angle	helical hole min–max		ap max helical/ linear	a_e max plunging	
5661017	7792VXD12CA032Z2R70	10,60	1,8	42	62	1,80	9,00	31500
6025563	7792VXD12CA032Z3R70	10,6	1,8	42	62	1,80	9,00	31500
6025272	7792VXD12-A040Z4R	21,6	1,4	58	78	1,80	9,00	26500
6025273	7792VXD12-A050Z6R	31,6	0,9	78	98	1,80	9,00	22500
5656728	7792VXD12-A052Z3R	33,60	0,8	82	102	1,80	9,00	22000
5666187	7792VXD12-A052Z4R	33,60	0,8	82	102	1,80	9,00	22000
5656383	7792VXD12-A052Z5R	33,60	0,8	82	102	1,80	9,00	22000
6025274	7792VXD12-A052Z6R	33,6	0,8	82	102	1,80	9,00	22000
5656729	7792VXD12-A063Z4R	44,60	0,6	104	124	1,80	9,00	19500
5657235	7792VXD12-A063Z5R	44,60	0,6	104	124	1,80	9,00	19500
6025275	7792VXD12-A063Z7R	44,6	0,6	104	124	1,80	9,00	19500
5660064	7792VXD12-A066Z4R	47,60	0,5	110	130	1,80	9,00	19000
5660065	7792VXD12-A066Z5R	47,60	0,5	110	130	1,80	9,00	19000
6025276	7792VXD12-A066Z7R	47,6	0,5	110	130	1,80	9,00	19000
5656730	7792VXD12-A080Z5R	61,60	0,5	138	158	1,80	9,00	17000
5667478	7792VXD12-A080Z8R	61,60	0,5	138	158	1,80	9,00	17000
6025277	7792VXD12-A080Z10R	61,6	0,5	138	158	1,80	9,00	17000
5667834	7792VXD12-A100Z6R	81,60	0,3	178	198	1,80	9,00	15000
5666144	7792VXD12-A100Z9R	81,60	0,3	178	198	1,80	9,00	15000
6025278	7792VXD12-A100Z11R	81,6	0,3	178	198	1,80	9,00	15000
5656380	7792VXD12-A125Z8R	106,60	0,2	228	248	1,80	9,00	13000
5665943	7792VXD12-A125Z11R	106,60	0,2	228	248	1,80	9,00	13000
6025279	7792VXD12-A125Z13R	106,6	0,2	228	248	1,80	9,00	13000
5659130	7792VXD12-160Z7R	141,6	0,2	298	318	1,80	9,00	11500
5659132	7792VXD12SA032Z2R43	10,60	1,8	42	62	1,80	9,00	31500
6025280	7792VXD12SA032Z3R43	10,6	1,8	42	62	1,80	9,0	31500
6025561	7792VXD12SA035Z3R43	16,6	1,8	48	68	1,80	9,0	29000
6025562	7792VXD12SA042Z4R43	23,6	1,3	62	82	1,80	9,0	25500


Helical Interpolation


Plunging





Ramp angle A uses one outside cutting edge only.

A = max ramp angle utilising full face contact.

Inserts

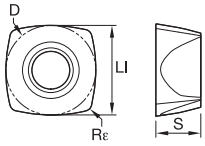
Insert Selection Guide • IC 12

Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		←	→	toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	…GP	KC522M	**…GP**	**KCPM40**	…GP	KCPM40
P3–P4	…GP	KC522M	**…D**	**KC522M**	…D	KCPM40
P5–P6	…D411	SP6519	**…D411**	**X500**	…D41	X500
M1–M2	…D411	SP6519	**…D41**	**KCSM40**	…D41	KCSM40
M3	…D411	SP6519	**…D41**	**KCSM40**	…D41	KCSM40
K1–K2	…D	KCK15	**…D**	**KCK15**	…D	KCPK30
K3	…D	KCPK30	**…D**	**KCPK30**	…D	KCPK30
N1–N2	…D721	GH2	**…D721**	**GH2**	…D721	GH2
N3	…D721	GH2	**…D721**	**GH2**	…D721	GH2
S1–S2	…D411	SP6519	**…D411**	**KCSM40**	…D41	KCSM40
S3	…D411	SP6519	**…D411**	**KCSM40**	…D41	KCSM40
S4	…D411	SP6519	**…D411**	**KCSM40**	…D41	KCSM40
H1	…D	KC510M	**…D**	**KC510M**	…D	KCPM40

Copy Milling



XDLT12-D721



XDLT12-D721

● first choice
○ alternate choice

		GH2	KC510M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	SC3025	SC6525	SP6519	X400	X500
P			○	○	●		●	●	○		●	○	●	○
M				●	●		○	○	●			●		●
K		○	●	○		●	○			●	●	○		
N		●	○											
S				●	●				●			●		●
H													○	

XDLT12-D721 • First choice for non-ferrous alloys

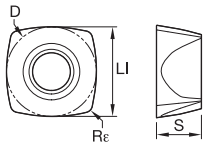
catalogue number	D	LI	S	Rε	hm	RT	GH2	KC510M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	SC3025	SC6525	SP6519	X400	X500
XDLT120508ERD721	12,70	12,70	5,56	0,8	0,04	2,50	●	–	–	–	–	–	–	–	–	–	–	–	–

NOTE: RT is the theoretical radius to be used for CAD/CAM programming.

- Positive geometry for lower cutting forces; first choice for machining stainless steel and high-temp alloys.



XDLT12-D41



XDLT12-D41

XDLT12-D41 • General purpose in soft steels. Best fit for face milling, slotting operation

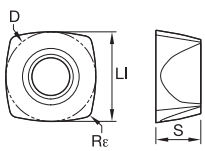
catalogue number	D	LI	S	Rε	hm	RT	GH2	KC510M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	SC3025	SC6525	SP6519	X400	X500
XDLT120508ERD41	12,70	12,70	5,56	0,8	0,05	2,50	–	–	–	–	–	–	–	●	–	●	●	–	●

NOTE: RT is the theoretical radius to be used for CAD/CAM programming.

- First choice for machining stainless steel and high-temp alloys.



XDPT12-D41



XDPT12-D41

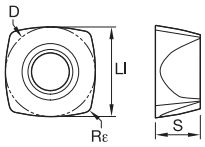
XDPT12-D41 • Precision pressed insert; improved cost per edge. General purpose in soft steels. Best fit for face milling, slotting operation

catalogue number	D	LI	S	Rε	hm	RT	GH2	KC510M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	SC3025	SC6525	SP6519	X400	X500
XDPT120508ERD41	12,70	12,70	5,56	0,8	0,05	2,50	–	–	–	–	–	–	–	●	–	●	●	–	●

NOTE: RT is the theoretical radius to be used for CAD/CAM programming.



XDPT12-D411



XDPT12-D411

● first choice
○ alternate choice

		GH2	KC510M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	SC3025	SC6525	SP6519	X400	X500
P			○	○	●		●	●	○		●	○	●	○
M					●	●		○	○	●			●		●
K		○	●	○		●	○				●	●	○		
N		●	○												
S					●	●				●			●		●
H														○	

XDPT12-D411 • Precision pressed. General purpose in stainless steel and high-temp alloys. Best fit for pocketing and profiling operations in general, also in combination with long overhangs.

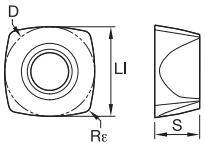
catalogue number	D	LI	S	Rε	hm	RT	GH2	KC510M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	SC3025	SC6525	SP6519	X400	X500
XDPT120512ERD411	12,70	12,70	5,56	1,2	0,05	2,73	–	–	–	–	–	–	–	●	–	–	–	–	–

NOTE: RT is the theoretical radius to be used for CAD/CAM programming.

- Geometry similar to D41, but with higher corner nose protection for heavier applications.



XDLT12-D411

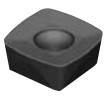


XDLT12-D411

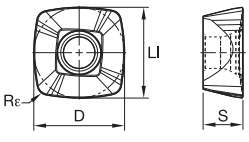
XDLT12-D411 • General purpose in stainless steel and high-temp alloys. Best fit for pocketing and profiling operations in general

catalogue number	D	LI	S	Rε	hm	RT	GH2	KC510M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	SC3025	SC6525	SP6519	X400	X500
XDLT120512ERD411	12,70	12,70	5,56	1,2	0,05	2,73	–	–	–	–	–	–	–	●	–	–	●	–	●

NOTE: RT is the theoretical radius to be used for CAD/CAM programming.



XDPT12-GP



XDPT12-GP

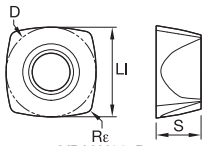
XDPT12-GP • Precision pressed insert; improved cost per edge. General use on alloyed steels. Good balance across all machining situations

catalogue number	D	LI	S	Rε	hm	RT	GH2	KC510M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	SC3025	SC6525	SP6519	X400	X500
XDPT120515SRGP	12,70	12,70	5,56	1,5	0,23	2,78	–	–	●	●	–	●	●	–	–	–	–	–	–

NOTE: RT is the theoretical radius to be used for CAD/CAM programming.



XDLW12-D



XDLW12-D

● first choice
○ alternate choice

		GH2	KC510M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	SC3025	SC6525	SP6519	X400	X500
P			○	○	●		●	●	○		●	○	●	○
M				●	●		○	○	●			●		●
K		○	●	○		●	○			●	●	○		
N		●	○											
S				●	●				●			●		●
H													○	

XDLW12-D • First choice for roughing alloyed steel and cast iron

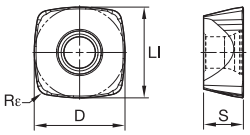
catalogue number	D	LI	S	Rε	hm	RT
XDLW120508SRD	12,70	12,70	5,56	0,8	0,25	2,50

NOTE: RT is the theoretical radius to be used for CAD/CAM programming.

- Particularly suitable for high strength steels, hardened materials, and cast iron.



XDPT12-D



XDPT12-D

XDPW12-D • Precision Pressed with Reinforced Geometry • First Choice for Hardened Materials and Cast Iron

catalogue number	D	LI	S	Rε	hm	RT	GH2	KC510M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	SC3025	SC6525	SP6519	X400	X500
XDPW120515SRD	12,70	12,70	5,56	1,5	0,25	2,78	–	●	●	–	●	●	●	–	–	–	–	–	–

NOTE: RT is the theoretical radius to be used for CAD/CAM programming.

Recommended Starting Feeds [mm] • High-Feed

Light Machining	General Purpose	Heavy Machining

At 2,50 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.E..D721	0,28	**1,02**	1,65	0,21	**0,73**	1,18	0,15	**0,55**	0,88	0,13	**0,48**	0,76	0,12	**0,44**	0,70	.E..D721
.E..D41	0,36	**1,15**	1,81	0,26	**0,83**	1,29	0,19	**0,62**	0,96	0,17	**0,54**	0,83	0,15	**0,49**	0,76	.E..D41
.E..D411	0,36	**1,15**	1,81	0,26	**0,83**	1,29	0,19	**0,62**	0,96	0,17	**0,54**	0,83	0,15	**0,49**	0,76	.E..D411
.S..GP	0,51	**1,30**	1,99	0,37	**0,93**	1,41	0,28	**0,70**	1,05	0,24	**0,61**	0,91	0,22	**0,55**	0,83	.S..GP
.S..D	0,51	**1,30**	1,95	0,37	**0,93**	1,38	0,28	**0,70**	1,03	0,24	**0,61**	0,89	0,22	**0,55**	0,82	.S..D

At 1,70 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.E..D721	0,34	**1,23**	2,00	0,25	**0,88**	1,42	0,19	**0,66**	1,05	0,16	**0,57**	0,92	0,15	**0,52**	0,84	.E..D721
.E..D41	0,43	**1,39**	2,20	0,31	**0,99**	1,56	0,23	**0,74**	1,15	0,20	**0,64**	1,00	0,19	**0,59**	0,92	.E..D41
.E..D411	0,43	**1,39**	2,20	0,31	**0,99**	1,56	0,23	**0,74**	1,15	0,20	**0,64**	1,00	0,19	**0,59**	0,92	.E..D411
.S..GP	0,62	**1,57**	2,41	0,45	**1,12**	1,70	0,33	**0,84**	1,26	0,29	**0,73**	1,10	0,27	**0,67**	1,00	.S..GP
.S..D	0,62	**1,57**	2,36	0,45	**1,12**	1,67	0,33	**0,84**	1,24	0,29	**0,73**	1,08	0,27	**0,67**	0,98	.S..D

At 1,30 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.E..D721	0,39	**1,41**	2,29	0,28	**1,01**	1,62	0,21	**0,75**	1,20	0,18	**0,65**	1,04	0,17	**0,60**	0,96	.E..D721
.E..D41	0,49	**1,59**	2,52	0,35	**1,13**	1,78	0,26	**0,84**	1,31	0,23	**0,73**	1,14	0,21	**0,67**	1,04	.E..D41
.E..D411	0,49	**1,59**	2,52	0,35	**1,13**	1,78	0,26	**0,84**	1,31	0,23	**0,73**	1,14	0,21	**0,67**	1,04	.E..D411
.S..GP	0,70	**1,80**	2,76	0,51	**1,28**	1,94	0,38	**0,95**	1,44	0,33	**0,83**	1,25	0,30	**0,76**	1,14	.S..GP
.S..D	0,70	**1,80**	2,71	0,51	**1,28**	1,90	0,38	**0,95**	1,41	0,33	**0,83**	1,22	0,30	**0,76**	1,12	.S..D

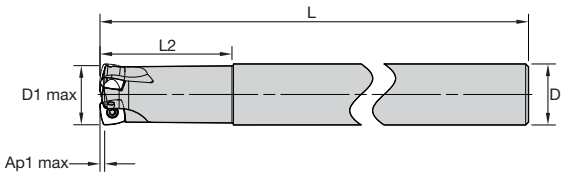
Feed Rate Guide • Plunging • IC 12 • fz [mm/tooth]

Insert Geometry	Programmed Feed per Tooth (fz) Max 9mm insert engagement (ae radial engagement)			Insert Geometry
.E..D721	0,06	**0,20**	0,32	.E..D721
.E..D41	0,07	**0,23**	0,35	.E..D41
.E..D411	0,07	**0,23**	0,35	.E..D411
.S..GP	0,10	**0,25**	0,38	.S..GP
.S..D	0,10	**0,25**	0,38	.S..D

NOTE: For further details about using the 7792VX series in plunging operations, please see page V33.
Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

- Ultra-fine pitch cutters available to increase material removal rates, especially on high-temp alloys.
- Positive design to support lower cutting forces and long overhang usage.
- Ramping and plunge milling capabilities.







7792VXE16 Cylindrical Shank

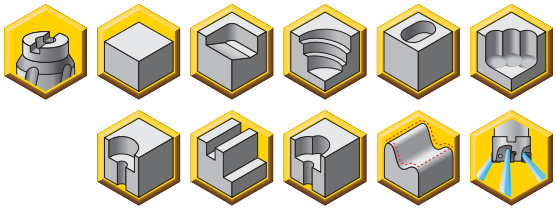
order number	catalogue number	D1 max	D	D1	L	L2	Ap1 max	Z U
5658651	**7792VXE16CA040Z2R102**	40	40	16	172	102	3,50	2
5659563	**7792VXE16CA050Z3R102**	50	40	26	172	102	3,50	3

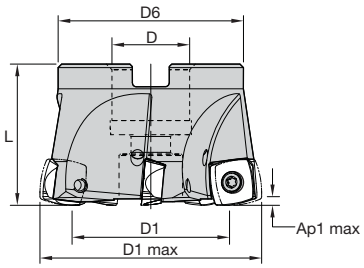
Spare Parts

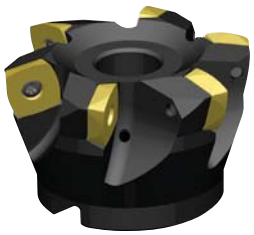
catalogue number	 insert screw	 Nm	 Torx driver
7792VXE16CA040Z2R102	**DP5013T**	6,1	**TP20**
7792VXE16CA050Z3R102	**DP5013T**	6,1	**TP20**

NOTE: For further application recommendation, please see technical information on pages V33–V35.

- Ultra-fine pitch cutters available to increase material removal rates, especially on high-temp alloys.
- Positive design to support lower cutting forces and long overhang usage.
- Ramping and plunge milling capabilities.







7792VXE16 Shell Mill

order number	catalogue number	D1 max	D	D1	D6	L	Ap1 max	Z U
6025614	7792VXE16-A050Z3R	50	22	26	45	45	3,50	3
6025615	7792VXE16-A050Z4R	50	22	26	45	45	3,50	4
6025616	7792VXE16-A052Z4R	52	22	28	45	45	3,50	4
5659955	7792VXE16-A063Z5R	63	22	37	47	40	3,50	5
6025617	7792VXE16-A063Z6R	63	22	39	45	40	3,50	6
6025618	7792VXE16-A066Z6R	66	27	42	55	50	3,50	6
5667006	7792VXE16-A080Z6R	80	27	54	58	50	3,50	6
6025619	7792VXE16-A080Z7R	80	27	56	55	50	3,50	7
5659956	7792VXE16-A100Z8R	100	32	74	68	50	3,50	8
6025620	7792VXE16-A100Z9R	100	32	76	63	50	3,50	9
5661028	7792VXE16-A125Z10R	125	40	99	84	63	3,50	10
6025661	7792VXE16-A125Z11R	125	40	101	80	63	3,50	11
5665957	7792VXE16-160Z12R	160	40	135	102	63	3,50	12
6025662	7792VXE16-160Z13R	160	40	136	90	63	3,50	13

NOTE: No through coolant for cutters where D1 max = 160mm.

Spare Parts








catalogue number	insert screw	Nm	Torx driver	mounting screw	LHCS mounting screw	mounting screw
7792VXE16-A050Z3R	DP5013T	6,1	TP20	–	–	KLSSM22-39-CG
7792VXE16-A050Z4R	DP5013T	6,1	TP20	–	–	KLSSM22-39-CG
7792VXE16-A052Z4R	DP5013T	6,1	TP20	–	–	KLSSM22-39-CG
7792VXE16-A063Z5R	DP5013T	6,1	TP20	M10 1.5 X 25 SHCS	–	–
7792VXE16-A063Z6R	DP5013T	6,1	TB20	M10 1.5 X 25 SHCS	–	–
7792VXE16-A066Z6R	DP5013T	6,1	TB20	M12 X 1.75 X 30 SHCS	–	–
7792VXE16-A080Z6R	DP5013T	6,1	TP20	M12 X 1.75 X 30 SHCS	–	–
7792VXE16-A080Z7R	DP5013T	6,1	TB20	M12 X 1.75 X 30 SHCS	–	–
7792VXE16-A100Z8R	DP5013T	6,1	TP20	–	M16X2X40 LHSCS	–
7792VXE16-A100Z9R	DP5013T	6,1	TB20	–	M16X2X40 LHSCS	–
7792VXE16-A125Z10R	DP5013T	6,1	TP20	M20 X 2.5 X 50 SHCS	–	–
7792VXE16-A125Z11R	DP5013T	6,1	TB20	M20 X 2.5 X 50 SHCS	–	–
7792VXE16-160Z12R	DP5013T	6,1	TP20	–	–	–
7792VXE16-160Z13R	DP5013T	6,1	TB20	–	–	–

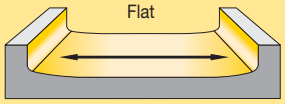
NOTE: For further application recommendation, please see technical information on pages V33–V35.

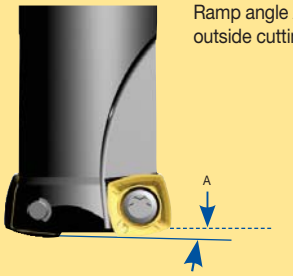
Technical Information (mm)

order number	catalogue number	dimension						max RPM
		facing pitch	ramping angle	helical hole min–max		ap max helical/ linear	a_e max plunging	
5658651	7792VXE16CA040Z2R102	16,3	2,55	50	78	2,50	13,00	33000
6025614	7792VXE16-A050Z3R	26,10	1,36	70	98	2,50	13,00	27500
6025615	7792VXE16-A050Z4R	26,10	1,36	70	98	2,50	13,00	27500
6025616	7792VXE16-A052Z4R	28	1,24	74	102	2,50	13,00	25000
5659955	7792VXE16-A063Z5R	39	0,86	96	124	2,50	13,00	22000
6025617	7792VXE16-A063Z6R	39	0,86	96	124	2,50	13,00	22000
6025618	7792VXE16-A066Z6R	41,9	0,80	102	130	2,50	13,00	23000
5667006	7792VXE16-A080Z6R	55,9	0,58	130	158	2,50	13,00	19000
6025619	7792VXE16-A080Z7R	55,9	0,58	130	158	2,50	13,00	19000
5659956	7792VXE16-A100Z8R	75,9	0,42	170	198	2,50	13,00	16500
6025620	7792VXE16-A100Z9R	75,9	0,42	170	198	2,50	13,00	16500
5661028	7792VXE16-A125Z10R	100,9	0,32	220	248	2,50	13,00	14500
6025661	7792VXE16-A125Z11R	100,9	0,32	220	248	2,50	13,00	14500
5665957	7792VXE16-160Z12R	135,8	0,23	290	318	2,50	13,00	12500
6025662	7792VXE16-160Z13R	135,8	0,23	290	318	2,50	13,00	12500


Helical Interpolation


Plunging





Ramp angle A uses one outside cutting edge only.

A = max ramp angle utilising full-face contact.

Insert Selection Guide • IC 16

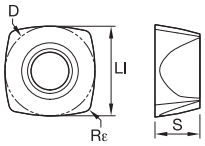
Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		⟷		toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	...D41	SC6525	**...D41**	**KCPM40**	...D41	KCPM40
P3–P4	...D41	SC6525	**...D**	**KCPM40**	...D	KCPM40
P5–P6	...D41	SP6519	**...D41**	**KCPM40**	...D41	KCPM40
M1–M2	...D41	SP6519	**...D41**	**KCSM40**	...D41	KCSM40
M3	...D41	SP6519	**...D41**	**KCSM40**	...D41	KCSM40
K1–K2	...D	KCK15	**...D**	**KCK15**	...D	KCPK30
K3	...D	KCPK30	**...D**	**KCPK30**	...D	KCPK30
N1–N2	–	–	**–**	**–**	–	–
N3	–	–	**–**	**–**	–	–
S1–S2	...D41	SP6519	**...D41**	**KCSM40**	...D41	KCSM40
S3	...D41	SP6519	**...D41**	**KCSM40**	...D41	KCSM40
S4	...D41	SP6519	**...D41**	**KCSM40**	...D41	KCSM40
H1	...D	KCPM40	**...D**	**KCPM40**	...D	KCPM40

Milling Inserts

- First choice for machining stainless steel and high-temp alloys.



XELT16-D41



XELT16-D41

● first choice
○ alternate choice

		KC522M	KCK15	KCPK30	KCPM40	KCSM40	SC3025	SC6525	SP6519	X400	X500
P		○		●	●	○		●	○	●	○
M		●		○	○	●			●		●
K		○	●	○			●	●	○		
N											
S		●				●			●		●
H										○	

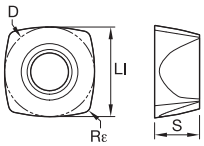
XELT16-D41 • Best fit for face milling and slotting operation. General purpose in soft steels.

catalogue number	D	LI	S	Rε	hm	RT	KC522M	KCK15	KCPK30	KCPM40	KCSM40	SC3025	SC6525	SP6519	X400	X500
XELT160512ERD41	16,79	16,79	5,56	1,2	0,05	4,18	–	–	–	–	●	–	●	●	–	●

NOTE: RT is the theoretical radius to be used for CAD/CAM programming.

Copy Milling


XEPT16-D41



XEPT16-D41

● first choice
○ alternate choice

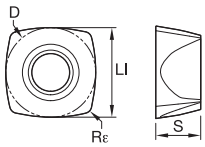
		KC522M	KCK15	KCPK30	KCPM40	KCSM40	SC3025	SC6525	SP6519	X400	X500
P		○		●	●	○		●	○	●	○
M		●		○	○	●			●		●
K		○	●	○			●	●	○		
N											
S		●				●			●		●
H										○	

XEPT16-D41 • Precision pressed insert • Best fit for face milling and slotting operation. General purpose in soft steels.

catalogue number	D	LI	S	Rε	hm	RT	KC522M	KCK15	KCPK30	KCPM40	KCSM40	SC3025	SC6525	SP6519	X400	X500
XEPT160512ERD41	16,80	16,80	5,56	1,2	0,05	4,18	–	–	–	–	●	–	–	–	–	–
XEPT160516ERD41	16,80	16,80	5,56	1,6	0,05	4,44	●	–	●	●	–	–	–	–	–	–

NOTE: RT is the theoretical radius to be used for CAD/CAM programming.


XEPW16-D



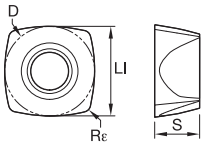
XEPW16-D

XEPW16-D • Precision pressed insert. First Choice for machining steel and cast iron

catalogue number	D	LI	S	Rε	hm	RT	KC522M	KCK15	KCPK30	KCPM40	KCSM40	SC3025	SC6525	SP6519	X400	X500
XEPW160520SRD	16,80	16,79	5,56	2,0	0,12	4,75	●	●	●	●	–	–	–	–	–	–

NOTE: RT is the theoretical radius to be used for CAD/CAM programming.


XELW16-D



XELW16-D

XELW16-D • First Choice for machining steel and cast iron

catalogue number	D	LI	S	Rε	hm	RT	KC522M	KCK15	KCPK30	KCPM40	KCSM40	SC3025	SC6525	SP6519	X400	X500
XELW160512SRD	16,79	16,79	5,56	1,2	0,12	4,18	–	–	–	–	–	●	–	–	●	–

NOTE: RT is the theoretical radius to be used for CAD/CAM programming.

Recommended Starting Feeds [mm] • High-Feed

Light Machining	General Purpose	Heavy Machining

At 3,50 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.E..D41	0,30	**0,98**	1,66	0,22	**0,71**	1,18	0,17	**0,53**	0,88	0,14	**0,46**	0,76	0,13	**0,42**	0,70	.E..D41
.S..D	0,44	**1,11**	1,80	0,32	**0,80**	1,28	0,24	**0,59**	0,95	0,21	**0,52**	0,83	0,19	**0,47**	0,76	.S..D

At 2,50 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.E..D41	0,36	**1,15**	1,95	0,26	**0,83**	1,38	0,19	**0,62**	1,03	0,17	**0,54**	0,89	0,15	**0,49**	0,82	.E..D41
.S..D	0,51	**1,30**	2,12	0,37	**0,93**	1,50	0,28	**0,70**	1,11	0,24	**0,61**	0,97	0,22	**0,55**	0,89	.S..D

At 2,00 Axial Depth of Cut (ap)

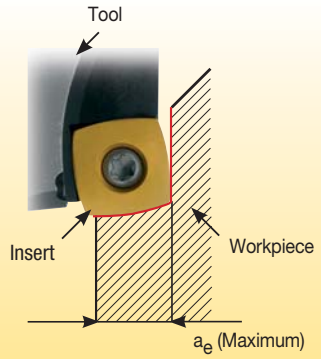
Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.E..D41	0,40	**1,28**	2,18	0,29	**0,92**	1,54	0,21	**0,68**	1,14	0,19	**0,60**	0,99	0,17	**0,55**	0,91	.E..D41
.S..D	0,57	**1,45**	2,37	0,41	**1,04**	1,67	0,31	**0,77**	1,24	0,27	**0,67**	1,08	0,25	**0,62**	0,99	.S..D

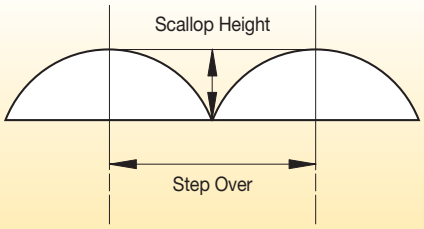
Feed Rate Guide • Plunging • IC 16 • fz [mm/tooth]

Insert Geometry	Programmed Feed per Tooth (fz) Max 13mm insert engagement (ae radial engagement)			Insert Geometry
.E..D41	0,07	**0,23**	0,38	.E..D41
.S..D	0,10	**0,25**	0,41	.S..D

NOTE: For further details about using the 7792VX series in plunging operations, please see page V33.
Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

Plunging





The cutting edge should not be in contact with the material face after machining to maintain the cutting edge quality.

The scallop height is calculated in relation to the step over.

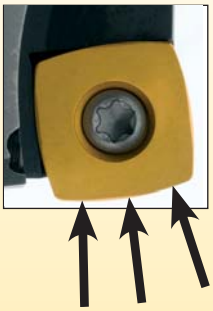
The maximum radial engagement is directly in relation to insert cutting edge length.

For insert type:
XP…06 the ae, max is 3mm.
XD…09 the ae, max is 6mm.
XD…12 the ae, max is 9mm.
XE…16 the ae, max is 13mm.

The advantages of face milling and producing cavities with the Stellram® high-feed face mill are numerous.
The unique design of the insert, approach angle, and the cutter body ensure the cutting forces are predominantly directed in the axial direction.
The example shown with a round insert tool shows complex forces which result in high levels of vibration and damage to the cutting edge.

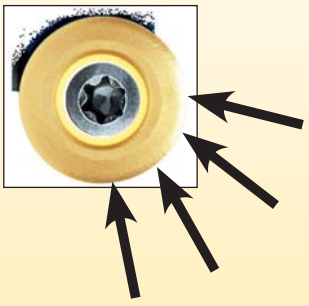
7792VX

- Cutting forces predominantly axial.
- Relationship between cutting edge and workpiece is at its most stable.
- Results in high feed rates and consistent tool life.



Round Insert Tools

- Tangential forces act around the radius.
- Leads to vibration and damage of the cutting edge.
- Leads to reduced feed and lower productivity.



The 7792VX machines with a constant volume of chip throughout all aspects of producing cavities and produces a side wall that is close to profile.

7792VX

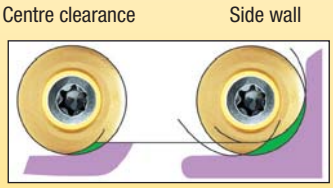
- Constant cutting section (chip volume) irrespective of position in cavity.
- Producing a close to profile side wall.
- Near-square side walls possible.



Round insert tools have increasing chip volume through the process.

Round insert

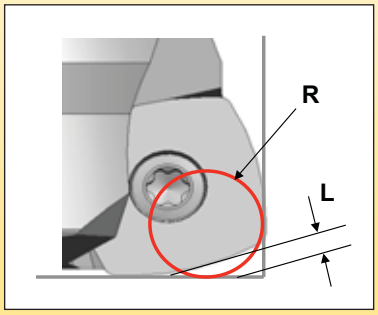
- Greater surface contact.
- Increased chip section for side wall machining.
- Vibration in corners.
- Undulating side wall cusps.



CNC Programme • Corner Radius Definition

The use of common CAD/CAM systems requires a round insert dimension to be known for cavity machining. This is available with 7792VX cutters as shown below and in the reference table.

For finish pass applications:
Wiper Facet for finishing use max feed 0,5 mm/z

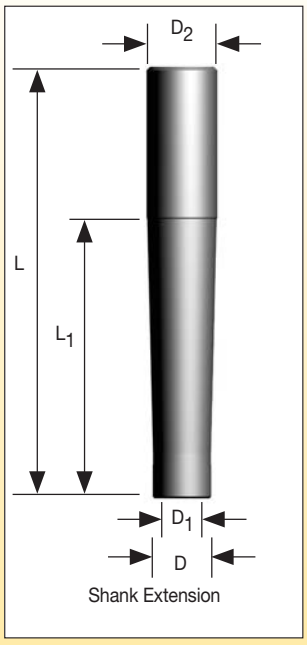


Programming Data (mm)			
Insert corner nose size (IC)	Rε	R	L
06	0,80	1,37	0,40
09	0,80	2,01	0,73
	1,20	2,27	0,67
12	0,80	2,50	1,02
	1,20	2,73	0,97
16	1,20	4,18	1,46

Cylindrical Shank Extensions for Modular Heads

order number	catalogue number	dimension					
			ramping angle		helical hole		
		L	L1	D_2	D	D1	M
5673782	**M-13-M8-CA16-090**	90	40	16	13	8,50	M8
5673352	**M-13-M8-CA16-110**	110	60	16	13	8,50	M8
5672829	**M-13-M8-CA16-130**	130	80	16	13	8,50	M8
5673587	**M-13-M8-CA16-170**	170	120	16	13	8,50	M8
5673703	**M-18-M10-CA20-110**	110	60	20	18	10,50	M10
5673519	**M-18-M10-CA20-130**	130	80	20	18	10,50	M10
5672984	**M-18-M10-CA20-170**	170	120	20	18	10,50	M10
5672830	**M-18-M10-CA20-190**	190	140	20	18	10,50	M10
5672985	**M-21-M12-CA25-131**	131	75	25	21	12,50	M12
5672468	**M-21-M12-CA25-156**	156	100	25	21	12,50	M12
5672986	**M-21-M12-CA25-181**	181	125	25	21	12,50	M12
5672831	**M-21-M12-CA25-206**	206	150	25	21	12,50	M12
5672987	**M-21-M12-CA25-231**	231	175	25	21	12,50	M12
5672832	**M-29-M16-CA32-160**	160	100	32	29	17,00	M16
5672988	**M-29-M16-CA32-210**	210	150	32	29	17,00	M16
5673783	**M-29-M16-CA32-260**	260	200	32	29	17,00	M16
5672989	**M-29-M16-CA32-310**	310	250	32	29	17,00	M16

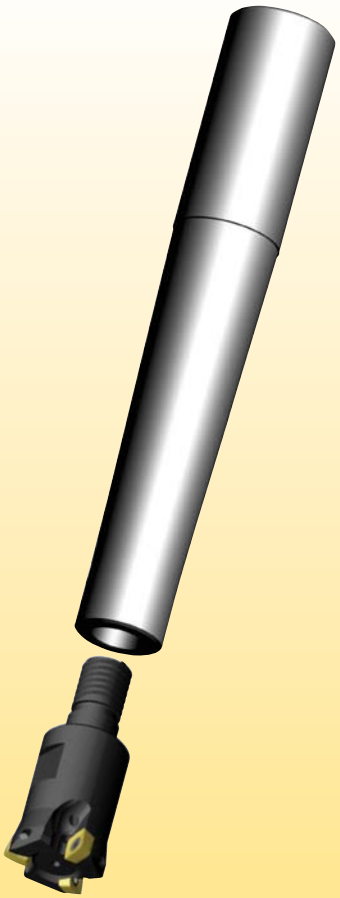
NOTE: Order example with cylindrical shank: M-13-M8-CA.625-3.543.



Shank Extension

Cylindrical shank extensions can be used with all modular heads found in several product family series within this catalogue.

These extensions have the industry standard of metric threads.



Technical Advice

M	Modular adaptor
13	Diameter in front of the modular shank (D) = 13mm
M8	Metric Thread (M)
CA16	Cylindrical shank diameter 16mm with through coolant
90	Total length of the body

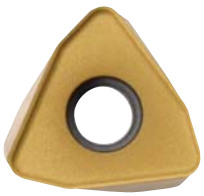
KenFeed™ 2X Series

Primary Application

KenFeed 2X is a double-sided trigon insert with six cutting edges engineered to provide superior metal removal and productivity through high feed rates in roughing operations. Smaller depths of cut at extremely high feed rates result in lower cutting forces, reducing vibrations and increasing process reliability.

Features and Benefits

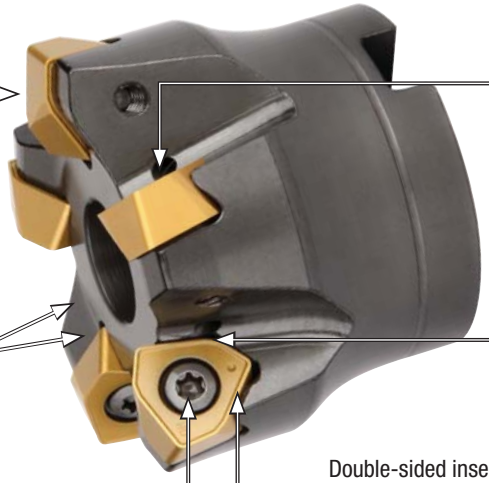
- Six cutting edges per insert. Double-sided solution with unique design.
- Two different topography styles cover any type of material, component, and application.
- KenFeed 2X inserts are specially suitable for long, deep applications, up to 10 x L/D ratio.



9mm IC Insert WOEJ094....
Up to 1,5mm Ap max.
Diameter 25–80mm

The ultimate and innovative concept for applying the latest high-feed milling strategies.





Strong design with a thick insert provides outstanding reliability.

Screw-on, end mill, and shell mill cutters with internal coolant.

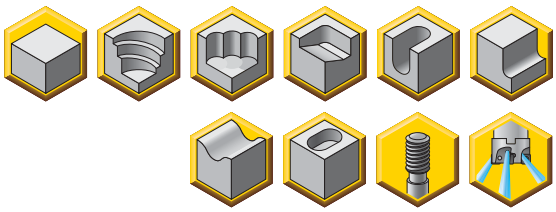
Platform designed for pocketing, ramping, and helical interpolations.

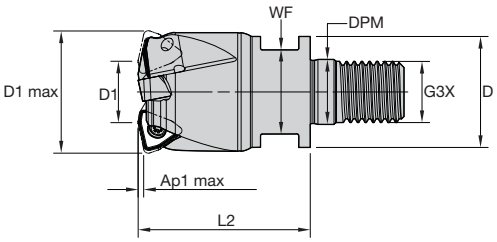
Just two topographies to cover all applications with easy selection.

Double-sided insert with six cutting edges for better cost-per-edge position with full usage.

No need for additional clamping device. Screw provides easy handling.

- Dramatically improves MRR using the latest milling strategies.
- Engineered to run up to 2,5mm fz.
- Ideal for pocketing, ramping, and helical interpolations. Z-plunge capabilities.
- First choice for deep cavities or from 3 x D.







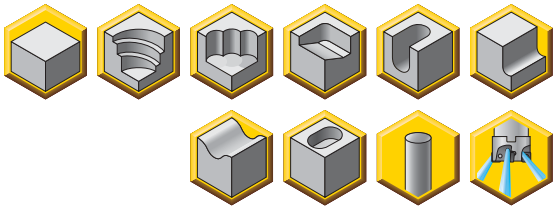
Screw-On End Mills

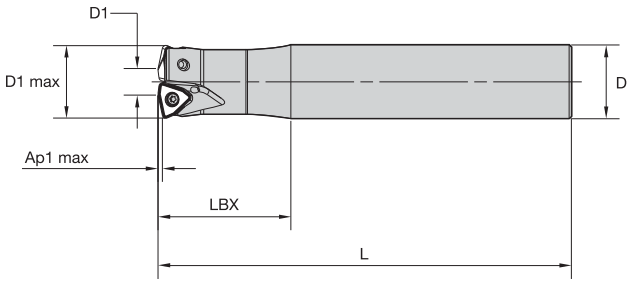
order number	catalogue number	D1 max	D1	D	DPM	WF	G3X	L2	Ap1 max	Z	kg	max RPM	insert 1
4113983	**KF2X25Z02M12WO09**	25	9	21	13	17	M12	35	1,5	2	0,09	37000	WOEJ090512__
4113984	**KF2X32Z03M16WO09**	32	16	29	17	22	M16	45	1,5	3	0,22	30900	WOEJ090512__
4113985	**KF2X35Z03M16WO09**	35	19	29	17	22	M16	45	1,5	3	0,24	29000	WOEJ090512__
4113986	**KF2X42Z04M16WO09**	42	26	29	17	22	M16	45	1,5	4	0,28	25800	WOEJ090512__

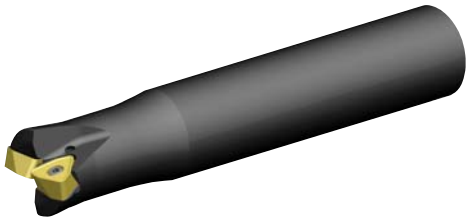
Spare Parts

D1 max	 insert screw	 Nm	 Torx Plus driver
25	**MS2219**	1,8	**DT9IP**
32	**MS2219**	1,8	**DT9IP**
35	**MS2219**	1,8	**DT9IP**
42	**MS2219**	1,8	**DT9IP**

- Dramatically improves MRR using the latest milling strategies.
- Engineered to run up to 2,5mm fz.
- Ideal for pocketing, ramping, and helical interpolations. Z-plunge capabilities.
- First choice for deep cavities or from 3 x D.







End Mills

order number	catalogue number	D1 max	D1	D	L	LBX	Ap1 max	Z	kg	max RPM	insert 1
4113987	**KF2X25Z02A25WO09L140**	25	9	25	140	45	1,5	2	0,46	37000	WOEJ090512__
4113988	**KF2X25Z02A25WO09L200**	25	9	25	200	45	1,5	2	0,68	37000	WOEJ090512__
4113989	**KF2X25Z02A25WO09L300**	25	9	25	300	45	1,5	2	1,05	37000	WOEJ090512__
4113990	**KF2X28Z02A25WO09L200**	28	11	25	200	45	1,5	2	0,70	34000	WOEJ090512__
4113991	**KF2X32Z03A32WO09L150**	32	16	32	150	50	1,5	3	0,82	30900	WOEJ090512__
4113992	**KF2X32Z03A32WO09L200**	32	16	32	200	50	1,5	3	1,13	30900	WOEJ090512__
4113993	**KF2X32Z03A32WO09L300**	32	16	32	300	50	1,5	3	1,75	30900	WOEJ090512__
4113994	**KF2X35Z03A32WO09L200**	35	19	32	200	45	1,5	3	1,16	29000	WOEJ090512__

Spare Parts

D1 max	 insert screw	 Nm	 Torx Plus driver
25	**MS2219**	1,8	**DT9IP**
28	**MS2219**	1,8	**DT9IP**
32	**MS2219**	1,8	**DT9IP**
35	**MS2219**	1,8	**DT9IP**

- Dramatically improves MRR using the latest milling strategies.
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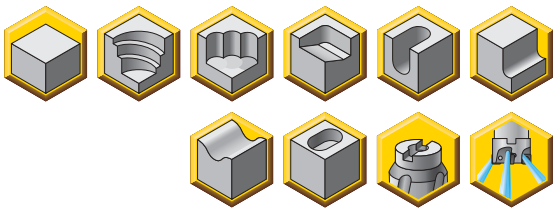
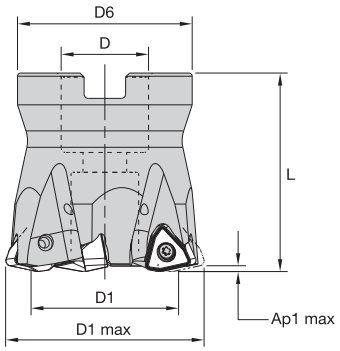
- First choice for deep cavities or from 3 x D.







Face Mills

order number	catalogue number	D1 max	D1	D	D6	L	Ap1 max	Z	kg	max RPM	insert 1
4113995	**KF2X40Z04WO09**	40	24	22	37	40	1,5	4	0,18	26600	WOEJ090512__
4113996	**KF2X50Z05WO09**	50	34	22	44	50	1,5	5	0,39	23100	WOEJ090512__
4113997	**KF2X52Z05WO09**	52	36	22	44	50	1,5	5	0,42	22600	WOEJ090512__
5396014	**KF2X63Z05S22WO09**	63	47	22	49	50	1,5	5	0,76	20100	WOEJ090512SRHD
4113998	**KF2X63Z05WO09**	63	47	22	60	50	1,5	5	0,76	20100	WOEJ090512__
5396015	**KF2X66Z06S22WO09**	66	50	22	49	50	1,5	6	0,78	19600	WOEJ090512SRHD
4113999	**KF2X66Z06WO09**	66	50	27	60	50	1,5	6	0,78	19600	WOEJ090512__
4114000	**KF2X80Z07WO09**	80	64	27	60	50	1,5	7	1,07	17500	WOEJ090512__

Spare Parts







D1 max	insert screw	Nm	Torx Plus driver	socket-head cap screw	mounting screw
40	**MS2219**	1,0	**DT9IP**	**–**	**KLSSM22-39-CG**
50	**MS2219**	1,0	**DT9IP**	**125.025**	**–**
52	**MS2219**	1,0	**DT9IP**	**125.025**	**–**
63	**MS2219**	1,0	**DT9IP**	**125.025**	**–**
66	**MS2219**	1,0	**DT9IP**	**125.025**	**–**
66	**MS2219**	1,0	**DT9IP**	**125.225**	**–**
80	**MS2219**	1,0	**DT9IP**	**125.230**	**–**

Insert Selection Guide

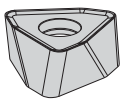
Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		◄———	———►	toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.S..GD	KCPK30	**.S..GD**	**KCPM40**	.S..HD	KCPM40
P3–P4	.S..GD	KCPK30	**.S..GD**	**KCPM40**	.S..HD	KCPM40
P5–P6	.S..GD	KCPK30	**.S..GD**	**KC725M**	.S..HD	KC725M
M1–M2	.S..GD	KC522M	**.S..GD**	**KC725M**	.S..HD	KC725M
M3	.S..GD	KCPK30	**.S..GD**	**KCPM40**	.S..HD	KCPM40
K1–K2	.S..HD	KCK15	**.S..HD**	**KCK15**	.S..HD	KCK15
K3	.S..GD	KCPK30	**.S..HD**	**KCK15**	.S..HD	KCPK30
N1–N2	–	–	**–**	**–**	–	–
N3	–	–	**–**	**–**	–	–
S1–S2	.S..GD	KC522M	**.S..GD**	**KC725M**	.S..HD	KC725M
S3	.S..GD	KC725M	**.S..GD**	**KCPM40**	.S..HD	KCPM40
S4	.S..GD	KC522M	**.S..HD**	**KC522M**	.S..HD	KC725M
H1	–	–	**–**	**–**	–	–

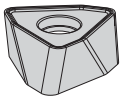
Indexable Inserts • WOEJ09...

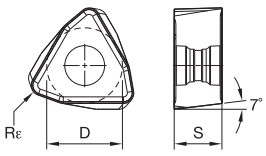
- Double-sided insert with six cutting edges.
- Unique and strong insert design that enables high-feed conditions, up to 2,5mm fz.
- -HD geometry is the first choice for steels, high-strength steels, and cast iron.
- -GD provides lower cutting forces; first choice for soft materials.

● first choice
○ alternate choice

	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30
P		○	●		●	●	
M		●	●		○	○	○
K	●	○		●	○		
N							
S		●	●				●
H		○					


WOEJ-GD


WOEJ-HD



WOEJ-GD
WOEJ-HD

WOEJ-GD

catalogue number	D	S	Rε	cutting edges	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30
WOEJ090512SRGD	8,90	5,40	1,2	6	–	●	●	–	●	●	●

WOEJ-HD

catalogue number	D	S	Rε	cutting edges	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30
WOEJ090512SRHD	8,90	5,50	1,2	6	–	●	●	–	●	●	–

Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.S..GD	1,15	**2,42**	3,84	0,82	**1,71**	2,67	0,61	**1,26**	1,96	0,53	**1,10**	1,70	0,49	**1,01**	1,55	.S..GD
.S..HD	1,15	**2,78**	4,27	0,82	**1,96**	2,94	0,61	**1,44**	2,16	0,53	**1,26**	1,87	0,49	**1,15**	1,71	.S..HD

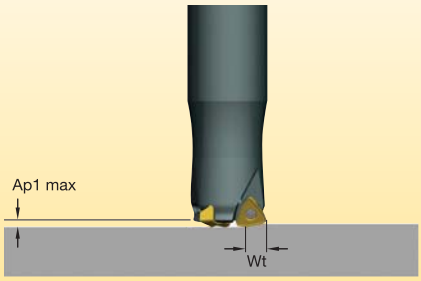
Feed Rate Guide • Plunging • IC09 • fz [mm/tooth]

Insert Geometry	Programmed Feed per Tooth (fz) Max 13mm insert engagement (ae radial engagement)			Insert Geometry
.S..GD	0,10	**0,21**	0,32	.S..GD
.S..HD	0,10	**0,24**	0,36	.S..HD

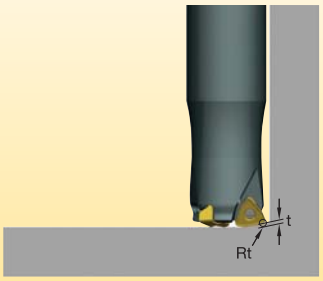
NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

General Programming Information for Applying KenFeed 2X • IC09

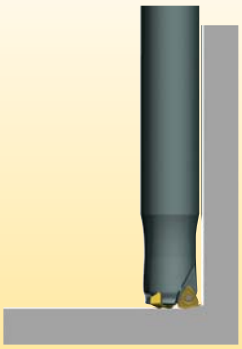
Rt	Wt	t
2.70	8.15	1.15



Small Ap1 values and higher feed rates generate lower cutting forces versus traditional milling strategies.

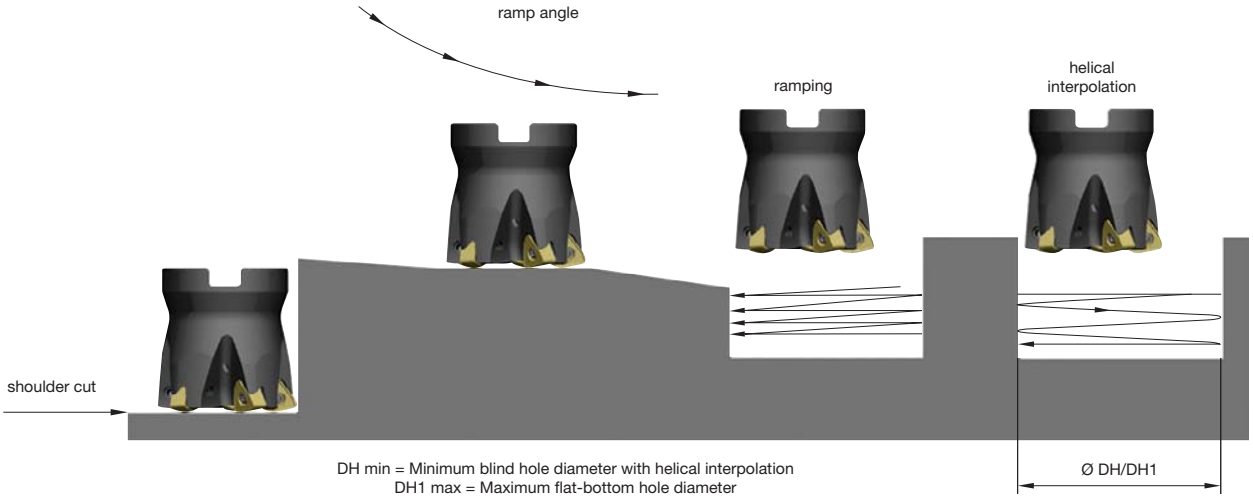


For CAM programming, the loads can be programmed as a toroidal tool type by using the Rt value as the insert radius.



Recommended when long overhang is necessary due to lower radial forces. Maximum L/D ratio of 10 x D.

Maximum Linear Ramping and Helical Interpolation from Solid



cutter type	catalogue number	recommended ramping angle (for continuous ramping process)	max ramp angle when Ap max (not for continuous ramping process)	max ramp angle for 360° helical interpolation	min hole diameter (DH min)	max flat-bottom hole diameter (DH1 max)	max diameter (no flat bottom)
Screw-On	**KF2X2X25Z02M12WO09**	3.6°	5.4°	3.1°	26,5	33,7	50
	KF2X32Z03M16WO09	1.8°	2.7°	1.7°	41,2	48,4	64
	KF2X35Z03M16WO09	1.6°	2.4°	1.4°	46,8	54,0	70
	KF2X42Z04M16WO09	1.2°	1.9°	0.8°	68,7	75,9	84
End Mills	**KF2X25Z02A25WO09L140**	3.6°	5.4°	3.1°	26,5	33,7	50
	KF2X25Z02A25WO09L200	3.6°	5.4°	3.1°	26,5	33,7	50
	KF2X25Z02A25WO09L300	3.6°	5.4°	3.1°	26,5	33,7	50
	KF2X28Z02A25WO09L200	3.1°	4.6°	2.5°	31,6	38,8	56
	KF2X32Z03A32WO09L150	1.8°	2.7°	1.7°	41,2	48,4	64
	KF2X32Z03A32WO09L200	1.8°	2.7°	1.7°	41,2	48,4	64
	KF2X32Z03A32WO09L300	1.8°	2.7°	1.7°	41,2	48,4	64
	KF2X35Z03A32WO09L200	1.6°	2.4°	1.4°	46,8	54,0	70
Face Mills	**KF2X40Z04WO09**	1.3°	2.0°	1.2°	56,4	63,6	80
	KF2X50Z05WO09	1.0°	1.5°	0.8°	76,7	83,9	100
	KF2X52Z05WO09	1.0°	1.4°	0.8°	80,7	87,9	104
	KF2X63Z05S22WO09	0.8°	1.2°	0.6°	102,7	109,9	126
	KF2X63Z05WO09	0.8°	1.2°	0.6°	102,7	109,9	126
	KF2X66Z06S22WO09	0.7°	1.1°	0.5°	108,7	115,9	132
	KF2X66Z06WO09	0.7°	1.1°	0.5°	108,7	115,9	132
	KF2X80Z07WO09	0.6°	0.9°	0.4°	136,6	143,8	160

Rodeka™ Inserts

The New Round Insert Generation

Primary Application

Kennametal introduces a revolutionary double-sided round milling insert capable of running in multiple types of milling operations and workpiece materials. The Rodeka series provides the latest double-sided insert technology to boost your productivity with the most efficient cost per edge.

Features and Benefits

Rodeka Double-Sided Round Inserts

- Three insert sizes: 10, 12, and 16mm.
- Innovative, cutting-edge design increases tool life and reduces cutting forces.
- Rodeka 12X series is a tailor-made solution for turbine blade machining.



Rodeka 10
10mm IC insert
8 cutting edges



Rodeka 12X
12mm IC insert
8 cutting edges

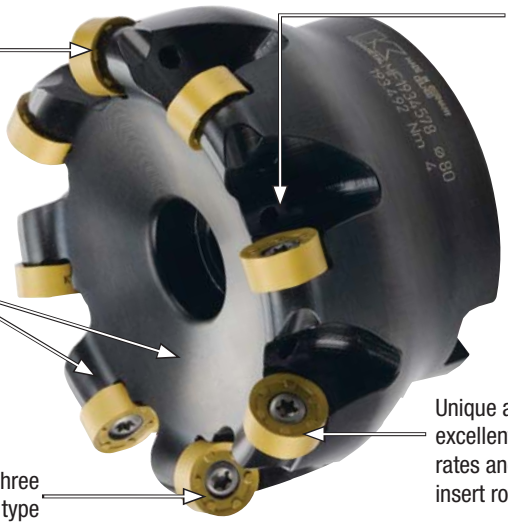


Rodeka 12
12mm IC insert
12 cutting edges



Rodeka 16
16mm IC insert
12 cutting edges





Double-sided insert with up to 12 cutting edges for a more productive cutting process.

Screw-on, end mill, and shell mill cutters with internal coolant.

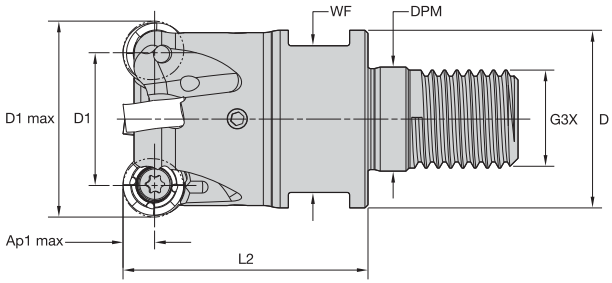
Higher clearance in bodies to permit pocketing, profiling, and 5-axis machining.

Unique anti-rotation feature for excellent stability with higher feed rates and cutting forces. User-friendly insert rotation.

Three different insert sizes and three topography styles per size cover any type of material, component, and application.

- Double-sided round inserts with eight indexable positions.
- Anti-rotation features enable higher cutting data and extra stability.
- Pocketing and profiling capabilities.







Screw-On End Mills

order number	catalogue number	D1 max	D1	D	DPM	WF	G3X	L2	Ap1 max	Z	max ramp angle	kg	max RPM	insert 1
5152621	**KDR25Z03M12RN10**	25	15	21	13	17	M12	32	5,0	3	.6°	0,07	54700	RNGJ10T3M0_N__
5152622	**KDR32Z04M16RN10**	32	22	29	17	24	M16	40	5,0	4	.5°	0,18	48300	RN_J10T3M0_N__
5152623	**KDR35Z05M16RN10**	35	25	29	17	24	M16	40	5,0	5	.5°	0,20	46200	RN_J10T3M0_N__
5152624	**KDR40Z05M16RN10**	40	30	29	17	24	M16	40	5,0	5	.4°	0,23	43200	RN_J10T3M0_N__

Spare Parts

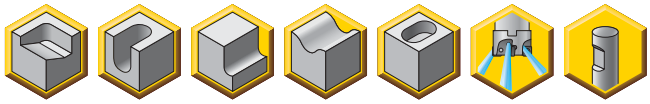


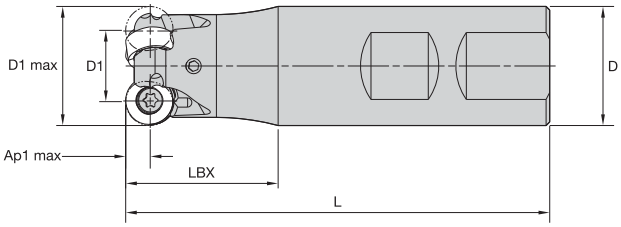




D1 max	insert screw	Nm	Torx Plus driver
25	**191.848**	2,0	**170.025**
32	**191.848**	2,0	**170.025**
35	**191.848**	2,0	**170.025**
40	**191.848**	2,0	**170.025**

- Double-sided round inserts with eight indexable positions.
- Anti-rotation features enable higher cutting data and extra stability.
- Pocketing, profiling, ramping, and helical interpolation capabilities.







Weldon End Mills

order number	catalogue number	D1 max	D1	D	L	LBX	Ap1 max	Z	max ramp angle	kg	max RPM	insert 1
5152626	**KDR25Z03B25RN10**	25	15	25	89	32	5,0	3	.6°	0,27	54700	RN_J10T3M0_N__

Spare Parts

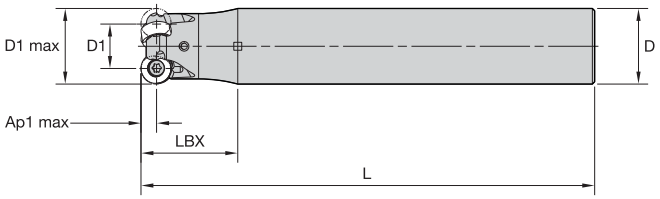




D1 max	insert screw	Nm	Torx Plus driver
25	**191.848**	2,0	**170.025**

- Double-sided round insert with eight indexable positions.
- Anti-rotation features enable higher cutting forces and extra stability.
- Pocketing and profiling capabilities.







Cylindrical End Mills

order number	catalogue number	D1 max	D1	D	L	LBX	Ap1 max	Z	max ramp angle	kg	max RPM	insert 1
5152629	**KDR25Z03A25RN10L150**	25	15	25	150	32	5,0	3	.6°	0,50	54700	RN_J10T3M0_N__
5152680	**KDR25Z03A25RN10L200**	25	15	25	200	32	5,0	3	.6°	0,69	54700	RN_J10T3M0_N__
5152681	**KDR25Z03A32RN10L250**	25	15	32	250	32	5,0	3	.6°	1,42	54700	RN_J10T3M0_N__
5152684	**KDR32Z03A32RN10L250**	32	22	32	250	40	5,0	3	.5°	1,44	48300	RN_J10T3M0_N__
5152683	**KDR32Z04A32RN10L200**	32	22	32	200	40	5,0	4	.5°	1,14	48300	RN_J10T3M0_N__

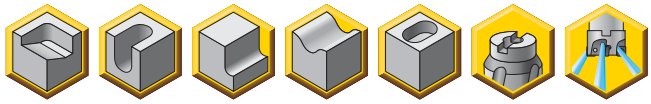
Spare Parts

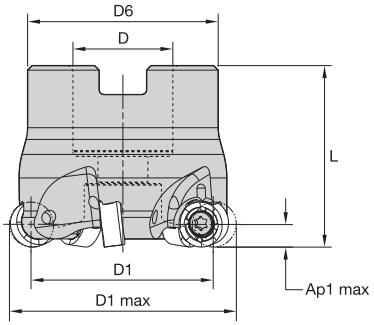




D1 max	insert screw	Nm	Torx Plus driver
25	**191.848**	2,0	**170.025**
32	**191.848**	2,0	**170.025**

- Double-sided round inserts with eight indexable positions.
- Anti-rotation features enable higher cutting data and extra stability.
- Pocketing and profiling capabilities.







Shell Mills

order number	catalogue number	D1 max	D1	D	D6	L	Ap1 max	Z	max ramp angle	kg	max RPM	insert 1
5152685	**KDR40Z04S16RN10**	40	30	16	38	40	5,0	4	.4°	0,24	43200	RN_J10T3M0_N__
5152686	**KDR40Z06S16RN10**	40	30	16	38	40	5,0	6	.4°	0,24	43200	RN_J10T3M0_N__
5152687	**KDR50Z05S22RN10**	50	40	22	42	40	5,0	5	.3°	0,32	38600	RN_J10T3M0_N__
5152688	**KDR50Z06S22RN10**	50	40	22	42	40	5,0	6	.3°	0,32	38600	RN_J10T3M0_N__
5152689	**KDR52Z06S22RN10**	52	42	22	49	50	5,0	6	.3°	0,52	37900	RN_J10T3M0_N__
5152690	**KDR63Z07S22RN10**	63	53	22	49	50	5,0	7	.3°	0,66	34400	RN_J10T3M0_N__
5152691	**KDR66Z07S27RN10**	66	56	27	60	50	5,0	7	.3°	0,86	33600	RN_J10T3M0_N__
5152692	**KDR80Z08S27RN10**	80	70	27	60	50	5,0	8	.2°	1,07	30500	RN_J10T3M0_N__

Spare Parts






D1 max	insert screw	Nm	socket-head cap screw	Torx Plus driver
40	**191.848**	2,0	**MS1294**	**170.025**
50	**191.848**	2,0	**–**	**170.025**
52	**191.848**	2,0	**MS1242**	**170.025**
63	**191.848**	2,0	**MS1242**	**170.025**
66	**191.848**	2,0	**MS2038**	**170.025**
80	**191.848**	2,0	**MS2038**	**170.025**

Insert Selection Guide

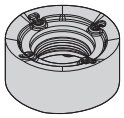
Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		◄———	———►	toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.E..LDJ	KC725M	**.S..GD**	**KCPM40**	.S..HD	KCPM40
P3–P4	.S..GD	KCPK30	**.S..HD**	**KCPK30**	.S..HD	KCPM40
P5–P6	.E..LDJ	KC725M	**.S..GDJ**	**KC725M**	.S..HD	KC725M
M1–M2	.E..LDJ	KC522M	**.E..LDJ**	**KCSM40**	.S..GDJ	KC522M
M3	.E..LDJ	KCSM40	**.S..GD**	**KCPM40**	.S..HD	KCPM40
K1–K2	.S..HD	KC520M	**.S..HD**	**KC520M**	.S..HD	KCK15
K3	.S..HD	KC520M	**.S..HD**	**KCK15**	.S..HD	KCPK30
N1–N2	.F..LDJ	KC422M	**.F..LDJ**	**KC422M**	.S..GD	KC510M
N3	–	–	**–**	**–**	–	–
S1–S2	.E..LDJ	KC725M	**.S..GDJ**	**KC725M**	.S..HD	KC725M
S3	.E..LDJ	KCSM40	**.S..GD**	**KCPM40**	.S..HD	KCPM40
S4	.E..LDJ	KC522M	**.E..LDJ**	**KCSM40**	.S..GDJ	KC522M
H1	.S..GD	KC510M	**.S..GD**	**KC510M**	–	–

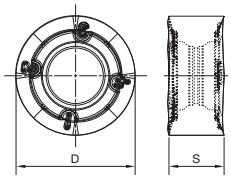
Indexable Inserts RN.J10..

- -LD geometry is the first choice for stainless steel and titanium machining at lower cutting forces.

● first choice
○ alternate choice

	KC422M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
P		○		○	●		●	●		○
M				●	●		○	○	○	●
K		●	●	○		●	○			
N	●	○								
S				●	●				●	●
H										


RNGJ10-LD

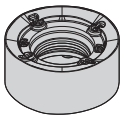


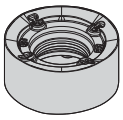
RNGJ10-LD

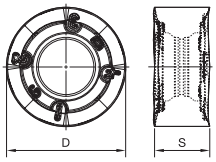
RNGJ10-LD

catalogue number	D	S	hm	cutting edges	KC422M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
RNGJ10T3M0ELDJ	10,00	3,93	0,04	8	–	–	–	–	●	–	–	–	–	●
RNGJ10T3M0FLDJ	10,00	3,93	0,04	8	●	–	–	–	–	–	–	–	–	–

- -GD geometry is for general use in steel and stainless steel.


RNGJ10-GD


RNPJ10-HD



RNGJ10-GD

● first choice
○ alternate choice

		KC422M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
P			○		○	●		●	●		○
M					●	●		○	○	○	●
K			●	●	○		●	○			
N		●	○								
S					●	●				●	●
H											

RNGJ10-GD

catalogue number	D	S	hm	cutting edges	KC422M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
RNGJ10T3M0SGDJ	10,00	3,93	0,09	8	–	–	–	–	–	–	–	–	●	–

RNGJ10-GDJ

catalogue number	D	S	hm	cutting edges	KC422M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
RNGJ10T3M0SGDJ	10,00	3,93	0,09	8	–	–	–	–	●	–	–	–	–	–

RNPJ10-GD

catalogue number	D	S	hm	cutting edges	KC422M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
RNPJ10T3M0SGD	10,00	3,93	0,09	8	–	–	–	●	–	–	●	●	–	–

- -HD geometry is the first choice for heavy machining high-strength steel and cast iron.

RNPJ10-HD

catalogue number	D	S	hm	cutting edges	KC422M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
RNPJ10T3M0SHD	10,00	3,93	0,18	8	–	–	–	–	●	●	●	●	–	–

Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining

At 5,00 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.F..LDJ	0,12	**0,40**	0,72	0,09	**0,29**	0,51	0,07	**0,21**	0,38	0,06	**0,19**	0,33	0,05	**0,17**	0,30	.F..LDJ
.E..LDJ	0,12	**0,44**	0,76	0,09	**0,32**	0,54	0,07	**0,24**	0,41	0,06	**0,21**	0,35	0,05	**0,19**	0,32	.E..LDJ
.E..LD	0,12	**0,44**	0,76	0,09	**0,32**	0,54	0,07	**0,24**	0,41	0,06	**0,21**	0,35	0,05	**0,19**	0,32	.E..LD
.S..GDJ	0,24	**0,53**	0,82	0,17	**0,38**	0,59	0,13	**0,28**	0,44	0,11	**0,25**	0,38	0,10	**0,23**	0,35	.S..GDJ
.S..GD	0,24	**0,53**	0,82	0,17	**0,38**	0,59	0,13	**0,28**	0,44	0,11	**0,25**	0,38	0,10	**0,23**	0,35	.S..GD
.S..HD	0,24	**0,53**	0,83	0,17	**0,38**	0,59	0,13	**0,29**	0,44	0,11	**0,25**	0,38	0,10	**0,23**	0,35	.S..HD

At 2,00 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.F..LDJ	0,15	**0,50**	0,90	0,11	**0,36**	0,64	0,08	**0,27**	0,48	0,07	**0,23**	0,42	0,07	**0,21**	0,38	.F..LDJ
.E..LDJ	0,15	**0,56**	0,96	0,11	**0,40**	0,68	0,08	**0,30**	0,51	0,07	**0,26**	0,44	0,07	**0,24**	0,40	.E..LDJ
.E..LD	0,15	**0,56**	0,96	0,11	**0,40**	0,68	0,08	**0,30**	0,51	0,07	**0,26**	0,44	0,07	**0,24**	0,40	.E..LD
.S..GDJ	0,29	**0,67**	1,04	0,21	**0,48**	0,74	0,16	**0,35**	0,55	0,14	**0,31**	0,48	0,13	**0,28**	0,44	.S..GDJ
.S..GD	0,29	**0,67**	1,04	0,21	**0,48**	0,74	0,16	**0,35**	0,55	0,14	**0,31**	0,48	0,13	**0,28**	0,44	.S..GD
.S..HD	0,29	**0,67**	1,04	0,21	**0,48**	0,74	0,16	**0,36**	0,55	0,14	**0,31**	0,48	0,13	**0,28**	0,44	.S..HD

At 1,00 Axial Depth of Cut (ap)

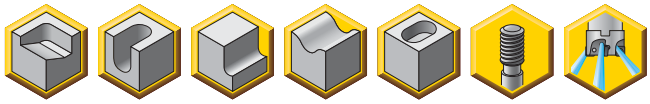
Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.F..LDJ	0,21	**0,67**	1,22	0,15	**0,48**	0,86	0,11	**0,36**	0,64	0,10	**0,31**	0,55	0,09	**0,29**	0,51	.F..LDJ
.E..LDJ	0,21	**0,75**	1,30	0,15	**0,53**	0,92	0,11	**0,40**	0,68	0,10	**0,35**	0,59	0,09	**0,32**	0,54	.E..LDJ
.E..LD	0,21	**0,75**	1,30	0,15	**0,53**	0,92	0,11	**0,40**	0,68	0,10	**0,35**	0,59	0,09	**0,32**	0,54	.E..LD
.S..GDJ	0,39	**0,89**	1,40	0,28	**0,64**	0,99	0,21	**0,47**	0,73	0,18	**0,41**	0,63	0,17	**0,38**	0,58	.S..GDJ
.S..GD	0,39	**0,89**	1,40	0,28	**0,64**	0,99	0,21	**0,47**	0,73	0,18	**0,41**	0,63	0,17	**0,38**	0,58	.S..GD
.S..HD	0,39	**0,90**	1,41	0,28	**0,64**	0,99	0,21	**0,48**	0,73	0,18	**0,41**	0,64	0,17	**0,38**	0,58	.S..HD

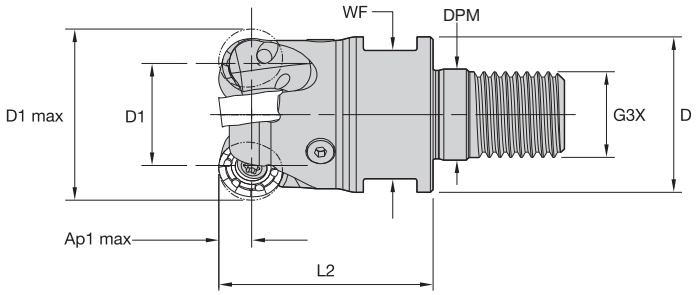
At 0,50 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.F..LDJ	0,29	**0,93**	1,71	0,21	**0,66**	1,19	0,15	**0,49**	0,88	0,13	**0,43**	0,76	0,12	**0,39**	0,70	.F..LDJ
.E..LDJ	0,29	**1,04**	1,83	0,21	**0,74**	1,27	0,15	**0,55**	0,93	0,13	**0,48**	0,81	0,12	**0,44**	0,74	.E..LDJ
.E..LD	0,29	**1,04**	1,83	0,21	**0,74**	1,27	0,15	**0,55**	0,93	0,13	**0,48**	0,81	0,12	**0,44**	0,74	.E..LD
.S..GDJ	0,55	**1,25**	1,98	0,39	**0,88**	1,37	0,29	**0,65**	1,01	0,25	**0,57**	0,87	0,23	**0,52**	0,80	.S..GDJ
.S..GD	0,55	**1,25**	1,98	0,39	**0,88**	1,37	0,29	**0,65**	1,01	0,25	**0,57**	0,87	0,23	**0,52**	0,80	.S..GD
.S..HD	0,55	**1,26**	1,99	0,39	**0,89**	1,38	0,29	**0,66**	1,01	0,25	**0,57**	0,88	0,23	**0,52**	0,80	.S..HD

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

- Double-sided round inserts with 12 indexable positions.
- Anti-rotation features enable higher cutting data and extra stability.
- Pocketing and profiling capabilities.







Screw-On End Mills

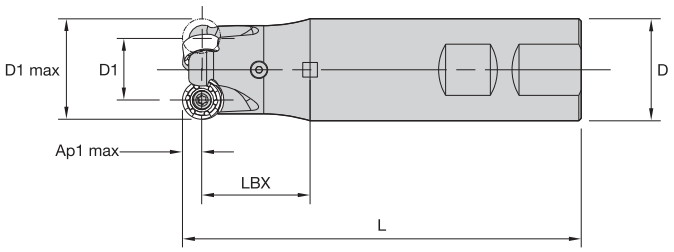
order number	catalogue number	D1 max	D1	D	DPM	WF	G3X	L2	Ap1 max	Z	max ramp angle	kg	max RPM	insert 1
4147001	**KDR32Z03M16RN12**	32	20	29	17	24	M16	40	3,0	3	.3°	0,18	39160	RN_J1204M0__
4147002	**KDR35Z03M16RN12**	35	23	29	17	24	M16	40	3,0	3	.4°	0,20	37440	RN_J1204M0__
4147033	**KDR42Z04M16RN12**	42	30	29	17	24	M16	40	3,0	4	.4°	0,23	34180	RN_J1204M0__

Spare Parts

D1 max	 insert screw	 Nm	 wrench
32	**193.492**	4,0	**170.025**
35	**193.492**	4,0	**170.025**
42	**193.492**	4,0	**170.025**

- Double-sided round inserts with 12 indexable positions.
- Anti-rotation features enable higher cutting data and extra stability.
- Pocketing, profiling, ramping, and helical interpolation capabilities.







Weldon End Mills

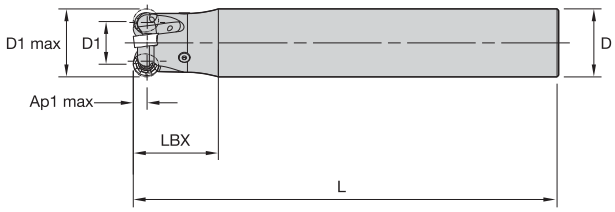
order number	catalogue number	D1 max	D1	D	L	LBX	Ap1 max	Z	max ramp angle	kg	max RPM	insert 1
4147035	**KDR32Z03B32RN12**	32	20	32	125	40	3,0	3	.3°	0,64	39160	RN_J1204M0__

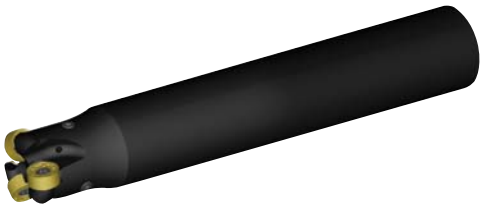
Spare Parts

D1 max	insert screw	Nm	Torx Plus driver
32	**193.492**	4,0	**170.025**

- Double-sided round insert with 12 indexable positions.
- Anti-rotation feature, enable higher cutting data and extra stability.
- Pocketing and profiling capabilities.







Cylindrical End Mills

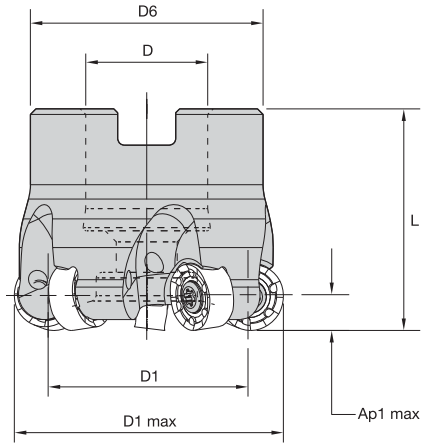
order number	catalogue number	D1 max	D1	D	L	LBX	Ap1 max	Z	max ramp angle	kg	max RPM	insert 1
4147038	**KDR32Z02A32RN12L250**	32	20	32	250	40	3,0	2	.4°	1,41	39160	RN_J1204M0__
4147037	**KDR32Z03A32RN12L200**	32	20	32	200	40	3,0	3	.3°	1,10	39160	RN_J1204M0__

Spare Parts

D1 max	insert screw	Nm	Torx Plus driver
32	**193.492**	4,0	**170.025**

- Double-sided round inserts with 12 indexable positions.
- Anti-rotation features enable higher cutting data and extra stability.
- Pocketing and profiling capabilities.







Shell Mills

order number	catalogue number	D1 max	D1	D	D6	L	Ap1 max	Z	max ramp angle	kg	max RPM	insert 1
4147039	**KDR40Z04S16RN12**	40	28	16	38	40	3,0	4	.5°	0,21	35020	RN_J1204M0__
4147040	**KDR50Z04S22RN12**	50	38	22	42	40	3,0	4	.7°	0,29	31330	RN_J1204M0__
4147041	**KDR50Z05S22RN12**	50	38	22	42	40	3,0	5	.7°	0,29	31330	RN_J1204M0__
4147042	**KDR52Z05S22RN12**	52	40	22	49	50	3,0	5	.5°	0,81	30720	RN_J1204M0__
4147043	**KDR63Z05S22RN12**	63	51	22	49	50	3,0	5	.5°	0,81	27910	RN_J1204M0__
4147044	**KDR63Z07S22RN12**	63	51	22	49	50	3,0	7	.5°	0,81	27910	RN_J1204M0__
4147045	**KDR66Z07S27RN12**	66	54	27	60	50	3,0	7	.5°	0,81	27260	RN_J1204M0__
4147046	**KDR80Z06S27RN12**	80	68	27	60	50	3,0	6	.5°	1,07	24760	RN_J1204M0__
4147047	**KDR80Z08S27RN12**	80	68	27	60	50	3,0	8	.5°	0,81	24760	RN_J1204M0__
4147048	**KDR100Z07S32RN12**	100	88	32	78	50	3,0	7	.4°	1,57	22150	RN_J1204M0__
4147049	**KDR100Z09S32RN12**	100	88	32	78	50	3,0	9	.4°	1,58	22150	RN_J1204M0__

Spare Parts








D1 max	insert screw	Nm	low-head cap screw	socket-head cap screw	coolant lock screw assembly	wrench
40	**193.492**	4,0	–	**MS1294**	–	**170.025**
50	**193.492**	4,0	**MS1336**	–	–	**170.025**
52	**193.492**	4,0	–	**MS1242**	–	**170.025**
63	**193.492**	4,0	–	**MS1242**	–	**170.025**
66	**193.492**	4,0	–	**MS2038**	–	**170.025**
80	**193.492**	4,0	–	**MS2038**	–	**170.025**
100	**193.492**	4,0	–	–	**MS2195C**	**170.025**

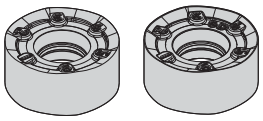
Insert Selection Guide

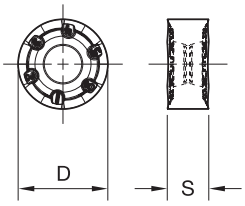
Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		←	→	toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.E..LD	KCPK30	**.S..GD**	**KCPM40**	.S..HD	KCPM40
P3–P4	.E..LD	KCPK30	**.S..GD**	**KCPK30**	.S..HD	KCPM40
P5–P6	.E..LD	KC725M	**.S..GD**	**KC725M**	.S..HD	KC725M
M1–M2	.E..LD	KC522M	**.S..GDJ**	**KCSM40**	.S..HD	KC725M
M3	.S..GD	KCPM40	**.S..GDJ**	**KCSM40**	.S..HD	KCPM40
K1–K2	.S..HD	KC520M	**.S..HD**	**KCK15**	.S..HD	KCK15
K3	.S..HD	KC520M	**.S..HD**	**KCK15**	.S..HD	KCK15
N1–N2	.F..LDJ	KC422M	**.F..LDJ**	**KC422M**	.S..GD	KC510M
N3	–	–	**–**	**–**	–	–
S1–S2	.E..LD	KC725M	**.S..GD**	**KC725M**	.S..HD	KC725M
S3	.S..GD	KCPM40	**.S..GDJ**	**KCSM40**	.S..HD	KCPM40
S4	.S..GD	KC522M	**.S..GDJ**	**KCSM40**	.S..HD	KC725M
H1	.S..GD	KC510M	**.S..GD**	**KC510M**	–	–

- -LD geometry is the first choice for stainless steel and titanium machining at lower cutting forces.
- -GD geometry is for general use in steel and stainless steel.

● first choice
○ alternate choice

	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
P			○	●		●	●		○
M			●	●		○	○	○	●
K		●	○		●	○			
N	●								
S			●	●				●	●
H									


RNGJ12-LD RNGJ12-GD



RNGJ12-LD
RNGJ12-GD

RNGJ12-LD

catalogue number	D	S	hm	cutting edges	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
RNGJ1204M0ELD	12,00	4,75	0,04	12	–	–	●	●	–	●	–	–	–
RNGJ1204M0ELDJ	12,00	4,75	0,04	12	–	–	–	–	–	–	–	●	–
RNGJ1204M0FLDJ	12,00	4,75	0,04	12	●	–	–	–	–	–	–	–	–

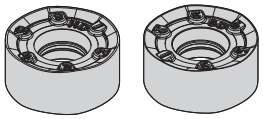
RNGJ12-GD

catalogue number	D	S	hm	cutting edges	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
RNGJ1204M0SGD	12,00	4,75	0,09	12	–	–	●	●	–	●	–	–	–
RNGJ1204M0SGDJ	12,00	4,75	0,09	12	–	–	–	–	–	–	–	–	●

- -HD geometry is the first choice for heavy machining high-strength steel and cast iron.
- -GD geometry is for general use in steel and for stainless steel.

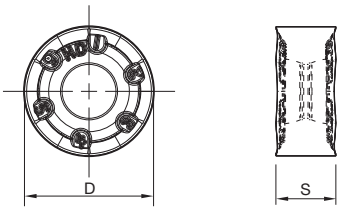
● first choice
○ alternate choice

P				○	●		●	●		○
M				●	●		○	○	○	●
K			●	○		●	○			
N		●								
S				●	●				●	●
H										



RNGJ12-HD
RNPJ12-HD

RNPJ12-GD



RNGJ12-HD
RNPJ12-GD

RNGJ12-HD

catalogue number	D	S	hm	cutting edges	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
RNGJ1204M0SHD	12,00	4,75	0,19	12	–	–	–	●	–	●	–	–	–

RNPJ12-GD

catalogue number	D	S	hm	cutting edges	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
RNPJ1204M0SGD	12,00	4,75	0,09	12	–	–	●	●	–	●	●	–	–

RNPJ12-HD

catalogue number	D	S	hm	cutting edges	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
RNPJ1204M0SHD	12,00	4,75	0,18	12	–	–	–	●	–	●	●	–	–

Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining

At 6,00 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.F..LDJ	0,12	**0,40**	0,76	0,09	**0,29**	0,54	0,07	**0,21**	0,40	0,06	**0,19**	0,35	0,05	**0,17**	0,32	.F..LDJ
.E..LDJ	0,12	**0,44**	0,80	0,09	**0,32**	0,58	0,07	**0,24**	0,43	0,06	**0,21**	0,37	0,05	**0,19**	0,34	.E..LDJ
.E..LD	0,12	**0,44**	0,80	0,09	**0,32**	0,58	0,07	**0,24**	0,43	0,06	**0,21**	0,37	0,05	**0,19**	0,34	.E..LD
.S..GDJ	0,23	**0,59**	0,90	0,17	**0,43**	0,64	0,13	**0,32**	0,48	0,11	**0,28**	0,42	0,10	**0,25**	0,38	.S..GDJ
.S..GD	0,23	**0,59**	0,90	0,17	**0,43**	0,64	0,13	**0,32**	0,48	0,11	**0,28**	0,42	0,10	**0,25**	0,38	.S..GD
.S..HD	0,23	**0,59**	0,90	0,17	**0,43**	0,64	0,13	**0,32**	0,48	0,11	**0,28**	0,42	0,10	**0,25**	0,38	.S..HD

At 2,00 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.F..LDJ	0,17	**0,53**	1,03	0,12	**0,38**	0,73	0,09	**0,29**	0,54	0,08	**0,25**	0,47	0,07	**0,23**	0,43	.F..LDJ
.E..LDJ	0,17	**0,60**	1,09	0,12	**0,43**	0,77	0,09	**0,32**	0,58	0,08	**0,28**	0,50	0,07	**0,25**	0,46	.E..LDJ
.E..LD	0,17	**0,60**	1,09	0,12	**0,43**	0,77	0,09	**0,32**	0,58	0,08	**0,28**	0,50	0,07	**0,25**	0,46	.E..LD
.S..GDJ	0,32	**0,80**	1,22	0,23	**0,57**	0,86	0,17	**0,43**	0,64	0,15	**0,37**	0,56	0,14	**0,34**	0,51	.S..GDJ
.S..GD	0,32	**0,80**	1,22	0,23	**0,57**	0,86	0,17	**0,43**	0,64	0,15	**0,37**	0,56	0,14	**0,34**	0,51	.S..GD
.S..HD	0,32	**0,80**	1,22	0,23	**0,57**	0,86	0,17	**0,43**	0,64	0,15	**0,37**	0,56	0,14	**0,34**	0,51	.S..HD

At 1,30 Axial Depth of Cut (ap)

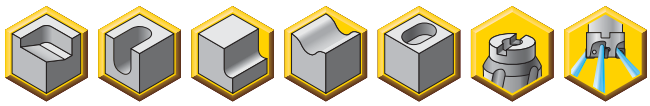
Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.F..LDJ	0,20	**0,64**	1,24	0,14	**0,46**	0,88	0,11	**0,34**	0,65	0,09	**0,30**	0,57	0,09	**0,28**	0,52	.F..LDJ
.E..LDJ	0,20	**0,72**	1,31	0,14	**0,51**	0,93	0,11	**0,38**	0,69	0,09	**0,33**	0,60	0,09	**0,31**	0,55	.E..LDJ
.E..LD	0,20	**0,72**	1,31	0,14	**0,51**	0,93	0,11	**0,38**	0,69	0,09	**0,33**	0,60	0,09	**0,31**	0,55	.E..LD
.S..GDJ	0,38	**0,97**	1,47	0,27	**0,69**	1,04	0,20	**0,51**	0,77	0,18	**0,45**	0,67	0,16	**0,41**	0,61	.S..GDJ
.S..GD	0,38	**0,97**	1,47	0,27	**0,69**	1,04	0,20	**0,51**	0,77	0,18	**0,45**	0,67	0,16	**0,41**	0,61	.S..GD
.S..HD	0,38	**0,97**	1,47	0,27	**0,69**	1,04	0,20	**0,51**	0,77	0,18	**0,45**	0,67	0,16	**0,41**	0,61	.S..HD

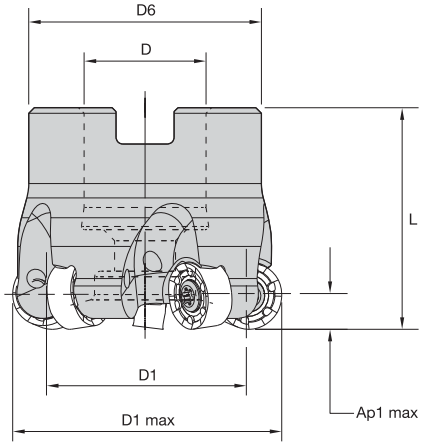
At 0,80 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.F..LDJ	0,25	**0,81**	1,56	0,18	**0,58**	1,10	0,13	**0,43**	0,81	0,12	**0,37**	0,71	0,11	**0,34**	0,65	.F..LDJ
.E..LDJ	0,25	**0,90**	1,65	0,18	**0,64**	1,17	0,13	**0,48**	0,86	0,12	**0,42**	0,75	0,11	**0,38**	0,69	.E..LDJ
.E..LD	0,25	**0,90**	1,65	0,18	**0,64**	1,17	0,13	**0,48**	0,86	0,12	**0,42**	0,75	0,11	**0,38**	0,69	.E..LD
.S..GDJ	0,47	**1,21**	1,86	0,34	**0,86**	1,30	0,26	**0,64**	0,96	0,22	**0,56**	0,84	0,20	**0,51**	0,76	.S..GDJ
.S..GD	0,47	**1,21**	1,86	0,34	**0,86**	1,30	0,26	**0,64**	0,96	0,22	**0,56**	0,84	0,20	**0,51**	0,76	.S..GD
.S..HD	0,47	**1,21**	1,86	0,34	**0,86**	1,30	0,26	**0,64**	0,96	0,22	**0,56**	0,84	0,20	**0,51**	0,76	.S..HD

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

- Double-sided round inserts with 12 indexable positions.
- Anti-rotation features enable higher cutting data and extra stability.
- Pocketing and profiling capabilities.



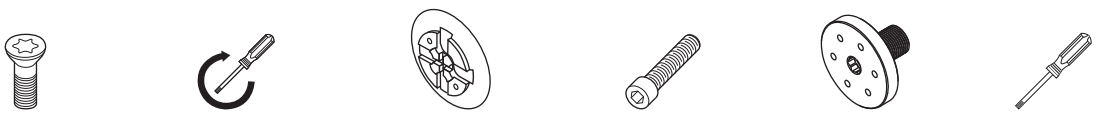




Shell Mills

order number	catalogue number	D1 max	D1	D	D6	L	Ap1 max	Z	max ramp angle	kg	max RPM	insert 1
5153837	KDR50Z04S22RN16	50	34	22	42	50	4,0	4	.5°	0,36	26700	RNGJ1605M0___
5153838	KDR52Z04S22RN16	52	36	22	42	50	4,0	4	.4°	0,39	26000	RNGJ1605M0___
5153839	KDR63Z04S22RN16	63	47	22	49	50	4,0	4	.4°	0,58	22700	RNGJ1605M0___
5153890	KDR63Z06S22RN16	63	47	22	49	50	4,0	6	.4°	0,57	22700	RNGJ1605M0___
5153891	KDR66Z05S27RN16	66	50	27	60	50	4,0	5	.4°	0,69	22000	RNGJ1605M0___
5153892	KDR80Z05S27RN16	80	64	27	60	50	4,0	5	.3°	0,88	19500	RNGJ1605M0___
5153893	KDR80Z07S27RN16	80	64	27	60	50	4,0	7	.3°	0,88	19500	RNGJ1605M0___
5153894	KDR100Z06S32RN16	100	84	32	78	50	4,0	6	.3°	1,51	17000	RNGJ1605M0___
5153895	KDR100Z08S32RN16	100	84	32	78	50	4,0	8	.3°	1,52	17000	RNGJ1605M0___
5153897	KDR125Z08S40RN16	125	109	40	90	63	4,0	8	.2°	2,88	14900	RNGJ1605M0___
5153898	KDR125Z10S40RN16	125	109	40	90	63	4,0	10	.2°	2,92	14900	RNGJ1605M0___
5338057	KDR160Z12S40RN16	160	144	40	100	63	4,0	12	.2°	4,06	13000	RNGJ1605M0___

Spare Parts



D1 max	insert screw	Nm	coolant shower plate assembly	socket-head cap screw	coolant lock screw assembly	wrench
50	192.932	4,0	–	MS1242	–	170.026
52	MS2260	4,0	–	MS1242	–	170.026
63	MS2260	4,0	–	MS1242	–	170.026
63	192.932	4,0	–	MS1242	–	170.026
66	MS2260	4,0	–	MS2038	–	170.026
80	MS2260	4,0	–	MS2038	–	170.026
100	MS2260	4,0	–	–	MS2195C	170.026
125	MS2260	4,0	–	–	MS2187C	170.026
160	MS2260	4,0	MCCM16001	–	–	170.026

NOTE: For coolant shower plates (MCC..), only use low-pressure coolant.

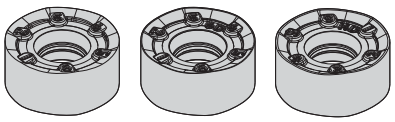
Insert Selection Guide

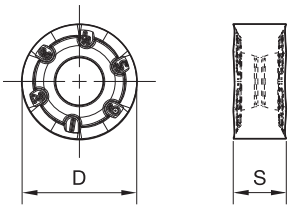
Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		←	→	toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.E..LDJ	KC725M	.S..GD	KCPM40	.S..HD	KCPM40
P3–P4	.E..LDJ	KC522M	.S..GD	KCPK30	.S..HD	KCPM40
P5–P6	.E..LDJ	KC725M	.S..GD	KC725M	.S..HD	KC725M
M1–M2	.E..LDJ	KC522M	.S..HD	KC725M	.S..GD	KCSM40
M3	.E..LDJ	KC725M	.S..GD	KCPM40	.S..HD	KCPM40
K1–K2	.S..HD	KC520M	.S..HD	KC520M	.S..HD	KCK15
K3	.S..GD	KCPK30	.S..HD	KC520M	.S..HD	KCK15
N1–N2	–	–	–	–	–	–
N3	–	–	–	–	–	–
S1–S2	.E..LDJ	KC725M	.S..GD	KCSM40	.S..HD	KC725M
S3	.E..LDJ	KC725M	.S..GD	KCSM40	.S..HD	KCPM40
S4	.E..LDJ	KC522M	.S..GD	KCSM40	.S..HD	KC725M
H1	–	–	–	–	–	–

Indexable Inserts • RN.J16..

- -LD geometry is the first choice for stainless steel and titanium machining at lower cutting forces.
- -GD geometry is for general use in steel and for stainless steel.
- -HD geometry is the first choice for heavy machining high-strength steel and cast iron.

● first choice
○ alternate choice


RNGJ16-LD RNPJ16-GD RNPJ16-HD



RNGJ16-LD

RNGJ16-LD

catalogue number	D	S	hm	cutting edges	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
RNGJ1605M0ELDJ	16,00	5,52	0,04	12	–	●	●	–	–	–	–	–

RNPJ16-GD

catalogue number	D	S	hm	cutting edges	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
RNPJ1605M0SGD	16,00	5,52	0,09	12	–	●	●	–	●	●	–	●

RNPJ16-HD

catalogue number	D	S	hm	cutting edges	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
RNPJ1605M0SHD	16,00	5,52	0,23	12	●	–	●	●	●	●	–	–

Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining

At 8,00 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.E..LDJ	0,12	**0,44**	0,80	0,09	**0,32**	0,57	0,07	**0,24**	0,43	0,06	**0,21**	0,37	0,05	**0,19**	0,34	.E..LDJ
.E..LD	0,12	**0,44**	0,80	0,09	**0,32**	0,57	0,07	**0,24**	0,43	0,06	**0,21**	0,37	0,05	**0,19**	0,34	.E..LD
.S..GD	0,23	**0,50**	0,89	0,17	**0,36**	0,64	0,13	**0,27**	0,48	0,11	**0,24**	0,42	0,10	**0,22**	0,38	.S..GD
.S..HD	0,23	**0,59**	0,95	0,17	**0,43**	0,68	0,13	**0,32**	0,51	0,11	**0,28**	0,44	0,10	**0,25**	0,41	.S..HD

At 2,50 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.E..LDJ	0,17	**0,61**	1,10	0,12	**0,44**	0,79	0,09	**0,33**	0,59	0,08	**0,29**	0,51	0,07	**0,26**	0,47	.E..LDJ
.E..LD	0,17	**0,61**	1,10	0,12	**0,44**	0,79	0,09	**0,33**	0,59	0,08	**0,29**	0,51	0,07	**0,26**	0,47	.E..LD
.S..GD	0,32	**0,70**	1,24	0,23	**0,50**	0,89	0,18	**0,38**	0,66	0,15	**0,33**	0,58	0,14	**0,30**	0,53	.S..GD
.S..HD	0,32	**0,81**	1,32	0,23	**0,59**	0,94	0,18	**0,44**	0,70	0,15	**0,38**	0,61	0,14	**0,35**	0,56	.S..HD

At 1,50 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.E..LDJ	0,21	**0,76**	1,38	0,15	**0,55**	0,99	0,12	**0,41**	0,74	0,10	**0,36**	0,64	0,09	**0,33**	0,59	.E..LDJ
.E..LD	0,21	**0,76**	1,38	0,15	**0,55**	0,99	0,12	**0,41**	0,74	0,10	**0,36**	0,64	0,09	**0,33**	0,59	.E..LD
.S..GD	0,40	**0,87**	1,55	0,29	**0,63**	1,11	0,22	**0,47**	0,82	0,19	**0,41**	0,72	0,17	**0,37**	0,66	.S..GD
.S..HD	0,40	**1,02**	1,65	0,29	**0,73**	1,18	0,22	**0,55**	0,87	0,19	**0,48**	0,76	0,17	**0,44**	0,70	.S..HD

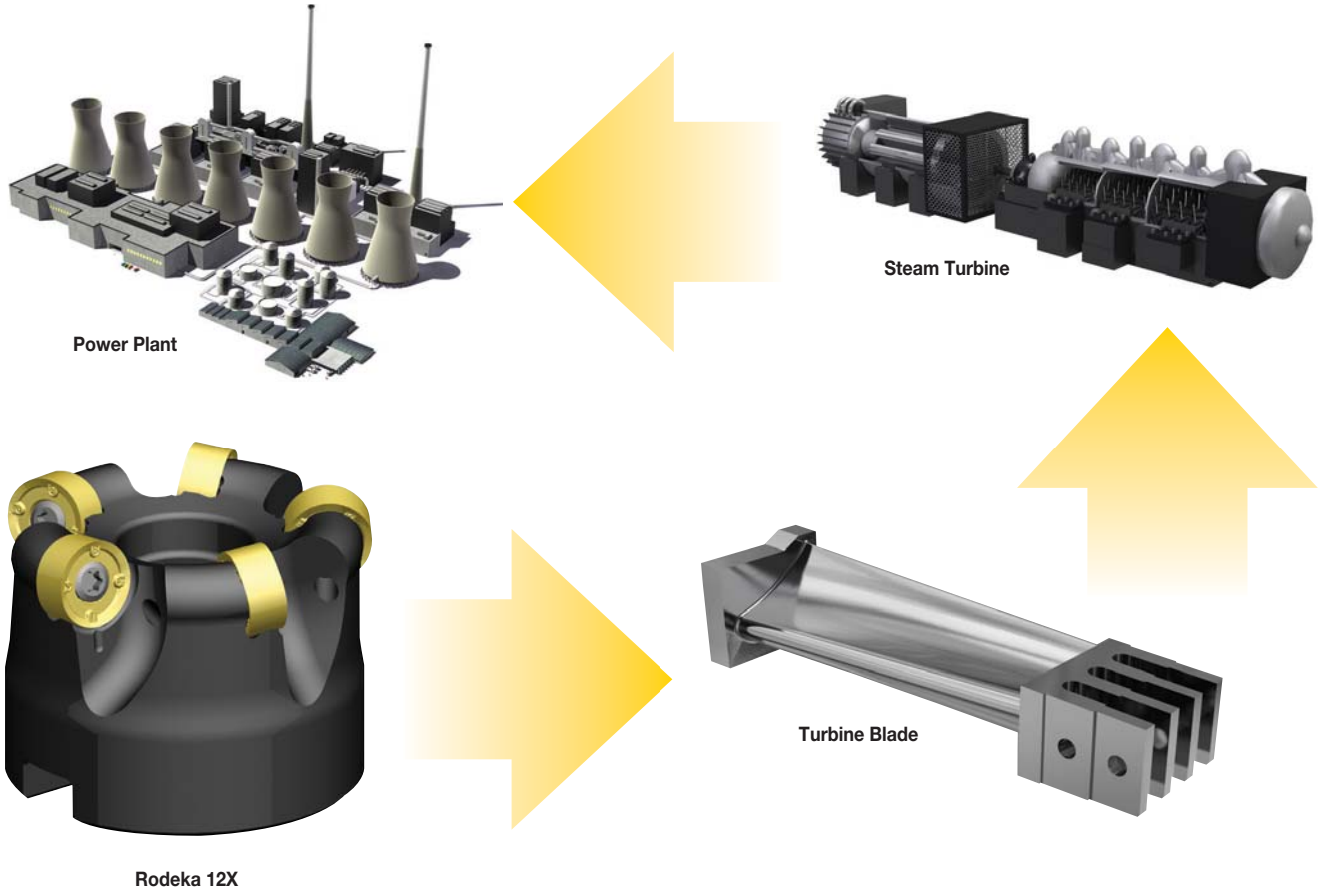
At 1,00 Axial Depth of Cut (ap)

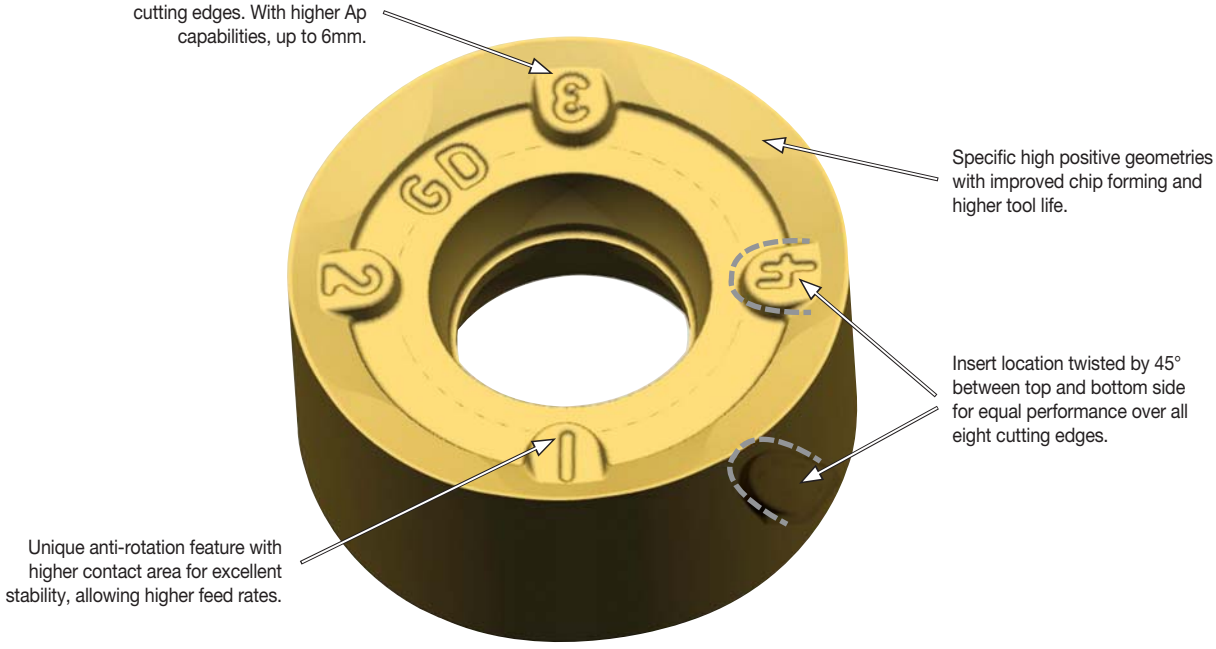
Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.E..LDJ	0,26	**0,92**	1,67	0,19	**0,66**	1,19	0,14	**0,49**	0,89	0,12	**0,43**	0,77	0,11	**0,39**	0,71	.E..LDJ
.E..LD	0,26	**0,92**	1,67	0,19	**0,66**	1,19	0,14	**0,49**	0,89	0,12	**0,43**	0,77	0,11	**0,39**	0,71	.E..LD
.S..GD	0,49	**1,05**	1,88	0,35	**0,75**	1,34	0,26	**0,56**	0,99	0,23	**0,49**	0,86	0,21	**0,45**	0,79	.S..GD
.S..HD	0,49	**1,23**	2,00	0,35	**0,88**	1,42	0,26	**0,66**	1,05	0,23	**0,57**	0,92	0,21	**0,52**	0,84	.S..HD

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

Rodeka 12X Turbine Blade Version

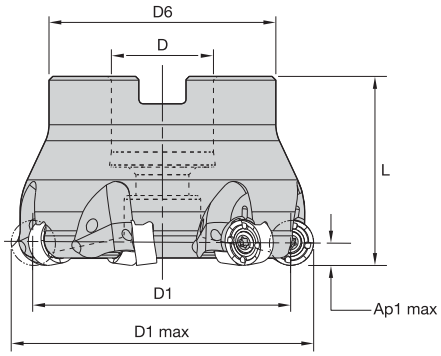
Revolutionary double-sided round insert engineered for turbine blade machining. Special geometries, insert styles, and dedicated cutter bodies have been developed to serve this demanding application.





- Double-sided round inserts with eight indexable positions.
- Anti-rotation features enable higher cutting data and extra stability.
- Engineered for turbine blade machining.







Shell Mills

order number	catalogue number	D1 max	D1	D	D6	L	Ap1 max	Z	max ramp angle	kg	max RPM	insert 1
5104420	**KDR40Z04S16RN12X**	40	28	16	38	40	6,0	4	.5°	0,23	35020	RN_J1204M0___
5104421	**KDR50Z05S22RN12X**	50	38	22	42	40	6,0	5	.7°	0,30	31330	RN_J1204M0___
5104424	**KDR63Z06S22RN12X**	63	51	22	49	40	6,0	6	.5°	0,48	27910	RN_J1204M0___
5104426	**KDR80Z07S27RN12X**	80	68	27	60	50	6,0	7	.3°	1,05	24760	RN_J1204M0___

Spare Parts







D1 max	insert screw	Nm	socket-head cap screw	socket-head cap screw with coolant groove	wrench
40	**193.492**	4,0	**MS1294**	**MS1294CG**	**170.025**
50	**193.492**	4,0	**–**	**MS1234CG**	**170.025**
63	**193.492**	4,0	**–**	**MS1234CG**	**170.025**
80	**193.492**	4,0	**MS2038**	**MS2038CG**	**170.025**

NOTE: Socket-head cap screw with coolant groove needs to be purchased separately.

Insert Selection Guide

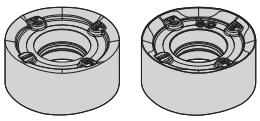
Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		←	→	toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.E..LDJX	KC522M	**.E..LDJX**	**KC725M**	.S..GDJX	KC725M
P3–P4	.E..LDJX	KC522M	**.E..LDJX**	**KC725M**	.S..GDJX	KC522M
P5–P6	.E..LDJX	KC725M	**.E..LDJX**	**KC725M**	.S..GDJX	KC725M
M1–M2	.E..LDJX	KC522M	**.E..LDJX**	**KC725M**	.S..GDJX	KC522M
M3	.E..LDJX	KC522M	**.E..LDJX**	**KC725M**	.S..GDJX	KC725M
K1–K2	–	–	**–**	**–**	–	–
K3	–	–	**–**	**–**	–	–
N1–N2	–	–	**–**	**–**	–	–
N3	–	–	**–**	**–**	–	–
S1–S2	.E..LDJX	KC522M	**.E..LDJX**	**KC725M**	.S..GDJX	KC725M
S3	.E..LDJX	KC725M	**.E..LDJX**	**KC725M**	.S..GDJX	KC725M
S4	.E..LDJX	KC522M	**.S..GDJX**	**KC522M**	.S..GDJX	KC725M
H1	–	–	**–**	**–**	–	–

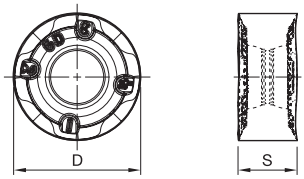
Indexable Inserts RN.J12..

- -LD geometry is for general use on blades from a solid block.
- -LD geometry is the first choice for stainless steel and titanium machining at lower cutting forces.
- -GD geometry is the first choice for forged blades.
- -GD geometry is for general use in steel and stainless steel.

● first choice
○ alternate choice

P	○	●	
M	●	●	○
K	○		
N			
S	●	●	●
H	○		


RNGJ-LDX RNGJ-GDX



RNGJ-LDX
RNGJ-GDX

RNGJ12-LDX

catalogue number	D	S	hm	cutting edges	KC522M	KC725M	KCSM30
RNGJ1204M0ENLDJX	12,00	4,75	0,03	8	●	–	–

RNGJ12-GDX

catalogue number	D	S	hm	cutting edges	KC522M	KC725M	KCSM30
RNGJ1204M0SNGDJX	12,00	4,75	0,09	8	–	●	–

Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining

At 6,00 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.E..LDJX	0,12	**0,49**	0,84	0,08	**0,35**	0,60	0,06	**0,26**	0,45	0,06	**0,23**	0,39	0,05	**0,21**	0,36	.E..LDJX
.S..GDJX	0,23	**0,59**	0,89	0,17	**0,43**	0,64	0,13	**0,32**	0,48	0,11	**0,28**	0,42	0,10	**0,25**	0,38	.S..GDJX

At 2,00 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.E..LDJX	0,16	**0,65**	1,13	0,11	**0,47**	0,81	0,09	**0,35**	0,61	0,07	**0,31**	0,53	0,07	**0,28**	0,48	.E..LDJX
.S..GDJX	0,31	**0,79**	1,20	0,23	**0,57**	0,86	0,17	**0,43**	0,64	0,15	**0,37**	0,56	0,14	**0,34**	0,51	.S..GDJX

At 1,30 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.E..LDJX	0,19	**0,79**	1,36	0,14	**0,57**	0,98	0,10	**0,42**	0,73	0,09	**0,37**	0,63	0,08	**0,34**	0,58	.E..LDJX
.S..GDJX	0,38	**0,95**	1,44	0,27	**0,69**	1,03	0,20	**0,51**	0,77	0,18	**0,45**	0,67	0,16	**0,41**	0,61	.S..GDJX

At 0,80 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.E..LDJX	0,23	**0,98**	1,71	0,17	**0,71**	1,22	0,13	**0,53**	0,91	0,11	**0,46**	0,79	0,10	**0,42**	0,72	.E..LDJX
.S..GDJX	0,47	**1,19**	1,81	0,34	**0,86**	1,29	0,25	**0,64**	0,96	0,22	**0,56**	0,83	0,20	**0,51**	0,76	.S..GDJX

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

Mobile App

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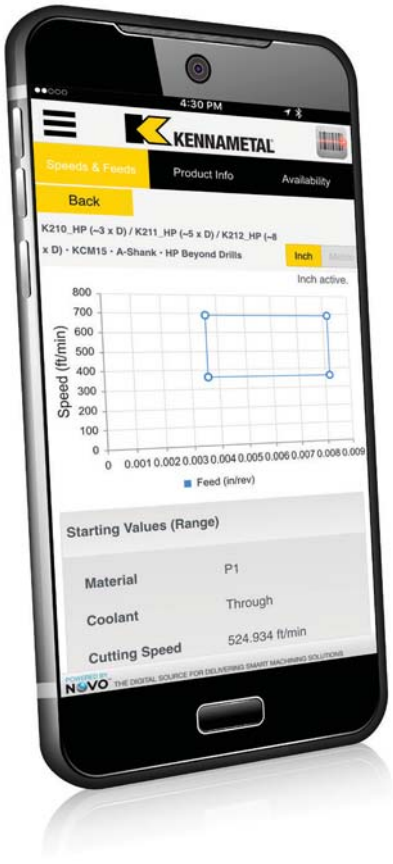

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KSRM™ Series

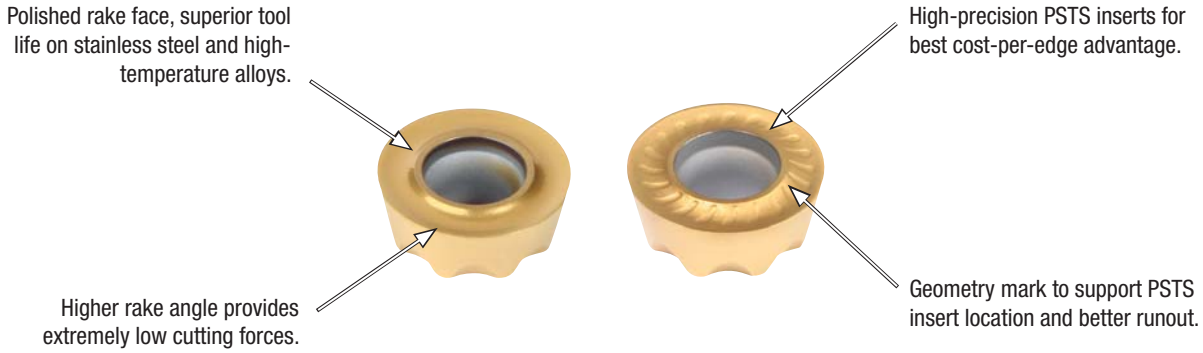
Multipurpose Milling Cutters • 12mm, 16mm, and 20mm ICs

Primary Application

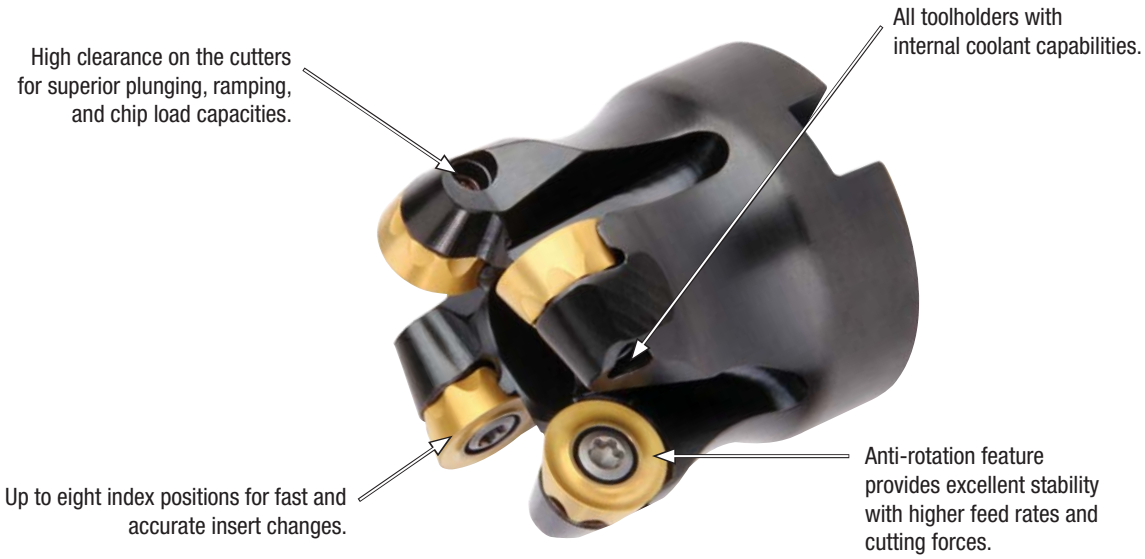
Specially developed for machining titanium and stainless steel. KSRM platform enables you to pocket, profile, ramp, and plunge with consistent performance and outstanding metal removal rates with the lowest cutting forces.

Features and Benefits

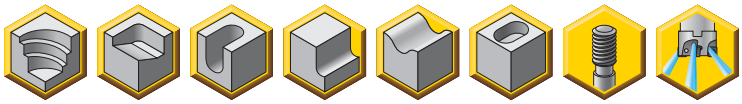
- Up to eight cutting edges per insert.
- Anti-rotation feature achieves excellent stability.
- Engineered to provide longer tool life in titanium and stainless steel.
- Roughing and semi-finishing operations with lower cutting forces.

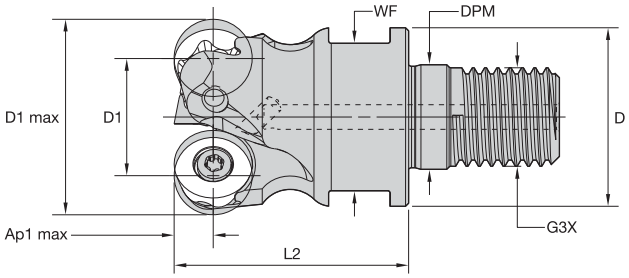





High clearance on the cutters for superior plunging, ramping, and chip load capacities.
All toolholders with internal coolant capabilities.
Up to eight index positions for fast and accurate insert changes.
Anti-rotation feature provides excellent stability with higher feed rates and cutting forces.

- Engineered for titanium and stainless steel machining.
- Anti-rotation components feature eight indexable positions.
- Pocketing, ramping, plunging, and helical interpolation capabilities.







Screw-On End Mills

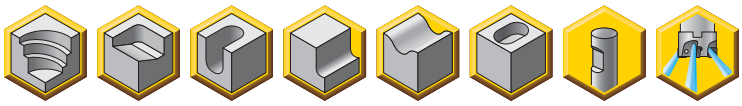
order number	catalogue number	D1 max	D1	D	DPM	G3X	L2	Ap1 max	Z	max ramp angle	max RPM	kg	insert 1
4043046	**32E03R045M16RP12**	32	20	29	17,0	M16	45	6,0	3	6.0°	43400	0,18	RP.T1204M0..
4043047	**40E04R045M16RP12**	40	28	29	17,0	M16	45	6,0	4	9.0°	38800	0,21	RP.T1204M0..

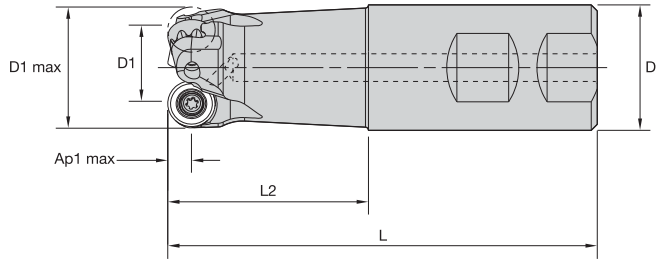
Spare Parts





D1 max	insert screw	Nm	Torx Plus driver
32	**MS2077**	2,3	**DT15IP**
40	**MS2077**	2,3	**DT15IP**







Weldon End Mills

order number	catalogue number	D1 max	D1	D	L	L2	Ap1 max	Z	max ramp angle	kg	max RPM	insert 1
4043048	**32A03R040B32RP12**	32	20	32	101	40	6,0	3	6.0°	0,51	43400	RP.T1204M0..

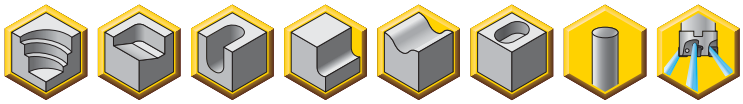
Spare Parts

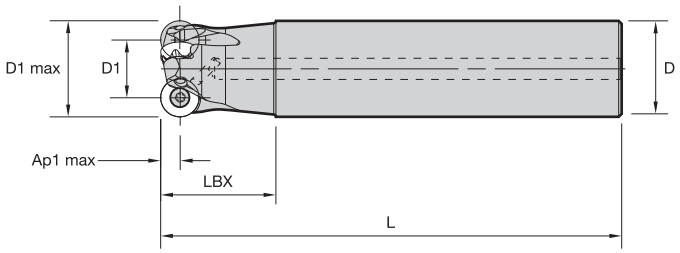




D1 max	insert screw	Nm	Torx Plus driver
32	**MS2077**	2,3	**DT15IP**

- Engineered for titanium and stainless steel machining.
- Anti-rotation components feature eight indexable positions.
- Pocketing, ramping, plunging, and helical interpolation capabilities.







Cylindrical End Mills

order number	catalogue number	D1 max	D1	D	L	LBX	Ap1 max	Z	max ramp angle	kg	max RPM	insert 1
4043049	32A03R040A32RP12L190	32	20	32	190	40	6,0	3	6.0°	1,05	43400	RP_T1204M0__
4177052	35E04R050A32RP12L200	35	23	32	200	50	6,0	4	7.0°	1,11	41400	RP_T1204M0__

Spare Parts

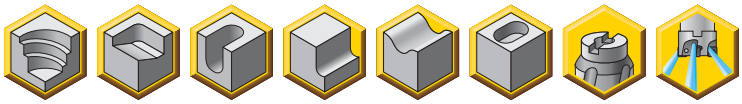


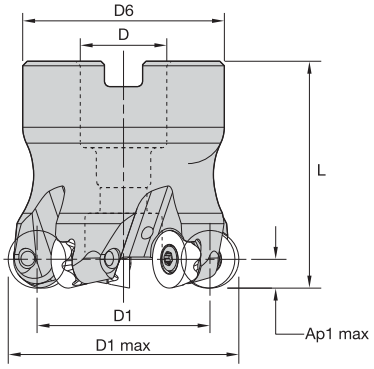




D1 max	insert screw	Nm	Torx Plus driver
32	MS2077	2,3	DT15IP
35	MS2077	2,3	DT15IP

- Engineered for titanium and stainless steel machining.
- Anti-rotation components feature eight indexable positions.
- Pocketing, ramping, plunging, and helical interpolation capabilities.







Shell Mills

order number	catalogue number	D1 max	D1	D	D6	L	Ap1 max	Z	max ramp angle	kg	max RPM	insert 1
4043050	40A04RS90RP12	40	28	16	38	40	6,0	4	9.0°	0,21	38800	RP.T1204M0..
4177163	42A04RS90RP12	42	30	16	38	40	6,0	4	10.0°	0,22	37800	RP.T1204M0..
4043051	50A04RS90RP12	50	38	22	42	40	6,0	4	10.8°	0,26	34700	RP.T1204M0..
4043052	50A05RS90RP12	50	38	22	42	40	6,0	5	7.9°	0,26	34700	RP.T1204M0..
3891914	52A05RS90RP12	52	40	22	49	50	6,0	5	10.2°	0,50	34000	RP.T1204M0..
4043063	63A05RS90RP12	63	51	22	49	50	6,0	5	7.7°	0,56	30900	RP.T1204M0..
4025498	63A07RS90RP12	63	51	22	49	50	6,0	7	2.6°	0,56	30900	RP.T1204M0..
4005063	66A06RS90RP12	66	54	27	60	50	6,0	6	6.6°	0,74	30200	RP.T1204M0..
4043064	80A06RS90RP12	80	68	27	60	50	6,0	6	5.1°	0,95	27300	RP.T1204M0..
4024763	80A08RS90RP12	80	68	27	60	50	6,0	8	4.1°	0,96	27300	RP.T1204M0..
4043065	100B07RS90RP12	100	88	32	78	50	6,0	7	4.0°	1,39	24000	RP.T1204M0..
4027389	100B09RS90RP12	100	88	32	78	50	6,0	9	3.1°	1,39	24000	RP.T1204M0..

Spare Parts



D1 max	insert screw	Nm	low-head cap screw	socket-head cap screw	socket-head cap screw with coolant groove	coolant nozzle screw	coolant lock screw assembly	T-handle hex wrench	Torx Plus driver
40	MS2077	2,3	–	MS1294	MS1294CG	–	–	–	DT15IP
42	MS2077	2,3	–	MS1294	MS1294CG	–	–	–	DT15IP
50	MS2077	2,3	MS1336	–	MS2072CG	–	–	–	DT15IP
52	MS2077	2,3	–	MS1242	MS1242CG	–	–	–	DT15IP
63	MS2077	2,3	–	MS1242	MS1242CG	–	–	–	DT15IP
66	MS2077	2,3	–	MS2038	MS2038CG	–	–	–	DT15IP
80	MS2077	2,3	–	MS2038	MS2038CG	–	–	–	DT15IP
100	MS2077	2,3	–	–	–	MS2191C00	MS2195C	THW2M	DT15IP

NOTE: Socket-head cap screw with coolant groove sold separately as a spare part.

Insert Selection Guide

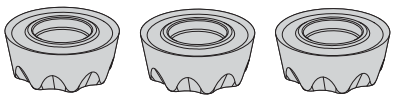
Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		←	→	toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.S..GE	KCPK30	**.S..GDX**	**KCPM40**	.S..GP	KCPM40
P3–P4	.S..GE	KCPK30	**.S..GDX**	**KCPM40**	.S..GP	KCPM40
P5–P6	.S..GEJ	KC725M	**.S..GDX**	**KC725M**	.S..GP	KC725M
M1–M2	.E..LEJ	KC725M	**.S..GDX**	**KC725M**	.S..GP	KC725M
M3	.S..GE	KCPK30	**.S..GDX**	**KCPM40**	.S..GP	KCPM40
K1–K2	–	–	**–**	**–**	–	–
K3	.E..LE	KCPK30	**.S..GE**	**KCPK30**	.S..GP	KCPK30
N1–N2	.E..LEJ	KC422M	**.E..LEJ**	**KC422M**	.E..LEJ	KC422M
N3	–	–	**–**	**–**	–	–
S1–S2	.S..GEJ	KC725M	**.S..GDX**	**KC725M**	.S..GP	KC725M
S3	.S..GEJ	KC725M	**.S..GDX**	**KCPM40**	.S..GP	KCPM40
S4	.S..GEJ	KC522M	**.S..GDX**	**KC725M**	.S..GP	KC725M
H1	–	–	**–**	**–**	–	–

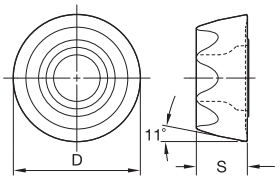
Indexable Inserts

- -SGEJ and -ELEJ are the first choice for titanium machining.
- -ELEJ is the first choice for lower cutting forces to avoid built-up edges.
- -SGEJ geometry for general purpose in roughing operations.

● first choice
○ alternate choice

		KC422M	KC522M	KC725M	KCPK30	KCPM40	KCSM30	KCSM40
P			○	●	●	●		○
M			●	●	○	●	○	●
K			○		○			
N		●						
S			●	●		○	●	●
H								


RPET-LEJ RPET-GEJ RPET-LE



RPET-LEJ

RPET-LEJ

catalogue number	D	S	hm	cutting edges
RPET1204M0ELEJ	12,00	4,76	0,05	8

RPET-GEJ

catalogue number	D	S	hm	cutting edges
RPET1204M0SGEJ	12,00	4,76	0,11	8

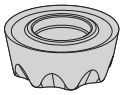
RPET-LE

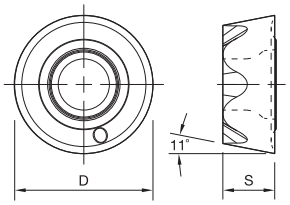
catalogue number	D	S	hm	cutting edges
RPET1204M0ELE	12,00	4,76	0,05	8

- -SGEJ and -ELEJ are the first choice for titanium machining.
- -ELEJ is the first choice for lower cutting forces to avoid built-up edges.
- -SGEJ geometry for general purpose in roughing operations.

● first choice
○ alternate choice

		KC422M	KC522M	KC725M	KCPK30	KCPM40	KCSM30	KCSM40
P			○	●	●	●		○
M			●	●	○	●	○	●
K			○		○			
N		●						
S			●	●		○	●	●
H								


RPET-GE



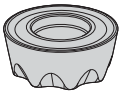
RPET-GE

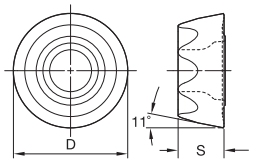
RPET-GE

catalogue number	D	S	hm	cutting edges	KC422M	KC522M	KC725M	KCPK30	KCPM40	KCSM30	KCSM40
RPET1204M0SGE	12,00	4,76	0,11	8	–	–	–	●	–	–	–

- -GP geometry for roughing operations, especially in steel.
- -SGDX is the first choice for martensitic stainless steel and turbine blade applications.


RPPT-GDX


RPPT-GP



RPPT-GDX
RPPT-GP

RPPT-GDX

catalogue number	D	S	hm	cutting edges	KC422M	KC522M	KC725M	KCPK30	KCPM40	KCSM30	KCSM40
RPPT1204M0SGDX	12,00	4,76	0,18	8	–	–	●	–	●	–	–

RPPT-GP

catalogue number	D	S	hm	cutting edges	KC422M	KC522M	KC725M	KCPK30	KCPM40	KCSM30	KCSM40
RPPT1204M0SGP	12,00	4,76	0,13	8	–	–	●	●	●	–	–

Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining

At 6,00 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			30%			20%			30%			40–100%			
.E..LEJ	0,17	**0,47**	0,75	0,12	**0,34**	0,54	0,09	**0,26**	0,40	0,08	**0,22**	0,35	0,07	**0,20**	0,32	.E..LEJ
.E..LE	0,17	**0,47**	0,75	0,12	**0,34**	0,54	0,09	**0,26**	0,40	0,08	**0,22**	0,35	0,07	**0,20**	0,32	.E..LE
.S..GEJ	0,23	**0,53**	0,82	0,17	**0,38**	0,59	0,13	**0,29**	0,44	0,11	**0,25**	0,39	0,10	**0,23**	0,35	.S..GEJ
.S..GE	0,23	**0,53**	0,82	0,17	**0,38**	0,59	0,13	**0,29**	0,44	0,11	**0,25**	0,39	0,10	**0,23**	0,35	.S..GE
.S..GDX	0,23	**0,59**	0,89	0,17	**0,43**	0,64	0,13	**0,32**	0,48	0,11	**0,28**	0,42	0,10	**0,25**	0,38	.S..GDX
.S..GP	0,23	**0,59**	0,89	0,17	**0,43**	0,64	0,13	**0,32**	0,48	0,11	**0,28**	0,42	0,10	**0,25**	0,38	.S..GP

At 2,00 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			30%			20%			30%			40–100%			
.E..LEJ	0,22	**0,64**	1,01	0,16	**0,46**	0,72	0,12	**0,34**	0,54	0,11	**0,30**	0,47	0,10	**0,27**	0,43	.E..LEJ
.E..LE	0,22	**0,64**	1,01	0,16	**0,46**	0,72	0,12	**0,34**	0,54	0,11	**0,30**	0,47	0,10	**0,27**	0,43	.E..LE
.S..GEJ	0,31	**0,71**	1,11	0,23	**0,51**	0,80	0,17	**0,38**	0,59	0,15	**0,33**	0,52	0,14	**0,31**	0,47	.S..GEJ
.S..GE	0,31	**0,71**	1,11	0,23	**0,51**	0,80	0,17	**0,38**	0,59	0,15	**0,33**	0,52	0,14	**0,31**	0,47	.S..GE
.S..GDX	0,31	**0,79**	1,20	0,23	**0,57**	0,86	0,17	**0,43**	0,64	0,15	**0,37**	0,56	0,14	**0,34**	0,51	.S..GDX
.S..GP	0,31	**0,79**	1,20	0,23	**0,57**	0,86	0,17	**0,43**	0,64	0,15	**0,37**	0,56	0,14	**0,34**	0,51	.S..GP

At 1,30 Axial Depth of Cut (ap)

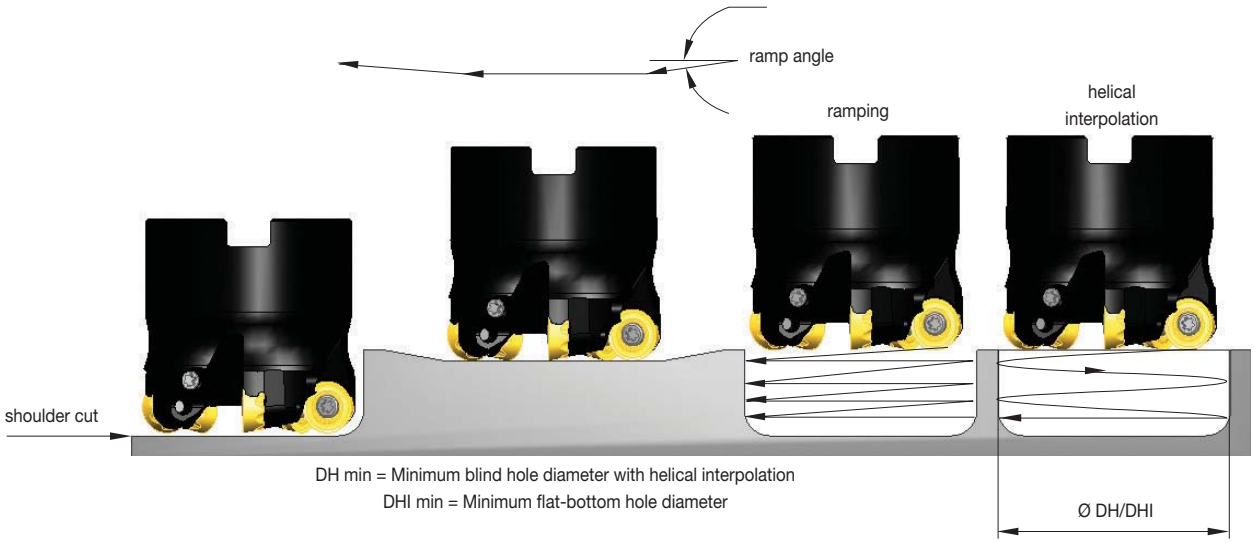
Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			30%			20%			30%			40–100%			
.E..LEJ	0,27	**0,76**	1,21	0,19	**0,55**	0,87	0,15	**0,41**	0,65	0,13	**0,36**	0,56	0,12	**0,33**	0,52	.E..LEJ
.E..LE	0,27	**0,76**	1,21	0,19	**0,55**	0,87	0,15	**0,41**	0,65	0,13	**0,36**	0,56	0,12	**0,33**	0,52	.E..LE
.S..GEJ	0,38	**0,85**	1,34	0,27	**0,62**	0,96	0,20	**0,46**	0,71	0,18	**0,40**	0,62	0,16	**0,37**	0,57	.S..GEJ
.S..GE	0,38	**0,85**	1,34	0,27	**0,62**	0,96	0,20	**0,46**	0,71	0,18	**0,40**	0,62	0,16	**0,37**	0,57	.S..GE
.S..GDX	0,38	**0,95**	1,44	0,27	**0,69**	1,03	0,20	**0,51**	0,77	0,18	**0,45**	0,67	0,16	**0,41**	0,61	.S..GDX
.S..GP	0,38	**0,95**	1,44	0,27	**0,69**	1,03	0,20	**0,51**	0,77	0,18	**0,45**	0,67	0,16	**0,41**	0,61	.S..GP

At 0,80 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			30%			20%			30%			40–100%			
.E..LEJ	0,33	**0,95**	1,52	0,24	**0,69**	1,09	0,18	**0,51**	0,81	0,16	**0,45**	0,70	0,14	**0,41**	0,64	.E..LEJ
.E..LE	0,33	**0,95**	1,52	0,24	**0,69**	1,09	0,18	**0,51**	0,81	0,16	**0,45**	0,70	0,14	**0,41**	0,64	.E..LE
.S..GEJ	0,47	**1,07**	1,68	0,34	**0,77**	1,20	0,25	**0,57**	0,89	0,22	**0,50**	0,77	0,20	**0,46**	0,71	.S..GEJ
.S..GE	0,47	**1,07**	1,68	0,34	**0,77**	1,20	0,25	**0,57**	0,89	0,22	**0,50**	0,77	0,20	**0,46**	0,71	.S..GE
.S..GDX	0,47	**1,19**	1,81	0,34	**0,86**	1,29	0,25	**0,64**	0,96	0,22	**0,56**	0,83	0,20	**0,51**	0,76	.S..GDX
.S..GP	0,47	**1,19**	1,81	0,34	**0,86**	1,29	0,25	**0,64**	0,96	0,22	**0,56**	0,83	0,20	**0,51**	0,76	.S..GP

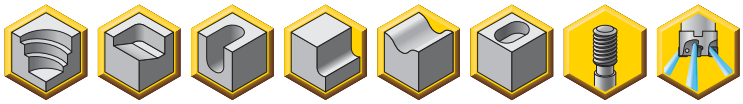
NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

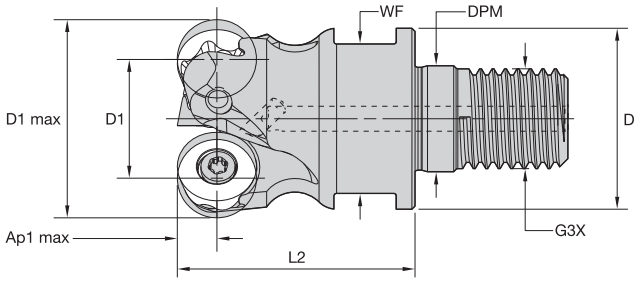
Maximum Linear Ramping and Helical Interpolation from Solid



catalogue number	max ramp angle	max plunging depth	min hole diameter (DH min)	min flat-bottomed hole diameter (DHI min)	max hole diameter (flat bottom)
32E03R045M16RP12	6.0°	1,65	43,95	52	64
40E04R045M16RP12	9.0°	3,50	57,24	68	80
32A03R040B32RP12	6.0°	1,65	43,95	52	64
32A03R040A32RP12L190	6.0°	1,65	43,95	52	64
40A04RS90RP12	9.0°	3,50	57,24	68	80
42A04RS90RP12	9.6°	4,20	60,68	72	84
50A04RS90RP12	10.8°	6,00	76,04	88	100
50A05RS90RP12	7.9°	4,40	76,50	88	100
52A05RS90RP12	10.2°	6,00	80,05	92	104
63A05RS90RP12	7.7°	6,00	102,02	114	126
63A07RS90RP12	2.6°	2,10	105,08	114	126
66A06RS90RP12	6.6°	5,50	108,14	120	132
80A06RS90RP12	5.1°	5,50	136,04	148	160
80A08RS90RP12	4.1°	4,40	136,58	148	160
100B07RS90RP12	4.0°	5,70	176,04	188	200
100B09RS90RP12	3.1°	4,40	176,55	188	200

- Engineered for titanium and stainless steel machining.
- Anti-rotation components feature eight indexable positions.
- Pocketing, ramping, plunging, and helical interpolation capabilities.







Screw-On End Mills

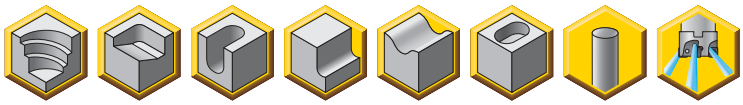
order number	catalogue number	D1 max	D1	D	DPM	G3X	L2	WF	Ap1 max	Z	max ramp angle	kg	max RPM	insert 1
4042581	40E03R045M16RP16	40	24	29	17,0	M16	45	22	8,0	3	8.4°	0,19	27300	RP..T1605M0..

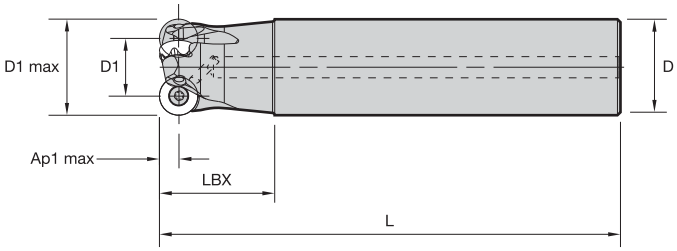
Spare Parts





D1 max	insert screw	Nm	Torx Plus driver
40	MS-2071	4,0	DT15IP







Cylindrical End Mills

order number	catalogue number	D1 max	D1	D	L	LBX	Ap1 max	Z	max ramp angle	kg	max RPM	insert 1
4042582	40E02R040A32RP16L200	40	24	32	200	40	8,0	2	11.1°	1,13	27300	RP..T1605M0..

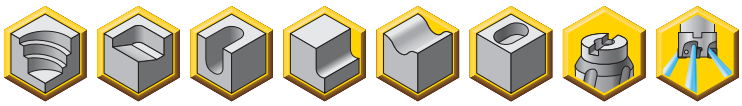
Spare Parts

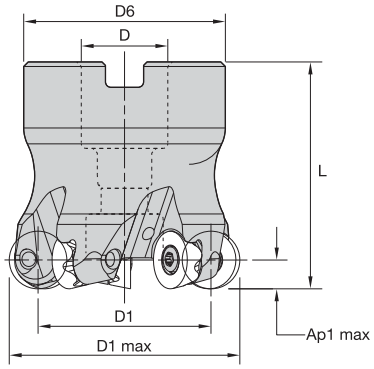




D1 max	insert screw	Nm	Torx Plus driver
40	MS-2071	4,0	DT15IP

- Engineered for titanium and stainless steel machining.
- Anti-rotation components feature eight indexable positions.
- Pocketing, ramping, plunging, and helical interpolation capabilities.



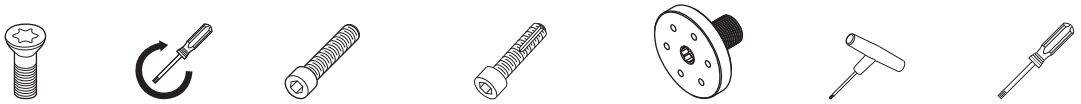




Shell Mills

order number	catalogue number	D1 max	D1	D	D6	L	Ap1 max	Z	max ramp angle	kg	max RPM	insert 1
4164868	50A04RS90RP16	50	34	22	42	50	8,0	4	9.3°	0,33	24400	RP..T1605M0..
4042693	52A04RS90RP16	52	36	22	49	50	8,0	4	10.7°	0,42	23900	RP..T1605M0..
4042694	63A04RS90RP16	63	47	22	49	50	8,0	4	11.8°	0,50	21700	RP..T1605M0..
4042695	63A06RS90RP16	63	47	22	49	50	8,0	6	4.3°	0,51	21700	RP..T1605M0..
4042696	80A05RS90RP16	80	64	27	60	50	8,0	5	8.2°	0,87	19200	RP..T1605M0..
4042697	80A07RS90RP16	80	64	27	60	50	8,0	7	4.5°	0,90	19200	RP..T1605M0..
4042698	100B06RS90RP16	100	84	32	78	50	8,0	6	6.1°	1,29	16700	RP..T1605M0..
4042699	100B08RS90RP16	100	84	32	78	50	8,0	8	4.7°	1,29	16700	RP..T1605M0..
4042700	125B09RS90RP16	125	109	40	90	63	8,0	9	4.3°	2,48	14700	RP..T1605M0..

Spare Parts



D1 max	insert screw	Nm	socket-head cap screw	socket-head cap screw with coolant groove	coolant lock screw assembly	T-handle hex wrench	Torx Plus driver
50	MS-2071	4,0	MS1242	MS1242CG	–	–	DT15IP
52	MS-2071	4,0	MS1242	MS1242CG	–	–	DT15IP
63	MS-2071	4,0	MS1242	MS1242CG	–	–	DT15IP
80	MS-2071	4,0	MS2038	MS2038CG	–	–	DT15IP
100	MS-2071	4,0	–	–	MS2195C	THW2M	DT15IP
125	MS-2071	4,0	–	–	MS2187C	THW2M	DT15IP

NOTE: Socket-head cap screw with coolant groove sold separately as a spare part.

Insert Selection Guide

Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		←	→	toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.E..LE	KCPK30	**.S..GE**	**KCPK30**	.S..HP	KCPM40
P3–P4	.E..LE	KCPK30	**.S..GE**	**KCPK30**	.S..HP	KCPM40
P5–P6	.E..LEJ	KC725M	**.S..GEJ**	**KC725M**	.S..HP	KC725M
M1–M2	.E..LEJ	KC522M	**.S..GEJ**	**KC522M**	.S..HP	KC725M
M3	.E..LEJ	KC725M	**.S..GEJ**	**KC725M**	.S..HP	KCPM40
K1–K2	–	–	**–**	**–**	–	–
K3	.E..LE	KCPK30	**.S..GE**	**KCPK30**	.S..HP	KCPK30
N1–N2	.E..LEJ	KC422M	**.E..LEJ**	**KC422M**	.E..LEJ	KC422M
N3	–	–	**–**	**–**	–	–
S1–S2	.E..LEJ	KC725M	**.S..GEJ**	**KC725M**	.S..HP	KC725M
S3	.E..LEJ	KC725M	**.S..GEJ**	**KC725M**	.S..HP	KCPM40
S4	.E..LEJ	KC522M	**.S..GEJ**	**KC522M**	.S..HP	KC725M
H1	–	–	**–**	**–**	–	–

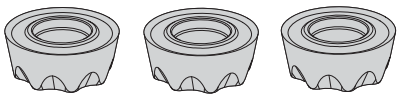
Indexable Inserts

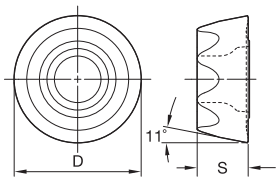
- -SGEJ and -ELEJ are the first choice for titanium machining.
- -ELEJ is the first choice for lower cutting forces to avoid built-up edge.
- -SGEJ geometry for general purpose in roughing operations.

● first choice
○ alternate choice

beyond

P			○	●	●	●		○
M			●	●	○	●	○	●
K			○		○			
N		●						
S			●	●		○	●	●
H								


RPET-LEJ RPET-GEJ RPET-GE RPET-LE



RPET-GEJ

RPET-LEJ

catalogue number	D	S	hm	cutting edges	KC422M	KC522M	KC725M	KCPK30	KCPM40	KCSM30	KCSM40
RPET1605M0ELEJ	16,00	5,56	0,03	8	–	–	●	–	–	–	–

RPET-LE

catalogue number	D	S	hm	cutting edges	KC422M	KC522M	KC725M	KCPK30	KCPM40	KCSM30	KCSM40
RPET1605M0ELE	16,00	5,56	0,03	8	–	–	–	●	–	–	–

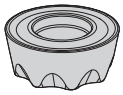
RPET-GEJ

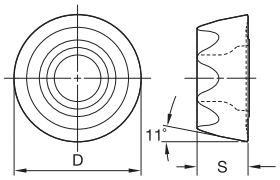
catalogue number	D	S	hm	cutting edges	KC422M	KC522M	KC725M	KCPK30	KCPM40	KCSM30	KCSM40
RPET1605M0SGEJ	16,00	5,56	0,11	8	–	●	●	–	–	●	–

RPET-GE

catalogue number	D	S	hm	cutting edges	KC422M	KC522M	KC725M	KCPK30	KCPM40	KCSM30	KCSM40
RPET1605M0SGE	16,00	5,56	0,11	8	–	–	–	●	–	–	–

- -HP geometry for roughing operations, especially in steel.


RPPT-HP



RPPT-HP

● first choice
○ alternate choice

beyond

		KC422M	KC522M	KC725M	KCPK30	KCPM40	KCSM30	KCSM40
P			○	●	●	●		○
M			●	●	○	●	○	●
K			○		○			
N		●						
S			●	●		○	●	●
H								

RPPT-HP

catalogue number	D	S	hm	cutting edges	KC422M	KC522M	KC725M	KCPK30	KCPM40	KCSM30	KCSM40
RPPT1605M0SHP	16,00	5,56	0,18	8	–	–	●	●	●	–	–

Recommended Starting Feeds

Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining

At 8,00 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.E..LEJ	0,12	**0,49**	0,81	0,08	**0,35**	0,58	0,06	**0,26**	0,43	0,06	**0,23**	0,38	0,05	**0,21**	0,35	.E..LEJ
.E..LE	0,12	**0,49**	0,81	0,08	**0,35**	0,58	0,06	**0,26**	0,43	0,06	**0,23**	0,38	0,05	**0,21**	0,35	.E..LE
.S..GEJ	0,23	**0,53**	0,88	0,17	**0,38**	0,63	0,13	**0,29**	0,47	0,11	**0,25**	0,41	0,10	**0,23**	0,38	.S..GEJ
.S..GE	0,23	**0,53**	0,88	0,17	**0,38**	0,63	0,13	**0,29**	0,47	0,11	**0,25**	0,41	0,10	**0,23**	0,38	.S..GE
.S..HP	0,23	**0,59**	0,95	0,17	**0,43**	0,68	0,13	**0,32**	0,51	0,11	**0,28**	0,44	0,10	**0,25**	0,41	.S..HP

At 2,50 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.E..LEJ	0,16	**0,67**	1,12	0,12	**0,49**	0,80	0,09	**0,36**	0,60	0,08	**0,32**	0,52	0,07	**0,29**	0,48	.E..LEJ
.E..LE	0,16	**0,67**	1,12	0,12	**0,49**	0,80	0,09	**0,36**	0,60	0,08	**0,32**	0,52	0,07	**0,29**	0,48	.E..LE
.S..GEJ	0,32	**0,73**	1,23	0,23	**0,53**	0,87	0,18	**0,39**	0,65	0,15	**0,34**	0,57	0,14	**0,31**	0,52	.S..GEJ
.S..GE	0,32	**0,73**	1,23	0,23	**0,53**	0,87	0,18	**0,39**	0,65	0,15	**0,34**	0,57	0,14	**0,31**	0,52	.S..GE
.S..HP	0,32	**0,82**	1,33	0,23	**0,59**	0,95	0,18	**0,44**	0,70	0,15	**0,38**	0,61	0,14	**0,35**	0,56	.S..HP

At 1,50 Axial Depth of Cut (ap)

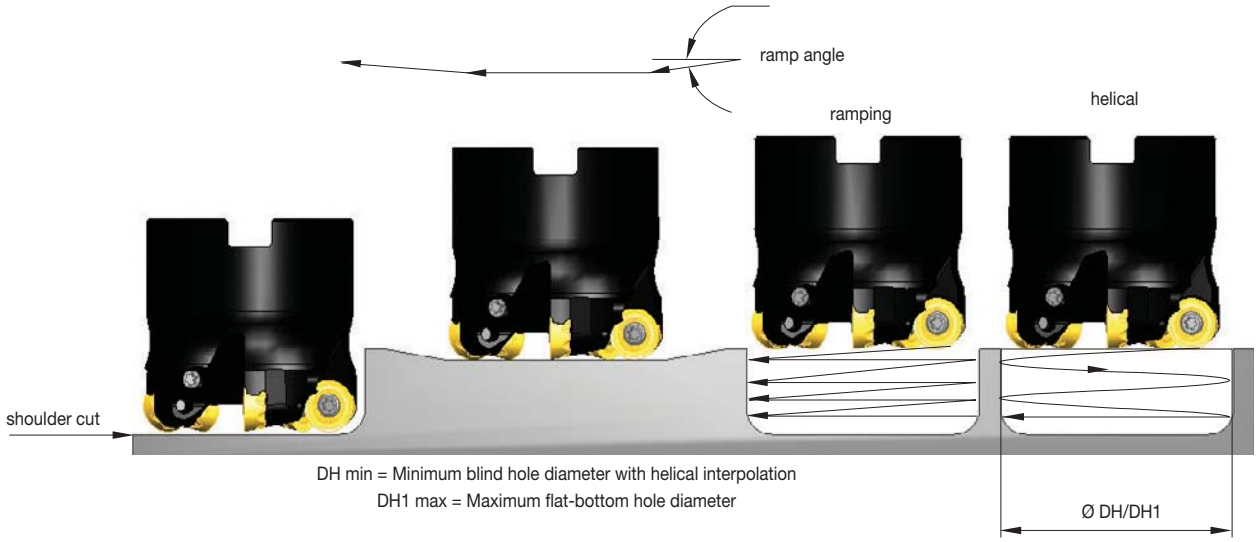
Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.E..LEJ	0,20	**0,84**	1,41	0,15	**0,61**	1,00	0,11	**0,45**	0,74	0,10	**0,39**	0,65	0,09	**0,36**	0,59	.E..LEJ
.E..LE	0,20	**0,84**	1,41	0,15	**0,61**	1,00	0,11	**0,45**	0,74	0,10	**0,39**	0,65	0,09	**0,36**	0,59	.E..LE
.S..GEJ	0,40	**0,92**	1,54	0,29	**0,66**	1,09	0,22	**0,49**	0,81	0,19	**0,43**	0,71	0,17	**0,39**	0,65	.S..GEJ
.S..GE	0,40	**0,92**	1,54	0,29	**0,66**	1,09	0,22	**0,49**	0,81	0,19	**0,43**	0,71	0,17	**0,39**	0,65	.S..GE
.S..HP	0,40	**1,03**	1,67	0,29	**0,73**	1,18	0,22	**0,55**	0,88	0,19	**0,48**	0,76	0,17	**0,44**	0,70	.S..HP

At 1,00 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.E..LEJ	0,24	**1,02**	1,71	0,18	**0,73**	1,21	0,13	**0,54**	0,90	0,11	**0,47**	0,78	0,10	**0,43**	0,71	.E..LEJ
.E..LE	0,24	**1,02**	1,71	0,18	**0,73**	1,21	0,13	**0,54**	0,90	0,11	**0,47**	0,78	0,10	**0,43**	0,71	.E..LE
.S..GEJ	0,49	**1,11**	1,87	0,35	**0,79**	1,32	0,26	**0,59**	0,98	0,23	**0,51**	0,85	0,21	**0,47**	0,78	.S..GEJ
.S..GE	0,49	**1,11**	1,87	0,35	**0,79**	1,32	0,26	**0,59**	0,98	0,23	**0,51**	0,85	0,21	**0,47**	0,78	.S..GE
.S..HP	0,49	**1,24**	2,03	0,35	**0,89**	1,43	0,26	**0,66**	1,06	0,23	**0,57**	0,92	0,21	**0,52**	0,84	.S..HP

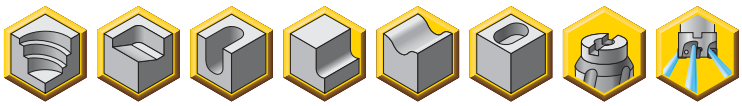
NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

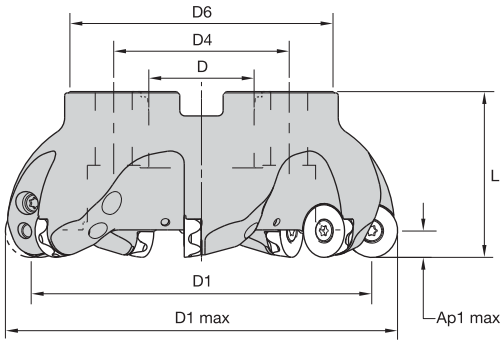
Maximum Linear Ramping and Helical Interpolation from Solid

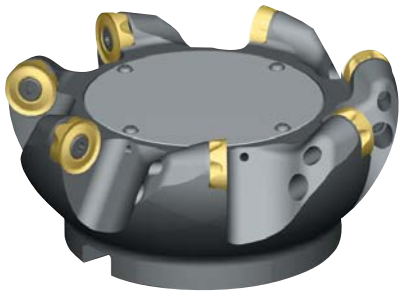


catalogue number	max ramp angle	max plunging depth	min hole diameter (DH min)	max flat-bottom hole diameter (DH1 max)	max diameter (no flat bottom)
40E03R045M16RP16	8.3°	2,6	52,4	64	80
40E02R040A32RP16L200	11.1°	3,3	51,2	64	80
50A04RS90RP16	9.2°	4,3	70	84	100
52A04RS90RP16	10.7°	5,25	73,14	88	104
63A04RS90RP16	11.8°	8,0	94,05	110	126
63A06RS90RP16	4.3°	3,07	97,71	110	126
80A05RS90RP16	8.2°	8,0	128,02	144	160
80A07RS90RP16	4.5°	4,5	129,89	144	160
100B06RS90RP16	6.1°	8,0	168,01	184	200
100B08RS90RP16	4.7°	6,22	168,58	184	200
125B09RS90RP16	4,3°	7,5	218,08	234	250

- Diameter range from 63–200mm.
- Engineered for roughing titanium with large depths of cut through positive geometry inserts.
- Anti-rotation feature allows up to six indexable rotations.
- High coolant pressure capabilities.







Shell Mills

order number	catalogue number	D1 max	D1	D	D4	D6	L	Ap1 max	Z	max ramp angle	kg	max RPM	insert 1
3095646	63A04RS90RC20C	63	43	22	–	50	50	10,0	4	.8°	0,62	26000	RCGT2006M0___
3095647	80A05RS90RC20C	80	60	27	–	60	50	10,0	5	.8°	0,89	22000	RCGT2006M0___
3095649	100B06RS90RC20C	100	80	32	–	80	63	10,0	6	.9°	2,11	18000	RCGT2006M0___
3095650	125B06RS90RC20C	125	105	40	–	90	63	10,0	6	.6°	2,96	15000	RCGT2006M0___
3095651	160C07RS90RC20C	160	140	40	67	100	63	10,0	7	.5°	3,90	14000	RCGT2006M0___
5971597	160C07RS90RC20CHP *	160	140	40	67	100	63	10,0	7	.5°	3,92	14000	RCGT2006M0___
3095652	160C08RS90RC20C	160	140	40	67	104	63	10,0	8	.5°	3,87	14000	RCGT2006M0___
5971596	160C08RS90RC20CHP *	160	140	40	67	100	63	10,0	8	.5°	3,96	14000	RCGT2006M0___
3095653	200C09RS90RC20C	200	180	60	102	130	63	10,0	9	.4°	5,77	12500	RCGT2006M0___
5971570	200C09RS90RC20CHP *	200	180	60	102	150	63	10,0	9	.4°	6,53	12500	RCGT2006M0___

NOTE: For high pressure coolant applications (>30 bar/>435 PSI) with cutter diameter 160-200mm, use items marked with “HP” in the catalogue number. They are available as per request. Please ask your local sales contact for further information.
*Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Spare Parts



order number	D1 max	insert screw	Nm	Torx wrench	anti-rotation screw	coolant cap assembly	socket-head cap screw with coolant groove	coolant lock screw assembly	high pressure coolant cap assembly	wrench adaptor
3095646	63	MS1162	5,0	TT25	S2160	–	MS1242CG	–	–	–
3095647	80	MS1162	5,0	TT25	S2160	–	MS2190CG	–	–	–
3095649	100	MS1162	5,0	TT25	S2160	–	–	MS2188C	–	–
3095650	125	MS1162	5,0	TT25	S2160	–	–	MS2187C	–	–
3095651	160	MS1162	5,0	TT25	S2160	MCCM16001	–	–	–	–
5971597	160	MS1162	5,0	TT25	S2160	–	–	–	MCCM160HP	SDSW66
3095652	160	MS1162	5,0	TT25	S2160	MCCM16001	–	–	–	–
5971596	160	MS1162	5,0	TT25	S2160	–	–	–	MCCM160HP	SDSW66
3095653	200	MS1162	5,0	TT25	S2160	MCC080001	–	–	–	–
5971570	200	MS1162	5,0	TT25	S2160	–	–	–	MCC0800HP	SDSW66

NOTE: For coolant shower plate assembly use only low pressure coolant.
Use high pressure coolant cap assembly only in combination with high pressure cutters.
Wrench adaptor for high-pressure tools SDSW66, order number 5976678 is not included and needs to be purchased separately.

Insert Selection Guide

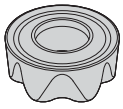
Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		←	→	toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.E..LF	KC725M	**.S..GFJ**	**KCPM40**	.S..HFJ	KCPM40
P3–P4	.E..LF	KC725M	**.S..GFJ**	**KCPM40**	.S..HFJ	KCPM40
P5–P6	.E..LF	KC725M	**.S..GF**	**KC725M**	.S..HF	KC725M
M1–M2	.E..LF	KCSM40	**.S..GF**	**KC522M**	.S..HF	KCSM40
M3	.E..LF	KCSM40	**.S..GFJ**	**KCPM40**	.S..HF	KCSM40
K1–K2	–	–	**–**	**–**	–	–
K3	.S..HF	KCPK30	**.S..HF**	**KCPK30**	.S..HF	KCPK30
N1–N2	–	–	**–**	**–**	–	–
N3	–	–	**–**	**–**	–	–
S1–S2	.E..LF	KCSM40	**.S..GF**	**KC725M**	.S..HF	KCSM40
S3	.E..LF	KCSM40	**.S..GFJ**	**KCPM40**	.S..HF	KCSM40
S4	.E..LF	KCSM40	**.S..GF**	**KC522M**	.S..HF	KCSM40
H1	–	–	**–**	**–**	–	–

Indexable Inserts

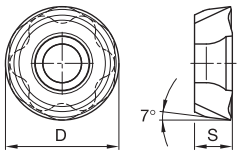
- -ELF is the first choice for lower cutting forces to avoid built-up edge.
- -SGF is for general purpose in roughing applications.
- -SHF is the first choice for heavy-duty applications.

● first choice
○ alternate choice

		KC522M	KC725M	KCPK30	KCPM40	KCSM30	KCSM40
P		○	●	●	●		○
M		●	●	○	●	○	●
K		○		○			
N							
S		●	●		○	●	●
H							



RCGT-LF
RCGT-GF
RCGT-HF



RCGT-LF
RCGT-GF
RCGT-HF

RCGT-LF

catalogue number	D	S	hm	cutting edges	KC522M	KC725M	KCPK30	KCPM40	KCSM30	KCSM40
RCGT2006M0ELF	20,00	6,35	0,04	6	–	●	–	–	–	●

RCGT-GF

catalogue number	D	S	hm	cutting edges	KC522M	KC725M	KCPK30	KCPM40	KCSM30	KCSM40
RCGT2006M0SGFJ	20,00	6,35	0,10	6	–	–	–	●	●	–
RCGT2006M0SGF	20,00	6,35	0,10	6	●	●	–	–	–	–

RCGT-HF

catalogue number	D	S	hm	cutting edges	KC522M	KC725M	KCPK30	KCPM40	KCSM30	KCSM40
RCGT2006M0SHFJ	20,00	6,35	0,25	6	–	–	–	●	–	–
RCGT2006M0SHF	20,00	6,35	0,25	6	–	●	●	–	–	●

Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining

At 10,00 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.E..LFJ	0,12	**0,44**	0,87	0,09	**0,32**	0,62	0,07	**0,24**	0,47	0,06	**0,21**	0,41	0,05	**0,19**	0,37	.E..LFJ
.E..LF	0,12	**0,44**	0,87	0,09	**0,32**	0,62	0,07	**0,24**	0,47	0,06	**0,21**	0,41	0,05	**0,19**	0,37	.E..LF
.S..GFJ	0,23	**0,52**	0,93	0,17	**0,38**	0,67	0,13	**0,28**	0,50	0,11	**0,24**	0,43	0,10	**0,22**	0,40	.S..GFJ
.S..GF	0,23	**0,52**	0,93	0,17	**0,38**	0,67	0,13	**0,28**	0,50	0,11	**0,24**	0,43	0,10	**0,22**	0,40	.S..GF
.S..HFJ	0,23	**0,59**	1,01	0,17	**0,42**	0,72	0,13	**0,32**	0,54	0,11	**0,28**	0,47	0,10	**0,25**	0,43	.S..HFJ
.S..HF	0,23	**0,59**	1,01	0,17	**0,42**	0,72	0,13	**0,32**	0,54	0,11	**0,28**	0,47	0,10	**0,25**	0,43	.S..HF

At 3,80 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.E..LFJ	0,16	**0,56**	1,11	0,11	**0,40**	0,80	0,09	**0,30**	0,59	0,07	**0,26**	0,52	0,07	**0,24**	0,47	.E..LFJ
.E..LF	0,16	**0,56**	1,11	0,11	**0,40**	0,80	0,09	**0,30**	0,59	0,07	**0,26**	0,52	0,07	**0,24**	0,47	.E..LF
.S..GFJ	0,30	**0,66**	1,18	0,22	**0,48**	0,85	0,16	**0,36**	0,64	0,14	**0,31**	0,55	0,13	**0,29**	0,51	.S..GFJ
.S..GF	0,30	**0,66**	1,18	0,22	**0,48**	0,85	0,16	**0,36**	0,64	0,14	**0,31**	0,55	0,13	**0,29**	0,51	.S..GF
.S..HFJ	0,30	**0,75**	1,29	0,22	**0,54**	0,92	0,16	**0,41**	0,69	0,14	**0,35**	0,60	0,13	**0,32**	0,55	.S..HFJ
.S..HF	0,30	**0,75**	1,29	0,22	**0,54**	0,92	0,16	**0,41**	0,69	0,14	**0,35**	0,60	0,13	**0,32**	0,55	.S..HF

At 2,00 Axial Depth of Cut (ap)

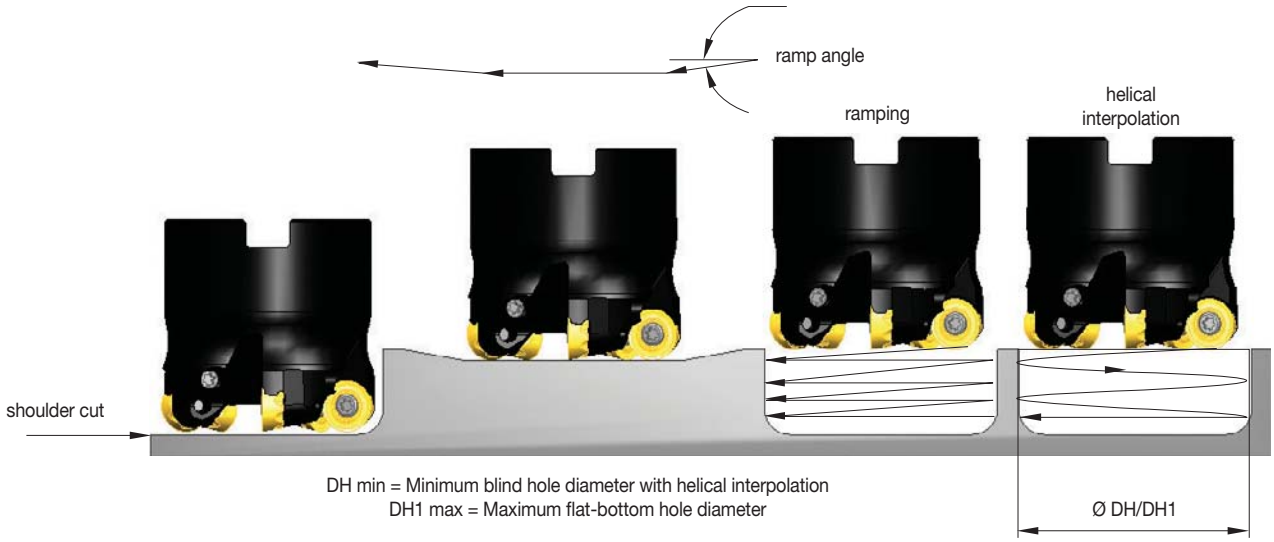
Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.E..LFJ	0,21	**0,73**	1,46	0,15	**0,53**	1,04	0,11	**0,40**	0,78	0,10	**0,35**	0,68	0,09	**0,32**	0,62	.E..LFJ
.E..LF	0,21	**0,73**	1,46	0,15	**0,53**	1,04	0,11	**0,40**	0,78	0,10	**0,35**	0,68	0,09	**0,32**	0,62	.E..LF
.S..GFJ	0,39	**0,87**	1,56	0,28	**0,63**	1,12	0,21	**0,47**	0,83	0,18	**0,41**	0,72	0,17	**0,37**	0,66	.S..GFJ
.S..GF	0,39	**0,87**	1,56	0,28	**0,63**	1,12	0,21	**0,47**	0,83	0,18	**0,41**	0,72	0,17	**0,37**	0,66	.S..GF
.S..HFJ	0,39	**0,99**	1,69	0,28	**0,71**	1,21	0,21	**0,53**	0,90	0,18	**0,46**	0,79	0,17	**0,42**	0,72	.S..HFJ
.S..HF	0,39	**0,99**	1,69	0,28	**0,71**	1,21	0,21	**0,53**	0,90	0,18	**0,46**	0,79	0,17	**0,42**	0,72	.S..HF

At 1,30 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.E..LFJ	0,25	**0,90**	1,78	0,18	**0,65**	1,27	0,14	**0,48**	0,95	0,12	**0,42**	0,83	0,11	**0,39**	0,76	.E..LFJ
.E..LF	0,25	**0,90**	1,78	0,18	**0,65**	1,27	0,14	**0,48**	0,95	0,12	**0,42**	0,83	0,11	**0,39**	0,76	.E..LF
.S..GFJ	0,48	**1,06**	1,90	0,34	**0,76**	1,36	0,26	**0,57**	1,01	0,22	**0,50**	0,88	0,21	**0,46**	0,81	.S..GFJ
.S..GF	0,48	**1,06**	1,90	0,34	**0,76**	1,36	0,26	**0,57**	1,01	0,22	**0,50**	0,88	0,21	**0,46**	0,81	.S..GF
.S..HFJ	0,48	**1,20**	2,07	0,34	**0,86**	1,48	0,26	**0,65**	1,10	0,22	**0,56**	0,96	0,21	**0,52**	0,88	.S..HFJ
.S..HF	0,48	**1,20**	2,07	0,34	**0,86**	1,48	0,26	**0,65**	1,10	0,22	**0,56**	0,96	0,21	**0,52**	0,88	.S..HF

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

Maximum Linear Ramping and Helical Interpolation from Solid

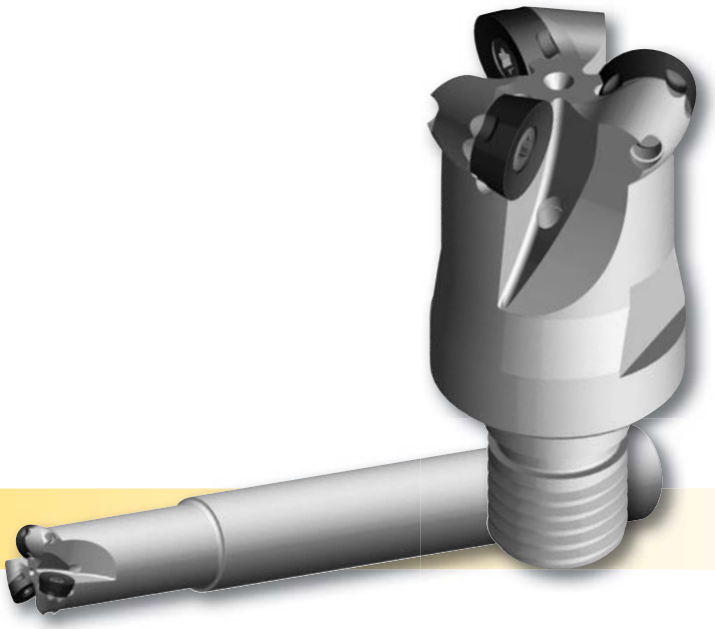


insert IC	catalogue number	max ramp angle (ra) when hx = .127mm	max ramp angle (ra) when hx = .5mm	max plunge radial depth (ae) when hx = .5mm	min hole diameter (DH min)	max flat-bottom hole diameter	max diameter (no flat bottom)
RCGX2006	**63A04RS90RC20C**	1.29°	0.79°	13.61	99.48	106.08	126.00
RCGX2006	**80A05RS90RC20C**	1.23°	0.80°	14.35	131.61	140.08	160.00
RCGX2006	**100B05RS90RC20C**	1.17°	0.84°	15.24	170.31	180.08	200.00
RCGX2006	**100B06RS90RC20C**	1.15°	0.89°	15.16	170.09	180.08	200.00
RCGX2006	**125B06RS90RC20C**	1.06°	0.63°	15.50	219.05	230.08	250.00
RCGX2006	**160C07RS90RC20C**	0.92°	0.50°	14.95	220.23	230.08	250.00
RCGX2006	**160C08RS90RC20C**	0.92°	0.49°	14.90	290.34	300.08	320.00
RCGX2006	**200C09RS90RC20C**	0.79°	0.41°	15.03	290.01	300.08	320.00

7713VR Series

Round Insert Milling Cutter with Indexation

The 7713VR is our newest round insert cutter series. Designed with a new silver-satin surface treatment that reduces body degradation during high-performance applications and enhances body tool life. This cutter series has an anti-rotation design that ensures a precise number of indexes per insert. This enables maximum usage of the available edges for roughing applications.



Features and Benefits

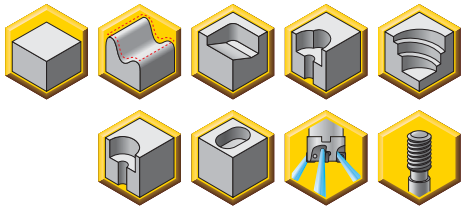
This unique patented pocket system prevents the inserts from rotating in the pocket during heavy-feed machining and unstable conditions. The 7713VR cutter is excellent for roughing and semi-finishing of all materials, especially stainless steel and high-temperature alloys, as well as steel, tool steel, and aluminium alloys.

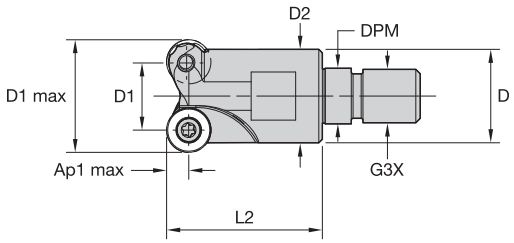


7713VR10:
Maximum ap = 5mm
Diameter Range = 20–63mm

7713VR12:
Maximum ap = 6mm
Diameter Range = 25–80mm

- Turbine blade machining and copy/contour milling applications.
- Patented locking system prevents insert rotation during heavy machining.
- Positive flute design for excellent chip evacuation.







Screw-On End Mills

order number	catalogue number	D1 max	D1	D	D2	L2	G3X	DPM	Ap1 max	Z
5673049	**7713VR10SA020Z2R25**	20	10	18	19	25	M10	10,50	5,0	2
5672230	**7713VR10SA025Z2R35**	25	15	21	24	35	M12	12,50	5,0	2
5673768	**7713VR10SA025Z3R35**	25	15	21	24	35	M12	12,50	5,0	3
5672231	**7713VR10SA032Z3R35**	32	22	29	31	35	M16	17,00	5,0	3
5673050	**7713VR10SA032Z4R35**	32	22	29	31	35	M16	17,00	5,0	4
5673341	**7713VR10SA035Z5R35**	35	25	29	34	35	M16	17,00	5,0	5

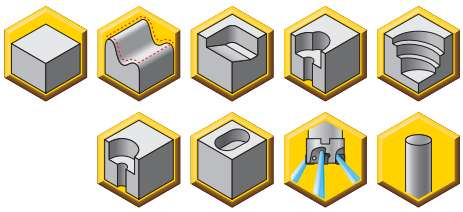
Spare Parts

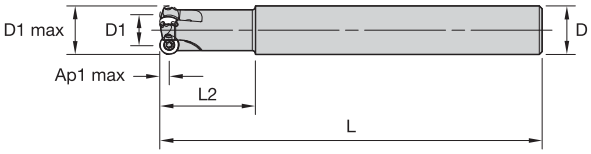




D1 max	insert screw	Nm	Torx driver
20	**D4007T**	3,1	**TB15**
25	**D4007T**	3,1	**TB15**
32	**D4008T**	3,1	**TB15**
35	**D4007T**	3,1	**TB15**

- Turbine blade machining and copy/contour milling applications.
- Patented locking system prevents insert rotation during heavy machining.
- Positive flute design for excellent chip evacuation.







Cylindrical End Mills

order number	catalogue number	D1 max	D1	D	L	L2	Ap1 max	Z
5672811	**7713VR10CA020Z2R40**	20	10	20	180	40	5,0	2
5673047	**7713VR10CA025Z3R50**	25	15	25	200	50	5,0	3
5672812	**7713VR10CA032Z3R70**	32	22	32	250	70	5,0	3
5673048	**7713VR10CA032Z4R70**	32	22	32	250	70	5,0	4

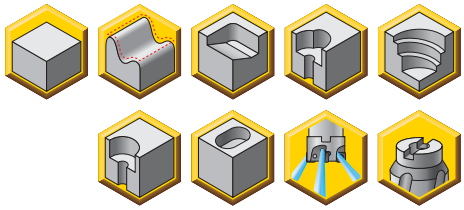
Spare Parts

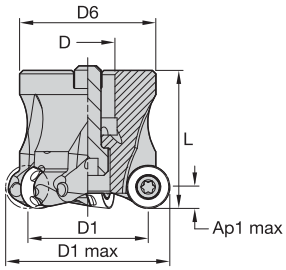




D1 max	insert screw	Nm	Torx driver
20	**D4007T**	3,1	**TB15**
25	**D4007T**	3,1	**TB15**
32	**D4008T**	3,1	**TB15**

- Turbine blade machining and copy/contour milling applications.
- Patented locking system prevents insert rotation during heavy machining.
- Positive flute design for excellent chip evacuation.







Shell Mills

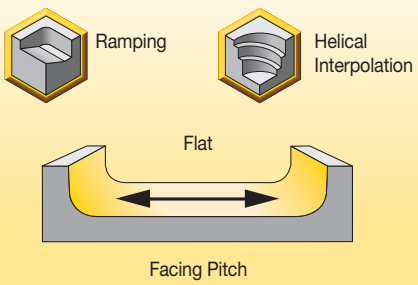
order number	catalogue number	D1 max	D1	D	D6	L	Ap1 max	Z
5672813	7713VR10-A040Z05R	40	30	16	36	40	5,0	5
5672625	7713VR10-A042Z06R	42	32	16	38	40	5,0	6
5673340	7713VR10-A050Z06R	50	40	22	41	40	5,0	6
5673828	7713VR10-A050Z07R	50	40	22	41	40	5,0	7
5673438	7713VR10-A063Z08R	63	53	22	56	40	5,0	8

Spare Parts

D1 max	insert screw	Nm	Torx driver	socket-head cap screw
40	D4008T	3,1	TB15	M8 1.25 X 25 SHCS
42	D4007T	3,1	TB15	M8 1.25 X 25 SHCS
50	D4008T	3,1	TB15	M10 1.5 X 25 SHCS
63	D4008T	3,1	TB15	M10 1.5 X 25 SHCS

Technical Information (mm)

order number	catalogue number	dimension facing pitch	ramping angle	helical hole min	helical hole max	ap max helical/linear	max RPM
5672811	7713VR10CA020Z2R40	10	1,89	22	38	3,33	79500
5673047	7713VR10CA025Z3R50	15	5,22	32	48	3,33	64500
5672812	7713VR10CA032Z3R70	22	8,64	46	62	3,33	53500
5673048	7713VR10CA032Z4R70	22	8,64	46	62	3,33	53500
5672813	7713VR10-A040Z05R	30	7,28	62	78	3,33	45500
5672625	7713VR10-A042Z06R	32	6,71	66	82	3,33	39500
5673340	7713VR10-A050Z06R	40	5,22	82	98	3,33	39500
5673828	7713VR10-A050Z07R	40	5,31	82	98	3,33	39500
5673438	7713VR10-A063Z08R	53	3,79	108	124	3,33	34500
5673049	7713VR10SA020Z2R25	10	1,89	22	38	3,33	79500
5672230	7713VR10SA025Z2R35	15	5,22	32	48	3,33	64500
5673768	7713VR10SA025Z3R35	15	5,22	32	48	3,33	64500
5672231	7713VR10SA032Z3R35	22	8,64	46	62	3,33	53500
5673050	7713VR10SA032Z4R35	22	8,64	46	62	3,33	53500
5673341	7713VR10SA035Z5R35	25	7,20	52	68	3,33	50000



Insert Selection Guide • IC 10

Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance ⟷				⟷ toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	422-X8	SP6519	**432-X5**	**SC6525**	422-X4	SP6519
P3–P4	422-X8	SP6519	**432-X5**	**SP6519**	422-X4	SP6519
P5–P6	422-X8	SP6519	**T-X4**	**SP6519**	T-X4	X500
M1–M2	422-X8	SP6519	**432-X5**	**SC6525**	422-X4	SP6519
M3	422-X8	X700	**432-X5**	**SP6519**	422-X4	X500
K1–K2	422-X8	SP6519	**432-X5**	**SC6525**	T-X4	SP6519
K3	422-X8	SP6519	**432-X5**	**SC6525**	T-X4	SP6519
N1–N2	701-X4	GH1	**701-X4**	**GH1**	701-X4	GH1
N3	701-X4	GH1	**701-X4**	**GH1**	701-X4	GH1
S1–S2	422-X8	X700	**432-X5**	**X500**	422-X4	X500
S3	422-X8	X700	**432-X5**	**X500**	422-X4	X500
S4	422-X8	X700	**432-X5**	**X500**	422-X4	X500
H1	–	–	**–**	**–**	–	–

Indexable Inserts

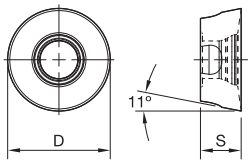
- Four indexation positions:
  - Ap max: 5mm.
  - Ap recommended: ≤2,5mm.

● first choice
○ alternate choice

		GH1	KCM40	MP91M	SC6525	SP4019	SP6519	X500	X700
P			●	●	●	○	○	○	
M			●			●	●	●	●
K		○		●	●	●	○		
N		●							
S			○			●	●	●	●
H				○		○			


RPEX10-701-X4


RPHT10-421-X4



RPEX10-701-X4 • Precision Ground • 4 Indexes • First Choice for Roughing Non-Ferrous Alloys and Finishing High-Temp Alloys

catalogue number	D	S	hm	cutting edges	GH1	KCM40	MP91M	SC6525	SP4019	SP6519	X500	X700
RPEX10T3M0F701X4	10,00	3,97	0,02	4	●	–	–	–	●	–	–	–

RPHT10-421-X4 • Precision Ground • 4 Indexes

catalogue number	D	S	hm	cutting edges	GH1	KCM40	MP91M	SC6525	SP4019	SP6519	X500	X700
RPHT10T3M0E421X4	10,00	3,97	0,04	4	–	–	–	–	–	–	●	●


RPHT10-422-X8

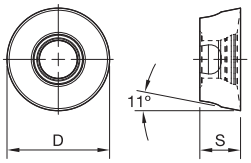

RPHT10-TX4


RPMT10-41-X4


RPHT10-422-X4


RPMW10-T-X4


RPPT10-432-X5



● first choice
○ alternate choice

P			●	●	●	○	○	○	
M			●			●	●	●	●
K		○		●	●	●	○		
N		●							
S			○			●	●	●	●
H				○		○			

RPHT10-422-X4 • Precision Ground • 4 Indexes • For Machining Stainless Steel and Heat-Resistant Alloys

catalogue number	D	S	hm	cutting edges	GH1	KCM40	MP91M	SC6525	SP4019	SP6519	X500	X700
RPHT10T3M0E422X4	10,00	3,97	0,03	4	–	–	–	–	–	●	●	●

RPHT10-422-X8 • Precision Ground • 8 Indexes • For Machining Stainless Steel and Heat-Resistant Alloys

catalogue number	D	S	hm	cutting edges	GH1	KCM40	MP91M	SC6525	SP4019	SP6519	X500	X700
RPHT10T3M0E422X8	10,00	3,96	0,03	8	–	–	–	–	–	●	●	●

RPHT10-TX4 • Precision Ground • 4 Indexes • General Purpose for Roughing

catalogue number	D	S	hm	cutting edges	GH1	KCM40	MP91M	SC6525	SP4019	SP6519	X500	X700
RPHT10T3M0TX4	10,00	3,97	0,08	4	–	–	–	–	–	●	●	–

RPMT10-41-X4 • 4 Indexes • For Finishing Alloy Steel and Iron

catalogue number	D	S	hm	cutting edges	GH1	KCM40	MP91M	SC6525	SP4019	SP6519	X500	X700
RPMT10T3M0E41X4	10,00	3,97	0,04	4	–	–	●	–	–	●	●	–

RPMW10-T-X4 • 4 Indexes • General Purpose for Roughing

catalogue number	D	S	hm	cutting edges	GH1	KCM40	MP91M	SC6525	SP4019	SP6519	X500	X700
RPMW10T3M0TX4	10,00	3,97	0,13	4	–	–	–	–	–	–	●	–

RPPT10-432-X5 • Precision Pressed • 5 Indexes • For Machining Stainless Steel and Heat-Resistant Alloys

catalogue number	D	S	hm	cutting edges	GH1	KCM40	MP91M	SC6525	SP4019	SP6519	X500	X700
RPPT10T3M0E432X5	10,00	3,97	0,03	5	–	–	–	●	–	●	●	●

Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining

At 5,00 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
701-X4	0,12	**0,19**	0,26	0,08	**0,13**	0,18	0,06	**0,10**	0,14	0,05	**0,09**	0,12	0,05	**0,08**	0,11	701-X4
422-X8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	422-X8
432-X5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	432-X5
422-X4	0,12	**0,29**	0,57	0,08	**0,21**	0,40	0,06	**0,16**	0,30	0,05	**0,14**	0,26	0,05	**0,13**	0,24	422-X4
T-X4	0,23	**0,41**	0,66	0,17	**0,30**	0,47	0,13	**0,22**	0,35	0,11	**0,19**	0,31	0,10	**0,18**	0,28	T-X4

At 2,50 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
701-X4	0,13	**0,21**	0,30	0,10	**0,15**	0,21	0,07	**0,12**	0,16	0,06	**0,10**	0,14	0,06	**0,09**	0,13	701-X4
422-X8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	422-X8
432-X5	0,13	**0,34**	0,66	0,10	**0,24**	0,47	0,07	**0,18**	0,35	0,06	**0,16**	0,30	0,06	**0,15**	0,28	432-X5
422-X4	0,13	**0,34**	0,66	0,10	**0,24**	0,47	0,07	**0,18**	0,35	0,06	**0,16**	0,30	0,06	**0,15**	0,28	422-X4
T-X4	0,27	**0,48**	0,77	0,19	**0,34**	0,55	0,14	**0,25**	0,41	0,13	**0,22**	0,35	0,12	**0,20**	0,32	T-X4

At 2,00 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
701-X4	0,14	**0,23**	0,32	0,10	**0,17**	0,23	0,08	**0,13**	0,17	0,07	**0,11**	0,15	0,06	**0,10**	0,14	701-X4
422-X8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	422-X8
432-X5	0,14	**0,37**	0,71	0,10	**0,26**	0,51	0,08	**0,20**	0,38	0,07	**0,17**	0,33	0,06	**0,16**	0,30	432-X5
422-X4	0,14	**0,37**	0,71	0,10	**0,26**	0,51	0,08	**0,20**	0,38	0,07	**0,17**	0,33	0,06	**0,16**	0,30	422-X4
T-X4	0,29	**0,52**	0,84	0,21	**0,37**	0,59	0,16	**0,28**	0,44	0,14	**0,24**	0,38	0,13	**0,22**	0,35	T-X4

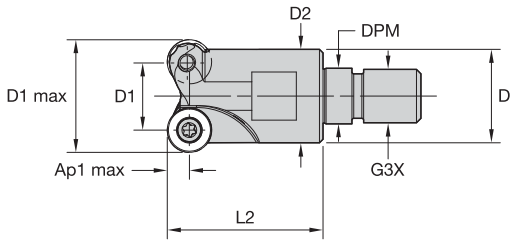
At 1,50 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
701-X4	0,16	**0,26**	0,36	0,12	**0,19**	0,26	0,09	**0,14**	0,19	0,08	**0,12**	0,17	0,07	**0,11**	0,15	701-X4
422-X8	0,16	**0,41**	0,80	0,12	**0,30**	0,57	0,09	**0,22**	0,42	0,08	**0,19**	0,37	0,07	**0,18**	0,34	422-X8
432-X5	0,16	**0,41**	0,80	0,12	**0,30**	0,57	0,09	**0,22**	0,42	0,08	**0,19**	0,37	0,07	**0,18**	0,34	432-X5
422-X4	0,16	**0,41**	0,80	0,12	**0,30**	0,57	0,09	**0,22**	0,42	0,08	**0,19**	0,37	0,07	**0,18**	0,34	422-X4
T-X4	0,33	**0,58**	0,94	0,23	**0,42**	0,67	0,18	**0,31**	0,49	0,15	**0,27**	0,43	0,14	**0,25**	0,39	T-X4

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

- Turbine blade machining and copy/contour milling applications.
- Patented locking system prevents insert rotation during heavy machining.
- Positive flute design for excellent chip evacuation.







Screw-On End Mills

order number	catalogue number	D1 max	D1	D	D2	L2	G3X	DPM	Ap1 max	Z
5672236	7713VR12SA025Z2R35	25	13	21	24	35	M12	12,50	6,0	2
5673052	7713VR12SA032Z3R35	32	20	29	31	35	M16	17,00	6,0	3
5673439	7713VR12SA040Z4R43	40	28	29	38	43	M16	17,00	6,0	4
5673053	7713VR12SA040Z5R43	40	28	29	38	43	M16	17,00	6,0	5

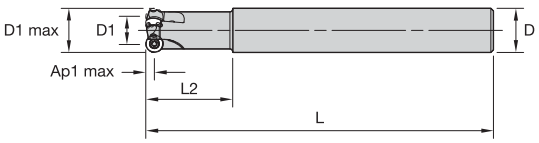
Spare Parts





D1 max	insert screw	Nm	Torx driver
25	D4008T	3,1	T15
32	D4008T	3,1	T15
40	D4008T	3,1	T15







Cylindrical End Mills

order number	catalogue number	D1 max	D1	D	L	L2	Ap1 max	Z
5673770	7713VR12CA025Z2R50	25	13	25	200	50	6,0	2
5673830	7713VR12CA032Z3R70	32	20	32	250	70	6,0	3

Spare Parts

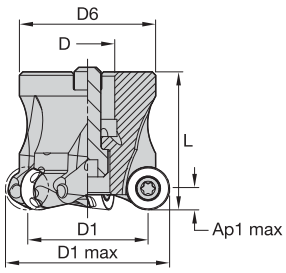




D1 max	insert screw	Nm	Torx driver
25	D4008T	3,1	T15
32	D4008T	3,1	T15

- Turbine blade machining and copy/contour milling applications.
- Patented locking system prevents insert rotation during heavy machining.
- Positive flute design for excellent chip evacuation.







Shell Mills

order number	catalogue number	D1 max	D1	D	D6	L	Ap1 max	Z
5672232	7713VR12-A040Z04R	40	28	16	34	40	6,0	4
5673360	7713VR12-A040Z05R	40	28	16	33	40	6,0	5
5672233	7713VR12-A050Z05R	50	38	22	43	40	6,0	5
5673051	7713VR12-A050Z06R	50	38	22	43	40	6,0	6
5673769	7713VR12-A052Z05R	52	40	22	45	40	6,0	5
5673342	7713VR12-A052Z06R	52	40	22	45	40	6,0	6
5672234	7713VR12-A063Z06R	63	51	22	56	50	6,0	6
5673599	7713VR12-A063Z07R	63	51	22	56	50	6,0	7
5672235	7713VR12-A066Z06R	66	54	27	56	50	6,0	6
5673479	7713VR12-A066Z07R	66	54	27	56	50	6,0	7
5673829	7713VR12-A080Z08R	80	68	27	68	50	6,0	8

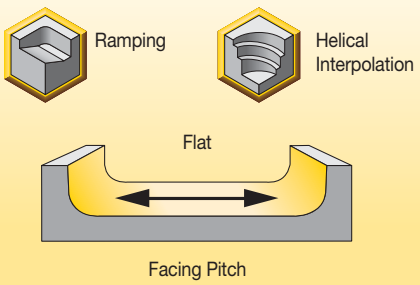
Spare Parts

order number	D1 max	 insert screw	 Nm	 Torx driver	 socket-head cap screw
5672232	40	D4010T	3,1	T15	M8 1.25 X 25 SHCS
5673360	40	D4008T	3,1	T15	M8 1.25 X 25 SHCS
5672233	50	D4010T	3,1	T15	M10 1.5 X 25 SHCS
5673051	50	D4010T	3,1	T15	M10 1.5 X 25 SHCS
5673769	52	D4010T	3,1	T15	M10 1.5 X 25 SHCS
5673342	52	D4010T	3,1	T15	M10 1.5 X 25 SHCS
5672234	63	D4010T	3,1	T15	M10 1.5 X 25 SHCS
5673599	63	D4010T	3,1	T15	M10 1.5 X 25 SHCS
5672235	66	D4010T	3,1	T15	M12 X 1.75 X 30 SHCS
5673479	66	D4010T	3,1	T15	M12 X 1.75 X 30 SHCS
5673829	80	D4010T	3,1	T15	M12 X 1.75 X 30 SHCS

Technical Information

Technical Information (mm)

order number	catalogue number	dimension: facing pitch	ramping angle	helical hole min	helical hole max	ap max helical/linear	max RPM
5673770	7713VR12CA025Z2R50	13	11,20	28	48	4,00	50000
5673830	7713VR12CA032Z3R70	20	10,80	42	62	4,00	40000
5672232	7713VR12-A040Z04R	28	7,90	58	78	4,00	34000
5673360	7713VR12-A040Z05R	28	7,90	58	78	4,00	34000
5672233	7713VR12-A050Z05R	38	5,50	78	98	4,00	29000
5673051	7713VR12-A050Z06R	38	5,50	78	98	4,00	29000
5673769	7713VR12-A052Z05R	40	5,15	82	102	4,00	28500
5673342	7713VR12-A052Z06R	40	5,15	82	102	4,00	28500
5672234	7713VR12-A063Z06R	51	3,85	104	124	4,00	25000
5673599	7713VR12-A063Z07R	51	3,85	104	124	4,00	25000
5672235	7713VR12-A066Z06R	54	3,60	110	130	4,00	24500
5673479	7713VR12-A066Z07R	54	3,60	110	130	4,00	24500
5673829	7713VR12-A080Z08R	68	2,75	138	158	4,00	21500
5672236	7713VR12SA025Z2R35	13	11,20	28	48	4,00	50000
5673052	7713VR12SA032Z3R35	20	10,80	42	62	4,00	40000
5673439	7713VR12SA040Z4R43	28	7,90	58	78	4,00	34000
5673053	7713VR12SA040Z5R43	28	7,90	58	78	4,00	34000



Insert Selection Guide • IC 12

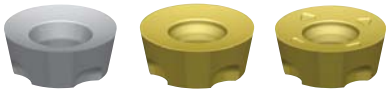
Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		◄———	———►	toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	442-X8	SC6525	**432-X5**	**SC6525**	GD-X5	KCM40
P3–P4	432-X8	SP6519	**432-X5**	**SP6519**	GD-X5	KCM40
P5–P6	432-X8	SP6519	**T-X4**	**SP6519**	T-X4	X500
M1–M2	442-X8	SC6525	**432-X5**	**SC6525**	GD-X5	KCM40
M3	432-X8	SP6519	**GD-X5**	**KCM40**	442-X4	X500
K1–K2	T-X4	MP91M	**T-X4**	**MP91M**	T-X4	MP91M
K3	T-X4	MP91M	**T-X4**	**MP91M**	T-X4	MP91M
N1–N2	701-X4	GH1	**701-X4**	**GH1**	701-X4	GH1
N3	701-X4	GH1	**701-X4**	**GH1**	701-X4	GH1
S1–S2	442-X5	SP6519	**GD-X5**	**KCM40**	442-X4	X500
S3	442-X5	SP6519	**GD-X5**	**KCM40**	442-X4	X500
S4	442-X5	SP6519	**442-X5**	**X500**	442-X4	X500
H1	–	–	**T-X4**	**MP91M**	–	–

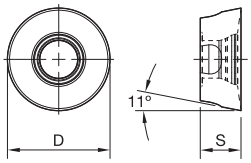
Indexable Inserts

- Four indexation positions:
  - — Ap max: 6mm
  - — Ap recommended: ≤ 3,5mm
- Five indexation positions:
  - — Ap max: 4mm
  - — Ap recommended: ≤ 2,5mm
- Eight indexation positions:
  - — Ap max: 3mm
  - — Ap recommended: ≤ 1,5mm

● first choice
○ alternate choice

		GH1	KCM40	MP91M	SC6525	SP4019	SP6519	X500	X700
P			●	●	●	○	○	○	
M			●			●	●	●	●
K		○		●	●	●	○		
N		●							
S			○			●	●	●	●
H				○		○			


RPEX12-701-X4 RPHT12-421-X4 RPHT12-422-X4



RPEX12-701-X4 • Precision Ground • 4 Indexes • For Roughing Non-Ferrous Alloys and Finishing High-Temp Alloys

catalogue number	D	S	hm	cutting edges	GH1	KCM40	MP91M	SC6525	SP4019	SP6519	X500	X700
RPEX1204M0F701X4	12,00	4,76	0,02	4	●	–	–	–	–	–	–	–
RPEX1204M0E701X4	12,00	4,76	0,03	4	–	–	–	–	–	–	●	–

RPHT12-421-X4 • Precision Ground • 4 Indexes

catalogue number	D	S	hm	cutting edges	GH1	KCM40	MP91M	SC6525	SP4019	SP6519	X500	X700
RPHT1204M0E421X4	12,00	4,76	0,04	4	–	–	–	–	–	–	●	–

RPHT12-442-X4 • Precision Ground • 4 Indexes • For Machining Stainless Steel and Heat-Resistant Alloys

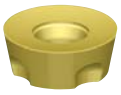
catalogue number	D	S	hm	cutting edges	GH1	KCM40	MP91M	SC6525	SP4019	SP6519	X500	X700
RPHT1204M0E442X4	12,00	4,76	0,04	4	–	–	–	–	–	●	●	●


RPHT12-442-X5

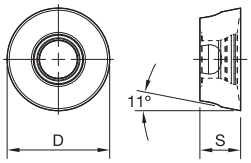

RPHT12-442-X8


RPHT12-SGD-X5


RPHT12-SGD-X8


RPHT12-T-X4


RPMT12-41-X4



● first choice
○ alternate choice

P			●	●	●	○	○	○		
M			●			●	●	●	●	
K		○		●	●	●	○			
N		●								
S			○			●	●	●	●	
H				○		○				

RPHT12-442-X5 • Precision Ground • 5 Indexes • For Machining Stainless Steel and Heat-Resistant Alloys

catalogue number	D	S	hm	cutting edges	GH1	KCM40	MP91M	SC6525	SP4019	SP6519	X500	X700
RPHT1204M0E442X5	12,00	4,76	0,04	5	–	–	–	●	–	●	●	●

RPHT12-442-X8 • Precision Ground • 8 Indexes • For Machining Stainless Steel and Heat-Resistant Alloys

catalogue number	D	S	hm	cutting edges	GH1	KCM40	MP91M	SC6525	SP4019	SP6519	X500	X700
RPHT1204M0E442X8	12,00	4,76	0,04	8	–	–	–	●	–	–	–	–

RPHT12-SGD-X5 • Precision Ground • 5 Indexes • For Stainless Steel and Heat-Resistant Alloys in Tougher Conditions

catalogue number	D	S	hm	cutting edges	GH1	KCM40	MP91M	SC6525	SP4019	SP6519	X500	X700
RPHT1204M0SGDX5	12,00	4,76	0,04	5	–	●	–	–	–	–	–	–

RPHT12-SGD-X8 • Precision Ground • 8 Indexes • For Stainless Steel and Heat-Resistant Alloys in Tougher Conditions

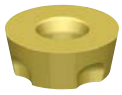
catalogue number	D	S	hm	cutting edges	GH1	KCM40	MP91M	SC6525	SP4019	SP6519	X500	X700
RPHT1204M0SGDX8	12,00	4,76	0,04	8	–	●	–	–	–	–	–	–

RPHT12-T-X4 • Precision Ground • 4 Indexes • General Purpose for Roughing

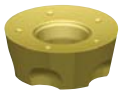
catalogue number	D	S	hm	cutting edges	GH1	KCM40	MP91M	SC6525	SP4019	SP6519	X500	X700
RPHT1204M0TX4	12,00	4,76	0,10	4	–	–	–	–	–	●	●	●

RPMT12-41-X4 • 4 Indexes • For Finishing Alloy Steel and Iron

catalogue number	D	S	hm	cutting edges	GH1	KCM40	MP91M	SC6525	SP4019	SP6519	X500	X700
RPMT1204M0E41X4	12,00	4,76	0,05	4	–	–	●	–	–	●	●	–


RPMW12-T-X4


RPPT12-432-X4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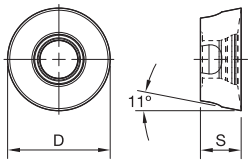
RPPT12-432-X8


RPPT12-SGD-X5



● first choice
○ alternate choice

		GH1	KCM40	MP91M	SC6525	SP4019	SP6519	X500	X700
P			●	●	●	○	○	○	
M			●			●	●	●	●
K		○		●	●	●	○		
N		●							
S			○			●	●	●	●
H				○		○			

RPMW12-T-X4 • 4 Indexes • General Purpose for Roughing

catalogue number	D	S	hm	cutting edges	GH1	KCM40	MP91M	SC6525	SP4019	SP6519	X500	X700
RPMW1204M0TX4	12,00	4,76	0,13	4	–	–	●	–	–	●	●	–

RPPT12-432-X4 • Precision Pressed • 4 Indexes • For Machining Stainless Steel and Heat-Resistant Alloys

catalogue number	D	S	hm	cutting edges	GH1	KCM40	MP91M	SC6525	SP4019	SP6519	X500	X700
RPPT1204M0E432X4	12,00	4,76	0,04	4	–	–	–	●	–	–	●	●

RPPT12-432-X5 • Precision Pressed • 5 Indexes • For Machining Stainless Steel and Heat-Resistant Alloys

catalogue number	D	S	hm	cutting edges	GH1	KCM40	MP91M	SC6525	SP4019	SP6519	X500	X700
RPPT1204M0E432X5	12,00	4,76	0,04	5	–	–	–	●	–	●	●	●

RPPT12-432-X8 • Precision Pressed • 8 Indexes • For Machining Stainless Steel and Heat-Resistant Alloys

catalogue number	D	S	hm	cutting edges	GH1	KCM40	MP91M	SC6525	SP4019	SP6519	X500	X700
RPPT1204M0E432X8	12,00	4,76	0,04	8	–	–	–	–	–	●	●	●

RPPT12-SGD-X4, X5, X8 • Precision Pressed • 4, 5, or 8 Indexes • For Stainless Steel and Heat-Resistant Alloys in Tougher Conditions

catalogue number	D	S	hm	cutting edges	GH1	KCM40	MP91M	SC6525	SP4019	SP6519	X500	X700
RPPT1204M0SGDX4	12,00	4,76	0,04	4	–	●	–	–	–	–	–	–
RPPT1204M0SGDX5	12,00	4,76	0,04	5	–	●	–	–	–	–	–	–
RPPT1204M0SGDX8	12,00	4,76	0,04	8	–	●	–	–	–	–	–	–

Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining

At 6,00 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
701–X4	0,12	**0,16**	0,22	0,08	**0,12**	0,16	0,06	**0,09**	0,12	0,05	**0,08**	0,10	0,05	**0,07**	0,10	701–X4
432–X5	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	432–X5
432–X8	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	432–X8
442–X5	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	442–X5
442–X8	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	442–X8
442–X4	0,23	**0,41**	0,66	0,17	**0,30**	0,47	0,13	**0,22**	0,35	0,11	**0,19**	0,31	0,10	**0,18**	0,28	442–X4
GD–X5	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	GD–X5
GD–X8	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	GD–X8
T–X4	0,23	**0,41**	0,66	0,17	**0,30**	0,47	0,13	**0,22**	0,35	0,11	**0,19**	0,31	0,10	**0,18**	0,28	T–X4

At 3,00 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
701–X4	0,13	**0,19**	0,25	0,10	**0,14**	0,18	0,07	**0,10**	0,14	0,06	**0,09**	0,12	0,06	**0,08**	0,11	701–X4
432–X5	0,16	**0,49**	0,93	0,12	**0,35**	0,66	0,09	**0,26**	0,49	0,08	**0,23**	0,43	0,07	**0,21**	0,39	432–X5
432–X8	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	432–X8
442–X5	0,16	**0,49**	0,93	0,12	**0,35**	0,66	0,09	**0,26**	0,49	0,08	**0,23**	0,43	0,07	**0,21**	0,39	442–X5
442–X8	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	442–X8
442–X4	0,16	**0,49**	0,93	0,12	**0,35**	0,66	0,09	**0,26**	0,49	0,08	**0,23**	0,43	0,07	**0,21**	0,39	442–X4
GD–X5	0,16	**0,54**	0,99	0,12	**0,39**	0,70	0,09	**0,29**	0,52	0,08	**0,25**	0,45	0,07	**0,23**	0,42	GD–X5
GD–X8	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	GD–X8
T–X4	0,27	**0,68**	1,10	0,19	**0,49**	0,78	0,14	**0,36**	0,58	0,13	**0,32**	0,50	0,12	**0,29**	0,46	T–X4

At 2,50 Axial Depth of Cut (ap)

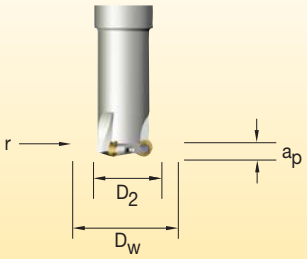
Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
701–X4	0,14	**0,20**	0,27	0,10	**0,14**	0,20	0,08	**0,11**	0,15	0,07	**0,09**	0,13	0,06	**0,09**	0,12	701–X4
432–X5	0,17	**0,52**	1,00	0,12	**0,37**	0,71	0,09	**0,28**	0,53	0,08	**0,24**	0,46	0,07	**0,22**	0,42	432–X5
432–X8	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	432–X8
442–X5	0,17	**0,52**	1,00	0,12	**0,37**	0,71	0,09	**0,28**	0,53	0,08	**0,24**	0,46	0,07	**0,22**	0,42	442–X5
442–X8	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	442–X8
442–X4	0,17	**0,52**	1,00	0,12	**0,37**	0,71	0,09	**0,28**	0,53	0,08	**0,24**	0,46	0,07	**0,22**	0,42	442–X4
GD–X5	0,17	**0,58**	1,06	0,12	**0,41**	0,75	0,09	**0,31**	0,56	0,08	**0,27**	0,48	0,07	**0,25**	0,44	GD–X5
GD–X8	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	GD–X8
T–X4	0,29	**0,73**	1,18	0,21	**0,52**	0,84	0,15	**0,39**	0,62	0,13	**0,34**	0,54	0,12	**0,31**	0,49	T–X4

At 1,50 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
701–X4	0,17	**0,24**	0,33	0,13	**0,18**	0,24	0,09	**0,13**	0,18	0,08	**0,12**	0,16	0,08	**0,11**	0,14	701–X4
432–X5	0,21	**0,64**	1,23	0,15	**0,46**	0,87	0,11	**0,34**	0,65	0,10	**0,30**	0,56	0,09	**0,27**	0,51	432–X5
432–X8	0,21	**0,64**	1,23	0,15	**0,46**	0,87	0,11	**0,34**	0,65	0,10	**0,30**	0,56	0,09	**0,27**	0,51	432–X8
442–X5	0,21	**0,64**	1,23	0,15	**0,46**	0,87	0,11	**0,34**	0,65	0,10	**0,30**	0,56	0,09	**0,27**	0,51	442–X5
442–X8	0,21	**0,64**	1,23	0,15	**0,46**	0,87	0,11	**0,34**	0,65	0,10	**0,30**	0,56	0,09	**0,27**	0,51	442–X8
442–X4	0,21	**0,64**	1,23	0,15	**0,46**	0,87	0,11	**0,34**	0,65	0,10	**0,30**	0,56	0,09	**0,27**	0,51	442–X4
GD–X5	0,21	**0,71**	1,31	0,15	**0,51**	0,93	0,11	**0,38**	0,68	0,10	**0,33**	0,60	0,09	**0,30**	0,54	GD–X5
GD–X8	0,21	**0,71**	1,31	0,15	**0,51**	0,93	0,11	**0,38**	0,68	0,10	**0,33**	0,60	0,09	**0,30**	0,54	GD–X8
T–X4	0,35	**0,90**	1,47	0,25	**0,64**	1,03	0,19	**0,47**	0,76	0,17	**0,41**	0,66	0,15	**0,38**	0,60	T–X4

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

7713VR Technical Information



Working Diameter:

Formula to evaluate the correct working diameter based on axial depth of cut (ap).

$$D_w = D_2 + 2 \times \sqrt{r^2 - (r - a_p)^2}$$

where:

D_w = Working diameter
D_2 = Diameter of cutter insert centre to centre
r = Insert radius
a_p = Axial depth of cut

where:

f_z = Feed per tooth
h_m = Average chip thickness
r = Insert radius
a_e = Radial depth of cut
a_p = Axial depth of cut

Formula to find programmed feed rate based on radial engagement and axial depth of cut.

$$f_z = \frac{h_m}{\frac{\sqrt{r^2-(r-a_e)^2}}{r} \times \frac{\sqrt{r^2-(r-a_p)^2}}{r}}$$

Formula to calculate the average chip thickness hm in relation with radial engagement and depth of cut.

$$h_m = f_z \times \frac{\sqrt{r^2-(r-a_e)^2}}{r} \times \frac{\sqrt{r^2-(r-a_p)^2}}{r}$$

Simplified formulas to evaluate h_m and f_z based on radial engagement or depth of cut.

Calculation of the average chip thickness in relation with the D.O.C. (Axial)

Formula: Programme Feed Rate (f_z)

$$f_z = h_m \times \sqrt{\frac{d}{a_p}}$$

h_m = Average chip thickness
a_p = Depth of cut
f_z = Feed per tooth
d = Insert diameter

Formula: Average Chip Thickness (h_m)

$$h_m = f_z \times \sqrt{\frac{a_e}{d}}$$

Calculation of the average chip thickness in relation with the a_e (Radial Engagement) if a_e is less than 50% of diameter

Formula: Programme Feed Rate (f_z)

$$f_z = h_m \times \sqrt{\frac{d}{a_e}}$$

h_m = Average chip thickness
a_e = Radial engagement
f_z = Feed per tooth
d = Cutter diameter

Formula: Average Chip Thickness (h_m)

$$h_m = f_z \times \sqrt{\frac{d}{a_p}}$$

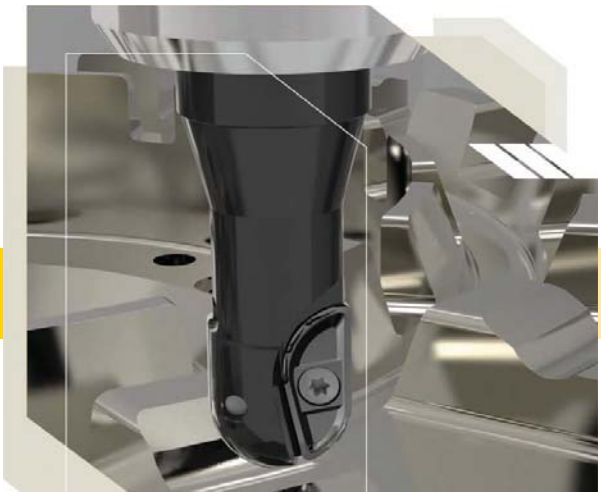
5505VX Series



Copy/3D



Contour Milling

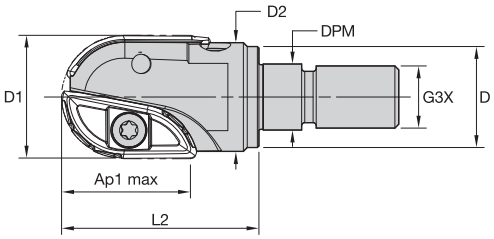


Ball Nose Contour Milling Cutter

- The 5505VX ball nose cutters have a reinforced design feature, which delivers a high volume of chip removal.
- The chipbreaker geometry provides excellent chip control and evacuation during machining and prevents edge build-up.
- 5505VX roughing ball nose cutters are ideal for roughing and semi-finishing profiles and complex contours.
- One grade and one geometry are qualified to machine steel, alloyed steel, stainless steel, high-temperature alloys, and cast iron.

- Rough to semi-finish profiling and contour milling.
- Helical insert design for increased speeds and feeds.
- One insert geometry covers most materials for optimised inventory.







Screw-On End Mills

order number	catalogue number	D1	D	D2	L2	G3X	DPM	Ap1 max	Z
5673711	**5505VX16SA016R25**	16	13	15	25	M8	8,50	16,6	2
5672843	**5505VX20SA020R35**	20	18	19	35	M10	10,50	20,0	2
5673115	**5505VX25SA025R40**	25	21	23	40	M12	12,50	25,2	2
5673632	**5505VX32SA032R50**	32	29	29	50	M16	17,00	32,4	2

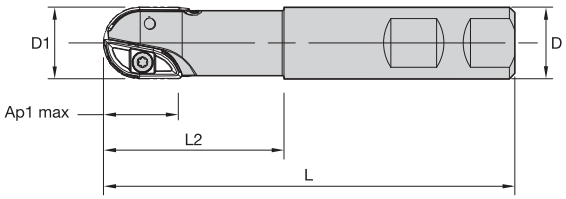
NOTE: **Products available by April 1st, 2018.**

Spare Parts

D1	 insert screw	 Nm	 Torx Plus driver	 Torx driver
16	**FP3006T**	1,8	**TP8**	**–**
20	**FP3007T**	1,4	**TP8**	**–**
25	**D4010T**	3,1	**–**	**T15**
32	**D5013T**	6,1	**–**	**T20**

- Rough to semi-finish profiling and contour milling.
- Helical insert design for increased speeds and feeds.
- One insert geometry covers most materials for optimised inventory.





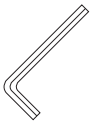


Weldon® End Mills

order number	catalogue number	D1	D	L	L2	Ap1 max	Z
5673112	**5505VX25WA025R60**	25	25	116	60	25,2	2
5673329	**5505VX32WA032R75**	32	32	135	75	32,7	2
5672842	**5505VX32WA032R100**	32	32	160	100	32,4	2
5673113	**5505VX40WA040R100**	40	40	170	100	40,1	2
5673521	**5505VX40WA040R150**	40	40	220	150	40,1	2
5673114	**5505VX50WA050R100**	50	40	170	100	51,0	2
5673297	**5505VX50WA050R150**	50	50	230	150	51,0	2

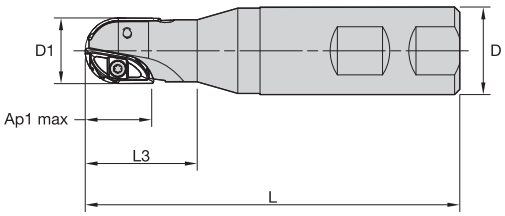
NOTE: **Products available by April 1st, 2018.**

Spare Parts

D1	 insert screw	 Nm	 Torx driver	 wrench
25	**D4010T**	3,1	**T15**	**–**
32	**D5013T**	6,0	**T20**	**–**
40	**D6014T**	10,5	**T20**	**–**
50	**F8017S**	24,5	**–**	**KH5005**

- Rough to semi-finish profiling and contour milling.
- Helical insert design for increased speeds and feeds.
- One insert geometry covers most materials for optimised inventory.







Weldon® End Mills Flat

order number	catalogue number	D1	D	L	L3	Ap1 max	Z
5673750	**5505VX20WA020R34**	20	25	106	34	20,3	2
5673749	**5505VX25WA025R69**	25	32	150	69	25,0	2

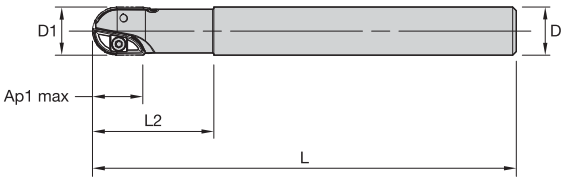
NOTE: **Products available by April 1st, 2018.**

Spare Parts

D1	 insert screw	 Nm	 Torx Plus driver	 Torx driver
20	**FP3007T**	1,8	**TP8**	**–**
25	**D4010T**	3,1	**–**	**T15**

- Rough to semi-finish profiling and contour milling.
- Helical insert design for increased speeds and feeds.
- One insert geometry covers most materials for optimised inventory.







Cylindrical End Mills

order number	catalogue number	D1	D	L	L2	Ap1 max	Z
5673712	**5505VX16CA20/016R30**	16	20	180	40	16,6	2
5672627	**5505VX20CA25/020R40**	20	25	200	50	20,3	2
5673610	**5505VX25CA025R55**	25	25	250	65	25,2	2
5673785	**5505VX25CA32/025R55**	25	32	250	65	25,2	2
5673141	**5505VX32CA032R65**	32	32	250	75	32,4	2

NOTE: **Products available by April 1st, 2018.**

Spare Parts

D1	 insert screw	 Nm	 Torx Plus driver	 Torx driver
16	**FP3006T**	1,8	**TP8**	**–**
20	**FP3007T**	1,8	**TP8**	**–**
25	**D4010T**	3,1	**–**	**T15**
32	**D5013T**	6,0	**–**	**T20**

Technical Information

Technical Information (mm)

order number	catalogue number	dimension: facing pitch	dimension: ramping angle	dimension: helical hole min	dimension: helical hole max	dimension: ap max helical/linear	max RPM
5673750	**5505VX20WA020R34**	–	85	–	–	–	34750
5673112	**5505VX25WA025R60**	–	85	–	–	–	30500
5673749	**5505VX25WA025R69**	–	85	–	–	–	30500
5673329	**5505VX32WA032R75**	–	85	–	–	–	23250
5672842	**5505VX32WA032R100**	–	85	–	–	–	23250
5673113	**5505VX40WA040R100**	–	85	–	–	–	17250
5673521	**5505VX40WA040R150**	–	85	–	–	–	17250
5673114	**5505VX50WA050R100**	–	85	–	–	–	17250
5673297	**5505VX50WA050R150**	–	85	–	–	–	17250
5673712	**5505VX16CA20/016R30**	–	85	–	–	–	54000
5672627	**5505VX20CA25/020R40**	–	85	–	–	–	34750
5673610	**5505VX25CA025R55**	–	85	–	–	–	30500
5673785	**5505VX25CA32/025R55**	–	85	–	–	–	30500
5673141	**5505VX32CA032R65**	–	85	–	–	–	23250
5673711	**5505VX16SA016R25**	–	85	–	–	–	54000
5672843	**5505VX20SA020R35**	–	85	–	–	–	34750
5673115	**5505VX25SA025R40**	–	85	–	–	–	30500
5673632	**5505VX32SA032R50**	–	85	–	–	–	23250



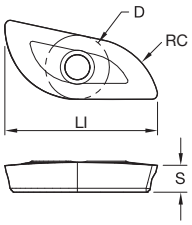
Ramping

Copy Milling

Insert Selection Guide

Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		◄——►		toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	R-F	SP6519	**R-F**	**SP6519**	R-F	SP6519
P3–P4	R-F	SP6519	**R-F**	**SP6519**	R-F	SP6519
P5–P6	R-F	SP6519	**R-F**	**SP6519**	R-F	SP6519
M1–M2	R-F	SP6519	**R-F**	**SP6519**	R-F	SP6519
M3	R-F	SP6519	**R-F**	**SP6519**	R-F	SP6519
K1–K2	R-F	SP6519	**R-F**	**SP6519**	R-F	SP6519
K3	R-F	SP6519	**R-F**	**SP6519**	R-F	SP6519
N1–N2	–	–	**–**	**–**	–	–
N3	–	–	**–**	**–**	–	–
S1–S2	R-F	SP6519	**R-F**	**SP6519**	R-F	SP6519
S3	R-F	SP6519	**R-F**	**SP6519**	R-F	SP6519
S4	R-F	SP6519	**R-F**	**SP6519**	R-F	SP6519
H1	R-F	SP6519	**R-F**	**SP6519**	R-F	SP6519


XPNT-F



● first choice
○ alternate choice

P	○
M	●
K	○
N	
S	●
H	

XPNT-F

catalogue number	D	LI	S	RC	hm	SP6519
XPNT16160308RF	7,39	17,40	3,18	7,93	0,04	●
XPNT2020T306RF	9,00	20,85	3,97	10,00	0,04	●
XPNT25250408RF	11,00	25,98	4,75	12,70	0,04	●
XPNT32320612RF	14,10	33,40	6,33	15,88	0,04	●
XPNT4040T716RF	18,00	41,84	7,95	20,00	0,04	●
XPNT5050T716RF	22,23	52,86	8,53	25,40	0,04	●

Very Important



Please do not remove this screw. The screw is glued into the body to keep the inserts in the correct position.

Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining

At 8,00 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
R-F	0,09	**0,20**	0,34	0,07	**0,15**	0,25	0,05	**0,11**	0,19	0,04	**0,10**	0,16	0,04	**0,09**	0,15	R-F

At 4,00 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
R-F	0,11	**0,23**	0,39	0,08	**0,17**	0,29	0,06	**0,13**	0,21	0,05	**0,11**	0,19	0,05	**0,10**	0,17	R-F

At 2,00 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
R-F	0,14	**0,31**	0,52	0,10	**0,22**	0,37	0,08	**0,17**	0,28	0,07	**0,15**	0,24	0,06	**0,13**	0,22	R-F

At 1,00 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
R-F	0,19	**0,42**	0,71	0,14	**0,30**	0,51	0,10	**0,23**	0,38	0,09	**0,20**	0,33	0,08	**0,18**	0,31	R-F

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

5505VX • 20mm • Recommended Starting Feeds

Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining

At 10,00 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
R-F	0,09	**0,26**	0,39	0,07	**0,19**	0,28	0,05	**0,14**	0,21	0,04	**0,12**	0,18	0,04	**0,11**	0,17	R-F

At 5,00 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
R-F	0,11	**0,30**	0,45	0,08	**0,22**	0,32	0,06	**0,16**	0,24	0,05	**0,14**	0,21	0,05	**0,13**	0,19	R-F

At 2,50 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
R-F	0,14	**0,39**	0,59	0,10	**0,28**	0,43	0,08	**0,21**	0,32	0,07	**0,18**	0,28	0,06	**0,17**	0,25	R-F

At 1,25 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
R-F	0,19	**0,54**	0,81	0,14	**0,39**	0,58	0,10	**0,29**	0,43	0,09	**0,25**	0,38	0,08	**0,23**	0,35	R-F

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining

At 12,50 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
R-F	0,09	**0,29**	0,46	0,07	**0,21**	0,33	0,05	**0,16**	0,25	0,04	**0,14**	0,22	0,04	**0,12**	0,20	R-F

At 6,00 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
R-F	0,11	**0,34**	0,54	0,08	**0,24**	0,39	0,06	**0,18**	0,29	0,05	**0,16**	0,26	0,05	**0,15**	0,23	R-F

At 3,00 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
R-F	0,14	**0,44**	0,72	0,10	**0,32**	0,52	0,08	**0,24**	0,39	0,07	**0,21**	0,34	0,06	**0,19**	0,31	R-F

At 1,50 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
R-F	0,19	**0,61**	0,98	0,14	**0,44**	0,71	0,11	**0,33**	0,53	0,09	**0,28**	0,46	0,08	**0,26**	0,42	R-F

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

5505VX • 32mm • Recommended Starting Feeds

Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining

At 16,00 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
R-F	0,09	**0,29**	0,46	0,07	**0,21**	0,33	0,05	**0,16**	0,25	0,04	**0,14**	0,22	0,04	**0,12**	0,20	R-F

At 8,00 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
R-F	0,11	**0,33**	0,54	0,08	**0,24**	0,39	0,06	**0,18**	0,29	0,05	**0,16**	0,25	0,05	**0,14**	0,23	R-F

At 4,00 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
R-F	0,14	**0,43**	0,70	0,10	**0,31**	0,51	0,08	**0,23**	0,38	0,07	**0,20**	0,33	0,06	**0,19**	0,30	R-F

At 2,00 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
R-F	0,19	**0,59**	0,96	0,14	**0,43**	0,69	0,10	**0,32**	0,52	0,09	**0,28**	0,45	0,08	**0,26**	0,41	R-F

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining

At 20,00 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
R-F	0,09	**0,31**	0,56	0,07	**0,23**	0,40	0,05	**0,17**	0,30	0,04	**0,15**	0,26	0,04	**0,14**	0,24	R-F

At 10,00 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
R-F	0,11	**0,36**	0,64	0,08	**0,26**	0,46	0,06	**0,20**	0,35	0,05	**0,17**	0,30	0,05	**0,16**	0,28	R-F

At 5,00 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
R-F	0,14	**0,48**	0,85	0,10	**0,34**	0,61	0,08	**0,26**	0,45	0,07	**0,22**	0,40	0,06	**0,21**	0,36	R-F

At 2,50 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
R-F	0,19	**0,65**	1,16	0,14	**0,47**	0,83	0,10	**0,35**	0,62	0,09	**0,31**	0,54	0,08	**0,28**	0,50	R-F

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

5505VX • 50mm • Recommended Starting Feeds

Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining

At 25,00 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
R-F	0,09	**0,37**	0,63	0,07	**0,27**	0,46	0,05	**0,20**	0,34	0,04	**0,17**	0,30	0,04	**0,16**	0,27	R-F

At 12,50 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
R-F	0,11	**0,43**	0,73	0,08	**0,31**	0,53	0,06	**0,23**	0,39	0,05	**0,20**	0,34	0,05	**0,18**	0,31	R-F

At 6,25 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
R-F	0,14	**0,56**	0,96	0,10	**0,40**	0,69	0,08	**0,30**	0,52	0,07	**0,26**	0,45	0,06	**0,24**	0,41	R-F

At 3,00 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
R-F	0,19	**0,78**	1,35	0,14	**0,56**	0,96	0,11	**0,42**	0,72	0,09	**0,37**	0,63	0,08	**0,34**	0,57	R-F

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

Service and Support

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Poland	Polish	0080 04411887	eu.techsupport@kennametal.com
Russia (landline)	Russian	8800 5556394	eu.techsupport@kennametal.com
Russia (cell phone)	Russian	+7 8005556394	eu.techsupport@kennametal.com
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KDMB™ • KDMT™

Indexable Copy Insert Platform

Primary Application

Ball nose and toroidal styles for roughing and finishing operations. Engineered with the ultimate technologies and supported with a wide range of diameters and insert styles to provide exceptional performance and productivity. The new high-feed insert style provides the highest metal removal rates for roughing applications.



Features and Benefits

Longer Tool Life and Improved Geometries

- Longer tool life for finishing operations, up to 63 HRC.
- High-accuracy inserts and holders: overall runout ± 0,01mm.
- Improved geometries for roughing and finishing operations.
- Smaller diameters from 6mm to replace SCEM, setting a more productive machining process.

Superior Productivity

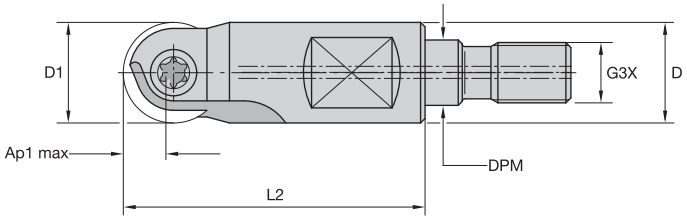
- Achieve better surface quality with the new helical geometry.
- New ultra-grain grade for outstanding tool life.
- Diameters 6mm and 8mm are a natural replacement for SEM tools.
- Better cost per edge.

Usability and Flexibility

- Wide diameter range, from 6–32mm, use in a wide range of machining conditions.
- Many workpiece materials are possible — from hardened steel to aluminium.
- Large holder style offering: screw-on, cylindrical, and tapered steel and carbide holders.

- Available diameters: 12–25mm.
- High precision and runout accuracy.
- Suitable for roughing and finishing operations.







Screw-On End Mills

order number	catalogue number	D1	D	DPM	G3X	L2	Ap1 max	Z	Z U	max ramp angle	max RPM	insert 1
1918651	**KDMB12R026M08SN**	12	13	8,5	M8	26	6,0	1	2	3.0°	40000	KDMB12..
1918652	**KDMB16R026M08SN**	16	13	8,5	M8	26	8,0	1	2	3.0°	40000	KDMB16..
1918663	**KDMB20R030M10SN**	20	18	10,5	M10	30	10,0	1	2	3.0°	40000	KDMB20..
1918664	**KDMB25R040M12SN**	25	21	12,5	M12	40	12,5	1	2	3.0°	30000	KDMB25..

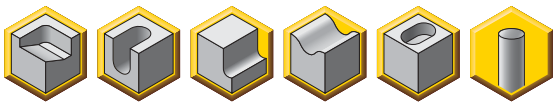
Spare Parts

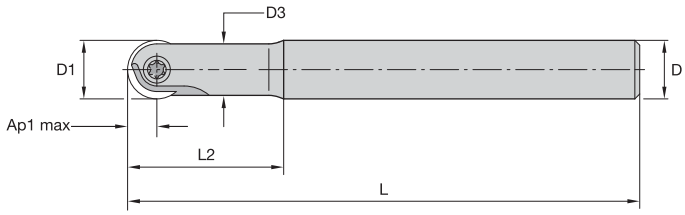




D1	insert screw	Nm	Torx wrench
12	**193.393**	4,0	**KT20**
16	**193.392**	5,0	**KT20**
20	**193.391**	6,0	**KT20**
25	**193.390**	6,5	**KT30**

- Cutting diameter ranges from 12–32mm.
- Ball nose finishers for 3D milling applications.
- Suitable for roughing and finishing operations.
- High precision and runout accuracy.
- Can be used with heat shrink technology, h6 shank tolerance.







Necked End Mills • Cylindrical Shank • Steel

order number	catalogue number	D1	D	D3	L	L2	Ap1 max	Z	Z U	coolant supply	max ramp angle	max RPM	insert 1
1918676	**KDMB12R130A12SN**	12	12	11	130	32	6,0	1	2	No	3.0°	40000	KDMB12..
1918677	**KDMB12R150A12SN**	12	12	11	150	46	6,0	1	2	No	3.0°	40000	KDMB12..
1918678	**KDMB16R140A16SN**	16	16	14	140	35	8,0	1	2	No	3.0°	40000	KDMB16..
1918679	**KDMB16R160A16SN**	16	16	14	160	53	8,0	1	2	No	3.0°	40000	KDMB16..
1918680	**KDMB20R160A20SN**	20	20	18	160	45	10,0	1	2	No	3.0°	40000	KDMB20..
1918681	**KDMB20R175A20SN**	20	20	18	175	61	10,0	1	2	No	3.0°	40000	KDMB20..
1918682	**KDMB25R160A25SN**	25	25	22	160	45	12,5	1	2	No	3.0°	40000	KDMB25..
1918683	**KDMB25R190A25SN**	25	25	22	190	70	12,5	1	2	No	3.0°	40000	KDMB25..
1918684	**KDMB32R175A32SN**	32	32	29	175	56	16,0	1	2	No	3.0°	40000	KDMB32..
1918685	**KDMB32R210A32SN**	32	32	29	210	80	16,0	1	2	No	3.0°	40000	KDMB32..

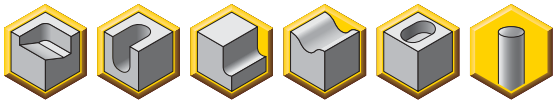
Spare Parts

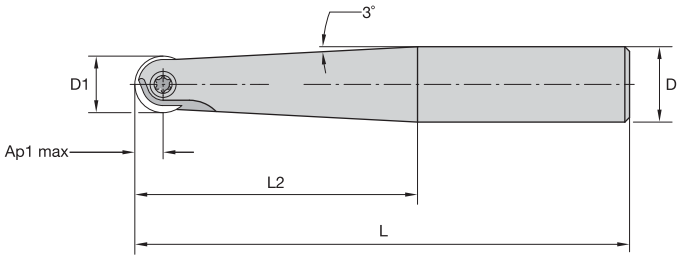




D1	insert screw	Nm	Torx wrench
12	**193.393**	4,0	**KT20**
16	**193.392**	5,0	**KT20**
20	**193.391**	6,0	**KT20**
25	**193.390**	6,5	**KT30**
32	**193.389**	6,5	**KT30**

- Available diameters: 8–25mm.
- Ball nose finishers for 3D milling applications.
- Suitable for roughing and finishing operations.
- Tapered version ideal for 5-axis applications.
- High precision and runout accuracy.
- Can be used with heat shrink technology, h6 shank tolerance.







Tapered End Mills • Cylindrical Shank • Steel

order number	catalogue number	D1	D	L	L2	Ap1 max	Z	Z U	coolant supply	max ramp angle	max RPM	insert 1
1918669	**KDMB08R140A08ST**	8	12	140	50	4,0	1	2	No	3.0°	40000	KDMB08..
1918670	**KDMB10R150A10ST**	10	12	150	34	5,0	1	2	No	3.0°	40000	KDMB10..
1918671	**KDMB12R160A12ST**	12	16	160	60	6,0	1	2	No	3.0°	40000	KDMB12..
1918672	**KDMB16R175A16ST**	16	20	175	67	8,0	1	2	No	3.0°	40000	KDMB16..
1918673	**KDMB20R190A20ST**	20	25	190	80	10,0	1	2	No	3.0°	40000	KDMB20..
1918674	**KDMB25R210A25ST**	25	32	210	100	12,5	1	2	No	3.0°	40000	KDMB25..

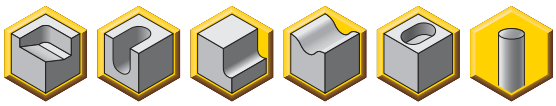
Spare Parts

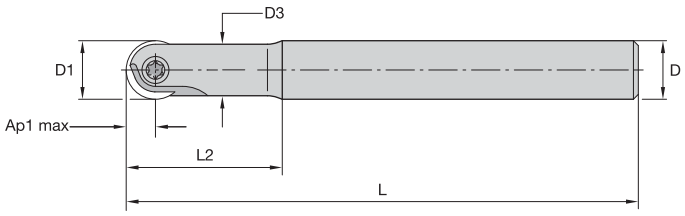




D1	insert screw	Nm	Torx wrench
8	**193.395**	2,0	**KT8**
10	**193.394**	3,0	**KT15**
12	**193.393**	4,0	**KT20**
16	**193.392**	5,0	**KT20**
20	**193.391**	6,0	**KT20**
25	**193.390**	6,5	**KT30**

- Available diameters: 6–32mm.
- Ball nose finishers for 3D milling applications.
- Suitable for roughing and finishing operations.
- High precision and runout accuracy.
- Can be used with heat shrink technology, h6 shank tolerance.







Necked End Mills • Cylindrical Shank • Carbide

order number	catalogue number	D1	D	D3	L2	L	Ap1 max	Z	Z U	coolant supply	max ramp angle	max RPM	insert 1
3700622	KDMB06R100A06HN	6	6	6	20	100	3,0	1	2	No	3.0°	40000	KDM.06..
3964191	KDMB06R150A06HN	6	6	6	70	150	3,0	1	2	No	3.0°	40000	KDM.06..
3964192	KDMB06R200A06HN	6	6	6	100	200	3,0	1	2	No	3.0°	40000	KDM.06..
1918704	KDMB08R100A08HN	8	8	7	25	100	4,0	1	2	No	3.0°	40000	KDM.08..
1918705	KDMB08R150A08HN	8	8	7	40	150	4,0	1	2	No	3.0°	40000	KDM.08..
2877242	KDMB10R120A10HNC	10	10	9	34	120	5,0	1	2	Yes	3.0°	40000	KDMB10..
2877373	KDMB10R150A10HNC	10	10	9	49	150	5,0	1	2	Yes	3.0°	40000	KDMB10..
2877374	KDMB12R120A12HNC	12	12	11	35	120	6,0	1	2	Yes	3.0°	40000	KDMB12..
2877375	KDMB12R160A12HNC	12	12	11	50	160	6,0	1	2	Yes	3.0°	40000	KDMB12..
2877376	KDMB16R140A16HNC	16	16	14	40	140	8,0	1	2	Yes	3.0°	40000	KDMB16..
2877377	KDMB16R175A16HNC	16	16	14	55	175	8,0	1	2	Yes	3.0°	40000	KDMB16..
2877378	KDMB20R140A20HNC	20	20	18	50	140	10,0	1	2	Yes	3.0°	40000	KDMB20..
2877379	KDMB20R190A20HNC	20	20	18	75	190	10,0	1	2	Yes	3.0°	40000	KDMB20..
2877380	KDMB25R160A25HNC	25	25	22	60	160	12,5	1	2	Yes	3.0°	30000	KDMB25..
2877381	KDMB25R210A25HNC	25	25	22	90	210	12,5	1	2	Yes	3.0°	30000	KDMB25..
2877383	KDMB32R240A32HNC	32	32	29	105	240	16,0	1	2	Yes	3.0°	30000	KDMB32..

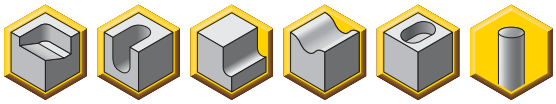
Spare Parts

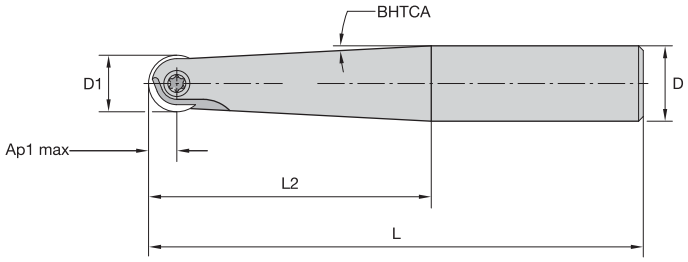




D1	insert screw	Nm	Torx wrench
6	MS2236	1,7	KT6
8	193.395	2,0	KT8
10	193.394	3,0	KT15
12	193.393	4,0	KT20
16	193.392	5,0	KT20
20	193.391	6,0	KT20
25	193.390	6,5	KT30
32	193.389	6,5	KT30

- Available diameters: 6–16mm.
- High precision and runout accuracy.
- Can be used with heat shrink technology, h6 shank tolerance.
- Suitable for roughing and finishing operations.
- Tapered version ideal for 5-axis applications.







Tapered End Mills • Cylindrical Shank • Carbide

order number	catalogue number	D1	D	BHTCA	L2	L	Ap1 max	Z	Z U	coolant supply	max ramp angle	max RPM	insert 1
3964257	KDMB06R90A08HN	6	8	1.8°	40	90	3,0	1	2	No	3.0°	40000	KDM.06..
3964258	KDMB08R100A10HN	8	10	1.3°	60	100	4,0	1	2	No	3.0°	40000	KDM.08..
3964259	KDMB08R150A10HN	8	10	1.0°	90	150	4,0	1	2	No	3.0°	40000	KDM.08..
3964260	KDMB10R100A12HNC	10	12	1.3°	60	100	5,0	1	2	Yes	3.0°	40000	KDMB10..
3964261	KDMB10R150A12HNC	10	12	1.0°	90	150	5,0	1	2	Yes	3.0°	40000	KDMB10..
3964262	KDMB12R120A16HNC	12	16	2.0°	70	120	6,0	1	2	Yes	3.0°	40000	KDMB12..
3964263	KDMB12R150A16HNC	12	16	1.5°	90	150	6,0	1	2	Yes	3.0°	40000	KDMB12..
3964264	KDMB16R140A20HNC	16	20	2.0°	70	140	8,0	1	2	Yes	3.0°	40000	KDMB16..
3964265	KDMB16R175A20HNC	16	20	1.5°	90	175	8,0	1	2	Yes	3.0°	40000	KDMB16..

Spare Parts

D1	insert screw	Nm	Torx wrench
6	MS2236	1,0	KT6
8	193.395	1,7	KT8
10	193.394	3,0	KT15
12	193.393	4,0	KT20
16	193.392	5,0	KT20

Insert Selection Guide

KDMB Ball Nose Platform • 6mm

Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance ⟷ toughness					
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.E..GP	KC515M	.E..GP	KC515M	–	–
P3–P4	.E..GP	KC505M	.E..GP	KC515M	–	–
P5–P6	.E..GP	KC505M	.E..GP	KC515M	–	–
M1–M2	.E..GP	KC515M	–	–	–	–
M3	.E..GP	KC515M	–	–	–	–
K1–K2	.E..GP	KC515M	.E..GP	KC515M	–	–
K3	.E..GP	KC515M	.E..GP	KC515M	–	–
N1–N2	.E..LD	K115M	.E..LD	K115M	–	–
N3	.E..LD	K115M	.E..LD	K115M	–	–
S1–S2	–	–	–	–	–	–
S3	–	–	–	–	–	–
S4	.E..LD	K115M	.E..GP	KC515M	–	–
H1	.E..GP	KC505M	.E..GP	KC505M	.E..GN	KC505M

KDMB Ball Nose Platform • 8mm

Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance ⟷ toughness					
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.E..GP	KC515M	.E..GP	KC515M	.E..GN	KC530M
P3–P4	.E..GP	KC505M	.E..GP	KC515M	.E..GN	KC515M
P5–P6	.E..GP	KC505M	.E..GP	KC515M	.E..GN	KC530M
M1–M2	.E..GP	KC515M	.E..GN	KC530M	–	–
M3	.E..GP	KC515M	.E..GN	KC530M	–	–
K1–K2	.E..GP	KC515M	.E..GN	KC515M	.E..GN	KC515M
K3	.E..GP	KC515M	.E..GN	KC515M	.E..GN	KC515M
N1–N2	.E..LD	K115M	.E..LD	K115M	–	–
N3	.E..LD	K115M	.E..LD	K115M	–	–
S1–S2	–	–	–	–	–	–
S3	–	–	–	–	–	–
S4	.E..LD	K115M	.E..GP	KC515M	–	–
H1	.E..GP	KC505M	.E..GP	KC505M	.E..GN	KC505M

KDMB Ball Nose Platform • 10mm

Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance ⟷ toughness					
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.E..GP	KC515M	.E..GP	KC515M	.E..GN	KC515M
P3–P4	.E..GP	KC505M	.E..GP	KC515M	.E..GN	KC515M
P5–P6	.E..GP	KC505M	.E..GP	KC515M	.E..GN	KC530M
M1–M2	.E..GP	KC515M	.E..GN	KC530M	.E..GN	KC530M
M3	.E..GP	KC515M	.E..GN	KC530M	.E..GN	KC530M
K1–K2	.E..GP	KC515M	.E..GN	KC515M	.E..GN	KC515M
K3	.E..GP	KC515M	.E..GN	KC515M	.E..GN	KC515M
N1–N2	.E..LD	K115M	.E..LD	K115M	–	–
N3	.E..LD	K115M	.E..LD	K115M	–	–
S1–S2	–	–	–	–	–	–
S3	–	–	–	–	–	–
S4	.E..LD	K115M	.E..GP	KC515M	–	–
H1	.E..GP	KC505M	.E..GP	KC505M	.E..GN	KC505M

KDMB Ball Nose Platform • 12mm

Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance ⟷ toughness					
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.E..GP	KC515M	.E..GP	KC515M	.E..HC	KC530M
P3–P4	.E..GP	KC505M	.E..GP	KC515M	.E..HC	KC530M
P5–P6	.E..GP	KC505M	.E..GP	KC515M	.E..HC	KC530M
M1–M2	.E..GP	KC515M	.E..HC	KC530M	.E..HC	KC530M
M3	.E..GP	KC515M	.E..HC	KC530M	.E..HC	KC530M
K1–K2	.E..GP	KC515M	.E..GN	KC515M	.E..GN	KC515M
K3	.E..GP	KC515M	.E..GN	KC515M	.E..GN	KC515M
N1–N2	.E..LD	K115M	.E..LD	K115M	–	–
N3	.E..LD	K115M	.E..LD	K115M	–	–
S1–S2	–	–	–	–	–	–
S3	–	–	–	–	–	–
S4	.E..LD	K115M	.E..GP	KC515M	.E..HC	KC530M
H1	.E..GP	KC505M	.E..GP	KC505M	.E..GN	KC505M

KDMB Ball Nose Platform • 16mm

Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance ⟷ toughness					
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.E..GP	KC515M	.E..GP	KC515M	.E..HC	KC530M
P3–P4	.E..GP	KC505M	.E..GP	KC515M	.E..HC	KC530M
P5–P6	.E..GP	KC505M	.E..GP	KC515M	.E..HC	KC530M
M1–M2	.E..GP	KC515M	.E..HC	KC530M	.E..HC	KC530M
M3	.E..GP	KC515M	.E..HC	KC530M	.E..HC	KC530M
K1–K2	.E..GP	KC515M	.E..GN	KC515M	.E..GN	KC515M
K3	.E..GP	KC515M	.E..GN	KC515M	.E..GN	KC515M
N1–N2	.E..LD	K115M	.E..LD	K115M	–	–
N3	.E..LD	K115M	.E..LD	K115M	–	–
S1–S2	–	–	–	–	–	–
S3	–	–	–	–	–	–
S4	.E..LD	K115M	.E..GP	KC515M	.E..HC	KC530M
H1	.E..GP	KC505M	.E..GP	KC505M	.E..GN	KC505M

KDMB Ball Nose Platform • 20mm

Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance ⟷ toughness					
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.E..GP	KC515M	.E..GP	KC515M	.E..HC	KC530M
P3–P4	.E..GP	KC505M	.E..GP	KC515M	.E..HC	KC530M
P5–P6	.E..GP	KC505M	.E..GP	KC515M	.E..HC	KC530M
M1–M2	.E..GP	KC515M	.E..HC	KC530M	.E..HC	KC530M
M3	.E..GP	KC515M	.E..HC	KC530M	.E..HC	KC530M
K1–K2	.E..GP	KC515M	.E..GN	KC515M	.E..GN	KC515M
K3	.E..GP	KC515M	.E..GN	KC515M	.E..GN	KC515M
N1–N2	.E..LD	K115M	.E..LD	K115M	–	–
N3	.E..LD	K115M	.E..LD	K115M	–	–
S1–S2	–	–	–	–	–	–
S3	–	–	–	–	–	–
S4	.E..LD	K115M	.E..GP	KC515M	.E..HC	KC530M
H1	.E..GP	KC505M	.E..GP	KC505M	.E..GN	KC505M

KDMB Ball Nose Platform • 25mm

Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance ⟷				toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.E..GP	KC515M	**.E..GP**	**KC515M**	.E..HC	KC530M
P3–P4	.E..GP	KC505M	**.E..GP**	**KC515M**	.E..HC	KC530M
P5–P6	.E..GP	KC505M	**.E..GP**	**KC515M**	.E..HC	KC530M
M1–M2	.E..GP	KC515M	**.E..HC**	**KC530M**	.E..HC	KC530M
M3	.E..GP	KC515M	**.E..HC**	**KC530M**	.E..HC	KC530M
K1–K2	.E..GP	KC515M	**.E..GN**	**KC515M**	.E..GN	KC515M
K3	.E..GP	KC515M	**.E..GN**	**KC515M**	.E..GN	KC515M
N1–N2	.E..LD	K115M	**.E..LD**	**K115M**	–	–
N3	.E..LD	K115M	**.E..LD**	**K115M**	–	–
S1–S2	–	–	**–**	**–**	–	–
S3	–	–	**–**	**–**	–	–
S4	.E..LD	K115M	**.E..GP**	**KC515M**	.E..HC	KC530M
H1	.E..GP	KC505M	**.E..GP**	**KC505M**	.E..GN	KC505M

KDMB Ball Nose Platform • 32mm

Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance ⟷				toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.E..GP	KC515M	**.E..GP**	**KC515M**	.E..HC	KC530M
P3–P4	.E..GP	KC505M	**.E..GP**	**KC515M**	.E..HC	KC530M
P5–P6	.E..GP	KC505M	**.E..GP**	**KC515M**	.E..HC	KC530M
M1–M2	.E..GP	KC515M	**.E..HC**	**KC530M**	.E..HC	KC530M
M3	.E..GP	KC515M	**.E..HC**	**KC530M**	.E..HC	KC530M
K1–K2	.E..GP	KC515M	**.E..GN**	**KC515M**	.E..GN	KC515M
K3	.E..GP	KC515M	**.E..GN**	**KC515M**	.E..GN	KC515M
N1–N2	.E..LD	K115M	**.E..LD**	**K115M**	–	–
N3	.E..LD	K115M	**.E..LD**	**K115M**	–	–
S1–S2	–	–	**–**	**–**	–	–
S3	–	–	**–**	**–**	–	–
S4	.E..LD	K115M	**.E..GP**	**KC515M**	.E..HC	KC530M
H1	.E..GP	KC505M	**.E..GP**	**KC505M**	.E..GN	KC505M

Insert Style

HC Geometry:

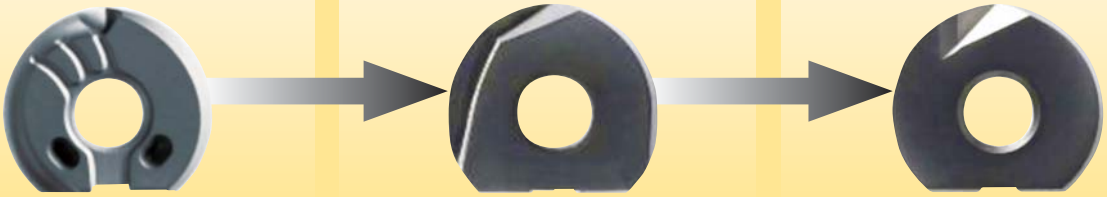
PSTS geometry with chipbreaker for roughing. Semi-finishing and rest material of steel, cast steel, and high-temperature alloys.

GP Geometry:

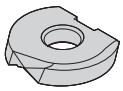
High-precision insert with helical geometry for semi-finishing and finishing of steel up to 63 HRC, cast steel, and high-temperature alloys.

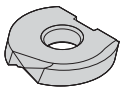
GN Geometry:

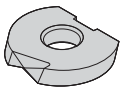
Geometry with extremely solid cutting edge for roughing cast steel, high-temperature alloys, and hardened steel up to 60 HRC.

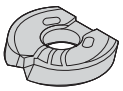


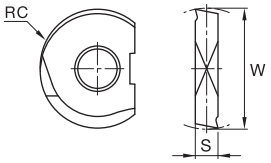
roughing, rest material | semi-finishing, finishing | finishing


KDMB-LD


KDMB-GP


KDMB-GN


KDMB-HC



KDMB-LD

● first choice
○ alternate choice

P			●	●	●
M			○	○	●
K			○	●	○
N		●			
S					○
H			●	○	○

KDMB-LD • High-Precision Positive Geometry • Non-Ferrous and Titanium

catalogue number	S	W	RC	hm	K115M	KC505M	KC515M	KC530M
KDMB06M0ERLD	1,60	6,00	3,00	0,05	●	–	–	–
KDMB08M0ERLD	2,00	8,00	4,00	0,05	●	–	–	–
KDMB10M0ERLD	2,50	10,00	5,00	0,05	●	–	–	–
KDMB12M0ERLD	2,50	12,00	6,00	0,05	●	–	–	–
KDMB16M0ERLD	3,00	16,00	8,00	0,05	●	–	–	–
KDMB20M0ERLD	3,00	20,00	10,00	0,05	●	–	–	–
KDMB25M0ERLD	4,00	25,00	12,50	0,05	●	–	–	–
KDMB32M0ERLD	5,00	32,00	16,00	0,05	●	–	–	–

KDMB-GP • High-Precision Helical Geometry and Lower Cutting Forces

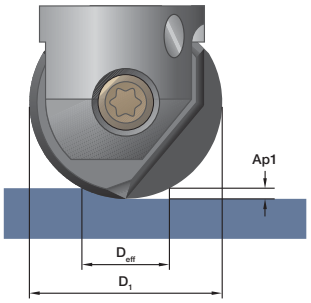
catalogue number	S	W	RC	hm	K115M	KC505M	KC515M	KC530M
KDMB06M0ERGP	1,60	6,00	3,00	0,06	–	●	●	–
KDMB08M0ERGP	2,00	8,00	4,00	0,06	–	●	●	–
KDMB10M0ERGP	2,50	10,00	5,00	0,06	–	●	●	–
KDMB12M0ERGP	2,50	12,00	6,00	0,06	–	●	●	–
KDMB16M0ERGP	3,00	16,00	8,00	0,06	–	●	●	–
KDMB20M0ERGP	3,00	20,00	10,00	0,06	–	●	●	–
KDMB25M0ERGP	4,00	25,00	12,50	0,06	–	●	●	–
KDMB32M0ERGP	5,00	32,00	16,00	0,06	–	●	●	–

KDMB-GN • High Precision • Extremely Solid Cutting Edge

catalogue number	S	W	RC	hm	K115M	KC505M	KC515M	KC530M
KDMB06M0ERGN	1,60	6,00	3,00	0,08	–	●	–	–
KDMB08M0ERGN	2,00	8,00	4,00	0,08	–	●	●	●
KDMB10M0ERGN	2,50	10,00	5,00	0,08	–	●	●	●
KDMB12M0ERGN	2,50	12,00	6,00	0,08	–	●	●	●
KDMB16M0ERGN	3,00	16,00	8,00	0,08	–	●	●	●
KDMB20M0ERGN	3,00	20,00	10,00	0,08	–	●	●	●
KDMB25M0ERGN	4,00	25,00	12,50	0,08	–	●	●	●
KDMB32M0ERGN	5,00	32,00	16,00	0,08	–	●	●	●

KDMB-HC • PSTS Insert Developed for Roughing and Rest Material Operations

catalogue number	S	W	RC	hm	K115M	KC505M	KC515M	KC530M
KDMB12M0ERHC	2,50	12,00	6,00	0,10	–	–	–	●
KDMB16M0ERHC	3,00	16,00	8,00	0,10	–	–	–	●
KDMB20M0ERHC	3,00	20,00	10,00	0,10	–	–	–	●
KDMB25M0ERHC	4,00	25,00	12,50	0,10	–	–	–	●
KDMB32M0ERHC	5,00	32,00	16,00	0,10	–	–	–	●



KDMB Ball Nose • 6mm

	Working Diameter (Dw) at Axial Depth of Cut (ap)			
D1 max	3,00	1,50	0,50	0,25
6,00	6,00	5,20	3,32	2,40

KDMB Ball Nose • 8mm

	Working Diameter (Dw) at Axial Depth of Cut (ap)			
D1 max	4,00	1,50	0,50	0,25
8,00	8,00	6,24	3,87	2,78

KDMB Ball Nose • 10mm

	Working Diameter (Dw) at Axial Depth of Cut (ap)			
D1 max	5,00	2,00	1,00	0,50
10,00	10,00	8,00	6,00	4,36

KDMB Ball Nose • 12mm

	Working Diameter (Dw) at Axial Depth of Cut (ap)			
D1 max	6,00	2,00	1,00	0,50
12,00	12,00	8,94	6,63	4,80

KDMB Ball Nose • 16mm

	Working Diameter (Dw) at Axial Depth of Cut (ap)			
D1 max	8,00	3,00	1,50	0,75
16,00	16,00	12,49	9,33	6,76

KDMB Ball Nose • 20mm

	Working Diameter (Dw) at Axial Depth of Cut (ap)			
D1 max	10,00	3,00	1,50	0,75
20,00	20,00	14,28	10,54	7,60

KDMB Ball Nose • 25mm

	Working Diameter (Dw) at Axial Depth of Cut (ap)			
D1 max	12,50	5,00	2,00	1,00
25,00	25,00	20,00	13,56	9,80

KDMB Ball Nose • 32mm

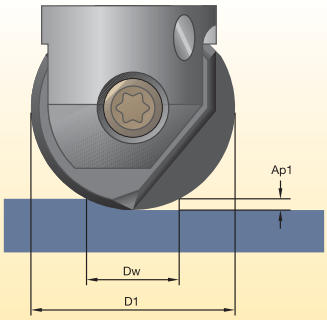
	Working Diameter (Dw) at Axial Depth of Cut (ap)			
D1 max	16,00	5,00	2,00	1,00
32,00	32,00	23,24	15,49	11,14

NOTE: Working diameter (Dw) or effective diameter has to be considered when calculating appropriate RPM.

Calculating Working Diameter and Resulting Surface Speed

Case 1:

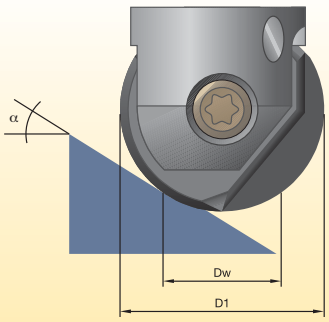
It is important to consider the effective diameter (Dw) when using light depths of cut in order to properly calculate RPM values. Use the following formula when machining flat surfaces or inclinations of 10° or less to find the Dw value. Then, use this for RPM calculations, as opposed to using the overall insert diameter (D1).



$$Dw = \sqrt{D1^2-(D1-2Ap1)^2}$$

Case 2:

When machining inclinations between 11° and 55°, further modification of vc is required. Apply factor "k" from the given formula to calculate the correct vc (vceff). This corrected value is then used to calculate the proper RPM for the tool.



$$k = \frac{1}{\sin[\alpha + \arccos(1-(2(Ap1/D1)))]}$$

$$vceff = vc \times k$$

Recommended Starting Feeds [mm] • Ball Nose Insert Size 6mm

Light Machining	General Purpose	Heavy Machining

At 3,00 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.E..LD	0,12	**0,17**	0,29	0,09	**0,13**	0,22	0,08	**0,11**	0,19	0,07	**0,10**	0,18	0,07	**0,10**	0,18	.E..LD
.E..GP	0,14	**0,20**	0,34	0,11	**0,15**	0,25	0,09	**0,13**	0,22	0,09	**0,12**	0,21	0,08	**0,12**	0,20	.E..GP
.E..GN	0,17	**0,25**	0,34	0,13	**0,19**	0,25	0,11	**0,17**	0,22	0,10	**0,16**	0,21	0,10	**0,15**	0,20	.E..GN

At 1,50 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.E..LD	0,14	**0,19**	0,34	0,10	**0,14**	0,25	0,09	**0,13**	0,22	0,08	**0,12**	0,21	0,08	**0,12**	0,20	.E..LD
.E..GP	0,16	**0,23**	0,39	0,12	**0,17**	0,29	0,11	**0,15**	0,26	0,10	**0,14**	0,24	0,10	**0,14**	0,23	.E..GP
.E..GN	0,20	**0,29**	0,39	0,15	**0,22**	0,29	0,13	**0,19**	0,26	0,12	**0,18**	0,24	0,12	**0,18**	0,23	.E..GN

At 0,50 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.E..LD	0,21	**0,30**	0,53	0,16	**0,23**	0,40	0,14	**0,20**	0,35	0,13	**0,18**	0,32	0,13	**0,18**	0,32	.E..LD
.E..GP	0,26	**0,36**	0,62	0,19	**0,27**	0,46	0,17	**0,24**	0,40	0,16	**0,22**	0,38	0,15	**0,22**	0,37	.E..GP
.E..GN	0,31	**0,46**	0,62	0,23	**0,35**	0,46	0,20	**0,30**	0,40	0,19	**0,28**	0,38	0,18	**0,28**	0,37	.E..GN

At 0,25 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.E..LD	0,30	**0,42**	0,74	0,22	**0,31**	0,55	0,19	**0,27**	0,48	0,18	**0,26**	0,45	0,18	**0,25**	0,44	.E..LD
.E..GP	0,36	**0,50**	0,86	0,27	**0,38**	0,64	0,23	**0,33**	0,56	0,22	**0,31**	0,52	0,21	**0,30**	0,51	.E..GP
.E..GN	0,43	**0,64**	0,86	0,32	**0,48**	0,64	0,28	**0,42**	0,56	0,26	**0,39**	0,52	0,25	**0,38**	0,51	.E..GN

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

Recommended Starting Feeds [mm] • Ball Nose Insert Size 8mm

Light Machining	General Purpose	Heavy Machining

At 4,00 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.E..LD	0,12	**0,17**	0,29	0,09	**0,13**	0,22	0,08	**0,11**	0,19	0,07	**0,10**	0,18	0,07	**0,10**	0,18	.E..LD
.E..GP	0,14	**0,20**	0,35	0,11	**0,15**	0,26	0,09	**0,13**	0,23	0,09	**0,12**	0,21	0,08	**0,12**	0,21	.E..GP
.E..GN	0,17	**0,25**	0,43	0,13	**0,19**	0,32	0,11	**0,17**	0,28	0,10	**0,16**	0,26	0,10	**0,15**	0,25	.E..GN

At 1,50 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.E..LD	0,15	**0,21**	0,38	0,11	**0,16**	0,28	0,10	**0,14**	0,24	0,09	**0,13**	0,23	0,09	**0,13**	0,22	.E..LD
.E..GP	0,18	**0,26**	0,45	0,14	**0,19**	0,34	0,12	**0,17**	0,29	0,11	**0,16**	0,27	0,11	**0,15**	0,27	.E..GP
.E..GN	0,22	**0,33**	0,55	0,16	**0,24**	0,41	0,14	**0,21**	0,36	0,13	**0,20**	0,33	0,13	**0,20**	0,33	.E..GN

At 0,50 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.E..LD	0,24	**0,35**	0,61	0,18	**0,26**	0,45	0,16	**0,23**	0,39	0,15	**0,21**	0,37	0,15	**0,21**	0,36	.E..LD
.E..GP	0,29	**0,41**	0,73	0,22	**0,31**	0,54	0,19	**0,27**	0,47	0,18	**0,25**	0,44	0,18	**0,25**	0,43	.E..GP
.E..GN	0,35	**0,53**	0,88	0,26	**0,39**	0,66	0,23	**0,34**	0,57	0,21	**0,32**	0,54	0,21	**0,31**	0,52	.E..GN

At 0,25 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.E..LD	0,34	**0,48**	0,85	0,25	**0,36**	0,63	0,22	**0,31**	0,55	0,21	**0,29**	0,51	0,20	**0,29**	0,50	.E..LD
.E..GP	0,41	**0,58**	1,02	0,31	**0,43**	0,76	0,27	**0,38**	0,66	0,25	**0,35**	0,62	0,24	**0,34**	0,60	.E..GP
.E..GN	0,49	**0,74**	1,23	0,37	**0,55**	0,92	0,32	**0,48**	0,80	0,30	**0,45**	0,75	0,29	**0,44**	0,73	.E..GN

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

Recommended Starting Feeds [mm] • Ball Nose Insert Size 10mm

Light Machining	General Purpose	Heavy Machining

At 5,00 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.E..LD	0,12	**0,17**	0,29	0,09	**0,13**	0,22	0,08	**0,11**	0,19	0,07	**0,10**	0,18	0,07	**0,10**	0,18	.E..LD
.E..GP	0,14	**0,20**	0,35	0,11	**0,15**	0,26	0,09	**0,13**	0,23	0,09	**0,12**	0,21	0,08	**0,12**	0,21	.E..GP
.E..GN	0,17	**0,27**	0,47	0,13	**0,20**	0,35	0,11	**0,17**	0,31	0,10	**0,16**	0,29	0,10	**0,16**	0,28	.E..GN

At 2,00 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.E..LD	0,15	**0,21**	0,37	0,11	**0,16**	0,27	0,10	**0,14**	0,24	0,09	**0,13**	0,22	0,09	**0,13**	0,22	.E..LD
.E..GP	0,18	**0,25**	0,44	0,13	**0,19**	0,33	0,12	**0,16**	0,29	0,11	**0,15**	0,27	0,11	**0,15**	0,26	.E..GP
.E..GN	0,21	**0,33**	0,59	0,16	**0,25**	0,44	0,14	**0,22**	0,38	0,13	**0,20**	0,36	0,13	**0,20**	0,35	.E..GN

At 1,00 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.E..LD	0,20	**0,28**	0,49	0,15	**0,21**	0,37	0,13	**0,18**	0,32	0,12	**0,17**	0,30	0,12	**0,17**	0,29	.E..LD
.E..GP	0,24	**0,33**	0,59	0,18	**0,25**	0,44	0,15	**0,22**	0,38	0,14	**0,20**	0,36	0,14	**0,20**	0,35	.E..GP
.E..GN	0,28	**0,45**	0,78	0,21	**0,33**	0,58	0,18	**0,29**	0,51	0,17	**0,27**	0,48	0,17	**0,27**	0,47	.E..GN

At 0,50 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.E..LD	0,27	**0,38**	0,67	0,20	**0,29**	0,50	0,18	**0,25**	0,44	0,17	**0,23**	0,41	0,16	**0,23**	0,40	.E..LD
.E..GP	0,33	**0,46**	0,81	0,24	**0,34**	0,60	0,21	**0,30**	0,53	0,20	**0,28**	0,49	0,19	**0,28**	0,48	.E..GP
.E..GN	0,39	**0,62**	1,08	0,29	**0,46**	0,81	0,25	**0,40**	0,70	0,24	**0,37**	0,66	0,23	**0,37**	0,64	.E..GN

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

Recommended Starting Feeds [mm] • Ball Nose Insert Size 12mm

Light Machining	General Purpose	Heavy Machining

At 6,00 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.E..LD	0,12	**0,17**	0,29	0,09	**0,13**	0,22	0,08	**0,11**	0,19	0,07	**0,10**	0,18	0,07	**0,10**	0,18	.E..LD
.E..GP	0,14	**0,20**	0,35	0,11	**0,15**	0,26	0,09	**0,13**	0,23	0,09	**0,12**	0,21	0,08	**0,12**	0,21	.E..GP
.E..GN	0,17	**0,27**	0,47	0,13	**0,20**	0,35	0,11	**0,17**	0,31	0,10	**0,16**	0,29	0,10	**0,16**	0,28	.E..GN
.E..HC	0,17	**0,33**	0,59	0,13	**0,25**	0,44	0,11	**0,22**	0,38	0,10	**0,20**	0,36	0,10	**0,20**	0,35	.E..HC

At 2,00 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.E..LD	0,16	**0,22**	0,39	0,12	**0,17**	0,29	0,10	**0,15**	0,26	0,10	**0,14**	0,24	0,09	**0,13**	0,23	.E..LD
.E..GP	0,19	**0,27**	0,47	0,14	**0,20**	0,35	0,12	**0,18**	0,31	0,12	**0,16**	0,29	0,11	**0,16**	0,28	.E..GP
.E..GN	0,23	**0,36**	0,63	0,17	**0,27**	0,47	0,15	**0,23**	0,41	0,14	**0,22**	0,38	0,14	**0,21**	0,38	.E..GN
.E..HC	0,23	**0,45**	0,79	0,17	**0,34**	0,59	0,15	**0,29**	0,51	0,14	**0,27**	0,48	0,14	**0,27**	0,47	.E..HC

At 1,00 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.E..LD	0,21	**0,30**	0,53	0,16	**0,23**	0,40	0,14	**0,20**	0,35	0,13	**0,18**	0,32	0,13	**0,18**	0,32	.E..LD
.E..GP	0,26	**0,36**	0,64	0,19	**0,27**	0,48	0,17	**0,24**	0,41	0,16	**0,22**	0,39	0,15	**0,22**	0,38	.E..GP
.E..GN	0,31	**0,48**	0,85	0,23	**0,36**	0,64	0,20	**0,32**	0,55	0,19	**0,30**	0,52	0,18	**0,29**	0,51	.E..GN
.E..HC	0,31	**0,61**	1,07	0,23	**0,45**	0,79	0,20	**0,40**	0,69	0,19	**0,37**	0,65	0,18	**0,36**	0,63	.E..HC

At 0,50 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.E..LD	0,30	**0,42**	0,74	0,22	**0,31**	0,55	0,19	**0,27**	0,48	0,18	**0,26**	0,45	0,18	**0,25**	0,44	.E..LD
.E..GP	0,36	**0,50**	0,88	0,27	**0,38**	0,66	0,23	**0,33**	0,57	0,22	**0,31**	0,54	0,21	**0,30**	0,53	.E..GP
.E..GN	0,43	**0,67**	1,18	0,32	**0,50**	0,88	0,28	**0,44**	0,77	0,26	**0,41**	0,72	0,25	**0,40**	0,70	.E..GN
.E..HC	0,43	**0,84**	1,48	0,32	**0,63**	1,10	0,28	**0,55**	0,96	0,26	**0,51**	0,89	0,25	**0,50**	0,88	.E..HC

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

Recommended Starting Feeds [mm] • Ball Nose Insert Size 16mm

Light Machining	General Purpose	Heavy Machining

At 8,00 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.E..LD	0,12	**0,17**	0,29	0,09	**0,13**	0,22	0,08	**0,11**	0,19	0,07	**0,10**	0,18	0,07	**0,10**	0,18	.E..LD
.E..GP	0,14	**0,20**	0,35	0,11	**0,15**	0,26	0,09	**0,13**	0,23	0,09	**0,12**	0,21	0,08	**0,12**	0,21	.E..GP
.E..GN	0,17	**0,27**	0,47	0,13	**0,20**	0,35	0,11	**0,17**	0,31	0,10	**0,16**	0,29	0,10	**0,16**	0,28	.E..GN
.E..HC	0,17	**0,33**	0,59	0,13	**0,25**	0,44	0,11	**0,22**	0,38	0,10	**0,20**	0,36	0,10	**0,20**	0,35	.E..HC

At 3,00 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.E..LD	0,15	**0,21**	0,38	0,11	**0,16**	0,28	0,10	**0,14**	0,24	0,09	**0,13**	0,23	0,09	**0,13**	0,22	.E..LD
.E..GP	0,18	**0,26**	0,45	0,14	**0,19**	0,34	0,12	**0,17**	0,29	0,11	**0,16**	0,27	0,11	**0,15**	0,27	.E..GP
.E..GN	0,22	**0,34**	0,60	0,16	**0,26**	0,45	0,14	**0,22**	0,39	0,13	**0,21**	0,37	0,13	**0,2**	0,36	.E..GN
.E..HC	0,22	**0,43**	0,75	0,16	**0,32**	0,56	0,14	**0,28**	0,49	0,13	**0,26**	0,46	0,13	**0,26**	0,45	.E..HC

At 1,50 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.E..LD	0,20	**0,29**	0,50	0,15	**0,21**	0,38	0,13	**0,19**	0,33	0,12	**0,18**	0,31	0,12	**0,17**	0,30	.E..LD
.E..GP	0,24	**0,34**	0,60	0,18	**0,26**	0,45	0,16	**0,22**	0,39	0,15	**0,21**	0,37	0,15	**0,21**	0,36	.E..GP
.E..GN	0,29	**0,46**	0,81	0,22	**0,34**	0,60	0,19	**0,30**	0,52	0,18	**0,28**	0,49	0,17	**0,27**	0,48	.E..GN
.E..HC	0,29	**0,58**	1,01	0,22	**0,43**	0,75	0,19	**0,37**	0,66	0,18	**0,35**	0,61	0,17	**0,34**	0,60	.E..HC

At 0,75 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.E..LD	0,28	**0,40**	0,7	0,21	**0,30**	0,52	0,18	**0,26**	0,45	0,17	**0,24**	0,42	0,17	**0,24**	0,41	.E..LD
.E..GP	0,34	**0,48**	0,84	0,25	**0,36**	0,62	0,22	**0,31**	0,54	0,20	**0,29**	0,51	0,20	**0,28**	0,50	.E..GP
.E..GN	0,40	**0,64**	1,12	0,30	**0,47**	0,83	0,26	**0,41**	0,72	0,25	**0,39**	0,68	0,24	**0,38**	0,66	.E..GN
.E..HC	0,40	**0,80**	1,40	0,30	**0,59**	1,04	0,26	**0,52**	0,90	0,25	**0,48**	0,85	0,24	**0,47**	0,83	.E..HC

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

Recommended Starting Feeds [mm] • Ball Nose Insert Size 20mm

Light Machining	General Purpose	Heavy Machining

At 10,00 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.E..LD	0,12	**0,17**	0,33	0,09	**0,13**	0,25	0,08	**0,11**	0,22	0,07	**0,10**	0,20	0,07	**0,10**	0,20	.E..LD
.E..GP	0,14	**0,20**	0,40	0,11	**0,15**	0,30	0,09	**0,13**	0,26	0,09	**0,12**	0,24	0,08	**0,12**	0,24	.E..GP
.E..GN	0,17	**0,27**	0,54	0,13	**0,20**	0,40	0,11	**0,17**	0,35	0,10	**0,16**	0,33	0,10	**0,16**	0,32	.E..GN
.E..HC	0,17	**0,33**	0,67	0,13	**0,25**	0,50	0,11	**0,22**	0,44	0,10	**0,20**	0,41	0,10	**0,20**	0,40	.E..HC

At 3,00 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.E..LD	0,17	**0,23**	0,47	0,12	**0,18**	0,35	0,11	**0,15**	0,31	0,10	**0,14**	0,29	0,10	**0,14**	0,28	.E..LD
.E..GP	0,20	**0,28**	0,56	0,15	**0,21**	0,42	0,13	**0,18**	0,37	0,12	**0,17**	0,34	0,12	**0,17**	0,34	.E..GP
.E..GN	0,24	**0,37**	0,75	0,18	**0,28**	0,56	0,16	**0,24**	0,49	0,15	**0,23**	0,46	0,14	**0,22**	0,45	.E..GN
.E..HC	0,24	**0,47**	0,94	0,18	**0,35**	0,70	0,16	**0,31**	0,61	0,15	**0,29**	0,57	0,14	**0,28**	0,56	.E..HC

At 1,50 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.E..LD	0,22	**0,32**	0,64	0,17	**0,24**	0,48	0,15	**0,21**	0,41	0,14	**0,19**	0,39	0,13	**0,19**	0,38	.E..LD
.E..GP	0,27	**0,38**	0,77	0,20	**0,29**	0,57	0,18	**0,25**	0,50	0,16	**0,23**	0,47	0,16	**0,23**	0,46	.E..GP
.E..GN	0,32	**0,51**	1,02	0,24	**0,38**	0,76	0,21	**0,33**	0,66	0,20	**0,31**	0,62	0,19	**0,30**	0,61	.E..GN
.E..HC	0,32	**0,64**	1,28	0,24	**0,48**	0,95	0,21	**0,41**	0,83	0,20	**0,39**	0,78	0,19	**0,38**	0,76	.E..HC

At 0,75 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.E..LD	0,31	**0,44**	0,89	0,23	**0,33**	0,66	0,20	**0,29**	0,57	0,19	**0,27**	0,54	0,19	**0,26**	0,53	.E..LD
.E..GP	0,37	**0,53**	1,06	0,28	**0,40**	0,79	0,24	**0,34**	0,69	0,23	**0,32**	0,64	0,22	**0,32**	0,63	.E..GP
.E..GN	0,45	**0,71**	1,43	0,33	**0,53**	1,06	0,29	**0,46**	0,92	0,27	**0,43**	0,86	0,27	**0,42**	0,84	.E..GN
.E..HC	0,45	**0,89**	1,79	0,33	**0,66**	1,32	0,29	**0,57**	1,15	0,27	**0,54**	1,07	0,27	**0,53**	1,05	.E..HC

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

Recommended Starting Feeds [mm] • Ball Nose Insert Size 25mm

Light Machining	General Purpose	Heavy Machining

At 12,50 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.E..LD	0,12	**0,17**	0,29	0,09	**0,13**	0,22	0,08	**0,11**	0,19	0,07	**0,10**	0,18	0,07	**0,10**	0,18	.E..LD
.E..GP	0,14	**0,20**	0,35	0,11	**0,15**	0,26	0,09	**0,13**	0,23	0,09	**0,12**	0,21	0,08	**0,12**	0,21	.E..GP
.E..GN	0,17	**0,27**	0,47	0,13	**0,20**	0,35	0,11	**0,17**	0,31	0,10	**0,16**	0,29	0,10	**0,16**	0,28	.E..GN
.E..HC	0,17	**0,33**	0,59	0,13	**0,25**	0,44	0,11	**0,22**	0,38	0,10	**0,20**	0,36	0,10	**0,20**	0,35	.E..HC

At 5,00 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.E..LD	0,15	**0,21**	0,37	0,11	**0,16**	0,27	0,10	**0,14**	0,24	0,09	**0,13**	0,22	0,09	**0,13**	0,22	.E..LD
.E..GP	0,18	**0,25**	0,44	0,13	**0,19**	0,33	0,12	**0,16**	0,29	0,11	**0,15**	0,27	0,11	**0,15**	0,26	.E..GP
.E..GN	0,21	**0,33**	0,59	0,16	**0,25**	0,44	0,14	**0,22**	0,38	0,13	**0,20**	0,36	0,13	**0,20**	0,35	.E..GN
.E..HC	0,21	**0,42**	0,73	0,16	**0,31**	0,55	0,14	**0,27**	0,48	0,13	**0,26**	0,45	0,13	**0,25**	0,44	.E..HC

At 2,00 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.E..LD	0,22	**0,31**	0,54	0,16	**0,23**	0,40	0,14	**0,20**	0,35	0,13	**0,19**	0,33	0,13	**0,18**	0,32	.E..LD
.E..GP	0,26	**0,37**	0,65	0,20	**0,28**	0,48	0,17	**0,24**	0,42	0,16	**0,23**	0,40	0,16	**0,22**	0,39	.E..GP
.E..GN	0,31	**0,49**	0,87	0,23	**0,37**	0,65	0,20	**0,32**	0,56	0,19	**0,30**	0,53	0,19	**0,29**	0,52	.E..GN
.E..HC	0,31	**0,62**	1,09	0,23	**0,46**	0,81	0,20	**0,40**	0,70	0,19	**0,38**	0,66	0,19	**0,37**	0,65	.E..HC

At 1,00 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.E..LD	0,30	**0,43**	0,75	0,23	**0,32**	0,56	0,20	**0,28**	0,49	0,18	**0,26**	0,46	0,18	**0,26**	0,45	.E..LD
.E..GP	0,36	**0,51**	0,90	0,27	**0,38**	0,67	0,24	**0,33**	0,59	0,22	**0,31**	0,55	0,22	**0,31**	0,54	.E..GP
.E..GN	0,43	**0,69**	1,21	0,32	**0,51**	0,90	0,28	**0,45**	0,78	0,26	**0,42**	0,73	0,26	**0,41**	0,71	.E..GN
.E..HC	0,43	**0,86**	1,51	0,32	**0,64**	1,12	0,28	**0,56**	0,98	0,26	**0,52**	0,91	0,26	**0,51**	0,89	.E..HC

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

Recommended Starting Feeds [mm] • Ball Nose Insert Size 32mm

Light Machining	General Purpose	Heavy Machining

At 16,00 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.E..LD	0,12	**0,17**	0,29	0,09	**0,13**	0,22	0,08	**0,11**	0,19	0,07	**0,10**	0,18	0,07	**0,10**	0,18	.E..LD
.E..GP	0,14	**0,20**	0,35	0,11	**0,15**	0,26	0,09	**0,13**	0,23	0,09	**0,12**	0,21	0,08	**0,12**	0,21	.E..GP
.E..GN	0,17	**0,27**	0,47	0,13	**0,20**	0,35	0,11	**0,17**	0,31	0,10	**0,16**	0,29	0,10	**0,16**	0,28	.E..GN
.E..HC	0,17	**0,33**	0,59	0,13	**0,25**	0,44	0,11	**0,22**	0,38	0,10	**0,20**	0,36	0,10	**0,20**	0,35	.E..HC

At 5,00 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.E..LD	0,16	**0,23**	0,40	0,12	**0,17**	0,30	0,11	**0,15**	0,26	0,10	**0,14**	0,25	0,10	**0,14**	0,24	.E..LD
.E..GP	0,20	**0,28**	0,48	0,15	**0,21**	0,36	0,13	**0,18**	0,32	0,12	**0,17**	0,30	0,12	**0,17**	0,29	.E..GP
.E..GN	0,23	**0,37**	0,65	0,18	**0,28**	0,48	0,15	**0,24**	0,42	0,14	**0,22**	0,39	0,14	**0,22**	0,39	.E..GN
.E..HC	0,23	**0,46**	0,81	0,18	**0,34**	0,60	0,15	**0,30**	0,53	0,14	**0,28**	0,49	0,14	**0,28**	0,48	.E..HC

At 2,00 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.E..LD	0,24	**0,35**	0,61	0,18	**0,26**	0,45	0,16	**0,23**	0,39	0,15	**0,21**	0,37	0,15	**0,21**	0,36	.E..LD
.E..GP	0,29	**0,41**	0,73	0,22	**0,31**	0,54	0,19	**0,27**	0,47	0,18	**0,25**	0,44	0,18	**0,25**	0,43	.E..GP
.E..GN	0,35	**0,55**	0,97	0,26	**0,41**	0,73	0,23	**0,36**	0,63	0,21	**0,34**	0,59	0,21	**0,33**	0,58	.E..GN
.E..HC	0,35	**0,69**	1,22	0,26	**0,52**	0,91	0,23	**0,45**	0,79	0,21	**0,42**	0,74	0,21	**0,41**	0,72	.E..HC

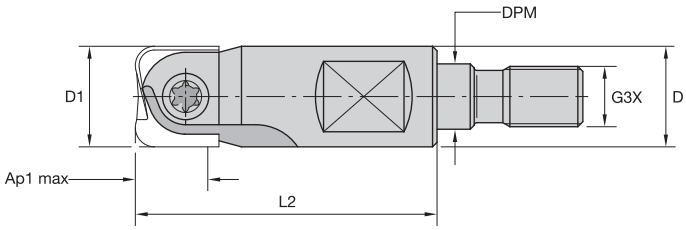
At 1,00 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.E..LD	0,34	**0,48**	0,85	0,25	**0,36**	0,63	0,22	**0,31**	0,55	0,21	**0,29**	0,51	0,20	**0,29**	0,50	.E..LD
.E..GP	0,41	**0,58**	1,02	0,31	**0,43**	0,76	0,27	**0,38**	0,66	0,25	**0,35**	0,62	0,24	**0,34**	0,60	.E..GP
.E..GN	0,49	**0,77**	1,36	0,37	**0,58**	1,01	0,32	**0,50**	0,88	0,30	**0,47**	0,82	0,29	**0,46**	0,80	.E..GN
.E..HC	0,49	**0,97**	1,71	0,37	**0,72**	1,26	0,32	**0,63**	1,10	0,30	**0,59**	1,03	0,29	**0,57**	1,01	.E..HC

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

- Available diameters: 12–20mm.
- High precision and runout accuracy.
- Suitable for roughing and finishing operations.
- Works with toroidal and high-feed inserts.







Screw-On End Mills

order number	catalogue number	D1	D	DPM	G3X	L2	Ap1 max	Z	Z U	max ramp angle	max RPM	insert 1
1918665	**KDMT12R028M08SN**	12	13	8,5	M8	28	3,0	1	2	3.0°	40000	KDM.12..
1918666	**KDMT16R028M08SN**	16	13	8,5	M8	28	4,0	1	2	3.0°	40000	KDM.16..
1918667	**KDMT20R032M10SN**	20	18	10,5	M10	32	5,0	1	2	3.0°	40000	KDM.20..

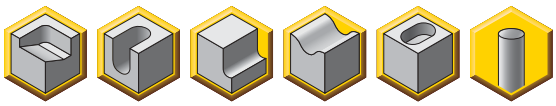
Spare Parts

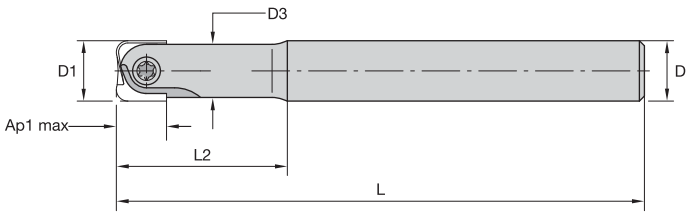




D1	insert screw	Nm	Torx wrench
12	**193.393**	4,0	**KT20**
16	**193.392**	5,0	**KT20**
20	**193.391**	6,0	**KT20**

- Available diameters: 12–25mm.
- High precision and runout accuracy.
- Can be used with the heat shrink technology, h6 shank tolerance.
- Suitable for roughing and finishing operations.
- Works with toroidal and high-feed inserts.







Necked End Mills • Cylindrical Shank • Steel

order number	catalogue number	D1	D	D3	L	L2	Ap1 max	Z	Z U	max ramp angle	max RPM	insert 1
1918690	**KDMT12R130A12SN**	12	12	11	132	34	3,0	1	2	3.0°	40000	KDM.12..
1918691	**KDMT12R150A12SN**	12	12	11	152	48	3,0	1	2	3.0°	40000	KDM.12..
1918692	**KDMT16R140A16SN**	16	16	14	142	40	4,0	1	2	3.0°	40000	KDM.16..
1918693	**KDMT16R160A16SN**	16	16	14	162	57	4,0	1	2	3.0°	40000	KDM.16..
1918694	**KDMT20R160A20SN**	20	20	18	162	47	5,0	1	2	3.0°	40000	KDM.20..
1918695	**KDMT20R175A20SN**	20	20	18	177	63	5,0	1	2	3.0°	40000	KDM.20..
1918697	**KDMT25R190A25SN**	25	25	22	192	72	6,0	1	2	3.0°	40000	KDM.25..
1918699	**KDMT32R210A32SN**	32	32	29	212	82	8,0	1	2	3.0°	40000	KDM.32..

Spare Parts



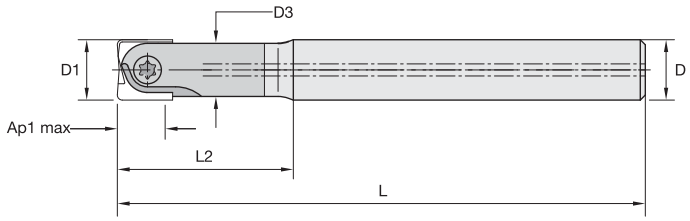




D1	insert screw	Nm	Torx wrench
12	**193.393**	4,0	**KT20**
16	**193.392**	5,0	**KT20**
20	**193.391**	6,0	**KT20**
25	**193.390**	6,5	**KT30**
32	**193.389**	6,5	**KT30**

- Suitable for roughing and finishing operations.
- High precision and runout accuracy.
- Can be used with the heat shrink technology, h6 shank tolerance.
- Works with toroidal and high-feed inserts.
- Available diameters: 10–20mm.







Necked End Mills • Carbide Shank with Through Coolant

order number	catalogue number	D1	D	D3	L	L2	Ap1 max	Z	Z U	max ramp angle	max RPM	insert 1
3964255	**KDMT10R120A10HNC**	10	10	9	122	37	2,5	1	2	3.0°	40000	KDM.10..
3964256	**KDMT10R150A10HNC**	10	10	9	152	52	2,5	1	2	3.0°	40000	KDM.10..
2877384	**KDMT12R120A12HNC**	12	12	11	122	37	3,0	1	2	3.0°	40000	KDM.12..
2877385	**KDMT12R160A12HNC**	12	12	11	162	52	3,0	1	2	3.0°	40000	KDM.12..
2877386	**KDMT16R140A16HNC**	16	16	14	142	42	4,0	1	2	3.0°	40000	KDM.16..
2877387	**KDMT16R175A16HNC**	16	16	14	177	57	4,0	1	2	3.0°	40000	KDM.16..
2877388	**KDMT20R140A20HNC**	20	20	18	142	52	5,0	1	2	3.0°	40000	KDM.20..
2877389	**KDMT20R190A20HNC**	20	20	18	192	77	5,0	1	2	3.0°	40000	KDM.20..

Spare Parts

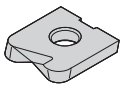


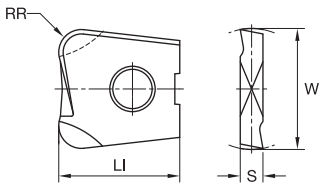


D1	insert screw	Nm	Torx wrench
10	**193.394**	3,0	**KT15**
12	**193.393**	4,0	**KT20**
16	**193.392**	5,0	**KT20**
20	**193.391**	6,0	**KT20**

Insert Selection Guide

Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		◄———	———►	toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.E..GC	KC515M	**.E..GC**	**KC515M**	.E..GN	KC515M
P3–P4	.E..HC	KC505M	**.E..GN**	**KC515M**	.E..GN	KC515M
P5–P6	.E..HC	KC505M	**.E..GN**	**KC515M**	.E..GN	KC515M
M1–M2	–	–	**.E..GC**	**KC515M**	–	–
M3	–	–	**.E..GC**	**KC515M**	–	–
K1–K2	.E..GN	KC515M	**.E..GN**	**KC515M**	.E..GN	KC515M
K3	.E..GN	KC515M	**.E..GN**	**KC515M**	.E..GN	KC515M
N1–N2	–	–	**–**	**–**	–	–
N3	–	–	**–**	**–**	–	–
S1–S2	–	–	**–**	**–**	–	–
S3	–	–	**–**	**–**	–	–
S4	–	–	**.E..GC**	**KC515M**	–	–
H1	.E..HC	KC505M	**.E..HC**	**KC505M**	.E..GN	KC515M


KDMS-GN



KDMS-GN

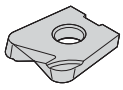
● first choice
○ alternate choice

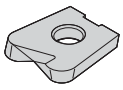
P ● M ○ K ● N S H ●

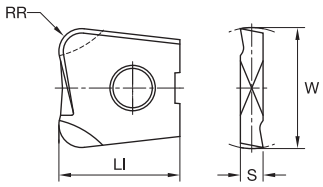
KDMS-GN • Precision Insert • 90° Capabilities

catalogue number	LI	S	W	RR	hm	KC515M
KDMS0806ERGN	9,50	2,00	8,00	0,60	0,08	●
KDMS1008ERGN	11,50	2,50	10,00	0,80	0,08	●
KDMS1210ERGN	14,00	2,50	12,00	1,00	0,08	●
KDMS1613ERGN	16,00	3,00	16,00	1,30	0,08	●
KDMS2016ERGN	18,00	3,00	20,00	1,60	0,08	●
KDMS3220ERGN	28,00	5,00	32,00	2,00	0,08	●

NOTE: Ap1 max is equal to LI.
Insert diameter 6mm and 8mm use KDMB™ holder type. See pages V111–V115.


KDMT-GC


KDMT-GN



KDMT-GC
KDMT-GN

● first choice
○ alternate choice

P		●
M		○
K		●
N		
S		
H		●

KDMT-GC • High-Tolerance Helical Geometry • Finishing Lower Cutting Force

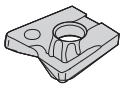
catalogue number	LI	S	W	RR	hm	KC515M
KDMT0605ERGC	8,00	1,60	6,00	0,50	0,05	●
KDMT0810ERGC	9,50	2,00	8,00	1,00	0,05	●
KDMT1010ERGC	11,50	2,50	10,00	1,00	0,05	●
KDMT1210ERGC	14,00	2,50	12,00	1,00	0,08	●
KDMT1610ERGC	16,00	3,00	16,00	1,00	0,08	●
KDMT2010ERGC	18,00	3,00	20,00	1,00	0,08	●
KDMT2510ERGC	23,50	4,00	25,00	1,00	0,08	●

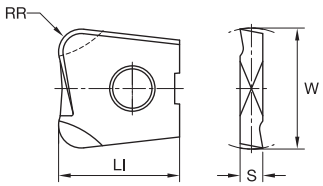
NOTE: Ap1 max is equal to RR.
Insert diameter 6mm and 8mm use KDMB™ holder type. See pages V111–V115.

KDMT-GN • High-Precision Insert • Semi-Finishing and Finishing

catalogue number	LI	S	W	RR	hm	KC515M
KDMT0806ERGN	9,50	2,00	8,00	0,60	0,07	●
KDMT1008ERGN	11,50	2,50	10,00	0,80	0,07	●
KDMT1210ERGN	14,00	2,50	12,00	1,00	0,08	●
KDMT1220ERGN	14,00	2,50	12,00	2,00	0,08	●
KDMT1610ERGN	16,00	3,00	16,00	1,00	0,08	●
KDMT1630ERGN	16,00	3,00	16,00	3,00	0,08	●
KDMT2010ERGN	18,00	3,00	20,00	1,00	0,08	●
KDMT2040ERGN	18,00	3,00	20,00	4,00	0,08	●
KDMT2510ERGN	23,50	4,00	25,00	1,00	0,08	●

NOTE: Ap1 max is equal to RR.
Insert diameter 6mm and 8mm use KDMB holder type. See pages V111–V115.


KDMT-HC



KDMT-HC

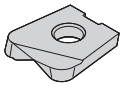
● first choice
○ alternate choice

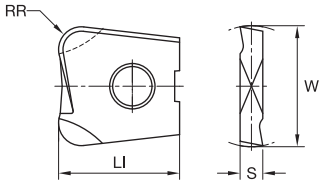
P		●	●	●
M		○	○	○
K		●	○	●
N				
S				
H		○	●	●

KDMT-HC • New Geometry for Semi-Finishing and Finishing with Coolant and Air Flow Grooves

catalogue number	LI	S	W	RR	hm	K115M	KC505M	KC515M
KDMT1010ERHC	11,50	2,50	10,00	1,00	0,10	–	●	–
KDMT1210ERHC	14,00	2,50	12,00	1,00	0,10	–	●	–
KDMT1610ERHC	16,00	3,00	16,00	1,00	0,10	–	●	–
KDMT2010ERHC	18,00	3,00	20,00	1,00	0,10	–	●	–

NOTE: Ap1 max is equal to RR.
Insert diameter 6mm and 8mm use KDMB™ holder type. See pages V111–V115.


KDMT-HF



KDMT-HF

KDMT-HF • Geometry Developed for High-Feed Machining up to 55 HRC

catalogue number	LI	S	W	RT	hm	K115M	KC505M	KC515M
KDMT0604SRHF	8,00	1,60	6,00	0,80	0,08	–	–	●
KDMT0806SRHF	9,50	2,00	8,00	1,00	0,08	–	–	●
KDMT1008SRHF	11,50	2,50	10,00	1,00	0,08	●	–	●
KDMT1210SRHF	14,00	2,50	12,00	1,00	0,08	●	–	●
KDMT1615SRHF	16,00	3,00	16,00	1,50	0,08	●	–	●
KDMT2020SRHF	18,00	3,00	20,00	2,00	0,08	●	–	●

NOTE: RT= Programming Radius
Inset diameter 6mm and 8mm use KDMB holder type. See pages V111–V115.

Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining

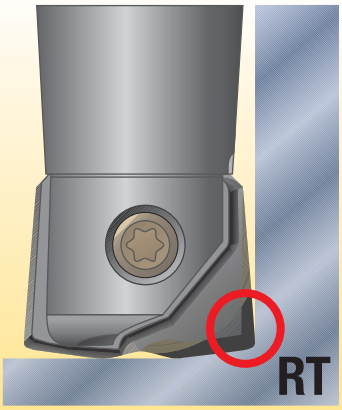
Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.E..GC	0,12	**0,25**	0,34	0,09	**0,19**	0,25	0,08	**0,17**	0,22	0,07	**0,16**	0,21	0,07	**0,15**	0,20	.E..GC
.E..GN	0,17	**0,25**	0,34	0,12	**0,19**	0,25	0,11	**0,17**	0,22	0,10	**0,16**	0,21	0,10	**0,15**	0,20	.E..GN
.E..HC	0,17	**0,25**	0,34	0,13	**0,19**	0,25	0,11	**0,17**	0,22	0,10	**0,16**	0,21	0,10	**0,15**	0,20	.E..HC

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

Application Advice for KDMT-HF Insert Style

For CAM programming, the tools can be programmed as a toroidal tool type requiring the diameter and the RT values only.

insert type	metric			
	Ap max	diameter	RT	max fz
KDMT0604SRHF	0,4	6	0,8	1
KDMT0806SRHF	0,5	8	1	1,3
KDMT1008SRHF	0,5	10	1	1,3
KDMT1210SRHF	0,6	12	1	1,3
KDMT1615SRHF	0,8	16	1,5	1,5
KDMT2020SRHF	1	20	2	1,5



Data for Face Milling, Pocketing, and Profiling Operations

Starting Values

tool diameter	Ø6	Ø8	Ø10	Ø12	Ø16	Ø20
Ap max (mm)	0,4	0,5	0,5	0,6	0,8	1
fz recommended for 45 HRC (approximately)	0,4	0,45	0,45	0,5	0,55	0,65
fz recommended for 55 HRC (approximately)	0,3	0,35	0,35	0,4	0,5	0,55
fz recommended for general purpose	0,5	0,55	0,55	0,65	0,7	0,8

NOTE: Use two effective teeth for feed calculations.
For materials above 45 HRC, we recommend to adjust the Ae max to 55% of cutting diameter.
Steel shanks for roughing operations are recommended.

Proven Solutions:

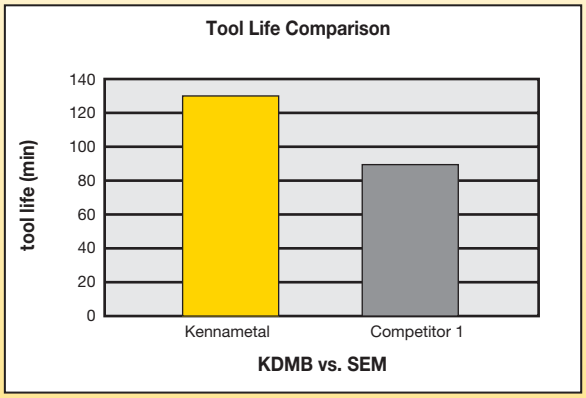
KDMB™ Indexable Milling Cutter vs. Solid Carbide End Mills

1.

Workpiece:
Forging die
Material:
X38 CrMoV 5 3 (1.2367)
Size:
154mm x 115mm x 80mm
Machine:
Vertical milling machine centre

Kennametal
Tool: KDMB06R100A06HN
Insert: KDMB06M0ERGN KC505M
Competitor 1
Solid Carbide End Mill
Ø 6 R3





Cutting data:
vc = 250 m/min (825 SFM)
Ap = 0,28mm (.099")
ae = 1,32mm (.052")
fz = 0,131mm (.0052")

Superior Productivity:
Higher tool life and cost per piece

2.

Workpiece:
Pressing die component
Material:
1.2479 (D2)
Size:
410mm x 320mm x 210mm
Machine:
Vertical milling machine

Kennametal
Tool: KDMB06R100A06HN
Insert: KDMB06M0ERGP KC515M
Competitor 1
Solid Carbide End Mill
Ø 6 R3

Cost Performance Ratio:
Costs for diameter 6mm
MMC:
solid carbide end mill +
2 x regrinding
Reference: 100%
KMT:
3 x inserts +
3 x toolholder share:
Cost savings: 31.15%



Z-Axis Plunge Mill

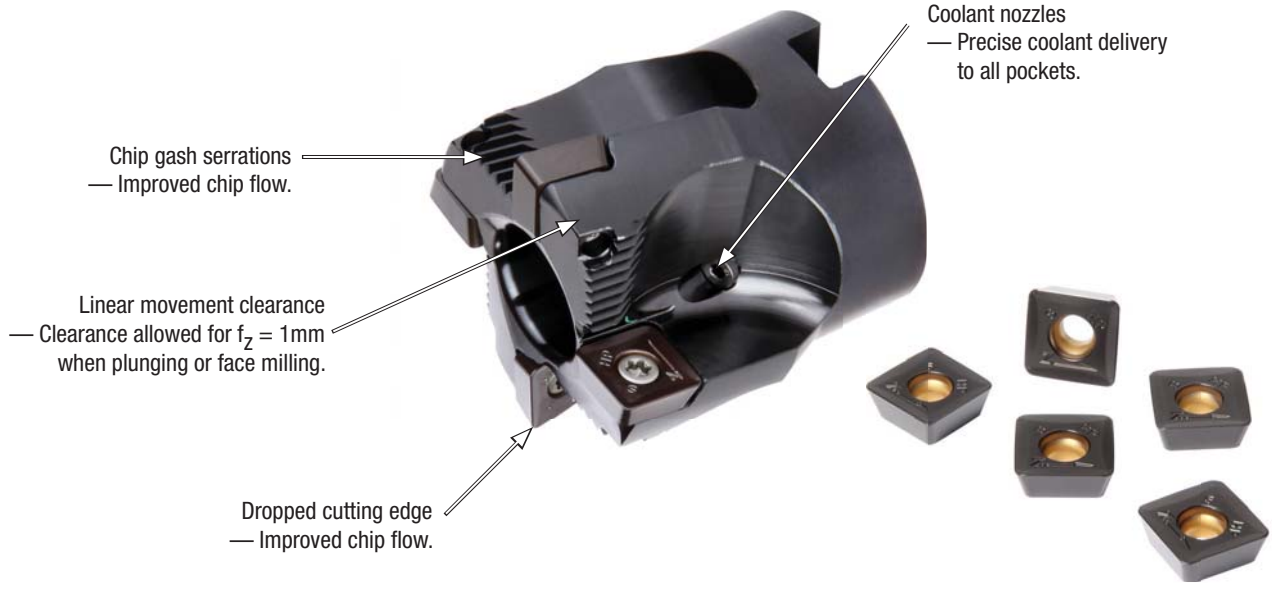
Primary Application

Specifically engineered to eliminate vibration and improve metal removal rates in roughing applications. Ideally suited for rough slotting applications in aerospace, general engineering, die and mould, and power generation.

Features and Benefits

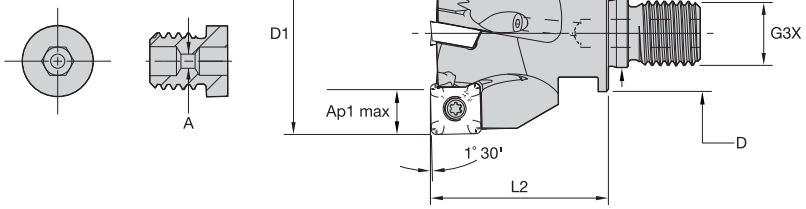
Platform Features

- Nine coolant nozzle sizes enable customised flow by machine tool.
- Unique design is unmatched for chip evacuation.
- Improved performance at a reduced cost per cutting edge.
- Positive geometry lowers cutting force and reduces power requirements, enabling higher feed rates.
- Improved chip control when slotting.
- Fast and easy insert indexing.



- Most stable cutting due to force directions.
- Excellent for long reach applications.
- Extended tool life.
- Suitable for a wide variety of workpiece materials.
- Up to 11mm stepover.
- Unique coolant delivery.
- Chip control when slotting.







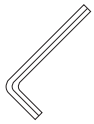
Screw-On End Mills

order number	catalogue number	D1	D	DPM	G3X	L2	Ap1 max	Z	kg	max RPM	insert 1
3111542	**32M2R050M16SSD12PL**	32	29	17,0	M16	50	11,0	2	0,17	25690	SD_T12_PD_N__Z
3064110	**40M3R050M16SSD12PL**	40	29	17,0	M16	50	11,0	3	0,23	22980	SD_T12_PD_N__Z

Spare Parts







D1	insert screw	Nm	Torx Plus driver	coolant nozzle screw	T-handle hex wrench
32	**MS2197**	4,0	**DT15IP**	**MS2191C20**	**THW2M**
40	**MS2197**	4,0	**DT15IP**	**MS2191C20**	**THW2M**

Coolant Screw Detail

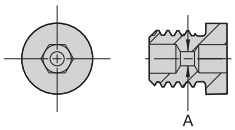
order number	catalogue number	A
3400611	**MS2191C00**	**–**
3400612	**MS2191C06**	**0,600**
3400613	**MS2191C08**	**0,800**
3400616	**MS2191C12**	**1,200**
3400617	**MS2191C14**	**1,400**
3400618	**MS2191C16**	**1,600**
3400619	**MS2191C18**	**1,800**
3400620	**MS2191C20**	**2,000**

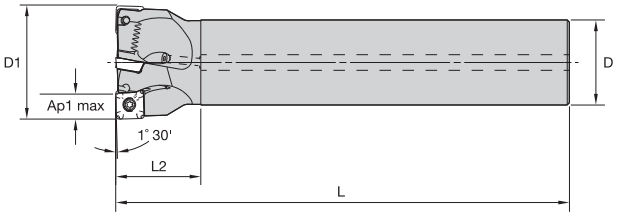
Coolant Nozzle Key

order number	catalogue number	drive size
1993552	**THW2M**	2 MM

NOTE: Check the spare parts table for the coolant hole size that is incorporated in the cutters.
If you need an alternative, there are eight other variants to choose from to increase or decrease the pressure.
Example: MS2191C12 is a 1,20mm hole. All coolant nozzles are interchangeable with the original that is supplied with the cutter, which gives flexibility with coolant flow.

- Most stable cutting due to force directions.
- Excellent for long reach applications.
- Extended tool life.
- Suitable for a wide variety of workpiece materials.
- Up to 11mm stepover.
- Unique coolant delivery.
- Chip control when slotting.





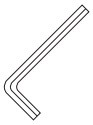


End Mills

order number	catalogue number	D1	D	L	L2	Ap1 max	Z	kg	max RPM	insert 1
3402143	**32M2R040A25SSD12PL**	32	25	200	40	11,0	2	0,69	25690	SD_T1204_PD_N_Z
3402144	**40M3R040A32SSD12PL**	40	32	200	40	11,0	3	1,14	22980	SD_T1204_PD_N_Z

Spare Parts



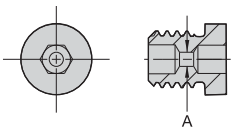

D1	insert screw	Nm	Torx Plus driver	T-handle hex wrench	coolant nozzle screw
32	**MS2197**	4,0	**DT15IP**	**THW2M**	**MS2191C20**
40	**MS2197**	4,0	**DT15IP**	**THW2M**	**MS2191C20**

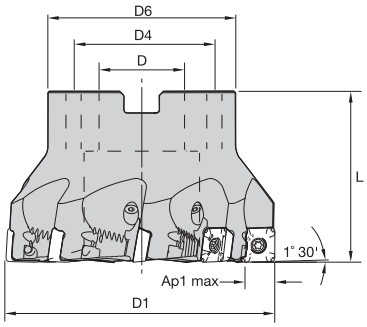
Coolant Screw Detail

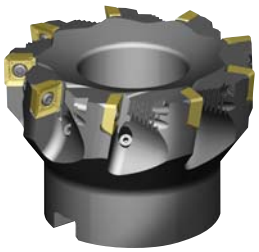
order number	catalogue number	A
3400611	**MS2191C00**	–
3400612	**MS2191C06**	0,600
3400613	**MS2191C08**	0,800
3400616	**MS2191C12**	1,200
3400617	**MS2191C14**	1,400
3400618	**MS2191C16**	1,600
3400619	**MS2191C18**	1,800
3400620	**MS2191C20**	2,000

NOTE: Check the spare parts table for the coolant hole size that is incorporated in the cutters.
If you need an alternative, there are eight other variants to choose from to increase or decrease the pressure.
Example: MS2191C12 is a 1,20mm hole. All coolant nozzles are interchangeable with the original that is supplied with the cutter, which gives flexibility with coolant flow.

- Most stable cutting due to force directions.
- Excellent for long reach applications.
- Extended tool life.
- Suitable for a wide variety of workpiece materials.
- Up to 11mm stepover.
- Unique coolant delivery.
- Chip control when slotting.



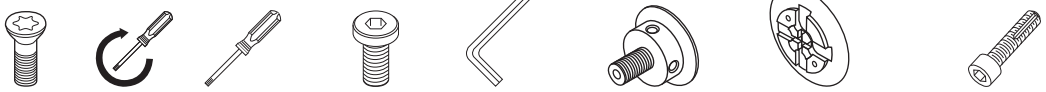




Shell Mills

order number	catalogue number	D1	D	D4	D6	L	Ap1 max	Z	kg	max RPM	insert 1
3873438	50A05RS90SD12PLHF	27	22	–	40	50	3,0	5	0,3	20600	SD_T1204PD_R___
3873464	52A05RS90SD12PLHF	29	22	–	50	50	3,0	5	0,4	20000	SD_T1204PD_R___
3873467	63A06RS90SD12PLHF	40	22	–	50	50	3,0	6	0,5	18300	SD_T1204PD_R___
3873469	66A06RS90SD12PLHF	43	27	–	60	50	3,0	6	0,7	17900	SD_T1204PD_R___
3055230	50A04RS90SD12PL	50	22	–	42	50	11,0	4	0,3	20600	SD_T1204PD_N__Z
3063843	50A05RS90SD12PL	50	22	–	42	50	11,0	5	0,4	20600	SD_T1204PD_N__Z
3873520	80A07RS90SD12PLHF	57	27	–	60	50	3,0	7	0,9	16300	SD_T1204PD_R___
3120265	63A05RS90SD12PL	63	22	–	50	50	11,0	5	0,5	18300	SD_T1204PD_N__Z
3120266	63A06RS90SD12PL	63	22	–	50	50	11,0	6	0,6	18300	SD_T1204PD_N__Z
3950653	100A08RS90SD12PL-HF	77	32	–	60	50	3,0	8	1,3	14600	SD_T1204PD_R___
3120267	80A05RS90SD12PL	80	27	–	60	50	11,0	5	1,0	16300	SD_T1204PD_N__Z
3120268	80A06RS90SD12PL	80	27	–	60	50	11,0	6	1,0	16300	SD_T1204PD_N__Z
3120269	80A07RS90SD12PL	80	27	–	60	50	11,0	7	1,0	16300	SD_T1204PD_N__Z
3120270	100B07RS90SD12PL	100	32	–	80	63	11,0	7	2,1	14600	SD_T1204PD_N__Z
3120574	125B09RS90SD12PL	125	40	–	90	63	11,0	9	3,1	13000	SD_T1204PD_N__Z
3120577	160C10RS90SD12PL	160	40	67	90	63	11,0	10	3,2	11500	SD_T1204PD_N__Z

Spare Parts



order number	D1	insert screw	Nm	Torx Plus driver	coolant nozzle screw	T-handle hex wrench	coolant lock screw assembly	coolant shower plate assembly	socket-head cap screw with coolant groove
3873438	27	MS2077	4,0	DT15IP	–	–	–	–	MS2072CG
3873464	29	MS2077	–	DT15IP	–	–	–	–	MS2072CG
3873467	40	MS2077	–	DT15IP	–	THW2M	–	–	MS2072CG
3873469	43	MS2077	–	DT15IP	MS2191C20	THW2M	–	–	MS2038CG
3055230	50	MS2197	4,0	DT15IP	MS2191C12	THW2M	–	–	MS1242CG
3063843	50	MS2197	4,0	DT15IP	MS2191C12	THW2M	–	–	MS1242CG
3873520	57	MS2077	–	DT15IP	–	THW2M	–	–	MS2038CG
3120265	63	MS2197	4,0	DT15IP	MS2191C12	THW2M	–	–	MS1242CG
3120266	63	MS2197	4,0	DT15IP	–	THW2M	–	–	MS1242CG
3950653	77	MS2077	–	DT15IP	–	THW2M	–	–	–
3120267	80	MS2197	4,0	DT15IP	MS2191C12	THW2M	–	–	MS2038CG
3120268	80	MS2197	4,0	DT15IP	MS2191C12	THW2M	–	–	MS2038CG
3120269	80	MS2197	4,0	DT15IP	–	THW2M	–	–	MS2038CG
3120270	100	MS2197	4,0	DT15IP	–	THW2M	MS2189C	–	–
3120574	125	MS2197	4,0	DT15IP	–	THW2M	MS2187C	–	–
3120577	160	MS2197	4,0	DT15IP	MS2191C20	THW2M	–	MCCM16001	–

NOTE: For coolant shower plates (MCC..), only use low-pressure coolant.

(continued)

(continued)

Coolant Screw Detail

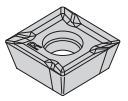
order number	catalogue number	A
3400611	**MS2191C00**	—
3400612	**MS2191C06**	0,600
3400613	**MS2191C08**	0,800
3400616	**MS2191C12**	1,200
3400617	**MS2191C14**	1,400
3400618	**MS2191C16**	1,600
3400619	**MS2191C18**	1,800
3400620	**MS2191C20**	2,000

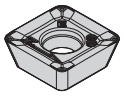
NOTE: Check the spare parts table for the coolant hole size that is incorporated in the cutters.
If you need an alternative, there are eight other variants to choose from to increase or decrease the pressure.
Example: MS2191C12 is a 1,20mm hole. All coolant nozzles are interchangeable with the original that is supplied with the cutter, which gives flexibility with coolant flow.

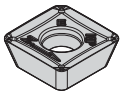
Inserts

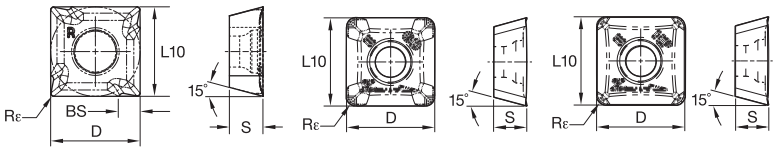
Insert Selection Guide

Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		←	→	toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.E..GDZ	KC725M	**.S..GDZ**	**KC725M**	.E..HPZ	KC725M
P3–P4	.S..GDZ	KCPK30	**.E..HPZ**	**KCPK30**	.S..HPZ	KCPK30
P5–P6	.S..GDZ	KCPK30	**–**	**–**	–	–
M1–M2	.E..GDZ	KC725M	**.S..GDZ**	**KC725M**	.E..HPZ	KC725M
M3	.S..GDZ	KCPK30	**.E..HPZ**	**KCPK30**	.S..HPZ	KCPK30
K1–K2	.E..GDZ	KCPK30	**.S..GDZ**	**KCPK30**	.E..HPZ	KCPK30
K3	.S..GDZ	KCPK30	**.E..HPZ**	**KCPK30**	.S..HPZ	KCPK30
N1–N2	.F..LE	KC410M	**.F..LE**	**KC410M**	.F..LE	KC410M
N3	–	–	**–**	**–**	–	–
S1–S2	.E..GDZ	KC725M	**.S..GDZ**	**KC725M**	.E..HPZ	KC725M
S3	.S..GDZ	KC725M	**.E..HPZ**	**KC725M**	.S..HPZ	KC725M
S4	.E..HPZ	KC725M	**.S..HPZ**	**KC725M**	–	–
H1	–	–	**–**	**–**	–	–


SDCT-LE


SDET-GDZ


SDPT-HPZ



● first choice
○ alternate choice

P		○		●		●	●		
M		●	●	●		○	○	○	
K		○			●	○			
N	●								
S		●	●	●					●
H									

- High positive rake insert.

SDCT-LE

catalogue number	D	S	BS	L10	Rε	hm	cutting edges	KC410M	KC522M	KC525M	KC725M	KCK15	KCPK30	KCPM40	KCSM30
SDCT120404PDFLLE	12,70	4,76	2,70	12,70	0,4	0,02	4	●	–	–	–	–	–	–	–
SDCT120404PDFRLE	12,70	4,76	2,70	12,70	0,4	0,02	4	●	–	–	–	–	–	–	–
SDCT120412PDFLLE	12,70	4,76	2,70	12,70	1,2	0,02	4	●	–	–	–	–	–	–	–
SDCT120412PDFRLE	12,70	4,76	2,70	12,70	1,2	0,02	4	●	–	–	–	–	–	–	–
SDCT120416FNLE	12,70	4,76	–	12,70	1,6	0,02	4	●	–	–	–	–	–	–	–
SDCT120420FNLE	12,70	4,76	–	12,70	2,0	0,02	4	●	–	–	–	–	–	–	–
SDCT120424FNLE	12,70	4,76	–	12,70	2,4	0,02	4	●	–	–	–	–	–	–	–
SDCT120432FNLE	12,70	4,76	–	12,70	3,2	0,02	4	●	–	–	–	–	–	–	–
SDCT1204PDFLLE	12,70	4,76	2,70	12,70	0,8	0,02	4	●	–	–	–	–	–	–	–
SDCT1204PDFRLE	12,70	4,76	2,70	12,70	0,8	0,02	4	●	–	–	–	–	–	–	–

- Precision ground insert.

SDET-GDZ

catalogue number	D	S	BS	L10	Rε	hm	cutting edges	KC410M	KC522M	KC525M	KC725M	KCK15	KCPK30	KCPM40	KCSM30
SDET120412PDENGDZ	12,70	4,76	–	12,70	1,2	0,06	4	–	–	–	●	–	●	●	–
SDET120412PDSNGDZ	12,70	4,76	–	12,70	1,2	0,13	4	–	●	–	●	–	●	●	–

- Pressed-to-size insert.

SDPT-HPZ

catalogue number	D	S	BS	L10	Rε	hm	cutting edges	KC410M	KC522M	KC525M	KC725M	KCK15	KCPK30	KCPM40	KCSM30
SDPT120412PDENHPZ	12,70	4,76	–	12,70	1,2	0,08	4	–	–	–	●	–	●	●	–
SDPT120412PDSNHPZ	12,70	4,76	–	12,70	1,2	0,15	4	–	–	–	●	–	●	●	–

Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.F..LE	–	–	–	–	–	–	–	–	–	–	–	–	0,05	**0,10**	0,20	.F..LE
.E..GDZ	–	–	–	–	–	–	–	–	–	–	–	–	0,09	**0,25**	0,41	.E..GDZ
.S..GDZ	–	–	–	–	–	–	–	–	–	–	–	–	0,10	**0,25**	0,41	.S..GDZ
.E..HPZ	–	–	–	–	–	–	–	–	–	–	–	–	0,10	**0,25**	0,41	.E..HPZ
.S..HPZ	–	–	–	–	–	–	–	–	–	–	–	–	0,10	**0,25**	0,41	.S..HPZ

NOTE: Use "Light Machining" values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

Z-Axis

Best Machining Practices

When finishing a workpiece, you sometimes have to use a Z-axis solution versus a conventional end mill solution to get the best results.

When the length-to-diameter ratio protrudes farther than 3:1, you will need to use a Z-axis solution. This is when the end mill starts to vibrate and the surface finish and noise are unacceptable.

When vibration occurs, the feed rates are compromised, which normally slows down the production of the workpiece.

Programming

At this point, there is very little software for this type of application on the market. We suggest that a simple macro is created for this type of application, which can be recalled and the “X” and “Y” movement changed.

The process can be repeated, so the cutter can be removed from the workpiece in the rapid (G00) movement. Tool life will be improved by not allowing the insert to rub on the retract path.

Slotting

There are several differing ways to machine a slot in a component using the Z-axis cutter solution.

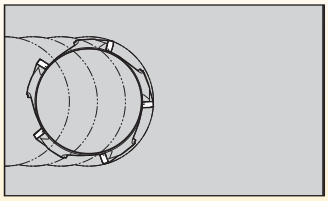


Figure 1

This shows the typical way of machining a slot. The movements are feeding down and straight back up (Z+) in the same axis and will have a negative impact on the insert radii (cutting edge) that could lead to premature failure of the nose radii. When looking at the component, it will show the rapid travel in the Z+ direction. This will highlight the spiral of the insert/cutter operating at a high feed. It looks similar to an oil groove spiralling upwards.

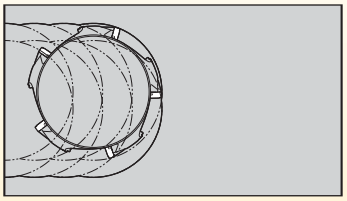


Figure 2

Using a cutter that is smaller than the slot width allows the insert/cutter to be removed from the material when (G00) rapid motion is retracting from the component. Because this type of cutter can be used across various types of machines, assume a 50mm (2.00") diameter cutter is being used to machine a slot of 63mm (2.50") wide on a vertical 3-axis machine.

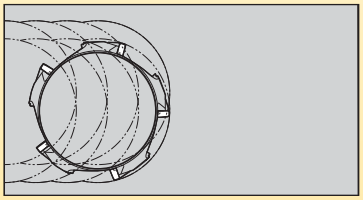


Figure 3

Align the cutter with the centre of the slot on the component and define the stepover that’s required. Move the Y-axis into a position for the first cut, take the first pass to a depth in the Z-axis, and when it reaches the bottom of the slot, programme a 2-axis move to retract the cutting edge for the workpiece.

The 2-axis move will move the Z-axis in a positive direction at 45° (.010") away from the component, and the Y-axis will move away from the workpiece by the same amount at the same angle. Now the cutter can be retracted from the component, and the insert will not rub on the retract move.

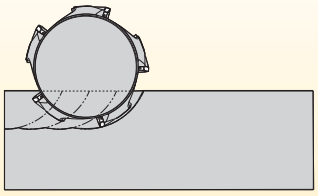
Move the cutter to the left of the slot to define the new position and make the cut. When reaching the base, a 3-axis move will need to be made. Again, the Z-axis will be in a positive direction at 45° (.010"), and the corresponding Y-axis will move away the same respective amount from the wall.

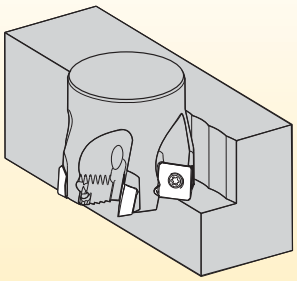
The insert/cutter has now moved away from the workpiece, and the rapid Z+ can take place. Repeat the process on the other side of the slot, remembering the X-axis move needs to be moving the other way.

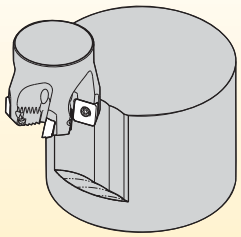
NOTE: When starting the process, it’s better to start at the centre of the slot. After the slot has been defined, you no longer need to put the cutter on the centre path. Passes from both sides create the slot width and enable clearance for the subsequent moves, so the insert/cutter can be moved away from the side walls of the material.

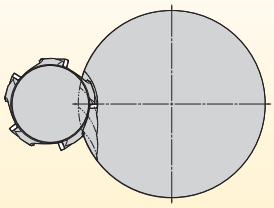
(continued)

Z-Axis *(continued)*









Linear Plunge Milling

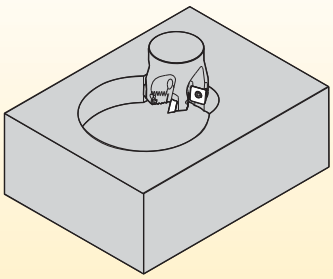
Entering the cutter along a parallel axis, the radial width of cut needs to be defined because the cutter might need to move away from the workpiece material.

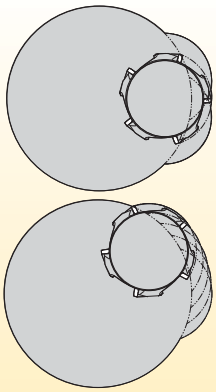
If the radial width of cut takes more than 60% of the cutter diameter, it is more difficult to remove the insert/cutter because the machine programme wants to move the cutter upwards to (G00) Z+. When taking more than 60% of the cutter diameter, the material is enveloping the cutter and is difficult to remove because a cusp has been created.

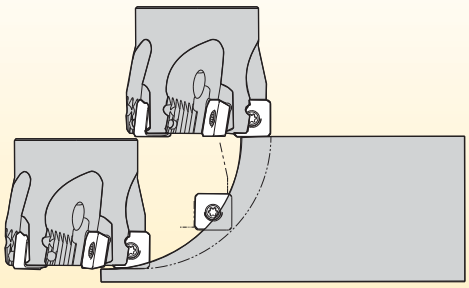
It is suggested to make the radial width of cut 50% of the cutter diameter to allow the insert/cutter to be removed without any problems.

External Profiling

This artwork represents the typical application for this type of process. Move into the cut and follow the external profile of the workpiece. When moving the cutter back to the start position, it's always advisable to move the insert from contacting the workpiece. This should be done with a 2- or 3-axis move (use .010") at 0,25mm. All axes moving in a Z+ direction will stop the rubbing in the retract move.







Internal Profiling

When taking the first pass of a depth, there is also a need to move the insert/cutter away from the material on the retract motion. Each of the passes that follow should adopt the same method on the retract move.

Follow the cutter path until the component has been finished.

Machining Around a Radii

This artwork shows the cutter taking a larger radial width of cut. When moving down in the Z-axis, the insert could start to take a larger radial width of cut. Typical application could be the manufacture of a turbine blade from a rectangular piece of material. Always remember that it's advisable to move the insert/cutter away from the material on the retract motion.

KCRA

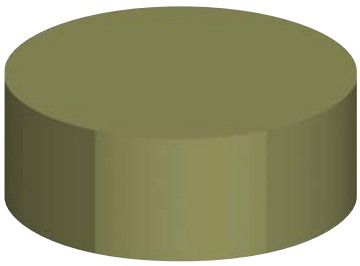
Double-Sided Ceramic Round Insert

KCRA is our newest (patent pending) indexable milling ceramic round platform specifically engineered to maximise productivity while machining high-temperature alloys. Featuring double-sided inserts with increased tooth density, KCRA provides the highest Metal Removal Rate (MRR) with the most effective machining.

Kennametal ceramics dramatically increase your productivity when machining Ni- and Co-based alloys.

Features and Benefits

- First choice for face and shoulder milling of high-temperature alloys.
- Higher metal removal rate due to fine-pitch cutters.
- Secure clamping system improves process stability and reliability.
- Effective air coolant feature. Better chip flow and increased insert tool life.



Flat-top geometry for roughing applications in Ni- and Co-based alloys.

-EGN

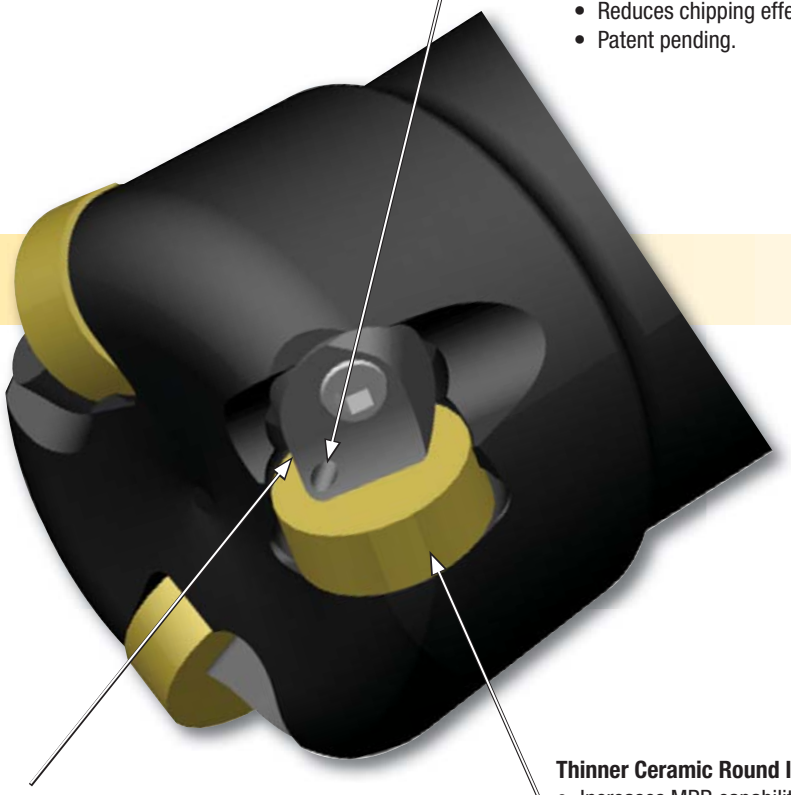
Lower cutting forces.

-TGN

Strongest cutting edge.

*Alternative for unstable situations.

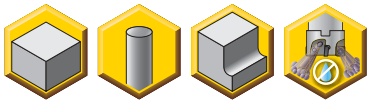
Unique Air Coolant Feature
- Improves chip flow.
- Reduces chipping effect on cutting edges.
- Patent pending.

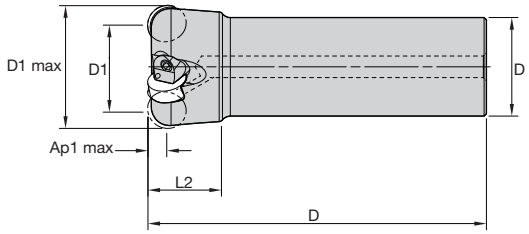


Secure Clamping System
- Improves stability.
- Increases process reliability.
- Facilitates insert change.

Thinner Ceramic Round Inserts
- Increases MRR capabilities.
- Reduces cutting forces.
- Improves cost per edge.

- First choice for face and shoulder milling high-temperature alloys.
- Higher material removal rate due to fine pitch cutters.
- Secure clamping system, improving process stability and reliability.
- Effective air coolant feature. Better chip flow and increased insert tool life.







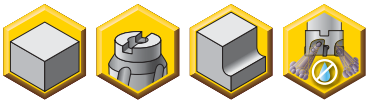
Cylindrical End Mills

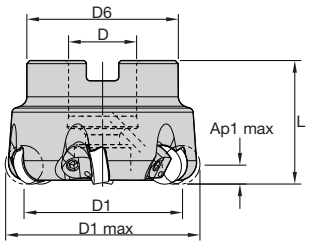
order number	catalogue number	D1 max	D1	D	L	L2	Ap1 max	Z	kg	max RPM	insert 1
5704053	**KCRA40Z03A32RN12**	40	27	32	110	24	6,4	3	0,67	27700	RNGN120400

Spare Parts

D1 max	clamp screw	Nm	hex wrench	wedge
40	**STCM25**	3,3	**MW25**	**KW1008**

- First choice for face and shoulder milling high-temperature alloys.
- Higher material removal rate due to fine pitch cutters.
- Secure clamping system, improving process stability and reliability.
- Effective air coolant feature. Better chip flow and increased insert tool life.







Shell Mills

order number	catalogue number	D1 max	D1	D	D6	L	Ap1 max	Z	kg	max RPM	insert 1
6002128	KCRA40Z04S22RN12	40	27	22	38	40	6,4	4	0,23	23700	RNGN120400
5704054	KCRA50Z04S22RN12	50	37	22	42	40	6,4	4	0,37	23700	RNGN120400
5704055	KCRA50Z06S22RN12	50	37	22	42	40	6,4	6	0,34	23700	RNGN120400
5704056	KCRA63Z06S22RN12	63	50	22	49	40	6,4	6	0,59	20400	RNGN120400
5704057	KCRA63Z09S22RN12	63	50	22	49	40	6,4	9	0,56	20400	RNGN120400
5704058	KCRA80Z08S27RN12	80	67	27	60	50	6,4	8	1,19	17600	RNGN120400

Spare Parts








D1 max	socket-head cap screw	mounting screw	clamp screw	Nm	hex wrench	wedge
40	–	KLSSM22-39-CG	STCM25	3,3	MW25	KW1008
50	MS1242	–	STCM25	3,3	MW25	KW1008
63	MS1242	–	STCM25	3,3	MW25	KW1008
80	MS1556	–	STCM25	3,3	MW25	KW1008

Insert Selection Guide

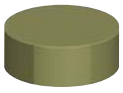
Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		◄——►		toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	–	–	–	–	–	–
P3–P4	–	–	–	–	–	–
P5–P6	–	–	–	–	–	–
M1–M2	–	–	–	–	–	–
M3	–	–	–	–	–	–
K1–K2	–	–	–	–	–	–
K3	–	–	–	–	–	–
N1–N2	–	–	–	–	–	–
N3	–	–	–	–	–	–
S1–S2	.EGN	KYS30	**.EGN**	**KYS30**	.TGN	KYS30
S3	.EGN	KYSP30	**.EGN**	**KYSP30**	.TGN	KYSP30
S4	–	–	–	–	–	–
H1	–	–	–	–	–	–

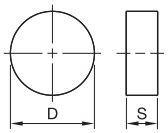
Indexable Inserts

- –EGN geometry is the first choice for unstable situations and/or lower cutting forces.
- –TGN geometry has a stronger cutting edge.
- Use KYSP30 as first choice for S3 group materials, Ni-based alloys.

● first choice
○ alternate choice

P		
M		
K		
N		
S	●	●
H		


RNGN1204



RNGN1204

RNGN1204

catalogue number	D	S	KYS30	KYSP30
RNGN120400EGN	12,70	4,76	●	●
RNGN120400TGN	12,70	4,76	●	●

NOTE: A — Use these tools with the appropriate equipment/machines. Machines have to be covered for safety reasons: Hot flowing chips and loud noises are involved, which is common during the milling process.
B — Use only air flow as coolant method.
C — Higher RPMs are involved; use balanced toolholder for higher tool life and safer operation.

Copy Milling

Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining

At 6,35 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.EGN	0,08	0,09	0,11	0,06	0,07	0,09	0,06	0,06	0,07	0,05	0,06	0,07	0,05	0,06	0,07	.EGN
.TGN	0,13	0,17	0,19	0,09	0,13	0,14	0,08	0,11	0,13	0,08	0,10	0,12	0,08	0,10	0,12	.TGN

At 3,00 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.EGN	0,10	0,11	0,13	0,07	0,08	0,10	0,07	0,07	0,09	0,06	0,07	0,08	0,06	0,07	0,08	.EGN
.TGN	0,15	0,20	0,23	0,11	0,15	0,17	0,10	0,13	0,15	0,09	0,12	0,14	0,09	0,12	0,14	.TGN

At 1,50 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.EGN	0,13	0,14	0,18	0,10	0,11	0,13	0,09	0,09	0,12	0,08	0,09	0,11	0,08	0,09	0,11	.EGN
.TGN	0,19	0,26	0,30	0,15	0,19	0,22	0,13	0,17	0,19	0,12	0,16	0,18	0,12	0,15	0,18	.TGN

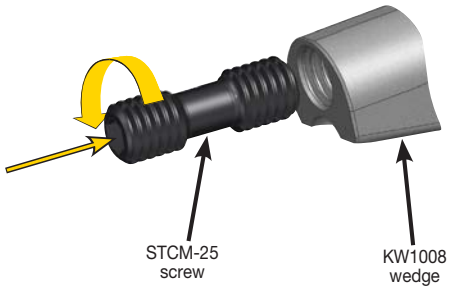
At 0,75 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.EGN	0,18	0,20	0,24	0,13	0,15	0,18	0,12	0,13	0,16	0,11	0,12	0,15	0,11	0,12	0,14	.EGN
.TGN	0,27	0,36	0,41	0,20	0,27	0,31	0,17	0,23	0,27	0,16	0,22	0,25	0,16	0,21	0,24	.TGN

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

Insert Assembly Guide

Safety Notes					
					
Read all instructions carefully	Wear eye protection	Inspect and tighten fasteners regularly	Warning: Cutting hazard	Warning: Hot surfaces	Do not exceed maximum RPM

Assembly Instructions	
1 Assemble STCM-25 screw to KW1008 wedge, 1 to 1 1/2 turns.	**2** Wedge/screw assembly.
	
3 Install wedge/screw assembly into cutter body, but maintain assembly gap for installing insert.	**4** Slide insert, RNGN12... into pocket and torque wedge/insert assembly to 3,5 Nm (31 in/lbs). Repeat for each pocket.
	

NOVO KNOWS SEARCH

Searching for a tool has been enhanced by Advise and Select functions from NOVO™ applications — saving you time and money.

ADVISE

Uses a rules-based approach to provide cutting tool recommendations:

- Define Machining Feature (face milling, slotting, blind hole, etc.)
- Apply Constraint Requirements (geometric, material, tolerance, etc.)
- Set Machining Sequence (single or multi-step operations, rough then finish, etc.)
- Receive Ranked Results

SELECT

A method of selecting cutting tools from a tree structure via a hierarchy or parametric search:

- If you know which product you are looking for, a quick search can be performed by just the catalogue number or product description.
- Smart filters significantly reduce the amount of potential tooling solutions.
- After the tool is selected, NOVO also provides cutting and adaptive item options that fit with your solution.

NOVO applications can ensure you have the right tools on your machines, in the right sequence. Resulting in flawless execution that accelerates every job, and maximises every shift. **kennametal.com/novo**

KIPR™

Ceramic Milling Cutters

Primary Application

The Kennametal ceramic milling platform has been specifically engineered to machine high-temperature alloys, PH series, stainless steel, and hardened materials. With excellent productivity through the massive reduction of machining time, Kennametal ceramics can run more than 10 times faster than comparable carbide grades.



Features and Benefits

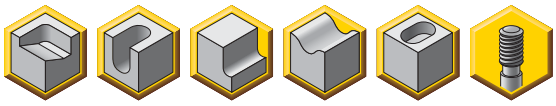
Unbeatable Productivity

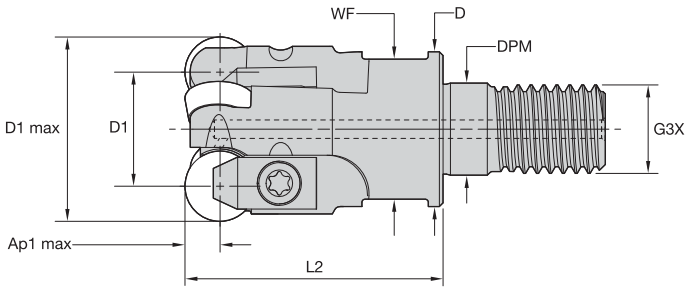
- Engineering to provide outstanding metal removal rates and productivity in nickel-based and/or cobalt-based alloys, stellites, stainless steel, and PH series through HSM.
- High axial and radial runout accuracy.
- Improved insert clearance and thickness tolerance to increase overall performance.
- New clamping system design provides higher spare part tool life and reliability and higher RPM.

Usability and Offering

- Three grades and three insert sizes available to cover a wide range of applications.
- Wide diameter range with end mills and Screw-On cutters from diameter 16mm.
- High clearance on the cutters for superior ramping capacities.
- Through-coolant option in all the cutters. Only for air use.

- For machining high-temp alloys, PH stainless, stainless steels, and hardened materials.
- Excellent productivity through massive reduction of machining time.
- Face milling, pocketing, and ramping capabilities.
- Through-body coolant delivery for internal air supply only.



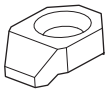




Screw-On End Mills

order number	catalogue number	D1 max	D1	D	DPM	G3X	L2	WF	Ap1 max	Z	max ramp angle	kg	max RPM	insert 1
4052782	**KIPR020RP09MF02**	20	11	18	10,5	M10	30	14	4,8	2	13.0°	0,05	23040	RP_N0903___
4052781	**KIPR020RP06MF03**	20	14	18	10,5	M10	30	14	3,2	3	10.0°	0,05	33325	RP_N0602___
4052843	**KIPR025RP09MF03**	25	16	21	12,5	M12	35	18	4,8	3	8.0°	0,08	20610	RP_N0903___
3101753	**KIPR032RP12MF03**	32	19	29	17,0	M16	45	22	6,3	3	4.2°	0,19	20420	RP_N1204__

Spare Parts

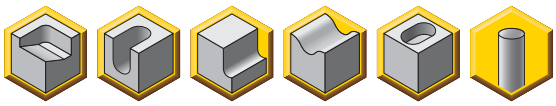


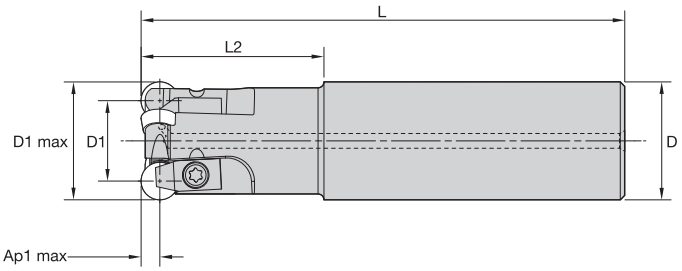




D1 max	clamp	clamp screw	Nm	Torx driver	Torx driver
20	**KCI1**	**191.924**	1,9	**DT9**	**–**
20	**KCI2**	**191.725**	3,5	**DT15**	**–**
25	**KCI2**	**191.725**	3,5	**DT15**	**–**
32	**KCI3M**	**193.409**	6,0	**–**	**TTP20**

- For machining high-temp alloys, PH stainless, stainless steels, and hardened materials.
- Excellent productivity through massive reduction of machining time.
- Face milling, pocketing, and ramping capabilities.
- Through-body coolant delivery for internal air supply only.







Cylindrical End Mills

order number	catalogue number	D1 max	D1	D	L	L2	Ap1 max	Z	max ramp angle	kg	max RPM	insert 1
3617418	**KIPR016RP06CF02**	16	10	16	75	26	3,2	2	14.0°	0,10	37260	RP_N0602___
4052780	**KIPR020RP09CF02**	20	11	20	82	31	4,8	2	13.0°	0,16	23040	RP_N0903___
3617416	**KIPR020RP06CF03**	20	14	20	82	31	3,2	3	10.0°	0,17	33325	RP_N0602___
3617415	**KIPR025RP09CF03**	25	16	25	96	39	4,8	3	8.0°	0,30	20610	RP_N0903___
3101754	**KIPR032RP12CF03**	32	20	32	110	50	6,3	3	4.2°	0,56	20420	RP_N1204___
3101755	**KIPR040RP12CF04**	40	27	32	110	49	6,3	4	2.9°	0,62	18260	RP_N1204___

Spare Parts







D1 max	clamp	clamp screw	Nm	Torx driver	Torx driver
16	**KCI1**	**KCI1**	1,9	**DT9**	**–**
20	**KCI1**	**KCI1**	1,9	**DT9**	**–**
20	**KCI2**	**KCI2**	3,5	**DT15**	**–**
25	**KCI2**	**KCI2**	3,5	**DT15**	**–**
32	**KCI3M**	**KCI3M**	6,0	**–**	**TTP20**
40	**KCI3M**	**KCI3M**	6,0	**–**	**TTP20**

Insert Selection Guide

RPGN06... High Temp

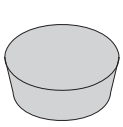
Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance ⟷ toughness					
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	–	–	–	–	–	–
P3–P4	–	–	–	–	–	–
P5–P6	..E	KYSP30	**..E**	**KYSP30**	..E	KYSP30
M1–M2	–	–	–	–	–	–
M3	–	–	–	–	–	–
K1–K2	–	–	–	–	–	–
K3	–	–	–	–	–	–
N1–N2	–	–	–	–	–	–
N3	–	–	–	–	–	–
S1–S2	..E	KYS30	**..E**	**KYS30**	..E	KYS30
S3	..E	KYS30	**..E**	**KYS30**	..E	KYS30
S4	–	–	–	–	–	–
H1	–	–	–	–	–	–

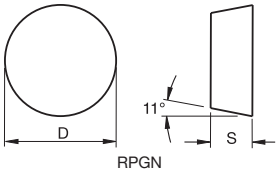
RPGN09... High Temp

Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance ⟷ toughness					
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	–	–	–	–	–	–
P3–P4	–	–	–	–	–	–
P5–P6	..E	KYSP30	**..E**	**KYSP30**	..E	KYSP30
M1–M2	–	–	–	–	–	–
M3	–	–	–	–	–	–
K1–K2	–	–	–	–	–	–
K3	–	–	–	–	–	–
N1–N2	–	–	–	–	–	–
N3	–	–	–	–	–	–
S1–S2	..E	KYS30	**..E**	**KYS30**	..T	KYS30
S3	..E	KYS30	**..T**	**KYS30**	..T	KYS30
S4	–	–	–	–	–	–
H1	–	–	–	–	–	–

RPGN12... High Temp

Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance ⟷ toughness					
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	–	–	–	–	–	–
P3–P4	–	–	–	–	–	–
P5–P6	..E	KYSP30	**..E**	**KYSP30**	..E	KYSP30
M1–M2	–	–	–	–	–	–
M3	–	–	–	–	–	–
K1–K2	–	–	–	–	–	–
K3	–	–	–	–	–	–
N1–N2	–	–	–	–	–	–
N3	–	–	–	–	–	–
S1–S2	..E	KYS30	**..E**	**KYS30**	..T	KYS30
S3	..E	KYS30	**..T**	**KYS30**	..T	KYS30
S4	–	–	–	–	–	–
H1	–	–	–	–	–	–





● first choice
○ alternate choice

P	○	○
M		
K		
N		
S	●	●
H		

RPGN

catalogue number	D	S	KYS30	KYSP30
RPGN060200E	6	2,38	●	●
RPGN090300E	10	3,18	●	●
RPGN090300T01020	10	3,18	●	–
RPGN120400E	13	4,76	●	●
RPGN120400T01020	13	4,76	●	–

NOTE: A — Use these tools with the appropriate equipment/machines. Machines have to be covered for safety reasons: Hot flowing chips and loud noises are involved, which is common during the milling process.
B — Use only air flows as coolant method.
C — Higher RPMs are involved; use balanced toolholder for higher tool life and safer operation.
D — Consider increasing the fz in hard machining when smaller Ap are applied.

Recommended Starting Feeds [mm] • RPGN06..

Light Machining	General Purpose	Heavy Machining

At 3,18 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
..E	0,12	**0,13**	0,17	0,09	**0,10**	0,13	0,08	**0,09**	0,11	0,07	**0,08**	0,10	0,07	**0,08**	0,10	..E

At 1,59 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
..E	0,14	**0,15**	0,20	0,10	**0,11**	0,15	0,09	**0,10**	0,13	0,09	**0,09**	0,12	0,08	**0,09**	0,12	..E

At 0,79 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
..E	0,18	**0,20**	0,26	0,14	**0,15**	0,19	0,12	**0,13**	0,17	0,11	**0,12**	0,16	0,11	**0,12**	0,15	..E

At 0,40 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
..E	0,25	**0,27**	0,35	0,19	**0,20**	0,26	0,16	**0,18**	0,23	0,15	**0,17**	0,22	0,15	**0,16**	0,21	..E

Recommended Starting Feeds [mm] • RPGN09...

At 4,76 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
..E	0,12	**0,13**	0,17	0,09	**0,10**	0,13	0,08	**0,09**	0,11	0,07	**0,08**	0,10	0,07	**0,08**	0,10	..E
..T	0,17	**0,20**	0,26	0,13	**0,15**	0,19	0,11	**0,13**	0,17	0,10	**0,12**	0,16	0,10	**0,12**	0,15	..T

At 2,38 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
..E	0,14	**0,15**	0,20	0,10	**0,11**	0,15	0,09	**0,10**	0,13	0,09	**0,09**	0,12	0,08	**0,09**	0,12	..E
..T	0,20	**0,24**	0,30	0,15	**0,18**	0,22	0,13	**0,15**	0,19	0,12	**0,14**	0,18	0,12	**0,14**	0,18	..T

At 1,19 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
..E	0,18	**0,20**	0,26	0,14	**0,15**	0,19	0,12	**0,13**	0,17	0,11	**0,12**	0,16	0,11	**0,12**	0,15	..E
..T	0,26	**0,31**	0,39	0,19	**0,23**	0,29	0,17	**0,20**	0,25	0,16	**0,19**	0,24	0,15	**0,19**	0,23	..T

At 0,60 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
..E	0,25	**0,27**	0,35	0,19	**0,20**	0,26	0,16	**0,18**	0,23	0,15	**0,17**	0,22	0,15	**0,16**	0,21	..E
..T	0,35	**0,42**	0,53	0,26	**0,32**	0,40	0,23	**0,28**	0,35	0,21	**0,26**	0,32	0,21	**0,25**	0,32	..T

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

Recommended Starting Feeds [mm] • RPGN12..

Light Machining	General Purpose	Heavy Machining

At 6,35 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
..E	0,12	**0,13**	0,17	0,09	**0,10**	0,13	0,08	**0,09**	0,11	0,07	**0,08**	0,10	0,07	**0,08**	0,10	..E
..T	0,17	**0,26**	0,29	0,13	**0,20**	0,22	0,11	**0,17**	0,19	0,10	**0,16**	0,18	0,10	**0,16**	0,17	..T

At 3,18 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
..E	0,14	**0,15**	0,20	0,10	**0,11**	0,15	0,09	**0,10**	0,13	0,09	**0,09**	0,12	0,08	**0,09**	0,12	..E
..T	0,20	**0,31**	0,33	0,15	**0,23**	0,25	0,13	**0,20**	0,22	0,12	**0,19**	0,20	0,12	**0,18**	0,20	..T

At 1,59 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
..E	0,18	**0,20**	0,26	0,14	**0,15**	0,19	0,12	**0,13**	0,17	0,11	**0,12**	0,16	0,11	**0,12**	0,15	..E
..T	0,26	**0,40**	0,44	0,19	**0,30**	0,33	0,17	**0,26**	0,29	0,16	**0,24**	0,27	0,15	**0,24**	0,26	..T

At 0,79 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
..E	0,25	**0,27**	0,35	0,19	**0,20**	0,26	0,16	**0,18**	0,23	0,15	**0,17**	0,22	0,15	**0,16**	0,21	..E
..T	0,35	**0,55**	0,60	0,26	**0,41**	0,45	0,23	**0,36**	0,39	0,21	**0,33**	0,37	0,21	**0,33**	0,36	..T

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.



Indexable Milling • Indexable Thread Milling

TM Series **W2–W27**

TM24 ..... W4–W8

TM25 ..... W10–W16

TM40 ..... W17–W22

TM41 ..... W24–W27

KTMD U Series **W28–W37**

TMS • Thread Milling System **W38–W47**

Thread Milling • Application and Technical Information **W48–W55**

TM Series

The latest Kennametal indexable thread milling tools deliver longer tool life and higher productivity while offering a comprehensive range of thread styles and sizes:

- TM24 Series — Small-bore threading applications with one cutting edge per insert.
- TM25 Series — Standard threading applications with two cutting edges per insert.
- TM40 Series — Long-thread threading applications with two cutting edges per insert.
- TM41 Series — Large-pitch threading applications with two cutting edges per insert.

Features and Benefits

Cutter Body Offering

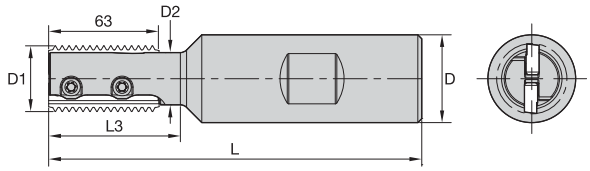
- Number of flutes:
  - TM24: 1–2 per body
  - TM25: 2–8 per body
  - TM40: 3–8 per body
  - TM41: 2–6 per body
- Short and long toolholders for multiple applications.
- Cutters available in parallel Weldon® and conical Weldon holders.
- Effective through coolant for each flute.
- Better chip evacuation.

Insert Offering

- Robust design.
- Inserts for ISO, UN, W, NPT, NPTF, and BSPT Thread Profiles.
- Pitch:
  - 0,50–2,50mm (TM24: 32–10 TPI)
  - 1,00–3,00mm (TM25: 20–8 TPI)
  - 1,00–3,00mm (TM40: 32–10 TPI)
  - 3,00–6,00mm (TM41: 8–4 TPI)
- Grades for most workpiece materials.
- Easy clamping systems.
- Fast indexing of inserts.



- 14–16mm cutting diameter range.
- For internal and external threading on most types of workpiece materials.
- One tool is used for both right- and left-hand threads.
- All cutters have through-coolant capability.
- Utilises inserts with various profiles and pitches.





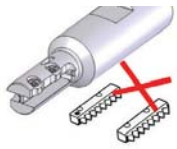
Thread Mill • Weldon Shank • Parallel Threads

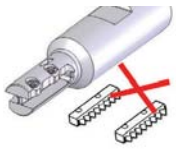
order number	catalogue number	D1	D	D2	L	L3	Z	insert screw	Torx Plus driver
5593149	**TM24D14L26Z1**	13,60	20,00	10,70	82,00	26,00	1	**TM25INSERTSCREW**	**DT8IP**
5593150	**TM24D15L30Z1**	15,10	20,00	11,90	85,00	30,00	1	**TM25INSERTSCREW**	**DT8IP**
5593151	**TM24D16L28Z2**	16,00	20,00	12,60	83,00	28,00	2	**TM25INSERTSCREW**	**DT8IP**
5593152	**TM24D16L36Z1**	16,00	20,00	12,60	91,00	36,00	1	**TM25INSERTSCREW**	**DT8IP**

NOTE: Torque value for insert screw is 4 Nm.
Through coolant is recommended, especially when D2 > 0.7 x nominal thread diameter.

Thread Application per Toolholder min thread Ø							
toolholder	D1 mm	ISO (coarse)	ISO (fine)	UNC	UN/UNF/UNEF/UNS	BSF	BSP(G)
TM24D14L26Z1	13.60	M16 x 2	M14.5 x 0.5; M15 x 0.75; M15 x 1; M15 x 1.25; M16 x 1.5; M16 x 1.75	–	11/16–12UN; 5/8–14UNS; 5/8–16UN; 5/8–18UNF; 5/8–20UN; 5/8–24UNEF; 5/8–28UN; 5/8–32UN	1 1/16–14; 3/4–12	3/8–19
TM24D15L30Z1	15.10	M18 x 2.5	M16 x 0.5; M17 x 0.75; M17 x 1; M17 x 1.25; M17 x 1.5; M18 x 1.75; M18 x 2	3/4–10	3/4–12UN; 3/4–14UNS; 1 1/16–16UN; 1 1/16–20UN; 1 1/16–24UNEF; 1 1/16–28UN; 1 1/16–32UN	3/4–12	–
TM24D16L28Z2	16.00	M20 x 2.5	M17 x 0.5; M17 x 0.75; M18 x 1; M18 x 1.25; M18 x 1.5; M18 x 1.75; M19 x 2	3/4–10	3/4–12UN; 3/4–14UNS; 3/4–16UN; 3/4–18UNS; 3/4–20UNEF; 1 1/16–24UNEF; 1 1/16–28UN; 1 1/16–32UN	3/4–12	–
TM24D16L36Z1	16.00	M20 x 2.5	M17 x 0.5; M17 x 0.75; M18 x 1; M18 x 1.25; M18 x 1.5; M18 x 1.75; M19 x 2	3/4–10	3/4–12UN; 3/4–14UNS; 3/4–16UN; 3/4–18UNS; 3/4–20UNEF; 1 1/16–24UNEF; 1 1/16–28UN; 1 1/16–32UN	3/4–12	–


Side with identification marks

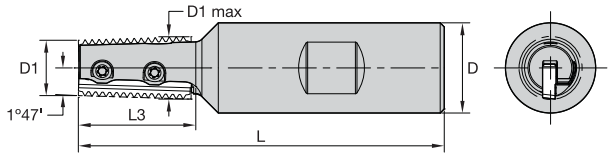

Always mount all inserts on the same side


Always mount all inserts on the same side


To mount insert correctly, push the insert toward the pocket walls*

* When not using an insert in each pocket, protect the pocket by using a TM24 blank insert.

- 12mm cutting diameter range.
- For internal and external threading on most types of workpiece materials.
- One tool is used for both right- and left-hand threads.
- All cutters have through-coolant capability.
- Utilises inserts with various profiles and pitches.



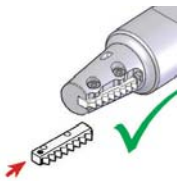


Thread Mill • Weldon Shank • Conical Threads

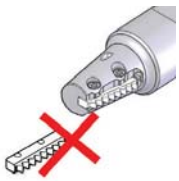
order number	catalogue number	D1	D1 max	D	L	L3	Z	insert screw	Torx Plus driver
5593153	TMT24D14L26Z1	11,50	13,90	20,00	81,00	26,00	1	TM25INSERTSCREW	DT8IP

NOTE: Torque value for insert screw is 4 Nm.

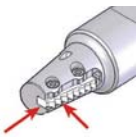
Thread Application per Toolholder				
	min thread Ø			
toolholder	D1 max	NPT	NPTF	BSPT
TMT24D14L26Z1	13,90	3/8–18	3/8–18	3/8–19



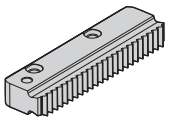
On Conical inserts, the identification mark must face up

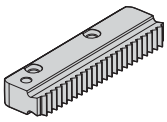


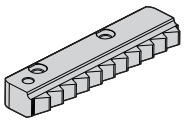
On Conical inserts, the identification mark must face up

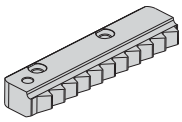


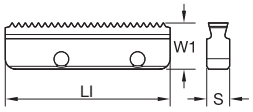
To mount insert correctly, push the insert toward the pocket walls

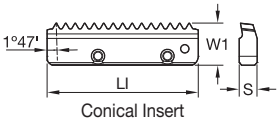

ISO Profiles


UN Profiles


BSF and BSP Profiles


NPT Profiles





Conical Insert

● first choice
○ alternate choice

P	○	●
M		●
K	●	
N	●	
S	○	●
H	●	○

ISO Profiles • Internal

catalogue number	thread pitch mm	LI	W1	S	number of teeth	KC610M	KC635M
TM24N050ISO	0,5	24,00	7,02	3,00	49	●	●
TM24N075ISO	0,75	24,00	7,02	3,00	33	●	●
TM24N100ISO	1,0	24,00	7,02	3,00	24	●	●
TM24N150ISO	1,5	24,00	7,02	3,00	16	●	●
TM24N125ISO	1,25	24,00	7,02	3,00	20	●	●
TM24N175ISO	1,75	24,00	7,02	3,00	14	●	●
TM24N200ISO	2,0	24,00	7,02	3,00	12	●	●
TM24N250ISO	2,5	24,00	7,02	3,00	10	●	●

UN Profiles • Internal

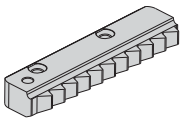
catalogue number	TPI	LI	W1	S	number of teeth	KC610M	KC635M
TM24N10UN	10	24,00	7,02	3,00	9	●	●
TM24N12UN	12	24,00	7,02	3,00	11	●	●
TM24N14UN	14	24,00	7,02	3,00	13	●	●
TM24N16UN	16	24,00	7,02	3,00	15	●	●
TM24N18UN	18	24,00	7,02	3,00	17	●	●
TM24N20UN	20	24,00	7,02	3,00	19	●	●
TM24N24UN	24	24,00	7,02	3,00	23	●	●
TM24N28UN	28	24,00	7,02	3,00	27	●	●
TM24N32UN	32	24,00	7,02	3,00	31	●	●

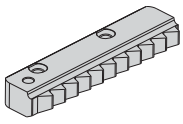
BSF and BSP Profiles • Internal and External

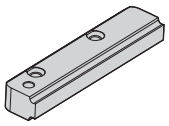
catalogue number	TPI	LI	W1	S	number of teeth	KC610M	KC635M
TM24EN14BSF	14	24,00	7,02	3,00	13	●	●
TM24EN19BSF	19	25,00	7,02	3,00	18	●	●

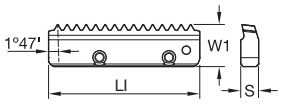
NPT Profiles • Internal and External

catalogue number	TPI	LI	W1	S	number of teeth	KC610M	KC635M
TM24EN18NPT	18	24,00	7,02	3,00	17	●	●

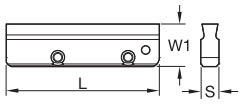

NPTF Profiles


BSPT Profiles


Blank Inserts



Conical Insert



Blank Insert

● first choice
○ alternate choice

P	○	●
M		●
K	●	
N	●	
S	○	●
H	●	○

NPTF Profiles • Internal and External

catalogue number	TPI	LI	W1	S	number of teeth	KC610M	KC635M
TM24EN18NPTF	18	24,00	7,02	3,00	17	●	●

BSPT Profiles • Internal and External

catalogue number	TPI	LI	W1	S	number of teeth	KC610M	KC635M
TM24EN19BSPT	19	24,00	7,02	3,00	18	●	●

Blank/Plug-In Insert • Internal and External

catalogue number	L	W1	S
TM24ENBLANK	24,00	7,02	3,00

TM24 Inserts

materials	Brinell	surface speeds		indexable inserts
steel	HB	KC610M	KC635M	feed fz (mm/tooth)
P1	125	100–210	90–180	0,05–0,20
P2	180	100–170	90–160	0,05–0,20
P3	225	60–130	70–115	0,05–0,20
P4	250	80–150	80–160	0,05–0,20
P5	275	75–130	80–160	0,05–0,15
P6	325	70–110	60–100	0,05–0,10
stainless steel				
M1	180	100–170	120–180	0,05–0,10
M2	250	70–140	100–140	0,05–0,10
M3	330	70–120	100–120	0,05–0,10
cast iron				
K1	180	60–130	100–120	0,02–0,08
K2	220	60–125	80–100	0,05–0,15
K3	260	50–90	60–90	0,05–0,10
non-ferrous				
N1	60–100	100–250	–	0,05–0,25
high-temp alloys				
S1	200	20–45	20–40	0,05–0,10
S2	250	20–30	20–30	0,02–0,05
S3	280	15–20	15–20	0,02–0,05
S4	350	10–15	10–15	0,02–0,05
hardened steel				
H1	55 HRC	20–45	20–45	0,01–0,03

NOTE: Use Kennametal thread mill software:
TM-CNC Generator for CNC Programming on our website under: **http://www.kennametal.com/en/resources/software.html**.

NOVO KNOWS CAD/CAM

With the addition of NOVO™ applications to your team, your CAD/CAM capabilities become much more accurate, streamlined, and productive.

Before NOVO: The programmer would be in their CAD/CAM software, programming a part. Using the tedious method of finding a tool in a catalogue, and then manually inputting the tooling information from the catalogue into the CAD/CAM software.

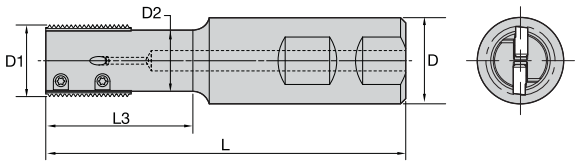
The concern is that assumptions are made, and only partial tooling information is entered.

With NOVO: The powerful digital intelligence of NOVO applications not only help the programmer find the right tool for the metalcutting job, but also automatically integrates all the tooling data into a complete CAD/CAM solution.
The integration of all the tooling data increases the viability of the part being programmed, and is delivered quickly — saving you time.

NOVO applications can ensure you have the right tools on your machines, in the right sequence. Resulting in flawless execution that accelerates every job, and maximises every shift. **kennametal.com/novo**



- 17–30mm cutting diameter range.
- For internal and external threading on most types of workpiece materials.
- One tool is used for both right- and left-hand threads.
- All cutters have through-coolant capability.
- Utilises inserts with various profiles and pitches.





Thread Mill • Weldon Shank • Parallel Threads

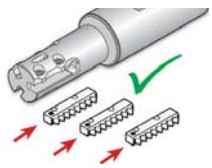
order number	catalogue number	D1	D	D2	L	L3	Z	insert screw	Torx Plus driver
3030845	TM25D17L26Z2	17,00	25,00	14,00	85,00	26,00	2	TM25INSERTSCREW	DT8IP
3030846	TM25D17L36Z2	17,00	25,00	14,00	95,00	36,00	2	TM25INSERTSCREW	DT8IP
3030848	TM25D20L37Z3	20,50	25,00	16,50	96,00	37,00	3	TM25INSERTSCREW	DT8IP
3030849	TM25D20L44Z3	20,50	25,00	16,50	103,00	44,00	3	TM25INSERTSCREW	DT8IP
3030850	TM25D22L43Z3	22,00	25,00	18,00	102,00	43,00	3	TM25INSERTSCREW	DT8IP
3030852	TM25D22L55Z3	22,00	25,00	18,00	114,00	55,00	3	TM25INSERTSCREW	DT8IP
3031703	TM25D30L55Z5	30,00	25,00	26,00	115,00	55,00	5	TM25INSERTSCREW	DT8IP
3031705	TMC25D30L80Z4	30,00	25,00	26,00	140,00	80,00	4	TM25INSERTSCREW	DT8IP

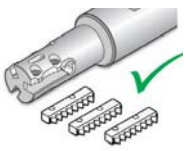
NOTE: Torque value for insert screw is 4 Nm.
Kennametal thread mill software: TM — CNC Generator: **http://www.kennametal.com/en/resources/software.html**.

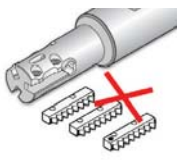
Thread Application per Toolholder

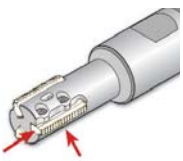
min thread Ø

toolholder	D1 mm	ISO (coarse)	ISO (fine)	UNC	UN/UNF/UNEF/UNS	BSF
TM25D17L26Z2 TM25D17L36Z2	17,00	M20 x 2.5	M19 x 1; M19 x 1.5; M20 x 2	–	7/8-10UNS; 13/16-12UN; 7/8-14UNF; 3/4-16UNF; 3/4-18UNS; 3/4-20UNEF	7/8-11; 7/8-12; 7/8-14; 7/8-16
TM25D20L37Z3 TM25D20L44Z3	20,50	M24 x 3.0	M22 x 1.; M23 x 1.5; M23 x 2.; M23.5 x 2.5	1-8	15/16-9UN; 1.0-10UNS; 15/16-12UN; 1.0-14UNS; 15/16-16UN; 7/8-18UNS; 7/8-20UNEF	1-11; 1-12; 1.14; 1.16
TM25D22L43Z3 TM25D22L55Z3	22,00	M27 x 3.0	M24 x 1.; M24 x 1.5; M25 x 2.; M25 x 2.5	–	11/16-8UN; 1.0-9UN; 1.0-10UNS; 1.0-12UNF; 1.0-14UNS; 1.0-16UN; 1.0-18UN; 15/16-20UNEF	1-11; 1-12; 1-14; 1-16
TM25D30L55Z5 TMC25D30L80Z4	30,00	–	M32 x 1.; M32 x 1.5; M33 x 2.; M33 x 2.5; M34 x 3	–	1 3/8-8UN; 1 3/8-9UN; 1 3/8-10UN; 1 5/16-12UN; 1 3/8-14UNS; 1 5/16-16UN; 1 5/16-18UNEF; 1 5/16-20UN	1 3/8-11; 1 3/8-12; 1 3/8-14; 1 3/8-16


Side with identification marks

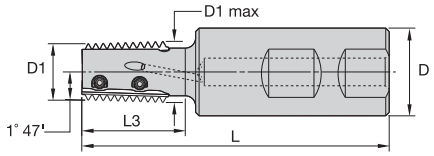

Side without identification marks

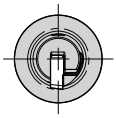

Always mount all inserts with identification marks on the same side


To mount insert correctly, push the insert toward the pocket walls*

* When not using an insert in each pocket, protect the pocket by using a TM25 blank insert.

- 16–29mm cutting diameter range.
- For internal and external threading on most types of workpiece materials.
- One tool is used for both right- and left-hand threads.
- All cutters have through-coolant capability.
- Utilises inserts with various profiles and pitches.





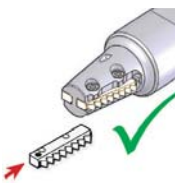


Thread Mill • Weldon Shank • Conical Threads

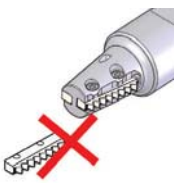
order number	catalogue number	D1	D1 max	D	L	L3	Z	insert screw	Torx Plus driver
3030847	**TMT25D17L26Z2**	15,45	17,00	25,00	85,00	26,00	2	**TM25INSERTSCREW**	**DT8IP**
3030851	**TMT25D22L43Z3**	20,30	22,00	25,00	102,00	43,00	3	**TM25INSERTSCREW**	**DT8IP**
3031704	**TMT25D28L43Z4**	26,40	28,00	25,00	103,00	43,00	4	**TM25INSERTSCREW**	**DT8IP**

NOTE: Torque value for insert screw is 4 Nm.
On conical inserts the identification mark must be face up.
Kennametal thread mill software: TM — CNC Generator: **http://www.kennametal.com/en/resources/software.html**.

Thread Application per Toolholder min thread Ø				
toolholder	**D1 mm**	**NPT**	**NPTF**	**BSPT**
TMT25D17L26Z2	17,00	1/2–14; 3/4–14; 1–11.5; 2–11.5	1/2–14; 3/4–14; 1–11.5; 2–11.5	1/2–14; 3/4–14; 1–11; 1 1/4–11; 1 1/2–11; 2–11
TMT25D22L43Z3	22,00	3/4–14; 1–11.5; 2–11.5	3/4–14; 1–11.5; 2–11.5	3/4–14; 1–11; 1 1/4–11;1 1/2–11; 2–11; 2 1/2–11; 3–11; 4–11; 5–11; 6–11
TMT25D28L43Z4	28,00	1–11.5; 2–11.5	1–11.5; 2–11.5	1–11; 1 1/4–11; 1 1/2–11; 2–11; 2 1/2–11; 3–11; 4–11; 5–11; 6–11



On Conical inserts, the identification mark must face up



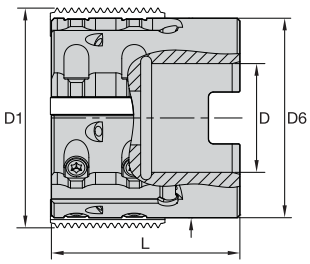
Side without identification marks

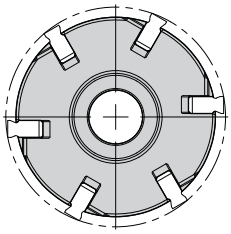


To mount insert correctly, push the insert toward the pocket walls*

* When not using an insert in each pocket, protect the pocket by using a TM25 blank insert.

- 36–52mm cutting diameter range.
- For internal and external threading on most types of workpiece materials.
- One tool is used for both right- and left-hand threads.
- All cutters have through-coolant capability.
- Utilises inserts with various profiles and pitches.





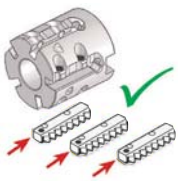


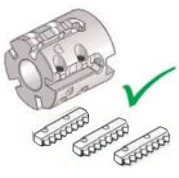
Thread Mill • Shell Mill • Parallel Threads

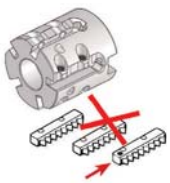
order number	catalogue number	D1	D	D6	L	Z	insert screw	Torx Plus driver	socket-head cap screw
5593142	**TMS25D36L34Z5**	36,00	16,00	32,00	33,50	5	**TM25INSERTSCREW**	**DT8IP**	**MS5001**
5593143	**TMS25D44L38Z6**	44,00	22,00	40,00	38,00	6	**TM25INSERTSCREW**	**DT8IP**	**MS5002**
5593141	**TMS25D52L40Z8**	52,00	27,00	48,00	40,00	3	**TM25INSERTSCREW**	**DT8IP**	**MS5004**

NOTE: Torque value for insert screw is 4 Nm.
Kennametal thread mill software: TM — CNC Generator: **http://www.kennametal.com/en/resources/software.html**.

Thread Application per Toolholder min thread Ø					
toolholder	**D1 mm**	**ISO (fine)**	**UN/UNF/UNEF/UNS**	**BSW**	**BSP(G)**
TMS25D36L34Z5	36,00	M38 x 1; M39 x 1.5; M39 x 2; M40 x 3	1 9/16–12UN; 1 5/8–14UNS; 1 9/16–16UN; 1 1/2–18UNEF; 1 1/2–20UN	1 3/4–16; 1 3/4–12	1 1/4–11
TMS25D44L38Z6	44,00	M48 x 1; M48 x 1.5; M48 x 2; M48 x 3	1 7/8–12UN; 1 13/16–16UN; 1 13/16–20UN; 1 15/16–8UN; 1 7/8–10UNS; 1 7/8–14UNS	2–16; 2–12	1 1/2–11
TMS25D52L40Z8	52,00	M55 x 1; M55 x 1.5; M55 x 2; M56 x 3	2 1/4–8UN; 2 1/4–10UN; 2 1/4–12UN; 2 1/4–14UN; 2 1/4–16UN; 2 1/4–18UN; 2 1/4–20UN	2 1/4–16; 2 1/4–12	2–11


Side with identification marks

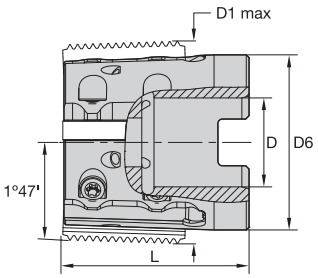

Side without identification marks

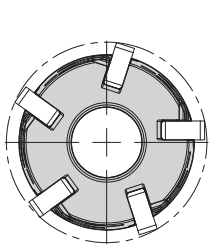

Always mount all inserts on the same side


To mount insert correctly, push the insert toward the pocket walls*

* When not using an insert in each pocket, protect the pocket by using a TM25 blank insert.

- 35mm cutting diameter range.
- For internal and external threading on most types of workpiece materials.
- One tool is used for both right- and left-hand threads.
- All cutters have through-coolant capability.
- Utilises inserts with various profiles and pitches.





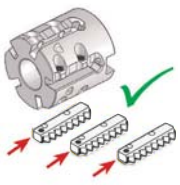


Thread Mill • Shell Mill • Conical Threads

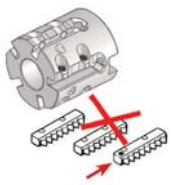
order number	catalogue number	D1 max	D	D6	L	Z	insert screw	Torx Plus driver	socket-head cap screw
5593144	TMST25D36L34Z5	36,10	16,00	31,50	33,50	5	TM25INSERTSCREW	DT8IP	MS5001

NOTE: Torque value for insert screw is 4 Nm.
Kennametal thread mill software: TM — CNC Generator: **http://www.kennametal.com/en/resources/software.html**.

Thread Application per Toolholder min thread Ø				
toolholder	D1 mm	NPT	NPTF	BSPT
TMST25D36L34Z5	34,50	1 1/4-11.5; 1 1/2-11.5; 2-11.5; 2 1/2-8 (and up)	1 1/4-11.5; 1 1/2-11.5; 2-11.5; 2 1/2-8; 3-8	1 1/2-6x11



Side with identification marks



Always mount all inserts on the same side

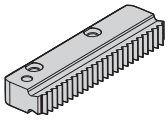


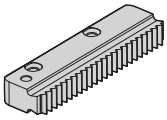
To mount insert correctly, push the insert toward the pocket walls*

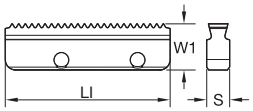
* When not using an insert in each pocket, protect the pocket by using a TM25 blank insert.

NOTE: On conical inserts the identification mark must be face up.

• ISO metric screw thread style.


ISO Profiles


UN Profiles



● first choice
○ alternate choice

P		●	○
M		○	●
K		●	
N		●	
S			●
H		○	●

ISO Profiles • Internal

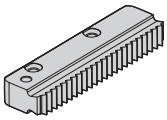
catalogue number	thread pitch mm	LI	W1	S	number of teeth	KC610M	KC635M
TM25N100ISO	1,0	25,00	7,62	3,56	24	●	●
TM25N150ISO	1,5	25,00	7,62	3,56	16	●	●
TM25N200ISO	2,0	25,00	7,62	3,56	12	●	●
TM25N250ISO	2,5	25,00	7,62	3,56	10	●	●
TM25N300ISO	3,0	25,00	7,62	3,56	8	●	●

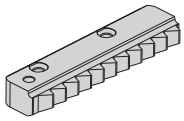
• Unified Thread Standard Style.

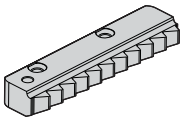
UN Profiles • Internal

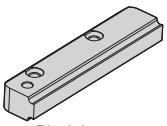
catalogue number	TPI	LI	W1	S	number of teeth	KC610M	KC635M
TM25N8UN	8	25,00	7,62	3,56	7	●	●
TM25N9UN	9	25,00	7,62	3,56	8	●	●
TM25N10UN	10	25,00	7,62	3,56	9	●	●
TM25N12UN	12	25,00	7,62	3,56	11	●	●
TM25N14UN	14	25,00	7,62	3,56	13	●	●
TM25N16UN	16	25,00	7,62	3,56	15	●	●
TM25N18UN	18	25,00	7,62	3,56	17	●	–
TM25N20UN	20	25,00	7,62	3,56	19	●	●

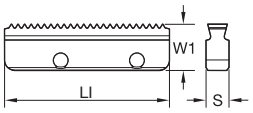
• British Standard Whitworth Thread Style.

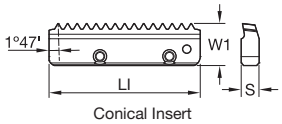

Whitworth Profiles


NPT Profiles

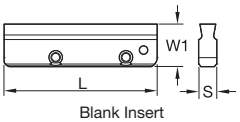

BSPT Profiles


Blank Inserts





Conical Insert



Blank Insert

● first choice
○ alternate choice

P		●	○
M		○	●
K		●	
N		●	
S			●
H		○	●

Whitworth Profiles • Internal/External

catalogue number	TPI	LI	W1	S	number of teeth	KC610M	KC635M
TM25EN11W	11	25,00	7,62	3,56	10	●	●
TM25EN12W	12	25,00	7,62	3,56	11	●	–
TM25EN14W	14	25,00	7,62	3,56	13	●	●

• National Pipe Thread Taper Style.

NPT Profiles • Internal/External

catalogue number	TPI	LI	W1	S	number of teeth	KC610M	KC635M
TM25EN115NPT	11.5	25,00	7,62	3,56	11	●	●
TM25EN14NPT	14	25,00	7,62	3,56	11	●	●

• British Standard Pipe Standard Thread Style.

BSPT Profiles • Internal/External

catalogue number	internal TPI	LI	W1	S	number of teeth	KC610M	KC635M
TM25EN11BSPT	11.0	25,00	7,62	3,56	10	●	–
TM25EN14BSPT	14.0	25,00	7,62	3,56	11	●	–

Blank Insert Form • Internal/External

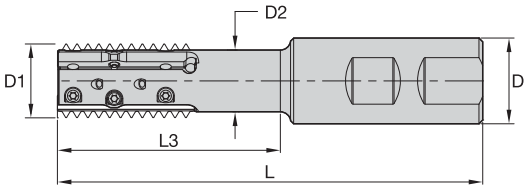
catalogue number	L	W1	S
TM25BLANK	25,00	5,59	3,56

TM25 Inserts

materials	Brinell	surface speeds		indexable inserts
steel	HB	KC610M	KC635M	feed fz (IPT)
P1	125	100–210	90–180	0,05–0,20
P2	180	100–170	90–160	0,05–0,20
P3	225	60–130	70–115	0,05–0,20
P4	250	80–150	80–160	0,05–0,20
P5	275	75–130	80–160	0,05–0,15
P6	325	70–110	60–100	0,05–0,10
stainless steel				
M1	180	100–170	120–180	0,05–0,10
M2	250	70–140	100–140	0,05–0,10
M3	330	70–120	100–120	0,05–0,10
cast iron				
K1	180	60–130	100–120	0,02–0,08
K2	220	60–125	80–100	0,05–0,15
K3	260	50–90	60–90	0,05–0,10
non-ferrous				
N1	60–100	100–250	–	0,05–0,25
high-temp alloys				
S1	200	20–45	20–40	0,05–0,10
S2	250	20–30	20–30	0,02–0,05
S3	280	15–20	15–20	0,02–0,05
S4	350	10–15	10–15	0,02–0,05
hardened steel				
H1	55 HRC	20–45	20–45	0,01–0,03

NOTE: Use Kennametal thread mill software:
TM-CNC Generator for CNC Programming on our website under: **http://www.kennametal.com/en/resources/software.html**.

- 22–30mm cutting diameter range.
- For internal and external threading on most types of workpiece materials.
- One tool is used for both right- and left-hand threads.
- All cutters have through-coolant capability.
- Utilises inserts with various profiles and pitches.







Thread Mill • Weldon Shank • Parallel Threads

order number	catalogue number	D1	D	D2	L	L3	Z	insert screw	Torx Plus driver	screw
5593184	**TM40D22L43Z3**	22,00	25,00	18,00	102,00	43,00	3	**TM25INSERTSCREW**	**DT8IP**	**MS9000**
5593185	**TM40D22L65Z3**	22,00	25,00	18,00	124,00	65,00	3	**TM25INSERTSCREW**	**DT8IP**	**MS9000**
5593186	**TM40D30L55Z4**	30,00	32,00	26,00	117,00	55,00	4	**TM25INSERTSCREW**	**DT8IP**	**MS9000**
5593187	**TM40D30L80Z3**	30,00	32,00	26,00	142,00	80,00	3	**TM25INSERTSCREW**	**DT8IP**	**MS9000**

NOTE: Torque value for insert screw is 4 Nm.

Thread Application per Toolholder min thread Ø						
toolholder	D1 mm	ISO (coarse)	ISO (fine)	UN/UNF/UNEF/UNS	BSF	BSP(G)
TM40D22L43Z3	22,00	M27 x 3	M24 x 1; M24 x 1.5; M25 x 2; M25 x 2.5	1 11/16–8UN; 1–9UN, 1–10UNS; 1–12UNF; 1–14YBS; 1–16UN; 1–18UN; 15/16–20UNEF	1–11; 1–12; 1–14; 1–16	3/4–14
TM40D22L65Z3	22,00	M27 x 3	M24 x 1; M24 x 1.5; M25 x 2; M25 x 2.5	1 11/16–8UN; 1–9UN; 1–10UNS; 1–12UNF; 1–14UNS; 1–16UN; 1–18UN; 15/16UNEF	1–11; 1–12; 1–14; 1–16	3/4–14
TM40D30L55Z4	30,00	–	M32 x 1; M32 x 1.5; M33 x 2; M33 x 2.5; M34 x 3	1 3/8–8UN; 1–9UN; 1 3/8–10UN; 15/16–12UN; 1 3/8–14UNS; 15/16–16UN; 15/16–18UNEF; 15/16–20UN	1 3/8–11; 1 3/8–12; 1 3/8–14; 1 3/8–16	1–11
TM40D30L80Z3	30,00	–	M32 x 1; M32 x 1.5; M33 x 2; M33 x 2.5; M34 x 3	1 3/8–8UN; 1 3/8–9UN; 1 3/8–10UN; 15/16–12UN; 1 3/8–14UNS; 15/16–16UN; 15/16–18UNEF; 15/16–20UN	1 3/8–11; 1 3/8–12; 1 3/8–14; 1 3/8–16	1–11



Side with identification marks



Side without identification marks



Always mount all inserts on the same side

* When not using an insert in each pocket, protect the pocket by using a TM40 blank insert.

2 Step Clamping System

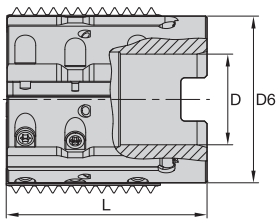
Step 1. Location Screw

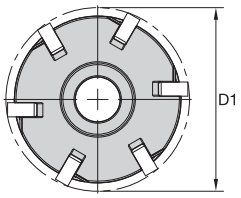


Step 2. Clamping Screw (2)



- 44–52mm cutting diameter range.
- For internal and external threading on most types of workpiece materials.
- One tool is used for both right- and left-hand threads.
- All cutters have through-coolant capability.
- Utilises inserts with various profiles and pitches.





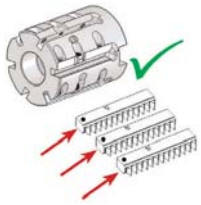


Thread Mill • Shell Mill • Parallel Threads

order number	catalogue number	D1	D	D6	L	Z	insert screw	Torx Plus driver	socket-head cap screw	screw
5593188	**TMS40D44L48Z6**	44,00	22,00	40,00	48,00	6	**TM25INSERTSCREW**	**DT8IP**	**MS5003**	**MS9000**
5593189	**TMS40D52L50Z8**	52,00	27,00	48,00	50,00	8	**TM25INSERTSCREW**	**DT8IP**	**–**	**MS9000**

NOTE: Torque value for insert screw is 4 Nm.

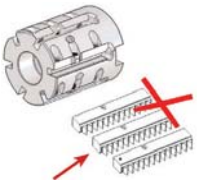
	Thread Application per Toolholder min thread Ø				
toolholder	D1 mm	ISO (fine)	UN/UNF/UNEF/UNS	BSW	BSP(G)
TMS40D44L48Z6	44.00	M48x 1; M48 x 1.5; M48 x 2; M48 x 3	1 7/8–12UN; 1 13/16–16UN; 1 13/16–20UN; 1 15/16–8UN; 1 7/8–10UNS; 1 7/8–14UNS	2–16; 2–12	1 1/2–11
TMS40D52L50Z8	52.00	M55 x 1; M55 x 1.5; M55 x 2; M56 x 3	1 11/16–8UN; 1–9UN; 1–10UNS; 1–12UNF; 1–14UNS; 1–16UN; 1–18UN; 15/16–20UNEF	2 1/4–16; 2 1/4–12	2–11



Side with identification marks



Side without identification marks



Always mount all inserts on the same side

* When not using an insert in each pocket, protect the pocket by using a TM40 blank insert.

2 Step Clamping System

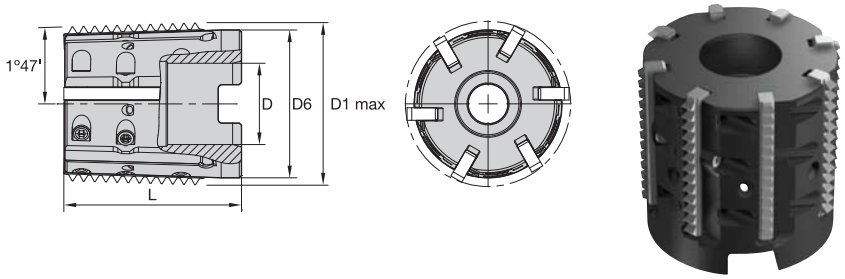
Step 1. Location Screw



Step 2. Clamping Screw (2)



- 45mm cutting diameter range.
- For internal and external threading on most types of workpiece materials.
- One tool is used for both right- and left-hand threads.
- All cutters have through-coolant capability.
- Utilises inserts with various profiles and pitches.

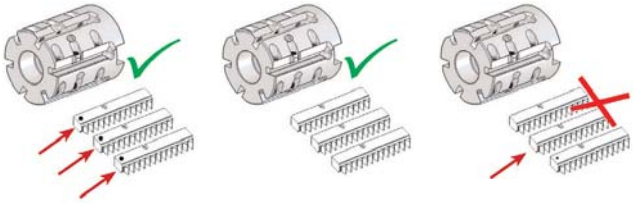


Thead Mill • Shell Mill Conical Threads

order number	catalogue number	D1 max	D	D6	L	Z	insert screw	Torx Plus driver	socket-head cap screw	screw
5593190	TMST40D45L48Z6	45,00	22,00	40,00	48,00	6	TM25INSERTSCREW	DT8IP	MS5003	MS9000

NOTE: Torque value for insert screw is 4 Nm.

Thread Application per Toolholder min thread Ø				
toolholder	D1 max	NPT	NPTF	BSPT
TMST40D45L48Z6	45,00	2–11.5; 2 1/2–8 (and up)	2–11.5; 2 1/2–8; 3–8	2–6 x 11



Side with identification marks

Side without identification marks

Always mount all inserts on the same side*

* When not using an insert in each pocket, protect the pocket by using a TM40 blank insert.

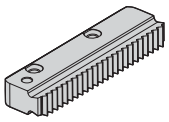
2 Step Clamping System

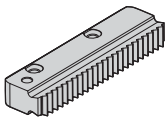
Step 1. Location Screw

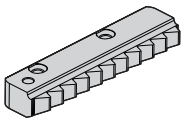


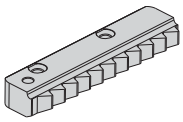
Step 2. Clamping Screw (2)




ISO Profiles

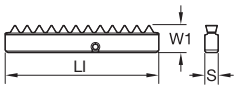

UN Profiles

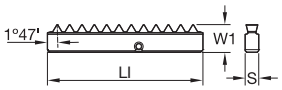

BSF and BSP Profiles


NPT Profiles

● first choice
○ alternate choice

P	○	●
M		●
K	●	
N	●	
S	○	●
H	●	○





Conical Inserts

ISO Profiles • Internal

catalogue number	thread pitch mm	LI	W1	S	KC610M	KC635M
TM40N100ISO	1,00	40,00	7,05	3,49	●	●
TM40N150ISO	1,50	40,00	7,05	3,49	●	●
TM40N200ISO	2,00	40,00	7,05	3,49	●	●
TM40N250ISO	2,50	40,00	7,05	3,49	●	–
TM40N300ISO	3,00	40,00	7,05	3,49	●	●

UN Profiles • Internal

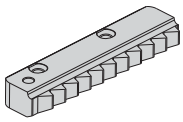
catalogue number	TPI	LI	W1	S	KC610M	KC635M
TM40N8UN	8	40,00	7,05	3,50	●	●
TM40N9UN	9	40,00	7,05	3,49	●	–
TM40N10UN	10	40,00	7,05	3,49	●	–
TM40N12UN	12	40,00	7,05	3,49	●	●
TM40N14UN	14	40,00	7,05	3,49	●	–
TM40N16UN	16	40,00	7,05	3,49	●	●
TM40N18UN	18	40,00	7,05	3,49	●	–
TM40N20UN	20	40,00	7,05	3,49	●	●

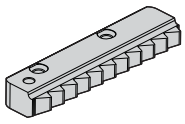
BSF and BSP Profiles • Internal and External

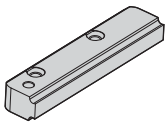
catalogue number	TPI	LI	W1	S	KC610M	KC635M
TM40EN11BSF	11	40,00	7,05	3,50	●	●
TM40EN12BSF	12	40,00	7,05	3,50	●	–
TM40EN14BSF	14	40,00	7,05	3,50	●	–
TM40EN16BSF	16	40,00	7,05	3,50	●	–

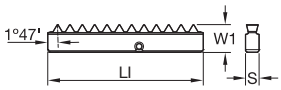
NPT Profiles • Internal and External

catalogue number	TPI	LI	W1	S	KC610M	KC635M
TM40EN008NPT	8.0	40,00	7,30	3,50	●	●
TM40EN115NPT	11.5	40,00	7,30	3,50	●	–

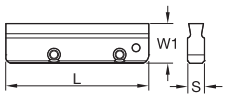

NPT Profiles


BSPT Profiles


Blank Inserts



Conical Insert



Blank Insert

● first choice
○ alternate choice

P	○	●
M		●
K	●	
N	●	
S	○	●
H	●	○

NPTF Profiles • Internal and External

catalogue number	TPI	LI	W1	S	KC610M	KC635M
TM40EN008NPTF	8.0	40,00	7,30	3,50	●	●
TM40EN115NPTF	11.5	40,00	7,30	3,50	●	–

BSPT Profiles • Internal and External

catalogue number	TPI	LI	W1	S	KC610M	KC635M
TM40EN011BSPT	11	40,00	7,30	3,50	●	●

Blank/Plug-In Insert • Internal and External

catalogue number	L	W1	S
TM40ENBLANK	40,00	7,05	3,49

TM40 Inserts

materials	Brinell	surface speeds		indexable inserts
steel	HB	KC610M	KC635M	feed fz (mm/tooth)
P1	125	100–210	90–180	0,05–0,20
P2	180	100–170	90–160	0,05–0,20
P3	225	60–130	70–115	0,05–0,20
P4	250	80–150	80–160	0,05–0,20
P5	275	75–130	80–160	0,05–0,15
P6	325	70–110	60–100	0,05–0,10
stainless steel				
M1	180	100–170	120–180	0,05–0,10
M2	250	70–140	100–140	0,05–0,10
M3	330	70–120	100–120	0,05–0,10
cast iron				
K1	180	60–130	100–120	0,02–0,08
K2	220	60–125	80–100	0,05–0,15
K3	260	50–90	60–90	0,05–0,10
non-ferrous				
N1	60–100	100–250	–	0,05–0,25
high-temp alloys				
S1	200	20–45	20–40	0,05–0,10
S2	250	20–30	20–30	0,02–0,05
S3	280	15–20	15–20	0,02–0,05
S4	350	10–15	10–15	0,02–0,05
hardened steel				
H1	55 HRC	20–45	20–45	0,01–0,03

NOTE: Use Kennametal thread mill software:
TM-CNC Generator for CNC Programming on our website under: **http://www.kennametal.com/en/resources/software.html**.



Carbide Recycling

Help preserve and protect our planet!

It's easy for your company to be environmentally conscious with the Kennametal Carbide Recycling Programme.

By sending us your used carbide tools, you help preserve and protect the environment and ensure that these products are recycled responsibly. Kennametal accepts any coated or non-coated carbide items, including inserts, drills, reamers, and taps.

By using the Kennametal Carbide Recycling Programme, you will receive:

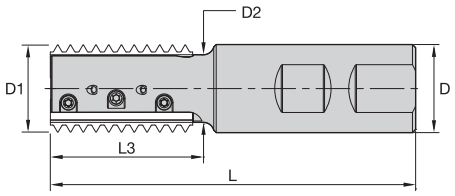
- A partner who cares about a sustainable environment.
- Easy-to-use web portal to value your used carbide.
- Access to our popular Green Box™ options for carbide collection.
- Systematic and efficient disposal of carbide materials.
- Improved profitability.

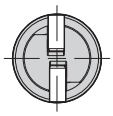
Programme is not currently available in all geographical areas.
For more information, please visit **kennametal.com/carbiderecycling**.

KENNAMETAL®

kennametal.com

- 21–58mm cutting diameter range.
- For internal and external threading on most types of workpiece materials.
- One tool is used for both right- and left-hand threads.
- All cutters have through-coolant capability.
- Utilises inserts with various profiles and pitches.





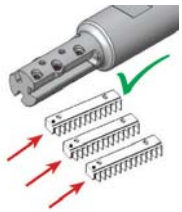


Thread Mill • Weldon Shank • Parallel Threads

order number	catalogue number	D1	D	D2	L	L3	Z	insert screw	Torx Plus driver	screw
5593159	TM41D21L45Z1	21,20	25,00	16,00	105,00	45,00	1	TM25INSERTSCREW	DT8IP	MS9000
5593170	TM41D25L43Z2	24,50	25,00	19,20	104,00	43,00	2	TM25INSERTSCREW	DT8IP	MS9000
5593171	TM41D30L43Z3	30,00	32,00	24,20	106,50	43,00	3	TM25INSERTSCREW	DT8IP	MS9000
5593172	TM41D30L65Z3	30,00	32,00	24,20	128,50	65,00	3	TM25INSERTSCREW	DT8IP	MS9000
5593173	TM41D36L43Z5	36,00	32,00	28,30	106,00	43,00	5	TM25INSERTSCREW	DT8IP	MS9000
5593174	TM41D36L65Z4	36,00	32,00	28,30	128,00	65,00	4	TM25INSERTSCREW	DT8IP	MS9000

NOTE: Torque value for insert screw is 4 Nm.

Thread Application per Toolholder min thread Ø								
toolholder	D1 mm	ISO (coarse)	ISO (fine)	UNC	UN/UNF/UNEF/UNS	BSW/BSF	NPT	NPTF
TM41D21L45Z1	21,20	M30 x 3.5; M36 x 4	M28 x 3; M45 x 4	1 1/8–7; 1 3/8–6	1 1/8–8UN; 1 7/16–6UN	1 3/8–8BSF; 1 1/4–7BSW	–	–
TM41D25L43Z2	24,50	M30 x 3.5; M36 x 4	M28 x 3; M45 x 4	1 1/8–7; 1 3/8–6	1 1/8–8UN; 1 7/16–6UN	1 3/8–8BSF; 1 1/4–7BSW	–	–
TM41D30L43Z3	30,00	M36 x 4; M42 x 4.5	M34 x 3; M34 x 3.5; M45 x 4	1 3/8–6	1 3/8–8UN; 1 7/16–6UN	1 3/8–8BSF; 1 3/4–7BSF; 1 1/2–6BSW	–	–
TM41D30L65Z3	30,00	M36 x 4; M42 x 4.5	M34 x 3; M34 x 3.5; M45 x 4	1 3/8–6	1 3/8–8UN; 1 7/16–6UN	1 3/8–8BSF; 1 3/4–7BSF; 1 1/2–6BSW	–	–
TM41D36L43Z5	36,00	M42 x 4.5; M48 x 5; M56 x 5.5; M64 x 6	M40 x 3; M40 x 3.5; M42 x 4; M70 x 6	1 3/4–5; 2–4.5; 2 1/2–4	1 5/8–8UN; 1 5/8–6UN	1 5/8–8BSF; 1 3/4–7BSF; 1 7/8–6BSF	2 1/2–8	2 1/2–8
TM41D36L65Z4	36,00	M42 x 4.5; M48 x 5; M56 x 5.5; M64 x 6	M40 x 3; M40 x 3.5; M42 x 4; M70 x 6	1 3/4–5; 2–4.5; 2 1/2–4	1 5/8–8UN; 1 5/8–6UN	1 5/8–8BSF; 1 3/4–7BSF; 1 7/8–6BSF	2 1/2–8	2 1/2–8



Side with identification marks



Side without identification marks



Always mount all inserts on the same side*

* When not using an insert in each pocket, protect the pocket by using a TM41 blank insert.

2 Step Clamping System

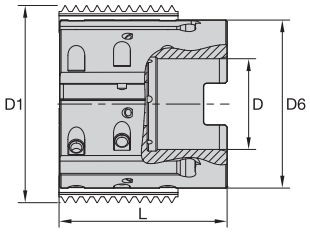
Step 1. Location Screw (2)

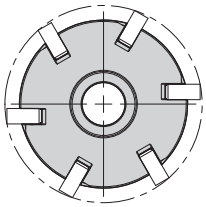


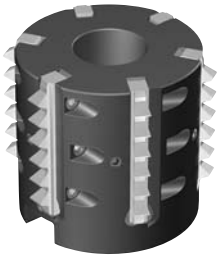
Step 2. Clamping Screw



- 48–58mm cutting diameter range.
- For internal and external threading on most types of workpiece materials.
- One tool is used for both right- and left-hand threads.
- All cutters have through-coolant capability.
- Utilises inserts with various profiles and pitches.





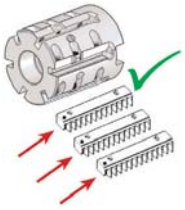


Thread Mill • Shell Mill • Parallel Threads

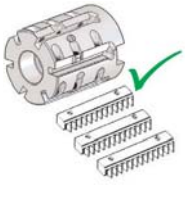
order number	catalogue number	D1	D	D6	L	Z	insert screw	Torx Plus driver	socket-head cap screw	screw
5593175	TMS41D48L50Z5	48,00	22,00	40,00	50,00	5	TM25INSERTSCREW	DT8IP	MS5003	MS9000
5593176	TMS41D58L50Z6	58,00	27,00	50,00	50,00	6	TM25INSERTSCREW	DT8IP	–	MS9000

NOTE: Torque value for insert screw is 4 Nm.

Thread Application per Toolholder min thread Ø								
toolholder	D1 mm	ISO (coarse)	ISO (fine)	UNC	UN/UNF/UNEF/UNS	BSF	NPT	NPTF
TMS41D48L50Z5	48,00	M56 x 5.5; M64 x 6	M55 x 4; M70 x 6;	2 1/4–4.5; 2 1/2–4	2 1/8–8UN; 2 1/8–6UN	2 1/4–8; 2 1/4–6	2 1/2–8	2 1/2–8
TMS41D58L50Z6	58,00	M68 x 6	M64 x 4; M70 x 6	2 3/4–4	2 1/8–8UN; 2 1/8–6UN	2 1/4–8; 2 1/4–6	2 1/2–8	2 1/2–8



Side with identification marks



Side without identification marks



Always mount all inserts on the same side*

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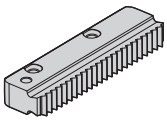
2 Step Clamping System

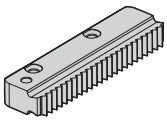
Step 1. Location Screw (2)

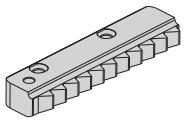


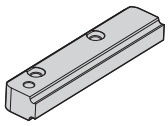
Step 2. Clamping Screw




ISO Profiles

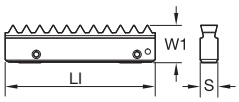

UN Profiles


NPT Profiles

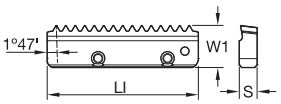

Blank Inserts

● first choice
○ alternate choice

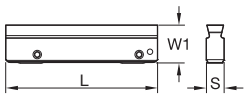
P		○	●
M			●
K		●	
N		●	
S		○	●
H		●	○



ISO Profiles
UN Profiles



Conical Insert



Blank Insert

ISO Profiles • Internal

catalogue number	thread pitch mm	LI	W1	S	KC610M	KC635M
TM41N300ISO	3,00	41,00	9,95	4,76	●	●
TM41N350ISO	3,50	41,00	9,95	4,76	●	●
TM41N400ISO	4,00	41,00	9,95	4,76	●	●
TM41N450ISO	4,50	41,00	9,95	4,76	●	●
TM41N500ISO	5,00	41,00	9,95	4,76	●	●
TM41N550ISO	5,50	41,00	9,95	4,76	●	●
TM41N600ISO	6,00	41,00	9,95	4,76	●	●

UN Profiles • Internal

catalogue number	TPI	LI	W1	S	KC610M	KC635M
TM41N4UN	4	41,00	9,95	4,76	●	●
TM41N45UN	4.5	41,00	9,95	4,76	●	●
TM41N5UN	5	41,00	9,95	4,76	●	●
TM41N6UN	6	41,00	9,95	4,76	●	●
TM41N7UN	7	41,00	9,95	4,76	●	●
TM41N8UN	8	41,00	9,95	4,76	●	●

NPT Profiles • Internal and External

catalogue number	TPI	LI	W1	S	KC610M	KC635M
TM41EN8NPT	8	41,00	9,95	4,76	●	●

Blank/Plug-In Insert • Internal and External

catalogue number	L	W1	S
TM41ENBLANK	41,00	9,95	4,76

TM41 Inserts

materials	Brinell	surface speeds		indexable inserts
steel	HB	KC610M	KC635M	feed fz (mm/tooth)
P1	125	100–210	90–180	0,05–0,20
P2	180	100–170	90–160	0,05–0,20
P3	225	60–130	70–115	0,05–0,20
P4	250	80–150	80–160	0,05–0,20
P5	275	75–130	80–160	0,05–0,15
P6	325	70–110	60–100	0,05–0,10
stainless steel				
M1	180	100–170	120–180	0,05–0,10
M2	250	70–140	100–140	0,05–0,10
M3	330	70–120	100–120	0,05–0,10
cast iron				
K1	180	60–130	100–120	0,02–0,08
K2	220	60–125	80–100	0,05–0,15
K3	260	50–90	60–90	0,05–0,10
non-ferrous				
N1	60–100	100–250	–	0,05–0,25
high-temp alloys				
S1	200	20–45	20–40	0,05–0,10
S2	250	20–30	20–30	0,02–0,05
S3	280	15–20	15–20	0,02–0,05
S4	350	10–15	10–15	0,02–0,05
hardened steel				
H1	55 HRC	20–45	20–45	0,01–0,03

NOTE: Use Kennametal thread mill software:
TM-CNC Generator for CNC Programming on our website under: **http://www.kennametal.com/en/resources/software.html**.

KTMD U Series

Primary Application

With a wide range of insert thread sizes and grades for most materials, KTMD U is a multiflute, single-point, high-productivity, and economical solution for milling threads in deep-hole applications.



Features and Benefits

Smooth Cutting Action

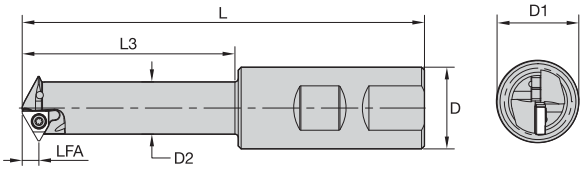
- Reduced load on the cutting edges due to single-point insert.
- Low cutting forces enable fast machining.
- Suitable for hard material applications.
- Wide range of applications, with partial profile insert (60°/55°).
- Pitch range 16–3 TPI (1,5–8mm).

Cost-Effective Solution

- Up to three cutting edges per insert.
- Very high feed per tooth.
- Fast machining.
- Multiflute — up to 7 cutting edges (inserts).

Comprehensive cutter bodies offering:

- Weldon®, steel, carbide, and shell mill cutters available.
- Long overhang capability.
- Through coolant capability.
- Diameter range 14,75–42mm (42–56mm shell mills).
- Improved chip evacuation and cooling.

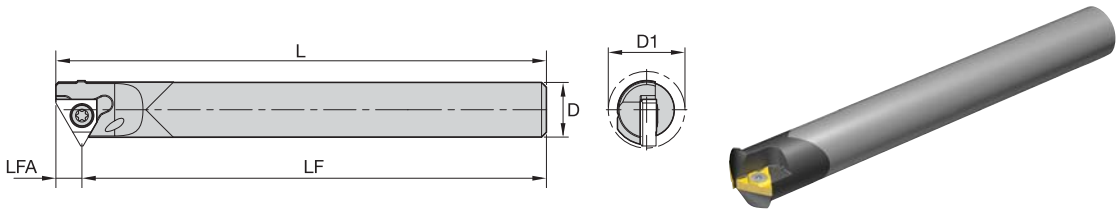




Thread Mill • U Style • Weldon® Shank • 1/4" IC

order number	catalogue number	D1	D	D2	L	L3	LFA	Z	max RPM	insert screw	Torx driver
5593078	KTMDUWD15L040Z1	14,75	16,00	11,00	95,00	45,40	5,40	1	7970	KTMDUSCREW1	DT8
5593079	KTMDUWD20L060Z2	20,65	25,00	16,00	123,00	65,40	5,40	2	6740	KTMDUSCREW1	DT8
5593100	KTMDUWD23L070Z2	23,00	25,00	17,70	135,00	75,40	5,40	2	6380	KTMDUSCREW1	DT8
5593101	KTMDUWD26L080Z3	26,00	25,00	20,40	147,00	85,40	5,40	3	6000	KTMDUSCREW1	DT8
5593103	KTMDUWD31L095Z4	31,00	32,00	25,40	164,00	100,40	5,40	4	5500	KTMDUSCREW1	DT8

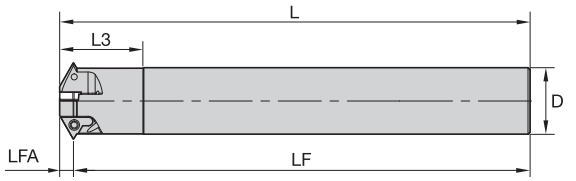
		Thread Application per Toolholder min thread Ø						
toolholder	D1 mm	ISO (coarse)	ISO (fine)	UNC	UN/UNF/ UNEF/UNS	BSP (G)	partial 55°	Trapez
KTMDUWD15L040Z1	14,75	M18 x 2.5; M24 x 3.0	M16 x 0.5; M16 x 0.75; M16 x 1.0; M17 x 1.25; M17 x 1.5; M17 x 2.0	3/4–10	5/8–32UN; 5/8–28UN; 5/8–27UNS; 11/16–24UN; 11/16–20UN; 11/16–16UN; 3/4–14UNS; 3/4–12UN	3/8–19; 1/2–14; 1–11	11/16–14; 3/4–12; 7/8–11; 3/4–10; 1–8; 1 1/8–7	TR22 x 3; TR24 x 3
KTMDUWD20L060Z2	20,65	M24 x 3.0; M30 x 3.5	M22 x 0.5; M22 x 0.75; M22 x 1.0; M23 x 1.25; M23 x 1.5; M23 x 2.0	1–8UNC; 1 1/8 7 UNC; 1 3/8 6UNC	7/8–32UN; 7/8–28UN; 7/8–27UNS; 7/8–24UNS; 7/8–20UNEF; 1–18UNS; 15/16–16UN; 1–14UNS; 15/16–12UN; 1/10UNS	3/4–14; 1–11	1–26; 1–20; 1–16; 1–12; 1–10; 1 1/8–9; 1–8; 1 1/8–7	(TR26–TR60 x 3)
KTMDUWD23L070Z2	23,00	M27 x 3.0; M30 x 3.5; M36 x 4.0	M24 x 0.5; M24 x 0.75; M25 x 1.0; M25 x 1.25; M26 x 1.5; M26 x 2.0; M27 x 2.5	1 1/8–7	1–32UN; 1–28UN; 1–27UNS; 1–24UNS; 1–20UNEF; 1–18UNS; 1–16UN; 1–14UNS; 1–12UNF; 1 1/8–10UN; 1 1/8–8UN	3/4–14; 1–11	1–26; 1–20; 1–16; 11/16–12; 1 1/8–9; 1 1/8–7	–
KTMDUWD26L080Z3	26,00	M30 x 3.5; M36 x 4.0	M27 x 0.5; M27 x 0.75; M28 x 1.0; M28 x 1.25; M28 x 1.5; M29 x 2.0; M30 x 2.5; M30 x 3.0	1 1/4–7; 1 3/8–6	1 1/8–28UN; 1 1/8–24UNS; 1 1/8–20UN; 1 1/8–18UNEF; 1 1/8–16UN; 1 1/8–14UNS; 1 1/8–12UNF; 1 1/4–10UNS; 13/16–8UN	7/8–14; 1–11	1 1/8–26; 1 1/8–20; 1 3/8–16; 1 3/8–12; 1 3/16–8; 1 1/4–7	–
KTMDUWD31L095Z4	31,00	M36 x 4.0	M32 x 0.5; M32 x 0.75; M33 x 1.0; M33 x 1.25; M33 x 1.5; M34 x 2.0; M34 x 2.5; M35 x 3.0; M36 x 3.5	1 1/2–6	15/16–28UN; 1 3/8–24UNS; 15/16–20UN; 15/16–18UNEF; 15/16–16UN; 1 3/8–14UNS; 1 3/8–12UNF; 1 3/8–10UNS; 1 3/8–8UN	1 1/8–11	1 3/8–26; 1 3/8–20; 1 3/8–16; 1 3/8–12; 1 7/16–8	–



Thread Mill • U Style • Carbide Cylindrical Shank • 1/4" IC

order number	catalogue number	D1	D	L	L3	LF	LFA	Z	max RPM	insert screw	Torx driver
5593122	**KTMDUCD15L060Z1**	14,75	10,70	120,00	65,40	114,60	5,40	1	7970	**KTMDUSCREW1**	**DT8**
5593123	**KTMDUCD17L065Z2**	17,20	14,00	132,00	68,40	128,60	3,40	2	7380	**KTMDUSCREW1**	**DT8**
5593124	**KTMDUCD20L080Z2**	20,65	16,00	135,00	85,40	129,60	5,40	2	6740	**KTMDUSCREW1**	**DT8**

Thread Application per Toolholder min thread Ø									
toolholder	D1	ISO (coarse)	ISO (fine)	UNC	UN/UNF/ UNEF/UNS	BSP(G)	partial 55°	Trapez
KTMDUCD15L060Z1	14,75	M18 x 2.5; M24 x 3.0; M30 x 3.5; M36 x 4.0	M16 x 0.5; M16 x 0.75; M16 x 1.0; M17 x 1.25; M17 x 1.5; M17 x 2.0	3/4–10; 7/8–9; 1 1/8–7; 1 3/8–6	5/8–32UN; 5/8–28UN; 5/8–28UNS; 11/16–24UNEF; 11/16–20 UN; 11/16–16UN; 3/4–UNS; 11/16–12UN	1/2–14; 1–11	11/16–26; 11/16–20; 11/16–16; 11/16–14; 3/4–12; 7/8–11; 3/4–10; 7/8–9; 1–8; 1 1/8–7	TR22 x 3; TR24 x 3; TR20 x 4; TR22 x 5; TR24 x 5; TR26 x 5; TR28 x 5
KTMDUCD17L065Z2	17,20	M20 x 2.5; M22 x 2.5	M21 x 2.0	7/8–9	7/8–10UNS; 13/16–12UN	–	–	–
KTMDUCD20L080Z2	20,65	M24 x 3.0; M30 x 3.5; M36 x 4.0	M22 x 0.5; M22 x 0.75; M22 x 1.0; M23 x 1.25; M23 x 1.5; M23 x 2.0	1–8; 1 1/8–7; 1 3/8–6	7/8–32UN; 7/8–28UN; 7/8–27 UNSL; 7/8–24UNS; 7/8–20UNEF; 1–18–UNS; 15/16–16UN; 1–14UNS; 12UN;15/16–12UN; 1–10UNS	3/4–14; 1–11	1–26; 1–20; 1–16; 1–12; 1–10; 1 1/8–9; 1–8; 1 1/8–7	(TR26–TR60) x 3; TR28 x 4; (TR65–TR110) x 4; TR28 x 5



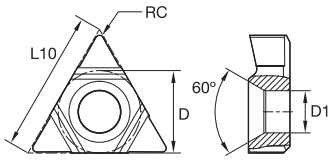


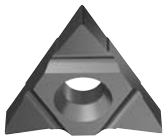
Thread Mill • U Style • Steel Cylindrical Shank • 1/4" IC




order number	catalogue number	D1	D	L	L3	LF	LFA	Z	max RPM	insert screw	Torx driver
5593128	KTMDUED23L086Z2	23,30	18,00	166,00	91,40	160,60	5,40	2	6340	KTMDUSCREW1	DT8
5593129	KTMDUED26L105Z3	26,00	20,00	186,00	110,40	180,60	5,40	3	6000	KTMDUSCREW1	DT8
5593131	KTMDUED31L115Z4	31,00	25,00	196,00	120,40	190,60	5,40	4	5500	KTMDUSCREW1	DT8

Thread Application per Toolholder min thread Ø							
toolholder	D1 mm	ISO (coarse)	ISO (fine)	UNC	UN/UNF/ UNEF/UNS	BSP(G)	partial 55°
KTMDUED23L086Z2	23,30	M27 x 3.0; M30 x 3.5; M36 x 4.0	M24 x 0.5; M25 x 0.75; M25 x 1.0; M25 x 1.25; M26 x 1.5; M26 x 2.0; M27 x 2.5	1 1/8–7	1–32UN; 1–28UN; 1–27UN; 1–24UNS; 1–20UNEF; 1–18UNS; 1–16UN; 1–14UNS; 11/16–12UN; 1 1/8–10UNS; 1 1/8–8UN	3/4–14; 1–11	1–26; 1–20; 1 1/8–16; 1 1/8–12; 1 1/8–9; 1 1/8–7
KTMDUED26L105Z3	26,00	M30 x 3.5; M36 x 4.0	M27 x 0.5; M27 x 0.75; M28 x 1.0; M28 x 1.25; M28 x 1.5; M29 x 2.0; M30 x 2.5; M30 x 3.0	1 1/4–7; 1 3/8–6	1 1/8–28UN; 1 1/8–24UNS; 1 1/8–20UN; 1 1/8–18UNEF; 1 1/8–16UN; 1 1/8–14UNS; 1 1/8–12UNF; 1 3/8–10UNS; 1 7/16–8UN	7/8–14; 1–11	1 1/8–26; 1 1/8–20; 13/16–16; 13/16–12; 13/16–8; 1 1/4–7
KTMDUED31L115Z4	31,00	M36 x 4.0	M32 x 0.5; M32 x 0.75; M33 x 1.0; M33 x 1.25; M33 x 1.5; M34 x 2.0; M34 x 2.5; M35 x 3.0; M36 x 3.5	1 1/2–6	15/16–28UN; 1 1/2–24UNS; 1 1/2–20UN; 1 1/2–18UNEF; 1 3/8–16UN; 1 3/8–14UNS; 1 3/8–12UNF; 1 3/8–10UNS; 1 7/16–8UN	1 1/8–11	15/16–26; 15/16–20; 1 3/8–16; 1 3/8–12; 1 7/16–8





● first choice
○ alternate choice

P		●	○
M		○	●
K		●	
N		●	
S			●
H		○	●

KTMD • 1/4" IC • Partial Profile 60°

catalogue number	Thread Pitch min	Thread Pitch max	TPI min	TPI max	D1	D	L10	RC	KC610M	KC635M
KTMDU11L0515N60	0.5	1.5	16	48	3,25	6,35	11,00	0,05	●	●
KTMDU11L1520N60	1.5	2.0	12	16	3,25	6,35	11,00	0,06	●	●
KTMDU11L2025N60	2.0	2.5	9	12	2,61	6,35	11,00	0,11	●	●
KTMDU11L2540N60	2.5	4.0	6	10	3,25	6,35	11,00	0,14	●	●
KTMDU11L2525N60	2.5	2.5	10	10	2,09	6,35	11,00	0,11	●	●

NOTE: KTMDU11L2525N60 can only be used with holder KTMDUCD17L065Z2.

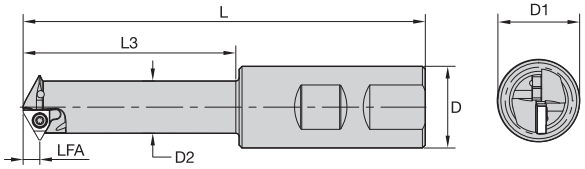
KTMD • 1/4" IC • Partial Profile 55°

catalogue number	TPI min	TPI max	D1	D	L10	RC	KC610M	KC635M
KTMDU11L1107N55	7	11	3,25	6,35	11,00	0,24	●	●
KTMDU11L1612N55	12	16	3,25	6,35	11,00	0,08	●	●
KTMDU11L4816N55	16	48	3,25	6,35	11,00	0,11	●	●

KTMD • 1/4" IC

materials	Brinell	surface speeds		indexable inserts
steel	HB	KC610M	KC635M	feed fz (mm/tooth)
P1	125	100–210	90–180	0,05–0,20
P2	180	100–170	90–160	0,05–0,20
P3	225	60–130	70–115	0,05–0,20
P4	250	80–150	80–160	0,05–0,20
P5	275	75–130	80–160	0,05–0,15
P6	325	70–110	60–100	0,05–0,10
stainless steel				
M1	180	100–170	120–180	0,05–0,10
M2	250	70–140	100–140	0,05–0,10
M3	330	70–120	100–120	0,05–0,10
cast iron				
K1	180	60–130	100–120	0,02–0,08
K2	220	60–125	80–100	0,05–0,15
K3	260	50–90	60–90	0,05–0,10
non-ferrous				
N1	60–100	100–250	–	0,05–0,25
high-temp alloys				
S1	200	20–45	20–40	0,05–0,10
S2	250	20–30	20–30	0,02–0,05
S3	280	15–20	15–20	0,02–0,05
S4	350	10–15	10–15	0,02–0,05
hardened steel				
H1	55 HRC	20–45	20–45	0,01–0,03

NOTE: Use Kennametal thread mill software:
TM-CNC Generator for CNC Programming on our website under: **http://www.kennametal.com/en/resources/software.html**.

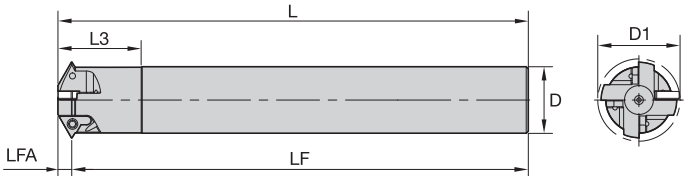




Thread Mill • U Style • Weldon® Shank • 3/8" IC

order number	catalogue number	D1	D	D2	L	L3	LFA	Z	max RPM	insert screw	Torx Plus driver
5593102	KTMDUWD36L095Z3	36,50	32,00	29,00	166,00	103,00	8,00	3	3900	KTMDUSCREW2	DT3IP
5593104	KTMDUWD42L120Z4	42,00	40,00	34,20	201,00	128,00	8,00	4	3430	KTMDUSCREW2	DT3IP

	Thread Application per Toolholder min thread Ø						
toolholder	D1 mm	ISO (coarse)	ISO (fine)	UNC	UN/UNF/ UNEF/UNS	BSP(G)	partial 55°
KTMDUWD36L095Z3	36,50	M42 x 4.5; M48 x 5.0; M56 x 5.5; M64 x 6.0	M39 x 1.5; M39 x 2.0; M40 x 2.5; M41 x 3.0; M42 x 3.5; M42 x 4.0	1 3/4–5; 2–4.5; 2 1/2–4	1 9/16–16UN; 1 5/8–14UNS; 1 9/16–12UN; 1 5/8–10UNS; 1 5/8–8UN; 1 5/8–6UN	1 1/4–11	1 5/8–16; 1 5/8–2 1 5/8–8; 2 1/4–6; 1 3/4–5
KTMDUWD42L120Z4	42,00	M48 x 5.0; M56 x 5.5; M64 x 6.0	M45 x 1.5; M45 x 2.0; M46 x 2.5; M48 x 3.0; M48 x 3.5; M48 x 4.0	2–4.5; 2 1/4–4	1 3/4–16UN;1 3/4–14UNS; 1 13/16–12UN; 113/16–8UN; 1 15/16–6UN	1 1/2–11	1 7/8–16; 1 7/8–12; 1 7/8–8; 1 7/8–6; 2–4.5

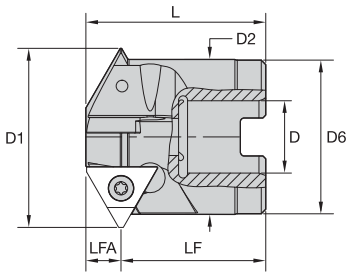


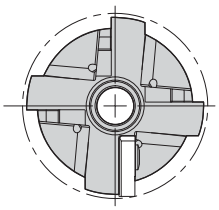


Thread Mill • U Style • Steel Cylindrical Shank • 3/8" IC

order number	catalogue number	D1	D	L	L3	LF	LFA	Z	max RPM	insert screw	Torx Plus driver
5593130	KTMDUED36L144Z3	36,50	28,00	222,00	152,00	214,00	8,00	3	3680	KTMDUSCREW2	DT3IP

	Thread Application per Toolholder min thread Ø						
toolholder	D1	ISO (coarse)	ISO (fine)	UNC	UN/UNF/ UNEF/UNS	BSP(G)	partial 55°
KTMDUED36L144Z3	36,50	M42.5 x 4.5; M48 x 5.0; M56 x 5.5; M64 x 6.0	M39 x 1.5; M40 x 2.5; M41 x 3.0; M42 x 3.5; M42 x 4.0	1 3/4–5; 2–4.5; 2 1/2–4	1 9/16–16UN; 1 5/8–14UNS; 1 9/16–12UN; 1 5/8–10UNS; 1 5/8–UN; 1 5/8–6UN	1 1/4–11	1 5/8–16; 1 5/8–12; 1 5/8–8; 2 1/4–6; 1 3/4–5







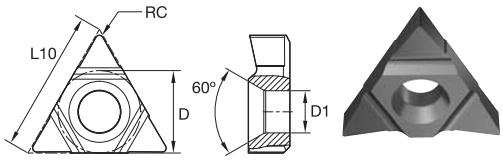
Thread Mill • U Style • Shell Mill • 3/8" IC





order number	catalogue number	D1	D	D2	D6	L	LF	LFA	Z	max RPM	insert screw	Torx Plus driver
5593136	KTMDUSD42L400Z4	41,00	16,00	34,50	34,00	40,00	32,00	7,80	4	3430	KTMDUSCREW2	DT3IP
5593137	KTMDUSD48L400Z5	47,00	22,00	39,50	39,30	40,00	32,00	8,00	5	3210	KTMDUSCREW2	DT3IP
5593138	KTMDUSD56L400Z6	55,00	22,00	48,00	47,20	39,80	32,00	7,80	6	2970	KTMDUSCREW2	DT3IP

Thread Application per Toolholder min thread Ø							
toolholder	D1 mm	ISO (coarse)	ISO (fine)	UNC	UN/UNF/ UNEF/UNS	BSP (G)	partial 55°
KTMDUSD42L400Z4	42,00	M48 x 5.0; M56 x 5.5; M64 x 6.0	M45 x 1.5; M45 x 2.0; M46 x 2.5; M48 x 3.0; M48 x 3.5; M48 x 4.0	2–4.5; 2 1/2–4	1 3/4–16UN; 1 3/4–14UNS; 1 13/16–12UN; 1 13/16–8UN; 1 15/16–6UN	1 1/2–11	1 7/8–16; 1 7/8–12; 1 7/8–8; 1 7/8–6; 2–4.5
KTMDUSD48L400Z5	48,00	M56 x 5.5; M64 x 6.0	M52 x 1.5; M52 x 2.0; M52 x 2.5; M52 x 3.0; M55 x 4.0	2 1/4–4.5; 2 1/2–4	2–16UN; 2–14UN; 2–12UN; 2 1/4–10UNS; 2 1/8–8UN; 2 1/8–6UN	1 3/4–11	2–16; 2 1/4–12; 2 1/4–8; 2 1/4–6; 3–5; 3 1/2–4.5; 2 1/4–4
KTMDUSD56L400Z6	56,00	M64 x 6.0	M60 x1.5; M60 x 2.0; M60 x 2.5; M60 x 3.0; M64 x 4.0	2 1/2–4	2 3/8–16UN; 2 3/8–14UN; 2 3/8–12UN; 2 1/2–10UNS; 2 3/8–8UN; 2 1/2–6UN	2–11	2 1/2–16; 2 1/2–12; 2 1/2–8; 2 3/4–6; 3–5; 3 1/2–4.5; 4 1/4–4



● first choice
○ alternate choice

P		●	○
M		○	●
K		●	
N		●	
S			●
H		○	●

KTMD • 3/8" IC • Partial Profile 60°

catalogue number	Thread Pitch min	Thread Pitch max	TPI min	TPI max	D1	D	L10	RC	KC610M	KC635M
KTMDU16L1520N60	1.5	2.0	12	16	3,85	9,53	16,00	0,06	●	●
KTMDU16L2535N60	2.5	3.5	7	10	3,85	9,53	16,00	0,14	●	●
KTMDU16L4060N60	4.0	6.0	4	6	3,85	9,53	16,00	0,25	●	●

KTMD • 3/8" IC • Partial Profile 55°

catalogue number	TPI min	TPI max	D1	D	L10	RC	KC610M	KC635M
KTMDU16L0604N55	5	6	3,85	9,53	16,00	0,27	●	●
KTMDU16L1107N55	7	11	3,85	9,53	16,00	0,24	●	●
KTMDU16L1612N55	12	16	3,85	9,53	16,00	0,08	●	–

KTMD • 3/8" IC

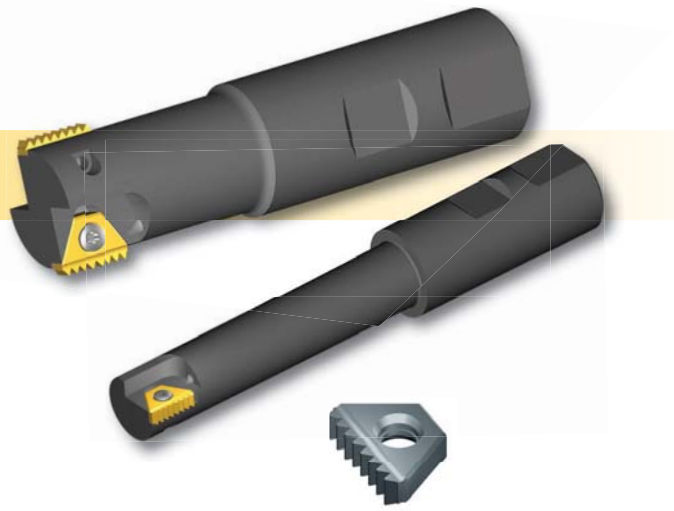
materials	Brinell	surface speeds		indexable inserts
steel	HB	KC610M	KC635M	feed fz (mm/tooth)
P1	125	100–210	90–180	0,05–0,20
P2	180	100–170	90–160	0,05–0,20
P3	225	60–130	70–115	0,05–0,20
P4	250	80–150	80–160	0,05–0,20
P5	275	75–130	80–160	0,05–0,15
P6	325	70–110	60–100	0,05–0,10
stainless steel				
M1	180	100–170	120–180	0,05–0,10
M2	250	70–140	100–140	0,05–0,10
M3	330	70–120	100–120	0,05–0,10
cast iron				
K1	180	60–130	100–120	0,02–0,08
K2	220	60–125	80–100	0,05–0,15
K3	260	50–90	60–90	0,05–0,10
non-ferrous				
N1	60–100	100–250	–	0,05–0,25
high-temp alloys				
S1	200	20–45	20–40	0,05–0,10
S2	250	20–30	20–30	0,02–0,05
S3	280	15–20	15–20	0,02–0,05
S4	350	10–15	10–15	0,02–0,05
hardened steel				
H1	55 HRC	20–45	20–45	0,01–0,03

NOTE: Use Kennametal thread mill software:
TM-CNC Generator for CNC Programming on our website under: **http://www.kennametal.com/en/resources/software.html**.

TMS Series

Primary Application

The TMS series, a Kennametal Thread Milling System, is a versatile thread milling product with proven solutions. This tool is specially designed for internal and external threading on most types of workpiece materials. The cutter body utilises inserts with various profiles and pitches.



Features and Benefits

Proven solution and versatile indexable thread milling product family.

Comprehensive Offering of Cutter Bodies

- Standard Weldon®, Mini Weldon, long-thread Weldon, conical shank, and double-sided Weldon cutters are available.
- One tool is used for both right- and left-hand threads.
- All cutters have through coolant capability.

Double-Sided Weldon Cutter Bodies

- Provides faster machining capabilities.
- Good surface finish.

Inserts:

- Insert grades for most workpiece materials.
- Inserts for ISO, UN, BSPT, and NPT thread profiles.
- Indexable inserts.
- Economical and cost effective.
- Versatile application.

Internal Threads • Insert and Holder Recommendations

thread	tap hole fl (mm)	indexable insert	largest milling cutter
M11 x 0,75	10,19	STN10075ISO-I	9X1R .. STN10M
M12	10,11	STN10175ISO-I-C	9X1R015B20-STN10C
M12 x 1,00	10,92	STN10100ISO-I	9X1R .. STN10M
M14	11,84	STN11200ISO-I-C	11X1R .. STN11N
M16	13,84	STN11200ISO-I-C	11X1R .. STN11N
M20	17,29	STN16250ISO-I-C	15X1R020B16-STN16C
M20 x 1,50	18,38	STN11150ISO-I	11X1R .. STN11N
M20 x 1,00	18,92	STN11100ISO-I	11X1R .. STN11N
M24	20,75	STN22300ISO-I-C	18X1R030B25-STN22C
M24 x 2,00	21,84	STN16200ISO-I	17X1R022B16-STN16N
M24 x 1,50	22,38	STN11150ISO-I	11X1R .. STN11N
M24 x 1,50	22,38	STN16150ISO-I	17X1R022B16-STN16N
M27	23,75	STN22300ISO-I-C	18X1R030B25-STN22C
M30	26,21	STN27350ISO-I-C	25X1R040B25-STN27C
M30 x 2,00	27,84	STN16200ISO-I	22X1R025B25-STN16L
M33	29,21	STN27350ISO-I-C	25X1R040B25-STN27C
M33 x 2,00	30,84	STN16200ISO-I	22X1R025B25-STN16L
M33 x 1,50	31,38	STN16150ISO-I	22X1R025B25-STN16L
M35 x 1,50	33,38	STN16150ISO-I	22X1R025B25-STN16L
M36 x 2,00	33,84	STN16200ISO-I	22X1R025B25-STN16L
M42 x 2,00	39,84	STN27200ISO-I	30X1R052B25-STN27N
M45 x 2,00	42,84	STN27200ISO-I	37X1R .. STN27N or L
M48 x 2,00	45,84	STN27200ISO-I	37X1R058B32-STN27N or L
M55 x 2,00	52,84	STN27200ISO-I	37X1R .. STN27N or L
M56 x 2,00	53,84	STN27200ISO-I	37X1R .. STN27N or L
M72 x 2,00	69,84	STN27200ISO-I	37X1R .. STN27N or L

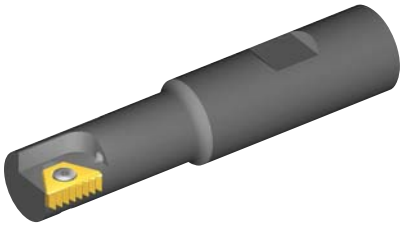
Internal Threads • Insert and Holder Recommendations

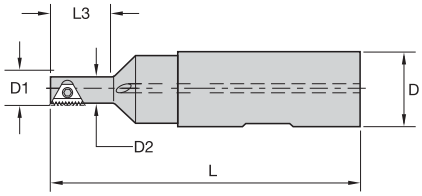
thread	tap hole fl (mm)	indexable insert	largest milling cutter
9/16 - 18UNF	12,76	STN1018UN-I	9X1R .. STN10M
5/8 - 24UNEF	14,73	STN1124UN-I	11X1R .. STN11N
5/8 - 18UNF	14,35	STN1118UN-I	11X1R .. STN11N
3/4 - 20UNEF	17,68	STN1120UN-I	11X1R .. STN11N
3/4 - 16UNF	17,33	STN1116UN-I	11X1R .. STN11N
7/8 - 14UNF	20,26	STN1114UN-I	11X1R .. STN11N
1 - 16UN	23,68	STN1616UN-I	18X1R030B25-STN22C
1 - 12UNF	23,11	STN1612UN-I	17X1R .. STN16N
1 1/8 - 12UNF	26,28	STN1612UN-I	22X1R .. STN16L
1 1/4 - 12UNF	29,46	STN1612UN-I	22X1R .. STN16L
1 3/8 - 12UNF	32,63	STN1612UN-I	22X1R .. STN16L

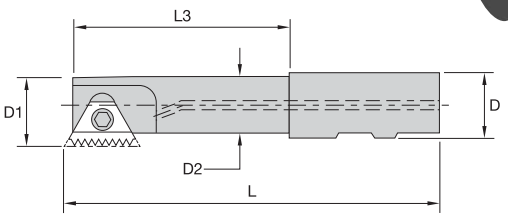
Whitworth Pipe Thread (Internal) to DIN 259

thread	tap hole fl (mm)	indexable insert	largest milling cutter
R 5/8	20,59	STN1614BSW	17X1R022B16-STN16N
R 3/4	24,12	STN1614BSW	20X1R043B20-STN16N
R 7/8	27,88	STN1614BSW	22X1R025B25-STN16L
R 1	30,29	STN1611BSW	22X1R025B25-STN16L

- For internal and external threading on most types of workpiece materials.
- One tool is used for both right-hand and left-hand threads.
- All cutters have through-coolant capability.
- Utilises inserts with various profiles and pitches.







Thread Mill • Mini

order number	catalogue number	D1	D	D2	L	L3	Z	max RPM	insert 1	insert screw	Nm	Torx driver
1132616	**9X1R012B12STN10M**	9,00	12,00	6,80	69,00	12,00	1	39935	STN10	**SN7T**	1,7	**DT7**
1191395	**9X1R017B20STN10M**	9,00	20,00	6,80	84,00	17,00	1	39935	STN10	**SN7T**	1,7	**DT7**

Thread Mill • Normal Shank • STN11

order number	catalogue number	D1	D	D2	L	L3	Z	max RPM	insert 1	insert screw	Nm	Torx driver
1294964	**11X1R012B12STN11N**	11,50	12,00	8,90	70,00	12,00	1	36825	STN11	**SN2TPKG**	1,7	**DT8**
1130302	**11X1R020B20STN11N**	11,50	20,00	8,90	85,00	20,00	1	36825	STN11	**SN2TPKG**	1,7	**DT8**

Thread Mill • Normal Shank • STN16

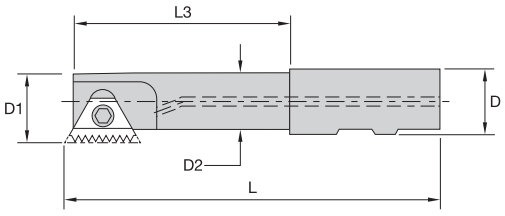
order number	catalogue number	D1	D	D2	L	L3	Z	max RPM	insert 1	insert screw	Nm	Torx driver
1130686	**17X1R022B16STN16N**	17,00	16,00	13,60	90,00	22,00	1	25750	STN16	**SN3TM**	2,3	**DT10**
1130740	**20X1R043B20STN16N**	20,00	20,00	16,60	95,00	43,00	1	23330	STN16	**SN3TPKG**	2,3	**DT10**

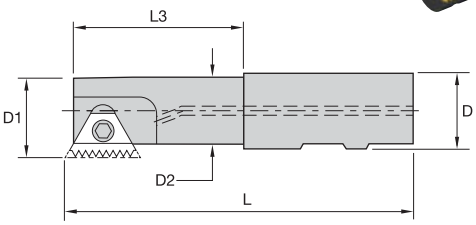
Thread Mill • Normal Shank • STN27

order number	catalogue number	D1	D	D2	L	L3	Z	max RPM	insert 1	insert screw	Nm	Torx wrench
1130969	**30X1R052B25STN27N**	30,00	25,00	24,00	110,00	52,00	1	12900	STN27	**SN5TM**	5,0	**TT25**
1131069	**37X1R058B32STN27N**	37,00	32,00	27,00	120,00	58,00	1	11600	STN27	**SN5TM**	5,0	**TT25**

- For internal and external threading on most types of workpiece materials.
- One tool is used for both right- and left-hand threads.
- All cutters have through-coolant capability.
- Utilises inserts with various profiles and pitches.







Thread Mill • Normal Shank • STN.38



order number	catalogue number	D1	D	D2	L	L3	Z	max RPM	insert 1	insert screw	Nm	Torx wrench
1178986	35X1R055B32STNB38N	35,00	32,00	31,00	115,00	55,00	1	11000	STNB38	SM7TPKG	6,5	TT30

Thread Mill • Long Shank • STN16



order number	catalogue number	D1	D	D2	L	L3	Z	max RPM	insert 1	insert screw	Nm	Torx driver
1130837	22X1R025B25STN16L	22,00	25,00	18,60	125,00	25,00	1	22230	STN16	SN3TPKG	2,3	DT10

Thread Mill • Long Shank • STN27



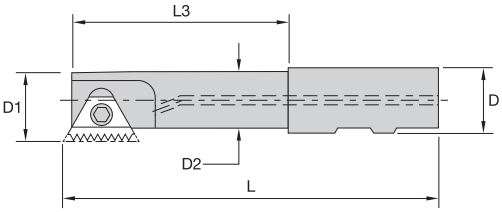
order number	catalogue number	D1	D	D2	L	L3	Z	max RPM	insert 1	insert screw	Nm	Torx wrench
1130977	30X1R092B25STN27L	30,00	25,00	24,00	150,00	92,00	1	12900	STN27	SN5TM	5,0	TT25
1131086	37X1R098B32STN27L	37,00	32,00	31,00	160,00	98,00	1	11600	STN27	SN5TM	5,0	TT25

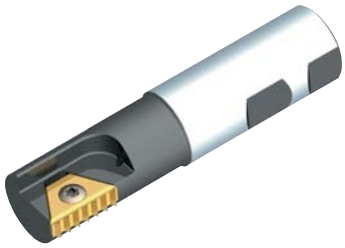
Thread Mill • Long Shank • STN38



order number	catalogue number	D1	D	D2	L	L3	Z	max RPM	insert 1	insert screw	Nm	Torx wrench
1566071	46X1R100B40STNB38L	46,00	40,00	38,00	170,00	100,00	1	10000	STNB38	SM7TPKG	6,5	TT30

- Thread Milling System.



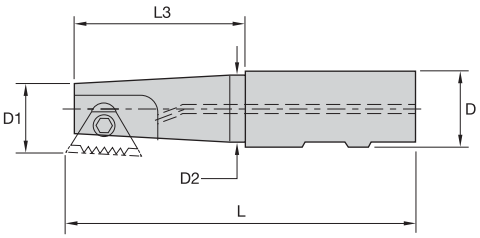


Thread Mill • Internal Coarse Pitch Thread

order number	catalogue number	D1	D	D2	L	L3	Z	max RPM	insert 1
1176964	**15X1R020B16STN16C**	15,50	16,00	12,200	91,00	–	1	26550	STN16___C
1176967	**25X1R040B25STN27C**	25,00	25,00	19,000	98,00	40,00	1	22000	STN27___C

Spare Parts

D1	 insert screw	 Nm	 Torx driver	 Torx wrench
15,50	**SN3TPKG**	2,30	**DT10**	**–**
25,00	**SN5TM**	5,00	**–**	**TT25**





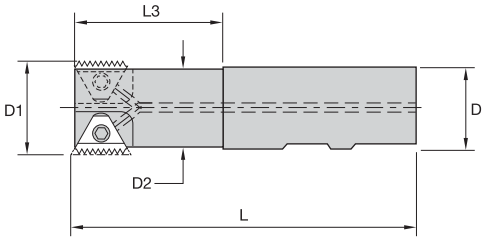
Thread Mill • Tapered Shank • Right Hand

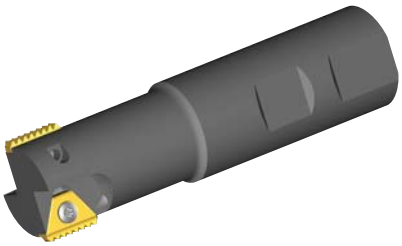
order number	catalogue number	D1	D	D2	L	L3	Z	max RPM	insert 1
1176970	**10X1R015B20STN11T**	9,90	20,00	7,40	77,00	15,50	1	36500	STN11
1132781	**15X1R022B16STN16T**	15,50	16,00	12,50	80,00	22,00	1	26550	STN16
1135826	**19X1R023B20STN16T**	19,00	20,00	15,00	85,00	23,00	1	24350	STN16

Spare Parts

D1	 insert screw	 Nm	 Torx driver
9,90	**SN2TPKG**	1,70	**DT8**
15,50	**SN3TPKG**	2,30	**DT10**
19,00	**SN3TM**	2,30	**DT10**

- Cutting diameter ranges from 26–42mm.
- For internal and external threading on most types of workpiece materials.
- One tool is used for both right- and left-hand threads.
- All cutters have through-coolant capability.
- Utilises inserts with various profiles and pitches.



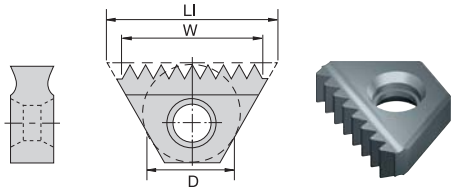


Thread Mill • Double Insert

order number	catalogue number	D1	D	D2	L	L3	Z	max RPM	insert 1
1124019	**26X2R043B25STN16D**	26,00	25,00	22,50	100,00	43,00	2	20530	STN16
1131118	**42X2R045B32STN27D**	42,00	32,00	36,00	120,00	45,00	2	10900	STN27

Spare Parts

D1	 insert screw	 Nm	 Torx driver	 Torx wrench
26,00	**SN3TPKG**	2,30	**DT10**	**–**
42,00	**SN5TM**	5,00	**–**	**TT25**



● first choice
○ alternate choice

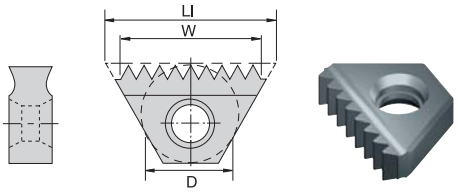
		KC610M	KC620M	KC635M
P		●	○	○
M		○	●	●
K		●		
N		●		
S			●	●
H			●	●

Internal • UN Thread • Unified Thread Standard Style

catalogue number	TPI	D	LI	W	number of teeth	KC610M	KC620M	KC635M
STN1018UNI	18	6,00	10,41	8,38	6	–	–	●
STN1020UNI	20	6,00	10,41	8,89	7	–	–	●
STN1114UNI	14	6,35	10,92	9,14	5	–	–	●
STN1116UNI	16	6,35	10,92	9,65	6	–	–	●
STN1118UNI	18	6,35	10,92	9,91	7	–	–	●
STN1120UNI	20	6,35	10,92	10,16	8	–	–	●
STN1124UNI	24	6,35	10,92	9,65	9	–	–	●
STN1612UNI	12	9,53	16,00	14,73	7	–	–	●
STN1614UNI	14	9,53	16,00	14,48	8	–	–	●
STN1616UNI	16	9,53	16,00	14,22	9	●	–	–
STN1624UNI	24	9,53	16,00	14,73	14	–	–	●
STN1627UNI	27	9,53	16,00	14,22	15	–	–	●
STN1632UNI	32	9,53	16,00	14,99	9	–	–	●

External • UN Thread • Unified Thread Standard Style

catalogue number	TPI	D	LI	W	number of teeth	KC610M	KC620M	KC635M
STN1118UNE	18	6,35	10,92	9,91	7	–	–	●
STN1614UNE	14	9,53	16,00	14,48	8	–	–	●
STN1616UNE	16	9,53	16,00	14,22	9	–	–	●
STN1620UNE	20	9,53	16,00	13,97	11	–	–	●
STN1624UNE	24	9,53	16,00	14,73	14	–	–	●



● first choice
○ alternate choice

		KC610M	KC620M	KC635M
P		●	○	○
M		○	●	●
K		●		
N		●		
S			●	●
H			●	●

Internal • ISO Thread • ISO Metric Screw Thread Style

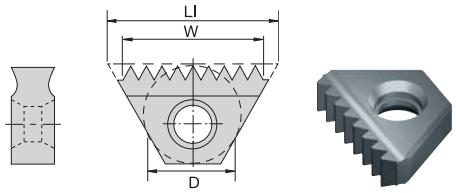
catalogue number	thread pitch mm	D	LI	W	number of teeth	KC610M	KC620M	KC635M
STN10075ISOI	0,75	6,00	10,41	9,65	13	–	–	●
STN10100ISOI	1,0	6,00	10,41	8,89	9	–	●	●
STN10150ISOI	1,5	6,00	10,41	8,89	6	–	–	●
STN10125ISOI	1,25	6,00	10,41	8,64	7	–	–	●
STN11100ISOI	1,0	6,35	10,92	9,91	10	–	–	●
STN11150ISOI	1,5	6,35	10,92	10,41	7	–	–	●
STN16100ISOI	1,0	9,53	16,00	14,99	15	–	–	●
STN16150ISOI	1,5	9,53	16,00	14,99	10	–	–	●
STN16175ISOI	1,75	9,53	16,00	13,97	8	–	–	●
STN16200ISOI	2,0	9,53	16,00	13,97	7	–	–	●

External • ISO Thread • Metric Screw Thread Style • Coarse

catalogue number	thread pitch mm	D	LI	W	number of teeth	KC610M	KC620M	KC635M
STN22300ISOIC	3,0	12,70	22,10	18,00	6	●	–	–
STN27350ISOIC	3,5	15,88	26,92	24,50	7	●	–	–

External • ISO Thread • ISO Metric Screw Thread Style

catalogue number	thread pitch mm	D	LI	W	number of teeth	KC610M	KC620M	KC635M
STN16150ISOE	1,5	9,53	16,00	14,99	10	●	●	–
STN27200ISOE	2,0	15,88	26,92	23,88	12	●	–	–



● first choice
○ alternate choice

P		●	○	○
M		○	●	●
K		●		
N		●		
S			●	●
H			●	●

BSW Thread • British Standard Whitworth Thread Style

catalogue number	TPI	D	LI	W	number of teeth	KC610M	KC620M	KC635M
STN1119BSW	19	6,35	10,92	9,40	7	–	–	●
STN1611BSW	11	9,53	16,00	13,97	6	●	–	●
STN1612BSW	12	9,53	16,00	14,73	7	–	–	●
STN1614BSW	14	9,53	16,00	14,48	8	●	–	●
STN2711BSW	11	15,88	26,92	23,11	10	–	–	●

NPS Thread • Nominal Pipe Size Style

catalogue number	TPI	D	LI	W	number of teeth	KC610M	KC620M	KC635M
STN16115NPS	11.5	9,53	16,00	13,21	6	–	–	●
STN1614NPS	14.0	9,53	16,00	14,48	8	–	–	●

NPT Thread • National Pipe Thread Taper Style

catalogue number	TPI	D	LI	W	number of teeth	KC610M	KC620M	KC635M
STN1118NPT	18.0	6,35	10,92	9,91	7	–	–	●
STN16115NPT	11.5	9,53	16,00	13,21	6	–	–	●
STN1614NPT	14.0	9,53	16,00	14,48	8	–	–	●

NPTF Thread • National Pipe Thread Fine Style

catalogue number	TPI	D	LI	W	number of teeth	KC610M	KC620M	KC635M
STN1118NPTF	18.0	6,35	10,92	9,91	7	–	–	●
STN16115NPTF	11.5	9,53	16,00	13,21	6	–	–	●
STN1614NPTF	14.0	9,53	16,00	14,48	8	–	–	●

NOTE: NPTF = Dry Seal
NPT and NPTF inserts possess right- and left-hand edges.
Must order left-hand bar for left-hand inserts.

TMS Series

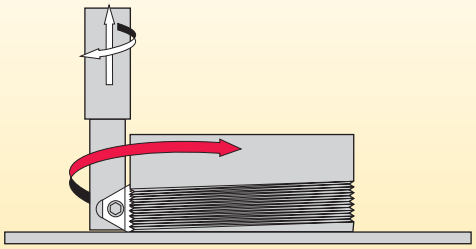
materials	Brinell	surface speeds		indexable inserts
steel	HB	KC610M	KC635M	feed fz (mm/tooth)
P1	125	100–210	90–180	0,05–0,20
P2	180	100–170	90–160	0,05–0,20
P3	225	60–130	70–115	0,05–0,20
P4	250	80–150	80–160	0,05–0,20
P5	275	75–130	80–160	0,05–0,15
P6	325	70–110	60–100	0,05–0,10
stainless steel				
M1	180	100–170	120–180	0,05–0,10
M2	250	70–140	100–140	0,05–0,10
M3	330	70–120	100–120	0,05–0,10
cast iron				
K1	180	60–130	100–120	0,02–0,08
K2	220	60–125	80–100	0,05–0,15
K3	260	50–90	60–90	0,05–0,10
non-ferrous				
N1	60–100	100–250	–	0,05–0,25
high-temp alloys				
S1	200	20–45	20–40	0,05–0,10
S2	250	20–30	20–30	0,02–0,05
S3	280	15–20	15–20	0,02–0,05
S4	350	10–15	10–15	0,02–0,05
hardened steel				
H1	55 HRC	20–45	20–45	0,01–0,03

NOTE: Use Kennametal thread mill software:
TM-CNC Generator for CNC Programming on our website under: **http://www.kennametal.com/en/resources/software.html**.

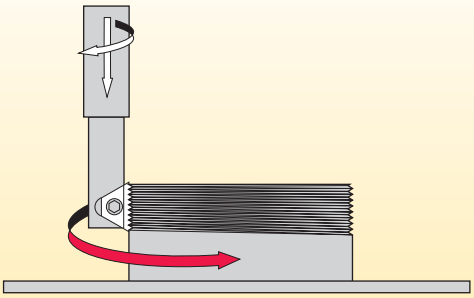
The Following Are a Few Thread Milling Methods (Work Directions)

NOTE: Climb milling results in lower cutting forces, better chip development, higher thread surface quality, and longer insert life. Therefore, it should be used whenever possible. But, in the case of some hardened materials or when milling certain difficult-to-machine exotic materials, conventional milling may be preferred.

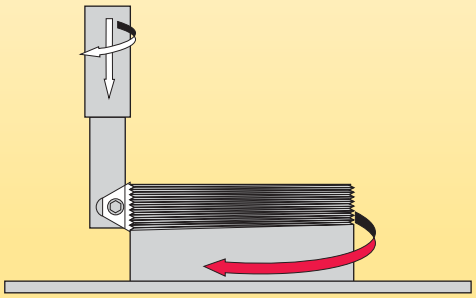
Methods of External Thread Milling



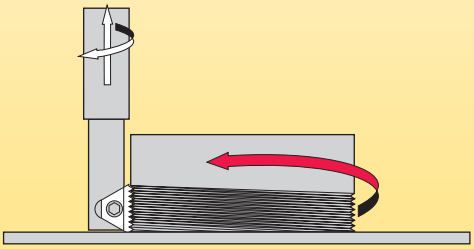
right-hand thread... conventional milling



left-hand thread... conventional milling

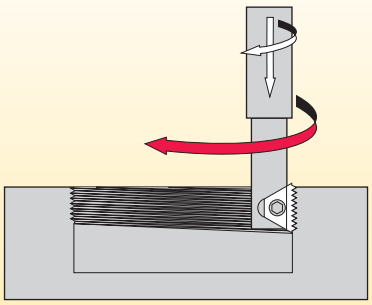


right-hand thread... climb milling

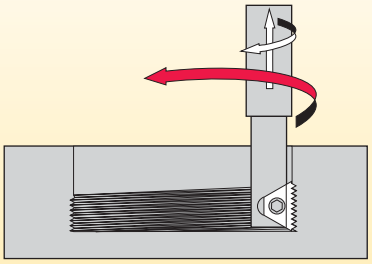


left-hand thread... climb milling

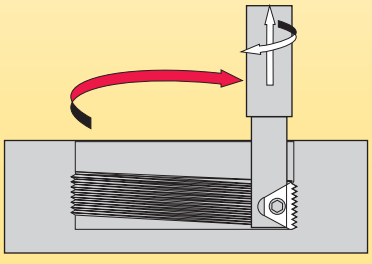
Methods of Internal Thread Milling



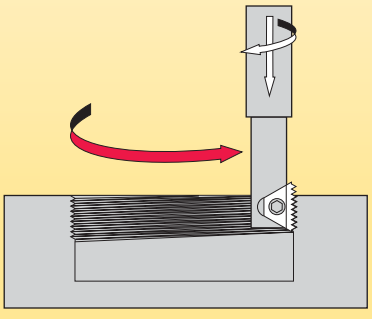
right-hand thread... conventional milling



left-hand thread... conventional milling



right-hand thread... climb milling



left-hand thread... climb milling

Application Guidelines

- All thread milling inserts are full profile or cresting type.
- Inserts are designed to mill full thread depth in one revolution or pass.
- When machining difficult materials, two passes may be desired. A 60% thread depth on the first pass and a 40% thread depth on the second pass is recommended.
- Thread relief grooves in blind holes are not necessary.
- Thread milling large parts requires considerably less horsepower compared to other threading methods.
- Thread milling produces short chips compared to stringy chips of other threading methods.
- One holder is suitable for many different thread pitches.
- PVD-coated inserts provide maximum tool life for a wide variety of materials.

Minimum Bore Diameters

UN-ISO-BSW

	TPI	48	32	24	20	16	12	10	8	7	6	5.5	5	4.5	4.5	4	4
	pitch mm	0,5	0,75	1,0	1,25	1,5	2,0	2,5	3,0	3,5	4,0	4,5	5,0	5,5	–	6,0	–
cutter	cutter diameter (D1 mm)	minimum bore diameter (D) (mm)															
K035TM1RW050-STN10	8,89	9,50	10,01	10,69	11,40												
K045TM1RW050-STN11N	11,43	11,99	12,50	13,21	13,89	14,50											
K049TM1RW037LT11S	12,45	13,00	13,49	14,20	14,91	15,49											
K061TM1RW062-STN16T	15,49	16,00	16,51	16,94	17,91	18,49	19,51										
K067TM2RW075-STN11D	17,02	17,60	18,21	19,00	19,61	19,99	21,01										
K075TM1RW075-STN16T	19,05	19,71	20,40	21,01	21,59	22,00	23,01										
K079TM1RW075-STN16N	20,07	20,70	21,41	22,00	22,61	23,01	24,00										
K087TM1RW100-STN16L	22,10	22,68	23,39	24,00	24,61	24,99	26,01										
K102TM2RW100-STN16D	25,91	26,70	27,41	27,99	28,70	29,31	30,30										
K118TM1RW100-STN27N	29,97	30,71	31,39	32,00	32,79	33,50	34,59	36,60	38,99	42,01	45,01	48,01					
K146TM1RW125-STN27N	37,08	38,00	38,61	39,50	40,41	41,00	42,01	43,99	46,48	49,00	51,99	55,50					
K165TM2RW125-STN27D	41,91	43,21	43,79	45,01	46,00	46,51	47,40	49,00	51,99	54,51	57,61	60,99					
–	35,05 (UN)	–	–	–	–	–	–	–	–	–	50,01	–	46,81	–	44,60	–	56,59
–	35,05 (ISO)	–	–	–	–	–	–	–	–	–	50,01	53,39	42,49	50,01	–	57,51	–
–	35,05 (BSW)	–	–	–	–	–	–	–	–	–	49,81	–	46,51	–	47,40	–	–

Cutting Data Recommendation

workpiece material	Cutting Speed — vc m/min	feed rate per revolution (mm)
	KC635M	
carbon steels <187 HB	90–210	0,10–0,20
carbon steels 187–220 HB	90–150	0,10–0,15
alloy steel 200–250 HB	60–130	0,10–0,15
alloy steel 250–325 HB	50–90	0,10–0,15
stainless steel, austenitic <210 HB	90–140	0,10–0,15
stainless steel, martensitic <321 HB	80–110	0,05–0,15
stainless steel, ferritic <245 HB	110–170	0,05–0,10
cast steel <140 HB	110–170	0,05–0,15
cast steel 220–302 HB	70–130	0,05–0,10
titanium alloys	60–120	0,03–0,08
high-temperature (nickel and iron base)	20–45	0,03–0,05
high-temperature (cobalt base)	15–30	0,03–0,05
cast iron	80–110	0,05–0,15
malleable iron	80–120	0,03–0,08

NOTE: Applications in this area may be machined with special inserts and cutter bodies. Quoted on request.

Understanding Thread Milling

In order to perform a thread milling operation, a milling machine with three-axis control, capable of helical interpolation, is required. Helical interpolation is a CNC function producing tool movement along a helical path. This helical travel combines circular movement in one plane with a simultaneous linear motion in a plane perpendicular to the first. For example, the path from point A to point B (figure A) on the envelope of the cylinder combines a circular movement in the X and Y plane with a linear movement in the Z direction.

On most CNC systems, this function can be executed in two different ways:

- G02: helical interpolation in a clockwise direction
- G03: helical interpolation in an anti-clockwise direction

The thread milling operation (figure B) consists of circular rotation of the tool about its own axis together with an orbiting motion along the bore or workpiece circumference.

During one such orbit, the tool will move vertically one pitch length. These movements, combined with the insert geometry, create the required thread form.

There are two acceptable ways of approaching the workpiece with the tool to initiate production of the thread:

1. Along a tangential arc.
2. Along a tangential straight line.

NOTE: Climb milling is preferred.

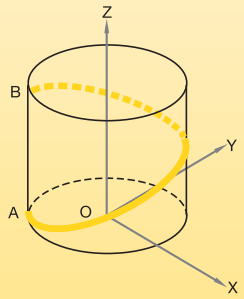
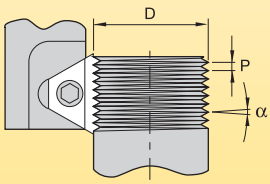


figure A



α - helix angle
D - external diameter
P - pitch

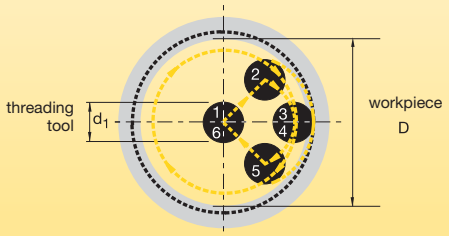
figure B

Tangential Approach (Arc)

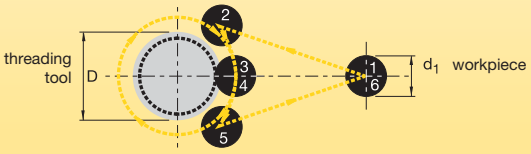
With this method, the tool enters and exits the workpiece smoothly. No marks are left on the workpiece and there is no vibration, even with harder materials.

Although it requires slightly more complex programming, this is the method recommended for machining the highest quality threads.

1–2:	rapid approach
2–3:	tool entry along tangential arc with simultaneous feed along Z-axis
3–4:	helical movement during one full orbit (360°)
4–5:	tool exit along tangential arc with continuing feed along the Z-axis
5–6:	rapid return



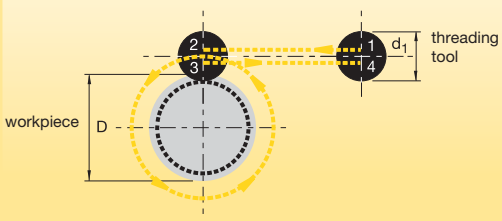
internal left-hand thread



external thread

Tangential Approach (Line)

This method is very simple and has all of the advantages of the tangential arc method. However, it is applicable only to external threads.



1–2:	radial entry with simultaneous feed along the Z-axis
2–3:	helical movement during one full orbit (360°)
3–4:	radial exit

Radial Approach

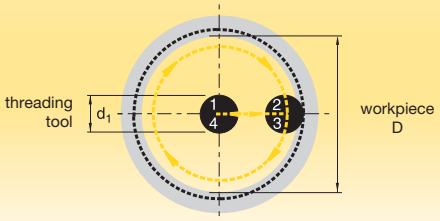
This radial approach is often considered the simplest. There are two characteristics worth noting about the radial approach:

a. A small vertical mark may be left at the entry (and exit) point. This is of no significance to the thread itself.

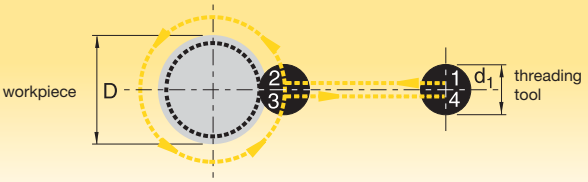
b. When using this method with very hard materials, there may be a tendency for the tool to vibrate as it approaches the full cutting depth.

1–2:	radial entry
2–3:	helical movement during one full orbit (360°)
3–4:	radial exit

NOTE: Radial feed during entry to the full profile depth should be only 1/3 of the subsequent circular feed.



internal thread



external thread

Calculation of Feed Rates at the Cutting Edge

The first step is to calculate the tool feed rate at the cutting edge:

$$F_1 = fz \times Z \times n$$

F_1 = tool feed rate at the cutting edge (mm/min)
fz = mm per tooth (feed rate)
Z = number of effective inserts in cutter
n = rotational speed (spindle RPM)

The rotational speed (RPM) is calculated by the following formula:

$$RPM = \frac{1000 \times Vc}{\pi \times d_1}$$

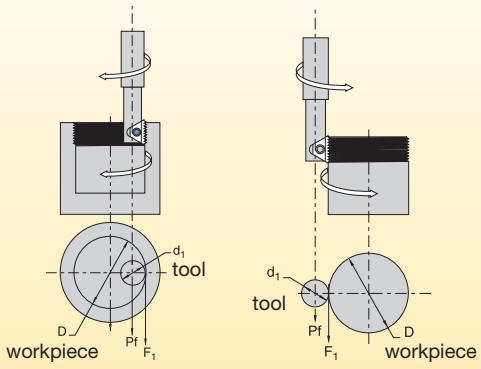
SFM = cutting speed, surface feet per minute
d_1 = cutter diameter, over insert
π = 3,1416

Calculation of Programme Feed Rate

On most CNC machines, the feed rate required for programming is at the centreline of the tool. When dealing with linear tool movement, the feed rate at the cutting edge and the centreline are identical. With circular tool movement this is not the case. The following equations define the relationship between feed rates at the cutting edge and at the tool centreline.

$$P_1 = F_1 + \frac{(F_1 \times d_1)}{D}$$

P_1 = programme feed rate (mm/min)
D = major diameter (external thread)
D = minor diameter (internal thread)
d_1 = cutting diameter, over insert



external thread internal thread

tool workpiece

Step-by-Step Thread Milling Example

thread: internal right hand 11/4 x 16 UN–2B–RH(21)
material: AISI 4140 (300 HB)
thread diameters: D (minimum bore dia.) = 30mm
Do (nominal dia.) = 31,75mm
thread length: 12,77mm

For best thread quality, the cutter with the largest d1 (cutter diameter) should be used. This cutter diameter can be found in the table on page W49, as a function of pitch and minimum bore diameter "D". The result for the above example is that any cutter diameter 25mm or smaller can be utilised.

A cutter with a smaller d1 will perform the thread milling operation in less time. The smaller d1 may result in less tool rigidity, so it should be used with caution on very tough materials.

Find the appropriate normal-length shank cutter diameter on pages W40–W43
Use the minimum bore diameter table below for reference.

pitch (TPI)	24	20	16	12
pitch mm	1,0	1,25	1,5	2,0
cutter dia. d_1	minimum bore diameter D			
17,02	19,00	19,61	19,99	21,01
19,05	21,01	21,59	22,00	23,01
20,07	22,00	22,61	23,01	24,00

Figure B: cutter selected: K079TMIRW075STN16N
outer dimensions: d_1 = 20,07mm, R_t (radius of tool) = $d_1 \div 2$ = 10,035mm

Choosing Insert Size

The insert IC is defined by the selected cutter (STN16).
Use the appropriate insert table on pages W44–W46.

insert IC	a (mm)	pitch (TPI)	internal thread catalogue number	b thread length (mm)	number of teeth	grade KC610M	grade KC620M	external thread catalogue number	b thread length (mm)	number of teeth	grade KC610M	grade KC620M	cutter type
		32	STN16 32UN-I	14,99	19	□	□	STN16 32UN-E	14,99	19	□	□	
		28	STN16 28UN-I	14,48	16	■	■	STN16 28UN-E	14,48	16	□	□	
		27	STN16 27UN-I	14,22	15	□	■	STN16 27UN-E	14,22	15	■	□	
		24	STN16 24UN-I	13,97	14	□	□	STN16 24UN-E	14,73	14	■	□	
9,53	16	20	STN16 20UN-I	13,97	11	■	■	STN16 20UN-E	13,97	11	■	■	STN16
		18	STN16 18UN-I	14,22	10	■	■	STN16 18UN-E	14,22	10	■	■	
		16	STN16 16UN-I	14,22	9	■	■	STN16 16UN-E	14,22	9	■	■	
		14	STN16 14UN-I	14,48	8	■	■	STN16 14UN-E	14,48	8	■	■	
		13	STN16 13UN-I	13,72	7	□	□	STN16 13UN-E	13,72	7	□	□	
		12	STN16 12UN-I	14,73	7	■	■	STN16 12UN-E	14,73	7	■	■	□

insert selected: STN16 16UN-I
■ stock standard
□ non-stock standard

Step-by-Step Thread Milling Example

Calculate the feed rates:

First, find the RPM.

$$RPM = \frac{1000 \times Vc}{\pi \times d_1} = \frac{1000 \times 150}{\pi \times 20} = 2387 \text{ RPM}$$

Next, calculate the feed rate at the insert cutting edge (F_1):

(using the chosen feed per tooth of 0,1mm.)

$$F_1 = F_z \times Z \times N = 0{,}1 \times 1 \times 2387 = 238{,}7 \text{ mm/min}$$

Finally, calculate the feed rate at the cutter centreline (F_2):

$$F_2 = \frac{F_1 \times (D - d_1)}{D} = \frac{238{,}7 \times (30-20)}{30} = 79{,}57 \text{ mm/min}$$

Select the thread milling method.

Climb milling (preferred) see page W48.

Calculate the radius of the tangential arc R_e:

$$R_e = \frac{(R_i - C_L)^2 + R_O^2}{2 \times R_O} = \frac{(15-0{,}5)^2 + 15{,}875^2}{2 \times 15{,}875}$$

R_e = 14,55mm

Calculate the angle (β):

$$\beta = 90° + \arcsin \frac{R_O - R_e}{R_e}$$

$$\beta = 90° + \arcsin \frac{15{,}875 - 14{,}55}{14{,}55}$$

β = 90° + 5.17° = 95,2° = 95° 12'

Calculate the movement along the Z-axis during the entry approach from point "A" to point "B" ($Z\alpha$). (NOTE: P = pitch)

$$Z_\alpha = P \text{ (mm)} \times \frac{\alpha°}{360°} = \frac{1{,}578}{4} = 0{,}394\text{mm because } \alpha = 90°$$

Calculate the "X" and "Y" values at the start of the entry approach.

X = 0Y = $R_i + C_L$ = 15 + 0,5 = 15,5mm

Define Z-axis location at the start of the entry approach. (NOTE: L = length of thread)

Z = (L + Z_α) = 12,7 + 0,3945 = 13,0945mm

Define the starting point.

$X_a = 0$

$Y_a = 0$

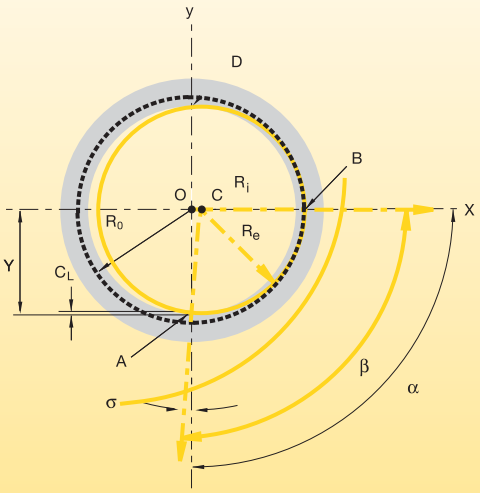
CNC Programme (Fanuc 11M)

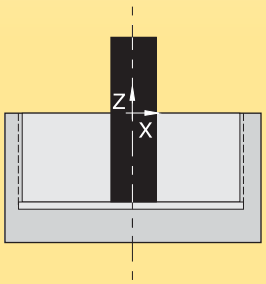
```
%
N10G90G00G57X0.000Y0.000
N20G43H10Z0.M3S2417
N30G91G00X0.Y0.Z–0.5156
N40G41D60X0.000Y–0.5710Z0.
N50G03X0.6250Y0.5710Z0.0156R0.5733F3.206
N60G03X0.Y0.Z0.0625I–0.625J0.
N70G03X–0.625Y0.5710Z0.0156R0.5733
N80G00G40X0.Y–0.5710Z0.
N90G49G57G00Z8.0M5
N100M30
%
```

$$R_i = \frac{D}{2} \qquad R_O = \frac{D_O}{2}$$

D = minor diameter **D_O = nominal diameter**

α 90°





Step-by-Step Thread Milling Example

Appendix A

Derivation of Formulas for Internal Thread Milling

R_e, β, and X can be found by a geometric analysis of the entry path.

This entry path is defined by the tool traveling along a circular path, with a radius of R_e about the point C.

$$R_e = \frac{(R_i - C_L)^2 + R_o^2}{2R_o}$$

Triangle OAC enables us to simply solve for R_e.
Note that OAC is a right angle triangle, and that:

$OA = R_i - C_L$
$CA = R_e$
$OC = R_o - R_e$

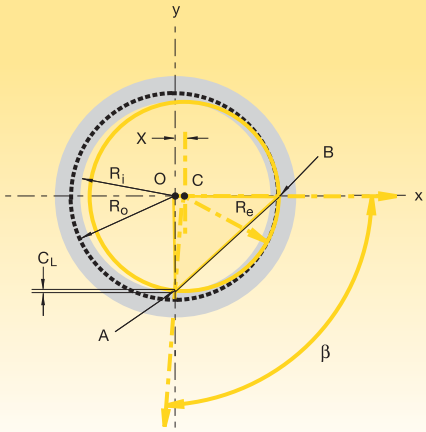
Pythagoras' law states: $OA^2 + OC^2 = AC^2$

Replacing actual values, we get:

$$(R_i - C_L)^2 + (R_o - R_e)^2 = R_e^2$$

Simplifying, we get:

$$R_e = \frac{(R_i - C_L)^2 + R_o^2}{2R_0}$$



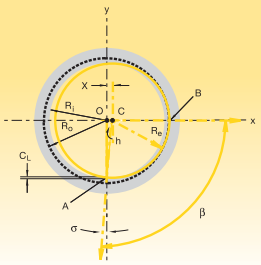
Find the angle β.

$\beta = 90° + \sigma$

$\sin \sigma = \frac{OC}{CA} = \frac{(R_o - R_e)}{R_e}$

$\sigma = \text{arc sin} \left(\frac{R_o - R_e}{R_e}\right)$

Therefore, $\beta = 90° + \text{arc sin} \left(\frac{R_o - R_e}{R_e}\right)$



Appendix B

Derivation of Formulas for External Thread Milling

R_e, β, and X can be found by a geometric analysis of the entry path.

This entry path is defined by the tool traveling along a circular path, with a radius of R_e about the point C.

$$R_e = \frac{(R_o - C_L)^2 + R_i^2}{2R_i}$$

Triangle OAC enables us to simply solve for R_e.
Note that OAC is a right angle triangle, and that:

$OA = R_o - C_L$
$CA = R_e$
$OC = R_e - R_i$

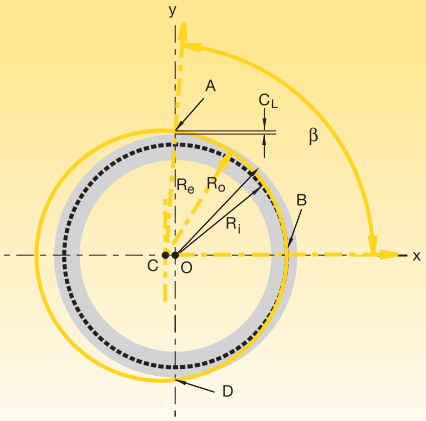
Pythagoras' law states: $OA^2 + OC^2 = AC^2$

Replacing actual values, we get:

$$(R_o - C_L)^2 + (R_e - R_i)^2 = R_e^2$$

Simplifying, we get:

$$R_e = \frac{(R_o - C_L)^2 + R_i^2}{2R_i}$$

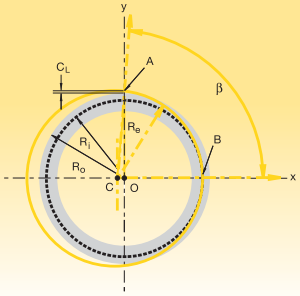


Find the angle β.

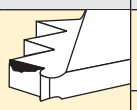
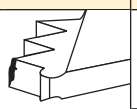
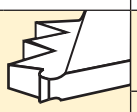
β can be easily found using the same triangle:

$\sin \beta = \frac{AO}{AC} = \frac{(R_o + C_L)}{R_e}$

$\beta = \text{arc sin} \left(\frac{R_o + C_L}{R_e}\right)$



Thread Mill Troubleshooting

problem	possible cause	solution
excessive insert flank wear 	• Cutting speed too high.	• Reduce cutting speed.
	• Chip is too thin.	• Increase feed rate.
	• Insufficient coolant.	• Increase coolant quantity/pressure.
chipping of cutting edge 	• Chip is too thick.	• Reduce feed rate. • Use the tangential arc method of entrance. • Increase RPM.
	• Vibration.	• Check rigidity.
material build-up on the cutting edge 	• Cutting speed too slow.	• Increase cutting speed.
	• Chip thickness too small.	• Increase feed rate.
chatter/vibration	• Feed rate is too high.	• Reduce the feed.
	• Profile is too deep (coarse pitch threads).	• Execute two passes, each with increased cutting depth. • Execute two passes, each cutting only half the thread length.
	• Thread length is too long.	• Execute two passes, each cutting only half of the thread length.
insufficient thread accuracy	• Tool deflection.	• Reduce feed rate. • Execute a zero cut.

Insert Tolerance Classes

thread designation	standard designation	tolerance class
UN	ANSI B 1.174	2A/2B
UNJ	MIL-S-8879A	3A/3B
ISO	R262 (DIN 13)	6g/6H
NPT	USAS B2.1 : 1968	standard NPT
NPTF	ANSI B 1.20.3-1976	standard
BSW	B.S. 84 : 1956, DIN 259, ISO 228/1 : 1982	medium class A
BSPT	B.S. 21 : 1985	standard BSPT
ACME	ANSI B1/5 : 1988	3G
PG	DIN 40430	standard
TR	DIN 103	7e/7H


ORIGIN
ABS/0
mm
OFF
ON

Indexable Milling • Technical Information • Recommended Starting Speeds

Overview Wrenches X2–X3

Technical Information X4–X20

Recommended Starting Speeds X22–X37

NOTE: Kennametal screw drivers, bits, torque wrenches, and bit drivers can be ordered separately, if needed.








drive size	1/4" bit 25mm length	order number	1/4" bit extended length	order number	screw driver	order number	Flag-Type Screw Driver	order number	Allen key	order number	T-Handle Screw Driver	order number
hex 1,5	–	–	–	–	170.270	**1126021**	–	–	170.000	**1138273**	–	–
hex 2,0	–	–	–	–	170.222	**1191006**	–	–	170.001	**1138280**	–	–
hex 2,5	170.179	**1138851**	–	–	170.224	**1138870**	–	–	170.002	**1138297**	–	–
hex 3,0	170.180	**1150198**	BTQSW3L90	**6205876**	170.225	**1138879**	–	–	170.003	**1138307**	THW3M	**2229285**
hex 3,5	–	–	–	–	–	–	–	–	–	–	THW35M	**1931555**
hex 3,5/Torx 15,0	–	–	–	–	–	–	FT1535	**1021609**	–	–	–	–
hex 4,0/Torx 15,0	–	–	–	–	–	–	FT154	**1021611**	–	–	–	–
hex 4,0	170.181	**1138857**	–	–	170.226	**1191007**	–	–	170.004	**1138315**	THW4M	**1931556**
hex 5,0	–	–	–	–	–	–	–	–	170.005	**1138323**	170.135	**1138748**
hex 6,0	–	–	–	–	–	–	–	–	170.006	**1138331**	170.136	**1138755**
hex 8,0	–	–	–	–	170.229	**1191010**	–	–	170.008	**1135984**	–	–
hex 9,0	–	–	–	–	–	–	–	–	170.009	**2272577**	–	–
hex 10,0	–	–	–	–	–	–	–	–	–	–	–	–
hex 12,0	–	–	–	–	–	–	–	–	–	–	–	–
hex 5/64	–	–	–	–	–	–	–	–	–	–	KW078	**1022575**
hex 3/32	–	–	–	–	–	–	–	–	–	–	KW093	**1022581**
hex 7/64	–	–	–	–	–	–	–	–	–	–	KW109	**1022537**
hex 1/8	–	–	–	–	–	–	–	–	–	–	–	–
hex 5/32	–	–	–	–	–	–	–	–	–	–	KW156	**1022565**
hex 3/16	–	–	–	–	–	–	–	–	–	–	KW187	**1022579**
hex 7/32	–	–	–	–	–	–	–	–	–	–	–	–
Torx 5	–	–	–	–	–	–	FT5	**1021589**	KT5	**1099677**	–	–
Torx 6	BT6	**1962981**	–	–	DT6	**1022463**	FT6	**1126361**	KT6	**1022691**	–	–
Torx 7	BT7	**1963853**	–	–	DT7	**1022485**	FT7	**1021591**	KT7	**1022693**	–	–
Torx 8	BT8	**1963855**	–	–	DT8	**1022487**	FT8	**1021593**	KT8	**1022695**	–	–
Torx 9	BT9	**1963854**	–	–	DT9	**1022489**	FT9	**1020533**	KT9	**1022697**	–	–
Torx 10	BT10	**1963856**	–	–	DT10	**1022491**	FT10	**1099651**	KT10	**1022699**	–	–
Torx 10/15	–	–	–	–	–	–	FT1015	**1099652**	–	–	–	–
Torx 15	170.182	**2261642**	170.177	**1138829**	DT15	**1022493**	FT15	**1021605**	KT15	**1022701**	TT15	**1022315**
Torx 15	–	–	BTQT15L90	**6205877**	–	–	–	–	–	–	–	–
Torx 20	170.176	**1138822**	BTQT20L90	**6205878**	–	–	FT20	**1021607**	KT20	**1022703**	TT20	**1022317**
Torx 25	–	–	170.259	**1994579**	–	–	–	–	KT25	**1022725**	TT25	**1022519**
Torx 25	–	–	BTQT25L90	**6205879**	–	–	–	–	–	–	–	–
Torx 27	170.256	**1984243**	170.257	**1985840**	–	–	–	–	KT27	**1022727**	–	–
Torx 30	–	–	–	–	–	–	–	–	KT30	**1099676**	TT30	**1022521**
Torx 40	–	–	–	–	–	–	–	–	–	–	–	–
Torx 45	–	–	–	–	–	–	–	–	KT45	**1018227**	–	–
Torx Plus 7	–	–	–	–	DT7IP	**3644073**	–	–	–	–	–	–
Torx Plus 8	–	–	–	–	DT8IP	**2388424**	–	–	K8IP	**2388488**	TTP8	**1931553**
Torx Plus 9	–	–	–	–	DT9IP	**2269913**	–	–	K9IP	**1985786**	TTP9	**1985792**
Torx Plus 10	–	–	–	–	DT10IP	**2388425**	–	–	K10IP	**2388489**	TTP10	**2504383**
Torx Plus 15	–	–	BTQTP15L90	**6205880**	DT15IP	**2269914**	–	–	K15IP	**1867353**	TTP15	**1931554**
Torx Plus 20	–	–	BTQTP20L90	**6205891**	DT20IP	**2388427**	–	–	K20IP	**2388491**	TTP20	**1994291**
Torx Plus 25	BT25IP	**2244316**	BTQTP25L90	**6205892**	DT25IP	**2269915**	–	–	K25IP	**2050113**	TTP25	**4064258**
Torx Plus 27	BT27IP	**2244317**	BTE27IP	**2244319**	–	–	–	–	K27IP	**1985787**	TTP27	**1985793**
Torx Plus 30	–	–	–	–	DT30IP	**2388426**	–	–	K30IP	**2388490**	–	–





Torque-Controlled Wrenches • 0,6–5,4 Nm (5.3–47.8 in. lbs.)

Order Number	Catalogue Number	Drive Size	Description
3641463	DTQ0615	–	Torque Control Wrench Handle 0.6–1.5 Nm
3641464	DTQ1530	–	Torque Control Wrench Handle 1.5–3.0 Nm
3641465	DTQ3054	–	Torque Control Wrench Handle 3.0–5.4 Nm
3641466	BTQT6	T6	Blade for screw driver
3641467	BTQT7	T7	Blade for screw driver
3641468	BTQT8	T8	Blade for screw driver
3641469	BTQT9	T9	Blade for screw driver
3641470	BTQT10	T10	Blade for screw driver
3641471	BTQT15	T15	Blade for screw driver
3641472	BTQT20	T20	Blade for screw driver
3641473	BTQT25	T25	Blade for screw driver
3641474	BTQ6IP	Torx Plus 6	Blade for screw driver
3641475	BTQ7IP	Torx Plus 7	Blade for screw driver
3641476	BTQ8IP	Torx Plus 8	Blade for screw driver
3641477	BTQ9IP	Torx Plus 9	Blade for screw driver
3641478	BTQ10IP	Torx Plus 10	Blade for screw driver
3641479	BTQ15IP	Torx Plus 15	Blade for screw driver
3641481	BTQW3M	hex 3mm	Blade for screw driver
3641480	DTQCAP	–	Cover Cap





Torque-Controlled Wrenches • 5–14 Nm (3.7–10.3 in. lbs.)

Order Number	Catalogue Number	Drive Size	Description
6197561	DTQ50140	hex 1/4"	T-handle torque wrench, adjustable 5–14 Nm
6205876	BTQSW3L90	hex 3mm	Bit Hex 3mm L = 90mm
6205877	BTQT15L90	T15	Bit Torx 15 L = 90mm
6205878	BTQT20L90	T20	Bit Torx 20 L = 90mm
6205879	BTQT25L90	T25	Bit Torx 25 L = 90mm
6205880	BTQTP15L90	Torx Plus 15	Bit Torx Plus 15 L = 90mm
6205891	BTQTP20L90	Torx Plus 20	Bit Torx Plus 20 L = 90mm
6205892	BTQTP25L90	Torx Plus 25	Bit Torx Plus 25 L = 90mm



Bit Adaptor

Order Number	Catalogue Number	Drive Size	Description
1963869	DRIVER	hex 1/4"	Bit Adaptor suitable for standard and extended length 1/4" drive bits

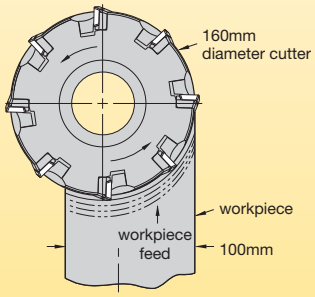
Workpiece dimensions determine the best face mill diameter to select.

Cutter-to-part width-of-cut ratio should be approximately 3:2 or 1 1/2 times the part width. For example, if the width of cut is 100mm, choose a 160mm diameter cutter. If the width is extremely wide, select a cutter diameter that matches the spindle capacity and take multiple passes. For example, if the width of cut is 610mm and the machine has a standard #50 taper spindle, you should use an 200mm diameter cutter and take five passes, at slightly less than 125mm per pass, or four passes at 160mm per pass, depending on horsepower and rigidity.

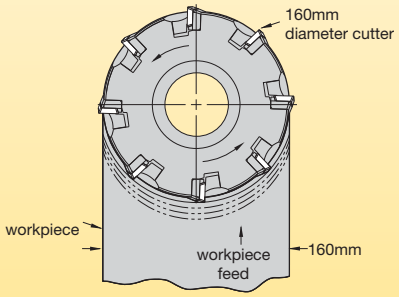
An undesirable situation is when the cutter diameter is about equal to the width of cut. The chip being formed at the entrance and exit of the cut will be very thin. The thin chips formed cannot carry away heat as well as thicker chips; therefore, the heat is transferred back into the insert causing premature edge failure. Work-hardening is also more likely to occur in the entry and exit area.

When the proper cutter diameter is not available, proper cutter positioning will provide positive results.

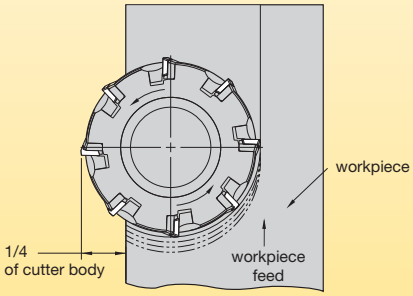
- Position cutter with approximately 1/4 of the cutter body outside the workpiece and make two passes.
- Produces negative angle of entry (desirable).
- Can result in longer tool life.



desirable



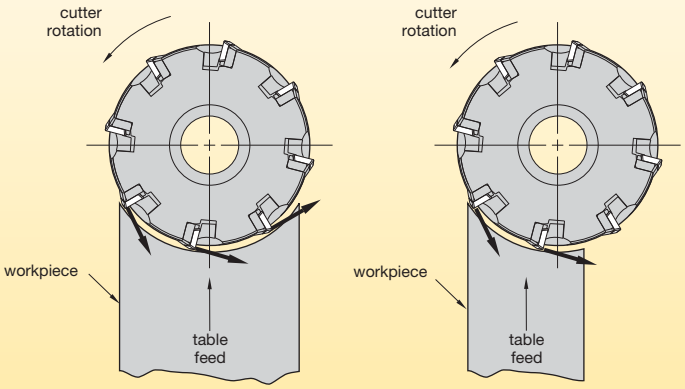
undesirable



cutter position

Cutter Positioning/Cutting Forces

The cutting forces are constantly changing as the inserts move through the cut. We should understand that in changing the position of the cutter in relation to the workpiece, we can re-direct the cutting forces. This is important to ensure a safe operation based on fixture design, workpiece design, and workpiece considerations.



Pitch, or density, refers to the number of inserts in a cutter. Cutters can be classified as having either coarse, medium, or fine pitch. When designing a cutter, the engineer must take the depth of cut and feed per tooth into consideration. He then must provide the necessary chip clearance in the body so that the chip can pass without restricting its formation. For this reason, cutters designed for heavy metal removal have maximum chip clearance. This, therefore, restricts the number of inserts in the cutter, making it a coarse pitch cutter.

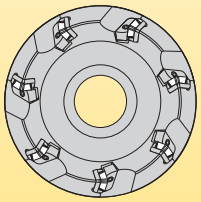
In medium pitch cutters, the chip clearance area in the body is usually slightly smaller than a coarse pitch cutter. And, in fine pitch cutters, the chip clearance is considerably less.

Coarse pitch is recommended for general purpose milling where adequate horsepower is available, and where maximum depth of cut is required.

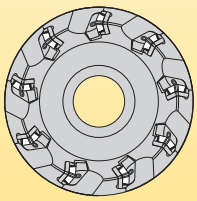
Medium pitch is recommended when moderate feed per insert is required, and where it is more advantageous to have more than one insert in the cut. Medium pitch also reduces entry shock and cutting pressure while maintaining feed rates.

Fine pitch is ideal when milling a severely interrupted surface such as a manifold block. Fine pitch cutters are capable of higher inch/mm per minute feed rates than medium or coarse pitch cutters. They also experience higher cutting forces and greater horsepower consumption than medium or coarse pitch cutters do.

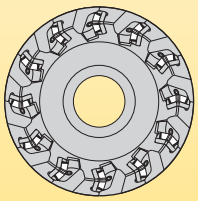
Differential pitch is a differential-pitch milling cutter with unequally spaced inserts. This configuration breaks up the harmonics that result from equally spaced inserts, greatly reducing the chance of vibration. Most cutters use this design regardless of the cutter pitch.



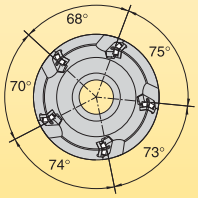
coarse pitch



medium pitch



fine pitch



differential pitch

Lead Angles/Cutting Forces on Workpiece and Fixturing

Cutting forces produced during the milling process are constantly changing as the insert moves through the cut. Understanding the relationship of these forces will help ensure safe operation by preventing workpiece movement during the cut. For example, fixture design and clamp positioning are determined by the cutting forces produced in milling. Equally important is an understanding of the effect lead angle has on cutting force direction, actual chip thickness, and tool life.

90° Lead Angle

Advantages:

- When 90° shoulder is required.
- Can be a problem solver on thin wall workpieces.

Disadvantages:

- Highest radial cutting forces.
- High entry shock load.
- Increased chance of bur on insert exit side of part.

75° and 70° Lead Angle

Advantages:

- For general milling applications and relatively rigid conditions.
- Good relation of insert size and maximum depth of cut.
- Reduced entry shock load.

Disadvantages:

- Higher radial forces can cause problems in weak machine/workpiece/fixture conditions.

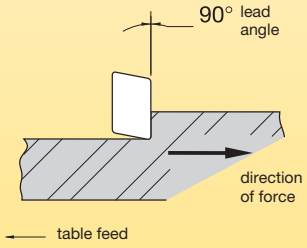
45° Lead Angle

Advantages:

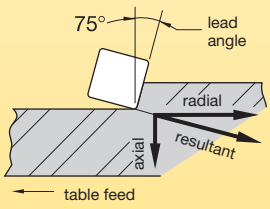
- Well-balanced axial and radial cutting forces.
- Less breakout on workpiece corner.
- Entry shock minimised.
- Less radial forces directed into spindle bearings.
- Higher feed rates possible.

Disadvantages:

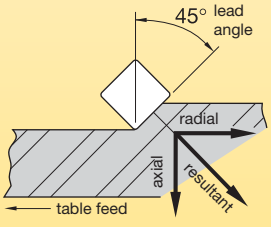
- Reduced maximum depth of cut due to lead angle.
- Larger body diameter can cause fixture clearance problems.



90° lead



75° and 70° lead



45° lead

(continued)

(continued)

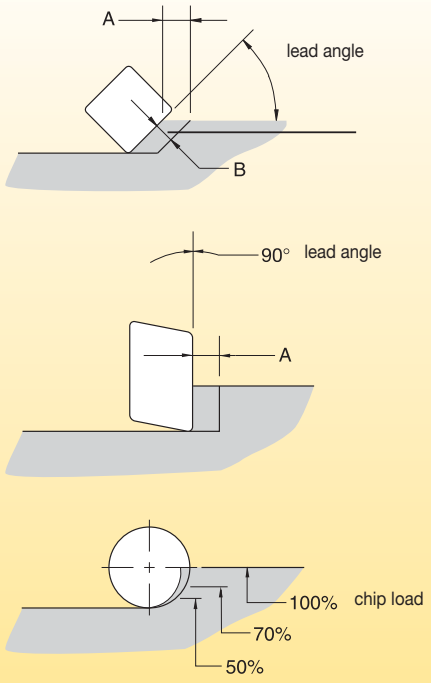
Lead Angle/Chip Thickness

Chip thickness is affected by lead angle. The greater the lead angle, the thinner the chip will be since it's distributed over a greater length of the cutting edge. To achieve greater productivity and problem-free milling, use a lead angle cutter whenever possible.

lead angle	feed per tooth	actual chip thickness "B"
90°	A	A
75°	A	.96 x A
70°	A	.94 x A
60°	A	.86 x A
45°	A	.707 x A

example:

90°	0,25mm	0,25mm
75°	0,25mm	0,24mm
70°	0,25mm	0,24mm
60°	0,25mm	0,22mm
45°	0,25mm	0,18mm



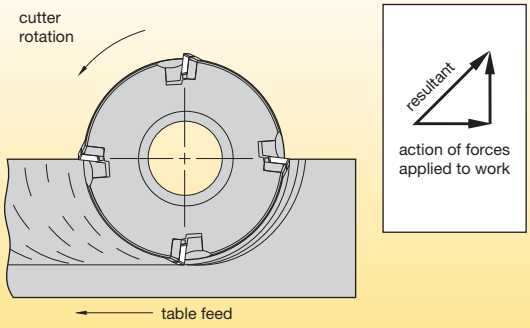
On round inserts, the chip load and lead angle vary with the depth of cut.

lead angle/chip thickness

Conventional Milling

For many years, it was common practice to mill against the direction of the feed due to the use of high-speed steel cutters and an absence of backlash-eliminating devices. The milling procedure became known as conventional, or up-milling.

In conventional milling, friction and rubbing occur as the insert enters into the cut, resulting in chip welding and heat dissipation into the insert and workpiece. Resultant forces in conventional milling are against the direction of the feed. Work-hardening is also likely to occur.

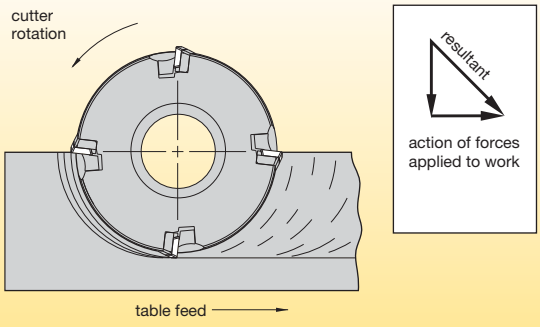


conventional milling

Climb Milling (preferred)

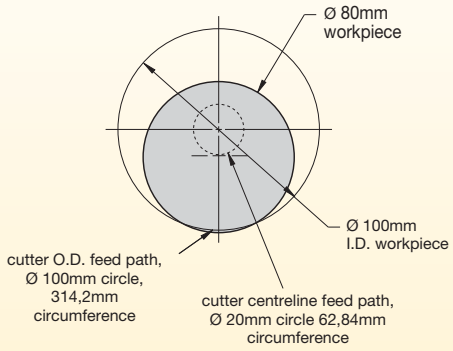
Climb milling is normally recommended. The insert enters the workpiece material with some chip load and produces a chip that thins as it exits the cut. This reduces the heat by dissipating it into the chip. Work-hardening is minimised.

Climb milling forces tend to push the workpiece toward the fixture and in the direction of the feed. Climb milling is preferred over conventional milling in most situations.

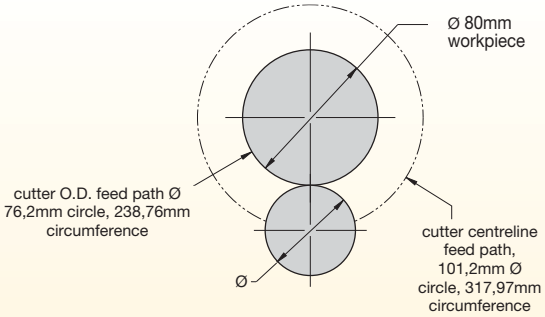


climb milling

Circular Interpolation: Consists of a cutter rotating about its own axis while traveling in an orbiting motion about an I.D. or O.D. workpiece circumference without any vertical shift during the operation. This orbiting movement utilises the "X" and "Y" axis.



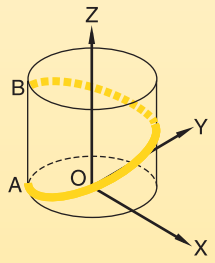
I.D. circular interpolation



O.D. circular interpolation

Helical Interpolation: This application requires a milling machine with three-axis control capability. The operation consists of a cutter rotating about its own axis together in an orbiting motion about an ID or OD workpiece circumference in the "X" and "Y" plane. The circular movement about the "X" and "Y" plane, with a simultaneous linear movement in the Z-axis plane (which is perpendicular to the "X" and "Y" plane), creates the helical movement. For example, the path from point A to point B on the envelope of the cylinder combines a circular movement in the "X" and "Y" plane with a linear movement in the "Z" direction. On most CNC systems, this function can be executed in two different ways:

- GO2: helical interpolation in a clockwise direction.
- GO3: helical interpolation in an anti-clockwise direction.



helical interpolation

Calculation of Feed Rate for Circular and Helical Interpolation: On most CNC machines, the feed rate required for programming contour (circular or helical) milling is calculated based on the centreline of the tool. When dealing with linear tool movement, the feed rate at the cutting edge and centreline are identical, but with circular tool movement, this is not the case.

Calculate Feed Rate at the Cutting Edge: First calculate the tool feed rate at the cutting edge with the following formula.

$F_1 = fz \times z \times n$

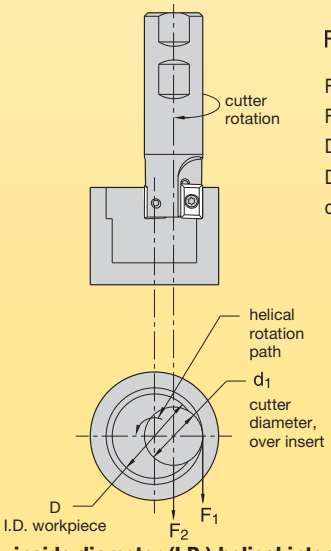
F_1 = tool feed rate at the cutting edge (mm/min)

f_z = mm per tooth (chip load)

Z = number of effective inserts in the cutter

n = revolutions per minute

Calculation of the Feed Rate at the Tool Centreline: Use the following equations to define the relationship between feed rates at the cutting edge and at the tool centreline.



inside diameter (I.D.) helical interpolation

$$F_2 = \frac{F_1 \times (D - d_1)}{D}$$

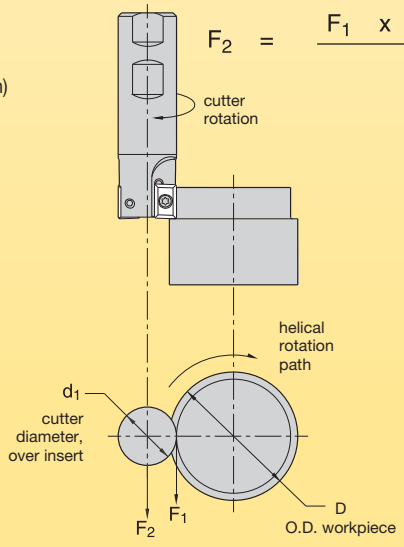
F_1 = tool feed rate at the cutting edge (mm/min)

F_2 = tool centreline feed rate (mm/min)

D = O.D. workpiece diameter

D = I.D. workpiece diameter

d_1 = cutter diameter, over insert



outside diameter (O.D.) helical interpolation

$$F_2 = \frac{F_1 \times (d_1 + D)}{D}$$

(continued)

(continued)

In I.D. contour applications, you will find the tool centreline feed is always less than the cutting edge feed rate.

Example for I.D.

D = 100mm (4") I.D. workpiece
d_1 = 80mm (3") cutter diameter
fz = 0,2 mm/tooth (.008 IPT)
n = 637 RPM
z = 7 effective inserts

1. Calculate feed rate at the cutting edge.

$F_1 = fz \times z \times n$
$F_1 = 0.2 \times 7 \times 637 = 892$ mm/min (008 x 7 x 637 = 35.7 in./min)

2. Calculate feed rate at the tool centreline.

$$F_2 = \frac{F_1 \times (D - d_1)}{D}$$

$$F_2 = \frac{35.7 \times (4.0 - 3.0)}{4.0} = 8.9 \text{ in./min}$$

$$F_2 = \frac{892 \times (100 - 80)}{100} = 178 \text{ mm/min}$$

To have (F_1) 892 mm/min at the cutting edge feed rate, we must programme the machine tool for (F_2) 178 mm/min at the tool centreline feed rate. This is a difference of approximately 75% less feed than the cutting edge feed rate (F_1).

In O.D. contour applications, you will find the tool centreline feed rate is always larger than the cutting edge feed rate.

Example for O.D.

D = 125mm (5") O.D. workpiece
d_1 = 50mm (2") cutter diameter
f_z = 0,2 mm/tooth (.008 IPT)
n = 955 RPM
z = 5 effective teeth

1. Calculate feed rate at the cutting edge.

$F_1 = fz \times z \times n$
$F_1 = 0.2 \times 5 \times 955 = 955$ mm/min (.008 x 5 x 955 = 38.2 in./min)

2. Calculate feed rate at the tool centreline.

$$F_2 = \frac{F_1 \times (d_1 + D)}{D}$$

$$F_2 = \frac{38.2 \times (2 + 5)}{5} = 53.5 \text{ in./min}$$

$$F_2 = \frac{955 \times (50 + 125)}{125} = 1{,}337 \text{ mm/min}$$

To have (F_1) 38.2 in/min (955 mm/min) at the cutting edge feed rate, we must programme the machine tool for (F_2) 53.5in/min (1,337 mm/min) at the tool centreline feed rate. This translates to an increase of about 40% more feed rate than the cutting edge feed rate (F_1).

Large Surfaces

Interpolating with a smaller cutter may be faster than using a large diameter cutter. Also, keep the cutter in contact with the workpiece rather than exiting and re-entering.

Maximise Metal Removal Rate

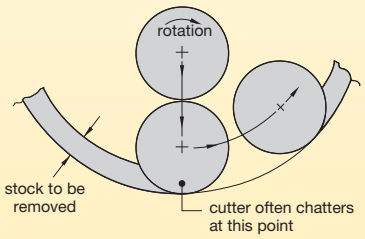
Concentrate on Metal Removal Rate (MRR), not just on higher vc (cutting speeds). Increasing spindle speed without increasing chip load will not improve MRR. However, by doubling fz, MRR does increase and horsepower consumption only increases by approximately 50%.

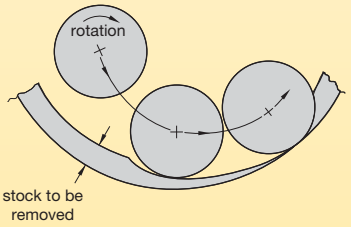
Preset

Use cutter preset areas for proper setting of cutters rather than indexing cutters at the machine, if possible.

Ramp In and Out

As shown below, ramping gradually into the cut will provide greater tool life. Also, by keeping the cutter constantly moving when entering and exiting the cut, dwell marks will be eliminated on the workpiece.

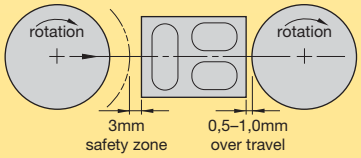




Safety and Over Travel

Programme the milling cutter to rapid advance up to the part, within a range of 3mm before engaging the workpiece. This allows the machine to reach its proper operating parameters before actual chip making begins.

Rapid advance to the next cutting location, when the cutter is 0,5mm to 1mm past the edge of the part. If the spindle has built-in tilt or programmed runout, the cutter can be advanced to the next cutting location while the back half of the cutter is still over the finished milled surface.



to find	given	formula
Vc	D n	$Vc = \frac{\pi \times D \times n}{1000}$
n	D Vc	$n = \frac{1000 \times Vc}{\pi \times D}$
Vf	fz n z	**Vf = fz x z x n**
fz	z Vf n	$fz = \frac{Vf}{z \times n}$

given	calculated
D = 125 mm cutter diameter Z = 8 teeth in cutter Vc = 200 mm/min fz = 0,2 mm	$n = \frac{1000 \times 200}{3.1416 \times 125} = 510$ RPM **Vf = 0,20 x 8 x 510 = 816 mm/min**

legend

Vc = surface feed per minute

n = revolutions per minute

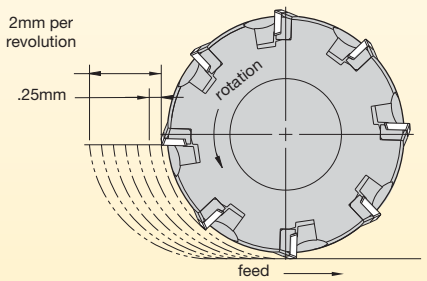
D = cutter diameter

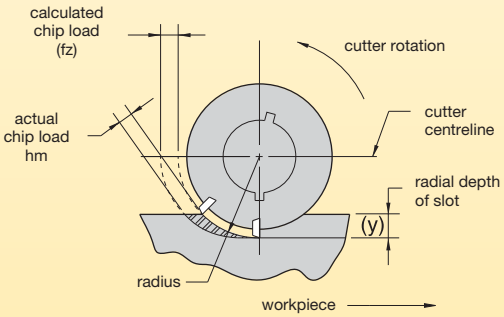
Vf = feed (mm per minute)

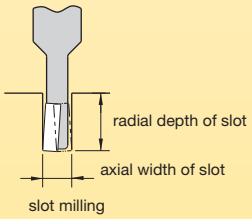
fz = mm per tooth (chip load)

z = number of effective teeth or inserts in cutter

π = 3.1416







Slotting or Periphery Milling

True or actual chip load on the cutting edge of the insert is equal to the programmed chip load only when 50% or more of the cutter's diameter is engaged in the cut (lead angle not considered). Anything less than half the diameter of the cutter means that the actual chip load is reduced by some percentage. The smaller the radial depth of cut, the greater the decrease in actual chip load.

It's very important to maintain a chip load which is great enough to ensure heat dissipation and prevent work hardening. A sufficient chip load will also create stability between the cutter and the workpiece.

The formulas shown below are used to determine the programmed chip load, or feed rate necessary to obtain the desired load on the insert cutting edge as it enters the workpiece. These formulas should be applied whenever an arbour mounted slotting cutter is being used, or when less than half the diameter of a face mill or end mill is engaged in the cut. The lighter the radial depth of cut, the more important it becomes to apply these productivity formulas.

Productivity Formulas

$$\text{chip load (fz)} = \frac{\left(\frac{\sqrt{(\text{dia.} - y) \times (y)}}{\text{radius}}\right) \times \left(\frac{vf}{n}\right)}{z}$$

or

$$Vf = \frac{n \times z \times fz}{\left(\frac{\sqrt{(\text{dia.} - y) \times (y)}}{\text{radius}}\right)}$$

Operations such as **periphery milling with a light radial depth of cut or slotting with an arbour mounted cutter** require a calculation for feed rate compensation to maintain the proper chip load on the insert edge at entry into the cut. The calculated chip load and actual chip load can be dramatically different, depending on the radial depth and the cutter diameter. For instance, the actual chip load on entry for a 20mm diameter cutter taking a 0.3mm radial depth cut is only 23% of the calculated chip load. It is not uncommon to encounter built-up edge, work-hardening, or chatter problems if the following formula is not applied. Minimal cutter runout is critical to obtaining an equal chip load on each flute of the cutter too. A side benefit to applying this formula is increased productivity as feed rates can increase dramatically.

Formulas — Horsepower

Metal Removal Rate

The Metal Removal Rate (MRR) calculation is a good basis for determining metalcutting efficiency.

MRR = doc x woc x Vf = mm^3/min.

Horsepower Consumption

Milling cutters can consume significant amounts of horsepower. Very often it is the lack of horsepower that is the limiting factor when deciding on a particular operation. On applications where large diameter cutters or heavy stock removal is necessary, it's advantageous to first calculate the necessary horsepower requirements.

NOTE: Spindle efficiency "E" varies from 75 to 90%.

(E = .75 to .90)

A suitable formula for calculating horsepower (HP_c) at the cutter is:

$$HP_c = \frac{MRR}{K}$$

example:
width of cut (woc) 42mm
depth of cut (doc) 5mm
feed (vf) . . . . . 1092 mm/min
4140 220 HB . . . . . "K" factor 1.56

MRR = 5 x 42 x 1092 = 229320 mm^3/min

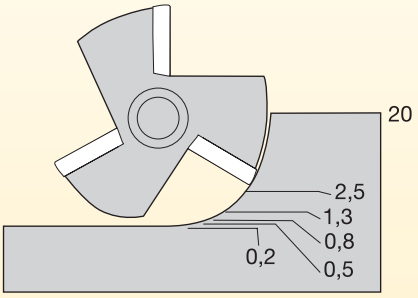
For horsepower at the motor (HP_m), use formula:

$$HPm = \frac{HPc}{E}$$

In determining horsepower consumption, "K" factors must be used. The "K" factor is a power constant that represents the number of cubic inches of metal per minute that can be removed by one horsepower.

NOTE: "K" factors vary depending on the hardness of the material.

radial depth of cut	actual chip load (fz)	feed required (Vf) to maintain fz = 0,1	increase
20	0,1	140	0%
2,5	0,05	292	109%
1,3	0,04	389	178%
0,8	0,03	498	256%
0,5	0,02	607	335%
0,3	0,015	859	515%



40mm end mill – 6 flutes
30 m/min (vc) 230 RPM
0,1mm (fz) 140 mm/min (Vf)

"K" Factors

workpiece material	hardness	"K" factor
steels, and wrought and cast irons (plain carbon alloy steels, and tool steels) 40mm end mill – 6 flutes 30 m/min (vc) 230 RPM 0,1mm (fz) 140 mm/min (Vf)	85–200	1.64
	201–253	1.56
	254–286	1.28
	287–327	1.10
	328–371	.88
	372–481	.69
	482–560	.59
	561–615	.54
precipitation hardening stainless steels	150–450	1.27–.42
cast irons (grey, ductile, and malleable)	150–175	2.27
	110–190	2.0
	176–200	1.89
	201–250	1.52
	251–300	1.27
	301–320	1.19
stainless steels, and wrought and cast irons (ferritic, austenitic, and martensitic)	135–275	1.54–.76
	286–421	.74–.50
titanium	250–375	1.33–.87
high-temperature alloys, nickel, cobalt base	200–360	.83–.48
iron base	180–320	.91–.53
nickel alloys	80–360	.91–.53
aluminium alloys	30–150 (500 kg)	6.25–3.33
magnesium alloys	40–90 (500 kg)	10.0–6.67
copper	150	3.33
copper alloys	100–150	3.33
	151–243	2.0

Over the past 50 years, Metal Removal Rates (MRR) and power constants have served as the conventional values used to calculate horsepower. Although this is a relatively common method of calculating horsepower, a more accurate method has been developed when milling with high shear cutters. This new approach utilises the following information:

1. calculating tangential force (F_t)
2. ultimate material strength
3. cross-sectional area of the chip
4. number of inserts in the cut
5. machinability factor
6. tool wear factor
7. calculating torque
8. calculating horsepower at cutter
9. calculating horsepower at motor

Tangential Force, Torque, and Horsepower Calculations in Face Milling with High Shear Milling Cutters

1. Calculation of tangential force (N)

Calculation of tangential force is important since it produces torque at the spindle and accounts for the greatest portion of machining power at the cutting tool. Using this tangential force formula is a quick way to determine the approximate forces that fixtures, part wall sections, or spindle bearings will endure. Tangential force is calculated with the following formula:

$$F_t = S \times A \times Z_c \times C_m \times C_w \text{ (N)}$$

where: S = ultimate strength of the work material (N/mm^2)
A = cross-sectional area of the chip removed by the milling insert (mm^2)
Z_c = number of inserts in cut
C_m = machinability factor
C_w = tool wear factor

2. Ultimate material strength (N/mm^2)

The approximate relationship between the ultimate material strength and hardness of the most commonly used work materials such as steels, irons (for example: grey cast iron), titanium alloys (Ti – 6Al – 4V), and aluminium alloys (2024, 5052) can be expressed by the empirical formula:

$$S = 5 \times HB \text{ (N/mm}^2\text{)}$$

Where HB = Brinell hardness numbers obtained, primarily, at the 3000-kgf load. When testing soft metals such as aluminium alloys, the 500-kgf load is used. Hardness obtained at the 500-kgf load should be converted into the hardness equivalent of the 3000-kgf load by using the load factor of 1.15. For example, 130 HB at the 500-kgf load is equivalent to 150 HB at the 3000-kgf load (130 x 1.15 = 150). If hardness is given in Rockwell “B” or Rockwell “C” numbers, see the Material Listing Overview on page Y191.

3. Cross-sectional area of the chip (A)

Cross-sectional area of the chip (Fig. 1) is defined by:

where: A = d f (mm^2)
d = axial depth of cut (mm)
fz = feed per tooth (mm)

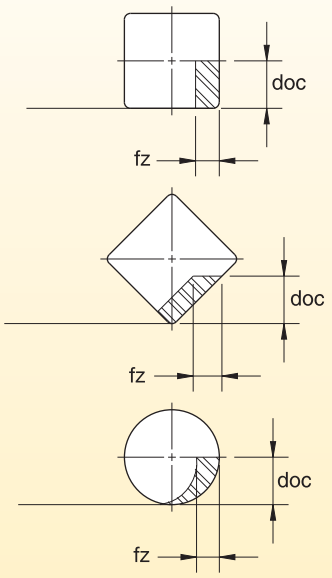


Figure 1: Cross-sectional area of the chip and insert’s shape

4. Number of inserts in cut (Zc)

The number of inserts in the cut (simultaneously engaged with work material) depends on the number of inserts in the cutter “Z” and the engagement angle (α). This relationship is shown by the formula:

$$Z_c = \frac{Z \times \alpha^\circ}{360^\circ}$$

The engagement angle depends on the width of cut “W” and cutter diameter “D”. This angle is found from the geometry of figure 2 (formulas to calculate engagement angle and the number of inserts in the cut at any width of cut are given in the appendix on page X20).

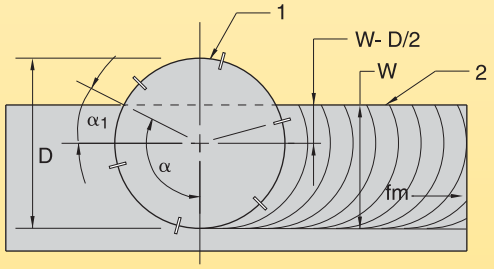


Figure 2: Schematic for calculating the number of inserts in cut

1 = milling cutter
2 = workpiece
α = engagement angle
α_1 = the angle between cutter centreline and cutter radius to the peripheral point of exit or entry
W = width of cut (woc)
D = cutter diameter
fm = workpiece feed motion

(continued)

(continued)

If the width of cut equals cutter diameter (W/D = 1.0), the engagement angle $\alpha = 180°$ and $Z_c = \frac{Z \times 180°}{360°} = 0.5Z$.

If the width of cut is equal to half of the cutter diameter (W/D = 0.5), the engagement angle $\alpha = 90°$ and $Z_c = \frac{Z \times 90°}{360°} = 0.25Z$.

The values of Z_c depending on the given W/D ratios, are shown in table 1.

Table 1

W/D	.88	.80	.75	.67	.56	.38	.33	.19	.125
Z_c	.38Z	.35Z	.33Z	.30Z	.27Z	.21Z	.20Z	.14Z	.12Z

5. Machinability factor (C_m)

Machinability factor is used to indicate degree of difficulty in machining various workpiece materials. Table 2 shows machinability factor values for some of the most common workpiece materials.

Table 2

workpiece material	C_m W/D≤.67	.67<W/D<1.0	W/D=1.0
carbon and alloy steels	1.0	1.15	1.3
stainless steel	2.0	2.15	2.3
grey cast iron	1.0	1.15	1.3
titanium alloys	1.0	1.20	1.4
aluminium alloys	1.0	1.05	1.1

The values of C_m are based on milling tests with a torque dynamometer at different cutting conditions. It has been found that machinability factor depends on type of work material and the ratio of radial width of cut to cutter diameter (W/D).

This ratio determines the uniformity of the chip thickness. When W/D = 1.0, the chip at the point of entry starts off at zero thickness. It increases to a maximum thickness at the centreline of the cutter, and thins off to zero again at the point of exit. This type of cut generates maximum friction at the cutting edge, and machinability factor reaches its maximum value. The optimal cutting conditions are obtained when W/D = 2/3 = .67. The thickness of the chip is practically uniform, the friction is minimal, and machinability factor decreases to its minimum value.

More extensive testing will determine machinability factors for a larger variety of work materials and improve the accuracy for calculating tangential force and power consumption.

6. Tool wear factor (C_w)

For milling with sharp cutting tools (short time operation), tool wear factor $C_w = 1.0$. For a longer operation (before the inserts are indexed), the following tool wear factors are considered:

- light face milling $C_w = 1.1$
- general face milling $C_w = 1.2$
- heavy-duty face milling $C_w = 1.3$

7. Calculation of torque (Nm)

The torque "T" generated by tangential force is calculated using the following formula:

$T = F_t \times D/2$ (Nm)

where D = cutter diameter (m)

8. Calculating horsepower (HP_c or HP_m)

The machining power at the cutter (sharp edges) is calculated by either of these two formulas:

$$HP_c = \frac{F_t \times Vc}{10{,}000}$$

or

$$HP_c = \frac{T \times n}{1{,}600}$$

where vc = peripheral cutting speed (m/min)
n = spindle speed (RPM)
10000 and 1600 = conversion factors

9. The required power at the motor is calculated using the following formula (HP_m):

$$HP_m = \frac{HP_c}{E}$$

where E = machine tool efficiency factor (E = .75–.90)

NOTE: Spindle efficiency varies from 75–90%.

(continued)

(continued)

Example for Calculating Horsepower

given values:

milling cutter KSOM125R06OF07:

effective diameter	D = 125mm
number of inserts	Z = 6

workpiece material:
alloy steel AISI 4140
hardness 220 HB

machining conditions:

spindle speed	n = 458 RPM
cutting speed	Vc = 180 m/min
machine feed rate	Vf = 824 mm/min
mm per tooth (chip load)	fz = 0,3mm
axial depth of cut	doc = 4mm
radial width of cut	woc = 90mm
W/D ratio	W/D = 0,72

Step-By-Step Calculations

1. Calculating tangential force

1.1 ultimate strength of the workpiece material
$S = 5 \times HB = 5 \times 220 = 1100\ N/mm^2$

1.2 cross-sectional area of the chip
$A = doc \times fz = 4 \times 0,3 = 1,2\ mm^2$

1.3 number of inserts in cut:
width of cut-to-diameter ratio (w/d)
W/D = 90 / 125 = 0,72 (See Table 1, page X12)
Now use Z_c value shown in Table 1 under 0,72.
Zc = 0,33 x Z = 0,33 x 6 = 2 inserts in cut.

NOTE: Z = number of inserts in cutter.

1.4 tangential force
$Ft = S \times A \times Z_c \times C_m \times C_w$
$Ft = 1100 \times 1,2 \times 2 \times 1.1 \times 1.1 = 3194\ N$

NOTE: $C_m = 1.1$ and $C_w = 1.1$

2. Calculating torque at the cutter

$$T = (F_t \times D)/2 = \frac{3,194 \times 0,125}{2} = 199,6\ Nm$$

3. Calculating horsepower

- At the cutter...reference formulas in paragraph 8 on page X12.

$$HP_c = \frac{F_t \times Vc}{10,000} = \frac{3,194 \times 458}{10,000} = 57,5hp$$

or

$$HP_c = \frac{T \times RPM}{1,600} = \frac{1,996 \times 458}{1,600} = 57,5hp$$

- At the motor...reference formula in paragraph 9 on page X12.
- Where E = machine tool efficiency factor (E = .75 to .90).

$$HP_m = \frac{HP_c}{E} = \frac{57,5}{.8} = 71,9\ hp$$

Surface finish may be an important specification on a machined part. Finishes produced by indexable insert cutters usually range from 0.80–3.2 (32–150) Ra. This broad range can be affected by several variables such as work material, machine rigidity, spindle alignment, fixturing, insert nose geometry, insert wear, cutting feed and speed, heat-generated chip welding, and chatter.

Good finishes will result when you use the right combination of cutter geometry, insert style, and cutting speeds and feeds for the material being milled. It is also important to have the part adequately fixtured, and the machine properly maintained.

Figure 1 illustrates that finer finishes can be obtained by using a larger corner radius, flat, or wiper on the insert. This tends to wipe out or reduce feed marks. In addition to the corner geometry of the insert, it is important to correctly set each insert relative to the other inserts. For example, if all of the inserts have the same corner geometry, and are set in the cutter body to a face height of approximately 0,025mm relative to each other, the finish produced will be better than if the inserts were set to within 0,07mm.

Improved finishes can also be obtained by increasing speeds and reducing feeds. Be aware, however, that increased speed also increases cutting temperatures, and may reduce insert edge life.

Finish will not necessarily be the same on all areas of the milled surface. Figure 2 shows that the Ra finish will be lower on the area where the feed marks are close to each other, and higher where feed marks are farther apart.

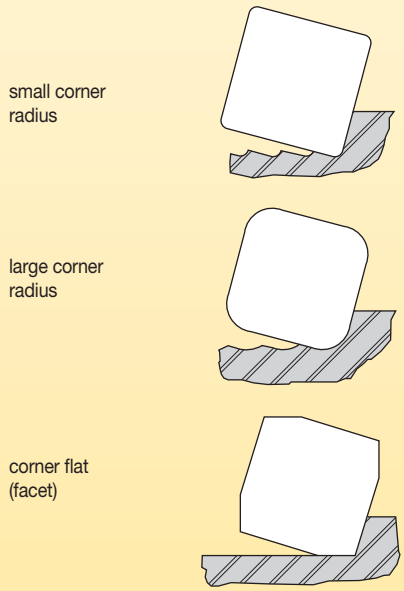


Figure 1: Larger insert corner radii or flats produce finer milling finishes.

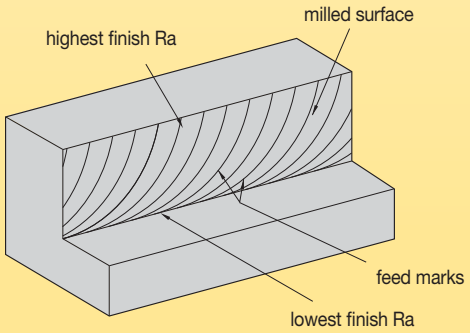


Figure 2: Quality of Ra finish corresponds to the distance between feed marks.

In figure 3, the Ra value will be lower near the outside diameter of the cut where the feed marks are at their closest, and higher at the centre where the feed marks are farthest apart. Peaks produced are highest at the centre of the cutter as it is positioned in the cut, and lowest at the outside diameter of the cutter, as illustrated below in figures 3 and 4.

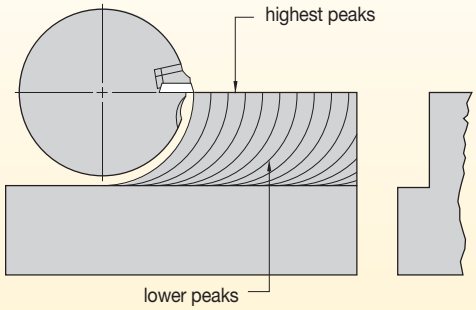


Figure 3: Ra finish is higher at the widest feed marks.

Both finish and flatness are affected by feed marks. A taper will be produced from the high peaks down to the low peaks.

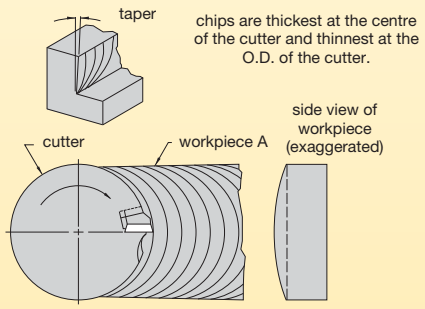


Figure 4: A taper is produced from the high peaks to the low ones.

Flatness also affects part tolerance. This effect is more predominant in side milling both sides of a part as shown in figure 5.

An obvious solution to obtaining a more consistent and improved surface finish with a minimum of taper is to reduce or flatten the peaks between feed marks. This can be done by introducing an insert with a corner configuration capable of wiping out or reducing these peaks. Shown in figure 5 is an exaggerated change in part width due to flatness and taper.

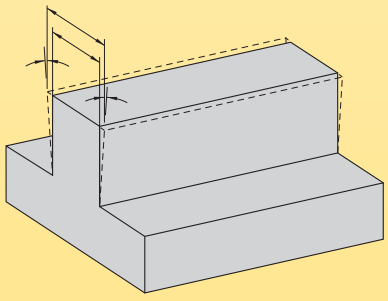


Figure 5: Flatness affects part tolerance more when milling both sides of a part.

(continued)

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Figures 6 and 7 compare the feed marks produced with a nose radius insert to those produced with a wiper insert. A wiper insert with a large radius for wiping out or reducing peaks (figure 7) has been effective in producing finishes below 2.5 Ra. Figures 6 and 7 show the wiper insert is designed to "top off" the peaks of the feed marks. An improved surface finish, surface flatness, and reduced taper will result.

Wiper inserts are normally set at 0,025–0,04mm above the highest positioned insert in the cutter to ensure a good wiping action. Kennametal wiper inserts are typically designed to fit into any pocket in the cutter body. This means one or more wiper inserts can be used. Interchangeable wipers can be used to share the load on the periphery of the cut in feed per tooth.

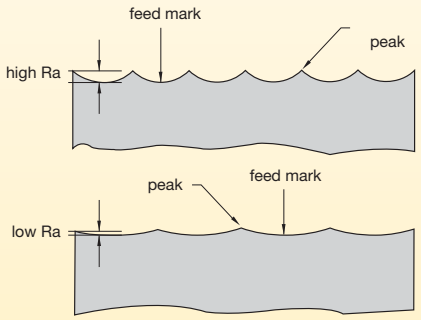

Figure 6: Peaks produced with a standard radii insert (top) compared to those produced with a large radius wiper insert (bottom).

Poor Surface Finish

cause	solution
cutter runout	Check for high insert, dirt in the pockets, or dirty spindle and cutter mounting face. Also, look for burs on the cutter and damaged cutter pocket.
worn or chipped insert	Index insert.
feed per revolution exceeding flat on wiper	Reduce feed rate or install wiper with greater effective insert facet width.
wiper insert is set too high	Set the wiper insert 0,025–0,04mm above highest insert.
chatter	Check rigidity of machine and table fixturing. Check arbour and spindle, adjust feed rates, adjust RPM, or reduce cut width. Consider cutter with fewer pockets.

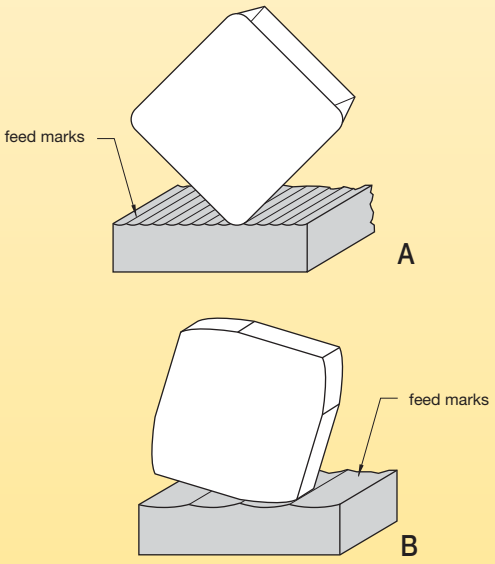

Figure 7: Feed marks produced with a nose radius insert (A) compared to marks produced with a wiper insert (B).

(continued)

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Measuring Finish Produced in a Milling Operation

Do not rely on your eye or fingernail to determine surface finish. Fingernails are about 25 times as thick as the stylus tip of a surface measuring instrument. They will skid across surface peaks, missing the valleys. Use a surface measuring instrument since the appearance of the surface finish may be deceiving. For example, reflected light on a uniformly milled surface pattern will look smoother than a random pattern. Also, a shiny surface will appear smoother than a dull surface.

Placement of the measuring device in a specific area on the milled surface will affect the reading. Also, a surface finish measured perpendicular to the feed direction is better than measuring parallel to the feed direction. This is usually the case regardless of workpiece condition and material (see figure 8).

Changing the cut-off width of the surface measuring instrument will affect the Ra value of the measurement.

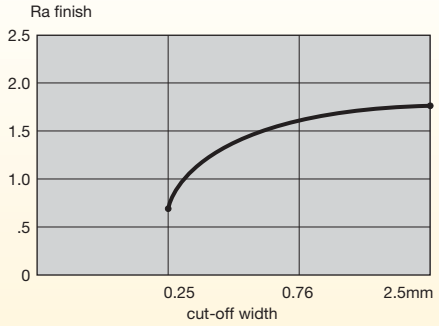


Figure 10: Finish quality is directly proportional to the cut-off width.

Surface Profile Record

Figure 9 shows the variation in roughness created by increasing the cut-off width on the instrument. The greater the cut-off, (see figure 9), the higher the Ra finish. For example, figure 10 illustrates that a 0,25mm cut-off width will produce a 0.6 Ra finish; whereas, a 0,76mm cut-off width will produce a 2.0 Ra finish.

Also, figure 10 demonstrates that most measuring devices are provided with 0,25mm, 0,76mm, and 2,54mm cut-offs. In most cases, the 0,76mm width cut-off is preferred.

Figure 11 shows the standard surface symbols specifying maximum and minimum roughness, waviness, and lay, which is the direction in which the measurement is taken.

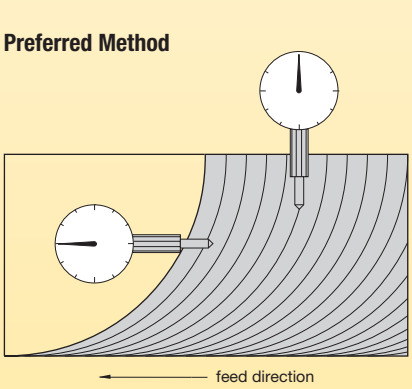


Figure 8: Measuring surface finish

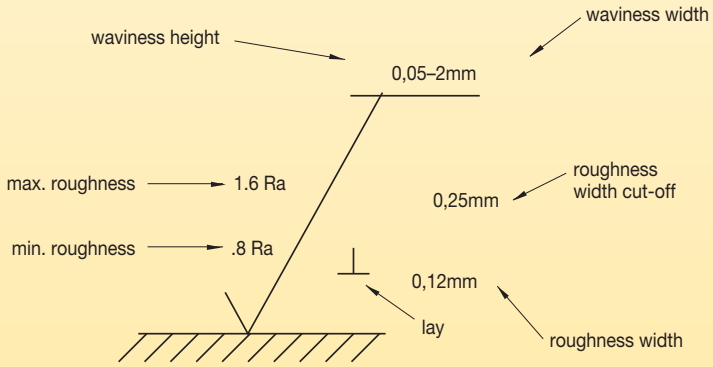


Figure 11: Standard surface symbols

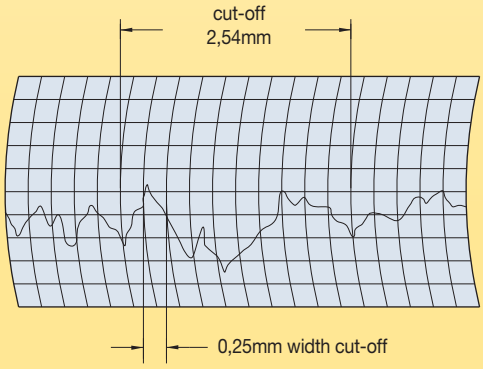


Figure 9: Increasing the cut-off width creates a variation in roughness.

Troubleshooting Introduction

Troubleshooting should be performed in a sequential method to identify and solve your milling problems. These problems can be recognised as premature insert edge failure, part appearance, machine noise or vibration, and the cutter's appearance. Successful troubleshooting requires that we correctly identify the problem, then take the necessary corrective action one step at a time. The five key areas of concern are:

1. cutting tool material (grade)
2. cutter/adaptor
3. machine
4. workpiece
5. set-up/fixturing

This section will discuss possible causes and will recommend corrective actions for each of the five areas listed. Remember, if more than one step is taken concurrently, the real cause of the problem may never be discovered. Always perform one corrective measure at a time.

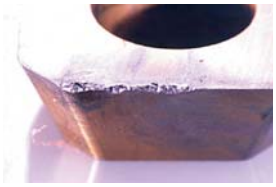
Edge Condition Problems and Solutions

Chipping:

Appears like normal flank wear to the untrained eye. Actually, normal flank wear lands have a fine, smooth wear pattern, while a land formed by chipping has a saw-toothed, uneven surface. If chipping is not detected soon enough, it may be perceived as depth-of-cut notching.

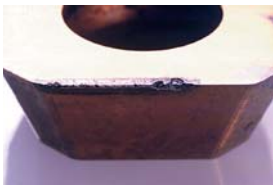
Chipping can also be caused by recutting of chips. A good example of this would be a slotting operation where chip clearance or chip gullet space does not allow the chips to evacuate cleanly. In this instance, packing of the chips also occurs.

In most cases, by changing to a stronger grade and/or to a different edge preparation such as a larger hone or T-land, or from a 90° cutter geometry to a lead angle cutter geometry, will resolve the problem.

problem	cause	solution
chipping 	• chatter	• Check system rigidity for proper part clamping. • Correct worn gibs/bearings. • Check for improper cutter mounting.
	• edge prep	• Use largest hone or T-land possible.
	• grade	• Use a tougher grade.
	• built-up edge	• Increase speed.
	• feed	• Reduce feed per tooth.
	• recutting chips	• Choose cutter geometry with correct pitch for chip clearance. • Use air blast or coolant to remove chips.

Depth-of-cut notching:

Appears when chipping or localised wear at the depth-of-cut line on the rake face and flank of the insert occurs. Notching is primarily caused by the condition of the workpiece material. Material conditions prone to depth-of-cut notch include: an abrasive workpiece skin of scale, abrasive properties of high-temperature alloys like Inconel®, a work-hardened outer layer resulting from a previous machining operation, or heat-treated material above 55 HRC.

problem	cause	solution
depth-of-cut notching 	• cutter geometry	• Change to a lead angle cutter.
	• grade	• Use a more wear-resistant grade of carbide.
	• feed	• Reduce feed per tooth.
	• speed	• Reduce speed.
	• edge-prep	• Use honed or T-land inserts.
	• programming	• Vary depth of cut on very abrasive materials.

Thermal cracks:

These cracks run perpendicular to the insert's cutting edge and are caused by the extreme temperature variations involved in milling. In one revolution of a milling cutter, the insert starts to cut and the temperature quickly rises as the insert enters the cut. The varying chip thickness also changes the temperature throughout the cut. When the insert comes out of the cut, air or coolant flow rapidly cools the insert before it re-enters the cut.

These temperature variations create heat stresses in the insert which can result in thermal cracks. To the untrained eye, advanced thermal cracking could appear as chipping.

problem	cause	solution
thermal cracks 	• speed and feed	• Reduce cutting edge temperature by reducing the cutting speed and possibly the feed per tooth.
	• coolant	• Shut off coolant.
	• grade	• Use coated grade designed for wet milling.

Built-up edge:

This condition involves the adhesion of layers of workpiece material to the top surface of the insert. Hardened pieces of the adhered material periodically break free, leaving an irregularly shaped depression along the cutting edge. This causes damage to the part and insert. Cutting forces also will be increased due to built-up edge.

problem	cause	solution
built-up edge 	• speed	• Increase SFM.
	• feed	• Increase feed per tooth.
	• coolant	• Use mist or flood coolant to avoid chips sticking to the insert when machining stainless steel and aluminium alloys.
	• grade	• Use sharp edge PVD inserts.
		• Higher speeds require diamond-tipped inserts or diamond-coated inserts on certain non-ferrous alloys.
	• edge-prep	• Use sharp edge, positive rake PVD inserts, or polished inserts.

Crater wear:

A relatively smooth, regular depression is produced on the insert's rake face. Crater wear occurs in two ways:

1. Material adhering to the insert's top surface is dislodged, carrying away minute fragments of the top surface of the insert.
2. Frictional heat builds up from the flow of chips over the top surface of the insert. Eventually, this heat buildup softens the insert behind the cutting edge and removes minute particles of the insert until a crater forms.

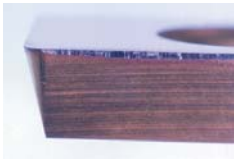
Crater wear is rarely encountered in milling, but can appear when machining certain steel and cast iron alloys. If crater wear becomes severe, there is a risk that the cutting edge will break, destroying the insert.

problem	cause	solution
crater wear 	• grade	• Use a more wear-resistant grade.
	• speed	• Reduce cutting speed.
	• edge-prep	• Use smaller T-land or increase feed to proper range for T-land.

Flank wear:

Uniform flank wear is the preferred method of insert failure because it can be predicted. Excessive flank wear increases cutting forces and contributes to poor surface finish. When wear occurs at an unacceptable rate or becomes unpredictable, the key elements that must be investigated are speed, feed, grade, and insert/cutter geometry.

NOTE: Inserts should be indexed for roughing applications when flank wear reaches 0,38–0,50mm. For finish applications, inserts should be indexed once flank wear reaches 0,25–0,38mm, if not sooner.

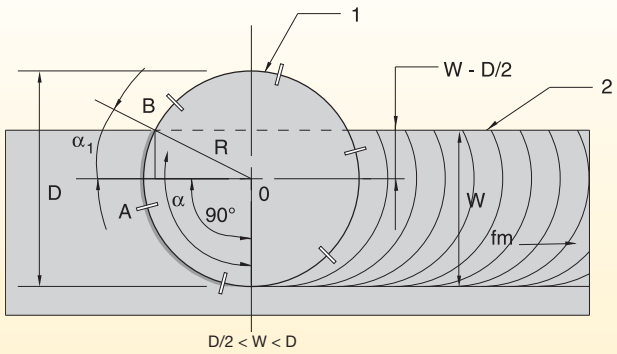
problem	cause	solution
flank wear 	• speed	• Check this area first. Recalculate SFM (Vc) to assure correctness. • Speed should be reduced without changing feed per tooth.
	• feed	• Increase feed per tooth (feed should be high enough to avoid the pure rubbing, which occurs with small chip thickness).
	• grade	• Use more wear-resistant grade. • Change to a coated grade if you are now using an uncoated grade.
	• insert geometry	• Inspect insert to determine if proper style is being used in the cutter.

Multiple factors:

When wear, chipping, thermal cracking, and breakage occur at once, the machine operator must look beyond the normal feed, speed, and depth-of-cut adjustments to find the root cause of the problem. Speed, feed, and depth-of-cut parameters should be re-examined for accuracy, but the system's rigidity should also be closely inspected for loose or worn parts as well.

problem	cause	solution
multiple factors 	• system rigidity	• Check system for loose cutter mounting. • Improve fixture and cutter rigidity. • Check for worn hardware or improper insert installation. • Reduce the gauge length of the cutter and arbour assembly.
	• feed	• Reduce feed rate to relieve cutting forces.
	• cutter geometry	• If possible, use a lead angle cutter to redirect cutting forces away from the insert nose.
	• insert/grade	• If possible, use a larger nose radius. • Use T-land insert. • Use a tougher grade of carbide.

Appendix • Engagement Angle and Number of Inserts in Cut

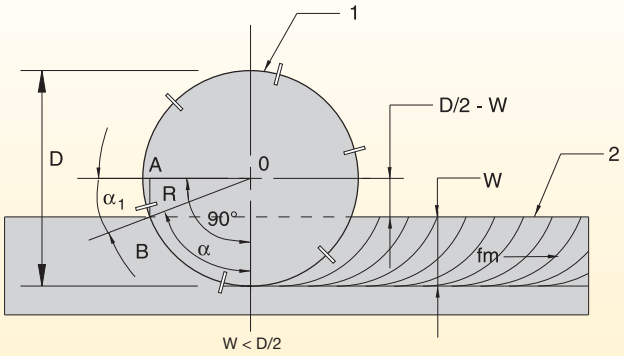


$$Z_c = \frac{Z \times \alpha^\circ}{360^\circ} \qquad \alpha = 90^\circ + \alpha_1$$

$$\sin \alpha_1 = \frac{AB}{OB} = \frac{W - D/2}{D/2} = \frac{2(W - D/2)}{D} = \frac{2W - D}{D};$$

$$\alpha_1 = \arcsin \frac{2W - D}{D};$$

$$Z_c = \frac{Z\left(90^\circ + \arcsin \frac{2W - D}{D}\right)}{360^\circ}$$



$$Z_c = \frac{Z \times \alpha^\circ}{360^\circ} \qquad \alpha = 90^\circ - \alpha_1$$

$$\sin \alpha_1 = \frac{AB}{OB} = \frac{D/2 - W}{D/2} = \frac{2(D/2 - W)}{D} = \frac{D - 2W}{D};$$

$$\alpha_1 = \arcsin \frac{D - 2W}{D}$$

$$Z_c = \frac{Z\left(90^\circ - \arcsin \frac{D - 2W}{D}\right)}{360^\circ}$$

D = cutter diameter
W = width of cut (woc)
α = engagement angle
α_1 = angle between cutter centreline and cutter radius to the peripheral point of exit or entry
Z = number of inserts in cutter
Z_c = number of inserts in cut

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Norway	English	800 10080	na.techsupport@kennametal.com
Poland	Polish	0080 04411887	eu.techsupport@kennametal.com
Russia (landline)	Russian	8800 5556394	eu.techsupport@kennametal.com
Russia (cell phone)	Russian	+7 8005556394	eu.techsupport@kennametal.com
Singapore	English	1800 6221031	ap-kmt.techsupport@kennametal.com
South Africa	English	0800 981643	na.techsupport@kennametal.com
Sweden	English	020799246	na.techsupport@kennametal.com
Taiwan	English	0800 666 197	ap-kmt.techsupport@kennametal.com
Thailand	English	1800 4417820	ap-kmt.techsupport@kennametal.com
UK	English	0800 032 8339	na.techsupport@kennametal.com
Ukraine	Russian	0800502664	eu.techsupport@kennametal.com
USA	English	800 835 3668	na.techsupport@kennametal.com

Numbers shown only serve the originating country listed.

Metric • Face Milling, Contour Milling, Profiling and Die & Mould

Material Group		GH1			GH2			K110M			K115M			K313			KBK50			KC410M*		
P	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	6	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
M	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
K	1	350	**260**	160	300	**220**	145	155	**145**	140	220	**180**	145	230	**205**	180	1200	**800**	600	–	–	–
	2	295	**220**	145	260	**190**	125	140	**125**	120	180	**145**	110	–	–	–	1200	**800**	600	–	–	–
	3	240	**190**	140	220	**175**	120	120	**110**	95	110	**90**	70	–	–	–	1200	**800**	600	–	–	–
N	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
S	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
H	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

Material Group		KC422M*			KC505M			KC510M			KC515M			KC520M			KC522M			KC524M		
P	1	–	–	–	–	–	–	–	–	–	330	**295**	260	–	–	–	395	**340**	325	–	–	–
	2	–	–	–	–	–	–	–	–	–	310	**275**	240	–	–	–	330	**290**	240	–	–	–
	3	–	–	–	–	–	–	–	–	–	275	**240**	205	–	–	–	305	**260**	210	–	–	–
	4	–	–	–	360	**265**	215	295	**240**	205	240	**205**	160	–	–	–	270	**220**	180	–	–	–
	5	–	–	–	360	**265**	215	–	–	–	205	**160**	125	–	–	–	220	**205**	180	–	–	–
	6	–	–	–	350	**240**	190	–	–	–	160	**125**	110	–	–	–	200	**150**	120	–	–	–
M	1	–	–	–	–	–	–	–	–	–	330	**275**	240	–	–	–	245	**215**	200	–	–	–
	2	–	–	–	–	–	–	–	–	–	275	**220**	160	–	–	–	220	**190**	155	–	–	–
	3	–	–	–	–	–	–	–	–	–	220	**180**	145	–	–	–	170	**145**	115	–	–	–
K	1	–	–	–	230	**205**	180	355	**320**	290	440	**330**	220	325	**295**	260	275	**245**	220	450	**320**	230
	2	–	–	–	210	**185**	160	275	**245**	230	330	**260**	180	250	**230**	210	215	**190**	180	390	**245**	190
	3	–	–	–	140	**115**	90	235	**210**	190	145	**110**	70	210	**190**	175	180	**160**	145	300	**220**	155
N	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
S	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
H	1	–	–	–	265	**205**	170	190	**155**	110	170	**120**	95	–	–	–	145	**110**	85	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

*Recommended for wet machining only.

(continued)

NOTE: FIRST choice starting speeds are in **bold** type.
As the average chip thickness increases, the speed should be decreased.

Dry

Wet

(continued)

Metric • Face Milling, Contour Milling, Profiling, and Die & Mould

Material Group		KC525M			KC530M			KC725M			KC735M			KCK15			KCK20			KCPK30		
P	1	265	**240**	215	275	**240**	205	310	**275**	260	155	**145**	120	–	–	–	–	–	–	545	**475**	445
	2	215	**190**	180	240	**205**	160	265	**230**	190	145	**130**	125	–	–	–	–	–	–	335	**305**	275
	3	190	**180**	170	205	**180**	160	240	**205**	170	130	**120**	110	–	–	–	–	–	–	305	**275**	245
	4	170	**155**	145	180	**160**	145	215	**180**	145	120	**110**	95	–	–	–	–	–	–	230	**210**	190
	5	180	**170**	155	160	**145**	125	180	**160**	145	110	**95**	90	–	–	–	–	–	–	310	**275**	250
	6	155	**145**	130	125	**110**	90	155	**120**	95	95	**90**	85	–	–	–	–	–	–	190	**160**	–
M	1	180	**170**	155	275	**220**	180	205	**180**	160	125	**110**	95	–	–	–	–	–	–	245	**220**	185
	2	155	**145**	130	180	**145**	125	185	**155**	130	115	**100**	90	–	–	–	–	–	–	220	**190**	170
	3	110	**95**	85	145	**125**	110	140	**120**	95	85	**70**	–	–	–	–	–	–	–	175	**155**	140
K	1	–	–	–	–	–	–	–	–	–	–	–	–	505	**460**	410	350	**305**	260	355	**320**	290
	2	–	–	–	–	–	–	–	–	–	–	–	–	400	**355**	330	275	**240**	210	280	**250**	230
	3	–	–	–	–	–	–	–	–	–	–	–	–	335	**300**	275	230	**205**	175	235	**210**	190
N	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
S	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
H	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

Material Group		KCPM40			KCSM30			KCSM40			KD1400			KD1410*			KD1415*			KD1425*		
P	1	355	**310**	295	265	**240**	215	275	**240**	205	310	**275**	260	–	–	–	–	–	–	–	–	–
	2	300	**260**	215	215	**190**	180	240	**205**	160	265	**230**	190	–	–	–	–	–	–	–	–	–
	3	275	**235**	190	190	**180**	170	205	**180**	160	240	**205**	170	–	–	–	–	–	–	–	–	–
	4	245	**205**	160	170	**155**	145	180	**160**	145	215	**180**	145	–	–	–	–	–	–	–	–	–
	5	205	**185**	160	180	**170**	155	160	**145**	125	180	**160**	145	–	–	–	–	–	–	–	–	–
	6	180	**140**	110	155	**145**	130	125	**110**	90	155	**120**	95	–	–	–	–	–	–	–	–	–
M	1	235	**205**	185	180	**170**	155	275	**220**	180	205	**180**	160	–	–	–	–	–	–	–	–	–
	2	210	**180**	150	155	**145**	130	180	**145**	125	185	**155**	130	–	–	–	–	–	–	–	–	–
	3	155	**140**	110	110	**95**	85	145	**125**	110	140	**120**	95	–	–	–	–	–	–	–	–	–
K	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
N	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
S	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
H	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

*Recommended for wet machining only.

(continued)

NOTE: FIRST choice starting speeds are in **bold** type.
As the average chip thickness increases, the speed should be decreased.

Dry

Wet

(continued)

Metric • Face Milling, Contour Milling, Profiling, and Die & Mould

Material Group		KTPK20			KY3500			KYS30			KYSP30			MP91M			SC3025			SC6525		
P	1	440	**360**	305	–	**–**	–	–	**–**	–	–	**–**	–	415	**295**	170	–	**–**	–	445	**305**	170
	2	270	**230**	190	–	**–**	–	–	**–**	–	–	**–**	–	365	**260**	145	–	**–**	–	390	**270**	145
	3	245	**205**	175	–	**–**	–	–	**–**	–	–	**–**	–	325	**230**	125	–	**–**	–	350	**240**	125
	4	180	**155**	130	–	**–**	–	–	**–**	–	–	**–**	–	245	**175**	95	–	**–**	–	250	**175**	95
	5	250	**210**	175	–	**–**	–	910	**730**	545	910	**730**	545	–	**–**	–	–	**–**	–	190	**145**	95
	6	155	**125**	–	–	**–**	–	910	**730**	545	910	**730**	545	–	**–**	–	–	**–**	–	170	**120**	70
M	1	290	**235**	200	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	240	**215**	170
	2	260	**220**	180	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	230	**190**	145
	3	190	**160**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	175	**155**	110
K	1	275	**235**	190	965	**875**	780	–	**–**	–	–	**–**	–	440	**305**	175	475	**330**	180	470	**325**	175
	2	220	**180**	155	760	**685**	635	–	**–**	–	–	**–**	–	340	**240**	140	400	**275**	145	365	**250**	140
	3	180	**155**	125	–	**–**	–	–	**–**	–	–	**–**	–	310	**220**	125	330	**230**	125	–	**–**	–
N	1	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
	2	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
	3	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
S	1	–	**–**	–	–	**–**	–	805	**660**	510	805	**660**	510	–	**–**	–	–	**–**	–	–	**–**	–
	2	–	**–**	–	–	**–**	–	805	**660**	510	805	**660**	510	–	**–**	–	–	**–**	–	–	**–**	–
	3	–	**–**	–	–	**–**	–	1170	**955**	730	1170	**955**	730	–	**–**	–	–	**–**	–	–	**–**	–
	4	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
H	1	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	125	**95**	60	–	**–**	–	–	**–**	–
	2	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	115	**85**	50	–	**–**	–	–	**–**	–
	3	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–

Material Group		SP4019			SP6519			X400			X500			X700		
P	1	380	**275**	170	355	**260**	155	310	**230**	145	325	**240**	155	–	**–**	–
	2	330	**240**	145	310	**230**	140	275	**205**	125	290	**215**	140	–	**–**	–
	3	295	**210**	125	275	**200**	120	240	**180**	115	250	**185**	120	–	**–**	–
	4	230	**160**	95	210	**150**	90	180	**130**	85	190	**145**	90	–	**–**	–
	5	180	**130**	85	170	**125**	85	–	**–**	–	155	**120**	85	160	**125**	85
	6	155	**110**	60	145	**100**	60	–	**–**	–	130	**95**	60	140	**100**	60
M	1	335	**240**	145	325	**235**	140	–	**–**	–	300	**220**	140	310	**230**	140
	2	300	**215**	130	280	**205**	125	–	**–**	–	265	**190**	120	275	**205**	125
	3	240	**175**	110	235	**170**	100	–	**–**	–	215	**155**	95	230	**170**	100
K	1	395	**290**	175	355	**265**	170	–	**–**	–	310	**265**	205	–	**–**	–
	2	305	**220**	140	290	**210**	130	–	**–**	–	265	**215**	155	–	**–**	–
	3	280	**205**	125	265	**190**	120	–	**–**	–	205	**170**	120	–	**–**	–
N	1	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
	2	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
	3	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
S	1	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
	2	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
	3	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
	4	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
H	1	120	**90**	60	–	**–**	–	115	**85**	55	–	**–**	–	–	**–**	–
	2	110	**80**	50	–	**–**	–	95	**70**	40	–	**–**	–	–	**–**	–
	3	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–

*Recommended for wet machining only.

NOTE: FIRST choice starting speeds are in **bold** type.
As the average chip thickness increases, the speed should be decreased.

Dry

Wet

Metric • Shoulder Milling, Slotting, and Thread Mills

Material Group		GH1			GH2			K110M			K115M			K313			KBK50			KC410M*		
P	1	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
	2	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
	3	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
	4	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
	5	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
	6	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
M	1	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
	2	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
	3	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
K	1	290	**215**	135	250	**185**	120	130	**120**	115	185	**150**	120	190	**170**	150	1000	**665**	500	–	**–**	–
	2	245	**185**	120	215	**160**	105	115	**105**	100	150	**120**	90	–	**–**	–	1000	**665**	500	–	**–**	–
	3	200	**160**	115	185	**145**	100	100	**90**	80	90	**75**	60	–	**–**	–	1000	**665**	500	–	**–**	–
N	1	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
	2	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
	3	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
S	1	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
	2	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
	3	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
	4	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
H	1	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
	2	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
	3	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–

Material Group		KC422M *			KC505M			KC510M			KC515M			KC520M			KC522M			KC524M		
P	1	–	**–**	–	–	**–**	–	–	**–**	–	275	**245**	215	–	**–**	–	330	**285**	270	–	**–**	–
	2	–	**–**	–	–	**–**	–	–	**–**	–	260	**230**	200	–	**–**	–	275	**240**	200	–	**–**	–
	3	–	**–**	–	–	**–**	–	–	**–**	–	230	**200**	170	–	**–**	–	255	**215**	175	–	**–**	–
	4	–	**–**	–	300	**220**	180	245	**200**	170	200	**170**	135	–	**–**	–	225	**185**	150	–	**–**	–
	5	–	**–**	–	300	**220**	180	–	**–**	–	170	**135**	105	–	**–**	–	185	**170**	150	–	**–**	–
	6	–	**–**	–	290	**200**	160	–	**–**	–	135	**105**	90	–	**–**	–	165	**125**	100	–	**–**	–
M	1	–	**–**	–	–	**–**	–	–	**–**	–	275	**230**	200	–	**–**	–	205	**180**	165	–	**–**	–
	2	–	**–**	–	–	**–**	–	–	**–**	–	230	**185**	135	–	**–**	–	185	**160**	130	–	**–**	–
	3	–	**–**	–	–	**–**	–	–	**–**	–	185	**150**	120	–	**–**	–	140	**120**	95	–	**–**	–
K	1	–	**–**	–	190	**170**	150	295	**265**	240	365	**275**	185	270	**245**	215	230	**205**	185	375	**265**	190
	2	–	**–**	–	175	**155**	135	230	**205**	190	275	**215**	150	210	**190**	175	180	**160**	150	325	**205**	160
	3	–	**–**	–	115	**95**	75	195	**175**	160	120	**90**	60	175	**160**	145	150	**135**	120	250	**185**	130
N	1	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
	2	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
	3	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
S	1	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
	2	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
	3	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
	4	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
H	1	–	**–**	–	220	**170**	140	160	**130**	90	140	**100**	80	–	**–**	–	120	**90**	70	–	**–**	–
	2	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
	3	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–

*Recommended for wet machining only.

NOTE: FIRST choice starting speeds are in **bold** type.
As the average chip thickness increases, the speed should be decreased.

(continued)

Dry

Wet

(continued)

Metric • Shoulder Milling, Slotting, and Thread Mills

Material Group		KC525M			KC530M			KC725M			KC735M			KCK15			KCK20			KCPK30		
P	1	220	**200**	180	230	**200**	170	260	**230**	215	130	**120**	100	–	–	–	–	–	–	455	**395**	370
	2	180	**160**	150	200	**170**	135	220	**190**	160	120	**110**	105	–	–	–	–	–	–	280	**255**	230
	3	160	**150**	140	170	**150**	135	200	**170**	140	110	**100**	90	–	–	–	–	–	–	255	**230**	205
	4	140	**130**	120	150	**135**	120	180	**150**	120	100	**90**	80	–	–	–	–	–	–	190	**175**	160
	5	150	**140**	130	135	**120**	105	150	**135**	120	90	**80**	75	–	–	–	–	–	–	260	**230**	210
	6	130	**120**	110	105	**90**	75	130	**100**	80	80	**75**	70	–	–	–	–	–	–	160	**135**	–
M	1	150	**140**	130	230	**185**	150	170	**150**	135	105	**90**	80	–	–	–	–	–	–	205	**185**	155
	2	130	**120**	110	150	**120**	105	155	**130**	110	95	**85**	75	–	–	–	–	–	–	185	**160**	140
	3	90	**80**	70	120	**105**	90	115	**100**	80	70	**60**	–	–	–	–	–	–	–	145	**130**	115
K	1	–	–	–	–	–	–	–	–	–	–	–	–	420	**385**	340	290	**255**	215	295	**265**	240
	2	–	–	–	–	–	–	–	–	–	–	–	–	335	**295**	275	230	**200**	175	235	**210**	190
	3	–	–	–	–	–	–	–	–	–	–	–	–	280	**250**	230	190	**170**	145	195	**175**	160
N	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
S	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
H	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

Material Group		KCPM40			KCSM30			KCSM40			KD1400			KD1410*			KD1415*			KD1425*		
P	1	295	**260**	245	230	**200**	170	260	**230**	215	130	**120**	100	–	–	–	–	–	–	–	–	–
	2	250	**215**	180	200	**170**	135	220	**190**	160	120	**110**	105	–	–	–	–	–	–	–	–	–
	3	230	**195**	160	170	**150**	135	200	**170**	140	110	**100**	90	–	–	–	–	–	–	–	–	–
	4	205	**170**	135	150	**135**	120	180	**150**	120	100	**90**	80	–	–	–	–	–	–	–	–	–
	5	170	**155**	135	135	**120**	105	150	**135**	120	90	**80**	75	–	–	–	–	–	–	–	–	–
	6	150	**115**	90	105	**90**	75	130	**100**	80	80	**75**	70	–	–	–	–	–	–	–	–	–
M	1	195	**170**	155	230	**185**	150	170	**150**	135	105	**90**	80	–	–	–	–	–	–	–	–	–
	2	175	**150**	125	150	**120**	105	155	**130**	110	95	**85**	75	–	–	–	–	–	–	–	–	–
	3	130	**115**	90	120	**105**	90	115	**100**	80	70	**60**	–	–	–	–	–	–	–	–	–	–
K	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
N	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
S	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
H	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

*Recommended for wet machining only.

(continued)

NOTE: FIRST choice starting speeds are in **bold** type.
As the average chip thickness increases, the speed should be decreased.

Dry

Wet

Technical Information

(continued)

Metric • Shoulder Milling, Slotting, and Thread Mills

Material Group		KTPK20			KY3500			KYS30			KYSP30			MP91M			SC3025			SC6525		
P	1	365	**300**	255	–	–	–	–	–	–	–	–	–	345	**245**	140	–	–	–	370	**255**	140
	2	225	**190**	160	–	–	–	–	–	–	–	–	–	305	**215**	120	–	–	–	325	**225**	120
	3	205	**170**	145	–	–	–	–	–	–	–	–	–	270	**190**	105	–	–	–	290	**200**	105
	4	150	**130**	110	–	–	–	–	–	–	–	–	–	205	**145**	80	–	–	–	210	**145**	80
	5	210	**175**	145	–	–	–	760	**610**	455	760	**610**	455	–	–	–	–	–	–	160	**120**	80
	6	130	**105**	–	–	–	–	760	**610**	455	760	**610**	455	–	–	–	–	–	–	140	**100**	60
M	1	240	**195**	165	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	200	**180**	140
	2	215	**185**	150	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	190	**160**	120
	3	160	**135**	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	145	**130**	90
K	1	230	**195**	160	805	**730**	650	–	–	–	–	–	–	365	**255**	145	395	**275**	150	390	**270**	145
	2	185	**150**	130	635	**570**	530	–	–	–	–	–	–	285	**200**	115	335	**230**	120	305	**210**	115
	3	150	**130**	105	–	–	–	–	–	–	–	–	–	260	**185**	105	275	**190**	105	–	–	–
N	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
S	1	–	–	–	–	–	–	670	**550**	425	670	**550**	425	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	670	**550**	425	670	**550**	425	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	975	**795**	610	975	**795**	610	–	–	–	–	–	–	–	–	–
	4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
H	1	–	–	–	–	–	–	–	–	–	–	–	–	105	**80**	50	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	95	**70**	40	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

Material Group		SP4019			SP6519			X400			X500			X700		
P	1	315	**230**	140	295	**215**	130	260	**190**	120	270	**200**	130	–	–	–
	2	275	**200**	120	260	**190**	115	230	**170**	105	240	**180**	115	–	–	–
	3	245	**175**	105	230	**165**	100	200	**150**	95	210	**155**	100	–	–	–
	4	190	**135**	80	175	**125**	75	150	**110**	70	160	**120**	75	–	–	–
	5	150	**110**	70	140	**105**	70	–	–	–	130	**100**	70	135	**105**	70
	6	130	**90**	50	120	**85**	50	–	–	–	110	**80**	50	115	**85**	50
M	1	280	**200**	120	270	**195**	115	–	–	–	250	**185**	115	260	**190**	115
	2	250	**180**	110	235	**170**	105	–	–	–	220	**160**	100	230	**170**	105
	3	200	**145**	90	195	**140**	85	–	–	–	180	**130**	80	190	**140**	85
K	1	330	**240**	145	295	**220**	140	–	–	–	260	**220**	170	–	–	–
	2	255	**185**	115	240	**175**	110	–	–	–	220	**180**	130	–	–	–
	3	235	**170**	105	220	**160**	100	–	–	–	170	**140**	100	–	–	–
N	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
S	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
H	1	100	**75**	50	–	–	–	95	**70**	45	–	–	–	–	–	–
	2	90	**65**	40	–	–	–	80	**60**	35	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

*Recommended for wet machining only.

NOTE: FIRST choice starting speeds are in **bold** type.
As the average chip thickness increases, the speed should be decreased.

Dry

Wet

Metric • Face Milling, Contour Milling, Profiling, and Die & Mould

Material Group		GH1			GH2			K110M			K115M			K313			KBK50*			KC410M		
P	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	6	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
M	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
K	1	280	**210**	130	240	**175**	115	125	**115**	110	175	**145**	115	185	**165**	145	1200	**800**	600	–	–	–
	2	235	**175**	115	210	**150**	100	110	**100**	95	145	**115**	90	–	–	–	1200	**800**	600	–	–	–
	3	190	**150**	110	175	**140**	95	95	**90**	75	90	**70**	55	–	–	–	1200	**800**	600	–	–	–
N	1	1150	**895**	385	1150	**910**	385	485	**455**	430	350	**265**	175	765	**670**	575	–	–	–	1170	**1035**	955
	2	1150	**895**	385	1150	**910**	385	390	**350**	310	235	**175**	145	–	–	–	–	–	–	1035	**955**	880
	3	850	**790**	285	850	**700**	285	390	**350**	310	235	**175**	145	–	–	–	–	–	–	1035	**955**	880
S	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	4	–	–	–	–	–	–	–	–	–	70	**55**	45	–	–	–	–	–	–	–	–	–
H	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

Material Group		KC422M			KC505M			KC510M			KC515M			KC520M			KC522M			KC524M		
P	1	–	–	–	–	–	–	–	–	–	265	**235**	210	–	–	–	315	**270**	260	–	–	–
	2	–	–	–	–	–	–	–	–	–	250	**220**	190	–	–	–	265	**230**	190	–	–	–
	3	–	–	–	–	–	–	–	–	–	220	**190**	165	–	–	–	245	**210**	170	–	–	–
	4	–	–	–	290	**210**	170	235	**190**	165	190	**165**	130	–	–	–	215	**175**	145	–	–	–
	5	–	–	–	290	**210**	170	–	–	–	165	**130**	100	–	–	–	175	**165**	145	–	–	–
	6	–	–	–	280	**190**	150	–	–	–	130	**100**	90	–	–	–	160	**120**	95	–	–	–
M	1	–	–	–	–	–	–	–	–	–	265	**220**	190	–	–	–	195	**170**	160	–	–	–
	2	–	–	–	–	–	–	–	–	–	220	**175**	130	–	–	–	175	**150**	125	–	–	–
	3	–	–	–	–	–	–	–	–	–	175	**145**	115	–	–	–	135	**115**	90	–	–	–
K	1	–	–	–	185	**165**	145	285	**255**	230	350	**265**	175	260	**235**	210	220	**195**	175	360	**255**	185
	2	–	–	–	170	**150**	130	220	**195**	185	265	**210**	145	200	**185**	170	170	**150**	145	310	**195**	150
	3	–	–	–	110	**90**	70	190	**170**	150	115	**90**	55	170	**150**	140	145	**130**	115	240	**175**	125
N	1	1030	**910**	840	–	–	–	615	**550**	505	–	–	–	–	–	–	–	–	–	–	–	–
	2	910	**840**	730	–	–	–	555	**510**	470	–	–	–	–	–	–	–	–	–	–	–	–
	3	910	**840**	730	–	–	–	555	**510**	470	–	–	–	–	–	–	–	–	–	–	–	–
S	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	40	**30**	25	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	40	**30**	25	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	50	**40**	25	–	–	–
	4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	70	**50**	30	–	–	–
H	1	–	–	–	210	**165**	135	150	**125**	90	135	**95**	75	–	–	–	115	**90**	70	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

*Recommended for dry machining only.

(continued)

NOTE: FIRST choice starting speeds are in **bold** type.
As the average chip thickness increases, the speed should be decreased.

Dry

Wet

(continued)

Metric • Face Milling, Contour Milling, Profiling, and Die & Mould

Material Group		KC525M			KC530M			KC725M			KC735M			KCK15			KCK20			KCPK30		
P	1	210	**190**	170	220	**190**	165	250	**220**	210	125	**115**	95	–	–	–	–	–	–	435	**380**	355
	2	170	**150**	145	190	**165**	130	210	**185**	150	115	**105**	100	–	–	–	–	–	–	270	**245**	220
	3	150	**145**	135	165	**145**	130	190	**165**	135	105	**95**	90	–	–	–	–	–	–	245	**220**	195
	4	135	**125**	115	145	**130**	115	170	**145**	115	95	**90**	75	–	–	–	–	–	–	185	**170**	150
	5	145	**135**	125	130	**115**	100	145	**130**	115	90	**75**	70	–	–	–	–	–	–	250	**220**	200
	6	125	**115**	105	100	**90**	70	125	**95**	75	75	**70**	70	–	–	–	–	–	–	150	**130**	–
M	1	145	**135**	125	220	**175**	145	165	**145**	130	100	**90**	75	–	–	–	–	–	–	195	**175**	150
	2	125	**115**	105	145	**115**	100	150	**125**	105	90	**80**	70	–	–	–	–	–	–	175	**150**	135
	3	90	**75**	70	115	**100**	90	110	**95**	75	70	**55**	–	–	–	–	–	–	–	140	**125**	110
K	1	–	–	–	–	–	–	–	–	–	–	–	–	405	**370**	330	280	**245**	210	285	**255**	230
	2	–	–	–	–	–	–	–	–	–	–	–	–	320	**285**	265	220	**190**	170	225	**200**	185
	3	–	–	–	–	–	–	–	–	–	–	–	–	270	**240**	220	185	**165**	140	190	**170**	150
N	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
S	1	55	**50**	50	–	–	–	30	**30**	25	–	–	–	–	–	–	–	–	–	–	–	–
	2	55	**50**	50	–	–	–	30	**30**	25	–	–	–	–	–	–	–	–	–	–	–	–
	3	50	**45**	40	–	–	–	45	**30**	25	–	–	–	–	–	–	–	–	–	–	–	–
	4	55	**50**	40	65	**50**	45	50	**45**	30	–	–	–	–	–	–	–	–	–	65	**50**	30
H	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

Material Group		KCPM40			KCSM30			KCSM40			KD1400			KD1410			KD1415			KD1425		
P	1	285	**250**	235	355	**310**	290	–	–	–	310	**275**	260	–	–	–	–	–	–	–	–	–
	2	240	**210**	170	290	**260**	210	–	–	–	265	**230**	190	–	–	–	–	–	–	–	–	–
	3	220	**190**	150	270	**230**	190	–	–	–	240	**205**	170	–	–	–	–	–	–	–	–	–
	4	195	**165**	130	240	**195**	160	–	–	–	215	**180**	145	–	–	–	–	–	–	–	–	–
	5	165	**150**	130	195	**185**	160	165	**140**	115	180	**160**	145	–	–	–	–	–	–	–	–	–
	6	145	**110**	90	175	**135**	105	145	**105**	75	155	**120**	95	–	–	–	–	–	–	–	–	–
M	1	190	**165**	150	215	**190**	175	200	**165**	135	205	**180**	160	–	–	–	–	–	–	–	–	–
	2	170	**145**	120	195	**170**	140	170	**140**	115	185	**155**	130	–	–	–	–	–	–	–	–	–
	3	125	**110**	90	150	**130**	100	140	**105**	80	140	**120**	95	–	–	–	–	–	–	–	–	–
K	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
N	1	–	–	–	–	–	–	–	–	–	–	–	–	3850	**3365**	2870	3850	**3365**	2870	730	**1585**	3905
	2	–	–	–	–	–	–	–	–	–	–	–	–	1535	**1435**	1345	3850	**3365**	2870	730	**1585**	3905
	3	–	–	–	–	–	–	–	–	–	–	–	–	1535	**1435**	1345	1535	**1435**	1345	370	**490**	570
S	1	40	**30**	30	45	**40**	30	40	**30**	25	–	–	–	–	–	–	–	–	–	–	–	–
	2	40	**30**	30	45	**40**	30	40	**30**	25	–	–	–	–	–	–	–	–	–	–	–	–
	3	50	**40**	30	50	**45**	30	50	**40**	25	–	–	–	–	–	–	–	–	–	–	–	–
	4	65	**50**	30	70	**55**	40	55	**50**	30	–	–	–	–	–	–	–	–	–	–	–	–
H	1	–	–	–	130	**95**	70	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

NOTE: FIRST choice starting speeds are in **bold** type.
As the average chip thickness increases, the speed should be decreased.

(continued)

Dry

Wet

(continued)

Metric • Face Milling, Contour Milling, Profiling, and Die & Mould

Material Group		KTPK20			KY3500*			KYS30*			KYSP30*			SC3025			SC6525			SP4019		
P	1	350	**290**	245	–	–	–	–	–	–	–	–	–	355	**245**	135	445	**305**	170	305	**220**	135
	2	215	**185**	150	–	–	–	–	–	–	–	–	–	310	**215**	115	390	**270**	145	265	**190**	115
	3	195	**165**	140	–	–	–	–	–	–	–	–	–	280	**190**	100	350	**240**	125	235	**170**	100
	4	145	**125**	105	–	–	–	–	–	–	–	–	–	200	**140**	75	250	**175**	95	185	**130**	75
	5	200	**170**	140	–	–	–	–	–	–	–	–	–	150	**115**	75	190	**145**	95	145	**105**	70
	6	125	**100**	–	–	–	–	–	–	–	–	–	–	135	**95**	55	170	**120**	70	125	**90**	50
M	1	230	**190**	160	–	–	–	–	–	–	–	–	–	190	**170**	135	240	**215**	170	270	**190**	115
	2	210	**175**	145	–	–	–	–	–	–	–	–	–	185	**150**	115	230	**190**	145	240	**170**	105
	3	150	**130**	–	–	–	–	–	–	–	–	–	–	140	**125**	90	175	**155**	110	190	**140**	90
K	1	220	**190**	150	–	–	–	–	–	–	–	–	–	375	**260**	140	470	**325**	175	315	**230**	140
	2	175	**145**	125	–	–	–	–	–	–	–	–	–	290	**200**	110	365	**250**	140	245	**175**	110
	3	145	**125**	100	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	225	**165**	100
N	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	2780	**1585**	385
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	2780	**1585**	385
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	2230	**1255**	285
S	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	60	**45**	25
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	50	**40**	25
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	55	**45**	25
	4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	80	**55**	35
H	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	95	**70**	50
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	90	**65**	40
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

Material Group		SP6519			X400			X500			X700		
P	1	285	**210**	125	250	**185**	115	260	**190**	125	–	–	–
	2	250	**185**	110	220	**165**	100	230	**170**	110	–	–	–
	3	220	**160**	95	190	**145**	90	200	**150**	95	–	–	–
	4	170	**120**	70	145	**105**	70	150	**115**	70	–	–	–
	5	135	**100**	70	–	–	–	125	**95**	70	130	**100**	70
	6	115	**80**	50	–	–	–	105	**75**	50	110	**80**	50
M	1	260	**190**	110	–	–	–	240	**175**	110	250	**185**	110
	2	225	**165**	100	–	–	–	210	**150**	95	220	**165**	100
	3	190	**135**	80	–	–	–	170	**125**	75	185	**135**	80
K	1	285	**210**	135	–	–	–	250	**210**	165	–	–	–
	2	230	**170**	105	–	–	–	210	**170**	125	–	–	–
	3	210	**150**	95	–	–	–	165	**135**	95	–	–	–
N	1	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–
S	1	50	**40**	25	–	–	–	50	**30**	25	50	**40**	25
	2	50	**30**	20	–	–	–	45	**30**	20	45	**30**	20
	3	50	**40**	25	–	–	–	50	**40**	25	50	**40**	25
	4	75	**55**	35	–	–	–	70	**50**	30	70	**50**	35
H	1	–	–	–	90	**70**	45	–	–	–	–	–	–
	2	–	–	–	75	**55**	30	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–

*Recommended for dry machining only.

NOTE: FIRST choice starting speeds are in **bold** type.
As the average chip thickness increases, the speed should be decreased.

Dry

Wet

Metric • Shoulder and Slotting Cutters, Thread Mills

Material Group		GH1			GH2			K110M			K115M			K313			KBK50*			KC410M		
P	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	6	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
M	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
K	1	230	**170**	110	200	**150**	95	105	**95**	90	150	**120**	95	150	**135**	120	800	**530**	400	–	–	–
	2	195	**150**	95	170	**130**	85	90	**85**	80	120	**95**	70	–	–	–	800	**530**	400	–	–	–
	3	160	**130**	90	150	**115**	80	80	**70**	65	70	**60**	50	–	–	–	800	**530**	400	–	–	–
N	1	960	**750**	320	960	**755**	320	405	**380**	360	290	**220**	150	635	**555**	480	–	–	–	970	**865**	795
	2	960	**750**	320	960	**755**	320	330	**290**	255	195	**150**	120	–	–	–	–	–	–	865	**795**	730
	3	710	**655**	235	710	**585**	235	330	**290**	255	195	**150**	120	–	–	–	–	–	–	865	**795**	730
S	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	4	–	–	–	–	–	–	–	–	–	60	**50**	35	–	–	–	–	–	–	–	–	–
H	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

Material Group		KC422M			KC505M			KC510M			KC515M			KC520M			KC522M			KC524M		
P	1	–	–	–	–	–	–	–	–	–	220	**195**	170	–	–	–	265	**230**	215	–	–	–
	2	–	–	–	–	–	–	–	–	–	210	**185**	160	–	–	–	220	**190**	160	–	–	–
	3	–	–	–	–	–	–	–	–	–	185	**160**	135	–	–	–	205	**170**	140	–	–	–
	4	–	–	–	240	**175**	145	195	**160**	135	160	**135**	110	–	–	–	180	**150**	120	–	–	–
	5	–	–	–	240	**175**	145	–	–	–	135	**110**	85	–	–	–	150	**135**	120	–	–	–
	6	–	–	–	230	**160**	130	–	–	–	110	**85**	70	–	–	–	130	**100**	80	–	–	–
M	1	–	–	–	–	–	–	–	–	–	220	**185**	160	–	–	–	165	**145**	130	–	–	–
	2	–	–	–	–	–	–	–	–	–	185	**150**	110	–	–	–	150	**130**	105	–	–	–
	3	–	–	–	–	–	–	–	–	–	150	**120**	95	–	–	–	110	**95**	75	–	–	–
K	1	–	–	–	150	**135**	120	235	**210**	190	290	**220**	150	215	**195**	170	185	**165**	150	300	**210**	150
	2	–	–	–	140	**125**	110	185	**165**	150	220	**170**	120	170	**150**	140	145	**130**	120	260	**165**	130
	3	–	–	–	90	**75**	60	155	**140**	130	95	**70**	50	140	**130**	115	120	**110**	95	200	**150**	105
N	1	860	**755**	700	–	–	–	510	**455**	420	–	–	–	–	–	–	–	–	–	–	–	–
	2	755	**700**	610	–	–	–	465	**430**	390	–	–	–	–	–	–	–	–	–	–	–	–
	3	755	**700**	610	–	–	–	465	**430**	390	–	–	–	–	–	–	–	–	–	–	–	–
S	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	30	**30**	20	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	30	**30**	20	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	40	**30**	20	–	–	–
	4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	55	**40**	30	–	–	–
H	1	–	–	–	175	**135**	110	130	**105**	70	110	**80**	65	–	–	–	95	**70**	55	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

*Recommended for dry machining only.

NOTE: FIRST choice starting speeds are in **bold** type.
As the average chip thickness increases, the speed should be decreased.

Dry

Wet

(continued)

(continued)

Metric • Shoulder and Slotting Cutters, Thread Mills

Material Group		KC525M			KC530M			KC725M			KC735M			KCK15			KCK20			KCPK30		
P	1	175	**160**	145	185	**160**	135	210	**185**	170	105	**95**	80	–	–	–	–	–	–	365	**315**	295
	2	145	**130**	120	160	**135**	110	175	**150**	130	95	**90**	85	–	–	–	–	–	–	225	**205**	185
	3	130	**120**	110	135	**120**	110	160	**135**	110	90	**80**	70	–	–	–	–	–	–	205	**185**	165
	4	110	**105**	95	120	**110**	95	145	**120**	95	80	**70**	65	–	–	–	–	–	–	150	**140**	130
	5	120	**110**	105	110	**95**	85	120	**110**	95	70	**65**	60	–	–	–	–	–	–	210	**185**	170
	6	105	**95**	90	85	**70**	60	105	**80**	65	65	**60**	55	–	–	–	–	–	–	130	**110**	–
M	1	120	**110**	105	185	**150**	120	135	**120**	110	85	**70**	65	–	–	–	–	–	–	165	**150**	125
	2	105	**95**	90	120	**95**	85	125	**105**	90	75	**70**	60	–	–	–	–	–	–	150	**130**	110
	3	70	**65**	55	95	**85**	70	90	**80**	65	55	**50**	–	–	–	–	–	–	–	115	**105**	90
K	1	–	–	–	–	–	–	–	–	–	–	–	–	335	**310**	270	230	**205**	170	235	**210**	190
	2	–	–	–	–	–	–	–	–	–	–	–	–	270	**235**	220	185	**160**	140	190	**170**	150
	3	–	–	–	–	–	–	–	–	–	–	–	–	225	**200**	185	150	**135**	115	155	**140**	130
N	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
S	1	50	**45**	40	–	–	–	30	**25**	20	–	–	–	–	–	–	–	–	–	–	–	–
	2	50	**45**	40	–	–	–	30	**25**	20	–	–	–	–	–	–	–	–	–	–	–	–
	3	40	**35**	30	–	–	–	35	**30**	20	–	–	–	–	–	–	–	–	–	–	–	–
	4	50	**40**	30	50	**40**	35	45	**35**	25	–	–	–	–	–	–	–	–	–	55	**40**	25
H	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

Material Group		KCPM40			KCSM30			KCSM40			KD1400			KD1410			KD1415			KD1425		
P	1	285	**250**	235	295	**255**	240	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	240	**210**	170	245	**215**	175	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	220	**190**	150	230	**190**	155	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	4	195	**165**	130	200	**165**	130	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	5	165	**150**	130	165	**150**	130	135	**115**	95	–	–	–	–	–	–	–	–	–	–	–	–
	6	145	**110**	90	150	**110**	90	120	**90**	65	–	–	–	–	–	–	–	–	–	–	–	–
M	1	190	**165**	150	180	**160**	150	170	**135**	110	–	–	–	–	–	–	–	–	–	–	–	–
	2	170	**145**	120	165	**145**	115	145	**115**	95	–	–	–	–	–	–	–	–	–	–	–	–
	3	125	**110**	90	125	**110**	85	115	**90**	70	–	–	–	–	–	–	–	–	–	–	–	–
K	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
N	1	–	–	–	–	–	–	–	–	–	3210	**2805**	2390	3850	**3365**	2870	3210	**2805**	2390	610	**1320**	3250
	2	–	–	–	–	–	–	–	–	–	1280	**1195**	1120	1535	**1435**	1345	1280	**1195**	1120	610	**1320**	3250
	3	–	–	–	–	–	–	–	–	–	1280	**1195**	1120	1535	**1435**	1345	1280	**1195**	1120	310	**410**	470
S	1	40	**30**	30	35	**30**	25	30	**30**	20	–	–	–	–	–	–	–	–	–	–	–	–
	2	40	**30**	30	35	**30**	25	30	**30**	20	–	–	–	–	–	–	–	–	–	–	–	–
	3	50	**40**	30	45	**35**	25	40	**30**	20	–	–	–	–	–	–	–	–	–	–	–	–
	4	65	**50**	30	55	**50**	30	50	**40**	25	–	–	–	–	–	–	–	–	–	–	–	–
H	1	–	–	–	110	**80**	60	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

NOTE: FIRST choice starting speeds are in **bold** type.
As the average chip thickness increases, the speed should be decreased.

(continued)

Dry

Wet

(continued)

Metric • Shoulder and Slotting Cutters, Thread Mills

Material Group		KTPK20			KY3500*			KYS30*			KYSP30*			SC3025			SC6525			SP4019		
P	1	290	**240**	205	–	–	–	–	–	–	–	–	–	–	–	–	295	**205**	110	250	**185**	110
	2	180	**150**	130	–	–	–	–	–	–	–	–	–	–	–	–	260	**180**	95	220	**160**	95
	3	165	**135**	115	–	–	–	–	–	–	–	–	–	–	–	–	230	**160**	85	195	**140**	85
	4	120	**105**	90	–	–	–	–	–	–	–	–	–	–	–	–	170	**115**	65	150	**110**	65
	5	170	**140**	115	–	–	–	–	–	–	–	–	–	–	–	–	130	**95**	65	120	**90**	55
	6	105	**85**	–	–	–	–	–	–	–	–	–	–	–	–	–	110	**80**	50	105	**70**	40
M	1	190	**155**	130	–	–	–	–	–	–	–	–	–	–	–	–	160	**145**	110	225	**160**	95
	2	170	**150**	120	–	–	–	–	–	–	–	–	–	–	–	–	150	**130**	95	200	**145**	90
	3	130	**110**	–	–	–	–	–	–	–	–	–	–	–	–	–	115	**105**	70	160	**115**	70
K	1	185	**155**	130	–	–	–	–	–	–	–	–	–	315	**220**	120	310	**215**	115	265	**190**	115
	2	150	**120**	105	–	–	–	–	–	–	–	–	–	270	**185**	95	245	**170**	90	205	**150**	90
	3	120	**105**	85	–	–	–	–	–	–	–	–	–	220	**150**	85	–	–	–	190	**135**	85
N	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	2315	**1320**	320
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	2315	**1320**	320
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	1855	**1050**	235
S	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	50	**35**	20
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	40	**30**	20
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	45	**35**	20
	4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	65	**50**	30
H	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	80	**60**	40
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	70	**50**	30
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

Material Group		SP6519			X400			X500			X700		
P	1	235	**170**	105	210	**150**	95	215	**160**	105	–	–	–
	2	210	**150**	90	185	**135**	85	190	**145**	90	–	–	–
	3	185	**130**	80	160	**120**	75	170	**125**	80	–	–	–
	4	140	**100**	60	120	**90**	55	130	**95**	60	–	–	–
	5	110	**85**	55	–	–	–	105	**80**	55	110	**85**	55
	6	95	**70**	40	–	–	–	90	**65**	40	90	**70**	40
M	1	215	**155**	90	–	–	–	200	**150**	90	210	**150**	90
	2	190	**135**	85	–	–	–	175	**130**	80	185	**135**	85
	3	155	**110**	70	–	–	–	145	**105**	65	150	**110**	70
K	1	235	**175**	110	–	–	–	210	**175**	135	–	–	–
	2	190	**140**	90	–	–	–	175	**145**	105	–	–	–
	3	175	**130**	80	–	–	–	135	**110**	80	–	–	–
N	1	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–
S	1	45	**30**	20	–	–	–	40	**30**	20	40	**30**	20
	2	40	**30**	20	–	–	–	35	**30**	15	35	**30**	20
	3	45	**30**	20	–	–	–	40	**30**	20	40	**30**	20
	4	65	**50**	30	–	–	–	60	**45**	30	60	**45**	30
H	1	–	–	–	75	**55**	35	–	–	–	–	–	–
	2	–	–	–	65	**50**	30	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–

*Recommended for dry machining only.

NOTE: FIRST choice starting speeds are in **bold** type.
As the average chip thickness increases, the speed should be decreased.

Dry

Wet

Metric • Extra Fine Pitch Cutters from Platforms Mill 16™, HexaCut™, KSSR™ • Dry Machining

Material Group		KC514M			KC524M			KCK15			KCK20			KCPK30			KY3500		
P	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	6	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
M	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
K	1	275	**180**	130	430	**305**	220	320	**210**	145	320	**210**	145	280	**250**	230	925	**845**	750
	2	215	**155**	110	370	**240**	180	240	**175**	120	240	**175**	120	230	**205**	180	730	**660**	610
	3	180	**130**	110	290	**215**	155	210	**145**	115	210	**145**	115	185	**170**	155	–	–	–
N	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
S	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
H	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

NOTE: FIRST choice starting speeds are in **bold** type.
As the average chip thickness increases, the speed should be decreased.

Dry

Wet

Metric • Extra Fine Pitch Cutters from Platforms Mill 16™, HexaCut™, KSSR™ • Wet Machining

Material Group		KC514M			KC524M			KCK15			KCK20			KCPK30			KY3500*		
P	1	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
	2	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
	3	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
	4	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
	5	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
	6	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
M	1	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
	2	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
	3	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
K	1	220	**145**	105	345	**245**	175	255	**170**	115	255	**170**	115	225	**200**	185	–	**–**	–
	2	170	**125**	90	295	**190**	145	190	**140**	95	190	**140**	95	185	**165**	145	–	**–**	–
	3	145	**105**	90	230	**170**	125	170	**115**	90	170	**115**	90	150	**135**	125	–	**–**	–
N	1	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
	2	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
	3	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
S	1	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
	2	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
	3	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
	4	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
H	1	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
	2	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
	3	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–

*Recommended for dry machining only.

NOTE: FIRST choice starting speeds are in **bold** type.
As the average chip thickness increases, the speed should be decreased.

Dry

Wet

Metric • High Speed Cutting • Face Milling, Round Insert, Profiling, Chamfer, and Die & Mould

Material Group		GH1			GH2		
P	1	–	–	–	–	–	–
	2	–	–	–	–	–	–
	3	–	–	–	–	–	–
	4	–	–	–	–	–	–
	5	–	–	–	–	–	–
	6	–	–	–	–	–	–
M	1	–	–	–	–	–	–
	2	–	–	–	–	–	–
	3	–	–	–	–	–	–
K	1	280	**210**	130	240	**175**	115
	2	235	**175**	115	210	**150**	100
	3	190	**150**	110	175	**140**	95
N	1	2930	**1655**	385	2635	**1510**	385
	2	2930	**1655**	385	2635	**1510**	385
	3	2345	**1315**	285	2050	**1170**	285
S	1	–	–	–	–	–	–
	2	–	–	–	–	–	–
	3	–	–	–	–	–	–
	4	–	–	–	–	–	–
H	1	–	–	–	–	–	–
	2	–	–	–	–	–	–
	3	–	–	–	–	–	–

NOTE: FIRST choice starting speeds are in **bold** type.
As the average chip thickness increases, the speed should be decreased.

Dry

Wet

Metric • High Speed Cutting • Shoulder and Slotting Cutters, Thread Mills

Material Group		GH1			GH2		
P	1	–	**–**	–	–	**–**	–
	2	–	**–**	–	–	**–**	–
	3	–	**–**	–	–	**–**	–
	4	–	**–**	–	–	**–**	–
	5	–	**–**	–	–	**–**	–
	6	–	**–**	–	–	**–**	–
M	1	–	**–**	–	–	**–**	–
	2	–	**–**	–	–	**–**	–
	3	–	**–**	–	–	**–**	–
K	1	230	**170**	110	200	**150**	95
	2	195	**150**	95	170	**130**	85
	3	160	**130**	90	150	**115**	80
N	1	2440	**1380**	320	2195	**1260**	320
	2	2440	**1380**	320	2195	**1260**	320
	3	1950	**1095**	235	1710	**970**	235
S	1	–	**–**	–	–	**–**	–
	2	–	**–**	–	–	**–**	–
	3	–	**–**	–	–	**–**	–
	4	–	**–**	–	–	**–**	–
H	1	–	**–**	–	–	**–**	–
	2	–	**–**	–	–	**–**	–
	3	–	**–**	–	–	**–**	–

NOTE: FIRST choice starting speeds are in **bold** type.
As the average chip thickness increases, the speed should be decreased.

Dry

Wet

Order No.	Catalogue No.	Page(s)
1015658	SUWTCR	E58
1015659	SUWTCL	E58
1015684	NUWTC	E59
1015687	FUWTCR	E57
1015688	FUWTCL	E57
1015689	NUFRR	E58
1015690	NUFRL	E58
1015723	HUWTCR	E57
1015754	HUWTCL	E57
1016536	SM812 K9	E38–40, E42–43
1016544	SM837 K9	B172, B354, B378
1016546	SM840 K9	B170, B353–354
1016548	SM841 K9	B172–174, B354–355, B371
1016552	SM871 K9	E37, E41
1016574	SM872 K9	E37
1016576	SM885 K9	E36, E40
1016578	SM886 K9	E36, E40–41
1016582	SM449 K9	T102
1016602	SKTP343 K9	B247–248, B257
1016624	SKCP343 K9	B179–181
1016626	SKDP343 K9	B209–211
1016628	SKCP453 K9	B180, B182
1016644	IWSN433 K9	B161–164
1016648	ITSN323 K9	B132, B137
1016674	ISSN433 K9	B105, B107–108, B110
1016678	ICSN433 K9	B58–60, B66
1016680	IDSN433 K9	B85, B89–90
1016694	IDSN533 K9	B91
1017174	SMYE3 K9	D78–79, D81, D83–86
1017176	SMYI3 K9	D78–79, D81–86
1017178	SMYE4 K9	D78–79, D81, D83–84, D86
1017180	SMYI4 K9	D78–79, D81–86
1017220	ITSN322 K9	B133–134, B137, B139–141
1017222	ISSN332 K9	B109
1017226	IVSN322 K9	B149–153
1017228	SKVN343 K9	B266–268
1017230	IDSN432 K9	B86, B90–93
1017246	IRSN43 K9	B95
1017252	ICSN432 K9	B61–63, B67–68, B70–72
1017276	ITSN433 K9	B133–134, B139–141
1017278	ISSN432 K9	B109–110, B114–117, B119
1017282	IVSN432 K9	B151–152
1017296	ISSN533 K9	B108–109
1017298	ICSN533 K9	B61–63, B66–67, B72
1017300	ISSN633 K9	B108–110, B114–115, B119
1017334	ICSN633 K9	B61–63, B67–68, B72
1018407	CM105	E40–41
1018409	CM106	E40–41
1018413	CM109	C170, D37
1018525	CM66	E37, E41
1018527	CM68	E36, E40
1018531	CM-72	D31–33, D39
1018533	CM73	D31–33, D39
1018569	CM80	D32
1018571	CM81	D32
1018647	MW25	U27–35, V146–147
1018649	MW3	U40–49
1019821	MS1241	T109
1020545	MS1861	H76
1020575	CKM6	B62, B67, B151, B162, B164
1020577	CKM7	B86, B90, B162, B172, B354
1020581	CKM9	B133–134, B170, B173, B353–355
1020583	CKM10	B170, B173–174, B353–355, B371
1020595	CKM12	B61–63, B67–68, B91, B108–110, B114
1020597	CKM13	B172, B354
1020601	CKM19	B109, B172–174, B355, B371
1020603	CKM20	B68, B134, B164
1020605	CKM21	B61–63, B67–68, B95, B108–110, B114, B133–134, B137
1020607	CKM22	B86, B90–91, B153
1020645	CKM26	B151–152
1020653	CKM31	B151–153
1020657	CKM41	B72, B92
1020787	KUAM20	B199–205, B229, B260–262
1020789	KUAM22	B70–72, B92, B115–119, B139–141, B375, B378
1020791	KUAM23	B73, B183, B229, B235–237, B260–263, C171, D41–42
1020805	KUAM26	B72, C171, D41–42
1020807	KUAM27	B72, B115, B119, T81
1020809	KUAM28	B70, B73, B115–121, B142, B199, B202, B220–221, B240–242, B260–263, B376–378
1020811	KUAM30	B70, B115–119, B199, B202, B220–221, B240–242, B260–263, B376–378
1020813	KUAM31	B70–73, B92, B115–121, B139–142, B183, B229, B235–237, B260–263, B375, B378, C171, D41–42
1020835	KUAM32	B70–73, B92–93, B115–117, B119, B139–141, B183, B235, B378
1020839	KUAM34	B199–205, B229, B260–262
1020841	KUAM35	B199, B202, B204–205
1020843	KUAM25	B70–72, B92–93, B115–117, B119, B139–141, B183, B235, B378
1020917	SRS3	B179–181, B209–211, B227–228, B233–234, B247–248, B257, B266–268, B271, S41, T102
1020919	SRS4	B180, B182, B209–211, B213, B233–234
1020923	SSY3T	D78–79, D81–86
1020935	SSY4T	D78–79, D81–86
1020939	MS1374	T79–81
1020941	SSN2T	D81, D86
1020943	SSA3T	D78–79, D81–86
1020965	SSA4T	D78–79, D81–86
1020969	MS110	B174, B371
1020971	MS111	B170, B172–173, B353–355, E37, E41
1020973	MS412	B386, C171, D41–42, E38–40, E42–43
1020975	MS125	B172, B354, B378
1020977	MS1273	C46–47, T109
1021007	MS1321	B168, B370
1021011	MS524	E36, E40
1021013	MS625	E37
1021051	MS1025	C171, D41–42
1021087	MS337	B386
1021093	MS1433	T58–59
1021095	MS518	E37–38, E40–42
1021135	MS959	E36–43
1021137	MS960	B172–173, B354–355
1021139	MS961	B174, B371
1021143	MS364	B72, B115, B119
1021183	MS1375	K85
1021301	MS1571	C122
1021327	MS1242	S32, V49, V56, V60, V72, V78, V147
1021337	MS1152	B260–262, J23, J25, J27, J29, J31, J33, J35, J37
1021339	MS1153	B179–182, B192–205, B210–213, B217–221, B227–229, B247–248, B257–263, B266–269, B271, K74–76, K81, K85
1021341	MS1155	B179–183, B194–199, B202, B209–210, B212–213, B217–219, B229, B233–235, B240–242, B257–258, B260–263, B266–269, B271
1021343	MS1156	B179–181, B209–211, B213, B227–228, B233–234, B247–248, B257, B266–268, B271, C114
1021375	MS1158	B180, B182–183, B209–211, B213, B233–234
1021415	MS1282	U17–18
1021417	MS1284	U17
1021419	MS1285	C46–47
1021421	STCM9	B70–72, B92–93, B109, B115–117, B119, B139–141, B172–174, B355, B371
1021423	STCM11	B67, B90, B134, B164, U27–35, U40–49
1021451	STCM4	B61–63, B67–68, B91, B108–110, B114, B133–134, B151–152, B170, B172–173, B353–355
1021453	STCM5	B62, B67, B86, B90, B151, B162, B164, B172, B354
1021455	STCM8	B72, B115, B119, B170, B173–174, B353–355, B371, B378
1021463	STCM20	B61–63, B67–68, B72, B86, B90–91, B95, B108–110, B114, B133–134, B137, B151–153, B164
1021497	STCM26	B153
1021503	STCM32	U27–28, U30
1021505	STCM37	B139–141
1021507	STCM38	B70–72, B92, B115–119, B139–141, B375–378
1021511	STCM40	B72, B92, B115–117, B119
1021535	KLM43	B67, B70–72, B115–119, B164
1021537	KLM46	B61–63, B67–68, B70, B72, B92–93, B95, B108–110, B114, B133–134, B139–141, B151–152, B162, B164
1021539	KLM58	B61–63, B67, B72, B91, B108–109
1021541	KLM68	B61–63, B67–68, B72, B108–110, B114–115, B119
1021543	KLM33L	B90, B92, B139–141, B164
1021565	KLM34L	B62, B86, B90, B109, B133–134, B137, B139–141, B151–153, B162, B164
1021567	KLM46L	B86, B90–91
1021569	KLM46S	B70–72, B92–93, B115–117, B119
1021589	FT5	K74
1021591	FT7	K74–76, K81, K85, K120–121
1021593	FT8	K38, K81
1021605	FT15	K81, K120–121
1021607	FT20	K120–121
1021657	CM113	E38–40, E42–43
1021659	CM114	E38–39, E42
1021679	CM120	D32
1021681	CM121	D32
1021895	SU3	E59
1022071	CM158	E37–38
1022073	CM159	E37–38, E42
1022315	TT15	K38–39, T109
1022436	CKM37	B72, B115–117, B119
1022485	DT7	W40
1022487	DT8	U3, W29–31, W40, W42
1022489	DT9	V153–154
1022491	DT10	U3, W40–43
1022493	DT15	S60, S62, T79–81, U3, U17–18, V153–154
1022519	TT25	K38–39, V82, W40–43
1022521	TT30	K38–39, W41
1022691	KT6	V114–115
1022695	KT8	K72, V113–115
1022697	KT9	S72, S76, S79, S82
1022701	KT15	K72, K85, S144–147, V113–115, V130
1022703	KT20	V111–115, V128–130
1022727	KT27	K73–74, K84
1023055	S1006PKG	E59
1056234	SKSP453 K9	B233–234
1059784	MS1559	T50, T72, U32–35, U44–49
1059844	MS326	B386
1067613	CM74	C166, C168–171, D28–31, D33, D36–37, D39, D41–42
1067614	CM75	C166, C168–171, D28–31, D33, D36–37, D39, D41–42
1067630	CM146	C169, D36, D39–40
1067631	CM147	C169, D36, D39–40
1082671	SCFPR08CA06	B199
1086536	SCSPR08CA06	B204
1093271	75HC060M	G85
1093272	75HC080M	G85
1093273	75HC100M	G85
1093524	75HC120M	G85
1093525	75HC140M	G85
1093526	75HC160M	G85
1094300	MS1595	C36–37, C39–40, C43–44, C46–47, C112–115, C118–119
1095216	H16LSER3	D82
1095218	H20LSER3	D82
1095220	H24LSER3	D82
1095222	H32LSER3	D82
1095224	H24LSER4	D82
1095226	H32LSER4	D82
1097708	SCACR1010M06Q	B179
1097710	SCACR1212M06Q	B179
1097714	SCACR1616K09Q	B179
1097720	SDACR1616K11Q	B209
1097722	SVABR1010M11Q	B266
1097724	SVABR1212M11Q	B266
1097725	SVABL1212M11Q	B266
1097726	SVABR1616K16Q	B266
1097727	SVABL1616K16Q	B266
1097732	SWLCR2020K06	B271
1097750	CSBPR2020K12	B170, B353
1097754	CSDPN2020K12	B170, B353
1097755	CSDPN2525M12	B170, B353
1097762	CTGPR1212F11	B173, B355
1097763	CTGPR1616H11	B173, B355
1097764	CTGPR2020K16	B173, B355
1097765	CTGPR2525M16	B173, B355
1097775	CTCPN2510M11	B172, B354
1097776	CTCPN2514M16	B172, B354
1097778	CTCPN2520M22	B172, B354
1097781	CTCPN2518M22	B172, B354
1097788	SRGCR2525M12	B228
1097791	SRGCR1616H10	B228
1097792	SRGCR1616H06	B228
1097793	SRGCR2020K08	B228
1097794	SRGCR2020K10	B228
1097795	SRGCR2525M10	B228
1097796	SRGCR2525M08	B228
1097797	SVJBRF1010M11Q	B267
1097798	SVJBRF1212M11Q	B267
1097799	SVJBRF1616K16Q	B267
1097800	SVJBR1212N11	B267
1097801	SVJBR1616H11	B267
1097802	SVJBR2020K16	B267
1097803	SVJBR2525M16	B267
1097804	SVHBR1212N11	B266
1097805	SVHBR1616H11	B266
1097806	SVHBR2020K16	B266
1097807	SVHBR2525M16	B266
1097808	SSSCR1212N09	B234
1097809	SSSCR1616H09	B234
1097810	SSSCR2020K12	B234
1097811	SSSCR1616H12	B234
1097812	SCLCRF1010M06Q	B181
1097813	SCLCRF1212M06Q	B181
1097814	SCLCR0808L06	B180
1097816	SCLCR1010M06	B180
1097817	SCLCRF1616K09Q	B181
1097818	SCLCR1212N09	B180
1097819	SCLCR1616H09	B180
1097820	SCLCR2020K12	B180
1097821	SCLCR2020K09	B180
1097822	SCLCR2525M12	B180
1097824	SCGCR1010M06	B179
1097825	SCGCR1212N09	B179
1097828	SCRCR1212N09	B181
1097829	SCRCR1616H09	B181
1097840	SCKCR2020K09	B180
1097841	SDHCR1616H11	B209
1097843	SDHCR2525M15	B209
1097844	SDJCRF1010M07Q	B211

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
1097845	SDJCRF1212M07Q	B211
1097846	SDJCRF1616K11Q	B211
1097847	SDJCR0808L07	B210
1097848	SDJCR1010M07	B210
1097849	SDJCR1212N07	B210
1097850	SDJCR1212N11	B210
1097851	SDJCR1616H11	B210
1097852	SDJCR2020K15	B210
1097853	SDJCR2020K11	B210
1097854	SDJCR2525M11	B210
1097855	SDJCR2525M15	B210
1097856	SDNCN0808L07	B211
1097857	SDNCN1010M07	B211
1097858	SDNCN1212N07	B211
1097859	SDNCN1616H11	B211
1097860	SDNCN2020K15	B211
1097861	SDNCN2020K11	B211
1097862	SDNCN2525M15	B211
1097863	SSBCR1212N09	B233
1097867	SSBCR2525M12	B233
1097869	STGCR1212N11	B247
1097870	STGCR2020K16	B247
1097871	STGCR2525M16	B247
1097874	STGCR1616H16	B247
1097877	STFCR2020K16	B247
1097878	STFCR2525M16	B247
1097880	STFCR1616H16	B247
1097882	SSKCR1616H09	B234
1097887	SRACR1212N08	B227
1097888	SRACR1616Q08	B227
1097891	SRDCN1212N08	B227
1097892	SRDCN1212N06	B227
1097893	SRDCN1616Q08	B227
1097894	SRDCN2020K12	B227
1097895	SRDCN2525M12	B227
1097896	SRDCN2525M16	B227
1097897	SRDCN1616H08	B227
1097898	SRDCN1616H10	B227
1097899	SRDCN1616H06	B227
1097900	SRDCN2020K08	B227
1097901	SRDCN2020K10	B227
1097902	SRDCN2525M10	B227
1097903	SRDCN2525M08	B227
1097916	CTGPL1212F11	B173, B355
1097918	CTGPL2020K16	B173, B355
1097919	CTGPL2525M16	B173, B355
1097930	SDHCL2020K11	B209
1097933	SRGCL2525M12	B228
1097936	SRGCL1616H10	B228
1097937	SRGCL1616H06	B228
1097938	SRGCL2020K08	B228
1097940	SRGCL2525M10	B228
1097941	SRGCL2525M08	B228
1097942	SVJBLF1010M11Q	B267
1097943	SVJBLF1212M11Q	B267
1097944	SVJBLF1616K16Q	B267
1097945	SVJBL1212N11	B267
1097946	SVJBL1616H11	B267
1097947	SVJBL2020K16	B267
1097948	SVJBL2525M16	B267
1097949	SVHBL1212N11	B266
1097950	SVHBL1616H11	B266
1097951	SVHBL2020K16	B266
1097952	SVHBL2525M16	B266
1097953	SSSCL1212N09	B234
1097954	SSSCL1616H09	B234
1097955	SSSCL2020K12	B234
1097956	SSSCL1616H12	B234
1097959	SCLCL0808L06	B180
1097961	SCLCL1010M06	B180
1097963	SCLCL1212N09	B180
1097964	SCLCL1616H09	B180
1097965	SCLCL2020K12	B180
1097966	SCLCL2020K09	B180
1097967	SCLCL2525M12	B180
1097970	SCGCL1212N09	B179
1097986	SDHCL1616H11	B209
1097988	SDHCL2525M15	B209
1097989	SDHCR2020K11	B209
1097990	SVBN1212N11	B268
1097991	SVBN1616H11	B268
1097992	SVBN2020K16	B268
1097993	SVBN2525M16	B268
1097996	SDJCLF1616K11Q	B211
1097997	SDJCL0808L07	B210
1097998	SDJCL1010M07	B210
1097999	SDJCL1212N07	B210
1098000	SDJCL1212N11	B210
1098001	SDJCL1616H11	B210
1098003	SDJCL2020K11	B210
1098004	SDJCL2525M15	B210
1098005	SSDCN1212N09	B233
1098006	SSDCN1616H09	B233
1098007	SSDCN2020K09	B233
1098009	SSBCL1616H09	B233
1098014	STGCL1212N11	B247
1098015	STGCL2020K16	B247
1098016	STGCL2525M16	B247
1098019	STGCL1616H16	B247
1098022	STFCL2020K16	B247
1098023	STFCL2525M16	B247
1098027	SSKCL2020K12	B234
1098051	A20QCTFPR11	B174, B371
1098053	A25RCTFPR16	B174, B371
1098054	A25RCTFPL16	B174, B371
1098055	A32SCTFPR16	B174, B371
1098056	A32SCTFPL16	B174, B371
1098057	A16MCTUPR11	B174, B371
1098058	A16MCTUPL11	B174, B371
1098062	A10KSWLCR04	B271
1098063	A12MSWLCR04	B271
1098064	A16RSWLCR06	B271
1098065	A20SSWLCR06	B271
1098069	A16RSWLCL06	B271
1098071	A0510GSCLDRS4	B187
1098073	A0610HSCLDRS4	B187
1098078	BS32S	B386
1098079	BS40T	B386
1098080	BS50U	B386
1098088	A25RMCLNR12	B67
1098089	A25RMCLNL12	B67
1098090	A32SMCLNR12	B67
1098091	A32SMCLNL12	B67
1098092	A40TMCLNR12	B67
1098093	A40TMCLNL12	B67
1098094	A50UMCLNR12	B67
1098095	A50UMCLNL12	B67
1098096	A40TMCLNR16	B67
1098097	A40TMCLNL16	B67
1098098	A50UMCLNR16	B67
1098099	A50UMCLNL16	B67
1098100	A50UMCLNR19	B67
1098101	A50UMCLNL19	B67
1098102	A25RMDUNR15	B90
1098103	A25RMDUNL15	B90
1098104	A32SMDUNR15	B90
1098105	A32SMDUNL15	B90
1098106	A40TMDUNR15	B90
1098107	A40TMDUNL15	B90
1098108	A50UMDUNR15	B90
1098109	A50UMDUNL15	B90
1098115	A32SMSKNL12	B114
1098116	A40TMSKNR12	B114
1098117	A40TMSKNL12	B114
1098120	A50UMSKNR19	B114
1098121	A25RMTFNR16	B137
1098122	A25RMTFNL16	B137
1098123	A32SMTFNR16	B137
1098124	A32SMTFNL16	B137
1098125	A40TMTFNR16	B137
1098128	A25RMVUNR16	B153
1098129	A25RMVUNL16	B153
1098130	A32SMVUNR16	B153
1098131	A32SMVUNL16	B153
1098146	A20SSDUCR11	B213
1098147	A20SSDQCR11	B212
1098148	A20SSDUCL11	B213
1098149	A20SSDQCL11	B212
1098150	BSD32U	B386
1098151	BSD40V	B386
1098152	BSD50W	B386
1098154	A08JSTFPR09	B257
1098155	A08JSTFPL09	B257
1098156	A08JSCLPR06	B196
1098157	A08JSCFPR06	B194
1098159	A08JSCLCR06	B182
1098160	A08JSCLPL06	B196
1098161	A08JSCFPL06	B194
1098163	A08JSCLCL06	B182
1098164	A10KSCLPR06	B196
1098165	A10KSCFPR06	B194
1098167	A10KSCXPR06	B198
1098168	A10KSCLCR06	B182
1098169	A10KSCLPL06	B196
1098170	A10KSCFPL06	B194
1098173	A10KSCLCL06	B182
1098174	A12MSCLPR06	B196
1098175	A12MSCFPR06	B194
1098177	A12MSCXPR06	B198
1098178	A12MSCLCR06	B182
1098179	A12MSCLPL06	B196
1098180	A12MSCFPL06	B194
1098183	A12MSCLCL06	B182
1098184	A12MSDUPR07	B217
1098185	A12MSDXPR07	B218
1098186	A12MSDQPR07	B217
1098187	A12MSDUCR07	B213
1098188	A12MSDQCR07	B212
1098189	A12MSDUPL07	B217
1098190	A12MSDXPL07	B218
1098191	A12MSDQPL07	B217
1098192	A12MSDUCL07	B213
1098193	A12MSDQCL07	B212
1098194	A16RSDUPR07	B217
1098195	A16RSDXPR07	B218
1098196	A16RSDQPR07	B217
1098197	A16RSDUCR07	B213
1098198	A16RSDQCR07	B212
1098199	A16RSDUPL07	B217
1098200	A16RSDXPL07	B218
1098201	A16RSDQPL07	B217
1098202	A16RSDUCL07	B213
1098203	A16RSDQCL07	B212
1098204	A10KSTFPR11	B257
1098205	A10KSTWPR11	B259
1098206	A10KSTWPL11	B259
1098207	A10KSTFCR11	B248
1098208	A10KSTFPL11	B257
1098209	A10KSTFCL11	B248
1098210	A12MSTFPR11	B257
1098211	A12MSTFCR11	B248
1098212	A12MSTFPL11	B257
1098213	A12MSTFCL11	B248
1098214	A16RSTFPR11	B257
1098215	A16RSTFPL11	B257
1098216	A12MSTWPR11	B259
1098218	A16RSTWPR11	B259
1098220	A16RSCLPR09	B196
1098221	A16RSCFPR09	B194
1098223	A16RSCXPR09	B198
1098225	A16RSCLCR09	B182
1098226	A16RSCLPL09	B196
1098227	A16RSCFPL09	B194
1098231	A16RSCLCL09	B182
1098232	A16RSVQBR11	B268
1098233	A16RSVQBL11	B268
1098234	A20SSCLPR09	B196
1098235	A20SSCFPR09	B194
1098236	A20SSCKPR09	B195
1098239	A20SSCLCR09	B182
1098240	A20SSCLPL09	B196
1098241	A20SSCFPL09	B194
1098244	A20SSCLCL09	B182
1098245	A20SSDUPR11	B217
1098246	A20SSDXPR11	B218
1098247	A20SSDQPR11	B217
1098248	A20SSVQBR11	B268
1098249	A20SSVUBR11	B269
1098250	A20SSDUPL11	B217
1098251	A20SSDXPL11	B218
1098252	A20SSDQPL11	B217
1098253	A20SSVQBL11	B268
1098254	A20SSVUBL11	B269
1098255	A20SSTFPR16	B257
1098256	A20SSTFPL16	B257
1098257	A25TSDUPR11	B217
1098258	A25TSDQPR11	B217
1098259	A25TSDUCR11	B213
1098260	A25TSDQCR11	B212
1098262	A25TSDQPL11	B217
1098263	A25TSDUCL11	B213
1098264	A25TSDQCL11	B212
1098266	A25TSCFCR12	B182
1098268	A25TSCLCR12	B182
1098270	A25TSCFCL12	B182
1098272	A25TSCLCL12	B182
1098273	A25TSTFPR16	B257
1098274	A25TSVQBR16	B268
1098275	A25TSVUBR16	B269
1098276	A25TSTFPL16	B257
1098277	A25TSVQBL16	B268
1098278	A25TSVUBL16	B269
1098280	A32TSCLCR12	B182
1098282	A32TSCLCL12	B182
1098283	A32TSDUCR15	B213
1098284	A32TSDUCL15	B213
1098285	A32TSTFPR16	B257
1098286	A32TSTFCR16	B248
1098328	SCSPR06CA05	B204
1098380	NER12CA2	C171, D41–42
1098436	MSRNR10CA09	B116
1098465	MSYNR25CA19	B119
1098529	MTUNL12CA16	B141
1098535	MTUNL16CA16	B141
1098536	MTUNR20CA22	B141
1098541	SCLPR06CA05	B202
1098542	SCLPR08CA06	B202
1098543	SCLPR10CA09	B202
1098544	SCLCR12CA12	B183
1098545	SCLCR16CA12	B183
1098548	SCSPL06CA05	B204
1098549	SCSPL08CA06	B204
1098551	SCFPR06CA05	B199
1098552	SCKPR08CA06	B201
1098554	SCGPR08CA06	B200
1098555	SCRPR08CA06	B203
1098556	SCTPR06CA05	B205
1098557	SCTPR08CA06	B205
1098558	STFPL12CA16	B260
1098559	STFPL10CA11	B260
1098561	STFPL08CA09	B260
1098562	STFPR12CA16	B260
1098563	STFPR10CA11	B260
1098565	STFPR08CA09	B260
1098566	STGPR12CA16	B261
1098567	STGPR10CA11	B261
1098570	SSKPR10CA09	B240
1098572	SSSPR10CA09	B242
1098574	SSRPR10CA09	B241
1098624	NEL12CA2	C171, D41–42
1098626	NEL25CA3	C171, D41–42
1098691	MSYNL20CA15	B119
1098711	SRGCR08CA06	B229
1098713	SRGCR12CA10	B229
1098719	SSKCR12CA12	B235
1098720	SSKCR16CA12	B235
1098721	SSKCL12CA12	B235
1098723	SSRCR12CA12	B236
1098725	SSRCL12CA12	B236
1098728	SDUPR10CA07	B221
1098730	SCLPL08CA06	B202
1098731	SCLPL10CA09	B202
1098732	SCLCL12CA12	B183
1098736	SCTPL08CA06	B205
1098737	SSSCR12CA12	B237
1098739	SSSCL12CA12	B237
1098741	STTPR12CA16	B262
1098742	STTPR10CA11	B262
1098744	STTPR08CA09	B262
1098749	STWPR12CA16	B263
1098750	STWPR10CA11	B263
1098757	SDJPR10CA07	B220
1098758	SDJPL10CA07	B220
1098760	STGPL10CA11	B261
1098762	STGPL08CA09	B261
1098763	SCKPL08CA06	B201
1098764	SSSPL10CA09	B242
1098766	SCFPL08CA06	B199

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
1098767	A25RMCLNR09	B67
1098769	A25RMDUNR11	B90
1098770	A32SMDUNR11	B90
1098771	A25RMWLNR06	B164
1098772	A32SMWLNR06	B164
1098773	A25RMWLNR08	B164
1098774	A32SMWLNR08	B164
1098775	A40TMWLNR08	B164
1098779	A25RMDUNL11	B90
1098780	A32SMDUNL11	B90
1098782	A32SMWLNL06	B164
1098783	A25RMWLNL08	B164
1098784	A32SMWLNL08	B164
1098785	A40TMWLNL08	B164
1098786	NASR1616K3Q	C167, D27
1098788	NASR1010M2Q	C167, D27
1098789	NASR1212M2Q	C167, D27
1098790	NSR1010E2	C166, D29
1098791	NSR1212F2	C166, D29
1098792	NSR1616H2	C166, D29
1098793	NSR2020K2	C166, D29
1098794	NSR2525M2	C166, D29
1098795	NSR2020K3	C166, D29
1098796	NSR2525M3	C166, D29
1098797	NSR3225P3	C166, D29
1098798	NSR3232P3	C166, D29
1098799	NSR2525M4	C166, D29
1098800	NSR3225P4	C166, D29
1098801	NSR3232P4	C166, D29
1098803	NER1616H2	C168, D28
1098804	NER2020K2	C168, D28
1098805	NER2525M2	C168, D28
1098806	NER2525M3	C168, D28
1098807	NER3225P3	C168, D28
1098808	NER2525M4	C168, D28
1098809	NER3225P4	C168, D28
1098810	NER3232P4	C168, D28
1098812	NRR2020K3	C168
1098813	NRR2525M3	C168
1098814	NRR3225P3	C168
1098816	NKLCR1616H11	E36
1098817	NKLCR2020K11	E36
1098818	NKLCR2525M11	E36
1098819	NKLCRF1212M11Q	E36
1098821	NKLNR2020K15	E37
1098822	NKLNR2525M15	E37
1098835	NVLCR1616H16	E38
1098836	NVLCR2020K16	E38
1098837	NVLCR2525M16	E38
1098838	NVLCR3225P16	E38
1098840	NVVCN2020K16	E40
1098841	NVVCN2525M16	E40
1098842	NVOCR2020K16	E39
1098843	NVOCR2525M16	E39
1098857	NASL1616K3Q	C167, D27
1098859	NASL1010M2Q	C167, D27
1098860	NASL1212M2Q	C167, D27
1098861	NSL1010E2	C166, D29
1098862	NSL1212F2	C166, D29
1098863	NSL1616H2	C166, D29
1098864	NSL2020K2	C166, D29
1098865	NSL2525M2	C166, D29
1098866	NSL2020K3	C166, D29
1098867	NSL2525M3	C166, D29
1098868	NSL3225P3	C166, D29
1098869	NSL3232P3	C166, D29
1098870	NSL2525M4	C166, D29
1098871	NSL3225P4	C166, D29
1098872	NSL3232P4	C166, D29
1098874	NEL1616H2	C168, D28
1098875	NEL2020K2	C168, D28
1098876	NEL2525M2	C168, D28
1098877	NEL2525M3	C168, D28
1098878	NEL3225P3	C168, D28
1098879	NEL2525M4	C168, D28
1098880	NEL3225P4	C168, D28
1098881	NEL3232P4	C168, D28
1098883	NRL2020K3	C168
1098884	NRL2525M3	C168
1098885	NRL3225P3	C168
1098888	NKLCL2020K11	E36
1098889	NKLCL2525M11	E36
1098892	NKLNL2020K15	E37
1098893	NKLNL2525M15	E37
1098908	NVLBR2020K11	E38
1098909	NVLBR2525M11	E38
1098912	NVLCL2020K16	E38
1098913	NVLCL2525M16	E38
1098924	NVLCL3225P16	E38
1098926	NVLBL2020K11	E38
1098927	NVLBL2525M11	E38
1098929	NVOCL2020K16	E39
1098930	NVOCL2525M16	E39
1098932	NVHBL2020K11	E37
1098933	NVHBL2525M11	E37
1098935	NVHBR2020K11	E37
1098936	NVHBR2525M11	E37
1098943	A10KNNTOR1	C170, D37
1098944	A12MNNTOR1	C170, D37
1098945	A12MNNTOR2	C169, D36
1098946	A12MNNTOL2	C169, D36
1098947	A16MNNTOR2	C169, D36
1098948	A16MNNTOL2	C169, D36
1098949	A20QNNTOR2	C169, D36
1098950	A20QNNTOL2	C169, D36
1098951	A25RNNTOR2	C169, D36
1098952	A25RNNTOL2	C169, D36
1098953	A25RNNTOR3	C169, D36
1098954	A25RNNTOL3	C169, D36
1098955	A32SNNTOR3	C169, D36
1098956	A32SNNTOL3	C169, D36
1098957	A40TNNTOR3	C169, D36
1098958	A40TNNTOL3	C169, D36
1098959	A12MNKLCR11	E40
1098960	A12MNKLCL11	E40
1098961	A16MNKLCR11	E40
1098962	A16MNKLCL11	E40
1098966	A25TNVQBR11	E42
1098975	A32SNKLCR11	E40
1098977	A32SNVOCR16	E42
1098978	A32SNVQCR16	E43
1098979	A32SNVOCL16	E42
1098983	A40TNVOCL16	E42
1098987	A40TNKLNR15	E41
1098989	A20QNKLCR11	E40
1098990	A20QNKLCL11	E40
1098992	A25RNKLCR11	E40
1098993	A25RNKLCL11	E40
1098997	A50UNVOCR16	E42
1099001	A40TNNTOR4	C169, D36
1099002	A40TNNTOL4	C169, D36
1099003	A50UNNTOR4	C169, D36
1099094	H40MDUNR15	B91
1099102	H50MCLNR19	B68
1099132	MCLNR2020K09	B62
1099133	MCLNR2020K12	B62
1099148	MSBNL4040R19	B108
1099158	MSKNL3232P15	B109
1099162	KRCSCFPR061A	K82
1099163	KRCSCFPR062A	K82
1099164	KRCSCFPR063A	K82
1099165	KRCSCFPR061B	K82
1099166	KRCSCFPR062B	K82
1099167	KRCSCFPR063B	K82
1099168	KRCSCFPR061C	K82
1099169	KRCSCFPR062C	K82
1099170	KRCSCFPR063C	K82
1099171	KRCSCFPR061D	K82
1099172	KRCSCFPR062D	K82
1099173	KRCSCFPR063D	K82
1099174	KRCSCFPR061E	K85, K104–105
1099175	KRCSCFPR062E	K85, K104–105
1099176	KRCSCFPR063E	K85, K104–105
1099177	KRCSCFPR061F	K85, K106–110
1099178	KRCSCFPR062F	K85, K106–110
1099179	KRCSCFPR063F	K85, K106–110
1099253	MCKNL3225P16	B61
1099379	CM180	E36
1099381	CM182	C167, D27
1099382	CM183	C167, D27
1099427	SM813 K9	E37–38, E42
1099428	SM815 K9	B174, B371
1099429	SM819 K9	B172–173, B354–355
1099440	SKSP343 K9	B233–234
1099444	SKDP453 K9	B209–211, B213
1099445	SKSN566K K9	B115–117, B119
1099446	SKRN100300 K9	B227–228
1099447	SKRN160400 K9	B227
1099448	SKWP343 K9	B271
1099451	ICSN332 K9	B59, B62
1099452	IDSN322 K9	B85–86, B89–90
1099469	ITSN443 K9	B132
1099614	MS1933	B199, B202, B204–205, B257–259
1099615	MS1939	B182, B195–198, B271
1099631	SRS5	B227
1099634	MS319	B386
1099636	MS330	B386
1099638	MS624	E41
1099640	MS1034	C170, D37
1099643	MS1154	B227–228
1099644	MS1157	B182–183, B235–237
1099645	MS1160	B227, C36–37, C39–42, C46–48, C112–114, C120
1099646	MS1200	C166–170, D27–30, D36–37
1099649	KLM33	B62, B67, B70, B115–119
1099650	KLM54	B115–117, B119
1099651	FT10	K38
1099675	MS-1896	K81
1099676	KT30	V111–114, V129
1100493	MCLNR12CA12	B72
1100936	MDJNR1616H11	B86
1100937	MSBNR2020K12	B108
1100938	MCLNL1616H09	B62
1100939	MCLNR1616H09	B62
1100941	MSBNR2525M12	B108
1100943	MCLNR2525M09	B62
1101285	MDJNL2020K11	B86
1101286	MDJNR2020K11	B86
1101287	MDJNL2525M11	B86
1101288	MDJNR2525M11	B86
1101289	MSBNR3225P12	B108
1101292	MWLNL2020K06	B162
1101293	MWLNR2020K06	B162
1101354	MWLNL2525M06	B162
1101355	MWLNR2525M06	B162
1101356	MDJNR2020K15	B86
1101357	MDJNR2525M15	B86
1101358	MDJNR3225P15	B86
1101359	MSBNR2525M15	B108
1101361	MSBNR3232P15	B108
1101362	MVJNR2020K16	B151
1101363	MVJNR3225P16	B151
1101634	MVJNR2525M16	B151
1101635	MVJNR3225P22	B151
1101636	MDNNR2525M15	B86
1101637	MDNNR3225P15	B86
1101638	MCRNR2020K12	B63
1101639	MCRNR2525M12	B63
1101640	MCRNR3225P12	B63
1101641	MCLNR2525M16	B62
1101642	MCLNR3225P16	B62
1101643	MCRNR3232P19	B63
1101704	MCLNR2525M19	B62
1101705	MCLNR3225P19	B62
1101706	MCLNR3232P19	B62
1101707	MCLNR4040R19	B62
1101708	MCMNN2020K12	B63
1101709	MCMNN2525M12	B63
1101710	MCLNR1616H12	B62
1101711	MCLNR2525M12	B62
1101712	MCLNR3225P12	B62
1101713	MSDNN3225P12	B109
1101884	MSZNR2525M12	B110
1101886	MSKNR2525M12	B109
1101888	MSDNN3232P19	B109
1101889	MSDNN1616H09	B109
1101890	MSDNN2020K12	B109
1101891	MSDNN2525M12	B109
1101892	MSDNN2525M15	B109
1101893	MSBNR3232P19	B108
1101954	MSBNR4040R19	B108
1101957	MSKNR3232P19	B109
1101961	MTFNR2525M16	B134
1102086	MRGNR2525M12	B95
1102088	MTGNR1616H16	B134
1102090	MTGNR2525M16	B134
1102091	MTGNR2525M22	B134
1102093	MTGNR3232P22	B134
1102164	MSSNR2020K12	B110
1102165	MSSNR2525M12	B110
1102166	MSSNR3232P19	B110
1102168	MTENNS3225P22	B133
1102169	MTENNS2020K16	B133
1102170	MTENNS2525M16	B133
1102171	MTENNS2525M22	B133
1102172	MTANRS2020K16	B133
1102173	MTANRS2525M16	B133
1102236	MCKNR2525M12	B61
1102237	MCKNR3225P12	B61
1102238	MVONR2525M16	B151
1102239	MCMNN4040R19	B63
1102240	MCKNR3225P16	B61
1102241	MCRNL3232P16	B63
1102242	MSBNL2020K12	B108
1102243	MSBNL2525M12	B108
1102314	MSBNL3225P12	B108
1102316	MDJNL2525M15	B86
1102317	MDJNL3225P15	B86
1102318	MSBNL2525M15	B108
1102319	MSBNL3232P15	B108
1102320	MVJNL2020K16	B151
1102321	MVJNL2525M16	B151
1102322	MVJNL3225P16	B151
1102323	MVJNL3225P22	B151
1102434	MDNNL2525M15	B86
1102435	MDNNL3225P15	B86
1102437	MCRNL2525M12	B63
1102439	MCRNL3225P12	B63
1102440	MCLNL2525M16	B62
1102442	MCLNL3225P16	B62
1102443	MCRNL3232P19	B63
1102534	MCLNL2525M19	B62
1102535	MCLNL3225P19	B62
1102536	MCLNL3232P19	B62
1102537	MCLNL4040R19	B62
1102538	MCMNN3225P16	B63
1102539	MCLNL1616H12	B62
1102540	MCLNL2020K12	B62
1102541	MCLNL2525M12	B62
1102542	MCLNL3225P12	B62
1102634	MSZNL2525M12	B110
1102637	MSKNL2525M12	B109
1102638	MSKNL3225P12	B109
1102640	MSBNL3232P19	B108
1102641	MSKNL3232P19	B109
1102643	MTFNL2020K16	B134
1102694	MTFNL2525M16	B134
1102699	MRGNL2525M12	B95
1102714	MTGNL2525M16	B134
1102715	MTGNL2525M22	B134
1102716	MTGNL3232P22	B134
1102717	MSSNL2020K12	B110
1102718	MSSNL2525M12	B110
1102719	MSSNL3232P19	B110
1102720	MVVNN2020K16	B152
1102721	MVVNN2525M16	B152
1102722	MVVNN3225P16	B152
1102723	MVVNN2525M22	B152
1102726	MTANLS2525M16	B133
1102728	MCKNL3232P19	B61
1102729	MCKNL2525M12	B61
1102730	MVONL2525M16	B151
1102732	MCRNR3232P16	B63
1104311	E12QSTFPR11	B258
1105612	191.924	H98, J23, J25, J27, J29, J31, J33, J35, J37, J45–46, J74–75, J98, V153
1106668	MS1970	C36–40, C43–45, C112–115, C118–119
1107188	HSK100AKR50085M	K87
1108062	515.018	B64–66, B68–69, B87–88, B91, B111–114, B135, B138, B163, B165
1108063	513.023	B64–66, B68–69, B73, B87–88, B91, B111–114, B135, B138, B163, B165

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
1108065	511.023	B64–66, B68, B73, B111–114, B135, B138, B163, B165
1108068	512.112	B64–66, B68–69, B73
1108097	PCLNR2525M12	B65
1112602	SNHX1102T KC725M	U14
1112603	SNHX1103T KC725M	U14
1112604	SNHX1203T KC725M	U14
1112605	SNHX1204T KC725M	U14
1112606	SNHX12045T KC725M	U14
1112607	SNHX1205T KC725M	U14
1113180	NBD2R K313	C163
1113182	NBD3R K313	C163
1113183	NBD3L K313	C163
1113194	NB2L K313	C162
1113195	NB3L K313	C162
1113196	NB4L K313	C162
1113197	NB2R K313	C162
1113198	NB3R K313	C162
1113199	NB4R K313	C162
1113216	NR3031R K313	C158
1113217	NR3047R K313	C158
1113218	NR3062R K313	C158
1113219	NR3078R K313	C158
1113221	NR4094R K313	C158
1113224	NR3031L K313	C158
1113225	NR3047L K313	C158
1113226	NR3062L K313	C158
1113231	NR3094L K313	C158
1113233	NG2031R K313	C154
1113234	NG2041R K313	C154
1113237	NG2062R K313	C154
1113238	NG2094R K313	C154
1113240	NG2031L K313	C155
1113244	NG2062L K313	C155
1113245	NG2094L K313	C155
1113248	NG3125R K313	C154
1113252	NG3189R K313	C154
1113253	NG3047R K313	C154
1113254	NG3062R K313	C154
1113257	NG3094R K313	C154
1113261	NG3125L K313	C155
1113265	NG3047L K313	C155
1113266	NG3062L K313	C155
1113268	NG3094L K313	C155
1113269	NG4125R K313	C154
1113270	NG4189R K313	C154
1113272	NG4125L K313	C155
1113276	NF3125R K313	C161
1113277	NF3125L K313	C161
1113477	NJF3009R18 K68	D17
1113486	NA3L4 K68	D12
1113499	NTF2L K68	D23
1113500	NTF3L K68	D23
1113501	NTF2R K68	D23
1113502	NTF3R K68	D23
1113504	NT2L K68	D19
1113505	NT3L K68	D19
1113506	NT4L K68	D19
1113507	NT2R K68	D19
1113508	NT3R K68	D19
1113509	NT4R K68	D19
1113510	NTP2L K68	D24
1113511	NTP3L K68	D24
1113513	NTP2R K68	D24
1113514	NTP3R K68	D24
1113559	NJ3010R16 K68	D17
1114462	NGD3189R K313	C157
1114463	NGD4250R K313	C157
1114464	NGD4250L K313	C157
1114465	NGD3189L K313	C157
1114470	NRP3047R K313	C153
1114483	NGD3125RK K313	C149
1114484	NGD3062RK K313	C149
1114486	NGD3094RK K313	C149
1114487	NGD3125LK K313	C149
1114490	NGD3094LK K313	C149
1114624	NTK2R K68	D23
1114625	NTK3R K68	D23
1114626	NTK2L K68	D23
1114627	NTK3L K68	D23
1114680	NJP3014R12 K68	D18
1116889	CKM34	B70–72, B92–93, B115–119, B139–141, B375–378
1120731	AFB31115SCFCR09	K130
1120807	552.240	B361
1121036	EB43040450	K139
1121055	551.316	B358–361, B363–367, B369, B372–374
1121063	551.332	B360
1121078	551.333	B362, B368
1121086	551.317	B358–361, B363–367, B372–373
1121094	557.111	B358–368, B372–373
1121102	557.125	B358, B361
1121195	112.244	E15
1121205	552.232	B363–367, B373
1121211	552.231	B363–366
1121217	552.234	B364–365
1121232	552.221	B356, B358–359, B372
1121239	552.220	B358, B372
1121265	552.225	B359–360
1121273	552.228	B360
1121288	552.236	B368
1121295	552.235-H	B368
1121302	552.230	B362
1121313	552.229	B362
1121346	554.252	B356, B358–367, B369, B372–374
1121353	554.253	B364–365
1121362	554.254	B359–360, B368
1121703	EB33040350	K139
1121711	BT50BT13088	K138
1121716	880.252.550	K133–134
1122168	PKG1565	K137–139
1122180	191.726	H98–99, J45
1122185	CV50BT13069	K138
1122328	192.759	J81
1122397	CPGT060204K K313	B188
1124019	26X2R043B25STN16D	W43
1124093	BT40BEWD20096M	J47
1124104	MS1163	C58–65, C129–135
1124107	536.091	J47
1124195	SPMT09T308LF K68	B238
1124300	TNMA220408 K68	B123
1124630	SDHCL2525M11	B209
1124975	PKG0002	K141
1125085	EB18030200	K139
1125092	RS1606	K125
1125110	AFB09075SCFCR06	K130
1125440	TNMA160408 K68	B123
1125454	LSASR3232P16	D78
1125685	KNUX150410L25 K68	E31
1126021	170.270	H58, H63, H65
1126032	170.271	H65
1126040	170.272	H58, H63, H65
1126049	170.273	H65
1126066	170.274	H58, H63, H65
1126072	170.275	H65
1126079	170.276	H58, H63, H65
1126088	170.277	H65
1126361	FT6	K75, T24
1126830	EB28035300	K139
1126838	AFB27115SCFCR09	K130
1127019	MS1162	C46–48, C58–65, C129–135, S116, S120, S122, V82
1127184	PKG7001	K124
1127271	AFB34115SCFCR09	K130
1127579	MS1280	U17–18
1127907	B510S08000 AS3	J76
1127915	B510S25000 AS3	J76
1127923	B510S30000 AS3	J76
1128324	AFB24115SCFCR09	K130
1128691	KNUX150410R25 K68	E31
1129375	5.34050-028450	J78
1129376	5.34050-032350	J78
1129377	5.34050-032500	J78
1129378	5.34050-040450	J78
1129379	5.34050-040600	J78
1129380	5.34050-048450	J78
1129381	5.34050-048600	J78
1129382	5.34050-058450	J78
1129383	5.34050-058600	J78
1130249	100G10NS90LN12N08	U17
1130277	100Y10RS90LN12N06	U18
1130283	100Y10RS90LN12N08	U18
1130286	364.010	H58–59, H61, H63, H98
1130295	364.011	H58–61, H63, H98
1130302	11X1R020B20STN11N	W40
1130303	364.012	H58, H60–63, H98–99
1130313	364.013	H58, H60, H62–63, H99
1130381	SDHCR2525M11	B209
1130477	125H12NS90LN12N06	U17
1130506	125Y12RS90LN12N10	U18
1130595	160H15NS90LN12N10	U17
1130608	160H15NS90LN12N12	U17
1130615	160H16NS90LN12N06	U17
1130686	17X1R022B16STN16N	W40
1130740	20X1R043B20STN16N	W40
1130837	22X1R025B25STN16L	W41
1130969	30X1R052B25STN27N	W40
1130977	30X1R092B25STN27L	W41
1131036	B510S08000 A30	J76
1131051	B510S15000 A30	J76
1131060	B510S20000 A30	J76
1131069	37X1R058B32STN27N	W40
1131070	B510S25000 A30	J76
1131086	37X1R098B32STN27L	W41
1131090	B510S30000 A30	J76
1131111	KM40FBH01660	K124
1131118	42X2R045B32STN27D	W43
1131119	B510S10000 AS3	J76
1131128	B510S15000 AS3	J76
1131134	B510S20000 AS3	J76
1131438	80F08NS90LN12N06	U17
1131447	80F08NS90LN12N08	U17
1131458	A1020LSEL11	D81
1131459	MS1488	D31, D33, D39–40
1131463	80Y08RS90LN12N06	U18
1131468	A1020LSER11	D81
1131472	80Y08RS90LN12N08	U18
1131476	A1320LSEL11	D81
1131479	191.282	K72
1131481	A1320LSER11	D81
1131499	A1620LSEL16	D81
1131509	A1620LSER16	D81
1131516	A2020LSEL16	D81
1131524	A2020LSER16	D81
1131532	A2525LSEL16	D81
1131540	A2525LSEL22	D81
1131545	512.135	B163, B165
1131547	A2525LSER16	D81
1131566	A2525LSER22	D81
1131574	A2532LSER16	D81
1131582	A2532LSER22	D81
1131602	191.375	J45
1131646	191.405	B70, B115–119, B199, B202, B220–221, B240–242, B260–263, B376–378
1131653	191.406	B70–73, B92, B115–121, B139–142, B183, B229, B235–237, B260–263, B375, B378
1131658	191.407	B70–73, B92–93, B115–117, B119, B139–141, B183, B235, B378
1131977	SN2TPKG	W40, W42
1132036	KM50FBH01670	K124
1132063	191.698	H98, J23, J25, J27, J29, J45–46, J74–75
1132119	191.725	I14, V153
1132130	191.727	J77–79
1132138	191.728	J77, J79–81
1132154	191.729	J80–81
1132436	191.848	J45–46, J74–75, V46–49
1132523	191.916	C41–42, H98–99, J23, J25, J27, J29, J31, J33, J35, J37, J75, J98
1132599	ISSN846 K9	B105–106
1132616	9X1R012B12STN10M	W40
1132781	15X1R022B16STN16T	W42
1132857	EB23035250	K139
1132931	192.057	I24
1132990	DCMT070204LF K313	B207
1133075	192.111	J74–75
1133083	192.112	J74–75
1133110	192.126	J81
1133202	PKG3242	K130, K132
1133229	192.156	J77–79
1133236	192.157	J77–80
1133280	EB13030150	K139
1133349	SN3TPKG	D82, D86, W40–43
1133581	DV50BT13069	K138
1133669	R31FBHS06	K136
1133702	570.850	J47
1133883	AFB13085SCFCR06	K130
1133894	AFB17100SCFCR06	K130
1133903	PKG2025	K130, K132
1133914	RS1608	K125
1133935	DV40BEWD20090M	J47
1134129	840.142.550	K118–119
1134246	192.416	J10–15, J67
1134271	192.419	J77–79
1134279	192.420	J77–79
1134285	SNMA120408 K68	B96
1134298	192.421	J77–80
1134307	192.422	J77–79
1134316	192.423	J77–80
1134324	192.424	J77, J79–81
1134333	192.425	J77, J79–81
1134342	192.426	J80–81
1134353	5.34032-028115	J78
1134361	5.34032-028200	J78
1134385	192.432	H98, I14, J10–12, J23, J25, J27, J29, J31, J33, J35, J37, J67, J74–75, J98
1134388	5.34032-032125	J78
1134393	192.433	J23, J25, J27, J29
1134415	5.34050-028300	J78
1134425	5.34050-032200	J78
1134434	5.34050-040148	J78
1134440	5.34050-040300	J78
1134457	5.34050-048168	J78
1134464	5.34050-048300	J78
1134472	5.34050-058186	J78
1134482	5.34050-058300	J78
1134503	5.34128R028150	J77
1134512	5.34132R032100	J77
1134523	5.34132R032200	J77
1134530	5.34140R040200	J77
1134547	5.34148R048200	J77
1134555	5.34158R058300	J77
1134564	5.34170R070186	J77
1134570	5.34170R070300	J77
1134581	5.34170R070500	J77
1134588	5.34180R080204	J77
1134597	5.34180R080300	J77
1134609	5.36050-154040	J80
1134614	5.34180R080500	J77
1134624	5.34240R032100	J77
1134631	5.34248R040100	J77
1134639	5.34258R048100	J77
1134650	5.34280R040080	J77
1134657	5.34280R058080	J77
1134666	5.34280R070150	J77
1134674	5.34350-090100	J81
1134716	192.529	U13
1134725	192.530	U13
1134735	192.531	U13
1134743	192.532	U13
1134879	193.113	I24
1134964	192.592	J67, J74
1134971	192.593	J74–75
1135110	193.114	I24
1135177	KCUX110305L15 K68	E32
1135184	KCUX110302R15 K68	E32
1135192	KCUX110302L15 K68	E32
1135217	KNUX150405R25 K68	E31
1135224	KCUX110305R15 K68	E32

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
1135293	DV40BEWD32108M	J47
1135346	PKG156502	K139–140
1135358	PKG7994	K141
1135369	R40FBHS06	K136
1135375	EBUFF0975	K141
1135387	192.718	I14
1135392	512.134	B163
1135404	192.720	I14
1135473	192.730	J81
1135481	192.731	J81
1135617	840.142.720	K118–119
1135623	840.142.940	K118–119
1135642	RS1610	K125
1135662	RS1612	K125
1135739	KNUX150405L25 K68	E31
1135802	KM63BT13065	K137
1135826	19X1R023B20STN16T	W42
1135961	DV50BEWD32108M	J47
1135981	BT40RMEWD32114M	J47
1135984	170.008	J79–81
1136025	192.636	B162
1136105	192.888	I14
1136108	112.403	E14–15
1136114	192.889	I14
1136116	112.404	E14–16
1136144	112.505	E15
1136174	114.114	E16
1136242	192.902	J67, J74–75
1136247	118.204	E17–18
1136251	192.903	J74–75
1136295	118.314	E17–18
1136414	192.932	V60
1136436	193.115	I24
1136445	193.116	I24
1136592	DV50RMEWD32108M	J47
1136616	121.610	S76
1136625	121.612	E14–15, E17, S72, S76, S79, S82
1136633	121.616	E14–16, E18, E49, E55, S79, S82
1136675	121.808	K44–46
1136703	121.812	E16, K44–46
1136713	121.816	E16–18
1136743	121.825	E18
1136777	125.025	S5, S10, S14, S17, S21, S48, S53, S68, S72, S76, S143–144, S146, T7, T17, V40
1136819	199.123	H64
1136840	125.225	V40
1136858	5.36050-154050	J80
1136926	LSASL1212N16	D78
1136935	LSASL1616H16	D78
1136943	LSASL2020K16	D78
1136949	360.510	I23
1136951	LSASL2525M16	D78
1136955	360.511	I23
1136959	LSASL2525M22	D78
1136965	LSASR1212N16	D78
1136984	LSASR1616H16	D78
1136992	LSASR2020K16	D78
1137000	LSASR2525M16	D78
1137007	LSASR2525M22	D78
1137022	LSSL2525M16Q	D79
1137029	LSSL2525M22Q	D79
1137036	LSSRDH2525M22Q	D79
1137054	LSSR2020K16Q	D79
1137063	LSSR2525M16Q	D79
1137069	LSSR2525M22Q	D79
1137096	125.616	U8
1137111	125.625	K44–46
1137209	125.820	J74–75
1137229	125.830	J74–75
1137321	511.018	B111, B113, B135, B138, B163
1137331	511.024	B87–88, B91
1137339	511.025	B64–65, B68, B111–113
1137353	511.030	B142, B165
1137382	511.033	B64–66, B111–113
1137396	511.038	B111
1137405	128.508	H64
1137412	128.510	H64
1137420	128.610	J67
1137452	511.060	B87–88
1137453	129.025	S21, S41, S48, S76, T102
1137479	R51FBHS06	K136
1137487	R24FBHS06	K136
1137505	R67FBHS09	K136
1137509	512.013	B135, B138
1137520	129.612	J74–75
1137528	129.616	J74–75
1137533	512.023	B135, B138
1137541	512.025	B111–113
1137547	BT50BEWD32127M	J47
1137597	129.830	S143–144
1137600	512.053	B111, B113
1137610	512.060	B87–88
1137616	512.063	B111–114
1137650	512.083	B111–113
1137670	512.092	B111
1137710	512.117	B64–65, B68
1137713	360.550	I23–24
1137720	360.551	H64, I23–24
1137736	512.123	B64–66
1137746	512.125	B136
1137756	512.126	B136
1137781	512.131	B162
1137789	512.153	B87–88, B91
1137835	AFB21110SCFCR09	K130
1137910	STCM25	V146–147
1137929	STN10100ISOI KC620M	W45
1137965	STN1611BSW KC610M	W46
1137987	513.018	B135, B138, B163
1137996	513.019	B111, B113
1138019	STN1614BSW KC610M	W46
1138029	513.025	B64–65, B68, B111–113
1138033	STN16150ISOE KC610M	W45
1138041	STN16150ISOE KC620M	W45
1138057	513.033	B64–66, B111–113
1138064	513.038	B111
1138071	513.060	B87–88
1138096	513.125	B136
1138107	513.126	B136
1138133	513.132	B162
1138136	STN27200ISOE KC610M	W45
1138273	170.000	K72
1138297	170.002	K47
1138307	170.003	E14–18, E49, E55, I14, K47, S68, S72, S76, S79, S82, S143–147
1138315	170.004	E16–18, J79, K44–47
1138319	515.022	B64–66, B68, B111–113
1138323	170.005	I14, J80, K44–46, U8
1138328	515.028	B111
1138331	170.006	J79–80, K44–46
1138413	170.023	J10–15, J23, J25, J27, J29, J31, J33, J35, J37, U13
1138430	170.024	I23–24, J23, J25, J27, J29, J31, J33, J35, J37, J45–46, J98
1138438	170.025	I14, I23–24, J23, J25, J27, J29, J31, J33, J35, J37, J45–46, J98, S4–5, S8–10, S14, S17, S20–21, U13, V46–49, V53–56, V64
1138446	170.026	J45, V60
1138455	170.027	J10–15
1138465	170.028	I14, J10–12, J23, J25, J27, J29, J31, J33, J35, J37, J98
1138748	170.135	K47
1138755	170.136	K47
1138816	BT40BEWD32114M	J47
1139210	190.076	I24
1139321	190.116	J67
1139429	190.195	I24
1139563	360.513	I23
1139601	B510S10000 A30	J76
1139637	190.371	I24
1140602	EB38040400	K139
1146699	CKM35	B72, B115, B139–141, B378
1147269	MS1454	B187, K75
1147293	MS325	B386
1147356	PSDNN4040S25	B111
1147828	511.022	B68, B73, B114, B120–121
1150356	460.716	J81
1150508	100G10NS90LN12N06	U17
1150511	160Y16RS90LN12N06	U18
1150513	160Y16RS90LN12N08	U18
1150524	160Y15RS90LN12N10	U18
1150527	200J18NS90LN12N08	U17
1150624	5.34280R048080	J77
1151011	551.126	B136
1151411	MS1276	J80
1152199	SPGN120308 K68	B169
1152824	E12QNKLCR11 KWH	E41
1152825	E12QNKLCL11 KWH	E41
1152826	E16RNKLCR11 KWH	E41
1152834	E16RNNTOR2 KWH	C170, D37
1152835	E16RNNTOL2 KWH	C170, D37
1152836	E20SNNTOR2 KWH	C170, D37
1152844	E16RLSER16 KWH	D82
1152846	E20SLSER16 KWH	D82
1152848	E25TLSER16 KWH	D82
1152852	E08KSCFPR06A	B195
1152853	E08KSCFPL06A	B195
1152854	E10MSCFPR06A	B195
1152856	E08KSCLPR06A	B197
1152857	E08KSCLPL06A	B197
1152858	E10MSCLPR06A	B197
1152859	E10MSCLPL06A	B197
1152860	E08KSTFPR09A	B258
1152862	E10MSTFPR11A	B258
1152863	E10MSTFPL11A	B258
1152873	E12QSTFPL11	B258
1152874	E16RSTFPR11	B258
1152875	E16RSTFPL11	B258
1152888	E12QSCFPR06	B195
1152889	E12QSCLPR06 KWH	B197
1152891	E12QSCLPL06	B197
1152892	E12QSDUPR07	B218
1152893	E12QSDUPL07	B218
1152894	E16RSDUPR07	B218
1152895	E16RSDUPL07	B218
1152897	E16RSCLPR09	B197
1152899	E16RSCLPL09 KWH	B197
1152902	E20SSCLPR09	B197
1152905	E20SSCLPL09	B197
1152906	E20SSDUPR11	B218
1152907	E20SSDUPL11	B218
1152908	E20SSTFPR16	B258
1152909	E20SSTFPL16	B258
1153403	HSK63AKR32075M	K87
1153604	HSK63AKR50080M	K87
1153606	HSK100AKR32075M	K87
1153612	HSK100AKR80090M	K87
1155782	MS1238	T58, T109
1156428	SNMA190612 K68	B96
1156961	PSSNR2525M12	B113
1156962	PCLNL2020K12	B65
1156968	PDJNL2525M15	B87
1156969	PDJNR3225P15	B87
1156970	PSDNN2525M12	B111
1156972	PTGNR1616H16	B135
1159961	CNMG120408 K313	B47
1159964	CNMG120408P K313	B52
1159971	SNMG120408 K313	B96
1159980	VNMG160408P K313	B146
1160004	RNMA120400 K68	B94
1160005	RNMA150600 K68	B94
1160013	CNMA120408 K68	B47
1160018	CNMG120404B K68	B47
1160019	CNMG120408 K68	B47
1160020	CNMG120412 K68	B47
1160025	CNMG190612 K68	B47
1160027	DNMG150408B K68	B75
1160039	SNMG120412 K68	B96
1160060	TNMG220412 K68	B123
1160068	VNMG160408 K68	B144
1160069	VNMG160412 K68	B144
1160070	VNMG220408 K68	B144
1160071	VNMG220412 K68	B144
1160077	VNGA160404 K68	B143
1160078	VNGA160408 K68	B143
1161093	VNGG160408LF K313	B143
1161095	CNMP120404 K313	B56
1161096	CNMP120408 K313	B56
1161098	CNMP190612 K313	B56
1161105	VNGP160404K K313	B144
1161106	VNGP160408K K313	B144
1161107	SNMP190612 K313	B104
1161108	TNMP160404 K313	B130
1161109	TNMP160408 K313	B130
1161112	CNGP120404 K313	B46
1161113	CNGP120408 K313	B46
1161114	CNGP120412 K313	B46
1161116	CNGP160612K K313	B47
1161118	DNGP150404 K313	B74
1161119	DNGP150408 K313	B74
1161121	DNGP150604 K313	B74
1161124	VNMP160404 K313	B148
1161125	VNMP160408 K313	B148
1161127	VNGP220408 K313	B143
1161146	CNMP120404 K68	B56
1161147	CNMP120408 K68	B56
1161148	CNMP120412 K68	B56
1161155	CNMS120408 K68	B57
1161157	CNMS190608 K68	B57
1161158	CNMS190612 K68	B57
1161159	DNMP150404 K68	B83
1161160	DNMP150408 K68	B83
1161161	DNMP150412 K68	B83
1161168	DNMS150408 K68	B84
1161172	SNMP190612 K68	B104
1161173	SNMS120408 K68	B104
1161175	SNMS190612 K68	B104
1161182	TNMP220416 K68	B130
1161186	CNGP120404 K68	B46
1161187	CNGP120408 K68	B46
1161191	TNMS160404 K68	B131
1161192	TNMS160408 K68	B131
1161194	TNMS220408 K68	B131
1161199	VNMP160404 K68	B148
1161200	VNMP160408 K68	B148
1161201	VNMP160404K K68	B148
1161202	VNMP160408K K68	B148
1161203	VNMS160404 K68	B148
1161204	VNMS160408 K68	B148
1162181	CCGT060202HP K313	B175
1162182	CCGT060204HP K313	B175
1162183	CCGT09T302HP K313	B175
1162184	CCGT09T304HP K313	B175
1162185	CCGT120404HP K313	B175
1162186	CCGT120408HP K313	B175
1162187	CCMT060204LF K313	B177
1162189	CCMT09T302LF K313	B177
1162190	CCMT09T304LF K313	B177
1162191	CCMT09T308LF K313	B177
1162192	CDHBS4T002 K313	B184
1162194	CPGT09T302HP K313	B188
1162195	CPGT09T304HP K313	B188
1162199	CPMT060204LF K313	B190
1162200	CPMT060208LF K313	B190
1162204	DCGT070202HP K313	B206
1162205	DCGT070204HP K313	B206
1162206	DCGT11T302HP K313	B206
1162207	DCGT11T304HP K313	B206
1162208	DCGT11T308HP K313	B206
1162209	DCMT070202LF K313	B207
1162211	DCMT11T304LF K313	B207
1162212	DCMT11T308LF K313	B207
1162216	DPGT11T304HP K313	B214
1162223	TPMT110204LF K313	B255
1162225	VBGT110304LF K313	B264
1162226	VBGT160402LF K313	B264
1162228	VBGT160404HP K313	B264
1162229	VBGT160408HP K313	B264
1162230	VBMT110304LF K313	B265
1162233	VBMT160402LF K313	B265
1162234	VBMT160404LF K313	B265
1162235	VBMT160408LF K313	B265
1162241	RCGT0803M0HP K313	B222

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
1162242	RCGT10T3M0HP K313	B222
1162243	RCGT1204M0HP K313	B222
1162245	RCMT09T300 K313	B224
1162246	RCMT0602M0 K313	B224
1162247	RCMT0803M0 K313	B224
1162249	RCMT1204M0 K313	B224
1162250	RCMT1605M0 K313	B224
1162251	RCMT2006M0 K313	B224
1162254	TCGT110204HP K313	B243
1162255	TCGT16T304HP K313	B243
1162256	TCGT16T308HP K313	B243
1162272	CPMT060204LF K68	B190
1162274	CPMT09T308LF K68	B190
1162288	VBGT110302LF K68	B264
1162289	VBGT160404HP K68	B264
1162296	RCGT0803M0HP K68	B222
1162297	RCMT0602M0 K68	B224
1162586	SPUN120308 K68	B169
1162732	TPUN110304 K68	B171
1162733	TPUN110308 K68	B171
1162734	TPUN160304 K68	B171
1162735	TPUN160308 K68	B171
1162737	TPUN220408 K68	B171
1162738	TPUN220412 K68	B171
1163009	CPGH09T304 K313	B188
1163010	CPGH09T308 K313	B188
1163033	TD6P K68	B253
1163051	CPGT060202K K68	B188
1163052	CPGT060204K K68	B188
1163054	CPGH09T302 K68	B188
1163055	CPGH09T304 K68	B188
1163056	CPGH09T308 K68	B188
1163276	KCGX110302R15 K313	E31
1163277	KCGX110302L15 K313	E31
1163280	KCGX110301R15 K313	E31
1163281	KCGX110304R15 K313	E31
1163283	KCGX110301L15 K313	E31
1163284	KCGX110304L15 K313	E31
1163285	KCGX110308L15 K313	E31
1163286	VCGR160404 K313	E34
1163287	VCGR160408 K313	E34
1163311	KCGX110301R15 K68	E31
1163312	KCGX110304R15 K68	E31
1163313	KCGX110308R15 K68	E31
1163314	KCGX110301L15 K68	E31
1163315	KCGX110304L15 K68	E31
1163316	KCGX110308L15 K68	E31
1163317	KNGX150401R15 K68	E30
1163323	KNGX150408L20 K68	E30
1163325	VCGR160402 K68	E34
1163326	VCGR160404 K68	E34
1163327	VCGR160408 K68	E34
1163328	VCGR160412 K68	E34
1163336	KCGR110304R08 K68	E29
1163338	KCGR110304L08 K68	E29
1163341	DCGR150408 K68	E28
1163532	RCMK060400 K313	E63
1163533	RCMK090700 K313	E63
1163535	RCMK040300 K313	E63
1164694	SPUN120304 K68	B169
1173988	HSK100AKR63100M	K87
1174502	LSSRDH2020K16Q	D79
1175211	3.77000R028V	J74
1175212	3.77000R031V	J74
1175225	193.281	J10–15, J23, J25, J31, J33, J35, J37
1176134	B105A08200 K10	G33
1176804	STN22300ISOIC KC610M	W45
1176808	STN27350ISOIC KC610M	W45
1176964	15X1R020B16STN16C	W42
1176967	25X1R040B25STN27C	W42
1176970	10X1R015B20STN11T	W42
1177888	460.889	U7–8
1178986	35X1R055B32STNB38N	W41
1180107	RNMG190600 K313	B94
1180737	TPGN220412T02020 KY3500	B299
1180917	SDET1204PDSRGB KC725M	T105, T112, U51
1181980	DNGA150608T02020 KY3500	B293
1181982	SNGA190612T02020 KY3500	B293
1181984	TNGA160408T02020 KY3500	B294
1181985	TNGA160412T02020 KY3500	B294
1181986	WNGA080408T02020 KY3500	B294
1181987	WNGA080412T02020 KY3500	B294
1181988	WNGA080416T02020 KY3500	B294
1181989	CNGA120408T02020 KY3500	B292
1181990	CNGA120412T02020 KY3500	B292
1181991	CNGA120416T02020 KY3500	B292
1181992	CNGA160612T02020 KY3500	B292
1181993	CNGA160616T02020 KY3500	B292
1181994	CNGA190612T02020 KY3500	B292
1181995	CNGA190616T02020 KY3500	B292
1181996	SNGA120408T02020 KY3500	B293
1181997	SNGA120412T02020 KY3500	B293
1181998	SNGA120416T02020 KY3500	B293
1181999	SNGA150612T02020 KY3500	B293
1182000	SNGA150616T02020 KY3500	B293
1182002	DNGA150408T02020 KY3500	B293
1182003	DNGA150412T02020 KY3500	B293
1182004	DNGA150416T02020 KY3500	B293
1182005	DNGA150612T02020 KY3500	B293
1182006	VNGA160408T02020 KY3500	B294
1182008	TNGA160416T02020 KY3500	B294
1182363	NT1L K68	D25
1182370	NTB3RB K68	D20
1182373	NTB3LB K68	D20
1182375	NTB2RA K68	D19
1182379	NTB3LA K68	D19
1182853	SPGN120308 K313	B169
1182856	SPGN190412 K313	B169
1182877	SNGN090308T02020 KY3500	B297
1182878	SNGN120408T02020 KY3500	B297
1182879	SNGN120412T02020 KY3500	B297
1182880	SNGN120416T02020 KY3500	B297
1182882	SNGN120432T02020 KY3500	B297
1182884	SNGN120716T02020 KY3500	B297
1182886	SNGN190416T02020 KY3500	B297
1182921	SPGN090304 K68	B169
1182922	SPGN090308 K68	B169
1182925	SPGN120304 K68	B169
1182926	SPGN120312 K68	B169
1182929	SPGN190408 K68	B169
1183203	TPGN110304 K313	B171
1183205	TPGN160304 K313	B171
1183206	TPGN160308 K313	B171
1183207	TPGN160312 K313	B171
1183209	TPGN160302 K313	B171
1183210	TPGN220404 K313	B171
1183211	TPGN220408 K313	B171
1183232	TNGN160408T02020 KY3500	B298
1183236	TNGN220416T02020 KY3500	B298
1183237	TPGN160308T02020 KY3500	B299
1183238	TPGN160312T02020 KY3500	B299
1183239	TPGN220408T02020 KY3500	B299
1183254	TPGN110304 K68	B171
1183255	TPGN110308 K68	B171
1183257	TPGN160304 K68	B171
1183258	TPGN160308 K68	B171
1183260	TPGN160316 K68	B171
1183262	TPGN160302 K68	B171
1183264	TPGN220404 K68	B171
1183265	TPGN220408 K68	B171
1183266	TPGN220412 K68	B171
1183267	TPGN220416 K68	B171
1183421	CPGN120304 K313	B166
1183422	CPGN120308 K313	B166
1183435	CNGN120408T02020 KY3500	B295
1183436	CNGN120412T02020 KY3500	B295
1183437	CNGN120416T02020 KY3500	B295
1183439	CNGN120712T02020 KY3500	B295
1183457	CPGN120304 K68	B166
1183458	CPGN120308 K68	B166
1183542	RPGN120300 K313	B166
1183544	RCGV120700 K313	B166
1183553	DNGX120708T02020 KY3500	B296
1183554	DNGX120712T02020 KY3500	B296
1183555	DNGX120716T02020 KY3500	B296
1183557	SNGX120712T02020 KY3500	B297
1183558	SNGX120716T02020 KY3500	B297
1183560	RNGN190700T02020 KY3500	B296
1183562	DNGX150708T02020 KY3500	B296
1183563	DNGX150712T02020 KY3500	B296
1183564	DNGX150716T02020 KY3500	B296
1183567	ENGX130716T02020 KY3500	B296
1183572	SNGX150724T02020 KY3500	B297
1183574	RNGN120400T02020 KY3500	B296
1183575	RNGN120700T02020 KY3500	B296
1184088	LNEU1245R08 KC725M	U19
1184089	LNEU1245R16 KC725M	U19
1184090	LNEU1245R32 KC725M	U19
1184091	LNEU1250R08 KC725M	U19
1184092	LNEU1255R08 KC725M	U19
1184093	LNEU1255R16 KC725M	U19
1184094	LNEU1255R32 KC725M	U19
1184097	LNEU1245R04 KC725M	U19
1184098	LNEU1250R04 KC725M	U19
1184099	LNEU1255R04 KC725M	U19
1184100	LNEU1260R04 KC725M	U19
1184103	LNEQ1245R04 KC725M	U20
1184105	LNEQ1255R04 KC725M	U20
1184106	LNEQ1260R04 KC725M	U20
1185937	DFT370R4WD40M	J46
1185959	DFT410R4WD40M	J46
1186677	SNGX150716T02020 KY3500	B297
1188639	PSKNR12CA-12	B120
1188641	PTFNR12CA-16	B142
1190977	1.78025R300	E18
1191046	3.37052R320	I14
1191047	3.37052R820	I14
1191048	3.37061R320	I14
1191049	3.37061R820	I14
1191050	3.37071R320	I14
1191051	3.37071R820	I14
1191052	3.37091R320	I14
1191053	3.37091R820	I14
1191054	3.37100R720	I23
1191055	3.37101R832	I14
1191056	3.37111R332	I14
1191057	3.37111R832	I14
1191058	3.37120R732	I23
1191059	3.37121R832	I14
1191060	3.37131R332	I14
1191061	3.37140R732	I23
1191062	3.37141R832	I14
1191063	3.37151R332	I14
1191072	3.42805R001 CS5	I27
1191073	3.42807R001 CS5	I27
1191074	CBTF200R2WD20N3M	J98
1191075	CBTF220R2WD20N3M	J98
1191076	CBTF260R2WD20N2M	J98
1191103	DFT260R4WD32M	J46
1191130	3.76055R032V	J72–73
1191131	3.76063R032V	J72–73
1191132	3.76073R040V	J72–73
1191133	3.76084R048V	J72–73
1191134	3.76102R058V	J72–73
1191135	3.77000R024V	J74
1191136	3.77000R025V	J74
1191137	3.77000R026V	J74
1191138	3.77000R027V	J74
1191139	3.77000R029V	J74
1191140	3.77000R038V	J74
1191141	3.77000R039V	J74
1191142	3.77000R081V	J74
1191143	3.77000R082V	J74
1191300	SPHX15T6ZCSRGP K110M	S80
1191306	4.96102-204	U13
1191346	SNHX1102PZTNGP K110M	U15
1191347	SNHX1203PZTNGP K110M	U15
1191366	551.125	B136
1191395	9X1R017B20STN10M	W40
1191396	A16RPWLNL06	B165
1191414	B105A03000 K10	G32
1191415	B105A03100 K10	G32
1191416	B105A03200 K10	G32
1191417	B105A03300 K10	G32
1191418	B105A03500 K10	G32
1191419	B105A04000 K10	G32
1191420	B105A04200 K10	G32
1191421	B105A04500 K10	G32
1191422	B105A05000 K10	G32
1191423	B105A05100 K10	G32
1191424	B105A05500 K10	G32
1191425	B105A05700 K10	G32
1191426	B105A05800 K10	G32
1191427	B105A06000 K10	G32
1191428	B105A06300 K10	G32
1191429	B105A06400 K10	G32
1191430	B105A06500 K10	G32
1191431	B105A06700 K10	G33
1191432	B105A06800 K10	G33
1191433	B105A07000 K10	G33
1191434	B105A07100 K10	G33
1191435	B105A07500 K10	G33
1191436	B105A07800 K10	G33
1191437	B105A08000 K10	G33
1191438	B105A08400 K10	G33
1191439	B105A08500 K10	G33
1191440	B105A08700 K10	G33
1191441	B105A08800 K10	G33
1191442	B105A09000 K10	G33
1191443	B105A09500 K10	G33
1191444	B105A09700 K10	G33
1191445	B105A09800 K10	G33
1191446	B105A10000 K10	G33
1191448	B105A10200 K10	G33
1191449	B105A10300 K10	G33
1191450	B105A10500 K10	G33
1191451	B105A10700 K10	G33
1191452	B105A11000 K10	G33
1191453	B105A11800 K10	G33
1191454	B105A12000 K10	G33
1191455	B105A12500 K10	G33
1191456	B105A12700 K10	G33
1191457	B105A12800 K10	G33
1191458	B105A13000 K10	G33
1191459	B105A13800 K10	G33
1191460	B105A14000 K10	G33
1191461	B105A14200 K10	G33
1191462	B105A14500 K10	G33
1191463	B105A15000 K10	G33
1191464	B105A15100 K10	G33
1191465	B105A15800 K10	G34
1191466	B105A16000 K10	G34
1191467	B105A16500 K10	G34
1191468	B105A18000 K10	G34
1191469	B105A20000 K10	G34
1191470	B105A20500 K10	G34
1191612	B411A05000 KF1	G100
1191613	B411A06000 KF1	G100
1191614	B411A08000 KF1	G100
1191616	B411A10000 KF1	G101
1191617	B411A12000 KF1	G101
1191618	B411A14000 KF1	G101
1191619	B411A16000 KF1	G101
1191620	B501Z06000 K10	G152
1191628	B505Z04000 K10	G152
1191629	B505Z06000 K10	G152
1191630	B505Z10000 K10	G152
1191631	B505Z12000 K10	G152
1191632	B505Z16000 K10	G152
1191633	B505Z20000 K10	G152
1191970	DV50BKR32040M	K86
1191971	DV50BKR50040M	K86
1192045	F2AA1800ADL45 K600	P119
1192275	KR32KR32038100M	K88
1192276	KR32KR32047100M	K88
1192280	KR50KR50065100M	K88
1192281	KR50SVS4B094M	K79
1192295	KRDCKR32M	K86–88
1192296	KRDCKR50M	K86–88
1192325	LSSL2020K16Q	D79
1192350	MTJNR2020K16H4	B136
1192352	MTJNR2525M16H4	B136
1192355	MWLNR2525M08H4	B162
1192372	PCBNL4040S19	B64
1192373	PCBNR4040S19	B64
1192375	PCLNL2525M12	B65
1192376	PCLNL2525M16	B65
1192377	PCLNL4040S19	B65
1192378	PCLNR2525M16	B65
1192379	PCLNR4040S19	B65
1192380	PDJNL2525M11	B87
1192381	PDJNL4025R15	B87
1192382	PDJNR2020K11	B87
1192383	PDJNR2020K15	B87
1192384	PDJNR2525M11	B87
1192385	PDJNR2525M15	B87

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
1192394	PTGNR2525M16	B135
1192396	PWLNL1616H06	B163
1192397	PWLNR2020K06	B163
1192398	PWLNR2020K08	B163
1192399	PWLNR2525M08	B163
1192469	SCLPR1212M06	B193
1192473	SDJCL2525M11	B210
1192530	SPHX060204R-21 KM1	J100
1192534	SPHX070304R-21 KM1	J100
1192535	SPHX070304R-22 KM1	J101
1192538	SPHX090304R-21 KM1	J100
1192539	SPHX090304R-22 KM1	J101
1192560	SVJBL3225P16	B267
1192561	SVBN3225P16	B268
1194440	A25RPWLNR08	B165
1197315	KM80BT13070	K137
1197539	SPHX1205ZCERGP KCK15	S73
1197540	SPHX1205ZCELGP KCK15	S73
1197721	410.081	E14, S72, S76
1197803	3.37530R010	I24
1198114	SNHX12L5PZTNGP K110M	U15
1198117	SNHX12L5PZFNGE K110M	U14
1198178	SCMT09T30811 KT315	B230
1198179	DCMT070202011 KT315	B206
1198180	VBMT11030211 KT315	B264
1198181	SCMT09T30411 KT315	B230
1198182	SCMT12040411 KT315	B230
1198183	VBMT16040411 KT315	B264
1198184	VBMT16040811 KT315	B264
1198185	TCMT11020411 KT315	B243
1198186	TCMT16T30411 KT315	B243
1198187	CCMT06020411 KT315	B176
1198188	CCMT09T30411 KT315	B176
1198189	CCMT09T30811 KT315	B176
1198191	DCMT070204011 KT315	B206
1198192	DCMT11T30411 KT315	B206
1198564	B411A03200 KF1	G100
1198566	B411A03300 KF1	G100
1198568	B411A03800 KF1	G100
1198570	B411A04000 KF1	G100
1198572	B411A04200 KF1	G100
1198574	B411A04500 KF1	G100
1198576	B411A04600 KF1	G100
1198578	B411A04650 KF1	G100
1198580	B411A04800 KF1	G100
1198582	B411A04900 KF1	G100
1198586	B411A05100 KF1	G100
1198588	B411A05200 KF1	G100
1198590	B411A05500 KF1	G100
1198592	B411A05550 KF1	G100
1198594	B411A05800 KF1	G100
1198597	B411A06300 KF1	G100
1198599	B411A06400 KF1	G100
1198602	B411A06500 KF1	G100
1198606	B411A06600 KF1	G100
1198608	B411A06800 KF1	G100
1198610	B411A07000 KF1	G100
1198613	B411A07400 KF1	G100
1198617	B411A07500 KF1	G100
1198620	B411A07800 KF1	G100
1198625	B411A08400 KF1	G100
1198628	B411A08500 KF1	G100
1198630	B411A09000 KF1	G100
1198632	B411A09300 KF1	G100
1198635	B411A09500 KF1	G101
1198637	DNMG11040833 KT315	B75
1198640	B411A09800 KF1	G101
1198644	B411A10200 KF1	G101
1198645	DNMG11040433 KT315	B75
1198648	B411A10500 KF1	G101
1198650	B411A11000 KF1	G101
1198652	B411A11200 KF1	G101
1198656	B411A11500 KF1	G101
1198658	B411A11800 KF1	G101
1198663	B411A12500 KF1	G101
1198665	B411A13000 KF1	G101
1198667	B411A13500 KF1	G101
1198670	B411A13800 KF1	G101
1198679	B411A14500 KF1	G101
1198682	B411A15000 KF1	G101
1198684	B411A15500 KF1	G101
1198686	CNMG12040833 KT315	B48
1198689	DNMG15060433 KT315	B75
1198691	B411A16500 KF1	G101
1198693	DNMG15060833 KT315	B75
1198694	B411A17000 KF1	G101
1198697	B411A17500 KF1	G101
1198701	B411A18000 KF1	G101
1198703	B411A19000 KF1	G101
1198704	B411A19500 KF1	G101
1198707	B411A20000 KF1	G101
1198711	B411A21000 KF1	G101
1198714	B411A22000 KF1	G101
1198716	B411A23000 KF1	G101
1198718	B411A24000 KF1	G101
1198721	B411A25000 KF1	G101
1198724	B501Z04000 K10	G152
1198733	B501Z10000 K10	G152
1198743	B505Z08000 K10	G152
1198753	B501Z12000 K10	G152
1199223	B105A12100 K10	G33
1199225	B105A08300 K10	G33
1199228	B105A04700 K10	G32
1199229	B105A06100 K10	G32
1199238	B105A08100 K10	G33
1199243	B105A10100 K10	G33
1199251	B105A10800 K10	G33
1199306	B105A07600 K10	G33
1199308	B105A11100 K10	G33
1199311	B105A09100 K10	G33
1199316	B105A11700 K10	G33
1199334	B105A03700 K10	G32
1199337	B105A03800 K10	G32
1199348	B105A04650 K10	G32
1199351	B105A04800 K10	G32
1199360	B105A05200 K10	G32
1199365	B105A05550 K10	G32
1199380	B105A06600 K10	G33
1199387	B105A07400 K10	G33
1199406	B105A09300 K10	G33
1199421	B105A11200 K10	G33
1199424	B105A11500 K10	G33
1199434	B105A13100 K10	G33
1199438	B105A13500 K10	G33
1199455	B105A15500 K10	G34
1199469	B105A17000 K10	G34
1199472	B105A17500 K10	G34
1199480	B105A18500 K10	G34
1199488	B105A19000 K10	G34
1199492	B105A19500 K10	G34
1199675	B105A21000 K10	G34
1199682	B105A04100 K10	G32
1199685	B105A08600 K10	G33
1199807	F2AA0400ADL45 K600	P119
1199808	F2AA0500ADL45 K600	P119
1199811	F2AA0600ADL45 K600	P119
1199812	F2AA0800ADL45 K600	P119
1199815	F2AA1000ADL45 K600	P119
1199816	F2AA1200ADL45 K600	P119
1199819	F2AA1400ADL45 K600	P119
1199820	F2AA1600ADL45 K600	P119
1199824	F2AA2000ADL45 K600	P119
1201617	B105A03400 K10	G32
1201621	B105A03600 K10	G32
1201661	B105A04900 K10	G32
1201677	B105A05600 K10	G32
1201708	B105A06200 K10	G32
1201713	B105A06350 K10	G32
1201892	B105A10400 K10	G33
1202275	B411A08800 KF1	G100
1208579	3.41020R901 CS5	I15
1208588	3.41020R902 CS5	I15
1208594	3.41020R903 CS5	I15
1208601	3.41220R901 CS5	I15
1208606	3.41220R902 CS5	I15
1208615	3.41220R903 CS5	I15
1208627	3.41020R900 KMF	I16
1208635	3.42805R001 KMF	I27
1208642	3.42807R001 KMF	I27
1208648	3.41220R900 KMF	I16
1208764	SPHX060204R-22 KM1	J101
1208782	SPHX120404R-21 KM1	J100
1208789	SPHX120404R-22 KM1	J101
1208830	SPHX150504R-21 KM1	J100
1208833	SPHX150504R-22 KM1	J101
1221501	4.81201R011 KCK15	S77
1223594	SPHX1205PCERGPB KCK15	S77
1230196	B105A04300 K10	G32
1230373	CKM36	B70, B92–93, B115–119
1232519	3.76068R040V	J72–73
1236864	PCLNR3232P16	B65
1236865	PDJNR3232P15	B87
1242260	PT00163	E54
1243476	114.111	E16
1243526	169.974	J47
1243527	132.151	E15
1243529	132.156	E15
1243735	192.158	J81
1243752	3.77000R083V	J74
1243753	3.77000R084V	J74
1243754	3.77000R086V	J74
1243769	302.009	J79
1243770	302.010	J79
1243771	302.011	J79
1243777	360.630	I23, I26
1243778	360.631	I23, I26
1243779	360.632	I23, I26
1243780	360.633	I23, I26
1243781	360.634	I23
1243782	360.635	I23, I26
1243783	360.636	I23, I26
1243903	511.011	B138
1243930	551.131	B162
1244113	A16RPWLNR06	B165
1244114	A20SPWLNL06	B165
1244115	A20SPWLNR06	B165
1244116	A25RPWLNL08	B165
1244117	A32SPWLNL08	B165
1244118	A32SPWLNR08	B165
1244119	A40TPWLNL08	B165
1244120	A40TPWLNR08	B165
1244368	4.96102-206	U13
1244370	4.96124-204	U13
1244371	4.96124-205	U13
1244374	4.96124-210	U13
1244375	4.96124-212	U13
1244376	4.96164-205	U13
1244379	4.96164-210	U13
1244385	4.96255-206	U13
1244386	4.96255-208	U13
1244389	4.96082-204	U13
1244394	4.96164-204	U13
1244395	4.96205-208	U13
1244398	4.96102-205	U13
1244443	PCLNL16CA-12	B73
1244444	PCLNR12CA-12	B73
1244452	PSSNL12CA12	B121
1244455	PSSNR12CA-12	B121
1244457	PTFNL12CA-16	B142
1244496	PCLNR16CA-12	B73
1244595	CTGPR2020K11	B173, B355
1244604	CSSPL2525M12	B170, B354
1244605	CSSPR2020K12	B170, B354
1244606	CSSPR2525M12	B170, B354
1244613	CTDPR1212F11	B172, B355
1244630	PCBNL2020K12	B64
1244631	PCBNL2525M16	B64
1244633	PCBNL3232P19	B64
1244635	PCBNR2525M16	B64
1244636	PCBNR3225P12	B64
1244637	PCBNR3225P16	B64
1244638	PCBNR3232P16	B64
1244646	PCKNL2020K12	B64
1244647	PCKNL3225P12	B64
1244648	PCKNL3232P19	B64
1244649	PCKNR2020K12	B64
1244650	PCKNR3225P12	B64
1244652	PCLNR2525M19	B65
1244653	PCLNR3225P19	B65
1244654	PCSNL2020K12	B66
1244655	PCSNL2525M12	B66
1244656	PCSNR2020K12	B66
1244657	PCSNR3225P12	B66
1244658	PDJNL2020K11	B87
1244659	PDNNL2525M11	B88
1244668	PSBNL2525M12	B111
1244669	PSBNL2525M15	B111
1244672	PSBNL3232P15	B111
1244673	PSBNL3232P19	B111
1244674	PSBNL4040S19	B111
1244675	PSBNL4040S25	B111
1244677	PSBNR2525M12	B111
1244678	PSBNR3225P12	B111
1244680	PSBNR3232P15	B111
1244681	PSBNR3232P19	B111
1244682	PSBNR4040S19	B111
1244683	PSBNR4040S25	B111
1244686	PSDNN1616H09	B111
1244687	PSDNN3225P12	B111
1244688	PSDNN3225P19	B111
1244690	PSKNL2525M12	B112
1244693	PSKNL3232P19	B112
1244699	PSKNR2020K12	B112
1244701	PSKNR3232P15	B112
1244702	PSKNR3232P19	B112
1244709	PSSNL2020K12	B113
1244710	PSSNL2525M15	B113
1244711	PSSNL3225P12	B113
1244714	PSSNL3232P19	B113
1244715	PSSNL4040S19	B113
1244718	PSSNR2020K09	B113
1244719	PSSNR2525M15	B113
1244720	PSSNR3225P12	B113
1244722	PSSNR3232P15	B113
1244723	PSSNR4040S19	B113
1244726	PTFNL2525M16	B135
1244751	PDJNL1616H11	B87
1244752	PDJNR1616H11	B87
1244754	PDNNL2020K11	B88
1244756	PDNNR2020K11	B88
1244767	PWLNL2020K06	B163
1244768	PWLNL2020K08	B163
1244769	PWLNL2525M08	B163
1244770	PWLNL3225P08	B163
1244771	PWLNR1616H06	B163
1244772	PWLNR3225P08	B163
1244773	PDNNR2525M15	B88
1244774	PSBNL2020K12	B111
1244775	PCKNR2525M16	B64
1244776	PCKNR3225P16	B64
1244777	PCKNL3225P16	B64
1244778	PTGNL2525M22	B135
1244779	PCBNR2525M12	B64
1244780	PCKNL2525M12	B64
1244781	PDJNL3225P15	B87
1244784	PDJNR4025R15	B87
1244785	PDNNL2525M15	B88
1244789	PSSNL2525M12	B113
1244791	PTGNL1616H16	B135
1244792	PTGNL2525M16	B135
1244794	PCBNL3232P16	B64
1244795	PCBNR3232P19	B64
1244797	PCKNR2525M12	B64
1244798	PCKNR3232P19	B64
1244799	PCLNL1616H12	B65
1244800	PCLNL2525M19	B65
1244802	PCLNL3225P16	B65
1244803	PCLNL3225P19	B65
1244804	PCLNL3232P16	B65
1244805	PCLNL3232P19	B65
1244809	PCLNR1616H12	B65
1244810	PCLNR2020K12	B65
1244811	PCLNR3225P12	B65
1244812	PCLNR3225P16	B65
1244813	PCLNR3232P19	B65
1244817	PCSNL3232P19	B66
1244818	PCSNR2525M12	B66
1244819	PCSNR3232P19	B66
1244820	PDJNL2020K15	B87
1244821	PDJNL3232P15	B87
1244822	PDNNL2020K15	B88
1244823	PDNNL4025M15	B88
1244824	PDNNR2020K15	B88
1244825	PDNNR4025M15	B88
1244833	PSBNR2020K12	B111
1244834	PSBNR2525M15	B111

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
1244835	PSDNN3232P19	B111
1244836	PSKNR2525M12	B112
1244837	PSSNR2020K12	B113
1244838	PSSNR3232P19	B113
1244839	PTFNL2020K16	B135
1244843	PTFNR2020K16	B135
1244844	PTFNR2525M16	B135
1244848	PTGNL2020K16	B135
1244850	PTGNR2020K16	B135
1244851	PTGNR2525M22	B135
1244858	PCLNL3225P12	B65
1244859	PCBNL2525M12	B64
1244863	PSDNN2020K12	B111
1244893	SCDPR1212H06	B192
1244896	SCEPR1010H06	B192
1244913	SCLPL1212M06	B193
1244917	SCSPR1010H06	B193
1244921	MWLNL2020K08H4	B162
1244922	MWLNL2525M08H4	B162
1244923	MWLNL3225P08H4	B162
1244924	MWLNR2020K08H4	B162
1244925	MWLNR3225P08H4	B162
1244940	STFCR1616H11	B247
1244943	STGCL1616H11	B247
1244944	STGCR1616H11	B247
1244949	SVHBL2020K11	B266
1244953	SVHBR2020K11	B266
1244957	SVJBL1616H16	B267
1244959	SVJBR1616H16	B267
1244961	SVVBN1616H16	B268
1244962	SVVBN2020K11	B268
1244966	SDJCL1616H07	B210
1244968	SDJCL2020K07	B210
1244972	SDJCR1616H07	B210
1244974	SDJCR2020K07	B210
1244982	SSSCR2525M12	B234
1244992	SVJBR3225P16	B267
1244995	SCLCR2525M09	B180
1244996	MTJNL2020K16H4	B136
1244997	MTJNL3225P16H4	B136
1244998	MTJNR3225P16H4	B136
1244999	MTJNR3225P22H4	B136
1245000	MTJNR2525M22H4	B136
1245001	MTJNL2525M22H4	B136
1245002	MTJNL2525M16H4	B136
1245016	S40T-CSYNR12-MN7	B373
1245236	1.18025L310	E15
1245237	1.18025R315	E15
1245244	1.10820R310	E14
1245245	1.10825L310	E14
1245247	1.10825R310	E14
1245248	1.10825R700	E14
1245255	1.18016R110	E15
1245256	1.18020L110	E15
1245257	1.18020R110	E15
1245258	1.18020R310	E15
1245259	1.18025R310	E15
1245260	1.18032L315	E15
1245261	1.18032R315	E15
1245277	1.17125L330	E15
1245287	1.18016L110	E15
1245292	1.18025L330	E16
1245326	1.18025L315	E15
1245338	1.38020R021	E16
1245339	1.38025L021	E16
1245340	1.38025R021	E16
1245357	1.77132R400	E17
1245364	1.78032R400	E18
1245371	1.77120L100	E17
1245372	1.77120R100	E17
1245374	1.77125R300	E17
1245382	1.77225R301	E18
1245388	1.77725R301	E17
1245392	1.78012R103	E18
1245394	1.78016R100	E18
1245397	1.78020R100	E18
1245398	1.78025L300	E18
1245712	302.014	J81
1245716	3.37042R320	I14
1245717	3.37042R820	I14
1245718	3.37051R320	I14
1245719	3.37051R820	I14
1245720	3.37062R320	I14
1245721	3.37062R820	I14
1245722	3.37081R320	I14
1245723	3.37081R820	I14
1245724	3.37101R332	I14
1245725	3.37121R332	I14
1245726	3.37131R832	I14
1245727	3.37141R332	I14
1245728	3.37151R832	I14
1245729	3.37161R332	I14
1245730	3.37161R832	I14
1245731	3.37171R332	I14
1245732	3.37171R832	I14
1245733	3.37181R332	I14
1245734	3.37181R832	I14
1245735	3.37060R720	I23
1245736	3.37080R720	I23
1245737	3.37160R732	I23
1245738	3.37180R732	I23
1245739	3.37526R006	I24
1245740	3.37528R008	I24
1245741	3.37532R012	I24
1245742	3.37534R014	I24
1245743	3.37538R016	I24
1245744	3.37540R018	I24
1245745	3.37542R020	I24
1245746	3.76063R040V	J72–73
1245747	3.76078R048V	J72–73
1245748	3.76096R058V	J72–73
1245749	3.76045R028V	J72–73
1245750	3.76050R028V	J72–73
1245751	3.76058R032V	J72–73
1245752	3.76078R040V	J72–73
1245753	3.76090R048V	J72–73
1245754	3.76096R048V	J72–73
1245755	3.76108R058V	J72–73
1245756	3.76115R070V	J72–73
1245757	3.76122R070V	J72–73
1245758	3.76130R070V	J72–73
1245759	3.76140R080V	J72–73
1245760	3.76150R080V	J72–73
1245761	3.76158R080V	J72–73
1245762	3.76162R080V	J72–73
1245818	3.77000R023V	J74
1245819	3.77000R030V	J74
1245820	3.77000R048V	J74
1245821	3.77000R049V	J74
1245822	3.77000R050V	J74
1245823	3.77000R051V	J74
1245824	3.77000R052V	J74
1245825	3.77000R053V	J74
1245826	3.77000R073V	J74
1245827	3.77000R074V	J74
1245828	3.77000R075V	J74
1245829	3.77000R076V	J74
1245830	3.77000R077V	J74
1245831	3.77000R078V	J74
1245832	3.77000R079V	J74
1245833	3.77000R080V	J74
1245834	3.77000R085V	J74
1245835	3.77000R087V	J74
1245836	3.77000R088V	J74
1245980	KSEM160R3WN20M	H59
1245983	KSEM160R5WN20M	H59
1245986	KSEM165R3WN20M	H59
1245988	KSEM165R5WN20M	H59
1245991	KSEM170R3WN20M	H59
1245993	KSEM170R5WN20M	H59
1245995	KSEM175R3WN20M	H59
1245997	KSEM175R5WN20M	H59
1245999	KSEM180R3WN20M	H59
1246001	KSEM180R5WN20M	H59
1246003	KSEM185R3WN25M	H59
1246005	KSEM185R5WN25M	H59
1246007	KSEM190R3WN25M	H59
1246008	KSEM190R5WN25M	H59
1246011	KSEM195R3WN25M	H59
1246013	KSEM195R5WN25M	H59
1246014	KSEM200R3WN25M	H59
1246017	KSEM200R5WN25M	H59
1246018	KSEM205R3WN25M	H59
1246021	KSEM205R5WN25M	H59
1246022	KSEM210R3WN25M	H59
1246024	KSEM210R5WN25M	H59
1246026	KSEM215R3WN25M	H59
1246028	KSEM215R5WN25M	H59
1246031	KSEM220R3WN25M	H59
1246032	KSEM220R5WN25M	H59
1246034	KSEM225R3WN25M	H60
1246036	KSEM225R5WN25M	H60
1246037	KSEM230R3WN25M	H60
1246040	KSEM230R5WN25M	H60
1246041	KSEM235R3WN25M	H60
1246044	KSEM235R5WN25M	H60
1246046	KSEM240R3WN25M	H60
1246048	KSEM240R5WN25M	H60
1246051	KSEM245R3WN32M	H60
1246053	KSEM245R5WN32M	H60
1246055	KSEM250R3WN32M	H60
1246057	KSEM250R5WN32M	H60
1246059	KSEM255R3WN32M	H60
1246061	KSEM255R5WN32M	H60
1246063	KSEM260R3WN32M	H60
1246065	KSEM260R5WN32M	H60
1246067	KSEM265R3WN32M	H60
1246069	KSEM265R5WN32M	H60
1246071	KSEM270R3WN32M	H60
1246073	KSEM270R5WN32M	H60
1246075	KSEM275R3WN32M	H60
1246077	KSEM275R5WN32M	H60
1246079	KSEM280R3WN32M	H60
1246081	KSEM280R5WN32M	H60
1246083	KSEM285R5WN32M	H60
1246085	KSEM290R3WN32M	H60
1246088	KSEM290R5WN32M	H60
1246089	KSEM295R3WN32M	H60
1246092	KSEM295R5WN32M	H60
1246093	KSEM300R3WN32M	H60
1246095	KSEM300R5WN32M	H60
1246098	KSEM305R3WN32M	H60
1246099	KSEM305R5WN32M	H60
1246102	KSEM310R3WN32M	H60
1246103	KSEM310R5WN32M	H60
1246106	KSEM315R3WN32M	H60
1246107	KSEM315R5WN32M	H60
1246109	KSEM320R3WN32M	H60
1246112	KSEM320R5WN32M	H60
1246114	4.97060116	U7
1246118	4.97060130	U7
1246120	4.97060140	U7
1246122	4.97080116	U7
1246124	4.97080122	U7
1246126	4.97080130	U7
1246129	4.97080140	U7
1246131	4.97101116	U7
1246132	4.97101122	U7
1246134	4.97101130	U7
1246136	4.97101140	U7
1246138	4.97123116	U7
1246140	4.97123122	U7
1246142	4.97123130	U7
1246145	4.97123140	U7
1246147	4.97164122	U7
1246149	4.97164130	U7
1246150	4.97164140	U7
1246153	4.97204130	U7
1246154	4.97204140	U7
1246157	4.97254130	U7
1246166	CBTF300R2WD20N3M	J98
1246168	CBTF420R2WD32N3M	J98
1246170	CBTF180R2WD20N3M	J98
1246187	CBTF330R2WD20N3M	J98
1246188	CBTF360R2WD32N3M	J98
1246195	CBTF400R2WD32N3M	J98
1246203	CBTF240R2WD20N2M	J98
1246205	CBTF280R2WD20N3M	J98
1246207	CBTF320R2WD20N3M	J98
1246216	CBTF460R2WD32N3M	J98
1246234	DFT250R4WD32M	J46
1246238	DFT270R4WD32M	J46
1246239	DFT280R4WD32M	J46
1246242	DFT290R4WD32M	J46
1246243	DFT300R4WD32M	J46
1246245	DFT310R4WD32M	J46
1246247	DFT320R4WD32M	J46
1246248	DFT250R4WD40M	J46
1246249	DFT260R4WD40M	J46
1246250	DFT270R4WD40M	J46
1246251	DFT280R4WD40M	J46
1246253	DFT290R4WD40M	J46
1246256	DFT300R4WD40M	J46
1246258	DFT310R4WD40M	J46
1246260	DFT320R4WD40M	J46
1246262	DFT330R4WD40M	J46
1246263	DFT340R4WD40M	J46
1246266	DFT350R4WD40M	J46
1246267	DFT360R4WD40M	J46
1246271	DFT380R4WD40M	J46
1246273	DFT390R4WD40M	J46
1246275	DFT400R4WD40M	J46
1246278	DFT420R4WD40M	J46
1246279	DFT430R4WD40M	J46
1246282	DFT440R4WD40M	J46
1246284	DFT450R4WD40M	J46
1246285	DFT460R4WD40M	J46
1246288	DFT470R4WD40M	J46
1246289	DFT480R4WD40M	J46
1247080	460.887	U8
1247082	460.888	U7–8
1247085	460.890	U7–8
1247087	460.897	U7–8
1247088	460.898	U7–8
1247091	460.899	U7–8
1249028	5.34280R028080	J77
1250901	SCEPR1212H06	B192
1251261	WXXNL4455X-FL	E54
1251262	WXXNR4455X-FL	E54
1252234	SVJBL2020K11	B267
1252235	SVJBR2020K11	B267
1255899	170.285	H65
1255900	170.286	H65
1255901	170.287	H65
1255902	170.288	H65
1255968	B105A05400 K10	G32
1258625	B105A03900 K10	G32
1260014	CCLNL2525M12-MF4	B358
1260015	CCLNL2525M12-MN4	B358
1260016	CCLNL2525M12-MN7	B358
1260017	CCLNL2525M12-MX7	B358
1260020	CCLNL3225P12-MX7	B358
1260022	CCLNR2525M12-MF4	B358
1260023	CCLNR2525M12-MN4	B358
1260024	CCLNR2525M12-MN7	B358
1260025	CCLNR2525M12-MX7	B358
1260027	CCLNR3225P12-MN7	B358
1260028	CCLNR3225P12-MX7	B358
1260086	CC09	B186–187
1260087	CC11	B185–187
1260172	CDJNL2525M12-MX7	B360
1260176	CDJNR2525M15MN7	B360
1260177	CDJNR2525M15-MX7	B360
1261273	CRSNR3225P12MN7	B362
1261299	CSKNL2525M12-MN4	B363
1261300	CSKNL2525M12-MN7	B363
1261315	CSKNR2525M12-MN7	B363
1261328	CSKPR12CA12	B375
1261334	CSRNL3225P12-MN7	B364
1261336	CSRNR2525M12-MN7	B364
1261349	CSSNL2525M12-MN7	B365
1261350	CSSNL2525M12-MX7	B365
1261353	CSSNL3225P12-MN4	B365
1261354	CSSNL3225P12-MN7	B365
1261366	CSSNR2525M12-MN7	B365
1261367	CSSNR2525M12-MX7	B365
1261370	CSSNR3225P12-MN4	B365
1261371	CSSNR3225P12-MN7	B365
1261378	CSSNR3225P15-MX7	B365
1261379	CSSPR10CA09	B377
1261408	CSYNL2525M12-MN7	B367
1261414	CSYNL3225P12-MX7	B367
1261423	CSYNR2525M12-MN7	B367
1261478	CTGNL2525M16-MN4	B368
1261479	CTGNL2525M16-MN7	B368
1261482	CTGNR2525M16-MN4	B368
1261483	CTGNR2525M16-MN7	B368
1262129	E0412XSCLDRS447	B187

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
1262131	E0416KSCLDRS447	B187
1262175	E0616XSCLDRS463	B187
1262178	E0612HSCLDRS463	B187
1263816	DV40BKR50060M	K86
1263825	DV40BT13069	K138
1264135	DV50BKR63060M	K86
1264136	DV50BKR80070M	K86
1270619	EB48040500	K139
1270620	EB53050550	K139
1270621	EB58050600	K139
1270966	E04MSCLDLS4	B186
1270967	E04MSCLDRS4	B186
1270977	E06MSCLDLS4	B186
1270978	E06MSCLDRS4	B186
1270981	E06MSTLDL07	B251
1270982	E06MSTLDR07	B251
1270987	E08MSCLDLS4	B186
1270988	E08MSCLDRS4	B186
1270991	E08MSTLDL07	B251
1270992	E08MSTLDR07	B251
1271092	FC11	B250–251
1271093	FC14	B250–252
1274022	ICSN643 K9	B59–60
1274800	ISSN443 K9	B105–107
1274805	ISSN543 K9	B105
1274807	ISSN643 K9	B105
1279732	KRCSTFPR113F	K85
1279733	KRDCKR63M	K86–88
1279734	KRDCKR80M	K86–88
1279736	KRDE070019M	K85, K104
1279739	KRDE083019M	K85, K104–105
1279740	KRDE096019M	K85, K105
1279741	KRDE101023M	K85, K106
1279742	KRDE120023M	K85, K106–107
1279743	KRDE139026M	K85, K107
1279745	KRDE156026M	K85, K108
1279746	KRDE175026M	K85, K109
1279748	KRDE193026M	K85, K110
1279772	KR32KR32038050M	K88
1279775	KR32KR32047050M	K88
1279785	KR50KR50065050M	K88
1279787	KR50SVS5B094M	K79
1279791	KR63KR63085050M	K88
1279792	KR63KR63085100M	K88
1279793	KR63SVS6B126M	K79
1279797	KR80KR80095050M	K88
1279798	KR80KR80095100M	K88
1279856	KSEM165R7WN20M	H61
1279857	KSEM170R7WN20M	H61
1279858	KSEM175R7WN20M	H61
1279859	KSEM180R7WN20M	H61
1279863	KSEM185R7WN25M	H61
1279864	KSEM190R7WN25M	H61
1279866	KSEM195R7WN25M	H61
1279867	KSEM200R7WN25M	H61
1279868	KSEM205R7WN25M	H61
1279872	KSEM210R7WN25M	H61
1279873	KSEM215R7WN25M	H61
1279874	KSEM220R7WN25M	H61
1279878	KSEM225R7WN25M	H61
1279881	KSEM230R7WN25M	H61
1279882	KSEM235R7WN25M	H61
1279889	KSEM245R7WN32M	H61
1279891	KSEM250R7WN32M	H61
1279892	KSEM255R7WN32M	H61
1279893	KSEM260R7WN32M	H62
1279894	KSEM265R7WN32M	H62
1279895	KSEM270R7WN32M	H62
1279896	KSEM275R7WN32M	H62
1279898	KSEM280R7WN32M	H62
1279902	KSEM285R3WN32M	H60
1279903	KSEM285R7WN32M	H62
1279905	KSEM290R7WN32M	H62
1279906	KSEM295R7WN32M	H62
1279908	KSEM300R7WN32M	H62
1279911	KSEM305R7WN32M	H62
1279913	KSEM310R7WN32M	H62
1279914	KSEM315R7WN32M	H62
1279915	KSEM320R7WN32M	H62
1282100	MCLNR16CA12	B72
1282677	KSEM240R7WN25M	H61
1282803	MSRNL12CA12	B116
1282807	MSSNR12CA12	B117
1284109	PCSNL3225P12	B66
1287636	SN5TM	W40–43
1288604	STN1616UNI KC610M	W44
1288876	A04XSCLDLS4	B186
1288877	A04XSCLDRS4	B186
1288884	A06HSTFDR07	B250
1288886	A06HSTLDR07	B250
1288892	A06XSCLDLS4	B186
1288893	A06XSCLDRS4	B186
1288898	A08HSTFDR07	B250
1288900	A08HSTLDR07	B250
1288905	A08XSCLDLS4	B186
1288906	A08XSCLDRS4	B186
1289072	S40T-CCLNL12-MN7	B372
1289075	S40T-CCLNR12-MN4	B372
1289076	S40T-CCLNR12-MN7	B372
1289077	S40T-CCLNR12-MX7	B372
1289129	A0412ESCLDRS412	B187
1289130	A0412ESCLDRS425	B187
1289155	A0612XSTLDR0731	B251
1291909	VBMT110304011 KT315	B264
1294964	11X1R012B12STN11N	W40
1300343	5.34270R058100	J77
1300344	5.34280R032080	J77
1310704	DPGT070204LF KC5010	B214
1310705	DPGT11T302LF KC5010	B214
1310707	DPGT11T301LF KC5010	B214
1310718	CCGT060202LF KC5010	B175
1310719	DPGT11T304HP KC5010	B214
1310720	DPGT11T304LF KC5010	B214
1310721	CCGT060201LF KC5010	B175
1310723	DPGT11T308HP KC5010	B214
1310724	CCGT060204HP KC5010	B175
1310725	DPGT11T308LF KC5010	B214
1310726	CCGT060204LF KC5010	B175
1310728	CCGT060208LF KC5010	B175
1310730	CCGT09T302HP KC5010	B175
1310733	CCGT09T302LF KC5010	B175
1310735	CCGT09T301LF KC5010	B175
1310737	CCGT09T304HP KC5010	B175
1310739	CCGT09T304LF KC5010	B175
1310740	CCGT09T308LF KC5010	B175
1310746	CCGT120402HP KC5010	B175
1310750	CCGT120404HP KC5010	B175
1310777	CNGP120408K KC5010	B47
1310793	TPGT110202HP KC5010	B254
1310800	TPGT16T304HP KC5010	B254
1310802	TPGT16T308HP KC5010	B254
1310803	CPGT060204K KC5010	B188
1310805	TPGT16T308LF KC5010	B254
1310838	CPGT060202LF KC5010	B189
1310839	CPGT060201LF KC5010	B189
1310841	VBMT110302LF KC5010	B265
1310842	CPGT060204LF KC5010	B189
1310844	CPGT09T302HP KC5010	B188
1310845	VBMT110304LF KC5010	B265
1310846	CPGT09T302LF KC5010	B189
1310849	VBMT160404LF KC5010	B265
1310850	CPGT09T304HP KC5010	B188
1310878	CPGT09T304LF KC5010	B189
1310880	DCGT11T302HP KC5010	B206
1310881	DCGT11T304HP KC5010	B206
1310882	DCGT11T308HP KC5010	B206
1310883	VNGP160404K KC5010	B144
1310885	DCMT070204LF KC5010	B207
1310887	DCMT11T302LF KC5010	B207
1310888	VNGP160408K KC5010	B144
1310890	DCMT11T304LF KC5010	B207
1310939	TPGT110204HP KC5010	B254
1310943	TPGT110204LF KC5010	B254
1310944	DPGT070202HP KC5010	B214
1310945	DPGT070204HP KC5010	B214
1310946	TPGT16T304LF KC5010	B254
1310947	DPGT070202LF KC5010	B214
1310948	VBMT160408LF KC5010	B265
1310950	WNGP080408K KC5010	B154
1310951	DCMT070202LF KC5010	B207
1310954	CCGT120408HP KC5010	B175
1310955	CNMG120408 KC5010	B47
1310956	CNMG120408MG KC5010	B57
1311193	KSEM160R7WN20M	H61
1312498	364.015	H58, H60, H63, H99
1313053	CRDNN2525M12MN7	B362
1314840	DCMT11T308LF KC5010	B207
1315965	MS1489	D31–33, D39
1316525	3.42805R001 KC7215	I27
1316526	3.42807R001 KC7215	I27
1318353	SCLCL2525M09	B180
1319470	IWSN322 K9	B161–162, B164
1320407	CRDNN3225P12MN7	B362
1321012	410.083	S143–147
1322363	3.90016SNGB KC735M	U9
1322365	3.90022SNGB KC735M	U9
1322366	3.90030SNGB KC735M	U9
1322367	3.90040SNGB KC735M	U9
1322368	3.90022ECGD KMF	U9
1322370	3.90030ECGD KMF	U9
1322371	3.90040ECGD KMF	U9
1322958	SPHX1205ZCTRGPK KY3500	S73
1324116	CRSNR2525M12MN7	B362
1324700	193.297	C118
1327362	CDJNR3225P15MN7	B360
1327363	CDJNL3225P15MN7	B360
1328642	A06MSWLCR2	B271
1328644	A08RSWLCR2	B271
1328646	A10SSWLCR3	B271
1331458	CELNR2525M13MF7	B361
1331597	CRSNL3225P12MN7	B362
1339367	MSSNR10CA09	B117
1500650	KRCSCFPR062L	K82
1501221	CELNL2525M13MN7	B361
1501222	CELNR2525M13MN7	B361
1501356	KRCSCFPR061L	K82
1501357	KRCSCFPR063L	K82
1501652	50A05RP90SP12CFP	S76
1501653	63A08RP90SP12CFP	S76
1501655	80A10RP90SP12CFP	S76
1501660	100B14RP90SP12CFP	S76
1501666	50A06RP70SP12CFP	S72
1501667	63B08RP70SP12CFP	S72
1501668	80B10RP70SP12CFP	S72
1501701	100B14RP70SP12CFP	S72
1502204	CRDNN3225P12MN4	B362
1503007	50A04RP90SP12CFP	S76
1503012	63A06RP90SP12CFP	S76
1503013	80A06RP90SP12C1WFP	S76
1503015	100B08RP90SP12C2WFP	S76
1503018	125B10RP90SP12C2WFP	S76
1503021	160C12RP90SP12C3WFP	S76
1503022	200C16RP90SP12C4WFP	S76
1503027	50A04RP70SP12CFP	S72
1503029	63B05RP70SP12CFP	S72
1503034	100B08RP70SP12C2WFP	S72
1503038	80B06RP70SP12C1WFP	S72
1503049	125B10RP70SP12C2WFP	S72
1503054	160C12RP70SP12C3WFP	S72
1503057	200C16RP70SP12C4WFP	S72
1503826	CCLNR2525M12-MF7	B358
1503827	CCRNL2525M12-MN7	B359
1504247	SPHX1205ZCTRGP4SK KY3500	S73
1504885	CCRNR3225P12-MN7	B359
1504931	CCLNL3225P12-MN7	B358
1504935	CCLNL2525M12-MF7	B358
1504937	CCLNR3225P12-MN4	B358
1504968	CDJNL2525M15MX7	B360
1504969	CDJNL2525M15MN7	B360
1505366	SPHX1205ZCTR-GP1WK KY3500	S74
1505370	SPHX1205PCTRGPBK KY3500	S77
1505394	SPHX1205PCTRGP4SBK KY3500	S77
1505400	SPHX1205PCTR-GP1WBK KY3500	S78
1505504	CDHNR2525M12-MX7	B359
1505803	CELNR2525M13-MX7	B361
1505865	SPHX1205PCSRGPB KC725M	S77
1505881	SPHX1205ZCERGP4S KCK15	S73
1505883	479.100	S72, S76, S79, S82
1505923	SPHX1205PCERGP4SB KCK15	S77
1510281	CRDNN2525M12MN4	B362
1510282	CRSNL2525M12-MN4	B362
1510283	CRSNL2525M12MN7	B362
1510284	CRSNL3225P12MN4	B362
1510285	CRSNR2525M12-MN4	B362
1510286	CRSNR3225P12MN4	B362
1510291	CSRNL2525M12-MN4	B364
1510292	CSRNL2525M12-MN7	B364
1510300	CSRNL3225P15-MX7	B364
1510303	CSRNR2525M12-MN4	B364
1510313	CSXNL2525M12-MN4	B366
1510327	CSXNR2525M12-MN4	B366
1510334	CSXNR3225P12-MX7	B366
1510341	CTFNL2525M16-MN4	B368
1510344	CTFNR2525M16-MN4	B368
1510401	S40T-CCLNL12-MX7	B372
1510773	170.281	H65
1510776	170.282	H65
1510779	170.283	H65
1510781	170.284	H65
1511189	VCGR160404 KT315	E34
1514473	SSSCL2525M12	B234
1516937	SPHX1205ZCER-GP1W KCK15	S74
1517764	SPHX1205PCER-GP1WB KCK15	S78
1520056	3.90016SNGD KC735M	U9
1520057	3.90022SNGD KC735M	U9
1520058	3.90030SNGD KC735M	U9
1520059	3.90040SNGD KC735M	U9
1520076	3.90016ECGD KMF	U9
1522062	KRBB16SCLDRS406A	K75, K98
1522063	KRBB16SCFPR06085A	K75, K98
1522064	KRBB16SCFPR0611A	K75, K98
1522068	KRBB16SCFPR06135A	K75, K98
1522069	KRBB16SCFPR0616A	K75, K99
1522070	KRBB16SCFPR0619A	K75, K99
1522071	KRBB16SCFPR0622A	K75, K99
1522848	TPGT090204LF KC5010	B254
1522850	TPGT16T302HP KC5010	B254
1522905	CPGT060202HP KC5010	B188
1522907	CPGT060204HP KC5010	B188
1522942	TCGT110204HP KC5010	B243
1522943	TCGT16T302HP KC5010	B243
1522945	TCGT16T304HP KC5010	B243
1522946	TCGT110204LF KC5010	B243
1522947	TCGT16T302LF KC5010	B243
1522948	TCGT16T304LF KC5010	B243
1522949	TCGT16T308LF KC5010	B243
1523196	TCGT110202HP KC5010	B243
1523329	TPGT090202LF KC5010	B254
1523354	TCGT16T308HP KC5010	B243
1523501	RCGK040300HP K313	E63
1527051	SCMT12040811 KT315	B230
1527992	DCMT11T30811 KT315	B206
1527995	TCMT16T30811 KT315	B243
1528328	DV50BKR32041M	K86
1535836	SDET120412PDERGB KC725M	T105, T112, U51
1536224	SDET1204PDERGB KC520M	T105, T112, U51
1539005	DV40BKR32041M	K86
1541367	DFT250R2WD32M	J44
1541368	DFT260R2WD32M	J44
1541369	DFT270R2WD32M	J44
1541370	DFT280R2WD32M	J44
1541381	DFT290R2WD32M	J44
1541382	DFT300R2WD32M	J44
1541383	DFT310R2WD32M	J44
1541384	DFT320R2WD32M	J44
1541385	DFT330R2WD32M	J44
1541386	DFT340R2WD32M	J44
1541387	DFT350R2WD32M	J44
1541388	DFT360R2WD32M	J44
1541389	DFT370R2WD32M	J44
1541390	DFT380R2WD32M	J44
1541391	DFT390R2WD32M	J44
1541392	DFT400R2WD32M	J44
1541393	DFT410R2WD32M	J44
1541394	DFT420R2WD32M	J44
1541395	DFT430R2WD32M	J44
1541396	DFT440R2WD32M	J44
1541847	DFT250R2WD40M	J44
1541848	DFT260R2WD40M	J44
1541849	DFT270R2WD40M	J44
1541850	DFT280R2WD40M	J44
1541851	DFT290R2WD40M	J44

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
1541852	DFT300R2WD40M	J44
1541853	DFT310R2WD40M	J44
1541854	DFT320R2WD40M	J44
1541855	DFT330R2WD40M	J44
1541856	DFT340R2WD40M	J44
1541857	DFT350R2WD40M	J44
1541858	DFT360R2WD40M	J44
1541859	DFT370R2WD40M	J44
1541860	DFT480R2WD40M	J44
1541871	DFT380R2WD40M	J44
1541872	DFT390R2WD40M	J44
1541873	DFT400R2WD40M	J44
1541874	DFT410R2WD40M	J44
1541875	DFT420R2WD40M	J44
1541876	DFT430R2WD40M	J44
1541877	DFT440R2WD40M	J44
1541878	DFT450R2WD40M	J44
1541879	DFT460R2WD40M	J44
1541880	DFT470R2WD40M	J44
1541901	DFT490R2WD40M	J44
1541902	DFT500R2WD40M	J44
1541903	DFT510R2WD40M	J44
1541904	DFT520R2WD40M	J44
1541905	DFT530R2WD40M	J44
1541906	DFT540R2WD40M	J44
1541931	DFT450R2WD50M	J44
1541932	DFT460R2WD50M	J44
1541933	DFT470R2WD50M	J44
1541934	DFT480R2WD50M	J44
1541935	DFT490R2WD50M	J44
1541936	DFT500R2WD50M	J44
1541951	DFT510R2WD50M	J44
1541952	DFT520R2WD50M	J44
1541953	DFT530R2WD50M	J44
1541954	DFT670R2WD50M	J45
1542043	DFT540R2WD50M	J44
1542071	DFT550R2WD50M	J44
1542072	DFT560R2WD50M	J44
1542074	DFT570R2WD50M	J44
1542076	DFT580R2WD50M	J44
1542081	DFT600R2WD50M	J44
1542083	DFT610R2WD50M	J45
1542090	DFT620R2WD50M	J45
1542092	DFT630R2WD50M	J45
1542093	DFT640R2WD50M	J45
1542096	DFT650R2WD50M	J45
1542097	DFT660R2WD50M	J45
1542099	DFT680R2WD50M	J45
1542105	DFT690R2WD50M	J45
1542107	DFT700R2WD50M	J45
1542781	DFT710R2WD50M	J45
1542782	DFT720R2WD50M	J45
1543235	DFT730R2WD50M	J45
1543236	DFT740R2WD50M	J45
1543237	DFT750R2WD50M	J45
1543238	DFT760R2WD50M	J45
1543239	DFT770R2WD50M	J45
1543240	DFT780R2WD50M	J45
1543311	DFT790R2WD50M	J45
1543312	DFT800R2WD50M	J45
1543313	DFT810R2WD50M	J45
1543314	DFT820R2WD50M	J45
1544364	DFT590R2WD50M	J44
1546392	SMYE5 K9	D84
1546393	SMYI5 K9	D82, D84–85
1549256	SN3TM	W40, W42
1551609	KSEM160R10WN20M	H61
1551610	KSEM165R10WN20M	H61
1551831	KSEM170R10WN20M	H61
1551833	KSEM175R10WN20M	H61
1551834	KSEM180R10WN20M	H61
1551835	KSEM185R10WN25M	H61
1551836	KSEM190R10WN25M	H61
1551837	KSEM195R10WN25M	H61
1551838	KSEM200R10WN25M	H61
1551839	KSEM210R10WN25M	H61
1551840	KSEM220R10WN25M	H61
1551841	KSEM230R10WN25M	H61
1551842	KSEM240R10WN25M	H61
1551843	KSEM250R10WN32M	H61
1551844	KSEM260R10WN32M	H62
1551845	KSEM265R10WN32M	H62
1551846	KSEM270R10WN32M	H62
1551847	KSEM280R10WN32M	H62
1551848	KSEM290R10WN32M	H62
1551849	KSEM300R10WN32M	H62
1551850	KSEM310R10WN32M	H62
1551861	KSEM320R10WN32M	H62
1553521	SPHX1205ZCTLGPK KY3500	S73
1556483	LNEQ1245R04 KC520M	U20
1556531	LNEU1245R04 KC520M	U19
1556533	LNEU1245R08 KC520M	U19
1556535	LNEU1245R16 KC520M	U19
1556536	LNEU1245R32 KC520M	U19
1556542	LNEU1255R08 KC520M	U19
1560389	CCGT060204HP KC5410	B175
1560390	CCGT09T302HP KC5410	B175
1560600	CCGT060202HP KC5410	B175
1560651	CCGT09T304HP KC5410	B175
1560653	CCGT120404HP KC5410	B175
1560655	CCGT120408HP KC5410	B175
1560692	CPGT060204LF KC5410	B189
1560693	CPGT09T302HP KC5410	B188
1560694	CPGT09T304HP KC5410	B188
1560698	CPGT09T304LF KC5410	B189
1560699	DCGT11T302HP KC5410	B206
1560714	DCGT11T304HP KC5410	B206
1560715	DCGT11T308HP KC5410	B206
1560717	DNGP150402 KC5410	B74
1560721	DPGT070204HP KC5410	B214
1560723	DPGT11T304HP KC5410	B214
1560751	RCGK060400HP KC5410	E63
1560752	RCGK090700HP KC5410	E63
1560753	RCGK120800HP KC5410	E63
1560756	TPGT110204HP KC5410	B254
1560757	TPGT16T304HP KC5410	B254
1560759	TPGT16T308HP KC5410	B254
1560781	VCGR160404 KC5410	E34
1560783	VCGR160408 KC5410	E34
1560784	WNGP080408K KC5410	B154
1560790	CNMP120404 KC5410	B56
1560795	CNMP120408 KC5410	B56
1560797	CNMS120408 KC5410	B57
1560799	CNMS160608 KC5410	B57
1560801	CNMS190608 KC5410	B57
1560803	DNMS150408 KC5410	B84
1560808	SNMS190612 KC5410	B104
1560829	TNMS220408 KC5410	B131
1560833	VNMS160404 KC5410	B148
1560834	VNMS160408 KC5410	B148
1566071	46X1R100B40STNB38L	W41
1582600	KR50SVU65110MCLB	K84
1582734	3.76180R110	J72–73
1582739	3.76195R110	J72–73
1582742	3.76213R125	J72–73
1582745	3.76230R160	J72–73
1582750	3.76260R160	J72–73
1592413	KSEM160R1WN20M	H58
1592414	KSEM181R1WN25M	H58
1592416	KSEM200R1WN25M	H58
1592417	KSEM221R1WN25M	H58
1592418	KSEM241R1WN32M	H58
1592419	KSEM261R1WN32M	H58
1592420	KSEM281R1WN32M	H58
1592461	KSEM301R1WN32M	H58
1592463	KSEM321R1WD50M	H58
1592464	KSEM361R1WD50M	H58
1592465	KSEM181R5WN25M	H59
1592466	KSEM221R5WN25M	H59
1592467	KSEM241R5WN32M	H60
1592468	KSEM261R5WN32M	H60
1592469	KSEM281R5WN32M	H60
1592491	KSEM301R5WN32M	H60
1592492	KSEM321R5WD50M	H60
1592493	KSEM330R5WD50M	H60
1592494	KSEM340R5WD50M	H60
1592496	KSEM350R5WD50M	H60
1592498	KSEM360R5WD50M	H60
1592502	KSEM361R5WD50M	H60
1592504	KSEM370R5WD50M	H60
1592505	KSEM380R5WD50M	H60
1592507	KSEM390R5WD50M	H60
1592509	KSEM400R5WD50M	H60
1597226	SDCW1204PDSRGN KY3500	T106, T113
1597228	SDCW120412PDSRGN KY3500	T106, T113
1599327	KSEM225R10WN25M	H61
1600249	KGMSR2525M50	C129
1600250	KGMSL2525M50	C129
1600270	KGMER2525M50	C130
1600271	KGMEL2525M50	C130
1601557	CNMG120404FF KC5010	B48
1601631	CNMG120404FF KT315	B48
1601632	CNMG120408FF KC5010	B48
1601636	CNMG120408FF KT315	B48
1601637	DNMG150608FF KC5010	B76
1601651	DNMG150608FF KT315	B76
1601652	WNMG080408FF KC5010	B155
1601656	TNMG160408FF KC5010	B124
1601886	TNMG160408FF KT315	B124
1601888	VNMG160404FF KC5010	B145
1601890	VNMG160408FF KC5010	B145
1601953	VNMG160408FF KT315	B145
1602247	VNMG160404FF KT315	B145
1602250	WNMG060408FF KC5010	B155
1602304	WNMG060408FF KT315	B155
1602579	TNMG160404FF KT315	B124
1602604	TNMG160404FF KC5010	B124
1604705	DNMG150408FF KT315	B76
1604706	DNMG150408FF KC5010	B76
1605207	CNMG120404FN KT315	B49
1605242	CNMG120408FN KT315	B49
1605250	CNMG120412FN KT315	B49
1605279	DNMG150408FN KT315	B77
1605334	DNMG150608FN KT315	B77
1606050	50HC040M	G85
1606061	50HC060M	G85
1606062	50HC080M	G85
1606064	50HC100M	G85
1606360	SNMG120408FN KT315	B97
1606485	TNMG160408FN KT315	B124
1606718	WNMG080408FN KT315	B155
1608363	DFR125R2WD20M	J10
1608364	DFR127R2WD20M	J10
1608365	DFR130R2WD20M	J10
1608366	DFR135R2WD20M	J10
1608367	DFR140R2WD20M	J10
1608368	DFR145R2WD20M	J10
1608369	DFR150R2WD20M	J10
1608370	DFR155R2WD20M	J10
1608391	DFR160R2WD20M	J10
1608392	DFR125R3WD20M	J11
1608393	DFR127R3WD20M	J11
1608394	DFR130R3WD20M	J11
1608395	DFR135R3WD20M	J11
1608396	DFR140R3WD20M	J11
1608397	DFR145R3WD20M	J11
1608398	DFR150R3WD20M	J11
1608399	DFR155R3WD20M	J11
1608400	DFR160R3WD20M	J11
1608497	DNMG110404FF KC5010	B76
1608500	DNMG110404FF KT315	B76
1608944	DNMG110408FF KT315	B76
1608949	TNMG160404FN KT315	B124
1610085	TNMG160412FN KT315	B124
1610089	DNMG110404FN KT315	B77
1610905	VCGR160408 KT315	E34
1610983	DNMG110408FN KT315	B77
1610985	DNMG150604FF KC5010	B76
1610988	DNMG150604FF KT315	B76
1611279	DNMG150604FN KT315	B77
1611325	DNMG150612FN KT315	B77
1611330	WNMG060404FN KT315	B155
1611335	WNMG060408FN KT315	B155
1611338	WNMG080404FF KC5010	B155
1611360	KSEM181R10WN25M	H61
1611414	WNMG080404FN KT315	B155
1611417	SNMG120408FF KC5010	B97
1611434	KSEM205R10WN25M	H61
1611435	KSEM215R10WN25M	H61
1611436	KSEM221R10WN25M	H61
1611437	KSEM235R10WN25M	H61
1611438	KSEM241R10WN32M	H61
1611439	KSEM245R10WN32M	H61
1611440	KSEM255R10WN32M	H61
1611441	KSEM261R10WN32M	H62
1611442	KSEM275R10WN32M	H62
1611443	KSEM281R10WN32M	H62
1611444	KSEM285R10WN32M	H62
1611445	KSEM295R10WN32M	H62
1611446	KSEM301R10WN32M	H62
1611931	LSASR3232P22	D78
1611933	LSSR3232P16Q	D79
1611934	LSSL3232P16Q	D79
1611935	LSSR3232P22Q	D79
1611938	LSSRDH2525M16	D79
1611939	LSSLDH2525M16	D79
1612562	DNMG150404FF KC5010	B76
1612565	DNMG150404FF KT315	B76
1612581	A1320LSER16	D81
1612584	A2020LSER22	D81
1612585	A2020LSEL22	D81
1612586	A2532LSEL16	D81
1612587	A3232LSER22	D81
1612588	A3232LSEL22	D81
1612950	DNMG150404FN KT315	B77
1617589	DNMG150412FN KT315	B77
1620372	KCGR110304R08 KT315	E29
1620373	TPMT110204LF KT315	B255
1620374	CPMT060208LF KT315	B190
1621083	KGMSR3232P50	C129
1621084	KGMSL3232P50	C129
1621085	KGMER3232P50	C130
1621086	KGMEL3232P50	C130
1621087	MS2002	C58–65, C129–135
1623193	CCGT060208HP KC5410	B175
1623194	CCGT09T308HP KC5410	B175
1623200	DCGT070202HP KC5410	B206
1623271	DCGT070204HP KC5410	B206
1623272	TCGT110202HP KC5410	B243
1623273	TCGT110204HP KC5410	B243
1623274	TCGT16T304HP KC5410	B243
1623275	TCGT16T308HP KC5410	B243
1623278	VBGT160404HP KC5410	B264
1623279	VBGT160408HP KC5410	B264
1624156	CNMG090304FF KC5010	B48
1624159	CNMG090308FF KC5010	B48
1624223	SNMG090304FF KC5010	B97
1624227	SNMG090308FF KC5010	B97
1624229	SNMG090308FF KT315	B97
1624233	TNMG110308FF KC5010	B124
1624424	CNMG090304FN KT315	B49
1624431	VNMG160404FN KT315	B145
1624432	VNMG160408FN KT315	B145
1624878	EBURF1975PKG	K141
1679773	LT11NRA60CB KC5025	D67
1679775	LT11NR075ISOCB KC5025	D71
1679776	LT11NR10ISOCB KC5025	D71
1679777	LT11NR125ISOCB KC5025	D71
1679778	LT11NR15ISOCB KC5025	D71
1679779	LT16ERAG60CB KC5010	D53
1679780	LT16ERAG60CB KC5025	D53
1690871	LT16ER05ISOCB KC5010	D58
1690872	LT16ER05ISOCB KC5025	D58
1690873	LT16ER075ISOCB KC5010	D58
1690874	LT16ER075ISOCB KC5025	D58
1690875	LT16ER10ISOCB KC5010	D58
1690876	LT16ER10ISOCB KC5025	D58
1690877	LT16ER125ISOCB KC5010	D58
1690878	LT16ER125ISOCB KC5025	D58
1690879	LT16ER15ISOCB KC5010	D58
1690880	LT16ER15ISOCB KC5025	D58
1692101	LT16ER175ISOCB KC5010	D58
1692102	LT16ER175ISOCB KC5025	D58
1692103	LT16ER20ISOCB KC5010	D58
1692109	LT16ER20ISOCB KC5025	D58
1698205	LT16ER25ISOCB KC5025	D58
1698206	LT16ER30ISOCB KC5010	D58
1698207	LT16ER30ISOCB KC5025	D58
1698208	LT16NRAG60CB KC5025	D67
1698209	LT16NRG60CB KC5025	D67
1698210	LT16NR10ISOCB KC5025	D71
1712545	840.142.250	K118–120
1712546	840.142.320	K118–119
1712547	840.142.420	K118–119
1712552	LT16NR15ISOCB KC5025	D71
1712554	LT16NR20ISOCB KC5025	D71

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
1712555	LT16NR25ISOCB KC5025	D71
1712556	LT11NR16UNCB KC5025	D75
1712557	LT11NR18UNCB KC5025	D75
1712558	LT11NR20UNCB KC5025	D75
1712559	LT11NR24UNCB KC5025	D75
1712561	LT11NR32UNCB KC5025	D75
1712563	LT16ER8UNCB KC5010	D63
1712564	LT16ER8UNCB KC5025	D63
1712566	LT16ER10UNCB KC5025	D63
1712567	LT16ER12UNCB KC5010	D63
1712568	LT16ER12UNCB KC5025	D63
1712569	LT16ER14UNCB KC5010	D63
1712570	LT16ER14UNCB KC5025	D63
1712586	SPHX1205ZCERGP KC520M	S73
1712601	LT16ER16UNCB KC5010	D63
1712602	LT16ER16UNCB KC5025	D63
1712603	LT16ER18UNCB KC5010	D63
1712604	LT16ER18UNCB KC5025	D63
1712605	LT16ER20UNCB KC5010	D63
1712606	LT16ER20UNCB KC5025	D63
1712607	LT16ER24UNCB KC5010	D63
1712608	LT16ER24UNCB KC5025	D63
1712609	LT16ER28UNCB KC5010	D63
1712610	LT16ER28UNCB KC5025	D63
1712611	LT16ER32UNCB KC5010	D63
1712612	LT16ER32UNCB KC5025	D63
1712614	LT16ER11WCB KC5025	D65
1712615	LT16ER14WCB KC5010	D65
1712616	LT16ER14WCB KC5025	D65
1712617	LT16ER14NPTCB KC5010	D59
1712618	LT16ER14NPTCB KC5025	D59
1712620	LT16ER115NPTFCB KC5025	D60
1712661	LT16NR8UNCB KC5025	D75
1712663	LT16NR10UNCB KC5025	D75
1712664	LT16NR12UNCB KC5025	D75
1712665	LT16NR14UNCB KC5025	D75
1712666	LT16NR16UNCB KC5025	D75
1712667	LT16NR18UNCB KC5025	D75
1712668	LT16NR20UNCB KC5025	D75
1712669	LT16NR11WCB KC5025	D76
1712670	LT16NR14WCB KC5025	D76
1712671	LT16NR115NPTCB KC5025	D72
1712672	LT16NR14NPTCB KC5025	D72
1712711	SPHX1205ZCER-GP1W KC520M	S74
1712714	SPHX1205PCERGPB KC520M	S77
1712730	NG2M150LK KC5025	C147
1712734	NG2M150RK KC5025	C146
1712949	SPHX1205PCERGP4SB KC520M	S77
1712981	SPHX1205PCER-GP1WB KC520M	S78
1713203	DFT090508MD KC7140	J87
1713307	RCGT0803M0HP KC5410	B222
1713308	RCGT10T3M0HP KC5410	B222
1713310	RCGT0803M0HP KC5010	B222
1713351	RCGT10T3M0HP KC5010	B222
1713352	RCGT1204M0HP KC5010	B222
1713356	CPGT09T308LF KC5010	B189
1713359	VBGT110301LF KC5010	B264
1713402	840.142.200	K118–120
1713440	DFT070408MD KC7140	J87
1713512	DFT06T308MD KC7140	J87
1713513	DFT05T308MD KC7140	J87
1713515	DFT030304MD KC7140	J87
1713517	DFT030204MD KC7140	J87
1715530	841.142.250	K118–120
1721296	SPHX1205PCELGPB KCK15	S77
1723607	NG3094RK KC5010	C146
1723608	SPGT09T308LF KC5410	B238
1723693	LT16ER15ISO KC5010	D57
1723694	LT16ER125ISO KC5010	D57
1723695	LT16ER175ISO KC5010	D57
1723696	LT16ER20ISO KC5010	D57
1723697	LT16ER25ISO KC5010	D57
1723698	LT16ER30ISO KC5010	D57
1723726	LT16EL15ISO KC5010	D57
1724012	LT11NR15ISO KC5010	D70
1724013	LT16NR10ISO KC5010	D70
1724014	LT16NR15ISO KC5010	D70
1724031	LT16NR20ISO KC5010	D70
1724040	LT16NR30ISO KC5010	D70
1724291	LT16ER32UN KC5010	D62
1724292	LT16ER28UN KC5010	D62
1724293	LT16ER24UN KC5010	D62
1724294	LT16ER20UN KC5010	D62
1724295	LT16ER18UN KC5010	D62
1724296	LT16ER16UN KC5010	D62
1724297	LT16ER14UN KC5010	D62
1724298	LT16ER12UN KC5010	D62
1724299	LT11NR16UN KC5010	D74
1724300	LT16EL05ISO KC5025	D57
1724331	LT16NR12UN KC5010	D74
1724333	LT16EL075ISO KC5025	D57
1724334	LT16ER20UNJ KC5010	D63
1724335	LT16EL10ISO KC5025	D57
1724337	LT16ER18UNJ KC5010	D63
1724338	LT16ER16UNJ KC5010	D63
1724340	LT16ER14UNJ KC5010	D63
1724352	LT16EL125ISO KC5025	D57
1724354	LT16ER12UNJ KC5010	D63
1724356	LT16ER19W KC5010	D64
1724358	LT16EL15ISO KC5025	D57
1724360	LT16ER14W KC5010	D64
1724372	LT16EL175ISO KC5025	D57
1724373	LT16ER11W KC5010	D64
1724377	LT16EL20ISO KC5025	D57
1724392	LT16NR11W KC5010	D76
1724394	LT16EL25ISO KC5025	D57
1724398	LT16ER18NPT KC5010	D59
1724400	LT16EL30ISO KC5025	D57
1724401	LT16ER14NPT KC5010	D59
1724402	LT16ER115NPT KC5010	D59
1724403	LT11NR14NPT KC5010	D72
1724405	LT16NR115NPT KC5010	D72
1724406	LT16ERA60 KC5010	D53
1724408	LT22EL35ISO KC5025	D57
1724411	LT16ERAG60 KC5010	D53
1724412	LT16ERG60 KC5010	D53
1724414	LT11NRA60 KC5010	D66
1724415	LT16NRA60 KC5010	D66
1724418	LT16NRAG60 KC5010	D66
1724420	LT16NRG60 KC5010	D66
1724426	LT16ERAG55 KC5010	D52
1724437	LT11NL10ISO KC5025	D70
1724439	LT11NL15ISO KC5025	D70
1724494	LT16NL10ISO KC5025	D70
1724495	LT16ER10ISO KC5010	D57
1724497	LT16NL15ISO KC5025	D70
1724499	LT16NL20ISO KC5025	D70
1724524	LT16ER05ISO KC5025	D57
1724525	LT16NL25ISO KC5025	D70
1724526	LT16NL30ISO KC5025	D70
1724527	LT16ER075ISO KC5025	D57
1724562	LT16ER48UN KC5025	D62
1724563	LT16ER40UN KC5025	D62
1724564	LT16ER36UN KC5025	D62
1724565	LT16ER32UN KC5025	D62
1724566	LT16ER28UN KC5025	D62
1724734	LT16ER24UN KC5025	D62
1724735	LT16ER20UN KC5025	D62
1724736	LT16ER18UN KC5025	D62
1724737	LT16ER16UN KC5025	D62
1724738	LT16ER14UN KC5025	D62
1724834	LT16ER12UN KC5025	D62
1724835	LT16ER10UN KC5025	D62
1724836	LT16ER8UN KC5025	D62
1724878	NG3047RK KC5010	C146
1725015	LT16EL28UN KC5025	D62
1725017	LT16EL24UN KC5025	D62
1725018	LT16EL20UN KC5025	D62
1725053	LT16EL18UN KC5025	D62
1725054	LT16EL16UN KC5025	D62
1725055	LT16EL14UN KC5025	D62
1725056	LT16EL12UN KC5025	D62
1725058	LT16EL8UN KC5025	D62
1725060	LT11NR40UN KC5025	D74
1725108	LT16ER10ISO KC5025	D57
1725109	LT16ER125ISO KC5025	D57
1725110	LT16ER15ISO KC5025	D57
1725221	LT16ER175ISO KC5025	D57
1725222	LT16ER20ISO KC5025	D57
1725223	LT16ER25ISO KC5025	D57
1725224	LT16ER30ISO KC5025	D57
1725225	LT22ER35ISO KC5025	D57
1725461	LT22ER40ISO KC5025	D57
1725462	LT22ER45ISO KC5025	D57
1725463	LT22ER50ISO KC5025	D57
1725464	LT11NR05ISO KC5025	D70
1725465	LT11NR075ISO KC5025	D70
1725466	LT11NR10ISO KC5025	D70
1725467	LT11NR125ISO KC5025	D70
1725468	LT11NR15ISO KC5025	D70
1725469	LT11NR175ISO KC5025	D70
1725471	LT11NR20ISO KC5025	D70
1725472	LT16NR05ISO KC5025	D70
1725474	LT16NR075ISO KC5025	D70
1725475	LT16NR10ISO KC5025	D70
1725476	LT16NR125ISO KC5025	D70
1725477	LT16NR15ISO KC5025	D70
1725478	LT16NR175ISO KC5025	D70
1725511	LT16NR20ISO KC5025	D70
1725512	LT16NR25ISO KC5025	D70
1725513	LT16NR30ISO KC5025	D70
1725515	LT22NR35ISO KC5025	D70
1725516	LT22NR40ISO KC5025	D70
1725519	LT22NR45ISO KC5025	D70
1725520	LT22NR50ISO KC5025	D70
1727704	LT16NR8UN KC5025	D74
1730321	DFR020204LD KC7140	J84
1732924	MS1944	C39–40, C112–114
1743686	LT16EL8APIRD KC5025	D55
1743696	LT16EL16UNJ KC5025	D63
1743701	LT16ELA60 KC5025	D53
1743702	LT16ELAG60 KC5025	D53
1743703	LT16ELG60 KC5025	D53
1743704	LT22ELN60 KC5025	D53
1743706	LT16ELAG55 KC5025	D52
1743715	LT16EL14W KC5025	D64
1743717	LT16EL11W KC5025	D64
1743734	LT16ER32UNJ KC5025	D63
1743735	LT16ER28UNJ KC5025	D63
1743736	LT16ER24UNJ KC5025	D63
1743737	LT16ER20UNJ KC5025	D63
1743738	LT16ER18UNJ KC5025	D63
1743739	LT16ER16UNJ KC5025	D63
1743740	LT16ER14UNJ KC5025	D63
1743741	LT16ER12UNJ KC5025	D63
1743744	LT16ERA60 KC5025	D53
1743745	16ERAG60 KC5025	D53
1743746	LT16ERG60 KC5025	D53
1743747	LT22ERN60 KC5025	D53
1743748	LT16ERA55 KC5025	D52
1743749	LT16ERAG55 KC5025	D52
1743750	16ERG55 KC5025	D52
1743751	LT22ERN55 KC5025	D52
1743752	LT16ER28W KC5025	D64
1743753	LT16ER24W KC5025	D64
1743754	LT16ER20W KC5025	D64
1743755	LT16ER19W KC5025	D64
1743756	LT16ER18W KC5025	D64
1743757	LT16ER16W KC5025	D64
1743758	LT16ER14W KC5025	D64
1743759	LT16ER12W KC5025	D64
1743760	LT16ER11W KC5025	D64
1743761	LT16ER10W KC5025	D64
1743762	LT16ER9W KC5025	D64
1743763	LT16ER8W KC5025	D64
1743764	LT22ER7W KC5025	D64
1743765	LT22ER6W KC5025	D64
1743767	LT16ER14BSPT KC5025	D56
1743768	LT16ER11BSPT KC5025	D56
1743769	LT16ER27NPT KC5025	D59
1743770	LT16ER18NPT KC5025	D59
1743771	LT16ER14NPT KC5025	D59
1743772	LT16ER115NPT KC5025	D59
1743773	LT16ER8NPT KC5025	D59
1743774	LT16ER14NPTF KC5025	D60
1743775	LT16ER115NPTF KC5025	D60
1743776	LT16ER16ACME KC5025	D54
1743778	LT16ER12ACME KC5025	D54
1743779	LT16ER10ACME KC5025	D54
1743780	LT16ER8ACME KC5025	D54
1743781	LT22ER6ACME KC5025	D54
1743782	LT22ER5ACME KC5025	D54
1743783	LT16ER16STACME KC5025	D61
1743785	LT16ER12STACME KC5025	D61
1743786	LT16ER10STACME KC5025	D61
1743787	LT16ER8STACME KC5025	D61
1743788	LT16ER6STACME KC5025	D61
1743789	LT22ER5STACME KC5025	D61
1743791	LT16ER2TR KC5025	D61
1743792	LT16ER3TR KC5025	D61
1743793	LT22ER4TR KC5025	D61
1743794	LT22ER5TR KC5025	D61
1743796	LT16ER8RD KC5025	D60
1743797	LT22ER6RD KC5025	D60
1743798	LT16ER10APIRD KC5025	D55
1743799	LT16ER8APIRD KC5025	D55
1743800	LT22ER4API382 KC5025	D55
1743803	LT22ER4API502 KC5025	D55
1743805	LT22ER5BUT75 KC5025	D56
1743810	LT11NL32UN KC5025	D74
1743824	LT16NL16UN KC5025	D74
1743826	LT16NL12UN KC5025	D74
1743827	LT16NL10UN KC5025	D74
1743829	LT11NLA60 KC5025	D66
1743830	LT16NLA60 KC5025	D66
1743831	LT16NLAG60 KC5025	D66
1743832	LT16NLG60 KC5025	D66
1743833	LT22NLN60 KC5025	D66
1743847	LT16NL11W KC5025	D76
1743899	LT11NR32UN KC5025	D74
1743900	LT11NR28UN KC5025	D74
1743901	LT11NR24UN KC5025	D74
1743902	LT11NR20UN KC5025	D74
1743903	LT11NR18UN KC5025	D74
1743904	LT11NR16UN KC5025	D74
1743908	LT16NR32UN KC5025	D74
1743909	LT16NR28UN KC5025	D74
1743910	LT16NR24UN KC5025	D74
1743921	LT16NR20UN KC5025	D74
1743922	LT16NR18UN KC5025	D74
1743923	LT16NR16UN KC5025	D74
1743924	LT16NR14UN KC5025	D74
1743925	LT16NR12UN KC5025	D74
1743926	LT16NR10UN KC5025	D74
1743927	LT11NRA60 KC5025	D66
1743928	LT16NRA60 KC5025	D66
1743929	LT16NRAG60 KC5025	D66
1743930	LT16NRG60 KC5025	D66
1743931	LT22NRN60 KC5025	D66
1743932	LT11NRA55 KC5025	D65
1743933	LT16NRA55 KC5025	D65
1743934	LT16NRAG55 KC5025	D65
1743935	LT16NRG55 KC5025	D65
1743936	LT22NRN55 KC5025	D65
1743937	LT11NR19W KC5025	D76
1743938	LT11NR14W KC5025	D76
1743939	LT16NR20W KC5025	D76
1743940	LT16NR19W KC5025	D76
1743942	LT16NR16W KC5025	D76
1743943	LT16NR14W KC5025	D76
1743944	LT16NR12W KC5025	D76
1743945	LT16NR11W KC5025	D76
1743946	LT16NR10W KC5025	D76
1743948	LT16NR8W KC5025	D76
1743949	LT22NR7W KC5025	D76
1743962	LT11NR14BSPT KC5025	D69
1743963	LT16NR14BSPT KC5025	D69
1743964	LT16NR11BSPT KC5025	D69
1743966	LT11NR18NPT KC5025	D72
1743967	LT11NR14NPT KC5025	D72
1743970	LT16NR14NPT KC5025	D72
1743971	LT16NR115NPT KC5025	D72
1743972	LT16NR8NPT KC5025	D72
1743973	LT11NR14NPTF KC5025	D72
1743974	LT16NR14NPTF KC5025	D72
1743978	LT16NR12ACME KC5025	D68
1743979	LT16NR10ACME KC5025	D68
1743980	LT16NR8ACME KC5025	D68
1743981	LT22NR6ACME KC5025	D68
1743982	LT22NR5ACME KC5025	D68
1743983	LT16NR16STACME KC5025	D73
1743984	LT16NR14STACME KC5025	D73
1743985	LT16NR12STACME KC5025	D73
1743986	LT16NR10STACME KC5025	D73
1743987	LT16NR8STACME KC5025	D73
1743988	LT16NR6STACME KC5025	D73
1743991	LT16NR2TR KC5025	D73

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
1743992	LT16NR3TR KC5025	D73
1743993	LT22NR4TR KC5025	D73
1743994	LT22NR5TR KC5025	D73
1743996	LT16NR8RD KC5025	D73
1743997	LT22NR6RD KC5025	D73
1743998	LT16NR10APIRD KC5025	D69
1743999	LT16NR8APIRD KC5025	D69
1744000	LT22NR4API382 KC5025	D68
1744002	LT22NR5API403 KC5025	D68
1744003	LT22NR4API502 KC5025	D68
1744005	LT22NR5BUT75 KC5025	D69
1744006	LT22NR5BUT1 KC5025	D69
1744444	KUAM33	B119, B141, C171, D41–42
1744665	NG3094R KC5010	C154
1746442	CTFPR12CA16	B378
1747635	DCGT070202HP KC5010	B206
1748698	NG3062RK KC5010	C146
1749102	KSEM321R3WD50M	H60
1749103	KSEM330R3WD50M	H60
1749106	KSEM340R3WD50M	H60
1749109	KSEM350R3WD50M	H60
1749110	KSEM360R3WD50M	H60
1749131	KSEM361R3WD50M	H60
1749132	KSEM370R3WD50M	H60
1749133	KSEM380R3WD50M	H60
1749207	CV50RMHTS27M394	J79
1749208	CV50RMHTS32M394	J79
1749210	CV50RMHTS40M413	J79
1749263	CV50BHTS13M295	J79
1749264	CV50BHTS16M295	J79
1749266	CV50BHTS22M295	J79
1749273	CV50RMHTS50M413	J79
1749281	BT50BHTS22075M	J80
1749285	BT50BHTS32080M	J80
1749286	BT50BHTS40080M	J80
1749287	BT50BHTS50080M	J80
1749428	CV50BHTS27M295	J79
1749429	CV50BHTS32M314	J79
1749430	CV50BHTS40M314	J79
1749461	CV50BHTS50M314	J79
1749491	CV50RMHTS13M394	J79
1749492	CV50RMHTS16M394	J79
1749493	CV50RMHTS22M394	J79
1749607	KSEM390R3WD50M	H60
1749610	KSEM400R3WD50M	H60
1749648	DFR020204GD KC7140	J84
1749718	420.060	S68, S143–147
1750433	B411A07700 KF1	G100
1752626	420.200	S10, S14, S17, S21, S25, S32, S34, S48, S53, S68, S72, S76, S79, S82, S102–103, S132, S143–144, S146, T17, T50, T72
1752628	420.100	S72, S76, S102–103, S143–144, S146
1752629	420.120	S68, S76, S79, S82, S102–103, S143–144, S146–147
1752630	420.160	S32, S34, S68, S72, S76, S79, S82, S143–144, S146
1753934	B411A08700 KF1	G100
1754251	DFR165R2WD32M	J10
1757331	63A04RP90BG15C1WPM	S144
1758493	50A03RP90BG15CPM	S144
1758495	80A05RP90BG15C1WPM	S144
1758496	100B06RP90BG15C2WPM	S144
1758497	125B08RP90BG15C2WPM	S144
1758498	160C10RP90BG15C2WPM	S144
1758499	200C12RP90BG15C3WPM	S144
1758500	250C16RP90BG15C4WPM	S144
1758572	80A06RP90BG15C2WPM	S144
1758573	100B08RP90BG15C2WPM	S144
1758574	125B10RP90BG15C2WPM	S144
1758580	50A03R049A32PBG15S3WHPM	S145
1758592	63A04RP90BG15C4WHPM	S146
1758593	80A05RP90BG15C5WHPM	S146
1762261	B411A05600 KF1	G100
1762299	NG3062LK KC5010	C148
1762369	100B06RP90BG15C6WHPM	S146
1762370	125B08RP90BG15C8WHPM	S146
1762381	NG3125RK KC5010	C147
1762451	160C10RP90BG15C10WHPM	S146
1763116	HSK63ASVS4B139M	K80
1763118	HSK63ASVS5B139M	K80
1763375	KM50SVS4B125M	K80
1763376	KM63SVS4B110M	K80
1763378	KM50SVS5B125M	K80
1763379	KM63SVS5B110M	K80
1763382	KM80SVS6B150M	K80
1764146	NG4250LK KC5010	C148
1764148	NG4250LK KC5025	C148
1764575	NTP3L KC5010	D24
1764576	NTP3L KC5025	D24
1765641	NTC3R8E KC5010	D22
1765732	NTC3R8E KC5025	D22
1765733	NTC3R12E KC5010	D22
1765734	NTC3R12E KC5025	D22
1770917	NT3LCK KC5010	D21
1771602	NG3125RK KT315	C147
1772152	SCLCRF0808M06Q	B181
1772157	SDJCRF0808M07Q	B211
1772159	SDACR1212M11Q	B209
1772160	SDACL1212M11Q	B209
1772173	SDPCN1212M11Q	B212
1772197	STJCRF1212M11Q	B248
1772198	STJCLF1212M11Q	B248
1772222	D25MTTB400	B386
1772223	D32MTTB447	B386
1772224	D40MTTB530	B386
1772230	D50MTTB700	B386
1772253	H32SCLCR09	B183
1772255	H25SDUCR11	B213
1772256	H25SDUCL11	B213
1772257	H32SDUCR11	B213
1772258	H32SDUCL11	B213
1772747	KSEM125R5WN16M	H59
1772748	KSEM140R5WN16M	H59
1772749	KSEM150R5WN20M	H59
1773924	360.637	I26
1774499	KSEM125R3WN16M	H59
1775033	NG3125RK KC5025	C147
1775034	NG3125LK KC5010	C148
1775035	NG3125LK KC5025	C148
1775036	NG3047RK KC5025	C146
1775037	NG3062RK KC5025	C146
1775478	CM72LP	C166, C168–169, C171, D28–30, D36, D41–42
1775479	CM73LP	C166, C168–169, D28–30, D36
1777658	100B08RP90SP15C2WFP	S82
1777661	100B09RP70SP15C2WFP	S79
1777860	CNMG120408MP KC5025	B51
1779401	193.337	S145–146
1781755	TK01338D	E54
1781756	TK01339D	E54
1782505	VCGR160402 KC5410	E34
1782709	50A03R060S63PBG15S3WHSM	S147
1782711	80A05R090S63PBG15S5WHSM	S147
1782830	VPGP443K KC5410	B144
1782831	TPGT090204LF KC5410	B254
1782896	RCMT120400 KC5010	B224
1782902	CNMG120404FW KT315	B49
1783133	CNMG120408FW KT315	B49
1783134	CNMG120412FW KT315	B49
1783135	DNMG110404FW KT315	B78
1783136	DNMG110408FW KT315	B78
1783137	DNMG150404FW KT315	B78
1783138	DNMG150408FW KT315	B78
1783141	WNMG060404FW KT315	B156
1783142	WNMG060408FW KT315	B156
1783143	WNMG080404FW KT315	B156
1783144	WNMG080408FW KT315	B156
1783152	CNMG120404FW KC5010	B49
1783233	CNMG120408FW KC5010	B49
1783234	CNMG120412FW KC5010	B49
1783237	DNMG150404FW KC5010	B78
1783273	WNMG060408FW KC5010	B156
1783275	WNMG080408FW KC5010	B156
1784381	SHVBR0635M	S147
1785086	NG2M300RK KC5025	C146
1785474	DCGT070204HP KC5010	B206
1785475	DCGT070208HP KC5010	B206
1785477	CCGT060208HP KC5010	B175
1785478	CPGT060208HP KC5010	B188
1785479	CCGT09T308HP KC5010	B175
1785480	CPGT09T308HP KC5010	B188
1785481	TCGT110208HP KC5010	B243
1785482	TPGT110208HP KC5010	B254
1785501	NG2M300LK KC5025	C148
1785713	VBGT160404HP KC5010	B264
1785714	VBGT160408HP KC5010	B264
1785715	CNGP120401 KC5410	B46
1785716	CNGP120402 KC5410	B46
1785717	CNGP120404 KC5410	B46
1785718	CNGP120408 KC5410	B46
1785719	CNGP120412 KC5410	B46
1785733	DNGP150404 KC5410	B74
1785734	DNGP150408 KC5410	B74
1785735	DNGP150604 KC5410	B74
1785740	TNGP160404 KC5410	B122
1785741	TNGP160408 KC5410	B122
1785746	VNGP160401 KC5410	B143
1785747	VNGP160402 KC5410	B143
1785748	CPGT060202HP KC5410	B188
1785749	CPGT060204HP KC5410	B188
1785750	CPGT060208HP KC5410	B188
1785752	CPGT09T308HP KC5410	B188
1785753	DCGT070208HP KC5410	B206
1785756	TPGT110208HP KC5410	B254
1787513	WNGX080712T02020 KY3500	B298
1791528	410.084	E17–18, S79, S82
1792258	KSEM125R1WN16M	H58
1792259	KSEM136R1WN16M	H58
1792260	KSEM146R1WN20M	H58
1792262	KSEM130R3WN16M	H59
1792293	KSEM135R3WN16M	H59
1792294	KSEM136R3WN16M	H59
1792295	KSEM140R3WN16M	H59
1792296	KSEM145R3WN20M	H59
1792297	KSEM146R3WN20M	H59
1792298	KSEM150R3WN20M	H59
1792299	KSEM155R3WN20M	H59
1792301	KSEM130R5WN16M	H59
1792302	KSEM136R5WN16M	H59
1792323	KSEM135R5WN16M	H59
1792325	KSEM145R5WN20M	H59
1792326	KSEM146R5WN20M	H59
1792328	KSEM155R5WN20M	H59
1792632	NR3047RK KC5010	C150
1792683	NR3047RK KC5025	C150
1792684	NR3062RK KC5010	C150
1792685	NR3062RK KC5025	C150
1793315	NG3110R KC5025	C154
1794406	NG3M225RK KC5025	C146
1794630	BGHX15L5PCFRGG K110M	S148
1794631	BGHX15L5PCFRGG KC510M	S148
1794653	BGHX15L5PCTRGG K110M	S148
1794655	BGHX15L5PCTRGG KC510M	S148
1794656	BGHX15L5PCFRGG1W K110M	S149
1794657	BGHX15L5PCFRGG1W KC510M	S149
1794659	BGHX15L5PCTRGG1W K110M	S149
1794660	BGHX15L5PCTRGG1W KC510M	S149
1795217	80A05RP90SP15C1WFP	S82
1795286	160C10RP90SP15C2WFP	S82
1795288	200C12RP90SP15C2WFP	S82
1795485	BGHX15L5PCERGGT KD1410	S148
1795486	BGHX15L5PCERGGT KD1415	S148
1795785	NT2RK KC5025	D24
1795786	NT2LK KC5025	D24
1795787	NT3RK KC5025	D24
1795788	NT3LK KC5025	D24
1795789	NT4RK KC5025	D24
1795790	NT4LK KC5025	D24
1795791	NTF2R KC5025	D23
1795792	NTF2L KC5025	D23
1795793	NTF3R KC5025	D23
1795794	NTF3L KC5025	D23
1795795	NTK2R KC5025	D23
1795796	NTK2L KC5025	D23
1795797	NJP3014R12 KC5025	D18
1795799	NJP3010R16 KC5025	D18
1795800	NJP3010L16 KC5025	D18
1795801	NA3R4 KC5025	D12
1795802	NA3L4 KC5025	D12
1795809	364.016	H58–59, H61, H63, H98
1795810	364.017	H58–59, H61, H63
1795811	170.289	H58, H65
1795956	170.290	H65
1795960	170.291	H65
1796047	NT2L KC5010	D19
1796048	NT2L KC5025	D19
1796049	NT2R KC5010	D19
1796050	NT2R KC5025	D19
1796051	NT3R KC5010	D19
1796052	NT3R KC5025	D19
1796083	NT3L KC5010	D19
1796084	NT3L KC5025	D19
1796085	NT4L KC5010	D19
1796086	NT4L KC5025	D19
1796087	NT4R KC5010	D19
1796088	NT4R KC5025	D19
1796090	NTP2R KC5010	D24
1796091	NTP2R KC5025	D24
1796103	NTP2L KC5010	D24
1796104	NTP2L KC5025	D24
1796105	NTP3R KC5010	D24
1796106	NTP3R KC5025	D24
1796107	NTP3R KC5410	D24
1796109	NTP4R KC5010	D24
1796110	NTP4R KC5025	D24
1796112	NTP4L KC5010	D24
1796113	NTP4L KC5025	D24
1796115	NT2RK KC5010	D24
1796116	NT2LK KC5010	D24
1796117	NT3RK KC5010	D24
1796118	NT3LK KC5010	D24
1796119	NT4RK KC5010	D24
1796120	NT4LK KC5010	D24
1796121	NT3RCK KC5010	D21
1796122	NT3RCK KC5025	D21
1796133	NT3LCK KC5025	D21
1796134	NT4RCK KC5010	D21
1796135	NT4RCK KC5025	D21
1796137	NT4LCK KC5025	D21
1796138	NTF2R KC5010	D23
1796139	NTF2L KC5010	D23
1796140	NTF3R KC5010	D23
1796141	NTF3L KC5010	D23
1796153	NTF4R KC5025	D23
1796156	NTK2R KC5010	D23
1796157	NTK2L KC5010	D23
1796158	NTK3R KC5010	D23
1796159	NTK3R KC5025	D23
1796160	NTK3L KC5010	D23
1796161	NTK3L KC5025	D23
1796176	NJP3020R8 KC5010	D18
1796177	NJP3020R8 KC5025	D18
1796179	NJP3020L8 KC5025	D18
1796180	NJP3014R12 KC5010	D18
1796181	NJP3014L12 KC5010	D18
1796182	NJP3010R16 KC5010	D18
1796194	NJF3012R14 KC5010	D17
1796195	NJF3012R14 KC5025	D17
1796198	NJF3010R16 KC5010	D17
1796199	NJF3010R16 KC5025	D17
1796200	NJF3010L16 KC5010	D17
1796202	NJF3009R18 KC5010	D17
1796203	NJF3009R18 KC5025	D17
1796331	NJF3008R20 KC5010	D17
1796332	NJF3008R20 KC5025	D17
1796393	NJF3008L20 KC5010	D17
1796395	NJF3007R24 KC5010	D17
1796396	NJF3007R24 KC5025	D17
1796397	NJF3007L24 KC5010	D17
1796399	NJF3006R28 KC5010	D17
1796400	NJF3006R28 KC5025	D17
1796403	NJF3005R32 KC5010	D17
1796407	NJK3012R14 KC5010	D18
1796408	NJK3012R14 KC5025	D18
1796411	NJK3010R16 KC5010	D18
1796412	NJK3010R16 KC5025	D18
1796425	NJK3009R18 KC5010	D18
1796426	NJK3009R18 KC5025	D18

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
1796429	NJK3008R20 KC5010	D18
1796430	NJK3008R20 KC5025	D18
1796443	NJK3007R24 KC5010	D18
1796446	NJK3007R24 KC5025	D18
1796449	NJK3006R28 KC5010	D18
1796452	NJK3006L28 KC5025	D18
1796473	NJK3005R32 KC5010	D18
1796474	NJK3005R32 KC5025	D18
1796476	NJK3005L32 KC5025	D18
1796497	NA3R12 KC5025	D12
1796499	NA3L12 KC5010	D12
1796500	NA3L12 KC5025	D12
1796501	NA3R10 KC5010	D12
1796502	NA3R10 KC5025	D12
1796504	NA3L10 KC5025	D12
1796505	NA3R8 KC5010	D12
1796506	NA3R8 KC5025	D12
1796507	NA3L8 KC5010	D12
1796508	NA3L8 KC5025	D12
1796509	NA3R6 KC5010	D12
1796510	NA3R6 KC5025	D12
1796511	NA3L6 KC5010	D12
1796512	NA3L6 KC5025	D12
1796514	NA3R5 KC5010	D12
1796515	NA3R5 KC5025	D12
1796516	NA3L5 KC5010	D12
1796517	NA3L5 KC5025	D12
1796518	NA3R4 KC5010	D12
1796519	NA3L4 KC5010	D12
1796520	NAS3R16 KC5025	D13
1796524	NAS3R12 KC5025	D13
1796525	NAS3L12 KC5025	D13
1796526	NAS3R10 KC5010	D13
1796527	NAS3R10 KC5025	D13
1796529	NAS3L10 KC5025	D13
1796530	NAS3R8 KC5010	D13
1796531	NAS3R8 KC5025	D13
1796532	NAS3L8 KC5010	D13
1796543	NAS3L8 KC5025	D13
1796544	NAS3R6 KC5010	D13
1796545	NAS3R6 KC5025	D13
1796546	NAS3L6 KC5010	D13
1796547	NAS3L6 KC5025	D13
1796549	NAS3R5 KC5025	D13
1796551	NAS3L5 KC5025	D13
1796552	NJ3020R8 KC5010	D17
1796553	NJ3020R8 KC5025	D17
1796555	NJ3020L8 KC5025	D17
1796556	NJ3014R12 KC5010	D17
1796557	NJ3014R12 KC5025	D17
1796558	NJ3014L12 KC5010	D17
1796559	NJ3014L12 KC5025	D17
1796561	NJ3010R16 KC5025	D17
1796583	NJ3010L16 KC5025	D17
1796705	470.232	S10, S14, S17, S21, S25, S32, S34, S48, S53, S68, S72, S76, S79, S82, S102–103, S143–144, S146, T50, T72
1796707	470.233	S17, S21, S25, S32, S34, S48, S53, S68, S72, S76, S79, S82, S102–103, S143–144, S146, T17, T50, T72
1796708	470.234	S21, S25, S34, S68, S72, S76, S79, S82, S102, S144, S146
1796709	470.235	S21, S25, S34, S68, S144
1796710	470.236	S21, S25
1797157	KSEM125R7WN16M	H61
1797158	KSEM130R7WN16M	H61
1797159	KSEM135R7WN16M	H61
1797160	KSEM136R7WN16M	H61
1797161	KSEM140R7WN16M	H61
1797162	KSEM145R7WN20M	H61
1797183	40A02RP90BG15CPM	S144
1797203	KSEM146R7WN20M	H61
1797204	KSEM150R7WN20M	H61
1797205	KSEM155R7WN20M	H61
1797206	KSEM125R10WN16M	H61
1797207	KSEM130R10WN16M	H61
1797208	KSEM135R10WN16M	H61
1797209	KSEM136R10WN16M	H61
1797210	KSEM140R10WN16M	H61
1797211	KSEM145R10WN20M	H61
1797212	KSEM146R10WN20M	H61
1797233	KSEM150R10WN20M	H61
1797234	KSEM155R10WN20M	H61
1797235	SCFPR10CA09	B199
1798199	160C10RP70SP15C2WFP	S79
1798200	200C12RP70SP15C2WFP	S79
1798604	80A06RP90SP15C1WFP	S82
1798605	125B10RP90SP15C2WFP	S82
1798920	A1010LSER11	D81
1798921	A1616LSER16	D81
1798922	A4040LSER22	D81
1798962	DFR170R3WD32M	J11
1798979	A1010LSEL11	D81
1798980	A1616LSEL16	D81
1799053	DFR180R3WD32M	J11
1799055	DFR200R3WD32M	J11
1799056	DFR210R3WD25M	J11
1799059	DFR220R3WD25M	J11
1799093	A4040LSEL22	D81
1799238	NT1L KC5010	D25
1799239	NT1L KC5025	D25
1799241	NTC3R7E KC5025	D22
1799363	NTC3L8E KC5010	D22
1799366	NTC3L8I KC5025	D20
1799369	NTC3R10E KC5010	D22
1799370	NTC3R10E KC5025	D22
1799384	NTC3L10I KC5025	D20
1799386	NTC3R11E KC5025	D22
1799389	NTC3R12I KC5025	D20
1799390	NTC3L12I KC5025	D20
1799391	NTC3R13E KC5010	D22
1799392	NTC3R13E KC5025	D22
1799393	NTC3R14E KC5010	D22
1799394	NTC3R14E KC5025	D22
1799398	NTC3L14I KC5025	D20
1799399	NTC3R16E KC5010	D22
1799400	NTC3R16E KC5025	D22
1799404	NTC3L16I KC5025	D20
1799405	NTC3R18E KC5010	D22
1799406	NTC3R18E KC5025	D22
1799409	NTC3R20E KC5010	D22
1799410	NTC3R20E KC5025	D22
1799413	NTC3R24E KC5010	D22
1799414	NTC3R24E KC5025	D22
1799416	NTC3R28E KC5025	D22
1799418	NTC3R32E KC5025	D22
1799439	NA4R6 KC5025	D12
1799441	NA4L6 KC5025	D12
1799443	NA4R5 KC5025	D12
1799445	NA4L5 KC5025	D12
1799446	NA4R4 KC5010	D12
1799447	NA4R4 KC5025	D12
1799449	NA4L4 KC5025	D12
1799450	NA6R2 KC5010	D12
1799451	NA6R2 KC5025	D12
1799452	NA6L2 KC5010	D12
1799463	NA6L2 KC5025	D12
1799465	NA6R25 KC5025	D12
1799469	NA6R3 KC5025	D12
1799471	NA6L3 KC5025	D12
1799483	NDC38VR75 KC5010	D16
1799484	NDC38VL75 KC5010	D16
1799485	NDC3115VR75 KC5010	D16
1799486	NDC3115VL75 KC5010	D16
1799490	NDC88VR75M KC5010	D16
1799491	NDC88VL75M KC5010	D16
1799497	NTU4R KC5025	D24
1799500	NWC3R11E KC5010	D25
1799501	NWC3R11E KC5025	D25
1799502	NWC3L11I KC5025	D25
1799503	NWC3R14E KC5010	D25
1799507	ND3040R KC5025	D14
1799511	ND3038R KC5025	D14
1799513	ND3038L KC5025	D14
1799521	NDC3040R3 KC5025	D14
1799522	NDC3040L3 KC5010	D14
1799525	NDC4038R2 KC5025	D14
1799527	NDC4038L2 KC5025	D14
1799529	NDC4040R3 KC5025	D14
1799553	NDC4050R2 KC5025	D14
1799555	NDC4050L2 KC5025	D14
1799557	NDC4050R3 KC5025	D14
1799560	NDC38RDR75 KC5010	D15
1799561	NDC38RDR75 KC5025	D15
1799562	NDC38RDL75 KC5010	D15
1799563	NDC38RDL75 KC5025	D15
1799565	NDC310RDR75 KC5025	D15
1799567	NDC310RDL75 KC5025	D15
1799576	NTB3RA KC5025	D19
1799577	NTB3LA KC5010	D19
1799578	NTB3LA KC5025	D19
1799583	NTB2RB KC5010	D20
1799585	NTB2LB KC5010	D20
1799587	NTB3RB KC5010	D20
1799588	NTB3RB KC5025	D20
1799589	NTB3LB KC5010	D20
1799591	NTB3LB KC5025	D20
1799603	NTB4RB KC5010	D20
1799604	NTB4RB KC5025	D20
1799605	NTB4LB KC5010	D20
1799606	NTB4LB KC5025	D20
1799693	DFR190R2WD32M	J10
1799695	DFR220R3WD32M	J11
1800067	BGHX15L5PCERGGT1W KD1415	S149
1801017	NG3M400LK KC5025	C148
1801125	3.41020R900STF CS5	I16
1801126	3.41220R900STF CS5	I16
1801129	3.41220R900SF KMF	I16
1801779	NR3031R KC5010	C158
1801793	NG3047R KC5010	C154
1802547	CCMT09T304MW KT315	B178
1802549	CCMT09T308MW KT315	B178
1802551	WNGG080408LF KC5010	B154
1802564	CCMT09T304MW KC5010	B178
1802566	CCMT09T308MW KC5010	B178
1802567	CPMT09T308MW KC5010	B191
1802568	CCMT120404MW KC5010	B178
1802569	CCMT120408MW KC5010	B178
1802594	80A07RP70SP15C1WFP	S79
1802595	125B12RP70SP15C2WFP	S79
1802596	160C16RP70SP15C4WFP	S79
1802810	SPHX15T6PCERGP KCK15	S83
1802813	CCMT060202FW KT315	B176
1802843	CPMT060202FW KT315	B189
1802844	CCMT060204FW KT315	B176
1802845	CPMT060204FW KT315	B189
1802846	CCMT060208FW KT315	B176
1802886	SPHX15T6PCERGP4S KCK15	S83
1802893	SPHX15T6PCFRGN1W KCK15	S84
1802971	CPMT060208FW KT315	B189
1802983	CCMT09T304FW KT315	B176
1802984	CPMT09T304FW KT315	B189
1802986	CCMT09T308FW KT315	B176
1802991	CPMT09T308FW KT315	B189
1802992	CCMT060202FW KC5010	B176
1803013	CPMT060202FW KC5010	B189
1803014	CCMT060204FW KC5010	B176
1803015	CPMT060204FW KC5010	B189
1803016	CCMT060208FW KC5010	B176
1803018	CPMT060208FW KC5010	B189
1803020	CCMT09T304FW KC5010	B176
1803021	CPMT09T304FW KC5010	B189
1803022	CCMT09T308FW KC5010	B176
1803023	CPMT09T308FW KC5010	B189
1803284	NTC3MR150E KC5010	D21
1803285	NTC3MR150E KC5025	D21
1803292	NTC3MR200E KC5010	D21
1803924	NG2062L KC5025	C155
1803995	H50LSER16	D82
1803997	H40LSER22	D82
1803999	H50LSER22	D82
1804265	SPHX1205ZCELGP KC520M	S73
1804638	NG2062L KC5010	C155
1804784	DFT05T308HP KMF	J87
1804785	DFT06T308HP KMF	J87
1804790	DFT070408HP KMF	J87
1804791	DFT090508HP KMF	J87
1804829	DFT05T308HP KC7140	J87
1804830	DFT06T308HP KC7140	J87
1804832	DFT070408HP KC7140	J87
1805013	DFT090508HP KC7140	J87
1805750	F3AA0300AWS45 K600	P121
1805808	F3BA0600BWS40 K600	P123
1805825	F3BA0800BWM40C160 K600	P124
1805929	F3AA0400AWS45 K600	P121
1805930	F3AA0500AWS45 K600	P121
1805931	F3AA0600AWS45 K600	P121
1805932	F3AA0800AWM45 K600	P121
1805983	F3AA1000AWL45 K600	P121
1805984	F3AA1200AWL45 K600	P121
1805985	F3AA1400AWL45 K600	P121
1805986	F3AA1600AWL45 K600	P121
1805987	F3AA1800AWL45 K600	P121
1805988	F3AA2000AWX45 K600	P121
1806435	DFR030204GD KC7140	J84
1806437	DFR040304GD KC7140	J84
1807047	F3BA0800BWM40 K600	P123
1807048	F3BA1000BWM40 K600	P123
1807049	F3BA1200BWL40 K600	P123
1807050	F3BA1600BWL40 K600	P123
1807051	F3BA2000BWX40 K600	P123
1807052	F3BA2500BWX40 K600	P123
1807220	CCGT09T304LF KC5410	B175
1807346	F3BA1000BWM40C220 K600	P124
1807347	F3BA1200BWL40C260 K600	P124
1807348	F3BA1600BWL40C320 K600	P124
1807349	F3BA2000BWX40C380 K600	P124
1807350	F3BA2500BWX40C450 K600	P124
1808487	NG2031RK KC5010	C146
1808488	NG4189RK KC5010	C147
1808491	NR3047LK KC5025	C150
1808583	NGD3125RK KC5025	C149
1809057	HSK100AHTS40085M	J81
1809059	HSK100AHTS50090M	J81
1810334	DFR170R2WD32M	J10
1810335	DFR175R2WD32M	J10
1810336	DFR180R2WD32M	J10
1810337	DFR185R2WD32M	J10
1810338	DFR195R2WD32M	J10
1810339	DFR200R2WD32M	J10
1810340	DFR205R2WD32M	J10
1810341	DFR210R2WD32M	J10
1810342	DFR220R2WD32M	J10
1810363	DFR230R2WD32M	J10
1810364	DFR240R2WD32M	J10
1810365	DFR165R3WD32M	J11
1810366	DFR175R3WD32M	J11
1810367	DFR185R3WD32M	J11
1810368	DFR190R3WD32M	J11
1810369	DFR195R3WD32M	J11
1810370	DFR205R3WD32M	J11
1810371	DFR210R3WD32M	J11
1810372	DFR230R3WD32M	J11
1810373	DFR240R3WD32M	J11
1816891	LT11NR14UNJ KC5025	D75
1816983	LT11NR16UNJ KC5025	D75
1816990	LT11NR18UNJ KC5025	D75
1817050	LT16NR16UNJ KC5025	D75
1817054	LT16NR12UNJ KC5025	D75
1817487	LT22ER5API403 KC5010	D55
1817512	LT22ER4API502 KC5010	D55
1817533	LT22ER4API503 KC5010	D55
1817570	NF3125LK KC5025	C159
1817571	NF3125RK KC5025	C159
1817572	CNMG120404FP KC5010	B49
1817588	NFD3125LK KC5025	C160
1817614	CNMG120408FP KC5010	B49
1817616	DNMG110404FP KC5010	B77
1817617	DNMG110408FP KC5010	B77
1817618	NG3189RK KC5025	C147
1817619	NG3M100LK KC5025	C148
1817620	NG3M100RK KC5025	C146
1817623	NG3M120LK KC5025	C148
1817626	NG3M120RK KC5025	C146
1817627	NG3M150LK KC5025	C148
1817629	NG3M150RK KC5025	C146
1817630	NG3M175LK KC5025	C148
1817631	NG3M175RK KC5025	C146
1817632	NG3M200LK KC5025	C148
1817635	NG3M200RK KC5025	C146
1817636	NG3M220LK KC5025	C148
1817637	NG3M220RK KC5025	C146
1817640	NG3M225RK KC5010	C146
1817658	NFD3125RK KC5025	C160

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
1817659	NFD3125RKI KC5025	C160
1817662	NFD4189LK KC5025	C160
1817667	420.080	S143–144
1817675	NG3M250LK KC5025	C148
1817676	NG3M250RK KC5025	C146
1817678	NG3M275LK KC5025	C148
1817679	NG3M275RK KC5010	C147
1817680	NG3M275RK KC5025	C147
1817681	NG3M300LK KC5010	C148
1817682	NG3M300LK KC5025	C148
1817699	NG1047L KC5025	C155
1817700	NG1062L KC5025	C155
1817702	NG1094L KC5025	C155
1817703	NG3M300RK KC5010	C147
1817704	NG3M300RK KC5025	C147
1817705	NG3M320LK KC5025	C148
1817706	NG3M320RK KC5025	C147
1817707	NG3M325LK KC5025	C148
1817708	NG3M325RK KC5025	C147
1817709	NG3M350LK KC5025	C148
1817710	NG3M350RK KC5025	C147
1817713	NG2031LK KC5010	C147
1817718	NG2031LK KC5025	C147
1817719	NG2031RK KC5025	C146
1817720	NG2041L KC5025	C155
1817721	NG2041R KC5025	C154
1817722	NG2047LK KC5010	C147
1817740	NG3M400RK KC5010	C147
1817741	NG3M400RK KC5025	C147
1817965	NG3M425RK KC5025	C147
1817970	NG4125RK KC5010	C147
1817972	NG4189LK KC5010	C148
1817975	NG2047LK KC5025	C147
1817977	NG2047RK KC5010	C146
1817979	NG2047RK KC5025	C146
1817993	NG4189LK KC5025	C148
1817994	NG4189RK KC5025	C147
1818000	NG4250RK KC5010	C147
1818001	NG4250RK KC5025	C147
1818003	NG2058R KC5025	C154
1818005	NG2062LK KC5010	C147
1818006	NG2062LK KC5025	C147
1818007	NG2062RK KC5010	C146
1818008	NG2062RK KC5025	C146
1818009	NG2094LK KC5010	C147
1818010	NG2094LK KC5025	C147
1818011	NG2094RK KC5010	C146
1818037	NG2094RK KC5025	C146
1818039	NG2125LK KC5010	C148
1818041	NG2125LK KC5025	C148
1818042	NG2125RK KC5010	C146
1818050	NG4M400RK KC5010	C147
1818051	NG4M400RK KC5025	C147
1818052	NG4M450LK KC5025	C148
1818054	NG4M500LK KC5010	C148
1818073	NG2125RK KC5025	C146
1818075	NG2M080LK KC5025	C147
1818077	NG2M080RK KC5025	C146
1818078	NG2M100LK KC5010	C147
1818079	NG2M100LK KC5025	C147
1818080	NG2M100RK KC5010	C146
1818081	NG2M100RK KC5025	C146
1818082	NG2M120LK KC5010	C147
1818093	NG2M120LK KC5025	C147
1818094	NG2M120RK KC5010	C146
1818095	NG2M120RK KC5025	C146
1818097	NG2M140LK KC5025	C147
1818098	NG2M140RK KC5010	C146
1818099	NG2M140RK KC5025	C146
1818110	NGD3062LK KC5010	C149
1818111	NGD3062LK KC5025	C149
1818112	NGD3062RK KC5010	C149
1818113	NGD3062RK KC5025	C149
1818114	NGD3094LK KC5010	C149
1818115	NGD3094LK KC5025	C149
1818116	NGD3094RK KC5010	C149
1818117	NGD3094RK KC5025	C149
1818118	NGD3125LK KC5010	C149
1818119	NGD3125LK KC5025	C149
1818120	NGD3125RK KC5010	C149
1818121	NGD3189LK KC5010	C149
1818122	NGD3189LK KC5025	C149
1818262	NGD3189RK KC5010	C149
1818352	NPD3012RK KC5010	C151
1818353	NGD3189RK KC5025	C149
1818354	NGD4125LK KC5010	C149
1818355	NGD4125LK KC5025	C149
1818356	NGD4125RK KC5010	C149
1818357	NGD4125RK KC5025	C149
1818359	NGD4189LK KC5010	C149
1818360	NGD4189LK KC5025	C149
1818361	NGD4189RK KC5010	C149
1818362	NGD4189RK KC5025	C149
1818366	NG2M300RK KC5010	C146
1818368	NG2M325RK KC5025	C146
1818369	NG3047LK KC5010	C148
1818370	NG3047LK KC5025	C148
1818371	NG3062LK KC5025	C148
1818372	NG3072LK KC5010	C148
1818374	NGD4250LK KC5025	C149
1818375	NGD4250RK KC5010	C149
1818376	NGD4250RK KC5025	C149
1818425	NR2031L KC5025	C158
1818426	NR2031R KC5025	C158
1818434	NP2002RK KC5010	C151
1818435	NP2002RK KC5025	C151
1818437	NP3002RK KC5010	C151
1818439	NP3012RK KC5025	C151
1818440	NPD2002RK KC5010	C151
1818444	NRD4125L KC5025	C159
1818455	NG2M170LK KC5010	C147
1818456	NG2M170LK KC5025	C147
1818457	NG2M170RK KC5010	C146
1818458	NR3031LK KC5010	C150
1818459	NR3031LK KC5025	C150
1818460	NR3031RK KC5010	C150
1818461	NG2M170RK KC5025	C146
1818462	NR3031RK KC5025	C150
1818473	NR3047LK KC5010	C150
1818474	NG2M175LK KC5025	C147
1818476	NG2M195LK KC5010	C147
1818478	NR3062LK KC5010	C150
1818479	NG2M195RK KC5010	C146
1818480	NG2M195RK KC5025	C146
1818481	NR3062LK KC5025	C150
1818482	NG2M200LK KC5010	C147
1818483	NG2M200LK KC5025	C147
1818484	NG2M200RK KC5010	C146
1818485	NG2M200RK KC5025	C146
1818487	NG2M220RK KC5025	C146
1818489	NG2M225LK KC5025	C147
1818491	NG2M225RK KC5025	C146
1818492	NG2M250LK KC5025	C147
1818493	NG2M250RK KC5025	C146
1818494	NG2M275LK KC5010	C147
1818497	NG2M275RK KC5025	C146
1818498	NG2M300LK KC5010	C148
1818503	NG3072LK KC5025	C148
1818504	NG3072RK KC5010	C146
1818505	NG3072RK KC5025	C146
1818506	NG3078LK KC5010	C148
1818507	NG3078LK KC5025	C148
1818508	NG3078RK KC5010	C146
1818509	NG3078RK KC5025	C146
1818714	SPHX15T6ZCERGP KCK15	S80
1818721	SPHX15T6ZCTRGPK KY3500	S80
1818755	SPHX15T6ZCERGP4S KCK15	S80
1818766	NG3094LK KC5010	C148
1818768	NG3094LK KC5025	C148
1818769	NG3094RK KC5025	C146
1818824	NG3105R KC5025	C154
1818825	NG3110L KC5025	C155
1818827	NR3078LK KC5010	C150
1818828	NR3078LK KC5025	C150
1818829	NR3078RK KC5010	C150
1818831	NR3094L KC5010	C158
1818833	NR3094L KC5025	C158
1818834	NR3094R KC5010	C158
1818835	NR3094R KC5025	C158
1818836	NR4062LK KC5010	C150
1818838	NR4062RK KC5010	C150
1818840	NR4094LK KC5010	C150
1818841	NR4094LK KC5025	C150
1818842	NR4094RK KC5010	C150
1818854	NR4125LK KC5010	C150
1818856	NR4125RK KC5010	C150
1818857	NR4125RK KC5025	C150
1818858	NRD3031L KC5010	C159
1818859	NRD3031L KC5025	C159
1818860	NRD3031R KC5010	C159
1818861	NRD3031R KC5025	C159
1818862	NRD3062L KC5010	C159
1818863	NRD3062L KC5025	C159
1818864	NRD3062R KC5010	C159
1818865	NRD3062R KC5025	C159
1818866	NRD4062L KC5025	C159
1818874	NU3094L KC5025	C161
1818875	NU3094R KC5025	C161
1818876	NU3125L KC5025	C161
1818878	NU3156L KC5025	C161
1818891	NG3156LK KC5010	C148
1818892	NG3156LK KC5025	C148
1818913	NG3156RK KC5010	C147
1818914	NG3156RK KC5025	C147
1818916	NG3178R KC5025	C154
1818917	NG3185L KC5025	C155
1818919	NG3189LK KC5010	C148
1818920	NG3189LK KC5025	C148
1818921	NG3189RK KC5010	C147
1819108	SPHX15T6ZCTRGP4SK KY3500	S80
1819110	SPHX15T6ZCFRGN1W KCK15	S81
1819168	SPHX15T6PCTRGPK KY3500	S83
1819171	SPHX15T6PCFRGN1WK KY3500	S84
1819206	CNMG120404FP KT315	B49
1819207	CNMG120408FP KT315	B49
1819211	DNMG110408FP KT315	B77
1819335	DNMG150404FP KT315	B77
1819336	DNMG150408FP KT315	B77
1819340	DNMG150612FP KT315	B77
1819354	TNMG160404FP KT315	B124
1819355	TNMG160408FP KT315	B124
1819357	VNMG160404FP KT315	B145
1819358	VNMG160408FP KT315	B145
1819440	DNMG150404FP KC5010	B77
1819441	DNMG150408FP KC5010	B77
1819451	SPHX1205PCTRGPB KTPK20	S77
1819494	DNMG150604FP KC5010	B77
1819495	DNMG150608FP KC5010	B77
1819500	TNMG160404FP KC5010	B124
1819501	TNMG160408FP KC5010	B124
1819502	TNMG160412FP KC5010	B124
1819513	VNMG160404FP KC5010	B145
1819514	VNMG160408FP KC5010	B145
1819515	WNMG060404FP KC5010	B156
1819516	WNMG060408FP KC5010	B156
1819517	WNMG080404FP KC5010	B156
1819518	WNMG080408FP KC5010	B156
1819519	WNMG080412FP KC5010	B156
1819846	SPHX1205PCFRGN1WB KCK15	S78
1819848	SPHX1205PCFRGN1WB KC725M	S78
1819849	SPHX1205PCFRGN1WB KC520M	S78
1819850	SPHX1205PCFRGN1WB KTPK20	S78
1819852	SPHX1205PCFRGN1WBK KY3500	S78
1819853	SPHX1205ZCTRGP KTPK20	S73
1819858	SPHX1205ZCFRGN1W KCK15	S74
1819861	SPHX1205ZCFRGN1W KC520M	S74
1819864	SPHX1205ZCFRGN1WK KY3500	S74
1824861	TCMT16T308LF KC5010	B244
1824882	TCMT16T304LF KC5010	B244
1829218	TNMG160404FW KT315	B125
1829219	TNMG160408FW KT315	B125
1829220	TNMG160404FW KC5010	B125
1831439	841.142.200	K118–120
1831441	841.142.320	K118–119
1831442	841.142.420	K118–119
1831590	KM63XMZKR5060Y	K87
1831749	NG3062L KC5010	C155
1831750	NG4250R KC5010	C154
1832293	CNMG090308MP KC5010	B51
1832294	CNMG120404MP KC5010	B51
1832295	CNMG120408MP KC5010	B51
1832296	CNMG120412MP KC5010	B51
1832297	CNMG120416MP KC5010	B51
1832298	CNMG160608MP KC5010	B51
1832299	CNMG160612MP KC5010	B51
1832301	CNMG160616MP KC5010	B51
1832302	CNMG190608MP KC5010	B51
1832313	CNMG190612MP KC5010	B51
1832315	CNMG190616MP KC5010	B51
1832316	DNMG110408MP KC5010	B79
1832318	DNMG150404MP KC5010	B79
1832319	DNMG150408MP KC5010	B79
1832321	DNMG150412MP KC5010	B79
1832322	DNMG150604MP KC5010	B79
1832323	DNMG150608MP KC5010	B79
1832324	DNMG150612MP KC5010	B79
1832325	SNMG120408MP KC5010	B98
1832327	SNMG120412MP KC5010	B98
1832330	SNMG150612MP KC5010	B98
1832353	SNMG190616MP KC5010	B98
1832354	TNMG160404MP KC5010	B125
1832355	TNMG160408MP KC5010	B125
1832356	TNMG160412MP KC5010	B125
1832357	TNMG220408MP KC5010	B125
1832358	TNMG220412MP KC5010	B125
1832359	TNMG220416MP KC5010	B125
1832360	VNMG160404MP KC5010	B146
1832361	VNMG160408MP KC5010	B146
1832373	VNMG160412MP KC5010	B146
1832374	WNMG060404MP KC5010	B157
1832376	WNMG060408MP KC5010	B157
1832378	WNMG080408MP KC5010	B157
1832379	WNMG080412MP KC5010	B157
1833500	SPHX1205PCERGNT1WB KB1340	S78, S84
1833501	SPHX1205ZCERGNT1W KB1340	S74
1833766	B411A06100 KF1	G100
1834274	R67FBHS06	K136
1834295	SNMG120412FW KT315	B98
1834819	170.294	H58, H65
1836470	170.295	H65
1836471	170.296	H65
1840501	KCGX110304R15 KC5410	E31
1841355	VCGR160416 KC5010	E34
1841781	MS1336	V56, V72
1841782	MS2038	S41, S60, S62, T33, T50, T72, T102, V49, V56, V60, V64, V72, V78
1841856	MS1556	T98, U32–34, V147
1843976	RCMT1204M0 KC5010	B224
1845216	TCMT110204LF KC5010	B244
1845218	CCMT120408LF KC5010	B177
1845219	TPMT110204LF KC5010	B255
1845227	CCMT09T304LF KC5010	B177
1845230	SCMT09T304LF KC5010	B230
1847935	CNGA120412T01020FW KY3500	B293
1848593	SPGX060304RHP KC7140	J89
1848597	SPGX070304RHP KC7140	J89
1848601	SPPX09T308RHP KC7140	J89
1848605	SPPX120408RHP KC7140	J89
1848655	ICSN443 K9	B58–60
1849051	DCGR150404 KC5010	E28
1849052	DCGR150408 KC5010	E28
1849053	DCGR150412 KC5010	E28
1849054	KCGX110301R15 KC5010	E31
1849055	KCGX110301L15 KC5010	E31
1849056	KCGX110302R15 KC5010	E31
1849058	KCGX110304R15 KC5010	E31
1849059	KCGX110304L15 KC5010	E31
1849060	KCGX110308R15 KC5010	E31
1849243	KCGX110308L15 KC5010	E31
1849249	KNGX150404R20 KC5010	E30
1849250	KNGX150404L20 KC5010	E30
1849251	KNGX150408R20 KC5010	E30
1849252	KNGX150408L20 KC5010	E30
1849274	KCGR110304R08 KC5010	E29
1849275	KCGR110304L08 KC5010	E29
1849279	VBMR110304 KC5010	E32
1849281	VCGR160402 KC5010	E34
1849301	VCGR160404 KC5010	E34
1849302	VCGR160408 KC5010	E34
1849323	VCGR160412 KC5010	E34
1849846	KCGR110304L08 KT315	E29
1849866	KCGR110308R08 KT315	E29
1849869	KCGX110302R15 KT315	E31
1849871	KCGX110304R15 KT315	E31
1849874	KCGX110308R15 KT315	E31

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
1849885	VBMR110304 KT315	E32
1849903	KCGR110308L08 KC5025	E29
1849906	VBMR110304 KC5025	E32
1849908	VCGR160402 KC5025	E34
1849909	VCGR160404 KC5025	E34
1849910	VCGR160408 KC5025	E34
1849983	KCGX110301R15 KC5025	E31
1849998	KCGX110304R15 KC5025	E31
1850011	KCGX110304L15 KC5025	E31
1850012	KCGX110308R15 KC5025	E31
1850067	KCGR110304R08 KC5025	E29
1850070	KCGR110304L08 KC5025	E29
1851263	CNGA120408T01020FW KY3500	B293
1851264	CNGA120416T01020FW KY3500	B293
1851265	WNGA080408T01020FW KY3500	B294
1851268	CNGX120708T01020FW KY3500	B295
1851269	CNGX120712T01020FW KY3500	B295
1851270	CNGX120716T01020FW KY3500	B295
1851304	SCGN090408EFW KY3500	B299
1852181	CS412	B168, B370
1854201	CPMT050204LF KC5010	B190
1854340	HTSR040R025M	J67
1854342	HTSR046R028M	J67
1854378	B514S08000 KC7030	J68
1854379	B514S10000 KC7030	J68
1855439	NG3M200RK KT315	C146
1855476	NG2031RK KT315	C146
1855479	NG2047RK KT315	C146
1855504	NG2062RK KT315	C146
1855506	NG2094RK KT315	C146
1855508	NG2125RK KT315	C146
1855556	NG2M200RK KT315	C146
1855576	NG3062RK KT315	C146
1855577	NG3094LK KT315	C148
1855578	NG3094RK KT315	C146
1855910	SPHX1205ZCSRGP KCK15	S73
1857709	420.102	S72
1859604	VBMT160404LF KT315	B265
1860701	190.458	J67
1860827	NG3088L KC5010	C155
1861004	FAS100302GD KC7015	H33
1861493	H32PCLNR12	B69
1861496	H32PDUNR15	B91
1861500	H40PCLNR12	B69
1861501	H40PCLNL12	B69
1861517	H50PCLNR12	B69
1861518	H50PCLNL12	B69
1861519	H50PDUNR15	B91
1861520	H50PDUNL15	B91
1863407	552.210	B369, B374
1864501	VCMR160404 KC5010	E33
1864502	VCMR160408 KC5010	E33
1864543	VCMR160404 KC5025	E33
1864544	VCMR160408 KC5025	E33
1864562	VCMR160404 KT315	E33
1864583	VCMR160408 KT315	E33
1864815	SNHX1102PZTNGP KC725M	U15
1864816	SNHX11T3PZTNGP KC725M	U15
1864817	SNHX1203PZTNGP KC725M	U15
1864825	SNHX12L5PZTNGP KC725M	U15
1864829	SNHX11T3PZFNGE KC510M	U14
1864830	SNHX1203PZFNGE KC510M	U14
1864831	SNHX12L5PZFNGE KC510M	U14
1865174	SPGR090308K KC5010	B169
1865210	TPGR110304K KC5010	B171
1865214	TPGR160304K KC5010	B171
1865218	TPGR160308K KC5010	B171
1865436	SPGN090304 KC5010	B169
1865452	SPGN090308 KC5010	B169
1865483	SPGN120304 KC5010	B169
1865484	SPGN120308 KC5010	B169
1865486	SPGN120316 KC5010	B169
1865531	TPGN110304 KC5010	B171
1865532	TPGN110308 KC5010	B171
1865533	TPGN160302 KC5010	B171
1865534	TPGN160304 KC5010	B171
1865535	TPGN160308 KC5010	B171
1865536	TPGN160312 KC5010	B171
1865537	TPGN160316 KC5010	B171
1865538	TPGN220404 KC5010	B171
1865539	TPGN220408 KC5010	B171
1865540	TPGN220412 KC5010	B171
1865541	TPGN220416 KC5010	B171
1865870	RCMK040300 KC5010	E63
1865871	RCMK060400 KC5010	E63
1865953	RCMK090700 KC5010	E63
1865954	RCMK120800 KC5010	E63
1865955	RCGK040300HP KC5010	E63
1865956	RCGK060400HP KC5010	E63
1865959	RCGV060400 KC5010	B166
1865960	RCGV090700 KC5010	B166
1865961	RCGV120700 KC5010	B166
1865962	RPGV090700 KC5010	B167
1865999	RCMT0602M0 KC5010	B224
1866000	RCMT0803M0 KC5010	B224
1866001	RCMT10T3M0 KC5010	B224
1866014	RCMT1605M0 KC5010	B224
1866015	RCMT2006M0 KC5010	B224
1866017	RCMT060200 KC5010	B224
1866019	RCMT09T300 KC5010	B224
1866310	CNMX120712T02020 KY3500	B295
1866311	CNMX120716T02020 KY3500	B295
1866356	SNMX120712T02020 KY3500	B298
1866357	SNMX120716T02020 KY3500	B298
1866358	SNMX150716T02020 KY3500	B298
1866564	CCGT0602X0LF KC5025	B175
1866565	CCGT060201LF KC5025	B175
1866566	CCGT060202LF KC5025	B175
1866567	CCGT060204LF KC5025	B175
1866569	CCGT09T3X0LF KC5025	B175
1866570	CCGT09T301LF KC5025	B175
1866571	CCGT09T302LF KC5025	B175
1866572	CCGT09T304LF KC5025	B175
1866593	CCGT09T308LF KC5025	B175
1866616	CCGT09T308LF K313	B175
1866617	CPGT060201LF KC5025	B189
1866618	CPGT060202LF KC5025	B189
1866619	CPGT060204LF KC5025	B189
1866620	CPGT060208LF KC5025	B189
1866621	CPGT09T302LF KC5025	B189
1866622	CPGT09T304LF KC5025	B189
1866623	CPGT09T308LF KC5025	B189
1866625	CPGT060201LF KC5410	B189
1866638	TPGT090204LF KC5025	B254
1866640	TPGT110202LF KC5025	B254
1866641	TPGT110204LF KC5025	B254
1866643	DCGT0702X0LF KC5025	B206
1866646	DCGT070201LF KC5025	B206
1866647	DCGT11T301LF KC5025	B206
1866648	DCGT11T3X0LF KC5025	B206
1866650	DCGT070201LF KC5010	B206
1866651	DCGT11T301LF KC5010	B206
1866652	DCGT150408LF KC5010	B206
1866653	TPGT16T304LF KC5025	B254
1866655	TPGT110208LF KC5010	B254
1866661	TPGT110204LF KC5410	B254
1866665	DPGT070204LF KC5025	B214
1866667	DPGT11T302LF KC5025	B214
1866668	DPGT11T304LF KC5025	B214
1866674	TPGT16T308LF KC5410	B254
1866675	VBGT1103X0LF KC5025	B264
1866676	VBGT110301LF KC5025	B264
1866677	VBGT110302LF KC5025	B264
1866678	VBGT110304LF KC5025	B264
1866679	VBGT1604X0LF KC5025	B264
1866681	VBGT160401LF KC5025	B264
1866682	VBGT160402LF KC5025	B264
1866683	VBGT160404LF KC5025	B264
1866685	VBGT110302LF KC5010	B264
1866686	VBGT110304LF KC5010	B264
1866754	VBGT160401LF KC5010	B264
1866755	VBGT160402LF KC5010	B264
1866756	VBGT160404LF KC5010	B264
1866757	VBGT110301LF KC5410	B264
1866761	VBGT160402LF KC5410	B264
1866762	VBGT160404LF KC5410	B264
1866781	DPGT070201LF KC5010	B214
1866782	SPGT09T304LF KC5025	B238
1866793	SPGT09T308LF KC5025	B238
1866795	SPGT09T304LF KC5010	B238
1866796	SPGT09T308LF KC5010	B238
1866801	TCGT110201LF KC5025	B243
1866802	TCGT110204LF KC5025	B243
1866955	CCGT060202HP KC5025	B175
1866956	CCGT060204HP KC5025	B175
1866959	CCGT09T302HP KC5025	B175
1866960	CCGT09T304HP KC5025	B175
1866961	CCGT09T308HP KC5025	B175
1866994	CCGT120404HP KC5025	B175
1866996	CPGT060202HP KC5025	B188
1866997	CPGT060204HP KC5025	B188
1867001	CPGT09T302HP KC5025	B188
1867002	CPGT09T304HP KC5025	B188
1867004	DCGT070202HP KC5025	B206
1867006	DCGT070204HP KC5025	B206
1867007	DCGT070208HP KC5025	B206
1867009	DCGT11T302HP KC5025	B206
1867010	DCGT11T304HP KC5025	B206
1867011	DCGT11T308HP KC5025	B206
1867028	RCGT10T3M0HP KC5025	B222
1867029	RCGT1204M0HP KC5025	B222
1867031	TCGT110204HP KC5025	B243
1867034	TCGT16T304HP KC5025	B243
1867035	TCGT16T308HP KC5025	B243
1867036	TPGT110202HP KC5025	B254
1867037	TPGT110204HP KC5025	B254
1867042	TPGT16T304HP KC5025	B254
1867046	VBGT160404HP KC5025	B264
1867049	VBGT160408HP KC5025	B264
1867050	VBGT110304HP KC5025	B264
1867051	VBGT110302HP KC5025	B264
1867060	VBGT110304HP KC5010	B264
1867061	VBGT110302HP KC5010	B264
1867212	SSP025016M	B58–60, B66, B85, B89–90, B105–107, B132, B137, B149–150, B152, B161, B163
1867278	KMSP415IP	B58–60, B66, B85, B89–90, B105–107, B132, B161, B163
1867314	KMSP515IP	B58–60, B66, B105
1867321	KLM46L15IP	B58–60, B85, B105–107, B132
1867333	KLM4615IP	B58–60, B105, B107, B161
1867338	KLM58L15IP	B58–60, B105
1867620	CNGP120408 KC5010	B46
1868190	CPGH09T301 KC5010	B188
1868253	CPGH09T301 KC5025	B188
1868254	CPGH09T301 KT315	B188
1868255	CPGH09T302 KC5010	B188
1868257	CPGH09T302 KC5025	B188
1868419	CNGP120401 KC5010	B46
1868420	CNGP120402 KC5010	B46
1868421	CNGP120404 KC5010	B46
1868443	CNGP120412 KC5010	B46
1868444	CNGP120416 KC5010	B46
1868451	DNGP150401 KC5010	B74
1868452	DNGP150402 KC5010	B74
1868453	DNGP150404 KC5010	B74
1868454	DNGP150408 KC5010	B74
1868456	DNGP150608 KC5010	B74
1868457	SNGP120404 KC5010	B96
1868458	SNGP120408 KC5010	B96
1868461	TNGP160402 KC5010	B122
1868462	TNGP160404 KC5010	B122
1868463	TNGP160408 KC5010	B122
1868464	VNGP160401 KC5010	B143
1868465	VNGP160402 KC5010	B143
1868466	VNGP220404 KC5010	B143
1868467	VNGP220408 KC5010	B143
1869820	CCMT060202LF KC5010	B177
1869821	CCMT060204LF KC5010	B177
1869894	CPGH09T304 KC5010	B188
1869896	CPGH09T304 KC5025	B188
1869899	CPGH09T304 KT315	B188
1869901	CPGH09T308 KC5010	B188
1869903	CPGH09T308 KC5025	B188
1869932	CCMT060202LF KT315	B177
1869964	CCMT060204LF KT315	B177
1869965	CCMT060208LF KT315	B177
1869966	CCMT09T302LF KT315	B177
1869967	CCMT09T304LF KT315	B177
1869968	CCMT09T308LF KT315	B177
1869973	DCMT070204LF KT315	B207
1869974	DCMT11T302LF KT315	B207
1869975	DCMT11T304LF KT315	B207
1869976	DCMT11T308LF KT315	B207
1869980	SCMT09T304LF KT315	B230
1869996	TCMT110204LF KT315	B244
1869998	TCMT110208LF KT315	B244
1870000	TCMT16T304LF KT315	B244
1870002	TCMT16T308LF KT315	B244
1870021	CNGG120401LF KC5010	B46
1870022	CNGG120402LF KC5010	B46
1870036	VBMT110302LF KT315	B265
1870037	VBMT110304LF KT315	B265
1870039	VBMT160402LF KT315	B265
1870043	CNGG120404LF KC5010	B46
1870044	CNGG120408LF KC5010	B46
1870069	CNGG120412LF KC5010	B46
1870072	DNGG150402LF KC5010	B74
1870113	DNGG150404LF KC5010	B74
1870114	DNGG150408LF KC5010	B74
1870323	VBMT160408LF KT315	B265
1870324	CPMT050204LF KT315	B190
1870326	CPMT060204LF KT315	B190
1870328	CPMT09T302LF KT315	B190
1870329	CPMT09T304LF KT315	B190
1870333	CPMT09T308LF KT315	B190
1870335	DPMT070204LF KT315	B215
1870337	DPMT11T304LF KT315	B215
1870339	SPMT09T304LF KT315	B238
1870342	TPMT090204LF KT315	B255
1870365	TPMT110208LF KT315	B255
1870366	TPMT16T304LF KT315	B255
1870367	TPMT16T308LF KT315	B255
1870619	TNGG160402LF KC5010	B122
1870983	CCMT060208LF KC5010	B177
1870984	CCMT09T302LF KC5010	B177
1870986	CCMT09T308LF KC5010	B177
1870987	CCMT120404LF KC5010	B177
1870990	CPMT050202LF KC5010	B190
1870992	CPMT060202LF KC5010	B190
1870998	DPMT11T302LF KC5010	B215
1870999	DPMT11T304LF KC5010	B215
1871000	DPMT11T308LF KC5010	B215
1871002	SCMT09T308LF KC5010	B230
1871013	CPMT060204LF KC5010	B190
1871014	CPMT060208LF KC5010	B190
1871015	CPMT09T302LF KC5010	B190
1871016	CPMT09T304LF KC5010	B190
1871017	CPMT09T308LF KC5010	B190
1871019	DCMT11T312LF KC5010	B207
1871020	DCMT150404LF KC5010	B207
1871021	DCMT150408LF KC5010	B207
1871022	DPMT070202LF KC5010	B215
1871033	DPMT070204LF KC5010	B215
1871035	VBMT110308LF KC5010	B265
1871036	VBMT160402LF KC5010	B265
1871038	WPMT040204LF KC5010	B272
1871039	WPMT06T304LF KC5010	B272
1871040	WPMT06T308LF KC5010	B272
1871041	WCMT040204LF KC5010	B270
1871042	WCMT06T308LF KC5010	B270
1871083	SCMT120404LF KC5010	B230
1871084	SCMT120408LF KC5010	B230
1871085	SCMT120412LF KC5010	B230
1871086	SPMT09T304LF KC5010	B238
1871087	SPMT09T308LF KC5010	B238
1871088	TCMT110202LF KC5010	B244
1871090	TCMT110208LF KC5010	B244
1871091	TCMT16T302LF KC5010	B244
1871104	TCMT16T312LF KC5010	B244
1871105	TCMT220408LF KC5010	B244
1871106	TPMT090202LF KC5010	B255
1871107	TPMT090204LF KC5010	B255
1871108	TPMT110202LF KC5010	B255
1871110	TPMT110208LF KC5010	B255
1871111	TPMT16T304LF KC5010	B255
1871112	TPMT16T308LF KC5010	B255
1871134	TPMT220408LF KC5010	B255
1871163	CCMT060204UF KC5010	B178
1871164	CCMT09T302UF KC5010	B178
1871165	CCMT09T304UF KC5010	B178
1871166	CCMT09T308UF KC5010	B178
1871167	CPMT060204UF KC5010	B191
1871168	CPMT09T304UF KC5010	B191

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
1871169	DCMT070204UF KC5010	B208
1871170	DCMT11T302UF KC5010	B208
1871171	DCMT11T304UF KC5010	B208
1871172	DCMT11T308UF KC5010	B208
1871193	DPMT070204UF KC5010	B216
1871196	SCMT09T308UF KC5010	B231
1871197	SPMT09T304UF KC5010	B239
1871198	TCMT110204UF KC5010	B245
1871199	TCMT110208UF KC5010	B245
1871200	TCMT16T308UF KC5010	B245
1871202	TPMT110204UF KC5010	B256
1871286	TNGG160404LF KC5010	B122
1871287	TNGG160408LF KC5010	B122
1871288	VNGG160402LF KC5010	B143
1871289	VNGG160404LF KC5010	B143
1871313	VNGG160408LF KC5010	B143
1871317	VNGG220408LF KC5010	B143
1871318	WNGG080401LF KC5010	B154
1871319	WNGG080402LF KC5010	B154
1871320	WNGG080404LF KC5010	B154
1872409	ICSN543 K9	B58–60
1873224	CWLNL2525M08-MX7	B369
1873227	CWLNR3225P08-MX7	B369
1873496	S40T-CWLNL08-MX7	B374
1873498	S40T-CSSNR12-MX7	B373
1873499	S40T-CSSNL12-MX7	B373
1874234	SPHX1205PCTLGPBK KY3500	S77
1874248	MDHX1004ZDFRGD4W K110M	S69
1874250	MDHX1004ZDFRGD4W KC520M	S69
1875191	DDJNR2525M15KC06	B85
1875192	DDJNL2525M15KC06	B85
1875193	DCLNR2525M12KC04	B59
1875194	DCLNL2020K12KC04	B59
1875195	DSSNR2525M12KC04	B107
1875196	DCLNL2525M12KC04	B59
1875197	DDJNR2020K15KC06	B85
1875198	DDJNL2020K15KC06	B85
1875199	DCLNR2020K12KC04	B59
1875200	DCKNR2525M12KC04	B58
1875201	DCRNR2525M12KC04	B60
1875202	DSSNR2020K12KC04	B107
1875203	DSSNL2525M12KC04	B107
1875204	DCKNL2525M12KC04	B58
1875205	DCLNL2525M16KC06	B59
1875206	DCRNL2525M12KC04	B60
1875207	DDJNL3225P15KC06	B85
1875208	DDJNR3225P15KC06	B85
1875209	DDJNL3232P15KC06	B85
1875210	DSDNN2020K12KC04	B105
1875211	DSDNN2525M12KC04	B105
1875212	DCLNR2525M16KC06	B59
1875215	DSBNL2525M12KC04	B105
1875216	DSDNN2525M15KC06	B105
1875219	DSKNR2525M12KC04	B106
1875220	DSKNL2525M12KC04	B106
1875222	DTGNR2525M22KC04	B132
1875223	DCLNR3225P12KC04	B59
1875224	DCLNR3232P16KC06	B59
1875225	DCLNL3232P16KC06	B59
1875226	DCRNR2020K12KC04	B60
1875227	DDJNR3232P15KC06	B85
1875228	DSRNR2525M12KC04	B106
1875230	DCLNL3225P16KC06	B59
1875231	DCLNL3225P12KC04	B59
1875232	DCLNR3225P16KC06	B59
1875233	DTFNL2525M22KC04	B132
1875234	DTGNL2525M22KC04	B132
1876838	TNMG160412FW KT315	B125
1876849	TNMG220404FP KC5010	B124
1877480	DNGN150704T02020 KY1615	B313
1877482	DNGN150708T02020 KY1615	B313
1877594	DNGN150712T02020 KY1615	B313
1877595	DNGN150716T02020 KY1615	B313
1877596	ENGN130704T02020 KY1615	B315
1877597	ENGN130708T02020 KY1615	B315
1877598	ENGN130712T02020 KY1615	B315
1877599	ENGN130716T02020 KY1615	B315
1877601	RNGN120700T02020 KY1615	B316
1877602	RNGN120700T10015 KY1615	B316
1877603	RNGN120700T20015 KY1615	B316
1881130	CNGA120404T02020 KY1615	B309
1881131	CNGA120408T00520 KY1615	B309
1881132	CNGA120408T02020 KY1615	B309
1881199	KCUX110302R15 KC5010	E32
1881200	KCUX110305R15 KC5010	E32
1881201	KCUX110302L15 KC5010	E32
1881202	KCUX110305L15 KC5010	E32
1881203	KNUX150405R20 KC5010	E31
1881243	CNGA120412T02020 KY1615	B309
1881244	CNGA120416T02020 KY1615	B309
1881246	CNGA160612T02020 KY1615	B309
1881249	CNGA190612T02020 KY1615	B309
1881250	CNGA190616T02020 KY1615	B309
1881251	CNGN120404T02020 KY1615	B309
1881252	CNGN120408T02020 KY1615	B309
1881253	CNGN120412T02020 KY1615	B309
1881255	CNGN120708T02020 KY1615	B309
1881257	CNGN120712T02020 KY1615	B309
1881258	CNGN120716T02020 KY1615	B309
1881266	CNGN160716T02020 KY1615	B309
1881267	CNGN160716T05015 KY1615	B309
1881272	CNGX120708T02020 KY1615	B311
1881273	CNGX120712T02020 KY1615	B311
1881278	DNGA150404T02020 KY1615	B313
1881279	DNGA150408T02020 KY1615	B313
1881280	DNGA150412T02020 KY1615	B313
1881281	DNGA150416T02020 KY1615	B313
1881282	DNGA150604T02020 KY1615	B313
1881283	DNGA150608T02020 KY1615	B313
1881285	DNGA150612T02020 KY1615	B313
1881297	DNGX150708T02020 KY1615	B315
1881305	RCGW1204M0T01020 KY1615	B316
1881310	RCGX090700T01020 KY1615	B315
1881311	RCGX090700T02020 KY1615	B315
1881313	RCGX090700T10015 KY1615	B315
1881314	RCGX090700T20015 KY1615	B315
1881316	RCGX120700T02020 KY1615	B315
1881318	RCGX120700T10015 KY1615	B315
1881319	RCGX120700T20015 KY1615	B315
1881320	RCGX151000T20015 KY1615	B315
1881321	RCGX191000T20015 KY1615	B315
1881322	RCGX251200T20015 KY1615	B315
1881325	RNGA090300T02020 KY1615	B316
1881326	RNGA120400T02020 KY1615	B316
1881327	RNGN090300T02020 KY1615	B316
1881328	RNGN090400T02020 KY1615	B316
1881329	RNGN120300T02020 KY1615	B316
1881330	RNGN120400T02020 KY1615	B316
1881332	RNGN190700T02020 KY1615	B316
1881347	SNGA120408T02020 KY1615	B317
1881348	SNGA120412T02020 KY1615	B317
1881351	SNGN090308T02020 KY1615	B317
1881355	SNGN120408T00520 KY1615	B317
1881356	SNGN120408T02020 KY1615	B317
1881357	SNGN120412T02020 KY1615	B317
1881358	SNGN120416T02020 KY1615	B317
1881361	SNGN120704T02020 KY1615	B317
1881362	SNGN120708T02020 KY1615	B317
1881364	SNGN120712T02020 KY1615	B317
1881365	SNGN120716T02020 KY1615	B317
1881366	SNGN120720T02020 KY1615	B317
1881367	SNGN120720T10015 KY1615	B317
1881368	SNGN120720T20015 KY1615	B317
1881371	SNGN150716T02020 KY1615	B317
1881396	SNGX120712T02020 KY1615	B318
1881402	SPGN090308T01020 KY1615	B318
1881405	SPGN120308T01020 KY1615	B318
1881413	TNGA160408T02020 KY1615	B319
1881414	TNGA160412T02020 KY1615	B319
1881416	TNGA220408T02020 KY1615	B319
1881417	TNGA220412T02020 KY1615	B319
1881422	TNGN110308T02020 KY1615	B319
1881423	TNGN160404T02020 KY1615	B319
1881424	TNGN160408T02020 KY1615	B319
1881425	TNGN160412T02020 KY1615	B319
1881426	TNGN160416T02020 KY1615	B319
1881427	TNGN160708T02020 KY1615	B319
1881428	TNGN160712T02020 KY1615	B319
1881430	TNGN220408T02020 KY1615	B319
1881437	TPGN110304T01020 KY1615	B320
1881438	TPGN110308T01020 KY1615	B320
1881439	TPGN110312T01020 KY1615	B320
1881440	TPGN160304T01020 KY1615	B320
1881441	TPGN160308T01020 KY1615	B320
1881442	TPGN160312T01020 KY1615	B320
1881447	TPUN110304T00520 KY1615	B321
1881448	TPUN110308T00520 KY1615	B321
1881449	TPUN160304T00520 KY1615	B321
1881450	TPUN160308T00520 KY1615	B321
1881451	TPUN160312T00520 KY1615	B321
1881452	VNGA160404T02020 KY1615	B322
1881453	VNGA160408T02020 KY1615	B322
1881454	VNGA160412T02020 KY1615	B322
1881455	VNGA220408T02020 KY1615	B322
1882046	CNMX120708T02020 KY3500	B295
1886327	80A09RP00MD10CF	S68
1886328	100B12RP00MD10CF	S68
1886329	125B16RP00MD10CF	S68
1886330	160C20RP00MD10CF	S68
1886331	200C24RP00MD10CF	S68
1886332	250C30RP00MD10CF	S68
1886492	A16RCTFPR11	B174, B371
1886494	A40VCTFPR16	B174, B371
1886498	A16RSCFPR06	B194
1886501	A16RSCLPL06	B196
1886502	A16RSCLPR06	B196
1886504	A20SSCLPR06	B196
1886505	A10KSDUCL07	B213
1886506	A10KSDUCR07	B213
1886507	A16RSDUCL11	B213
1886508	A16RSDUCR11	B213
1886510	A16RSSKCR09	B235
1887100	50A05RP70SP12CFP	S72
1887101	63B07RP70SP12CFP	S72
1887102	80B08RP70SP12C2WFP	S72
1887173	100B12RP70SP12C3WFP	S72
1887175	160C18RP70SP12C3WFP	S72
1887178	63A07RP90SP12CFP	S76
1887179	80A08RP90SP12C2WFP	S76
1887180	100B12RP90SP12C3WFP	S76
1887181	125B15RP90SP12C3WFP	S76
1887193	160C18RP90SP12C3WFP	S76
1887194	200C24RP90SP12C4WFP	S76
1887616	NG3094L KC5010	C155
1893753	80A06RP00MD10CF	S68
1893754	100B08RP00MD10CF	S68
1893755	125B10RP00MD10CF	S68
1893756	160C12RP00MD10CF	S68
1893757	200C14RP00MD10CF	S68
1893758	250C18RP00MD10CF	S68
1895492	SPHX1205PCFLGN1WB KCK15	S78
1897239	410.085	S68
1897657	TPGX0902ZPRGD KC7015	H63
1897658	TPGX1102ZPRGD KC7015	H63
1897659	TPGX1303ZPRGD KC7015	H63
1897660	TPGX1603ZPRGD KC7015	H63
1897830	BGHX15L508PCFRGG KC510M	S149
1905695	CNMG190612RP KC5010	B53
1905810	MS1294	B168, B370, S48, T50, V49, V64, V72
1906272	MCFNL12CA12	B70
1908860	DWLNR2525M08KC04	B161
1908861	DWLNL2525M08KC04	B161
1908862	DWLNR3232P08KC04	B161
1908893	DWLNL3232P08KC04	B161
1909790	CPGT060208LF KC5010	B189
1909791	TPGT110202LF KC5010	B254
1910043	VBGT110302HP KC5410	B264
1910044	VBGT110304HP KC5410	B264
1910215	CNMG120412RP KC5010	B53
1912477	STN1612UNI KC635M	W44
1913052	B966A03000 KC7315	G132
1913458	B966A03500 KC7315	G132
1913459	B966A03700 KC7315	G132
1913460	B966A03800 KC7315	G132
1913461	B966A04000 KC7315	G132
1913462	B966A04200 KC7315	G132
1913473	B966A04500 KC7315	G132
1913474	B966A04600 KC7315	G132
1913475	B966A04800 KC7315	G132
1913476	B966A05000 KC7315	G132
1913477	B966A05500 KC7315	G132
1913478	B966A05700 KC7315	G132
1913479	B966A05800 KC7315	G132
1913480	B966A06000 KC7315	G132
1913481	B966A06500 KC7315	G133
1913482	B966A06800 KC7315	G133
1913483	B966A07000 KC7315	G133
1913484	B966A07400 KC7315	G133
1913485	B966A07500 KC7315	G133
1913486	B966A07800 KC7315	G133
1913487	B966A08000 KC7315	G133
1913488	B966A08500 KC7315	G133
1913489	B966A08800 KC7315	G133
1913490	B966A09000 KC7315	G133
1913491	B966A09300 KC7315	G133
1913492	B966A09500 KC7315	G133
1913493	B966A09800 KC7315	G133
1913494	B966A10000 KC7315	G133
1913495	B966A10200 KC7315	G133
1913496	B966A10500 KC7315	G133
1913497	B966A10700 KC7315	G133
1913498	B966A11000 KC7315	G133
1913499	B966A11200 KC7315	G133
1913500	B966A11500 KC7315	G134
1913501	B966A11700 KC7315	G134
1913502	B966A12000 KC7315	G134
1913503	B966A12500 KC7315	G134
1913504	B966A12700 KC7315	G134
1913505	B966A13000 KC7315	G134
1913506	B966A13500 KC7315	G134
1913507	B966A13700 KC7315	G134
1913508	B966A14000 KC7315	G134
1913509	B966A14500 KC7315	G134
1913510	B966A14700 KC7315	G134
1913511	B966A15000 KC7315	G134
1913512	B966A15500 KC7315	G134
1913513	B966A15700 KC7315	G134
1913514	B966A16000 KC7315	G134
1913515	B976A04000 KC7315	G138
1913516	B976A04200 KC7315	G138
1913517	B976A04500 KC7315	G139
1913518	B976A04600 KC7315	G139
1913519	B976A04800 KC7315	G139
1913520	B976A05000 KC7315	G139
1913521	B976A05500 KC7315	G139
1913522	B976A05700 KC7315	G139
1913523	B976A05800 KC7315	G139
1913524	B976A06000 KC7315	G139
1913525	B976A06500 KC7315	G139
1913526	B976A06800 KC7315	G139
1913527	B976A07000 KC7315	G139
1913528	B976A07400 KC7315	G140
1913529	B976A07500 KC7315	G140
1913530	B976A07800 KC7315	G140
1913531	B976A08000 KC7315	G140
1913532	B976A08500 KC7315	G140
1913533	B976A08800 KC7315	G140
1913534	B976A09000 KC7315	G140
1913535	B976A09300 KC7315	G140
1913536	B976A09500 KC7315	G140
1913537	B976A09800 KC7315	G140
1913538	B976A10000 KC7315	G140
1913539	B976A10200 KC7315	G140
1913540	B976A10500 KC7315	G140
1913541	B976A10700 KC7315	G141
1913542	B976A11000 KC7315	G141
1913543	B976A11200 KC7315	G141
1913544	B976A11500 KC7315	G141
1913545	B976A11700 KC7315	G141
1913546	B976A12000 KC7315	G141
1913547	B976A12500 KC7315	G141
1913548	B976A12700 KC7315	G141
1913549	B976A13000 KC7315	G141
1913550	B976A13500 KC7315	G141
1913551	B976A13700 KC7315	G141
1913552	B976A14000 KC7315	G141
1913553	B976A14500 KC7315	G141
1913554	B976A14700 KC7315	G141
1913555	B976A15000 KC7315	G141
1913556	B976A15500 KC7315	G141
1913558	B976A16000 KC7315	G142
1913559	B976A16500 KC7315	G142
1913560	B976A17000 KC7315	G142
1913561	B976A17500 KC7315	G142
1913562	B976A18000 KC7315	G142
1913563	B976A18500 KC7315	G142

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
1913564	B976A19000 KC7315	G142
1913565	B976A19500 KC7315	G142
1913566	B976A20000 KC7315	G142
1913567	B977A04000 KC7315	G138
1913568	B977A04200 KC7315	G138
1913569	B977A04500 KC7315	G139
1913570	B977A04600 KC7315	G139
1913571	B977A04800 KC7315	G139
1913572	B977A05000 KC7315	G139
1913573	B977A05500 KC7315	G139
1913574	B977A05800 KC7315	G139
1913575	B977A06000 KC7315	G139
1913576	B977A06500 KC7315	G139
1913577	B977A06800 KC7315	G139
1913578	B977A07000 KC7315	G139
1913579	B977A07400 KC7315	G140
1913580	B977A07500 KC7315	G140
1913581	B977A07800 KC7315	G140
1913582	B977A08000 KC7315	G140
1913583	B977A08500 KC7315	G140
1913584	B977A08800 KC7315	G140
1913585	B977A09000 KC7315	G140
1913586	B977A09300 KC7315	G140
1913587	B977A09500 KC7315	G140
1913588	B977A09800 KC7315	G140
1913589	B977A10000 KC7315	G140
1913590	B977A10200 KC7315	G140
1913591	B977A10500 KC7315	G140
1913592	B977A10700 KC7315	G141
1913593	B977A11000 KC7315	G141
1913594	B977A11200 KC7315	G141
1913595	B977A11500 KC7315	G141
1913596	B977A11700 KC7315	G141
1913597	B977A12000 KC7315	G141
1913598	B977A12500 KC7315	G141
1913599	B977A12700 KC7315	G141
1913600	B977A13000 KC7315	G141
1913601	B977A13500 KC7315	G141
1913602	B977A13700 KC7315	G141
1913603	B977A14000 KC7315	G141
1913604	B977A14500 KC7315	G141
1913605	B977A14700 KC7315	G141
1913606	B977A15000 KC7315	G141
1913607	B977A15500 KC7315	G141
1913608	B977A15700 KC7315	G141
1913609	B977A16000 KC7315	G142
1913610	B977A16500 KC7315	G142
1913611	B977A17000 KC7315	G142
1913612	B977A17500 KC7315	G142
1913613	B977A18000 KC7315	G142
1913614	B977A18500 KC7315	G142
1913615	B977A19000 KC7315	G142
1913616	B977A19500 KC7315	G142
1913617	B977A20000 KC7315	G142
1913618	B978A05000 KC7315	G146
1913619	B978A05500 KC7315	G146
1913620	B978A06000 KC7315	G146
1913621	B978A06500 KC7315	G146
1913622	B978A06800 KC7315	G146
1913623	B978A07000 KC7315	G146
1913624	B978A07500 KC7315	G147
1913625	B978A07800 KC7315	G147
1913626	B978A08000 KC7315	G147
1913627	B978A08500 KC7315	G147
1913628	B978A09000 KC7315	G147
1913629	B978A09500 KC7315	G147
1913630	B978A10000 KC7315	G147
1913631	B978A10200 KC7315	G147
1913632	B978A10500 KC7315	G147
1913633	B978A11000 KC7315	G147
1913634	B978A11500 KC7315	G147
1913635	B978A12000 KC7315	G147
1913636	B978A12500 KC7315	G147
1913637	B978A13000 KC7315	G148
1913638	B978A13500 KC7315	G148
1913639	B978A14000 KC7315	G148
1913640	B978A14500 KC7315	G148
1913641	B978A15000 KC7315	G148
1913642	B978A15500 KC7315	G148
1913643	B978A16000 KC7315	G148
1913644	B978A16500 KC7315	G148
1913645	B978A17000 KC7315	G148
1913646	B978A17500 KC7315	G148
1913647	B978A18000 KC7315	G148
1913648	B978A18500 KC7315	G148
1913649	B978A19000 KC7315	G148
1913650	B978A19500 KC7315	G148
1913651	B978A20000 KC7315	G148
1913652	B966F03000 KC7315	G135
1913653	B966F03500 KC7315	G135
1913656	B966F04000 KC7315	G135
1913657	B966F04200 KC7315	G135
1913661	B966F05000 KC7315	G135
1913662	B966F05500 KC7315	G135
1913665	B966F06000 KC7315	G135
1913666	B966F06500 KC7315	G135
1913667	B966F06800 KC7315	G135
1913668	B966F07000 KC7315	G135
1913669	B966F07400 KC7315	G135
1913672	B966F08000 KC7315	G135
1913673	B966F08500 KC7315	G135
1913675	B966F09000 KC7315	G135
1913677	B966F09500 KC7315	G135
1913679	B966F10000 KC7315	G135
1913680	B966F10200 KC7315	G135
1913681	B966F10500 KC7315	G135
1913682	B966F10700 KC7315	G135
1913683	B966F11000 KC7315	G136
1913687	B966F12000 KC7315	G136
1913688	B966F12500 KC7315	G136
1913689	B966F12700 KC7315	G136
1913690	B966F13000 KC7315	G136
1913691	B966F13500 KC7315	G136
1913693	B966F14000 KC7315	G136
1913694	B966F14500 KC7315	G136
1913696	B966F15000 KC7315	G136
1913699	B966F16000 KC7315	G136
1913701	B976F04200 KC7315	G143
1913702	B976F04500 KC7315	G143
1913703	B976F04600 KC7315	G143
1913705	B976F05000 KC7315	G143
1913706	B976F05500 KC7315	G143
1913708	B976F05800 KC7315	G144
1913709	B976F06000 KC7315	G144
1913711	B976F06800 KC7315	G144
1913712	B976F07000 KC7315	G144
1913715	B976F07800 KC7315	G144
1913716	B976F08000 KC7315	G144
1913717	B976F08500 KC7315	G144
1913718	B976F08800 KC7315	G144
1913719	B976F09000 KC7315	G144
1913723	B976F10000 KC7315	G144
1913724	B976F10200 KC7315	G144
1913725	B976F10500 KC7315	G144
1913726	B976F10700 KC7315	G144
1913727	B976F11000 KC7315	G144
1913730	B976F11700 KC7315	G144
1913731	B976F12000 KC7315	G144
1913732	B976F12500 KC7315	G144
1913733	B976F12700 KC7315	G144
1913734	B976F13000 KC7315	G144
1913735	B976F13500 KC7315	G145
1913736	B976F13700 KC7315	G145
1913737	B976F14000 KC7315	G145
1913738	B976F14500 KC7315	G145
1913740	B976F15000 KC7315	G145
1913743	B976F16000 KC7315	G145
1913744	B976F16500 KC7315	G145
1913745	B976F17000 KC7315	G145
1913747	B976F18000 KC7315	G145
1913748	B976F18500 KC7315	G145
1913752	B977F04000 KC7315	G143
1913753	B977F04200 KC7315	G143
1913754	B977F04500 KC7315	G143
1913755	B977F04600 KC7315	G143
1913756	B977F04800 KC7315	G143
1913757	B977F05000 KC7315	G143
1913758	B977F05500 KC7315	G143
1913759	B977F05800 KC7315	G144
1913760	B977F06000 KC7315	G144
1913761	B977F06500 KC7315	G144
1913762	B977F06800 KC7315	G144
1913763	B977F07000 KC7315	G144
1913764	B977F07400 KC7315	G144
1913765	B977F07500 KC7315	G144
1913766	B977F07800 KC7315	G144
1913767	B977F08000 KC7315	G144
1913768	B977F08500 KC7315	G144
1913769	B977F08800 KC7315	G144
1913770	B977F09000 KC7315	G144
1913771	B977F09300 KC7315	G144
1913772	B977F09500 KC7315	G144
1913773	B977F09800 KC7315	G144
1913774	B977F10000 KC7315	G144
1913775	B977F10200 KC7315	G144
1913776	B977F10500 KC7315	G144
1913777	B977F10700 KC7315	G144
1913778	B977F11000 KC7315	G144
1913779	B977F11200 KC7315	G144
1913780	B977F11500 KC7315	G144
1913781	B977F11700 KC7315	G144
1913782	B977F12000 KC7315	G144
1913783	B977F12500 KC7315	G144
1913784	B977F12700 KC7315	G144
1913785	B977F13000 KC7315	G144
1913786	B977F13500 KC7315	G145
1913788	B977F14000 KC7315	G145
1913789	B977F14500 KC7315	G145
1913791	B977F15000 KC7315	G145
1913792	B977F15500 KC7315	G145
1913793	B977F15700 KC7315	G145
1913794	B977F16000 KC7315	G145
1913795	B977F16500 KC7315	G145
1913796	B977F17000 KC7315	G145
1913797	B977F17500 KC7315	G145
1913798	B977F18000 KC7315	G145
1913799	B977F18500 KC7315	G145
1913800	B977F19000 KC7315	G145
1913801	B977F19500 KC7315	G145
1913802	B977F20000 KC7315	G145
1914363	NG4250L KC5025	C155
1914364	NG4250R KC5025	C154
1915368	881.252.320	K133–134
1915629	MS2089	C119
1915829	MDHX1004ZDERGD4W KTPK20	S69
1916212	LNEU1245R04SGP KC725M	U20
1916215	LNEU1245R08SGP KC725M	U20
1916218	LNEU1245R16SGP KC725M	U20
1916221	LNEU1250R04SGP KC725M	U20
1916224	LNEU1250R08SGP KC725M	U20
1918651	KDMB12R026M08SN	V111
1918652	KDMB16R026M08SN	V111
1918663	KDMB20R030M10SN	V111
1918664	KDMB25R040M12SN	V111
1918665	KDMT12R028M08SN	V128
1918666	KDMT16R028M08SN	V128
1918667	KDMT20R032M10SN	V128
1918669	KDMB08R140A08ST	V113
1918670	KDMB10R150A10ST	V113
1918671	KDMB12R160A12ST	V113
1918672	KDMB16R175A16ST	V113
1918673	KDMB20R190A20ST	V113
1918674	KDMB25R210A25ST	V113
1918676	KDMB12R130A12SN	V112
1918677	KDMB12R150A12SN	V112
1918678	KDMB16R140A16SN	V112
1918679	KDMB16R160A16SN	V112
1918680	KDMB20R160A20SN	V112
1918681	KDMB20R175A20SN	V112
1918682	KDMB25R160A25SN	V112
1918683	KDMB25R190A25SN	V112
1918684	KDMB32R175A32SN	V112
1918685	KDMB32R210A32SN	V112
1918690	KDMT12R130A12SN	V129
1918691	KDMT12R150A12SN	V129
1918692	KDMT16R140A16SN	V129
1918693	KDMT16R160A16SN	V129
1918694	KDMT20R160A20SN	V129
1918695	KDMT20R175A20SN	V129
1918697	KDMT25R190A25SN	V129
1918699	KDMT32R210A32SN	V129
1918704	KDMB08R100A08HN	V114
1918705	KDMB08R150A08HN	V114
1918803	SM455 K9	S41
1918864	KDMB08M0ERGN KC530M	V118
1918865	KDMB08M0ERGN KC515M	V118
1918866	KDMB10M0ERGN KC530M	V118
1918867	KDMB10M0ERGN KC515M	V118
1918868	KDMB12M0ERGN KC530M	V118
1918869	KDMB12M0ERGN KC515M	V118
1918870	KDMB16M0ERGN KC530M	V118
1918871	KDMB16M0ERGN KC515M	V118
1918872	KDMB20M0ERGN KC530M	V118
1918873	KDMB20M0ERGN KC515M	V118
1918874	KDMB25M0ERGN KC530M	V118
1918875	KDMB25M0ERGN KC515M	V118
1918878	KDMB32M0ERGN KC530M	V118
1918879	KDMB32M0ERGN KC515M	V118
1918905	KDMS0806ERGN KC515M	V131
1918907	KDMS1008ERGN KC515M	V131
1918909	KDMS1210ERGN KC515M	V131
1918911	KDMS1613ERGN KC515M	V131
1918913	KDMS2016ERGN KC515M	V131
1918917	KDMS3220ERGN KC515M	V131
1918932	KDMT1220ERGN KC515M	V132
1918934	KDMT1630ERGN KC515M	V132
1918936	KDMT2040ERGN KC515M	V132
1920386	MDHX1004ZDFRGD4W KTPK20	S69
1920691	TPGN160304T00520 KY1615	B320
1920692	TPGN160308T00520 KY1615	B320
1920693	SPUN120308T00520 KY1615	B318
1920694	RCGX0907-001 KY1615	B316
1920751	NRD4125R KC5010	C159
1921611	193.395	V113–115
1921612	193.394	V113–115, V130
1921713	193.393	V111–115, V128–130
1921714	193.392	V111–115, V128–130
1921715	193.391	V111–114, V128–130
1921716	193.390	V111–114, V129
1921717	193.389	V112, V114, V129
1923011	NAS3R4 KC5025	D13
1923833	A4G0300M03P02GMP KC5025	C95
1923834	A4R0500M05P00GMP KC5025	C96
1923835	A4G0500M05P04GMP KC5010	C95
1923836	A4G0505M05U04GMN KC5025	C96
1923837	A4G0505M05U08GMN KC5025	C96
1923838	A4G0505M05U04GMP KC5025	C95
1923839	A4G0505M05U08GMP KC5025	C95
1923840	A4G0500M05P08GMP KC5010	C95
1926594	CNMG120402FN KT315	B49
1926595	CNMG120402FN KC5010	B49
1926812	50A03RS45SE14EG	S41
1926836	160C08RS90SD12DG	T102
1926837	125B10RS90SD12DG	T102
1926839	125B07RS90SD12DG	T102
1926840	100B08RS90SD12DG	T102
1926841	100B06RS90SD12DG	T102
1926850	40A03RS45SE14EG	S41
1926893	80A06RS45SE14EG	S41
1926894	80A05RS45SE14EG	S41
1926897	63A05RS45SE14EG	S41
1926898	80A06RS90SD12DG	T102
1926899	63A04RS45SE14EG	S41
1926900	50A04RS45SE14EG	S41
1926901	80A05RS90SD12DG	T102
1926908	160C10RS45SE14EG	S41
1926909	160C07RS45SE14EG	S41
1926911	125B08RS45SE14EG	S41
1926924	125B06RS45SE14EG	S41
1926925	100B07RS45SE14EG	S41
1926926	100B05RS45SE14EG	S41
1926933	63A05RS90SD12DG	T102
1926936	63A04RS90SD12DG	T102
1926938	50A04RS90SD12DG	T102
1926939	50A03RS90SD12DG	T102
1926941	200C14RS90SD12DG	T102
1926942	200C11RS90SD12DG	T102
1926983	160C12RS90SD12DG	T102
1927913	KSEM125R1WN16F45M	H63
1927914	KSEM160R1WN20F45M	H63
1927915	KSEM200R1WN25F45M	H63
1927916	KSEM241R1WN32F45M	H63
1928470	193.371	J77–78
1928504	193.372	J77–78
1928643	5.34032-025115	J78
1928644	5.34032-025200	J78
1928645	5.34050-025300	J78
1928646	5.34050-025450	J78

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
1928647	5.34125R025150	J77
1928667	SPHX090304R20 KC7215	J99
1928669	SPHX060204R20 KC7140	J99
1928670	SPHX070304R20 KC7140	J99
1928671	SPHX090304R20 KC7140	J99
1928672	SPHX120404R20 KC7140	J99
1930297	A05XSCLDLS4	B186
1930298	A05XSCLDRS4	B186
1930299	E04HSCLDLS4	B186
1930300	E04HSCLDRS4	B186
1930354	E05HSCFDRS4	B185
1930355	E05HSCLDLS4	B186
1930356	E05HSCLDRS4	B186
1930357	E05MSCLDLS4	B186
1930358	E05MSCLDRS4	B186
1930360	E06HSCFDRS4	B185
1930361	E06HSCLDLS4	B186
1930362	E06HSCLDRS4	B186
1930372	A0410ESCLDRS412	B187
1930374	A0410ESCLDRS425	B187
1930376	A0510ESCFDRS412	B185
1930378	A0510ESCLDRS412	B187
1930380	A0510ESCFDRS425	B185
1930382	A0510ESCLDRS425	B187
1930402	A0612ESCLDRS419	B187
1930404	A0612ESCFDRS431	B185
1930406	E0412DSCLDRS422	B187
1930408	E0512XSCFDRS425	B185
1930410	E0512XSCLDRS425	B187
1930412	E0512XSCFDRS450	B185
1930418	E0612ESCLDRS431	B187
1930434	E0616HSCLDRS431	B187
1930436	E0616XSCFDRS463	B185
1930492	A0616HSTLDR0731	B251
1930512	E0812XSTLDR0738	B252
1930544	A06HSWUPRS3	B273
1930546	A08HSWUPRS3	B273
1930549	E06MSWUPLS3	B273
1930550	E06MSWUPRS3	B273
1930552	E08MSWUPRS3	B273
1930556	A12MSWUPR04	B273
1930558	E10SSWUPR04	B273
1930560	E12SSWUPR04	B273
1930573	A12MSTFDL11	B250
1931147	MS2091	C36–37, C39–40, C112–114, C118
1931554	TTP15	S46–48, U40–49
1931573	MS2077	U40–49, V70–72, V139
1931575	MS2078	S41, T102, U38–39
1937503	CDHBS4T0S0 KC5010	B184
1937504	CDHBS4T0S0 KC5025	B184
1937506	CDHBS4T004 KC5010	B184
1937507	CDHBS4T004 KC5025	B184
1937508	CDHBS4T004 KT315	B184
1937509	CDHBS4T002 KC5010	B184
1937510	CDHBS4T002 KC5025	B184
1937511	CDHBS4T002 KT315	B184
1937512	CDHHS4T002L KC5010	B184
1937513	CDHHS4T002R KC5010	B184
1937514	CDHHS4T002L KC5025	B184
1937515	CDHHS4T002R KC5025	B184
1937516	CDHHS4T002L KT315	B184
1937517	CDHHS4T002R KT315	B184
1937518	CDHHS4T004L KC5010	B184
1937519	CDHHS4T004R KC5010	B184
1937520	CDHHS4T004L KC5025	B184
1937530	GPCD050102 KC5025	B222
1937532	TDHB07T12S0 KC5010	B249
1937534	TDHB07T12S0 KT315	B249
1937535	TDHB07T1202 KC5010	B249
1937536	TDHB07T1202 KC5025	B249
1937538	TDHB07T1204 KC5010	B249
1937539	TDHB07T1204 KC5025	B249
1937540	TDHB07T1204 KT315	B249
1937542	TDHB07T1208 KC5025	B249
1937544	TDHH07T1202L KC5010	B249
1937550	TDHH07T1204L KC5010	B249
1937562	WPGTS30101UF KC5010	B272
1937563	WPGTS30102UF KC5010	B272
1937571	TPCB110202 KC5010	B253
1937580	TPCG110202L KC5010	B253
1937586	TPCG110204L KC5010	B253
1937592	TPCG110208L KC5010	B253
1937598	TPCH110202 KC5010	B253
1937601	TPCH110204 KC5010	B253
1937615	TPCB160302 KC5010	B253
1937618	TPCB160304 KC5010	B253
1937621	TPCB160308 KC5010	B253
1937645	TPGH160308 KC5010	B253
1939528	B977A09700 KC7315	G140
1940731	HTSR10CI	J67
1940732	HTSR11CI	J67
1940738	B513S08000 A30	J68
1940739	B513S08000 AS3	J68
1940740	B513S10000 A30	J68
1940741	B513S10000 AS3	J68
1940783	HTSR12CI	J67
1940784	HTSR13CI	J67
1940785	HTSR14CI	J67
1940786	HTSR10CE	J67
1940787	HTSR11CE	J67
1940788	HTSR12CE	J67
1940789	HTSR13CE	J67
1940790	HTSR14CE	J67
1940958	CNMG120408RP KC5010	B53
1940959	CNMG120416RP KC5010	B53
1940961	CNMG160612RP KC5010	B53
1940965	DNMG150408RP KC5010	B81
1940967	DNMG150416RP KC5010	B81
1940968	DNMG150608RP KC5010	B81
1940971	SNMG120408RP KC5010	B101
1940972	SNMG120412RP KC5010	B101
1940975	SNMG190612RP KC5010	B101
1940977	TNMG160408RP KC5010	B128
1940979	TNMG220408RP KC5010	B128
1940984	VNMG160408RP KC5010	B147
1940986	WNMG080408RP KC5010	B159
1940987	WNMG080412RP KC5010	B159
1941189	B977A12800 KC7315	G141
1941190	B977A15800 KC7315	G142
1942326	HTSR043R025M	J67
1942327	HTSR049R028M	J67
1942328	HTSR052R028M	J67
1942450	B978A12800 KC7315	G148
1942715	193.397	J67
1949633	A4SMR1616K0314	C112
1949634	A4SML1616K0314	C113
1949635	A4SMR2020K0314	C112
1949636	A4SML2020K0314	C113
1949637	A4SMR2525M0317	C112
1949638	A4SML2525M0317	C113
1949639	A4SMR2020K0414	C112
1949640	A4SML2020K0414	C113
1949641	A4SMR2525M0417	C112
1949642	A4SML2525M0417	C113
1949643	A4SMR3225P0417	C112
1949644	A4SML3225P0417	C113
1949645	A4SMR2020K0519	C112
1949646	A4SML2020K0519	C113
1949647	A4SMR2525M0520	C112
1949648	A4SML2525M0520	C113
1949649	A4SMR3225P0522	C112
1949650	A4SML3225P0522	C113
1949651	A4ENN2020K0407	C118
1949652	A4ENN2525M0407	C118
1949654	A4ENN2525M0509	C118
1949655	A20RA4EMR0307M	C119
1949656	A20RA4EML0307M	C119
1949657	A25RA4EMR0310M	C119
1949658	A25RA4EML0310M	C119
1949659	A32SA4EMR0312M	C119
1949660	A32SA4EML0312M	C119
1949661	A20RA4EMR0407M	C119
1949662	A20RA4EML0407M	C119
1949663	A25RA4EMR0410M	C119
1949664	A25RA4EML0410M	C119
1949665	A32SA4EMR0412M	C119
1949666	A32SA4EML0412M	C119
1949667	A40TA4EMR0416M	C119
1949668	A40TA4EML0416M	C119
1949669	A32SA4EMR0516M	C119
1949670	A32SA4EML0516M	C119
1949671	A40TA4EMR0516M	C119
1949672	A40TA4EML0516M	C119
1950709	SECW1404AESNGN KY3500	S43
1950974	B978F06800 KC7315	G149
1950975	B978F10200 KC7315	G149
1952700	A4G0305M03U02GMN KC5010	C96
1952701	A4G0305M03U02GMN KC5025	C96
1952702	A4G0305M03U04GMN KC5010	C96
1952733	A4G0305M03U04GMN KC5025	C96
1952734	A4G0405M04U04GMN KC5010	C96
1952735	A4G0405M04U04GMN KC5025	C96
1952736	A4G0405M04U08GMN KC5010	C96
1952737	A4G0405M04U08GMN KC5025	C96
1952738	A4G0505M05U04GMN KC5010	C96
1952740	A4G0505M05U08GMN KC5010	C96
1952742	A4G0305M03U02GMP KT315	C95
1952743	A4G0305M03U02GMP KC5010	C95
1952744	A4G0305M03U02GMP KC5025	C95
1952745	A4G0305M03U04GMP KT315	C95
1952746	A4G0305M03U04GMP KC5010	C95
1952747	A4G0305M03U04GMP KC5025	C95
1952748	A4G0405M04U04GMP KT315	C95
1952749	A4G0405M04U04GMP KC5010	C95
1952750	A4G0405M04U04GMP KC5025	C95
1952751	A4G0405M04U08GMP KT315	C95
1952752	A4G0405M04U08GMP KC5010	C95
1952753	A4G0405M04U08GMP KC5025	C95
1952755	A4G0505M05U04GMP KC5010	C95
1952758	A4G0505M05U08GMP KC5010	C95
1952760	A4G0300M03P02GMP KC5010	C95
1952762	A4G0300M03P04GMP KC5010	C95
1952763	A4G0300M03P04GMP KC5025	C95
1952764	A4G0400M04P02GMP KC5010	C95
1952765	A4G0400M04P02GMP KC5025	C95
1952766	A4G0400M04P04GMP KC5010	C95
1952767	A4G0400M04P04GMP KC5025	C95
1952768	A4G0400M04P08GMP KC5010	C95
1952769	A4G0400M04P08GMP KC5025	C95
1952771	A4G0500M05P04GMP KC5025	C95
1952773	A4G0500M05P08GMP KC5025	C95
1952774	A4R0405M04U00GMN KC5010	C97
1952775	A4R0405M04U00GMN KC5025	C97
1952776	A4R0505M05U00GMN KC5010	C97
1952777	A4R0505M05U00GMN KC5025	C97
1952778	A4R0400M04P00GMP KC5010	C96
1952779	A4R0400M04P00GMP KC5025	C96
1952780	A4R0500M05P00GMP KC5010	C96
1952847	A4C0305N00CF02 KC5025	C102
1952848	A4C0305R06CF02 KC5025	C103
1952849	A4C0305L06CF02 KC5025	C103
1953085	A4G0300M03P02GMP K313	C95
1953086	A4G0300M03P04GMP K313	C95
1953087	A4G0400M04P02GMP K313	C95
1953088	A4G0400M04P04GMP K313	C95
1953090	A4G0500M05P04GMP K313	C95
1953091	A4G0500M05P08GMP K313	C95
1953092	A4R0400M04P00GMP K313	C96
1953153	A4R0500M05P00GMP K313	C96
1956732	MDHX1004ZDERGD4W KC520M	S69
1957573	MS2090	C118
1957789	B966A05900 KC7315	G132
1959586	B977F11800 KC7315	G144
1959664	B977A05600 KC7315	G139
1959665	B977A03300 KC7315	G138
1959666	B977A06900 KC7315	G139
1960078	B977A14900 KC7315	G141
1960079	B977A15100 KC7315	G141
1961106	B976A09700 KC7315	G140
1961108	B966A03200 KC7315	G132
1962704	B977F06900 KC7315	G144
1962705	B977F05600 KC7315	G143
1962706	B977F03300 KC7315	G143
1963407	DFR200R4WD32M	J12
1963864	QC26	B250
1967470	SN7T	W40
1969942	B966F06400 KC7315	G135
1970003	B966F08400 KC7315	G135
1970761	B977F05100 KC7315	G143
1971584	B978A09750 KC7315	G147
1971763	B977A08900 KC7315	G140
1972376	B966A13200 KC7315	G134
1974209	SPHX090310R20 KC7215	J99
1975006	B977A05200 KC7315	G139
1980539	BGHX15L504PCFRGG K110M	S149
1981264	BGHX15L508PCFRGG K110M	S149
1981677	50A05RS90SP10DG	T98
1981678	63A06RS90SP10DG	T98
1981679	25A02R039B25SSP10G	T97
1981758	BGHX15L515PCFRGG K110M	S149
1981759	BGHX15L515PCFRGG KC510M	S149
1981788	32A03R039B32SSP10G	T97
1981790	40A04R049B32SSP10G	T97
1981853	80A08RS90SP10DG	T98
1981854	100B10RS90SP10DG	T98
1982315	DFT030204HP KMF	J87
1982316	DFT030304HP KMF	J87
1982318	MDHX1004ZDFLGD4W K110M	S69
1982397	B966A06200 KC7315	G132
1982560	200C12RP90BG15C12WHPM	S146
1983309	3.42805R081 KC7215	I27
1983310	3.42807R081 KC7215	I27
1983992	CCMT120408LF KC5025	B177
1984003	CCMT09T308MF KC5025	B177
1984183	B976A05200 KC7315	G139
1984545	B978A11200 KC7315	G147
1985037	B966A06700 KC7315	G133
1985038	B966A08200 KC7315	G133
1985751	KLM34L9IP	B59, B85, B132, B149–150, B161
1985784	KMSP315IP	B59, B85, B89–90, B132, B137, B149–150, B152, B161
1985792	TTP9	U27–35
1985985	B978A10800 KC7315	G147
1986652	B977A08200 KC7315	G140
1986773	B976A06200 KC7315	G139
1987659	SPHX1205PCSRGPB KCK15	S77
1988099	B966A06900 KC7315	G133
1988100	B966A07900 KC7315	G133
1988291	B977F08100 KC7315	G144
1988931	B977A05700 KC7315	G139
1988932	B976A05300 KC7315	G139
1988983	B976A08700 KC7315	G140
1989347	A4M50L0314M	C124
1989348	A4M50R0314M	C124
1989349	A4M50L0414M	C124
1989350	A4M50R0414M	C124
1989351	A4M50L0519M	C124
1989352	A4M50R0519M	C124
1989874	B977F10800 KC7315	G144
1990689	SECW1404AEENGNW KC725M	S43
1991229	B966A12600 KC7315	G134
1992230	B977A07700 KC7315	G140
1992232	B966A10400 KC7315	G133
1992822	B105A04600 K10	G32
1993391	KSEM136R1WN16F45M	H63
1993392	KSEM146R1WN20F45M	H63
1993403	KSEM181R1WN25F45M	H63
1993404	KSEM221R1WN25F45M	H63
1993405	KSEM261R1WN32F45M	H63
1993406	KSEM281R1WN32F45M	H63
1993407	KSEM301R1WN32F45M	H63
1993408	KSEM321R1WD50F45M	H63
1993409	KSEM361R1WD50F45M	H63
1993552	THW2M	T58–59, V72, V78, V137–139
1994080	FAS100302GD KC7215	H33
1994291	TTP20	S53, V153–154
1995000	B966A05100 KC7315	G132
1995002	B966A08600 KC7315	G133
1995073	B966A09400 KC7315	G133
1995074	B966A10100 KC7315	G133
1995075	B966A11400 KC7315	G134
1995076	B966A12100 KC7315	G134
1995580	F4AJ0600AWS50L090 KC633M	P145
1995581	F4AJ0800AWM50L120 KC633M	P145
1995582	F4AJ1000AWM50L150 KC633M	P145
1995585	F4AJ1600AWL50L240 KC633M	P145
1995586	F4AJ2000AWL50L300 KC633M	P145
1995587	F5AJ2500AWX50L380 KC633M	P145
1995588	F4AJ0600AWS50R025 KC633M	P144
1995589	F4AJ0600AWS50R050 KC633M	P144
1995590	F4AJ0800AWM50R050 KC633M	P144
1995591	F4AJ0800AWM50R100 KC633M	P144
1995592	F4AJ1000AWL50R050 KC633M	P144

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
1995593	F4AJ1000AWL50R100 KC633M	P144
1995594	F4AJ1200AWL50R050 KC633M	P144
1995595	F4AJ1200AWL50R150 KC633M	P144
1995596	F4AJ1600AWL50R050 KC633M	P144
1995597	F4AJ1600AWL50R150 KC633M	P144
1995598	F4AJ2000AWX50R050 KC633M	P144
1995599	F4AJ2000AWX50R200 KC633M	P144
1996057	F2AL0100AWL30 KC637M	P148
1996058	F2AL0150AWL30 KC637M	P148
1996059	F2AL0200AWL30 KC637M	P148
1996060	F2AL0300AWL30 KC637M	P148
1996061	F2AL0400AWL30 KC637M	P148
1996062	F2AL0500AWL30 KC637M	P148
1996063	F2AL0600AWL30 KC637M	P148
1996064	F2AL0800AWL30 KC637M	P148
1996065	F2AL1000AWM30 KC637M	P148
1996066	F2AL1200AWM30 KC637M	P148
1996067	F2AL1600AWM30 KC637M	P148
1996068	F2AL0600AWM30 KC637M	P149
1996069	F2AL0800AWM30 KC637M	P149
1996070	F2AL1000AWL30 KC637M	P149
1996071	F2AL1200AWX30 KC637M	P149
1996072	F2AL1600AWX30 KC637M	P149
1996084	F2AL0050AWS30 KC637M	P165
1996087	F2AL0100AWS30 KC637M	P165
1996089	F2AL0150AWS30 KC637M	P165
1996090	F2AL0200AWS30 KC637M	P165
1996091	F2AL0250AWS30 KC637M	P165
1996092	F2AL0300AWS30 KC637M	P165
1996155	F6AV0600ADL45 KC637M	P146
1996156	F6AV0800ADL45 KC637M	P146
1996157	F6AV1000ADL45 KC637M	P146
1996158	F6AV1200ADL45 KC637M	P146
1996159	F6AV1600ADL45 KC637M	P146
1996160	F8AV2000ADL45 KC637M	P146
1996161	F6AV0600AWM45 KC637M	P146
1996162	F6AV0800AWM45 KC637M	P146
1996183	F6AV1000AWL45 KC637M	P146
1996184	F6AV1200AWL45 KC637M	P146
1996185	F6AV1600AWX45 KC637M	P146
1996186	F8AV2000AWX45 KC637M	P146
1996187	F8AV2500AWX45 KC637M	P146
1996188	F8AV2500ADL45 KC637M	P146
1996211	F4AL0300AWL30L040 KC637M	P151
1996212	F4AL0300AWM30L040 KC637M	P151
1996213	F4AL0400AWL30L050 KC637M	P151
1996214	F4AL0400AWM30L050 KC637M	P151
1996215	F4AL0500AWL30L060 KC637M	P151
1996216	F4AL0500AWM30L060 KC637M	P151
1996217	F4AL0600AWL30L080 KC637M	P151
1996218	F4AL0600AWM30L080 KC637M	P151
1996219	F4AL0800AWL30L120 KC637M	P151
1996220	F4AL0800AWX30L120 KC637M	P151
1996221	F4AL1000AWL30L150 KC637M	P151
1996222	F4AL1000AWX30L150 KC637M	P151
1996223	F2AL0200AWM20 KC637M	P147
1996224	F2AL0300AWM20 KC637M	P147
1996225	F2AL0400AWL20 KC637M	P147
1996226	F2AL0500AWL20 KC637M	P147
1996227	F2AL0600AWL20 KC637M	P147
1996228	F2AL0800AWL20 KC637M	P147
1996229	F2AL1000AWL20 KC637M	P147
1996230	F2AL1200AWX20 KC637M	P147
1996243	F2AT0200AWM20R005 KC637M	P142
1996244	F2AT0300AWM20R005 KC637M	P142
1996245	F2AT0400AWL20R005 KC637M	P142
1996246	F2AT0500AWL20R005 KC637M	P142
1996247	F2AT0600AWL20R010 KC637M	P142
1996248	F2AT0800AWL20R020 KC637M	P142
1996249	F2AT1000AWL20R030 KC637M	P142
1996276	F2AT0200AWM20R003 KC637M	P142
1996277	F2AT0300AWM20R010 KC637M	P142
1996278	F2AT0400AWL20R010 KC637M	P142
1996279	F2AT0500AWL20R010 KC637M	P142
1996280	F2AT0600AWL20R005 KC637M	P142
1996281	F2AT0800AWL20R010 KC637M	P142
1996282	F2AT1000AWL20R020 KC637M	P142
1996283	F2AT1200AWX20R030 KC637M	P142
1997389	B966A08100 KC7315	G133
1997391	B966A11800 KC7315	G134
1998276	CNGA120404E KD1405	B344
1998277	CNGA120408E KD1405	B344
1998279	CNMS120408E KD1405	B345
1998280	DNGA150404E KD1405	B346
1998287	VNMS160404E KD1405	B350
1998288	VNMS160408E KD1405	B350
1998291	CPGW060204E KD1405	B345
1998293	CPGW09T304E KD1405	B345
1998296	DPGW11T304E KD1405	B347
1998302	VBGW160408E KD1405	B349
1998336	A4G0300M03P04E KD1405	B352, C100
1998337	A4G0400M04P04E KD1405	B352, C100
1998338	A4G0500M05P08E KD1405	B352, C100
1998340	A4R0500M05P00E KD1405	B352, C101
1998358	63A06RP00MD10CF	S68
1998359	63A04RP00MD10CF	S68
1998947	B966A09600 KC7315	G133
2001853	B977F06100 KC7315	G144
2006399	12748308500	S94
2008288	12748601000	S32–33
2016107	80A10RF45HN09C	S89
2016109	100B14RF45HN09C	S89
2016111	125B18RF45HN09C	S89
2016133	160C22RF45HN09C	S89
2016165	80A62RF60HN09C	S94
2016167	100B82RF60HN09C	S94
2016169	125B123RF60HN09C	S94
2016171	160C164RF60HN09C	S94
2016193	200C205RF60HN09C	S94
2018142	12748358200	S89, S94, S102–103, S110
2018164	12748500200	S95
2018166	12748500400	S95
2018285	12148006000	T24
2018296	MS2260	V60
2018679	12148068700	K111–113
2029553	12148044900	S32–33, S89, S94, S102–103, S110
2032259	12748600900	S89, S94, S102–103
2033468	12748503400	S95
2033774	63A03RP90BG15CM	S143
2033852	360.660	H64
2033863	360.661	H64
2033865	360.663	H64
2033866	360.664	H64
2033867	360.665	H64
2033868	360.666	H64
2033869	360.667	H64
2033870	360.668	H64
2033871	360.669	H64
2033872	360.670	H64
2034084	MDHX1004ZDFLGD4W KC520M	S69
2035319	DFR190R4WD32M	J12
2035688	OFPT07L6AFSNHB KC725M	S55
2035689	OFPT07L6AFENGB KC725M	S55
2036154	B976A08100 KC7315	G140
2036529	KSEM1700HPM KC7315	H40
2036530	KSEM2200HPM KC7315	H40
2036531	KSEM1750HPM KC7315	H40
2036532	KSEM2000HPM KC7315	H40
2036604	KSEM3200HPM KC7315	H41
2036605	KSEM1400HPM KC7315	H40
2036606	KSEM1500HPM KC7315	H40
2036607	KSEM2250HPM KC7315	H40
2036608	KSEM1600HPM KC7315	H40
2036609	KSEM2600HPM KC7315	H41
2036612	KSEM2650HPM KC7315	H41
2036703	KSEM3300HPM KC7315	H41
2036704	KSEM2700HPM KC7315	H41
2036705	KSEM2100HPM KC7315	H40
2036706	KSEM2050HPM KC7315	H40
2036882	KSEM1800HPM KC7315	H40
2036903	KSEM2300HPM KC7315	H40
2036904	KSEM2400HPM KC7315	H40
2036905	KSEM3000HPM KC7315	H41
2036906	KSEM1250HPM KC7315	H40
2036907	KSEM1450HPM KC7315	H40
2036909	KSEM1300HPM KC7315	H40
2036910	KSEM2500HPM KC7315	H40
2036911	KSEM1650HPM KC7315	H40
2036912	KSEM3900HPM KC7315	H41
2036923	KSEM2900HPM KC7315	H41
2036924	KSEM1350HPM KC7315	H40
2036953	KSEM3050HPM KC7315	H41
2036954	KSEM1560HPM KC7315	H40
2036955	KSEM1900HPM KC7315	H40
2036956	KSEM2150HPM KC7315	H40
2036957	KSEM3500HPM KC7315	H41
2037058	B966A06400 KC7315	G133
2037059	B967A10000 KC7315	G133
2038613	B966A06050 KC7315	G132
2038795	B977F15200 KC7315	G145
2040139	DFR220R4WD32M	J12
2040680	B977A04300 KC7315	G139
2040682	B966A03900 KC7315	G132
2041877	B977F03700 KC7315	G143
2043136	B966A10600 KC7315	G133
2043137	B966A11600 KC7315	G134
2043415	B978A05700 KC7315	G146
2043417	B977A10600 KC7315	G141
2043418	B977A14600 KC7315	G141
2043552	KSEM3950HPM KC7315	H41
2043779	B977A06100 KC7315	G139
2044606	B978A11800 KC7315	G147
2044834	B976A19700 KC7315	G142
2045222	B966A05300 KC7315	G132
2045293	DFT030204HP KC7140	J87
2045294	DFT030304HP KC7140	J87
2045616	B978A11400 KC7315	G147
2045646	KSEM2950HPM KC7315	H41
2045820	B977A12300 KC7315	G141
2045822	B977A11600 KC7315	G141
2045867	B976A16800 KC7315	G142
2046287	B977F14200 KC7315	G145
2047379	KSEM1270HPM KC7315	H40
2047380	KSEM1280HPM KC7315	H40
2047382	KSEM1310HPM KC7315	H40
2047393	KSEM1320HPM KC7315	H40
2047395	KSEM1370HPM KC7315	H40
2047396	KSEM1380HPM KC7315	H40
2047397	KSEM1389HPM KC7315	H40
2047398	KSEM1410HPM KC7315	H40
2047399	KSEM1420HPM KC7315	H40
2047400	KSEM1429HPM KC7315	H40
2047401	KSEM1440HPM KC7315	H40
2047403	KSEM1468HPM KC7315	H40
2047404	KSEM1480HPM KC7315	H40
2047405	KSEM1508HPM KC7315	H40
2047406	KSEM1530HPM KC7315	H40
2047408	KSEM1550HPM KC7315	H40
2047409	KSEM1570HPM KC7315	H40
2047410	KSEM1580HPM KC7315	H40
2047411	KSEM1609HPM KC7315	H40
2047412	KSEM1620HPM KC7315	H40
2047413	KSEM1627HPM KC7315	H40
2047414	KSEM1667HPM KC7315	H40
2047415	KSEM1707HPM KC7315	H40
2047416	KSEM1746HPM KC7315	H40
2047417	KSEM1786HPM KC7315	H40
2047418	KSEM1826HPM KC7315	H40
2047419	KSEM1850HPM KC7315	H40
2047420	KSEM1865HPM KC7315	H40
2047421	KSEM1905HPM KC7315	H40
2047422	KSEM1927HPM KC7315	H40
2047423	KSEM1950HPM KC7315	H40
2047424	KSEM1984HPM KC7315	H40
2047425	KSEM2024HPM KC7315	H40
2047426	KSEM2064HPM KC7315	H40
2047427	KSEM2143HPM KC7315	H40
2047428	KSEM2183HPM KC7315	H40
2047429	KSEM2223HPM KC7315	H40
2047430	KSEM2244HPM KC7315	H40
2047431	KSEM2342HPM KC7315	H40
2047432	KSEM2350HPM KC7315	H40
2047433	KSEM2381HPM KC7315	H40
2047434	KSEM2450HPM KC7315	H40
2047435	KSEM2461HPM KC7315	H40
2047436	KSEM2540HPM KC7315	H40
2047437	KSEM2550HPM KC7315	H40
2047438	KSEM2567HPM KC7315	H40
2047439	KSEM2619HPM KC7315	H41
2047440	KSEM2659HPM KC7315	H41
2047441	KSEM2750HPM KC7315	H41
2047442	KSEM2778HPM KC7315	H41
2047443	KSEM2800HPM KC7315	H41
2047444	KSEM2818HPM KC7315	H41
2047445	KSEM2850HPM KC7315	H41
2047446	KSEM2858HPM KC7315	H41
2047447	KSEM2937HPM KC7315	H41
2047448	KSEM2977HPM KC7315	H41
2047449	KSEM3100HPM KC7315	H41
2047450	KSEM3150HPM KC7315	H41
2047451	KSEM3175HPM KC7315	H41
2047452	KSEM3250HPM KC7315	H41
2047453	KSEM3334HPM KC7315	H41
2047456	KSEM3400HPM KC7315	H41
2047458	KSEM3550HPM KC7315	H41
2047460	KSEM3600HPM KC7315	H41
2047464	KSEM3750HPM KC7315	H41
2047465	KSEM3800HPM KC7315	H41
2047466	KSEM3810HPM KC7315	H41
2047468	KSEM3850HPM KC7315	H41
2047469	KSEM4000HPM KC7315	H41
2047470	KSEM1588HPM KC7315	H40
2047471	KSEM1945HPM KC7315	H40
2047472	KSEM3016HPM KC7315	H41
2047474	KSEM3096HPM KC7315	H41
2047477	KSEM3413HPM KC7315	H41
2047478	KSEM3493HPM KC7315	H41
2047587	B978F15000 KC7315	G149
2047698	OFPT07L6AFSNHB KC522M	S55
2047701	OFPT07L6AFENGB KC522M	S55
2047751	B977F08600 KC7315	G144
2049487	B977A05100 KC7315	G139
2049488	B977A11800 KC7315	G141
2049489	B977A12200 KC7315	G141
2049505	B977F05550 KC7315	G143
2050081	MS2111	C166–169, D27–30, D36
2050230	B978A09800 KC7315	G147
2057426	MTFNL12CA16	B139
2071739	MSSNL12CA12	B117
2071758	MSSNL10CA09	B117
2072222	MSKNR20CA15	B115
2074429	MTFNR16CA16	B139
2074430	MSKNR16CA12	B115
2074432	MSRNR16CA12	B116
2074433	MCFNR16CA12	B70
2074904	MSTNR12CA12	B118
2077947	MCLNL12CA12	B72
2078231	MSRNR12CA12	B116
2078236	MTFNR12CA16	B139
2079654	NG3189R KC5010	C154
2114011	MSKNR10CA09	B115
2114013	MSKNR12CA12	B115
2114015	MSYNR10CA09	B119
2114034	CTFPL10CA11	B378
2114041	MTGNR12CA16	B140
2116588	CTFPR10CA11	B378
2193621	MTFNL16CA16	B139
2202438	KRBB10FABDRS204C	K74, K96
2202439	KRBB10SCLDR4060C	K74, K96
2202440	KRBB10SCFPR06085C	K74, K96
2202450	KRBB10SCFPR06110C	K74, K97
2202451	KRBB10SCFPR06135C	K74, K97
2202510	B977A05300 KC7315	G139
2203486	B966A08400 KC7315	G133
2203489	B977A03900 KC7315	G138
2203577	B977A12600 KC7315	G141
2203579	B977A07100 KC7315	G139
2203787	B977A16200 KC7315	G142
2203834	B977A08700 KC7315	G140
2204113	B977F21000 KC7315	G145
2204114	B977F06700 KC7315	G144
2204116	B966A13300 KC7315	G134
2204393	CBTF150R2WD20N2M	J98
2204394	CBTF160R2WD20N2M	J98
2204395	CBTF170R2WD20N2M	J98
2204396	CBTF200R2WD20N2M	J98
2204397	CBTF210R2WD20N2M	J98
2204398	CBTF210R2WD20N3M	J98
2204399	CBTF220R2WD20N2M	J98
2204400	CBTF230R2WD20N3M	J98
2204401	CBTF250R2WD20N3M	J98

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
2204402	CBTF340R2WD32N3M	J98
2204403	CBTF350R2WD32N3M	J98
2204404	CBTF380R2WD32N3M	J98
2204405	CBTF180R2WD20N2M	J98
2204406	CBTF230R2WD20N2M	J98
2204407	CBTF250R2WD20N2M	J98
2204408	CBTF240R2WD20N3M	J98
2204409	CBTF270R2WD20N3M	J98
2209877	B976F05100 KC7315	G143
2210084	LNEQ1245R04 KCPK30	U20
2210086	LNEU1245R04 KCPK30	U19
2210095	SDET1204PDSRGB KCPK30	T105, T112, U51
2210766	OFPT07L6AFSNHB KCPK30	S55
2210767	OFPT07L6AFENGB KCPK30	S55
2210826	40A02RP90BG15CM	S143
2210827	50A03RP90BG15CM	S143
2210828	80A03RP90BG15CM	S143
2210829	100B04RP90BG15CM	S143
2210830	125B05RP90BG15CM	S143
2210831	160C06RP90BG15CM	S143
2212773	OFKT07L6AFSNHB KC522M	S55
2213696	B966A03300 KC7315	G132
2213700	B966A04300 KC7315	G132
2213701	B966A04400 KC7315	G132
2213726	B977F05300 KC7315	G143
2213842	193.409	S53, V153
2213947	WNMG060408RP KC5010	B159
2213962	CCMT120412MF KC5025	B177
2214237	B978A15200 KC7315	G148
2214926	B966A11300 KC7315	G133
2215328	B976F05200 KC7315	G143
2217005	B966A07700 KC7315	G133
2217646	NTB3L12B KC5010	D20
2217647	NTB3R12B KC5010	D20
2217898	B976A13300 KC7315	G141
2218437	SNHX1103T KCPK30	U14
2218492	B977A09200 KC7315	G140
2219248	B977F06200 KC7315	G144
2220306	LNEQ1245R04 KCK15	U20
2220307	LNEQ1250R04 KCK15	U20
2220308	LNEQ1255R04 KCK15	U20
2220309	LNEQ1260R04 KCK15	U20
2220334	SPGN090308 KCK15	B169
2220598	F3AH0050AWS30 KC635M	P164
2220599	F3AH0060AWS30 KC635M	P164
2220600	F3AH0080AWS30 KC635M	P164
2220601	F3AH0100AWS30 KC635M	P164
2220602	F3AH0120AWS30 KC635M	P164
2220633	F3AH0150AWS30 KC635M	P164
2220651	F3AH0200AWS30 KC635M	P164
2220652	F3AH0250AWS30 KC635M	P164
2220653	F3AH0300AWS30 KC635M	P164
2220714	MDHX1004ZDERGD KC520M	S69
2220855	B966A06100 KC7315	G132
2220856	B966A06600 KC7315	G133
2220857	B966A14800 KC7315	G134
2221944	OFPT07L6AFENGB KCK15	S55
2221945	OFPT07L6AFSNHB KCK15	S55
2222651	B976A08600 KC7315	G140
2224587	B976A05600 KC7315	G139
2224588	B976A09100 KC7315	G140
2226032	VNMG160404MS K313	B146
2226630	B976A14100 KC7315	G141
2226662	B977A12900 KC7315	G141
2227124	3.90016SNGB KCPK30	U9
2227125	3.90016SNGD KCPK30	U9
2227126	3.90022SNGB KCPK30	U9
2227127	3.90022SNGD KCPK30	U9
2227128	3.90030SNGB KCPK30	U9
2227129	3.90030SNGD KCPK30	U9
2227130	3.90040SNGB KCPK30	U9
2227131	3.90040SNGD KCPK30	U9
2227145	SNHX1102PZTNGP KCPK30	U15
2227147	SNHX1203PZTNGP KCPK30	U15
2227149	SNHX12L4PZTNGP KCPK30	U15
2227150	SNHX12L5PZTNGP KCPK30	U15
2227155	SPHX1205PCERGPB KCPK30	S77
2227156	SPHX1205PCERGN1WB KCPK30	S78
2227157	SPHX1205PCSRGPB KCPK30	S77
2227159	SPHX1205ZCERGP KCPK30	S73
2227160	SPHX1205ZCSRGP KCPK30	S73
2227161	SPHX15T6PCERGP KCPK30	S83
2227162	SPHX15T6PCSRGP KCPK30	S83
2227164	SPHX15T6ZCERGP KCPK30	S80
2227165	SPHX15T6ZCSRGP KCPK30	S80
2227264	B977F08200 KC7315	G144
2227338	B966A10300 KC7315	G133
2227374	OFKT07L6AFENGB KC520M	S55
2227380	OFKT07L6AFSNHB KC520M	S55
2227984	B976A12800 KC7315	G141
2228362	B977A05900 KC7315	G139
2229054	B977A19200 KC7315	G142
2229055	B966A10800 KC7315	G133
2229138	B977A13300 KC7315	G141
2229285	THW3M	U27–35, U40–49
2229362	B256A16000 KC7315	G63
2229364	B256A13500 KC7315	G63
2229365	B256A11000 KC7315	G63
2229366	B256A14000 KC7315	G63
2229393	B256A08800 KC7315	G63
2229412	OFKT07L6AFSNHB KCPK30	S55
2229543	OFKT07L6AFENGB KC522M	S55
2229547	CNGG120404FS KC5010	B46
2229549	CNGG120404FS KC5025	B46
2229550	CNGG120408FS KC5010	B46
2229551	CNGG120408FS KC5025	B46
2229552	DNGG150402FS KC5010	B74
2229644	DNGG150404FS KC5010	B74
2229645	DNGG150404FS KC5025	B74
2229646	DNGG150408FS KC5010	B74
2229648	CNMG120402MS KC5010	B52
2229649	CNMG120402MS KC5025	B52
2229651	CNMG120401MS KC5010	B52
2229652	CNMG120401MS KC5025	B52
2229653	CNMG120404MS K313	B52
2229654	CNMG120404MS KC5010	B52
2229655	CNMG120404MS KC5025	B52
2229656	CNMG120408MS K313	B52
2229657	CNMG120408MS KC5010	B52
2229659	CNMG120408MS KC5025	B52
2229660	DNMG150404MS K313	B79
2229661	DNMG150404MS KC5010	B79
2229662	DNMG150404MS KC5025	B79
2229693	DNMG150408MS K313	B79
2229694	DNMG150408MS KC5010	B79
2229695	DNMG150408MS KC5025	B79
2229696	VNMG160404MS KC5010	B146
2229697	VNMG160404MS KC5025	B146
2230052	B978F12000 KC7315	G149
2230406	B977A14200 KC7315	G141
2230539	B977A06700 KC7315	G139
2231579	B966A07200 KC7315	G133
2231776	B976A06600 KC7315	G139
2231777	B976A08300 KC7315	G140
2231778	B976A09600 KC7315	G140
2231830	B966A12300 KC7315	G134
2233364	B977A16600 KC7315	G142
2234423	OFKT07L6AFENGB KCPK30	S55
2234816	A4C0405N00CF02 KC5025	C102
2234819	A4C0305R10CF02 KC5025	C103
2234821	A4C0405R10CF02 KC5025	C103
2234823	A4R0305M03U00GMN KC5025	C97
2234824	A4R0305M03U00GMN KC5010	C97
2234825	A4R0300M03P00GMP KC5025	C96
2234826	A4R0300M03P00GMP KC5010	C96
2235124	B978A19840 KC7315	G148
2235210	A4R0300M03P00GMP K313	C96
2236065	B977A08400 KC7315	G140
2239620	DCMT11T308FW KT315	B207
2239685	DCMT11T304FW KC5010	B207
2240351	B977A10300 KC7315	G140
2240426	HNEN0905XNSN KY3500	S92, S98
2240427	HNEN0905AMSN KY3500	S92, S98
2242390	B966A05600 KC7315	G132
2242780	B978A06600 KC7315	G146
2244229	B977A08100 KC7315	G140
2244276	B977A18800 KC7315	G142
2244883	CNMG120412MS KC5010	B52
2244884	CNMG120416MS KC5010	B52
2244885	CNMG160608MS KC5010	B52
2244886	CNMG160612MS KC5010	B52
2244887	CNMG190608MS KC5010	B52
2244888	CNMG190612MS KC5010	B52
2244891	DNMG150402MS KC5010	B79
2244892	DNMG150412MS KC5010	B79
2244893	DNMG150604MS KC5010	B79
2244894	DNMG150608MS KC5010	B79
2244896	SNMG120408MS KC5010	B99
2244897	SNMG120412MS KC5010	B99
2244901	TNMG160402MS KC5010	B126
2244902	TNMG160404MS KC5010	B126
2244903	TNMG160408MS KC5010	B126
2244904	TNMG220404MS KC5010	B126
2244905	TNMG220408MS KC5010	B126
2244910	VNMG160401MS KC5010	B146
2244911	VNMG160402MS KC5010	B146
2244912	VNMG160408MS KC5010	B146
2244913	VNMG220404MS KC5010	B146
2244914	VNMG220408MS KC5010	B146
2244916	WNMG080402MS KC5010	B158
2244917	WNMG080404MS KC5010	B158
2244918	WNMG080408MS KC5010	B158
2244919	CNMG120412MS KC5025	B52
2244920	CNMG120416MS KC5025	B52
2244921	CNMG160608MS KC5025	B52
2244922	CNMG160612MS KC5025	B52
2244923	CNMG190608MS KC5025	B52
2244924	CNMG190612MS KC5025	B52
2244929	DNMG150604MS KC5025	B79
2244930	DNMG150608MS KC5025	B79
2244931	DNMG150612MS KC5025	B79
2244932	SNMG120408MS KC5025	B99
2244936	SNMG190612MS KC5025	B99
2244937	TNMG160402MS KC5025	B126
2244938	TNMG160404MS KC5025	B126
2244939	TNMG160408MS KC5025	B126
2244940	TNMG220404MS KC5025	B126
2244941	TNMG220408MS KC5025	B126
2244943	TNMG270608MS KC5025	B126
2244947	VNMG160402MS KC5025	B146
2244948	VNMG160408MS KC5025	B146
2244950	VNMG220408MS KC5025	B146
2244953	WNMG080404MS KC5025	B158
2244954	WNMG080408MS KC5025	B158
2244955	CNMG120412MS K313	B52
2244958	CNMG160612MS K313	B52
2244965	DNMG150604MS K313	B79
2244966	DNMG150608MS K313	B79
2244977	TNMG220408MS K313	B126
2244981	TNMG270616MS K313	B126
2244983	VNMG160402MS K313	B146
2244984	VNMG160408MS K313	B146
2244989	WNMG080404MS K313	B158
2244990	WNMG080408MS K313	B158
2245036	TNMG220432RP KC5010	B128
2245037	TNMG270612RP KC5010	B128
2245045	CNMG120408RP KC5025	B53
2245046	CNMG120412RP KC5025	B53
2245048	CNMG160608RP KC5025	B53
2245049	CNMG160612RP KC5025	B53
2245050	CNMG160616RP KC5025	B53
2245051	CNMG190612RP KC5025	B53
2245053	DNMG150408RP KC5025	B81
2245056	DNMG150608RP KC5025	B81
2245059	SNMG120408RP KC5025	B101
2245060	SNMG120412RP KC5025	B101
2245063	SNMG190612RP KC5025	B101
2245064	SNMG190616RP KC5025	B101
2245065	TNMG160408RP KC5025	B128
2245066	TNMG160412RP KC5025	B128
2245067	TNMG220408RP KC5025	B128
2245074	VNMG160408RP KC5025	B147
2245076	WNMG080408RP KC5025	B159
2245079	DNMG110408RP KC5010	B81
2245088	SNMG120416RP KC5025	B101
2245191	B977A09900 KC7315	G140
2245263	B977A15900 KC7315	G142
2245484	A4SMR2525M0620	C112
2245485	A4SMR2525M0820	C112
2245486	A4SML2525M0620	C113
2245487	A4SML2525M0820	C113
2245738	SPHX060202R20 KC7215	J99
2245739	SPHX060206R20 KC7215	J99
2245740	SPHX060208R20 KC7215	J99
2245741	SPHX070302R20 KC7215	J99
2245742	SPHX070306R20 KC7215	J99
2245833	SPHX070308R20 KC7215	J99
2245834	SPHX070312R20 KC7215	J99
2245836	SPHX090312R20 KC7215	J99
2245837	SPHX090316R20 KC7215	J99
2245839	SPHX120410R20 KC7215	J99
2245840	SPHX120416R20 KC7215	J99
2245841	SPHX120420R20 KC7215	J99
2245843	SPHX150512R20 KC7215	J99
2245844	SPHX150516R20 KC7215	J99
2245845	SPHX150520R20 KC7215	J99
2245846	SPHX060202R21 KC7215	J100
2245847	SPHX060206R21 KC7215	J100
2245848	SPHX060208R21 KC7215	J100
2245849	SPHX070306R21 KC7215	J100
2245851	SPHX070310R21 KC7215	J100
2245853	SPHX090310R21 KC7215	J100
2245854	SPHX090312R21 KC7215	J100
2245855	SPHX090316R21 KC7215	J100
2245856	SPHX120408R21 KC7215	J100
2245857	SPHX120410R21 KC7215	J100
2245858	SPHX120416R21 KC7215	J100
2245859	SPHX120420R21 KC7215	J100
2245860	SPHX070310R20 KC7215	J99
2245861	SPHX120412R20 KC7215	J99
2245862	SPHX120412R21 KC7215	J100
2245972	HNEN090508MSN KY3500	S92, S98
2246044	A4G0605M06U08GMP KC5025	C95
2246045	A4G0605M06U08GMP KC5010	C95
2246047	A4G0600M06P08GMP KC5025	C95
2246074	TPMT110204LF KC5025	B255
2246494	SECT1404AEFNLE KC410M	S42
2248306	B966A14300 KC7315	G134
2248735	420.104	S68
2248993	50HC030M	G85
2248994	50HC050M	G85
2248995	75HC030M	G85
2248996	75HC040M	G85
2248997	75HC050M	G85
2249180	B978A09700 KC7315	G147
2250771	CNGG120401FS KC5010	B46
2250772	CNGG120402FS KC5010	B46
2250775	DNGG110402FS KC5010	B74
2250784	TNGG160404FS KC5010	B122
2250789	VNGG160402FS KC5010	B143
2250790	VNGG160404FS KC5010	B143
2250791	VNGG160408FS KC5010	B143
2250809	TNGG160402FS KC5025	B122
2250810	TNGG160404FS KC5025	B122
2250816	VNGG160404FS KC5025	B143
2250817	VNGG160408FS KC5025	B143
2250824	B966A05200 KC7315	G132
2251337	B977F09100 KC7315	G144
2251340	B977F10100 KC7315	G144
2251521	SSP025018M	B66, B105–106
2251639	B977A13800 KC7315	G141
2251799	B966F05300 KC7315	G135
2251802	B966F08200 KC7315	G135
2252989	KSEM1250PCM KC7135	H56
2252992	KSEM1750PCM KC7135	H56
2253024	KSEM2600PCM KC7135	H56, H87
2255896	B978A08800 KC7315	G147
2256128	NGP2062R KC5010	C152
2256252	B966A09900 KC7315	G133
2256916	B966A04700 KC7315	G132
2256918	B977A10800 KC7315	G141
2257597	B256A10500 KC7315	G63
2257646	B256A09500 KC7315	G63
2258040	KTIP080R5SS10M	H31
2258041	KTIP100R5SS12M	H31
2258042	KTIP120R5SS14M	H31
2258053	KTIP160R5SS18M	H31
2259958	170.306	H31–32
2259959	170.307	H31–32
2259960	170.308	H31–32
2259961	170.309	H31–32
2259981	MS2126	T69–72
2260660	B977F08700 KC7315	G144
2261701	B978A06100 KC7315	G146

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
2262952	RK90SP1014	U27, U30, U32, U34
2262954	RK90SP1016	U31, U35
2262956	RK90SD1218	U40, U42, U44, U48
2262957	LK90SD1218	U41
2262958	RK90SD1220	U43, U45, U49
2262959	LK90SD1220	U47
2262960	W14	U27–28, U30, U32–34
2262961	W16	U29, U31, U35
2262962	W18	U40–42, U44, U46, U48
2262963	W20	U43, U45, U47, U49
2262964	CP1416	U27–35
2262965	CP1820	U40–49
2263089	A4SMR3225P0626	C112
2263090	A4SML3225P0626	C113
2263091	A4SMR3225P0826	C112
2263092	A4SML3225P0826	C113
2263173	A4SMR3225P1026	C112
2263174	A4SML3225P1026	C113
2263197	A40TA4EMR0616M	C119
2263198	A40TA4EML0616M	C119
2263299	MS1490	C37–40, C44–45, C112–113, D32
2263361	A4G0605M06U04GMN KC5010	C96
2263362	A4G0605M06U04GMN KC5025	C96
2263373	A4G0605M06U08GMN KT315	C96
2263374	A4G0605M06U08GMN KC5010	C96
2263375	A4G0605M06U08GMN KC5025	C96
2263376	A4G0605M06U12GMN KC5010	C96
2263377	A4G0605M06U12GMN KC5025	C96
2263378	A4G0805M08U08GMN KC5010	C96
2263380	A4G0805M08U12GMN KC5010	C96
2263383	A4G1005M10U08GMN KC5025	C96
2263385	A4G1005M10U12GMN KC5025	C96
2263386	A4G0605M06U04GMP KC5010	C95
2263387	A4G0605M06U04GMP KC5025	C95
2263392	A4G0805M08U08GMP KC5025	C95
2263397	A4R0605M06U00GMN KC5010	C97
2263398	A4R0605M06U00GMN KC5025	C97
2263399	A4R0805M08U00GMN KC5010	C97
2263400	A4R0805M08U00GMN KC5025	C97
2263403	A4R0600M06P00GMP KC5010	C96
2263404	A4R0600M06P00GMP KC5025	C96
2263406	A4R0800M08P00GMP KC5010	C96
2263414	A4G0600M06P04GMP KC5010	C95
2263415	A4G0600M06P08GMP KC5010	C95
2263416	A4G0800M08P08GMP KC5010	C95
2263578	RCGH120400 KC5010	B222
2263727	B978A15100 KC7315	G148
2263756	B977F06600 KC7315	G144
2264017	B977A16700 KC7315	G142
2264019	B977A07200 KC7315	G140
2264020	B977A11100 KC7315	G141
2264538	B976A05400 KC7315	G139
2264864	B977F15800 KC7315	G145
2264867	B966F03400 KC7315	G135
2264869	B966F03600 KC7315	G135
2264876	B977F10300 KC7315	G144
2264881	B977F13800 KC7315	G145
2264885	B977F04900 KC7315	G143
2264889	B978A05300 KC7315	G146
2264892	B966F17000 KC7315	G136
2264893	B966F18000 KC7315	G136
2264897	B976F08600 KC7315	G144
2264898	B976F08700 KC7315	G144
2264901	B978A15800 KC7315	G148
2264903	B977F04300 KC7315	G143
2264905	B977F10400 KC7315	G144
2264912	B976F10800 KC7315	G144
2264915	B977F09900 KC7315	G144
2264918	B966F16500 KC7315	G136
2264920	B966F17500 KC7315	G136
2264921	B977F05200 KC7315	G143
2264928	B978A06200 KC7315	G146
2264931	B977F04700 KC7315	G143
2264932	B977F05400 KC7315	G143
2264933	B978A05100 KC7315	G146
2264934	B978A05200 KC7315	G146
2264936	B966F10800 KC7315	G136
2264938	B978A10100 KC7315	G147
2264939	B978A10300 KC7315	G147
2264941	B976F08300 KC7315	G144
2264952	B977F05900 KC7315	G144
2264953	B978A08100 KC7315	G147
2264954	B978A08600 KC7315	G147
2264955	B978A08700 KC7315	G147
2264956	B978A09900 KC7315	G147
2264958	B966F09100 KC7315	G135
2264970	B978A06300 KC7315	G146
2264971	B978A06400 KC7315	G146
2264972	B978A06700 KC7315	G146
2264973	B966F05100 KC7315	G135
2264976	B976F06300 KC7315	G144
2264977	B976F06400 KC7315	G144
2264978	B976F07100 KC7315	G144
2264981	B977F04100 KC7315	G143
2264983	B977F05700 KC7315	G143
2264985	B966F10400 KC7315	G135
2264986	B966F10600 KC7315	G135
2264988	B966F11800 KC7315	G136
2264990	B966F06700 KC7315	G135
2264996	B976F05600 KC7315	G143
2265002	B966F06300 KC7315	G135
2265003	B966F07300 KC7315	G135
2265006	B966F05600 KC7315	G135
2265008	B977F06400 KC7315	G144
2265022	B966F07100 KC7315	G135
2265023	B966F07600 KC7315	G135
2266804	B966A03960 KC7315	G132
2268303	KTIP080R3SS10M	H31
2268304	KTIP085R3SS10M	H31
2268305	KTIP090R3SS10M	H31
2268306	KTIP095R3SS10M	H31
2268307	KTIP100R3SS12M	H31
2268308	KTIP105R3SS12M	H31
2268309	KTIP110R3SS12M	H31
2268310	KTIP115R3SS12M	H31
2268311	KTIP120R3SS14M	H31
2268312	KTIP125R3SS14M	H31
2268313	KTIP130R3SS14M	H31
2268314	KTIP135R3SS14M	H31
2268315	KTIP140R3SS16M	H31
2268316	KTIP145R3SS16M	H31
2268317	KTIP150R3SS16M	H31
2268318	KTIP160R3SS18M	H31
2269913	DT9IP	T4–7, T47–50, T57–59, T97–98, U25–26, V38–40
2269914	DT15IP	S41, T14–17, T69–72, T102, U38–39, V70–72, V77–78, V137–139
2270351	114.305	E49, E55
2271064	EDPT180516PDERGD KC725M	T74
2271067	EDPT180516PDERGD KC522M	T74
2271071	EDPT180516PDERGD KCPK30	T74
2271072	EDPT180532PDERGD KC725M	T74
2271087	EDCT180504PDERGD KC725M	T74
2271088	EDCT180504PDFRLDJ KC410M	T73
2271089	EDCT180508PDFRLDJ KC410M	T73
2271090	EDCT180516PDFRLDJ KC410M	T73
2271091	EDCT180532PDFRLDJ KC410M	T73
2271092	EDCT180564PDFRLDJ KC410M	T73
2271093	EDCT180516PDERLD KC522M	T74
2271094	EDCT180532PDERLD KC522M	T74
2271095	EDCT180564PDERLD KC522M	T74
2271097	EDPT180524PDERGD KC725M	T74
2271115	EDPT180532PDERGD KC522M	T74
2271116	EDPT180532PDERGD KC520M	T74
2271118	EDPT180532PDERGD KCPK30	T74
2271119	EDPT180508PDERGD KC725M	T74
2271122	EDPT180508PDERGD KC520M	T74
2271135	EDPT180508PDERGD KCPK30	T74
2271155	EDPT180564PDERGD KC725M	T74
2271157	EDPT180564PDERGD KC522M	T74
2271158	EDPT180564PDERGD KCPK30	T74
2271159	EDPT180512PDERGD KC725M	T74
2272493	B977A11900 KC7315	G141
2272784	3.42805R021 KC7015	I27
2272786	3.42805R021 KC7315	I27
2272789	3.42807R021 KC7015	I27
2272790	3.42807R021 KC7315	I27
2273083	DCKNR2020K12KC04	B58
2273084	DCKNR3225P12KC04	B58
2273085	DCKNR3232P16KC06	B58
2273087	DCKNL2020K12KC04	B58
2273088	DCKNL3225P12KC04	B58
2273091	DCLNR3232P19KC06	B59
2273092	DCLNR4040S19KC06	B59
2273093	DCLNL3232P19KC06	B59
2273094	DCLNL4040S19KC06	B59
2273095	DCRNR3225P12KC04	B60
2273097	DCRNR3232P19KC06	B60
2273099	DCRNL3232P16KC06	B60
2273101	DCSNR2020K12KC04	B60
2273102	DCSNR2525M12KC04	B60
2273104	DCSNL2525M12KC04	B60
2273105	DDJNR2020K11KC04	B85
2273106	DDJNR2525M11KC04	B85
2273107	DDJNL2020K11KC04	B85
2273108	DDJNL2525M11KC04	B85
2273111	DDNNR2020K15KC06	B85
2273112	DDNNR2525M15KC06	B85
2273139	DSDNN3232P19KC06	B105
2273156	DSSNR3225P12KC04	B107
2273318	B966A03100 KC7315	G132
2273321	B966A09200 KC7315	G133
2273388	EDPT180548PDERGD KC725M	T74
2273392	DTFNR2020K16KC04	B132
2273440	DTGNR2020K16KC04	B132
2273441	DTGNR2525M16KC04	B132
2273451	DWLNR2525M06KC04	B161
2273455	DWLNL2525M06KC04	B161
2274469	NG2062R KC5010	C154
2274946	A4G125I03P05GMN KC5025	C97
2274947	A4G125I03P1GMN KC5025	C97
2274949	A4G187I04P2GMN KC5025	C97
2275076	A4R125I03P00GMN KC5025	C97
2275077	A4R187I04P00GMN KC5025	C97
2275078	A4R250I06P00GMN KC5025	C97
2275080	A4R375I10P00GMN KC5025	C97
2275081	A4G125I03P05GMN KC5010	C97
2275082	A4G125I03P1GMN KC5010	C97
2275083	A4G187I04P1GMN KC5010	C97
2275084	A4G187I04P2GMN KC5010	C97
2275085	A4G250I06P1GMN KC5010	C97
2275086	A4G250I06P2GMN KC5010	C97
2275087	A4G312I08P1GMN KC5010	C97
2275089	A4G375I10P1GMN KC5010	C97
2275090	A4G375I10P2GMN KC5010	C97
2275091	A4R125I03P00GMN KC5010	C97
2275092	A4R187I04P00GMN KC5010	C97
2275093	A4R250I06P00GMN KC5010	C97
2275452	B978A19800 KC7315	G148
2275583	MS2148	T57–59, T97–98, U25–35
2276088	B976A04300 KC7315	G139
2276090	B977A18400 KC7315	G142
2276698	B977A18600 KC7315	G142
2277900	VBMT110304LF KC5025	B265
2383518	TPGX0902ZPRGD KC7315	H63
2383519	TPGX1102ZPRGD KC7315	H63
2383520	TPGX1303ZPRGD KC7315	H63
2383521	TPGX1603ZPRGD KC7315	H63
2383522	TPGX0902ZPRGD KC7140	H63
2383552	B977A06350 KC7315	G139
2383555	SDCT120404PDERLD2 KC725M	T104, T111, U51
2383556	SDCT120404PDELLD2 KC725M	T104, T111, U51
2383557	SDCT1204PDELLD2 KC725M	T104, T111, U51
2383558	SDCT120412PDERLD2 KC725M	T104, T111, U51
2383559	SDCT120412PDELLD2 KC725M	T104, T111, U51
2383560	SDCT120416ENLD2 KC725M	T104, T111, U51
2383561	SDCT120420ENLD2 KC725M	T104, T111, U51
2383562	SDCT120424ENLD2 KC725M	T104, T111, U51
2383583	SDCT120432ENLD2 KC725M	T104, T111, U51
2383584	SPCT10T304PPERLD2 KC725M	T100, U36
2383585	SPCT10T304PPELLD2 KC725M	T100, U36
2383586	SPCT10T3PPELLD2 KC725M	T100, U36
2383587	SPCT10T312PPERLD2 KC725M	T100, U36
2383588	SPCT10T312PPELLD2 KC725M	T100, U36
2383589	SPCT10T316ENLD2 KC725M	T100, U36
2383590	SPCT10T320ENLD2 KC725M	T100, U36
2383591	SDCT120404PDFRLE KC410M	T103, T110, U50, V141
2383592	SDCT120404PDFLLE KC410M	T103, T110, U50, V141
2383593	SDCT1204PDFRLE KC410M	T103, T110, U50, V141
2383594	SDCT1204PDFLLE KC410M	T103, T110, U50, V141
2383595	SDCT120412PDFRLE KC410M	T103, T110, U50, V141
2383596	SDCT120412PDFLLE KC410M	T103, T110, U50, V141
2383597	SDCT120416FNLE KC410M	T103, T110, U50, V141
2383598	SDCT120420FNLE KC410M	T103, T110, U50, V141
2383599	SDCT120424FNLE KC410M	T103, T110, U50, V141
2383600	SDCT120432FNLE KC410M	T103, T110, U50, V141
2383601	SPCT10T304PPFRLE KC410M	T99, U36
2383602	SPCT10T304PPFLLE KC410M	T99, U36
2383603	SPCT10T3PPFRLE KC410M	T99, U36
2383604	SPCT10T3PPFLLE KC410M	T99, U36
2383605	SPCT10T312PPFRLE KC410M	T99, U36
2383608	SPCT10T320FNLE KC410M	T99, U36
2383778	B977A06400 KC7315	G139
2384123	TPGX1102ZPRGD KC7140	H63
2384124	TPGX1303ZPRGD KC7140	H63
2384125	TPGX1603ZPRGD KC7140	H63
2384430	B977A12100 KC7315	G141
2384504	STN1018UNI KC635M	W44
2384505	STN1020UNI KC635M	W44
2384509	STN1114UNI KC635M	W44
2384510	STN1116UNI KC635M	W44
2384511	STN1118UNI KC635M	W44
2384512	STN1120UNI KC635M	W44
2384513	STN1124UNI KC635M	W44
2384517	STN1614UNI KC635M	W44

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
2384521	STN1624UNI KC635M	W44
2384522	STN1627UNI KC635M	W44
2384524	STN1632UNI KC635M	W44
2385356	B976A05100 KC7315	G139
2385527	F2AL0050AWS30L050 KC637M	P166
2385528	F2AL0060AWS30L060 KC637M	P166
2385529	F2AL0080AWS30L080 KC637M	P166
2385530	F2AL0100AWS30L100 KC637M	P166
2385531	F2AL0120AWS30L120 KC637M	P166
2385553	F2AL0150AWS30L150 KC637M	P166
2385554	F2AL0160AWS30L160 KC637M	P166
2385555	F2AL0180AWS30L180 KC637M	P166
2385556	F2AL0200AWS30L200 KC637M	P166
2385557	F2AL0250AWS30L250 KC637M	P166
2385558	F2AL0300AWS30L300 KC637M	P166
2385559	F2AL0400AWS30L400 KC637M	P166
2385560	F2AL0600AWS30L600 KC637M	P166
2385561	F2AH0030AWS30L040 KC637M	P162–163
2385563	F2AH0050AWS30L070 KC637M	P162–163
2385566	F2AH0100AWS30L150 KC637M	P162–163
2385569	F2AH0150AWS30L230 KC637M	P162–163
2385570	F2AH0160AWS30L240 KC637M	P162–163
2385571	F2AH0180AWS30L270 KC637M	P162–163
2385572	F2AH0200AWS30L300 KC637M	P162–163
2385573	F2AH0250AWS30L370 KC637M	P162–163
2385576	F2AH0080AWM30L120 KC637M	P162–163
2385577	F2AH0100AWM30L150 KC637M	P162–163
2385580	F2AH0150AWM30L230 KC637M	P162–163
2385581	F2AH0160AWM30L240 KC637M	P162–163
2385582	F2AH0180AWM30L270 KC637M	P162–163
2385583	F2AH0200AWM30L300 KC637M	P162–163
2385584	F2AH0250AWM30L370 KC637M	P162–163
2386665	B977A19700 KC7315	G142
2388424	DT8IP	W4–5, W10–13, W17–19, W24–25
2388660	SKRN1203M0 K9	B227–228
2388784	B976A10800 KC7315	G141
2389802	PMT04525	C63, C133
2390123	B977A08300 KC7315	G140
2390253	SDCT1204PDERLD2 KC725M	T104, T111, U51
2390254	SPCT10T3PPERLD2 KC725M	T100, U36
2390256	SECT1404AEENLD2 KC725M	S42
2390257	SEKT1404AEENGP2 KC725M	S42
2390258	SEKT1404AEENGP2 KC520M	S42
2390259	SEKT1404AEENGP2 KCK15	S42
2390260	SEKT1404AEENGP2 KCPK30	S42
2390261	SEKT1404AESNGP2 KC725M	S42
2390262	SEKT1404AESNGP2 KC520M	S42
2390263	SEKT1404AESNGP2 KCK15	S42
2390264	SEKT1404AESNGP2 KCPK30	S42
2390265	SPET10T3PPELGB2 KC725M	T100, U37
2390266	SPET10T3PPELGB2 KCK15	T100, U37
2390267	SPET10T3PPELGB2 KCPK30	T100, U37
2390268	SPET10T3PPELGB2 KC520M	T100, U37
2390269	SPET10T3PPSLGB2 KC725M	T100, U37
2390271	SPET10T3PPSLGB2 KCPK30	T100, U37
2390273	SPET10T3PPERGB2 KC725M	T100, U37
2390274	SPET10T3PPERGB2 KCK15	T100, U37
2390275	SPET10T3PPERGB2 KCPK30	T100, U37
2390276	SPET10T3PPERGB2 KC520M	T100, U37
2390277	SPET10T3PPSRGB2 KC725M	T100, U37
2390278	SPET10T3PPSRGB2 KCK15	T100, U37
2390279	SPET10T3PPSRGB2 KCPK30	T100, U37
2390280	SPET10T3PPSRGB2 KC520M	T100, U37
2390281	SDET1204PDELGB2 KC520M	T104, T111, U52
2390282	SDET1204PDELGB2 KCK15	T104, T111, U52
2390283	SDET1204PDELGB2 KCPK30	T104, T111, U52
2390284	SDET1204PDELGB2 KC725M	T104, T111, U52
2390285	SDET1204PDERGB2 KC520M	T104, T111, U52
2390286	SDET1204PDERGB2 KCK15	T104, T111, U52
2390287	SDET1204PDERGB2 KCPK30	T104, T111, U52
2390288	SDET1204PDERGB2 KC725M	T104, T111, U52
2390289	SDET1204PDSRGB2 KC520M	T104, T111, U52
2390290	SDET1204PDSRGB2 KCK15	T104, T111, U52
2390291	SDET1204PDSRGB2 KCPK30	T104, T111, U52
2390292	SDET1204PDSRGB2 KC725M	T104, T111, U52
2390293	SDET120412PDELGB2 KC520M	T104, T111, U52
2390294	SDET120412PDELGB2 KCK15	T104, T111, U52
2390296	SDET120412PDELGB2 KC725M	T104, T111, U52
2390297	SDET120412PDERGB2 KC520M	T104, T111, U52
2390298	SDET120412PDERGB2 KCK15	T104, T111, U52
2390299	SDET120412PDERGB2 KCPK30	T104, T111, U52
2390300	SDET120412PDERGB2 KC725M	T104, T111, U52
2390446	25A02R044B25SED18	T70
2390448	32A03R050B32SED18	T70
2390450	40A04R050B32SED18	T70
2390483	63A06RS90ED18D	T72
2390485	100A08RS90ED18D	T72
2390486	125B09RS90ED18D	T72
2390487	160C12RS90ED18D	T72
2390961	B976A08200 KC7315	G140
2391872	B977A17700 KC7315	G142
2391902	B966A06350 KC7315	G133
2391925	B966A05040 KC7315	G132
2392360	B976A03800 KC7315	G138
2392361	B976A03900 KC7315	G138
2393422	STN1118UNE KC635M	W44
2393667	STN1624UNE KC635M	W44
2393668	STN1620UNE KC635M	W44
2393670	STN1616UNE KC635M	W44
2393671	STN1614UNE KC635M	W44
2396971	B977A04900 KC7315	G139
2397289	B976A17100 KC7315	G142
2397687	B976A04900 KC7315	G139
2397689	B976A07900 KC7315	G140
2397765	KLM68L25IP	B59–60, B105
2397767	KMSP625IP	B59–60, B105
2398751	A4M50R0314B036048	C127
2398752	A4M50R0314B042058	C127
2398763	A4M50R0314B052074	C127
2398764	A4M50R0314B068100	C127
2398765	A4M50R0314B090160	C127
2398766	A4M50R0314B130300	C127
2398767	A4M50R0314B290999	C127
2398768	A4M50L0314B036048	C128
2398769	A4M50L0314B042058	C128
2398770	A4M50L0314B052074	C128
2398771	A4M50L0314B068100	C128
2398772	A4M50L0314B090160	C128
2398773	A4M50L0314B130300	C128
2398774	A4M50L0314B290999	C128
2398775	A4M50R0414B048072	C127
2398776	A4M50R0414B064100	C127
2398777	A4M50R0414B092150	C127
2398778	A4M50R0414B132300	C127
2398779	A4M50R0414B290999	C127
2398780	A4M50L0414B048072	C128
2398781	A4M50L0414B064100	C128
2398782	A4M50L0414B092150	C128
2398783	A4M50L0414B132300	C128
2398784	A4M50L0414B290999	C128
2398785	A4M50R0519B058094	C127
2398786	A4M50R0519B080136	C127
2398787	A4M50R0519B120300	C127
2398788	A4M50R0519B250999	C127
2398789	A4M50L0519B058094	C128
2398790	A4M50L0519B080136	C128
2398791	A4M50L0519B120300	C128
2398792	A4M50L0519B250999	C128
2399462	KM25NER230	D30
2399494	KM25NER330	D30
2399495	KM25NEL330	D30
2399496	KM25NER430	D30
2399497	KM25NEL430	D30
2399498	KM25NSR230	D30
2399499	KM25NSL230	D30
2399500	KM25NSR330	D30
2399501	KM25NSL330	D30
2399503	KM25NSL430	D30
2399504	KM25LSSR1630	D83
2399505	KM25LSSL1630	D83
2399506	KM25LSER1630	D83
2399507	KM25LSEL1630	D83
2400403	F2AB0200AWM30 KC637M	P150
2400404	F2AB0300AWM30 KC637M	P150
2400405	F2AB0400AWL30 KC637M	P150
2400406	F2AB0500AWL30 KC637M	P150
2400407	F2AB0600AWL30 KC637M	P150
2400409	F2AB1000AWL30 KC637M	P150
2400410	F2AB1200AWX30 KC637M	P150
2400693	50A3RS90SD12L32	T109
2400694	63A3RS90SD12L50	T109
2400695	80A4RS90SD12L61	T109
2401853	B977A13100 KC7315	G141
2402283	KTIP085R5SS10M	H31
2402284	KTIP090R5SS10M	H31
2402285	KTIP095R5SS10M	H31
2402286	KTIP105R5SS12M	H31
2402287	KTIP110R5SS12M	H31
2402288	KTIP115R5SS12M	H31
2402289	KTIP125R5SS14M	H31
2402290	KTIP130R5SS14M	H31
2402291	KTIP135R5SS14M	H31
2402292	KTIP140R5SS16M	H31
2402293	KTIP145R5SS16M	H31
2402294	KTIP150R5SS16M	H31
2403807	B966A08300 KC7315	G133
2404108	B976A14200 KC7315	G141
2404433	B978A11700 KC7315	G147
2404438	B966A06300 KC7315	G133
2404444	STN10075ISOI KC635M	W45
2404445	STN10100ISOI KC635M	W45
2404446	STN10125ISOI KC635M	W45
2404447	STN10150ISOI KC635M	W45
2404449	STN11100ISOI KC635M	W45
2404451	STN11150ISOI KC635M	W45
2404454	STN16100ISOI KC635M	W45
2404456	STN16150ISOI KC635M	W45
2404457	STN16175ISOI KC635M	W45
2404458	STN16200ISOI KC635M	W45
2404472	MDHX1004ZDERGD4W K110M	S69
2404707	A4G0305M03U02B KC5025	C98
2404708	A4G0405M04U04B KC5025	C98
2404943	MDHX1004ZDERGD K110M	S69
2404944	MDHX1004ZDERGD KTPK20	S69
2404945	F3AA1000AWL45R050 K600	P122
2404946	F3AA1200AWL45R050 K600	P122
2404947	F3AA1600AWX45R050 K600	P122
2404948	F3AA2000AWX45R050 K600	P122
2404949	F3AA2500AWX45R050 K600	P122
2404950	F3AA1000AWL45R100 K600	P122
2404951	F3AA1200AWL45R100 K600	P122
2404952	F3AA1600AWX45R100 K600	P122
2405161	KTIP080R3SCF12M	H32
2405162	KTIP085R3SCF12M	H32
2405203	KTIP090R3SCF12M	H32
2405204	KTIP095R3SCF12M	H32
2405205	KTIP100R3SCF16M	H32
2405206	KTIP105R3SCF16M	H32
2405207	KTIP110R3SCF16M	H32
2405208	KTIP115R3SCF16M	H32
2405209	KTIP120R3SCF16M	H32
2405210	KTIP125R3SCF16M	H32
2405211	KTIP130R3SCF16M	H32
2405212	KTIP135R3SCF16M	H32
2405213	KTIP140R3SCF16M	H32
2405214	KTIP145R3SCF16M	H32
2405215	KTIP150R3SCF20M	H32
2405216	KTIP160R3SCF20M	H32
2405248	KTIP080R5SCF12M	H32
2405249	KTIP085R5SCF12M	H32
2405250	KTIP090R5SCF12M	H32
2405251	KTIP095R5SCF12M	H32
2405252	KTIP100R5SCF16M	H32
2405273	KTIP105R5SCF16M	H32
2405274	KTIP110R5SCF16M	H32
2405275	KTIP115R5SCF16M	H32
2405276	KTIP120R5SCF16M	H32
2405277	KTIP125R5SCF16M	H32
2405278	KTIP130R5SCF16M	H32
2405279	KTIP135R5SCF16M	H32
2405280	KTIP140R5SCF16M	H32
2405281	KTIP145R5SCF16M	H32
2405282	KTIP150R5SCF20M	H32
2405283	KTIP160R5SCF20M	H32
2405361	SEPT1404AEENGB2 KC725M	S43
2405362	SEPT1404AEENGB2 KCK15	S43
2405373	SEPT1404AEENGB2 KCPK30	S43
2405375	SEPT1404AESNGB2 KC725M	S43
2405376	SEPT1404AESNGB2 KCK15	S43
2405377	SEPT1404AESNGB2 KCPK30	S43
2405379	SPPT10T3PPERGB2 KCK15	T101, U37
2405380	SPPT10T3PPERGB2 KCPK30	T101, U37
2405381	SPPT10T3PPSRGB2 KCK15	T101, U37
2405382	SPPT10T3PPSRGB2 KCPK30	T101, U37
2405383	SPPT10T3PPSRGB2 KTPK20	T101, U37
2405384	SDPT1204PDERGB2 KC725M	T105, T112, U52
2405385	SDPT1204PDERGB2 KCK15	T105, T112, U52

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
2405386	SDPT1204PDERGB2 KCPK30	T105, T112, U52
2405387	SDPT1204PDSRGB2 KC725M	T105, T112, U52
2405388	SDPT1204PDSRGB2 KCK15	T105, T112, U52
2405389	SDPT1204PDSRGB2 KCPK30	T105, T112, U52
2405616	KSEM3200PCM KC7135	H56, H87
2405618	KSEM4000PCM KC7135	H56, H87
2406113	F3AA2000AWX45R100 K600	P122
2406114	F3AA2500AWX45R100 K600	P122
2406115	F3AA1000AWL45R200 K600	P122
2406116	F3AA1200AWL45R200 K600	P122
2406117	F3AA1600AWX45R200 K600	P122
2406118	F3AA2000AWX45R200 K600	P122
2406119	F3AA2500AWX45R200 K600	P122
2406120	F3AA1000AWL45R400 K600	P122
2406121	F3AA1200AWL45R400 K600	P122
2406122	F3AA1600AWX45R400 K600	P122
2406123	F3AA2000AWX45R400 K600	P122
2406124	F3AA2500AWX45R400 K600	P122
2407294	B977A10100 KC7315	G140
2407297	B978A07700 KC7315	G147
2408209	B977A09400 KC7315	G140
2408266	B966A03400 KC7315	G132
2408308	B976A09200 KC7315	G140
2414136	A4ENN2020K0305	C118
2414137	A4ENN2525M0305	C118
2416198	B977A16400 KC7315	G142
2416279	B977A04100 KC7315	G138
2417183	50A05RS90ED18D	T72
2417184	80A07RS90ED18D	T72
2417185	50A04RS90ED18D	T72
2417186	63A05RS90ED18D	T72
2417187	80A06RS90ED18D	T72
2417188	100A07RS90ED18D	T72
2417189	125B08RS90ED18D	T72
2417190	160C10RS90ED18D	T72
2417191	40A03R050B32SED18	T70
2417296	DCLNR1616H09KC03	B59
2419790	B976A12300 KC7315	G141
2421384	SSY5T K9	D82, D84–85
2421386	SSA5T	D82, D84–85
2424997	B967A12500 KC7315	G134
2425000	B967A09000 KC7315	G133
2425052	B967A10800 KC7315	G133
2425073	B967A08500 KC7315	G133
2425113	B966A04100 KC7315	G132
2425114	B966A04900 KC7315	G132
2425115	B966A05400 KC7315	G132
2425117	B966A03600 KC7315	G132
2425118	B966A07100 KC7315	G133
2425119	B966A07300 KC7315	G133
2425120	B966A07600 KC7315	G133
2425143	B966A08700 KC7315	G133
2425145	B966A08900 KC7315	G133
2425146	B966A09100 KC7315	G133
2425149	B966A09700 KC7315	G133
2425151	B966A10900 KC7315	G133
2425173	B966A11100 KC7315	G133
2425176	B966A11900 KC7315	G134
2425178	B966A12200 KC7315	G134
2425203	B966A12400 KC7315	G134
2425205	B966A12800 KC7315	G134
2425206	B966A12900 KC7315	G134
2425233	B966A14200 KC7315	G134
2425285	B977A03000 KC7315	G138
2425288	B977A03100 KC7315	G138
2425290	B977A03200 KC7315	G138
2425292	B977A03400 KC7315	G138
2425303	B977A03500 KC7315	G138
2425304	B977A03600 KC7315	G138
2425305	B977A03700 KC7315	G138
2425306	B977A03800 KC7315	G138
2425309	B977A04400 KC7315	G139
2425310	B977A04700 KC7315	G139
2425311	B977A05400 KC7315	G139
2425323	B977A06200 KC7315	G139
2425324	B977A06300 KC7315	G139
2425325	B977A06600 KC7315	G139
2425326	B977A07300 KC7315	G140
2425328	B977A07900 KC7315	G140
2425330	B977A07600 KC7315	G140
2425331	B977A08600 KC7315	G140
2425332	B977A09100 KC7315	G140
2425344	B977A09600 KC7315	G140
2425380	B977A12400 KC7315	G141
2425381	B977A11400 KC7315	G141
2425455	B977A10400 KC7315	G140
2425456	B977A11300 KC7315	G141
2425457	B977A10900 KC7315	G141
2425659	CCMT060202LF KC5025	B177
2425660	CCMT060204LF KC5025	B177
2425661	CCMT060208LF KC5025	B177
2425662	CCMT09T302LF KC5025	B177
2425773	CCMT09T304LF KC5025	B177
2425775	CCMT120404LF KC5025	B177
2425779	CPMT050204LF KC5025	B190
2425780	CPMT060202LF KC5025	B190
2425781	CPMT060204LF KC5025	B190
2425782	CPMT060208LF KC5025	B190
2425784	CPMT09T304LF KC5025	B190
2425785	CPMT09T308LF KC5025	B190
2425786	DCMT070202LF KC5025	B207
2425788	DCMT150404LF KC5025	B207
2425789	DCMT150408LF KC5025	B207
2425790	DPMT070202LF KC5025	B215
2425791	DPMT070204LF KC5025	B215
2425793	DPMT11T304LF KC5025	B215
2425794	DPMT11T308LF KC5025	B215
2425795	SCMT09T304LF KC5025	B230
2425796	SCMT09T308LF KC5025	B230
2425798	SCMT120408LF KC5025	B230
2425800	SPMT09T304LF KC5025	B238
2425801	SPMT09T308LF KC5025	B238
2425802	TCMT110202LF KC5025	B244
2425803	TCMT110204LF KC5025	B244
2425804	TCMT110208LF KC5025	B244
2425805	TCMT16T302LF KC5025	B244
2425806	TCMT16T304LF KC5025	B244
2425807	TCMT16T308LF KC5025	B244
2425809	TCMT220408LF KC5025	B244
2425811	TPMT090204LF KC5025	B255
2425813	TPMT110208LF KC5025	B255
2425814	TPMT16T304LF KC5025	B255
2425815	TPMT16T308LF KC5025	B255
2425817	TPMT220408LF KC5025	B255
2425818	VBMT110308LF KC5025	B265
2425819	VBMT160402LF KC5025	B265
2425820	WPMTS3T104LF KC5025	B272
2425821	WPMT040204LF KC5025	B272
2425825	WCMT06T308LF KC5025	B270
2425826	CNMG120404RP KC5010	B53
2425828	CNMG120404RP KC5025	B53
2425841	DNGG150412FS KC5010	B74
2425843	DCMT070204LF KC5025	B207
2425844	DCMT11T302LF KC5025	B207
2425845	DCMT11T304LF KC5025	B207
2425846	DCMT11T308LF KC5025	B207
2425847	VBMT160404LF KC5025	B265
2425848	VBMT160408LF KC5025	B265
2425863	DNMG110408MS KC5010	B79
2425864	DNMG110408MS KC5025	B79
2425869	WNMG060408MS KC5010	B158
2425870	WNMG060408MS KC5025	B158
2425871	WNMG060408MS K313	B158
2426878	SDET1204PDSLGB2 KCPK30	T104, T111, U52
2426879	SDET1204PDSLGB2 KC725M	T104, T111, U52
2428744	B978A15300 KC7315	G148
2428793	B966F03300 KC7315	G135
2428802	B966F12100 KC7315	G136
2428856	B966F12200 KC7315	G136
2429563	STN1118NPT KC635M	W46
2429564	STN1614NPT KC635M	W46
2429565	STN16115NPT KC635M	W46
2429570	STN1118NPTF KC635M	W46
2429571	STN1614NPTF KC635M	W46
2429572	STN16115NPTF KC635M	W46
2429575	STN1614NPS KC635M	W46
2429576	STN16115NPS KC635M	W46
2429582	STN1119BSW KC635M	W46
2429587	STN1614BSW KC635M	W46
2429588	STN1612BSW KC635M	W46
2429589	STN1611BSW KC635M	W46
2429593	STN2711BSW KC635M	W46
2429600	514.111	B138
2429601	514.112	B142, B165
2429602	514.118	B87–88, B111, B113, B135, B138, B163
2429633	514.122	B68, B73, B114, B120–121
2429634	514.123	B64–66, B68–69, B73, B111–113, B135, B138, B163, B165
2429635	514.124	B114
2429636	514.125	B64–65, B68, B111–113
2429637	514.128	B87–88, B91
2429638	514.133	B64–66, B111–113
2429639	514.138	B111
2429642	F3AA1000AWL45R300 K600	P122
2429673	F3AA1200AWL45R300 K600	P122
2429674	F3AA1600AWX45R300 K600	P122
2429675	F3AA2000AWX45R300 K600	P122
2429676	F3AA2500AWX45R300 K600	P122
2429851	CNMG120408CT KC5010	B48
2429979	DNMG150404CT KC5010	B76
2429985	DNMG150408CT KC5010	B76
2430006	DNMG150612CT KC5010	B76
2430467	F2AA1000AWL45R050 K600	P120
2430468	F2AA1200AWL45R050 K600	P120
2430469	F2AA1600AWX45R050 K600	P120
2430470	F2AA2000AWX45R050 K600	P120
2430471	F2AA2500AWX45R050 K600	P120
2430472	F2AA1000AWL45R100 K600	P120
2430503	F2AA1200AWL45R100 K600	P120
2430504	F2AA1600AWX45R100 K600	P120
2430505	F2AA2000AWX45R100 K600	P120
2430506	F2AA2500AWX45R100 K600	P120
2430507	F2AA1000AWL45R200 K600	P120
2430508	F2AA1200AWL45R200 K600	P120
2430509	F2AA1600AWX45R200 K600	P120
2430510	F2AA2000AWX45R200 K600	P120
2430511	F2AA2500AWX45R200 K600	P120
2430512	F2AA1000AWL45R400 K600	P120
2430513	F2AA1200AWL45R400 K600	P120
2430514	F2AA1600AWX45R400 K600	P120
2430515	F2AA2000AWX45R400 K600	P120
2430516	F2AA2500AWX45R400 K600	P120
2430517	F2AA1000AWL45R300 K600	P120
2430518	F2AA1200AWL45R300 K600	P120
2430519	F2AA1600AWX45R300 K600	P120
2430520	F2AA2000AWX45R300 K600	P120
2430521	F2AA2500AWX45R300 K600	P120
2433330	F1AA0200AWS30 K600	P118
2433331	F1AA0300AWS30 K600	P118
2433332	F1AA0400AWS30 K600	P118
2433343	F1AA0500AWS30 K600	P118
2433344	F1AA0600AWS30 K600	P118
2433345	F1AA0800AWM30 K600	P118
2433346	F1AA1000AWM30 K600	P118
2433347	F1AA1200AWM30 K600	P118
2435131	B967A08000 KC7315	G133
2435183	WLLNR32CA19S	E55
2435184	WLLNL32CA19S	E55
2435185	WLLNR32CA30S	E55
2435186	WLLNL32CA30S	E55
2435187	WLFNR32CA19S	E55
2435188	WLFNL32CA19S	E55
2435196	KSEM3800PCM KC7135	H56, H87
2435297	CNMG120404P KC5010	B52
2435298	CNMG120408P KC5010	B52
2435299	CNMG120412P KC5010	B52
2435301	DNMG150404P KC5010	B81
2435302	DNMG150408P KC5010	B81
2435315	TNMG160404P KC5010	B127
2435320	VNMG160404P KC5010	B146
2435321	VNMG160408P KC5010	B146
2435322	WNMG080404P KC5010	B158
2435323	WNMG080408P KC5010	B158
2435325	DNMG150608P KC5010	B81
2436719	B978A11300 KC7315	G147
2436798	B978A16200 KC7315	G148
2438407	NG3125R KC5010	C154
2438408	NG3125R KC5025	C154
2438663	BGHX15L5PCERGGTM KD1410	S148
2438664	BGHX15L5PCTRHET KD1410	S148
2438665	BGHX15L504ERGET KD1415	S149
2439073	TRAOR2525M04	E65
2439075	TRAOR2525M06	E65
2439076	TRAOL2525M06	E65
2439077	TRAOR3225P06	E65
2439399	DVJNR2020K16KC04	B149
2439400	DVJNL2020K16KC04	B149
2439401	DVJNR2525M16KC04	B149
2439402	DVJNL2525M16KC04	B149
2439443	DVJNR3225P16KC04	B149
2439444	DVJNL3225P16KC04	B149
2439449	DVONR2020K16KC04	B150
2439450	DVONL2020K16KC04	B150
2439451	DVONR2525M16KC04	B150
2439452	DVONL2525M16KC04	B150
2439453	DVONR3225P16KC04	B150
2439454	DVONL3225P16KC04	B150
2439455	DVVNN2020K16KC04	B150
2439456	DVVNN2525M16KC04	B150
2439470	DWLNL2020K06KC04	B161
2439471	DWLNR2020K08KC04	B161
2439472	DWLNL2020K08KC04	B161
2439476	DWLNR2020K06KC04	B161
2440526	KTIP085R8SS10M	H31
2440527	KTIP160R8SS18M	H31
2441866	A25RDTFNR16KC04	B137
2441867	A25RDCLNR12KC04	B66
2441869	A25RDTFNL16KC04	B137
2441870	A32SDTFNR16KC04	B137
2441916	A32SDVUNR16KC04	B152
2441917	A32SDVUNL16KC04	B152
2441918	A40TDVUNR16KC04	B152
2441919	A40TDVUNL16KC04	B152
2441921	A25RDWLNR06KC04	B163
2441922	A25RDWLNL06KC04	B163
2441923	A25RDWLNR08KC04	B163
2441924	A25RDWLNL08KC04	B163
2441925	A32SDWLNR08KC04	B163
2441926	A32SDWLNL08KC04	B163
2441927	A40TDWLNR08KC04	B163
2441930	A25RDCLNL12KC04	B66
2441931	A32SDCLNR12KC04	B66
2441932	A32SDCLNL12KC04	B66
2441933	A40TDCLNR12KC04	B66
2441934	A40TDCLNL12KC04	B66
2441938	A40TDCLNL16KC06	B66
2441939	A25RDDUNR11KC04	B90
2441940	A25RDDUNL11KC04	B90
2441941	A32SDDUNR11KC04	B90
2441942	A32SDDUNL11KC04	B90
2441945	A32SDDUNR15KC06	B90
2441946	A32SDDUNL15KC06	B90
2441947	A40TDDUNR15KC06	B90
2441948	A40TDDUNL15KC06	B90
2441949	A50UDDUNR15KC06	B90
2441950	A50UDDUNL15KC06	B90
2441951	A25RDDQNR11KC04	B89
2441952	A25RDDQNL11KC04	B89
2441953	A32SDDQNR15KC06	B89
2441954	A32SDDQNL15KC06	B89
2441955	A40TDDQNR15KC06	B89
2441956	A40TDDQNL15KC06	B89
2441957	A25RDDPNR11KC04	B89
2441959	A32SDDPNR15KC06	B89
2441960	A32SDDPNL15KC06	B89
2441961	A40TDDPNR15KC06	B89
2441962	A40TDDPNL15KC06	B89
2442595	100G06NK90SP10N14K	U30
2442596	100G06RK90SP10N14K	U27
2442597	100G06LK90SP10N14K	U28
2442598	100Y06NK90SP10N14K	U34
2442599	100Y06RK90SP10N14K	U32
2442600	100Y06LK90SP10N14K	U33
2442601	125H08NK90SP10N14K	U30

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
2442602	125H08RK90SP10N14K	U27
2442642	B978A09100 KC7315	G147
2443434	125H08NK90SP10N16K	U31
2443437	125H08NK90SD12N18K	U42
2443438	125H08RK90SD12N18K	U40
2443439	125H08LK90SD12N18K	U41
2443440	125H08NK90SD12N20K	U43
2443443	125Y08NK90SP10N14K	U34
2443444	125Y08RK90SP10N14K	U32
2443445	125Y08LK90SP10N14K	U33
2443446	125Y08NK90SP10N16K	U35
2443449	125Y08NK90SD12N18K	U48
2443450	125Y08RK90SD12N18K	U44
2443451	125Y08LK90SD12N18K	U46
2443452	125Y08NK90SD12N20K	U49
2443453	125Y08RK90SD12N20K	U45
2443454	125Y08LK90SD12N20K	U47
2443455	160H10NK90SP10N14K	U30
2443456	160H10RK90SP10N14K	U27
2443457	160H10LK90SP10N14K	U28
2443458	160H10NK90SP10N16K	U31
2443461	160H10NK90SD12N18K	U42
2443462	160H10RK90SD12N18K	U40
2443463	160H10LK90SD12N18K	U41
2443464	160H10NK90SD12N20K	U43
2443467	160Y10NK90SP10N14K	U34
2443468	160Y10RK90SP10N14K	U32
2443469	160Y10LK90SP10N14K	U33
2443470	160Y10NK90SP10N16K	U35
2443473	160Y10NK90SD12N18K	U48
2443475	160Y10LK90SD12N18K	U46
2443476	160Y10NK90SD12N20K	U49
2443479	200J14NK90SP10N14K	U30
2443484	200J14LK90SP10N16K	U29
2443485	200J14NK90SD12N18K	U42
2443488	200J14NK90SD12N20K	U43
2443491	200Y14NK90SP10N14K	U34
2443493	200Y14LK90SP10N14K	U33
2443494	200Y14NK90SP10N16K	U35
2443500	200Y14NK90SD12N20K	U49
2443502	200Y14LK90SD12N20K	U47
2443503	250J18NK90SP10N16K	U31
2443505	250J18LK90SP10N16K	U29
2443506	250J16NK90SD12N18K	U42
2443512	250Y18NK90SP10N16K	U35
2443515	250Y16NK90SD12N18K	U48
2443518	250Y16NK90SD12N20K	U49
2443521	315K20NK90SP10N16K	U31
2443524	315K18NK90SD12N18K	U42
2443526	315K18LK90SD12N18K	U41
2443527	315K18NK90SD12N20K	U43
2443530	315Y20NK90SP10N16K	U35
2443533	315Y18NK90SD12N20K	U49
2443536	315Y18NK90SD12N18K	U48
2443937	80A12RF84SN12B	S102
2443938	100B15RF84SN12B	S102
2444419	RCGK060400FS KC5010	E63
2444420	RCGK090700FS KC5010	E63
2444424	RCGK090700FS KC5025	E63
2445703	F2AA0600AWM45R050 K600	P120
2445704	F2AA0600AWM45R100 K600	P120
2445705	F2AA0800AWM45R050 K600	P120
2445706	F2AA0800AWM45R100 K600	P120
2445707	F3AA0600AWM45R050 K600	P122
2445708	F3AA0600AWM45R100 K600	P122
2445709	F3AA0800AWM45R050 K600	P122
2445710	F3AA0800AWM45R100 K600	P122
2446615	RPGV120700 KC5010	B167
2446618	RPGV060400 KC5010	B167
2447150	A25TPCLNR12	B68
2447151	A25TPCLNL12	B68
2447152	A32UPCLNR12	B68
2447377	EDCT180508PDERLD KC522M	T74
2447380	EDCT180548PDERLD KC522M	T74
2447473	A32UPCLNL12	B68
2447476	A32UPCLNR16	B68
2447478	A40VPCLNR16	B68
2447479	A40VPCLNL16	B68
2447480	A25TPSKNR12	B114
2447482	A32UPSKNR12	B114
2447489	A20SPTFNL11	B138
2447503	A32UPTFNL16	B138
2447504	A40VPTFNR22	B138
2447533	A40VPCLNR12	B68
2447534	A40VPCLNL12	B68
2447535	A16RPTFNR11	B138
2447536	A20SPTFNR11	B138
2447537	A25TPTFNR16	B138
2447538	A25TPTFNL16	B138
2447539	A32UPTFNR16	B138
2449473	KSEM2600HPGM KC7315	H43
2449475	KSEM3000HPGM KC7315	H43
2449476	KSEM4000HPGM KC7315	H43
2449518	KSEM2300HPGM KC7315	H43
2449924	KSEM1250HPGM KC7315	H42
2450291	B707A04000FBG KC7315	G114
2450292	B707A05000FBG KC7315	G114
2450343	B707A06000FBG KC7315	G114
2450344	B707A08000FBG KC7315	G114
2450345	B707A13000FBG KC7315	G115
2450346	B707A20000FBG KC7315	G115
2450909	KSEM2000HPGM KC7315	H42
2451576	EDCT180508PDERGD KC725M	T74
2451578	EDCT180512PDFRLDJ KC410M	T73
2451579	EDCT180512PDERGD KC725M	T74
2451580	EDCT180524PDFRLDJ KC410M	T73
2451581	EDCT180540PDFRLDJ KC410M	T73
2451582	EDCT180540PDERLD KC522M	T74
2451684	EDCT180548PDFRLDJ KC410M	T73
2451686	EDCT180508PDFLLDJ KC410M	T73
2452135	OFKT07L6AFENGB KC725M	S55
2452136	OFKT07L6AFSNHB KC725M	S55
2453684	OFPT06L5AFENGB KC725M	S51
2453686	OFPT06L5AFSNHB KC725M	S51
2453687	OFKT06L5AFENGB KC725M	S50
2453688	OFKT06L5AFSNHB KC725M	S50
2455054	B976A06100 KC7315	G139
2455056	B976A07300 KC7315	G140
2455057	B976A07700 KC7315	G140
2455430	A4R0500M05P00T01025 KY3500	B300, C100
2455801	OFPT06L5AFENGB KCK15	S51
2455802	OFPT06L5AFSNHB KCK15	S51
2455814	OFKT06L5AFENGB KCK15	S50
2455816	OFPT06L5AFENGB KCPK30	S51
2455818	OFPT06L5AFSNHB KCPK30	S51
2455819	OFKT06L5AFENGB KCPK30	S50
2455820	OFKT06L5AFSNHB KCPK30	S50
2455821	OFPT06L5AFENGB KC520M	S51
2455822	OFPT06L5AFSNHB KC520M	S51
2455854	OFKT06L5AFENGB KC520M	S50
2456097	RCGT0803M0MS KC5010	B223
2456099	RCGT1204M0MS KC5010	B223
2456320	DSDNN4040S25KC09	B105
2456321	DSRNR4040S25KC09	B106
2456322	DSRNL4040S25KC09	B106
2456906	DFR125R4WD20M	J12
2456907	DFR127R4WD20M	J12
2456908	DFR130R4WD20M	J12
2456909	DFR135R4WD20M	J12
2456910	DFR140R4WD20M	J12
2456911	DFR145R4WD20M	J12
2456912	DFR150R4WD20M	J12
2457733	DFR155R4WD20M	J12
2457734	DFR160R4WD20M	J12
2457735	DFR165R4WD32M	J12
2457736	DFR170R4WD32M	J12
2457737	DFR175R4WD32M	J12
2457738	DFR180R4WD32M	J12
2457739	DFR185R4WD32M	J12
2457741	DFR195R4WD32M	J12
2457743	DFR205R4WD32M	J12
2457744	DFR210R4WD32M	J12
2457746	DFR230R4WD32M	J12
2457747	DFR240R4WD32M	J12
2458790	OFKT06L5AFENGB KC522M	S50
2458791	OFKT06L5AFSNHB KC522M	S50
2458833	OFKT06L5AFFNLNJ KC410M	S49
2458914	SDET120416SNGB2 KCPK30	T104, T111, U52
2458915	SDET120416SNGB2 KC725M	T104, T111, U52
2458916	SDET120416SNGB2 KCK15	T104, T111, U52
2458917	SDET120416SNGB2 KC520M	T104, T111, U52
2458918	SDET120420SNGB2 KCPK30	T104, T111, U52
2458919	SDET120420SNGB2 KC725M	T104, T111, U52
2458920	SDET120420SNGB2 KCK15	T104, T111, U52
2458921	SDET120420SNGB2 KC520M	T104, T111, U52
2458922	SDET120424SNGB2 KCPK30	T104, T111, U52
2458933	SDET120424SNGB2 KC725M	T104, T111, U52
2458934	SDET120424SNGB2 KCK15	T104, T111, U52
2458936	SDET120432SNGB2 KCPK30	T104, T111, U52
2458937	SDET120432SNGB2 KC725M	T104, T111, U52
2458938	SDET120432SNGB2 KCK15	T104, T111, U52
2458939	SDET120432SNGB2 KC520M	T104, T111, U52
2460124	EDPT180512PDSRGD KC725M	T75
2460125	EDPT180512PDSRGD KCPK30	T75
2460185	EDPT180512PDSRGD KCK15	T75
2460273	881.252.200	K133, K135
2465831	63A09RF84SN12B	S102
2465832	125B18RF84SN12B	S102
2465988	KSEM2050HPGM KC7315	H42
2466093	160C24RF84SN12B	S102
2466094	200C30RF84SN12B	S102
2466477	KSEM3500HPGM KC7315	H43
2466478	KSEM3800HPGM KC7315	H43
2466598	KSEM3700HPGM KC7315	H43
2478640	25A03R044B25SED14	T48
2478642	32A04R050B32SED14	T48
2478686	50A06RS90ED14D	T50
2478689	63A07RS90ED14D	T50
2478690	80A09RS90ED14D	T50
2479504	40A02R80A32SKE25	T79
2487433	KSEM1750HPGM KC7315	H42
2488036	EDCT180520PDFRLDJ KC410M	T73
2488096	193.433	S46–48
2490989	B976A11300 KC7315	G141
2494500	KSEM2650HPGM KC7315	H43
2494501	KSEM3300HPGM KC7315	H43
2496015	KSEM2133HPGM KC7315	H43
2498749	DFR175R3WD25M	J11
2498750	DFR180R3WD25M	J11
2498751	DFR185R3WD25M	J11
2498752	DFR190R3WD25M	J11
2499003	DFR195R3WD25M	J11
2499004	DFR200R3WD25M	J11
2499005	DFR205R3WD25M	J11
2499006	DFR230R3WD25M	J11
2499007	DFR240R3WD25M	J11
2499516	B707A11000FBG KC7315	G115
2499607	KSEM1270HPGM KC7315	H42
2499608	KSEM1293HPGM KC7315	H42
2499609	KSEM1310HPGM KC7315	H42
2499610	KSEM1389HPGM KC7315	H42
2499611	KSEM1429HPGM KC7315	H42
2499612	KSEM1468HPGM KC7315	H42
2499723	KSEM1260HPGM KC7315	H42
2499725	KSEM1280HPGM KC7315	H42
2499727	KSEM1300HPGM KC7315	H42
2499729	KSEM1320HPGM KC7315	H42
2499730	KSEM1350HPGM KC7315	H42
2499731	KSEM1360HPGM KC7315	H42
2499732	KSEM1370HPGM KC7315	H42
2499733	KSEM1380HPGM KC7315	H42
2499735	KSEM1400HPGM KC7315	H42
2499736	KSEM1410HPGM KC7315	H42
2499737	KSEM1420HPGM KC7315	H42
2499739	KSEM1440HPGM KC7315	H42
2499740	KSEM1450HPGM KC7315	H42
2499741	KSEM1460HPGM KC7315	H42
2499743	KSEM1480HPGM KC7315	H42
2499744	KSEM1500HPGM KC7315	H42
2499746	KSEM1530HPGM KC7315	H42
2499748	KSEM1550HPGM KC7315	H42
2499749	KSEM1560HPGM KC7315	H42
2499750	KSEM1570HPGM KC7315	H42
2499751	KSEM1580HPGM KC7315	H42
2499753	KSEM1600HPGM KC7315	H42
2499755	KSEM1620HPGM KC7315	H42
2499757	KSEM1650HPGM KC7315	H42
2499759	KSEM1700HPGM KC7315	H42
2499763	KSEM1800HPGM KC7315	H42
2499765	KSEM1850HPGM KC7315	H42
2499767	KSEM1900HPGM KC7315	H42
2499771	KSEM1950HPGM KC7315	H42
2499775	KSEM2100HPGM KC7315	H42
2499777	KSEM2150HPGM KC7315	H43
2499779	KSEM2200HPGM KC7315	H43
2499782	KSEM2250HPGM KC7315	H43
2499784	KSEM2350HPGM KC7315	H43
2499786	KSEM2400HPGM KC7315	H43
2499787	KSEM2450HPGM KC7315	H43
2499789	KSEM2500HPGM KC7315	H43
2499791	KSEM2550HPGM KC7315	H43
2499795	KSEM2700HPGM KC7315	H43
2499796	KSEM2750HPGM KC7315	H43
2499798	KSEM2800HPGM KC7315	H43
2499800	KSEM2850HPGM KC7315	H43
2499802	KSEM2900HPGM KC7315	H43
2499803	KSEM2950HPGM KC7315	H43
2499807	KSEM3050HPGM KC7315	H43
2499810	KSEM3100HPGM KC7315	H43
2499811	KSEM3150HPGM KC7315	H43
2499813	KSEM3200HPGM KC7315	H43
2499814	KSEM3250HPGM KC7315	H43
2499818	KSEM3350HPGM KC7315	H43
2499820	KSEM3400HPGM KC7315	H43
2499822	KSEM3450HPGM KC7315	H43
2499824	KSEM3550HPGM KC7315	H43
2499826	KSEM3600HPGM KC7315	H43
2499828	KSEM3650HPGM KC7315	H43
2499831	KSEM3750HPGM KC7315	H43
2499834	KSEM3850HPGM KC7315	H43
2499835	KSEM3900HPGM KC7315	H43
2499836	KSEM3950HPGM KC7315	H43
2499837	OFKT07L6AFFNLNJ KC410M	S54
2499843	KSEM1508HPGM KC7315	H42
2499844	KSEM1548HPGM KC7315	H42
2499845	KSEM1588HPGM KC7315	H42
2499846	KSEM1609HPGM KC7315	H42
2499847	KSEM1627HPGM KC7315	H42
2499848	KSEM1667HPGM KC7315	H42
2499849	KSEM1707HPGM KC7315	H42
2499850	KSEM1746HPGM KC7315	H42
2499851	KSEM1786HPGM KC7315	H42
2499852	KSEM1826HPGM KC7315	H42
2499853	KSEM1865HPGM KC7315	H42
2499854	KSEM1905HPGM KC7315	H42
2499855	KSEM1927HPGM KC7315	H42
2499856	KSEM1945HPGM KC7315	H42
2499857	KSEM1984HPGM KC7315	H42
2499858	KSEM2024HPGM KC7315	H42
2499859	KSEM2064HPGM KC7315	H42
2499860	KSEM2143HPGM KC7315	H43
2499861	KSEM2183HPGM KC7315	H43
2499862	KSEM2223HPGM KC7315	H43
2499863	KSEM2244HPGM KC7315	H43
2499864	KSEM2342HPGM KC7315	H43
2499865	KSEM2381HPGM KC7315	H43

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
2499866	KSEM2461HPGM KC7315	H43
2499867	KSEM2540HPGM KC7315	H43
2499868	KSEM2567HPGM KC7315	H43
2499869	KSEM2619HPGM KC7315	H43
2499870	KSEM2659HPGM KC7315	H43
2499871	KSEM2778HPGM KC7315	H43
2499872	KSEM2818HPGM KC7315	H43
2499873	KSEM2858HPGM KC7315	H43
2499874	KSEM2937HPGM KC7315	H43
2499875	KSEM2977HPGM KC7315	H43
2499876	KSEM3016HPGM KC7315	H43
2499877	KSEM3056HPGM KC7315	H43
2499878	KSEM3096HPGM KC7315	H43
2499879	KSEM3175HPGM KC7315	H43
2499880	KSEM3254HPGM KC7315	H43
2499881	KSEM3294HPGM KC7315	H43
2499882	KSEM3334HPGM KC7315	H43
2499883	KSEM3373HPGM KC7315	H43
2499884	KSEM3413HPGM KC7315	H43
2499885	KSEM3493HPGM KC7315	H43
2499886	KSEM3572HPGM KC7315	H43
2499887	KSEM3612HPGM KC7315	H43
2499888	KSEM3651HPGM KC7315	H43
2499889	KSEM3731HPGM KC7315	H43
2499890	KSEM3810HPGM KC7315	H43
2499891	KSEM3846HPGM KC7315	H43
2499960	B977F03800 KC7315	G143
2500741	50A03R80A32SKE25	T79
2500876	LT16ERAG60K KU25T	D54
2500931	LT16NRAG60K KU25T	D67
2503543	A4ENN2020K0611	C118
2503544	A4ENN2525M0611	C118
2503545	A4ENN3232P0611	C118
2503550	A4SML2020K0317	C113
2503551	A4SMR2020K0317	C112
2503552	A4SML2020K0417	C113
2503553	A4SMR2020K0417	C112
2503554	A4SML2020K0620	C113
2503555	A4SMR2020K0620	C112
2503556	A4SML2016K0317	C113
2503557	A4SMR2016K0317	C112
2503559	A4SMR2016K0417	C112
2504223	KSEM1970HPGM KC7315	H42
2506705	B977A15200 KC7315	G141
2507899	KSEM2560HPM KC7315	H40
2509326	EDPT180508PDSRGD KC725M	T75
2509327	EDPT180508PDSRGD KCPK30	T75
2509328	EDPT180508PDSRGD KCK15	T75
2509387	EDPT180516PDSRGD KC725M	T75
2509388	EDPT180516PDSRGD KCPK30	T75
2509408	EDPT180532PDSRGD KC725M	T75
2509410	EDPT180532PDSRGD KCPK30	T75
2510390	125B09RS90ED14D	T50
2526351	KEGT25L531PEERLDJ KC410M	T82
2526385	KEGT25L508PEERLDJ KC410M	T82
2526387	KEGT25L564PEERLDJ KC410M	T82
2526391	KMSP825IP	B105–106
2526442	KLM81025IP	B105–106
2526757	KEGT25L516PEERLDJ KC410M	T82
2539334	CM184LP	C167, D27
2539335	CM185LP	C167, D27
2541018	KSEM1800PCM KC7135	H56, H87
2541019	KSEM1850PCM KC7135	H56
2541020	KSEM2300PCM KC7135	H56, H87
2541133	B707A07000FBG KC7315	G114
2541200	KRDEA046AM	K75
2541201	KRDEA051AM	K75
2541202	KRDEA012AM	K75
2541213	KRDE025010M	K76
2541214	KRDE033010M	K76
2541215	KRDE043010M	K76
2541216	KRDE065012M	K76
2541217	KRCW032A	K76
2541511	KSEM1300PCM KC7135	H56, H87
2541512	KSEM1350PCM KC7135	H56
2541535	B976A05530 KC7315	G139
2542517	A4M50R0314A036048	C125
2542518	A4M50R0314A042058	C125
2542519	A4M50R0314A052074	C125
2542520	A4M50R0314A068100	C125
2542521	A4M50R0314A090160	C125
2542522	A4M50R0314A130300	C125
2542523	A4M50R0314A290999	C125
2542524	A4M50L0314A036048	C126
2542527	A4M50L0314A068100	C126
2542528	A4M50L0314A090160	C126
2542529	A4M50L0314A130300	C126
2542530	A4M50L0314A290999	C126
2542531	A4M50R0414A048072	C125
2542532	A4M50R0414A064100	C125
2542533	A4M50R0414A092150	C125
2542534	A4M50R0414A132300	C125
2542535	A4M50R0414A290999	C125
2542537	A4M50L0414A064100	C126
2542538	A4M50L0414A092150	C126
2542539	A4M50L0414A132300	C126
2542540	A4M50L0414A290999	C126
2542541	A4M50R0519A058094	C125
2542542	A4M50R0519A080136	C125
2542543	A4M50R0519A120300	C125
2542544	A4M50R0519A250999	C125
2542545	A4M50L0519A058094	C126
2542546	A4M50L0519A080136	C126
2542547	A4M50L0519A120300	C126
2542548	A4M50L0519A250999	C126
2542822	KSEM2500PCM KC7135	H56, H87
2542849	KSEM3000PCM KC7135	H56, H87
2543238	B977F04650 KC7315	G143
2544200	SPCT10T3PPERLD2 KC520M	T100, U36
2544251	B977F03500 KC7315	G143
2544413	SDCT1204PDERLD2 KC520M	T104, T111, U51
2545095	OFKT07L6AFENLB KCPK30	S54
2545097	OFKT07L6AFSNLB KCPK30	S54
2546816	BGHX15L5PCSRLET KD1410	S148
2548776	KTIP080R8SS10M	H31
2548777	KTIP090R8SS10M	H31
2548778	KTIP095R8SS10M	H31
2548779	KTIP100R8SS12M	H31
2548780	KTIP105R8SS12M	H31
2548781	KTIP110R8SS12M	H31
2548782	KTIP115R8SS12M	H31
2548913	KTIP120R8SS14M	H31
2548914	KTIP125R8SS14M	H31
2548915	KTIP130R8SS14M	H31
2548916	KTIP135R8SS14M	H31
2548917	KTIP140R8SS16M	H31
2548918	KTIP145R8SS16M	H31
2548919	KTIP150R8SS16M	H31
2548920	KTIP080R8SCF12M	H32
2548921	KTIP085R8SCF12M	H32
2548922	KTIP090R8SCF12M	H32
2548923	KTIP095R8SCF12M	H32
2548924	KTIP100R8SCF16M	H32
2548925	KTIP105R8SCF16M	H32
2548926	KTIP110R8SCF16M	H32
2548927	KTIP115R8SCF16M	H32
2548928	KTIP120R8SCF16M	H32
2548929	KTIP125R8SCF16M	H32
2548930	KTIP130R8SCF16M	H32
2548931	KTIP135R8SCF16M	H32
2548932	KTIP140R8SCF16M	H32
2548933	KTIP145R8SCF16M	H32
2548934	KTIP150R8SCF20M	H32
2548935	KTIP160R8SCF20M	H32
2549023	NG3047L KC5010	C155
2549978	OFPT07L6AFENGB KC520M	S55
2579622	B976A06900 KC7315	G139
2582207	CTFPR20CA22	B378
2582790	B707A17000FBG KC7315	G115
2594849	B707A21000FBG KC7315	G115
2598759	NG3072R KC5010	C154
2598760	NG3072L KC5010	C155
2598761	NG3078R KC5010	C154
2598803	NG3088R KC5010	C154
2598804	NG3097R KC5010	C154
2598806	NG3105R KC5010	C154
2598807	NG3105L KC5010	C155
2598808	NG3125L KC5010	C155
2598809	NG3142R KC5010	C154
2598811	NG3156R KC5010	C154
2598813	NG3189L KC5010	C155
2598816	NGP3125R KC5010	C152
2598817	NGP3125L KC5010	C152
2598823	NGD3189L KC5010	C157
2598824	NG3062R KC5010	C154
2599495	NG4189R KC5010	C154
2599496	NR3031L KC5010	C158
2599497	NG4189L KC5010	C155
2599498	NG4250L KC5010	C155
2599501	NGP4250R KC5010	C152
2599504	NGD4250L KC5010	C157
2599505	NR4125R KC5010	C158
2599506	NR3047R KC5010	C158
2599507	NR3047L KC5010	C158
2599508	NR3062R KC5010	C158
2599509	NR3062L KC5010	C158
2599510	NRP3031R KC5010	C153
2599511	NRP3031L KC5010	C153
2599512	NRP3047R KC5010	C153
2599513	NRP3047L KC5010	C153
2599514	NRP3062R KC5010	C153
2599515	NRP3062L KC5010	C153
2599516	NRP3094R KC5010	C153
2599518	NRP3094L KC5010	C153
2599519	NG3047R KC5025	C154
2599521	NG3062R KC5025	C154
2599522	NG3062L KC5025	C155
2599523	NG3094R KC5025	C154
2599524	NG3094L KC5025	C155
2599525	NG3125L KC5025	C155
2599526	NG3156R KC5025	C154
2599527	NG3156L KC5025	C155
2599528	NG3189R KC5025	C154
2599529	NG3189L KC5025	C155
2599530	NR3031R KC5025	C158
2599531	NR3031L KC5025	C158
2599534	NR3062R KC5025	C158
2599535	NR3062L KC5025	C158
2599536	NRD4062R KC5010	C159
2599537	NRD4062L KC5010	C159
2599538	NRD4094R KC5010	C159
2599539	NRD4094L KC5010	C159
2599540	NRD4125L KC5010	C159
2599550	NR4125L KC5010	C158
2599571	NG2031R KC5010	C154
2599572	NG2031L KC5010	C155
2599743	NG2041R KC5010	C154
2599744	NG2041L KC5010	C155
2599745	NG2047R KC5010	C154
2599746	NG2047L KC5010	C155
2599748	NG2094R KC5010	C154
2599749	NG2094L KC5010	C155
2599750	NG2125R KC5010	C154
2599751	NG2125L KC5010	C155
2599752	NGP2031R KC5010	C152
2599757	NR2031R KC5010	C158
2599758	NR2031L KC5010	C158
2599759	NR2062R KC5010	C158
2599760	NR2062L KC5010	C158
2599761	NG2031R KC5025	C154
2599765	NG2062R KC5025	C154
2599887	B976A04100 KC7315	G138
2603030	KSEM2430HPGM KC7315	H43
2604354	RNMG120400RN KC5010	B94
2605709	B977F03000 KC7315	G143
2607377	B707A10000FBG KC7315	G115
2613785	25A02R050A25SED18-170	T71
2613786	32A03R050A32SED18-200	T71
2613787	40A04R050A32SED18-200	T71
2613788	32A02R050A32SED18-200	T71
2613789	40A03R050A32SED18-200	T71
2613790	3.41020R904 KC7315	I16
2613791	3.41020R901 KC7315	I15
2613792	3.41020R902 KC7315	I15
2613858	B967A14000 KC7315	G134
2614817	B976A07100 KC7315	G139
2615043	3.41020R903 KC7315	I15
2615044	3.41220R904 KC7315	I16
2615045	3.41220R901 KC7315	I15
2615046	3.41220R902 KC7315	I15
2615047	3.41220R903 KC7315	I15
2616697	KSEM2215HPGM KC7315	H43
2618743	170.314	H31–32
2619033	B707A05560FBG KC7315	G114
2620169	B978A04600 KC7315	G146
2622232	20A02R039B20SED14	T48
2623070	B707A16000FBG KC7315	G115
2623553	B256A05100 KC7315	G63
2623860	KSEM2000PCM KC7135	H56, H87
2623933	40A05R050B32SED14	T48
2623934	40A05RS90ED14D	T50
2623935	100A10RS90ED14D	T50
2623936	125B12RS90ED14D	T50
2623937	25A02R044B25SED14	T48
2623938	32A03R050B32SED14	T48
2623939	40A04R050B32SED14	T48
2623940	40A04RS90ED14D	T50
2623941	50A05RS90ED14D	T50
2623942	63A06RS90ED14D	T50
2623963	80A07RS90ED14D	T50
2623964	100A08RS90ED14D	T50
2623965	160C11RS90ED14D	T50
2625682	B256A07000 KC7315	G63
2625713	F3BA0600ADL40E180 K600	P125
2625714	F3BA0800ADL40E240 K600	P125
2625715	F3BA1000ADL40E300 K600	P125
2625716	F3BA1200ADL40E360 K600	P125
2625717	F3BA1600ADL40E480 K600	P125
2625718	F3BA2000ADL40E600 K600	P125
2625743	B256A08000 KC7315	G63
2627240	B967A12000 KC7315	G134
2627513	F4AW0400AWL38W040 KC633M	P22
2627514	F4AW0500AWL38W040 KC633M	P22
2627515	F4AW0600AWL38W040 KC633M	P22
2627516	F4AW0800AWL38W040 KC633M	P22
2627517	F4AW1000AWX38W040 KC633M	P22
2627518	F4AW0400AWL38W060 KC633M	P22
2627519	F4AW0500AWL38W060 KC633M	P22
2627520	F4AW0600AWL38W060 KC633M	P22
2627521	F4AW0800AWL38W060 KC633M	P22
2627522	F4AW1000AWX38W060 KC633M	P22
2628928	B707A11570FBG KC7315	G115
2629032	B707A04900FBG KC7315	G114
2629368	B707A12000FBG KC7315	G115
2633016	B707A18000FBG KC7315	G115
2633730	KTIP080R3BF08M	I11
2633731	KTIP090R5BF10M	I13
2633732	KTIP160R3BF17M	I11
2634374	3.77000R224V	J75
2634375	3.77000R227V	J75
2634376	3.77000R229V	J75
2634377	3.77000R231V	J75
2634378	3.77000R239V	J75
2634379	3.77000R249V	J75
2634380	3.77000R251V	J75
2634381	3.77000R253V	J75
2634382	3.77000R274V	J75
2634413	3.77000R276V	J75
2634414	3.77000R278V	J75
2634415	3.77000R280V	J75
2634416	3.77000R282V	J75
2634417	3.77000R284V	J75
2634418	3.77000R286V	J75
2634419	3.77000R288V	J75
2634568	B707A07500FBG KC7315	G114
2635436	B977A15300 KC7315	G141
2636514	B707A12800FBG KC7315	G115
2636741	S2160	V82
2636814	MS1235CG	T80
2637756	MS2060	S34
2637805	F7IP	T29, T38
2639052	B707A11800FBG KC7315	G115
2639144	B707A15250FBG KC7315	G115
2639491	KSEM3900PCM KC7135	H56, H87
2641904	B966A16500 KC7315	G134
2643468	B977F03400 KC7315	G143
2646000	B707A15000FBG KC7315	G115
2646064	KSEM1280PCM KC7135	H56
2646067	KSEM1380PCM KC7135	H56
2646068	KSEM1400PCM KC7135	H56, H87
2646069	KSEM1410PCM KC7135	H56
2646072	KSEM1450PCM KC7135	H56
2646073	KSEM1460PCM KC7135	H56
2646074	KSEM1480PCM KC7135	H56
2646075	KSEM1500PCM KC7135	H56, H87

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
2646077	KSEM1550PCM KC7135	H56
2646078	KSEM1560PCM KC7135	H56
2646080	KSEM1580PCM KC7135	H56
2646081	KSEM1600PCM KC7135	H56, H87
2646082	KSEM1620PCM KC7135	H56
2646083	KSEM1650PCM KC7135	H56
2646084	KSEM1700PCM KC7135	H56, H87
2646085	KSEM1900PCM KC7135	H56, H87
2646086	KSEM1950PCM KC7135	H56
2646087	KSEM2050PCM KC7135	H56
2646088	KSEM2100PCM KC7135	H56, H87
2646089	KSEM2150PCM KC7135	H56
2646090	KSEM2200PCM KC7135	H56, H87
2646091	KSEM2250PCM KC7135	H56
2646092	KSEM2350PCM KC7135	H56
2646093	KSEM2400PCM KC7135	H56, H87
2646094	KSEM2450PCM KC7135	H56
2646095	KSEM2550PCM KC7135	H56
2646096	KSEM2650PCM KC7135	H56
2646097	KSEM2700PCM KC7135	H56, H87
2646099	KSEM2800PCM KC7135	H56, H87
2646100	KSEM2850PCM KC7135	H56
2646101	KSEM2900PCM KC7135	H56, H87
2646102	KSEM2950PCM KC7135	H56
2646103	KSEM3050PCM KC7135	H56
2646104	KSEM3100PCM KC7135	H56, H87
2646106	B343S12200HPG KC7315	I10
2646108	B343S12500HPG KC7315	I10
2646109	B343S12700HPG KC7315	I10
2646110	B343S12800HPG KC7315	I10
2646111	B343S13000HPG KC7315	I10
2646112	B343S06100HPG KC7315	I8
2646253	B343S06200HPG KC7315	I8
2646254	B343S06300HPG KC7315	I8
2646255	B343S06350HPG KC7315	I8
2646256	B343S06400HPG KC7315	I8
2646257	B343S06500HPG KC7315	I8
2646258	B343S06528HPG KC7315	I8
2646259	B343S06600HPG KC7315	I8
2646260	B343S06700HPG KC7315	I8
2646261	B343S06746HPG KC7315	I9
2646262	B343S06800HPG KC7315	I9
2646263	B343S06900HPG KC7315	I9
2646265	B343S07000HPG KC7315	I9
2646266	B343S07145HPG KC7315	I9
2646267	B343S07300HPG KC7315	I9
2646268	B343S07400HPG KC7315	I9
2646269	B343S07500HPG KC7315	I9
2646270	B343S07541HPG KC7315	I9
2646272	B343S07800HPG KC7315	I9
2646273	B343S07900HPG KC7315	I9
2646274	B343S07938HPG KC7315	I9
2646275	B343S08000HPG KC7315	I9
2646276	B343S03175HPG KC7315	I8
2646277	B343S03400HPG KC7315	I8
2646278	B343S03500HPG KC7315	I8
2646279	B343S03797HPG KC7315	I8
2646280	B343S03800HPG KC7315	I8
2646281	B343S03970HPG KC7315	I8
2646282	B343S04000HPG KC7315	I8
2646333	B343S04100HPG KC7315	I8
2646334	B343S04200HPG KC7315	I8
2646335	B343S04300HPG KC7315	I8
2646336	B343S04500HPG KC7315	I8
2646337	B343S04600HPG KC7315	I8
2646338	B343S04623HPG KC7315	I8
2646339	B343S04763HPG KC7315	I8
2646340	B343S04900HPG KC7315	I8
2646341	B343S05000HPG KC7315	I8
2646342	B343S05100HPG KC7315	I8
2646343	B343S05200HPG KC7315	I8
2646344	B343S05300HPG KC7315	I8
2646345	B343S05400HPG KC7315	I8
2646346	B343S05410HPG KC7315	I8
2646347	B343S05500HPG KC7315	I8
2646348	B343S05550HPG KC7315	I8
2646349	B343S05558HPG KC7315	I8
2646350	B343S05600HPG KC7315	I8
2646351	B343S05800HPG KC7315	I8
2646352	B343S06000HPG KC7315	I8
2646385	B343S13200HPG KC7315	I10
2646386	B343S13500HPG KC7315	I10
2646387	B343S14000HPG KC7315	I10
2646389	B343S14200HPG KC7315	I10
2646390	B343S14280HPG KC7315	I10
2646391	B343S15000HPG KC7315	I10
2646392	B343S15500HPG KC7315	I10
2646393	B343S15870HPG KC7315	I10
2646394	B343S16000HPG KC7315	I10
2646395	B343S16500HPG KC7315	I10
2646396	B343S16670HPG KC7315	I10
2646397	B343S17000HPG KC7315	I10
2646399	B343S17500HPG KC7315	I10
2646400	B343S17700HPG KC7315	I10
2646401	B343S18000HPG KC7315	I10
2646402	B343S10100HPG KC7315	I9
2646423	B343S10200HPG KC7315	I9
2646424	B343S10300HPG KC7315	I9
2646425	B343S10320HPG KC7315	I9
2646426	B343S10400HPG KC7315	I9
2646427	B343S10500HPG KC7315	I9
2646428	B343S10600HPG KC7315	I9
2646429	B343S10700HPG KC7315	I9
2646430	B343S10710HPG KC7315	I9
2646431	B343S10800HPG KC7315	I9
2646432	B343S11000HPG KC7315	I9
2646433	B343S11100HPG KC7315	I9
2646434	B343S11110HPG KC7315	I9
2646435	B343S11200HPG KC7315	I9
2646436	B343S11300HPG KC7315	I9
2646437	B343S11500HPG KC7315	I9
2646438	B343S11508HPG KC7315	I9
2646439	B343S11700HPG KC7315	I9
2646440	B343S11800HPG KC7315	I10
2646441	B343S11900HPG KC7315	I10
2646442	B343S12000HPG KC7315	I10
2647585	B977F03900 KC7315	G143
2649363	B976A03970 KC7315	G138
2649364	B976A04763 KC7315	G139
2649365	B976A05575 KC7315	G139
2649366	B976A06350 KC7315	G139
2649367	B976A06746 KC7315	G139
2649368	B976A07145 KC7315	G139
2649369	B976A07541 KC7315	G140
2649370	B976A07938 KC7315	G140
2649371	B976A08334 KC7315	G140
2649372	B976A08733 KC7315	G140
2649373	B976A09129 KC7315	G140
2649374	B976A09525 KC7315	G140
2649375	B976A09921 KC7315	G140
2649376	B976A10320 KC7315	G140
2649377	B976A10716 KC7315	G141
2649378	B976A11113 KC7315	G141
2649379	B976A11509 KC7315	G141
2649380	B976A11908 KC7315	G141
2649381	B976A12304 KC7315	G141
2649382	B976A14288 KC7315	G141
2649383	B976A15875 KC7315	G142
2649384	B976A17463 KC7315	G142
2649385	B976A19050 KC7315	G142
2649386	B977A03970 KC7315	G138
2649387	B977A04580 KC7315	G139
2649388	B977A04623 KC7315	G139
2649389	B977A04763 KC7315	G139
2649390	B977A05410 KC7315	G139
2649391	B977A05558 KC7315	G139
2649486	B967A10500 KC7315	G133
2649548	R30FBHS06	K136
2649549	R38FBHS06	K136
2649550	R48FBHS06	K136
2649551	R65FBHS06	K136
2649552	R85FBHS06	K136
2649553	R85FBHS09	K136
2649554	R125FBHS09	K136
2649555	R24FBHS06LF	K136
2649556	R31FBHS06LF	K136
2649557	R40FBHS06LF	K136
2649558	R51FBHS06LF	K136
2649559	R67FBHS09LF	K136
2649569	40A02R50A32SKE25	T79
2649571	50A02R100A32SKE25	T79
2649913	DH35M	S41, T102
2650038	B707A08500FBG KC7315	G114
2651013	B343S08100HPG KC7315	I9
2651014	B343S08200HPG KC7315	I9
2651015	B343S08300HPG KC7315	I9
2651016	B343S08334HPG KC7315	I9
2651017	B343S08400HPG KC7315	I9
2651018	B343S08433HPG KC7315	I9
2651019	B343S08500HPG KC7315	I9
2651020	B343S08600HPG KC7315	I9
2651021	B343S08700HPG KC7315	I9
2651022	B343S08733HPG KC7315	I9
2651023	B343S08800HPG KC7315	I9
2651025	B343S09000HPG KC7315	I9
2651026	B343S09100HPG KC7315	I9
2651028	B343S09347HPG KC7315	I9
2651029	B343S09400HPG KC7315	I9
2651030	B343S09500HPG KC7315	I9
2651031	B343S09525HPG KC7315	I9
2651033	B343S09700HPG KC7315	I9
2651034	B343S09800HPG KC7315	I9
2651035	B343S09921HPG KC7315	I9
2651036	B343S10000HPG KC7315	I9
2651037	HSK63FBH01695	K124
2651038	AFB38115SCFPR09	K130
2651039	AFB42115SCFPR09	K130
2651040	AFB47115SCFPR09	K130
2651042	RS1605	K125
2651163	CFB10082	K131
2651164	CFB12096	K131
2651165	CFB14110	K131
2651166	CFB16120	K131
2651167	CFB18140	K131
2651168	HFB1023SCFPR06	K126
2651169	HFB1223SCFPR06	K126
2651170	HFB1627SCFPR06	K126
2651171	HFB2127SCFPR06	K126
2651172	HFB2427SCFPR06	K126
2651173	HFB2727SCFPR06	K126
2651174	HFB3127SCFPR06	K126
2651175	HFB3427SCFPR06	K126
2651176	HFB14FBHS1440	K126
2651177	HFB16FBHS1640	K126
2651178	HFB19FBHS1840	K126
2652755	B707A09000FBG KC7315	G115
2652965	SYB24RBHT06F	K121
2652967	SYB30RBHT06F	K121
2652968	SYB40RBHT09F	K121
2652969	SYB50RBHT09F	K121
2652970	SYB66RBHT12F	K121
2652971	SYB66RBHT12LF	K121
2652972	SYB87RBHT12F	K121
2652983	SYB87RBHT16LF	K121
2652984	SYB115RBHT16LF	K121
2653917	KSEM1925HPGM KC7315	H42
2655215	B977A13200 KC7315	G141
2655963	B707A04800FBG KC7315	G114
2656831	B978F08500 KC7315	G149
2656984	F4AT0600AWL20R005 KC637M	P143
2656985	F4AT0600AWL20R010 KC637M	P143
2656986	F4AT0800AWL20R005 KC637M	P143
2656987	F4AT0800AWL20R010 KC637M	P143
2656989	F4AT0800AWL20R020 KC637M	P143
2656990	F4AT1000AWL20R005 KC637M	P143
2656991	F4AT1000AWL20R010 KC637M	P143
2656993	F4AT1000AWL20R020 KC637M	P143
2656994	F4AT1000AWL20R025 KC637M	P143
2656995	F4AT1200AWX20R010 KC637M	P143
2656996	F4AT1200AWX20R015 KC637M	P143
2656998	F4AT1200AWX20R030 KC637M	P143
2656999	F4AT0400AWS20R005 KC637M	P143
2657000	F4AT0400AWS20R010 KC637M	P143
2657001	F4AT0500AWS20R005 KC637M	P143
2657002	F4AT0500AWS20R010 KC637M	P143
2657123	F4AT0600AWS20R005 KC637M	P143
2657126	F4AT0800AWM20R010 KC637M	P143
2657127	F4AT0800AWM20R020 KC637M	P143
2657128	F4AT1000AWM20R005 KC637M	P143
2657132	F4AT1000AWM20R025 KC637M	P143
2657135	F4AT1200AWL20R015 KC637M	P143
2657137	F4AT1200AWL20R030 KC637M	P143
2657417	F2AL0100AWM30E060 KC637M	P167
2657418	F2AL0100AWM30E100 KC637M	P167
2657419	F2AL0100AWM30E160 KC637M	P167
2657423	F2AL0150AWM30E160 KC637M	P167
2657425	F2AL0200AWM30E100 KC637M	P167
2657426	F2AL0200AWM30E160 KC637M	P167
2657427	F2AL0200AWM30E0200 KC637M	P167
2657432	F2AL0400AWM30E060 KC637M	P167
2657435	F2AL0400AWM30E160 KC637M	P167
2657439	F2AT1000AWL20R010 KC637M	P142
2657440	F2AT1200AWX20R005 KC637M	P142
2657441	F2AT1200AWX20R010 KC637M	P142
2657603	B707A11700FBG KC7315	G115
2658030	B707A08800FBG KC7315	G115
2658054	B256A08400 KC7315	G63
2658075	B967A10700 KC7315	G133
2658213	B977A06528 KC7315	G139
2658214	B977A09746 KC7315	G140
2658215	B977A06909 KC7315	G139
2658216	B977A07145 KC7315	G139
2658217	B977A07541 KC7315	G140
2658218	B977A07938 KC7315	G140
2658219	B977A08334 KC7315	G140
2658220	B977A08433 KC7315	G140
2658221	B977A08733 KC7315	G140
2658222	B977A09129 KC7315	G140
2658223	B977A09347 KC7315	G140
2658224	B977A09525 KC7315	G140
2658226	B977A09921 KC7315	G140
2658227	B977A10320 KC7315	G140
2658228	B977A10716 KC7315	G141
2658229	B977A11113 KC7315	G141
2658230	B977A11509 KC7315	G141
2658231	B977A11908 KC7315	G141
2658232	B977A12304 KC7315	G141
2658234	B977A13096 KC7315	G141
2658235	B977A14288 KC7315	G141
2658236	B977A15875 KC7315	G142
2658237	B977A16078 KC7315	G142
2658239	B977A17463 KC7315	G142
2658240	B977A19050 KC7315	G142
2658241	B977A19253 KC7315	G142
2658242	B977A19446 KC7315	G142
2658393	B978A03970 KC7315	G146
2658394	B978A04763 KC7315	G146
2658395	B978A05558 KC7315	G146
2658396	B978A06350 KC7315	G146
2658397	B978A06746 KC7315	G146
2658398	B978A07145 KC7315	G146
2658399	B978A07541 KC7315	G147
2658400	B978A07938 KC7315	G147
2658401	B978A08334 KC7315	G147
2658402	B978A08733 KC7315	G147
2658403	B978A09129 KC7315	G147
2658404	B978A09525 KC7315	G147
2658405	B978A09921 KC7315	G147
2658406	B978A10320 KC7315	G147
2658407	B978A10716 KC7315	G147
2658408	B978A11113 KC7315	G147
2658409	B978A11509 KC7315	G147
2658410	B978A11908 KC7315	G147
2658411	B978A12304 KC7315	G147
2658412	B978A12700 KC7315	G147
2658413	B978A14288 KC7315	G148
2658414	B978A15875 KC7315	G148
2658415	B978A16078 KC7315	G148
2658416	B978A17463 KC7315	G148
2658417	B978A19050 KC7315	G148
2658418	B978A19253 KC7315	G148
2658419	A4G0300M03P04T01025 KY3500	B300, C100
2658420	A4G0400M04P04T01025 KY3500	B300, C100
2658421	A4G0500M05P08T01025 KY3500	B300, C100
2658422	A4G0600M06P08T01025 KY3500	B300, C100
2658685	B967A16000 KC7315	G134
2659233	A4G0800M08P08T01025 KY3500	B300, C100
2659234	A4G125I03P1T0425 KY3500	B300, C100
2659236	A4G250I06P2T0425 KY3500	B300, C100
2659238	A4R0300M03P00T01025 KY3500	B300, C100

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
2659240	A4R0600M06P00T01025 KY3500	B300, C100
2659241	A4R0800M08P00T01025 KY3500	B300, C100
2659244	A4R250I06P00T0425 KY3500	B300, C100
2659833	KEGT25L520PEERLDJ KC410M	T82
2660255	KEGT25L540PEERLDJ KC410M	T82
2660384	B707A05900FBG KC7315	G114
2818063	B977A21000 KC7315	G142
2825941	QTM20 WG	B273
2832635	CT11 WG	B273
2868502	3.77000R250V	J75
2869513	3.77000R252V	J75
2869514	3.77000R228V	J75
2869515	3.77000R230V	J75
2869516	3.77000R248V	J75
2872839	KSEM1923HPM KC7315	H40
2875458	KEGT25L550PEERLDJ KC410M	T82
2875584	B978A05800 KC7315	G146
2876977	RPGV120700MP KC5010	B167
2877233	KDMT1610ERGC KC515M	V132
2877234	KDMT2010ERGC KC515M	V132
2877235	KDMT2510ERGC KC515M	V132
2877236	KDMT1210ERGN KC515M	V132
2877237	KDMT1610ERGN KC515M	V132
2877238	KDMT2010ERGN KC515M	V132
2877239	KDMT2510ERGN KC515M	V132
2877242	KDMB10R120A10HNC	V114
2877373	KDMB10R150A10HNC	V114
2877374	KDMB12R120A12HNC	V114
2877375	KDMB12R160A12HNC	V114
2877376	KDMB16R140A16HNC	V114
2877377	KDMB16R175A16HNC	V114
2877378	KDMB20R140A20HNC	V114
2877379	KDMB20R190A20HNC	V114
2877380	KDMB25R160A25HNC	V114
2877381	KDMB25R210A25HNC	V114
2877383	KDMB32R240A32HNC	V114
2877384	KDMT12R120A12HNC	V130
2877385	KDMT12R160A12HNC	V130
2877386	KDMT16R140A16HNC	V130
2877387	KDMT16R175A16HNC	V130
2877388	KDMT20R140A20HNC	V130
2877389	KDMT20R190A20HNC	V130
2877454	EDPT180508PDERHD KC725M	T75
2877455	EDPT180508PDERHD KCPK30	T75
2877456	EDPT180512PDERHD KC725M	T75
2877457	EDPT180512PDERHD KCPK30	T75
2877458	EDPT180516PDERHD KC725M	T75
2877459	EDPT180516PDERHD KCPK30	T75
2877460	EDPT180532PDERHD KC725M	T75
2877461	EDPT180532PDERHD KCPK30	T75
2878139	52A02RS90KE25	T80
2878591	B976A03300 KC7315	G138
2878592	B976A03000 KC7315	G138
2880434	40A02R110S63SKE25	T81
2880439	50A03R140S63SKE25	T81
2880630	KSCM63R08CAH63A090	S131
2881212	193.450	J75
2881283	193.451	J75
2881349	KSCM80R10CAB27	S132
2881352	KSCM100R12CAB32	S132
2881505	KSCM125R16CAB40	S132
2881509	KSCM160R18CAB40	S132
2881510	KSCM200R24CAB60	S132
2881511	KSCM250R30CAB60	S132
2882164	B976A16200 KC7315	G142
2883559	KEGT25L512PEERLDJ KC410M	T82
2884170	B976A10400 KC7315	G140
2884902	KSCMCA75UN KD1420	S133
2884915	KSCMCA90UN KD1420	S134
2884918	KSCMCA75QF KD1420	S133
2884919	KSCMCA75PT KD1420	S133
2885009	B707A12500FBG KC7315	G115
2886972	SDET120432XENGB2 KC725M	T104, T111, U52
2887393	KSEM2120HPGM KC7315	H42
2887394	KSEM2670HPGM KC7315	H43
2887395	KSEM1770HPGM KC7315	H42
2887724	B707A03000FBG KC7315	G114
2888086	KTIP080R4BF09M	I12
2888087	KTIP085R4BF09M	I12
2888088	KTIP090R4BF10M	I12
2888089	KTIP095R4BF10M	I12
2888090	KTIP100R4BF11M	I12
2888091	KTIP105R4BF11M	I12
2888092	KTIP110R4BF12M	I12
2888306	B978A04000 KC7315	G146
2888501	KTIP080R3BF09M	I11
2888502	KTIP085R3BF09M	I11
2888893	KTIP090R3BF09M	I11
2888894	KTIP090R3BF10M	I11
2888895	KTIP095R3BF10M	I11
2888896	KTIP100R3BF10M	I11
2888897	KTIP100R3BF11M	I11
2888898	KTIP105R3BF11M	I11
2888899	KTIP110R3BF11M	I11
2888900	KTIP110R3BF12M	I11
2888901	KTIP115R3BF12M	I11
2888902	KTIP120R3BF12M	I11
2888903	KTIP120R3BF13M	I11
2888904	KTIP125R3BF13M	I11
2888905	KTIP130R3BF13M	I11
2888906	KTIP130R3BF14M	I11
2888907	KTIP135R3BF14M	I11
2888908	KTIP140R3BF14M	I11
2888909	KTIP140R3BF15M	I11
2888910	KTIP145R3BF15M	I11
2888911	KTIP150R3BF15M	I11
2888912	KTIP150R3BF16M	I11
2888913	KTIP160R3BF16M	I11
2889053	KTIP115R4BF12M	I12
2889054	KTIP120R4BF13M	I12
2889055	KTIP125R4BF13M	I12
2889056	KTIP130R4BF14M	I12
2889057	KTIP135R4BF14M	I12
2889058	KTIP140R4BF15M	I12
2889059	KTIP145R4BF15M	I12
2889060	KTIP150R4BF16M	I12
2889061	KTIP160R4BF17M	I12
2889062	KTIP080R5BF09M	I13
2889063	KTIP085R5BF09M	I13
2889064	KTIP095R5BF10M	I13
2889065	KTIP100R5BF11M	I13
2889066	KTIP105R5BF11M	I13
2889067	KTIP110R5BF12M	I13
2889068	KTIP115R5BF12M	I13
2889069	KTIP120R5BF13M	I13
2889070	KTIP125R5BF13M	I13
2889071	KTIP130R5BF14M	I13
2889072	KTIP135R5BF14M	I13
2889073	KTIP140R5BF15M	I13
2889074	KTIP145R5BF15M	I13
2889075	KTIP150R5BF16M	I13
2889076	KTIP160R5BF17M	I13
2889261	SDCT120432ENLD2 KC522M	T104, T111, U51
2890223	B976A03700 KC7315	G138
2890773	S32SCCLNR12MX7	B372
2891696	CSDNN2525M12MX7	B363
2891706	CCKNR2525M12MX7	B356
2891727	CCKNL2525M12MX7	B356
2896948	B707A19000FBG KC7315	G115
2907289	FBSCUCR09CA06F	K112
2907291	FBSTFCR09CA11F	K113
2940518	B978A08200 KC7315	G147
2951623	BGHX15L5PCSRLET KD1415	S148
2951631	3.37092R320	I14
2951632	3.37092R820	I14
2954527	63A02RS90KE25	T80
2954528	63A03RS90KE25	T80
2956333	VNGX160712T02020 KY3500	B298
2956334	VNGX160716T02020 KY3500	B298
2957497	B707A14500FBG KC7315	G115
2957706	HNGF090504MF KC514M	S98
2957711	SNXF120412ENLD KC514M	S104
2957728	SNXF1204ZNENLD KC524M	S104
2957730	SNXF120412SNGP KC524M	S104
2957732	SNXF1204ZNSNGP KC524M	S104
2957734	SNXF120412ENLD KC524M	S104
2957735	SNXF120412SNHE KC524M	S104
2957736	SNXF1204ZNENLD KC514M	S104
2957738	SNXF120412SNGP KC514M	S104
2957739	SNXF1204ZNSNGP KC514M	S104
2957741	SNXF1204ZNSNHE KC514M	S104
2961763	551.013	B356
2963631	B511S08000 KC7315	J76
2963632	B511S10000 KC7315	J76
2963663	B511S15000 KC7315	J76
2963664	B511S20000 KC7315	J76
2963665	B511S25000 KC7315	J76
2963666	B511S30000 KC7315	J76
2963873	25A02R044A25SED18-150	T71
2963874	34A03R050A32SED18-250	T71
2963875	40A03R050A32SED18-250	T71
2963876	40A04R050A32SED18-250	T71
2964507	RNMG190600RN KC5010	B94
2965409	B977A04650 KC7315	G139
2968363	20A02R050A20SED14-170	T49
2968364	25A03R050A25SED14-170	T49
2968365	32A04R050A32SED14-200	T49
2968366	40A05R050A32SED14-200	T49
2968367	25A02R050A25SED14-170	T49
2968368	32A03R050A32SED14-200	T49
2968369	40A04R050A32SED14-200	T49
2968370	20A02R035M10SED14	T47
2968371	25A02R035M12SED14	T47
2968372	32A03R040M16SED14	T47
2968373	40A04R040M16SED14	T47
2972258	A4C0155N00CF01 KC5025	C102
2972259	A4C0155L06CF01 KC5025	C103
2972262	A4C0155R06CF01 KC5025	C103
2973094	A4C0155R16CF01 KC5025	C103
2974425	A4SMR2020K0217	C112
2975401	MS2166	T47–50
2975402	MS2167	T47–49
2978378	A4SCR1212K0113	C114
2979048	B978A05900 KC7315	G146
2979110	A4C0205L10CF02 KC5025	C103
2979111	A4C0205N00CF02 KC5025	C102
2979112	A4C0205R06CF02 KC5025	C103
2979192	A20RA4EML0207M	C119
2979216	A4C0255N00CF02 KC5025	C102
2979217	A4C0255R06CF02 KC5025	C103
2979223	A20RA4EMR0207M	C119
2979224	A25RA4EML0210M	C119
2979225	A25RA4EMR0210M	C119
2980526	EDPT140412PDSRGD KCPK30	T54, T63
2980527	EDPT140412PDSRGD KC520M	T54, T63
2980530	EDPT140408PDSRGD KC520M	T54, T63
2980531	EDPT140408PDSRGD KCPK30	T54, T63
2980568	EDPT140412PDSRGD KC725M	T54, T63
2981644	EDPT140408PDSRGD KC725M	T54, T63
2982018	OFKT07L6AFSNLB KC725M	S54
2982019	OFKT07L6AFENLB KC725M	S54
2982020	OFKT06L5AFSNLB KC725M	S50
2982021	OFKT06L5AFENLB KC725M	S50
2982065	OFKT07L6AFENLB KC522M	S54
2982069	OFKT06L5AFSNLB KC522M	S50
2982070	OFKT06L5AFSNLB KC520M	S50
2982072	OFKT06L5AFSNLB KCPK30	S50
2982077	EDPT140416PDSRGD KC725M	T54, T63
2982084	OFKT06L5AFENLB KC522M	S50
2982086	OFKT06L5AFENLB KCK15	S50
2982087	OFKT06L5AFENLB KCPK30	S50
2982090	EDPT140416PDSRGD KC520M	T54, T63
2982091	EDPT140416PDSRGD KCPK30	T54, T63
2982168	A4SCL2020K0113	C114
2982169	A4SCL1616K0113	C114
2982170	A4SCL1212K0113	C114
2982172	A4SCR2020K0113	C114
2982223	A4SCR1616K0113	C114
2982224	A4SCR1010K0113	C114
2983278	EDCT140408PDERLD KC522M	T52, T61
2983279	EDCT140408PDFRLDJ KC410M	T51, T60
2983331	EDCT140408PDERGD KC725M	T52, T61
2983890	EDCT140404PDERGD KC725M	T52, T61
2983891	EDCT140431PDERGD KC725M	T52, T61
2983980	A4G0205M02U02GMN KC5010	C96
2983981	A4G0205M02U02GMN KC5025	C96
2983982	A4G0205M02U02GMP KC5010	C95
2984013	A4G0205M02U02GMP KC5025	C95
2984015	A4G0200M02P02GMP KC5010	C95
2984016	A4G0200M02P02GMP KC5025	C95
2984018	A4G0255M2BU02GMN KC5025	C96
2984020	A4G0255M2BU02GMP KC5025	C95
2984022	A4G0250M2BP02GMP KC5010	C95
2984024	A4R0205M02U00GMN KC5010	C97
2984025	A4R0205M02U00GMN KC5025	C97
2984026	A4R0200M02P00GMP KC5010	C96
2984027	A4R0200M02P00GMP KC5025	C96
2984028	A4G0941I2BP05GMN KC5010	C97
2984053	EDCT140404PDERLD KC522M	T52, T61
2984054	EDCT140404PDFRLDJ KC410M	T51, T60
2984056	EDCT140431PDERLD KC522M	T52, T61
2984057	EDCT140431PDFRLDJ KC410M	T51, T60
2984137	EDCT140412PDERLD KC522M	T52, T61
2984138	EDCT140412PDFRLDJ KC410M	T51, T60
2984210	EDCT140412PDERGD KC725M	T52, T61
2984359	EDCT140416PDERLD KC522M	T52, T61
2984360	EDCT140416PDFRLDJ KC410M	T51, T60
2984773	EDCT140416PDERGD KC725M	T52, T61
2985272	B707A03500FBG KC7315	G114
2985333	B707A04500FBG KC7315	G114
2985334	B707A06500FBG KC7315	G114
2985335	B707A09500FBG KC7315	G115
2985336	B707A14000FBG KC7315	G115
2985682	193.465	S131–132
2985873	193.464	S131–132
2985874	193.461	S110, S131–132
2985875	193.460	S132
2985876	193.462	S132
2985878	470.269	S132
2985879	470.270	S132
2985880	470.271	S132
2985881	470.272	S132
2985882	470.273	S132
2987166	MSKNR25CA19	B115
2993398	B707A07800FBG KC7315	G114
3003873	KDMT1210ERGC KC515M	V132
3005898	B967A11000 KC7315	G133
3005899	B967A13500 KC7315	G134
3005956	B976A03100 KC7315	G138
3013657	KSEM1880HPGM KC7315	H42
3015439	DFR030204MD KC7140	J84
3015440	DFR040304MD KC7140	J84
3016028	KSEM2305HPGM KC7315	H43
3017334	A4SML2525M0217	C113
3017335	A4SML2525M0214	C113
3017336	A4SML2020K0214	C113
3017337	A4SML2020K0217	C113
3017338	A4SML1616K0214	C113
3017339	A4SMR2525M0217	C112
3017340	A4SMR2525M0214	C112
3017341	A4SMR2020K0214	C112
3017342	A4SMR1616K0214	C112
3017663	KTIP170R3SS18M	H31
3017664	KTIP180R3SS20M	H31
3017665	KTIP190R3SS20M	H31
3017666	KTIP200R3SS25M	H31

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
3017667	KTIP170R3SCF20M	H32
3017668	KTIP180R3SCF25M	H32
3017669	KTIP190R3SCF25M	H32
3017670	KTIP200R3SCF25M	H32
3017671	KTIP170R5SS18M	H31
3017672	KTIP180R5SS20M	H31
3017673	KTIP190R5SS20M	H31
3017674	KTIP200R5SS25M	H31
3017675	KTIP170R5SCF20M	H32
3017676	KTIP180R5SCF25M	H32
3017677	KTIP190R5SCF25M	H32
3017678	KTIP200R5SCF25M	H32
3020201	B707A10600FBG KC7315	G115
3021212	MS1242CG	T80, V72, V78, V82, V139
3022625	A4M50L0214M	C124
3023165	EDPT180548PDERHD KC725M	T75
3023166	EDPT180548PDERHD KCPK30	T75
3023574	KSEM2210HPGM KC7315	H43
3024727	B707A10200FBG KC7315	G115
3024745	B966A13100 KC7315	G134
3026450	12MHC030M	G85
3026451	12MHC040M	G85
3026452	12MHC050M	G85
3026643	12MHC060M	G85
3026644	12MHC070M	G85
3026645	12MHC080M	G85
3026646	12MHC090M	G85
3026647	12MHC100M	G85
3026648	20MHC030M	G85
3026649	20MHC040M	G85
3026650	20MHC050M	G85
3026651	20MHC060M	G85
3026652	20MHC070M	G85
3026653	20MHC080M	G85
3026654	20MHC090M	G85
3026655	20MHC100M	G85
3026656	20MHC110M	G85
3026657	20MHC120M	G85
3026658	20MHC130M	G85
3026659	20MHC140M	G85
3026660	20MHC150M	G85
3026661	20MHC160M	G85
3026662	25MHC030M	G85
3026663	25MHC040M	G85
3026664	25MHC050M	G85
3026665	25MHC060M	G85
3026666	25MHC070M	G85
3026667	25MHC080M	G85
3026668	25MHC090M	G85
3026669	25MHC100M	G85
3026670	25MHC120M	G85
3026671	25MHC140M	G85
3026672	25MHC160M	G85
3026675	32MHC060M	G85
3026676	32MHC070M	G85
3026677	32MHC080M	G85
3026678	32MHC090M	G85
3026679	32MHC100M	G85
3026680	32MHC110M	G85
3026681	32MHC120M	G85
3026682	32MHC130M	G85
3026683	32MHC140M	G85
3026684	32MHC150M	G85
3026685	32MHC160M	G85
3027980	KSEM1760HPGM KC7315	H42
3029371	PKG1402	K126
3029372	PKG1602	K126
3029373	PKG1802	K126
3029375	PKG0011	K126
3030845	TM25D17L26Z2	W10
3030846	TM25D17L36Z2	W10
3030847	TMT25D17L26Z2	W11
3030848	TM25D20L37Z3	W10
3030849	TM25D20L44Z3	W10
3030850	TM25D22L43Z3	W10
3030851	TMT25D22L43Z3	W11
3030852	TM25D22L55Z3	W10
3031703	TM25D30L55Z5	W10
3031704	TMT25D28L43Z4	W11
3031705	TMC25D30L80Z4	W10
3031717	TM25INSERTSCREW	W4–5, W10–13, W17–19, W24–25
3031718	TM25N100ISO KC610M	W14
3031719	TM25N150ISO KC610M	W14
3031720	TM25N200ISO KC610M	W14
3031721	TM25N250ISO KC610M	W14
3031722	TM25N300ISO KC610M	W14
3031733	TM25N20UN KC610M	W14
3031734	TM25N18UN KC610M	W14
3031735	TM25N16UN KC610M	W14
3031736	TM25N14UN KC610M	W14
3031737	TM25N12UN KC610M	W14
3031738	TM25N10UN KC610M	W14
3031739	TM25N9UN KC610M	W14
3031740	TM25N8UN KC610M	W14
3031742	TM25EN14W KC610M	W15
3031743	TM25EN12W KC610M	W15
3031744	TM25EN11W KC610M	W15
3031745	TM25EN14NPT KC610M	W15
3031746	TM25EN115NPT KC610M	W15
3031747	TM25EN14BSPT KC610M	W15
3031748	TM25EN11BSPT KC610M	W15
3031749	TM25N100ISO KC635M	W14
3031750	TM25N150ISO KC635M	W14
3031751	TM25N200ISO KC635M	W14
3031752	TM25N250ISO KC635M	W14
3031753	TM25N300ISO KC635M	W14
3031754	TM25N20UN KC635M	W14
3031756	TM25N16UN KC635M	W14
3031757	TM25N14UN KC635M	W14
3031758	TM25N12UN KC635M	W14
3031759	TM25N10UN KC635M	W14
3031760	TM25N9UN KC635M	W14
3031761	TM25N8UN KC635M	W14
3031763	TM25EN14W KC635M	W15
3031765	TM25EN11W KC635M	W15
3031766	TM25EN14NPT KC635M	W15
3031767	TM25EN115NPT KC635M	W15
3031770	TM25BLANK	W15
3031908	T320NC03750-16R3BX KC7542	M4
3031910	T320NC04375-14R3BX KC7542	M4
3031911	T320NC05000-13R3BX KC7542	M4
3031914	T320M060X100R6HX KC7542	M4
3031915	T320M080X125R6HX KC7542	M4
3031916	T320M100X150R6HX KC7542	M4
3031917	T320M120X175R6HX KC7542	M4
3031919	T320M160X200R6HX KC7542	M4
3032732	EDPT140412PDERHD KC520M	T53, T62
3033394	RCGT2006M0ELF KC725M	V83
3033723	EDPT140412PDERHD KC522M	T53, T62
3033724	EDPT140412PDERHD KC725M	T53, T62
3033725	EDPT140412PDERHD KCK15	T53, T62
3033726	EDPT140412PDERHD KCPK30	T53, T62
3033727	EDPT140408PDERHD KC520M	T53, T62
3033728	EDPT140408PDERHD KC522M	T53, T62
3033729	EDPT140408PDERHD KC725M	T53, T62
3033730	EDPT140408PDERHD KCK15	T53, T62
3033731	EDPT140408PDERHD KCPK30	T53, T62
3033751	EDPT140416PDERHD KC522M	T53, T62
3033752	EDPT140416PDERHD KC725M	T53, T62
3033953	EDPT140416PDERHD KCK15	T53, T62
3033954	EDPT140416PDERHD KCPK30	T53, T62
3033966	B707A06800FBG KC7315	G114
3039409	KSEM3400PCM KC7135	H56, H87
3039410	KSEM3600PCM KC7135	H56, H87
3040265	B978F13000 KC7315	G149
3041312	B707A06100FBG KC7315	G114
3043177	B977F03200 KC7315	G143
3043944	KSEM3500PCM KC7135	H56, H87
3047641	T320MF140X150R6HX KC7542	M4
3048803	KSEM3300PCM KC7135	H56, H87
3050716	DFR020204MD KC7140	J84
3051244	EDPT140420PDERHD KC522M	T53, T62
3051245	EDPT140420PDERHD KC725M	T53, T62
3051246	EDPT140420PDERHD KCPK30	T53, T62
3051247	EDPT140431PDERHD KC522M	T53, T62
3051248	EDPT140431PDERHD KC725M	T53, T62
3051249	EDPT140431PDERHD KCPK30	T53, T62
3051250	EDPT140440PDERHD KC522M	T53, T62
3051251	EDPT140440PDERHD KC725M	T53, T62
3051252	EDPT140440PDERHD KCPK30	T53, T62
3051549	EDPT140424PDERHD KC522M	T53, T62
3051550	EDPT140424PDERHD KC725M	T53, T62
3051551	EDPT140424PDERHD KCPK30	T53, T62
3051552	EDPT140404PDERHD KC522M	T53, T62
3051623	A4M50L2B14M	C124
3051624	A4M50R0214M	C124
3051629	A4M50L0212A060084	C126
3051631	A4M50L0212A120254	C126
3051632	A4M50L0212A250999	C126
3051663	A4M50L0212B036046	C128
3051664	A4M50L0212B042054	C128
3051665	A4M50L0212B050064	C128
3051666	A4M50L0212B060084	C128
3051667	A4M50L0212B080124	C128
3051668	A4M50L0212B120254	C128
3051670	A4M50R0212A036046	C125
3051671	A4M50R0212A042054	C125
3051672	A4M50R0212A050064	C125
3051673	A4M50R0212A060084	C125
3051674	A4M50R0212A080124	C125
3051675	A4M50R0212A120254	C125
3051676	A4M50R0212A250999	C125
3051677	A4M50R0212B036046	C127
3051678	A4M50R0212B042054	C127
3051679	A4M50R0212B050064	C127
3051680	A4M50R0212B060084	C127
3051681	A4M50R0212B080124	C127
3051682	A4M50R0212B120254	C127
3051683	A4M50R0212B250999	C127
3051863	EDPT140404PDERHD KC725M	T53, T62
3051864	EDPT140404PDERHD KCK15	T53, T62
3051865	EDPT140404PDERHD KCPK30	T53, T62
3051866	EDPT140404PDERHD KC520M	T53, T62
3053564	SDET120412PDENGDZ KCPK30	V141
3053565	SDET120412PDSNGDZ KCPK30	V141
3055223	B707A13500FBG KC7315	G115
3055230	50A04RS90SD12PL	V139
3057117	B978A03700 KC7315	G146
3057121	B978A07400 KC7315	G147
3057122	B978A09300 KC7315	G147
3058199	KSEM2560HPGM KC7315	H43
3058984	B707A04400FBG KC7315	G114
3061071	B978F14000 KC7315	G149
3063843	50A05RS90SD12PL	V139
3064110	40M3R050M16SSD12PL	V137
3064549	KSEM2470HPGM KC7315	H43
3066053	A4G0605M06U04B KCK20	C98
3066133	SDET120412PDENGDZ KC725M	V141
3066281	SDET120412PDSNGDZ KC725M	V141
3066375	SDET120412PDSNGDZ KC522M	V141
3077140	SF150FBHO1660	K125
3077141	SF100FBHO1660	K125
3093561	HNGJ0905ANENLD KC522M	S18, S22
3093719	HNGJ0905ANSNGD KCPK30	S18, S23
3094010	843.006.000	K120–122, K136
3094035	880.252.200	K133, K135
3095646	63A04RS90RC20C	V82
3095647	80A05RS90RC20C	V82
3095649	100B06RS90RC20C	V82
3095650	125B06RS90RC20C	V82
3095651	160C07RS90RC20C	V82
3095652	160C08RS90RC20C	V82
3095653	200C09RS90RC20C	V82
3097294	KSEM1660HPGM KC7315	H42
3097295	KSEM1860HPGM KC7315	H42
3098071	B707A04200FBG KC7315	G114
3101753	KIPR032RP12MF03	V153
3101754	KIPR032RP12CF03	V154
3101755	KIPR040RP12CF04	V154
3102669	B977A08020 KC7315	G140
3106096	SDPT120412PDENHPZ KCPK30	V141
3106097	SDPT120412PDSNHPZ KCPK30	V141
3106098	SDPT120412PDENHPZ KC725M	V141
3106099	SDPT120412PDSNHPZ KC725M	V141
3110522	B976A03200 KC7315	G138
3110544	B976A03600 KC7315	G138
3110545	B976A07200 KC7315	G140
3111542	32M2R050M16SSD12PL	V137
3114313	KTIP170R8SS18M	H31
3114314	KTIP180R8SS20M	H31
3114315	KTIP190R8SS20M	H31
3114316	KTIP200R8SS25M	H31
3114317	KTIP170R8SCF20M	H32
3114318	KTIP180R8SCF25M	H32
3114319	KTIP190R8SCF25M	H32
3114320	KTIP200R8SCF25M	H32
3114636	RIQ09E1312 KC6305	K55
3115582	KSOM63R050F07	S53
3115873	KSOM63R040F07	S53
3115874	KSOM80R060F07	S53
3115875	KSOM80R040F07	S53
3115876	KSOM100R080F07	S53
3115877	KSOM100R050F07	S53
3115878	KSOM125R100F07	S53
3115879	KSOM125R060F07	S53
3115880	KSOM160R120F07	S53
3115881	KSOM160R070F07	S53
3115882	KSOM32R03B250F06	S47
3115893	KSOM32R03B200F06	S47
3115894	KSOM32R02B200F06	S47
3115897	KSOM40R04B320F06	S47
3115898	KSOM40R04B250F06	S47
3115899	KSOM40R03B250F06	S47
3115903	KSOM50R040F06	S48
3115905	KSOM63R050F06	S48
3115907	KSOM80R060F06	S48
3115908	KSOM100R100F06	S48
3115909	KSOM100R070F06	S48
3115910	KSOM125R120F06	S48
3115911	KSOM125R080F06	S48
3115912	KSOM160R160F06	S48
3115913	KSOM160R100F06	S48
3117503	B967A09500 KC7315	G133
3119977	B976A10300 KC7315	G140
3120265	63A05RS90SD12PL	V139
3120266	63A06RS90SD12PL	V139
3120267	80A05RS90SD12PL	V139
3120268	80A06RS90SD12PL	V139
3120269	80A07RS90SD12PL	V139
3120270	100B07RS90SD12PL	V139
3120318	KSEM2170HPGM KC7315	H43
3120574	125B09RS90SD12PL	V139
3120577	160C10RS90SD12PL	V139
3120845	100B10RF84SN12B	S102
3121225	193.492	S4–5, S8–10, S14, S17, S20–21, S60, S62, V53–56, V64
3121287	B976A06700 KC7315	G139
3123992	RCGT2006M0SHF KC725M	V83
3124023	RCGT2006M0SHF KCPK30	V83
3124549	193.491	J23, J25, J27, J29, J31, J33, J35, J37

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
3124699	EDPT180564PDSRGD KC725M	T75
3127186	NAS3L4 KC5025	D13
3127866	B978F07400 KC7315	G149
3133459	MS1294CG	V64, V72
3135660	B256A12500 KC7315	G63
3136510	EDPT180540PDERHD KC725M	T75
3138954	SNXF120412AMSN KY3500	S105
3138955	SNXF1204ZNAMSN KY3500	S105
3139149	843.009.000	K120–122, K136
3176219	KM25LSSR2230	D83
3176220	KM25LSSL2230	D83
3176596	TRM50R0640M	E65
3176598	TRM50L0640M	E65
3176599	TRM50L0432M	E65
3176600	TRM50R0432M	E65
3176601	TRM50R0920M	E65
3176602	TRM50L0920M	E65
3176604	TRM50R0940M	E65
3176605	TRM50R0620M	E65
3176606	TRM50L0620M	E65
3176688	MS2173	B199, B202, B204–205
3176689	MS2175	B199–205, B229, B260–262
3180571	B977A14100 KC7315	G141
3273589	EDCT140402PDFRLDJ KC410M	T51, T60
3273590	EDCT140440PDFRLDJ KC410M	T51, T60
3287987	CSWM 035 040	B199, B202, B204–205
3287988	CSWM 040 050	B199–205, B229, B260–262
3287989	CSWM 060 050	B70–73, B92, B115–121, B139–142, B183, B199, B202, B220–221, B229, B235–237, B240–242, B260–263, B375–378, C171, D41–42
3287990	CSWM 080 050	B70–73, B92–93, B115–117, B119, B139–141, B183, B235, B378
3287991	CSWM 100 080	B72, B115, B119, C171, D41–42
3292774	EDCT180508PDERLDJ KC422M	T73
3292775	EDCT180524PDERLDJ KC422M	T73
3300212	B707A05800FBG KC7315	G114
3322050	B707A10500FBG KC7315	G115
3322370	CFM0402R45RHP KCU40	H34
3324493	KTIP170R3BF17M	I11
3324494	KTIP170R3BF18M	I11
3324495	KTIP180R3BF18M	I11
3324496	KTIP170R4BF18M	I12
3324497	KTIP180R4BF18M	I12
3324498	KTIP170R5BF18M	I13
3324499	KTIP180R5BF18M	I13
3324721	A4G0305M03U02B KCK20	C98
3324722	A4G0405M04U04B KCK20	C98
3324723	A4G0505M05U04B KCK20	C98
3324724	A4G0805M08U08B KCK20	C98
3324725	A4G1005M10U08B KCK20	C98
3324726	EDCT140424PDERLDJ KC422M	T52, T61
3324829	KSHR40D03R50B25SHN09	S20
3324830	KSHR40D04R50B25SHN09	S20
3324831	KSHR50A04RS45HN09	S21
3324832	KSHR50A05RS45HN09	S21
3324993	EDCT140404PDERLDJ KC422M	T52, T61
3324994	EDCT140408PDERLDJ KC422M	T52, T61
3325163	KSHR63A06RS45HN09	S21
3325164	KSHR63A07RS45HN09	S21
3325165	KSHR80A06RS45HN09	S21
3325166	KSHR80A09RS45HN09	S21
3325167	KSHR100B08RS45HN09	S21
3325168	KSHR100B11RS45HN09	S21
3325169	KSHR125B10RS45HN09	S21
3325170	KSHR125B14RS45HN09	S21
3325171	KSHR160C12RS45HN09	S21
3325172	KSHR160C16RS45HN09	S21
3326218	RCGT2006M0SGF KC522M	V83
3330195	MCFNR20CA12	B70
3330196	MCLNL20CA12	B72
3330197	MCLNR20CA12	B72
3330199	MDJNR20CA15	B92
3330200	MDQNL20CA15	B93
3330201	MDQNR20CA15	B93
3330202	MSKNL20CA15	B115
3330203	MSRNL20CA15	B116
3330206	MSSNR20CA15	B117
3330207	MTFNL20CA22	B139
3330208	MTFNR20CA22	B139
3330209	MTGNL20CA22	B140
3330222	MCKNR16CA12	B71
3330273	MCLNL16CA12	B72
3330274	MDJNL16CA15	B92
3330275	MDJNR16CA15	B92
3330276	MDQNL16CA15	B93
3330277	MDQNR16CA15	B93
3330279	MSRNL16CA12	B116
3330281	MSSNR16CA12	B117
3330283	MSYNR16CA12	B119
3330285	MTGNR16CA16	B140
3330527	100G10NP90SP10N16K	U26
3330528	100G10RP90SP10	U25
3330530	125H12NP90SP10N16K	U26
3330531	125H11RP90SP10	U25
3330952	HNGJ0905ANENLD KCK15	S18, S22
3330973	160H12NP90SP10N16K	U26
3330974	160H11RP90SP10	U25
3330975	160H11LP90SP10	U25
3330976	200J14NP90SP10N16K	U26
3330977	200J13RP90SP10	U25
3330978	200J13LP90SP10	U25
3330983	160H14NP90SD12N20K	U39
3330984	160H12RP90SD12	U38
3330985	160H12LP90SD12	U38
3330986	200J18NP90SD12N20K	U39
3330987	200J14RP90SD12	U38
3330988	200J14LP90SD12	U38
3330989	250J22NP90SD12N20K	U39
3330990	250J16RP90SD12	U38
3330991	250J16LP90SD12	U38
3331106	L20SSCLPR09	B198
3331107	L10MSCLPR06	B198
3331108	L16RSCLPR09	B198
3331109	L20SSCLPL09	B198
3331110	L12QSCLPR06	B198
3331112	L12QSCLPL06	B198
3331114	L16RSCLPL09	B198
3331115	L08KSCLPR06	B198
3331116	L12QSDUPR07	B219
3331117	L20SSDUPR11	B219
3331121	L12QSDUPL07	B219
3331123	L12QSTFPR11	B259
3331128	L08KSTFPR09	B259
3331131	L08KSTFPL09	B259
3331132	CSRPR10CA09	B376
3331143	CSSPL10CA09	B377
3331145	MCFNL10CA09	B70
3331146	MCFNR10CA09	B70
3331149	MSTNR10CA09	B118
3331150	MSYNL10CA09	B119
3331173	HNGJ0905ANSNGD KCK15	S18, S23
3331174	HNGJ0905ANENLD KC520M	S18, S22
3331175	HNGJ0905ANENLD KC725M	S18, S22
3331176	HNGJ0905ANSNGD KC725M	S18, S23
3331178	HNGJ0905ANENLD KCPK30	S18, S22
3331277	63A06RF84SN12B	S102
3331279	80A08RF84SN12B	S102
3332362	MCLNL25CA19	B72
3332803	MCLNR25CA12	B72
3332804	MCLNR25CA16	B72
3332805	MCLNR25CA19	B72
3343592	KSEM2310HPGM KC7315	H43
3345674	20A02R039A20SED14	T49
3345675	25A02R044A25SED14	T49
3345676	25A03R044A25SED14	T49
3345677	32A03R050A25SED14	T49
3345678	32A04R050A25SED14	T49
3345679	25A03R035M12SED14	T47
3345680	32A04R040M16SED14	T47
3345681	40A05R040M16SED14	T47
3346236	MCFNR12CA12	B70
3346237	MCKNL12CA12	B71
3346238	MCKNR12CA12	B71
3346240	MDJNL12CA11	B92
3346241	MDJNR12CA11	B92
3346242	MSKNL12CA12	B115
3346273	MSYNL12CA12	B119
3346274	MSYNR12CA12	B119
3346275	MTGNL12CA16	B140
3348765	32A03R050A32SED14	T49
3348766	32A04R050A32SED14	T49
3348767	40A04R050A32SED14	T49
3348768	40A05R050A32SED14	T49
3349309	HNEN0905ANSN KD200	S92, S98
3349685	25A02R044A25SED18	T71
3349686	32A03R050A32SED18	T71
3349688	40A04R050A32SED18	T71
3349689	32A03R050A25SED18	T71
3349690	25A02R035M12SED18	T69
3349691	32A02R040M16SED18	T69
3349692	32A03R040M16SED18	T69
3349773	40A03R040M16SED18	T69
3349774	40A04R040M16SED18	T69
3351707	KHDA0600A6ANA KC639M	P136
3351708	KHDA0800A6ANA KC639M	P136
3351709	KHDA1000A6ANA KC639M	P136
3351710	KHDA1200A6ANA KC639M	P136
3351711	KHDA1600A6ANA KC639M	P136
3351712	KHDA2000A6ANA KC639M	P136
3352074	881.252.720	K133
3352369	KMDA0600A6ANA KC639M	P137
3352370	KMDA0800A6ANA KC639M	P137
3352371	KMDA1000A6ANA KC639M	P137
3352372	KMDA1200A6ANA KC639M	P137
3352493	KMDA1600A6ANA KC639M	P137
3352494	KMDA2000A6ANA KC639M	P137
3353405	KSEM2973HPGM KC7315	H43
3362163	881.252.550	K133–134
3364974	B978F05000 KC7315	G149
3367371	B531A03200SPF KDF400	G105
3367372	B531A05100SPF KDF400	G105
3367373	B531A06500SPF KDF400	G105
3367382	B532A03200SPF KDF400	G105
3367383	B532A05100SPF KDF400	G105
3367384	B532A06500SPF KDF400	G105
3367385	B531A06000SPF KDF400	G105
3367386	B532A06000SPF KDF400	G105
3379064	EDPT180564PDERHD KC725M	T75
3379065	EDPT180564PDERHD KCPK30	T75
3380488	KSEM1250HPLM KC7320	H50
3380490	KSEM1270HPLM KC7320	H50
3380491	KSEM1280HPLM KC7320	H50
3380492	KSEM1293HPLM KC7320	H50
3381103	KSEM1300HPLM KC7320	H50
3381104	KSEM1350HPLM KC7320	H50
3381105	KSEM1360HPLM KC7320	H50
3381106	KSEM1380HPLM KC7320	H50
3381107	KSEM1389HPLM KC7320	H50
3381108	KSEM1400HPLM KC7320	H50
3381109	KSEM1410HPLM KC7320	H50
3381110	KSEM1415HPLM KC7320	H50
3381111	KSEM1420HPLM KC7320	H50
3381112	KSEM1429HPLM KC7320	H50
3381113	KSEM1450HPLM KC7320	H50
3381114	KSEM1460HPLM KC7320	H50
3381115	KSEM1468HPLM KC7320	H50
3381116	KSEM1480HPLM KC7320	H50
3381117	KSEM1500HPLM KC7320	H50
3381118	KSEM1508HPLM KC7320	H50
3381119	KSEM1548HPLM KC7320	H50
3381120	KSEM1550HPLM KC7320	H50
3381121	KSEM1560HPLM KC7320	H50
3381122	KSEM1588HPLM KC7320	H50
3381123	KSEM1600HPLM KC7320	H50
3381124	KSEM1609HPLM KC7320	H50
3381125	KSEM1610HPLM KC7320	H50
3381126	KSEM1615HPLM KC7320	H50
3381127	KSEM1620HPLM KC7320	H50
3381128	KSEM1627HPLM KC7320	H50
3381129	KSEM1650HPLM KC7320	H50
3381130	KSEM1667HPLM KC7320	H50
3381131	KSEM1700HPLM KC7320	H50
3381132	KSEM1707HPLM KC7320	H50
3381133	KSEM1746HPLM KC7320	H50
3381134	KSEM1750HPLM KC7320	H50
3381135	KSEM1775HPLM KC7320	H50
3381136	KSEM1780HPLM KC7320	H50
3381137	KSEM1786HPLM KC7320	H50
3381138	KSEM1790HPLM KC7320	H50
3381139	KSEM1800HPLM KC7320	H50
3381140	KSEM1826HPLM KC7320	H50
3381142	KSEM1850HPLM KC7320	H50
3381143	KSEM1860HPLM KC7320	H50
3381144	KSEM1865HPLM KC7320	H50
3381145	KSEM1890HPLM KC7320	H50
3381146	KSEM1900HPLM KC7320	H50
3381147	KSEM1905HPLM KC7320	H50
3381148	KSEM1920HPLM KC7320	H50
3381149	KSEM1923HPLM KC7320	H50
3381150	KSEM1925HPLM KC7320	H50
3381151	KSEM1927HPLM KC7320	H50
3381152	KSEM1935HPLM KC7320	H50
3381153	KSEM1936HPLM KC7320	H50
3381154	KSEM1945HPLM KC7320	H50
3381155	KSEM1950HPLM KC7320	H50
3381156	KSEM1984HPLM KC7320	H50
3381157	KSEM2000HPLM KC7320	H50
3381158	KSEM2010HPLM KC7320	H50
3381159	KSEM2024HPLM KC7320	H50
3381160	KSEM2035HPLM KC7320	H50
3381161	KSEM2050HPLM KC7320	H50
3381162	KSEM2064HPLM KC7320	H50
3381163	KSEM2100HPLM KC7320	H50
3381164	KSEM2115HPLM KC7320	H50
3381165	KSEM2133HPLM KC7320	H50
3381166	KSEM2810HPLM KC7320	H51
3381167	KSEM2143HPLM KC7320	H50
3381168	KSEM2850HPLM KC7320	H51
3381169	KSEM2150HPLM KC7320	H50
3381170	KSEM2858HPLM KC7320	H51
3381171	KSEM2183HPLM KC7320	H50
3381172	KSEM2900HPLM KC7320	H51
3381173	KSEM2200HPLM KC7320	H50
3381174	KSEM2937HPLM KC7320	H51
3381175	KSEM2223HPLM KC7320	H50
3381176	KSEM2950HPLM KC7320	H51
3381177	KSEM2244HPLM KC7320	H50
3381178	KSEM2977HPLM KC7320	H51
3381179	KSEM2250HPLM KC7320	H50
3381180	KSEM3000HPLM KC7320	H51
3381181	KSEM2277HPLM KC7320	H50
3381182	KSEM3016HPLM KC7320	H51
3381183	KSEM2300HPLM KC7320	H50
3381184	KSEM3050HPLM KC7320	H51
3381185	KSEM2342HPLM KC7320	H50
3381186	KSEM3100HPLM KC7320	H51
3381187	KSEM2350HPLM KC7320	H50
3381188	KSEM3150HPLM KC7320	H51
3381189	KSEM2381HPLM KC7320	H50
3381190	KSEM3175HPLM KC7320	H51
3381191	KSEM2400HPLM KC7320	H50
3381192	KSEM3200HPLM KC7320	H51
3381193	KSEM2450HPLM KC7320	H50
3381194	KSEM3300HPLM KC7320	H51
3381195	KSEM2461HPLM KC7320	H50
3381196	KSEM3493HPLM KC7320	H51
3381197	KSEM3571HPLM KC7320	H51
3381198	KSEM3810HPLM KC7320	H51
3381199	KSEM3846HPLM KC7320	H51
3381615	KSEM3400HPLM KC7320	H51
3381616	KSEM2500HPLM KC7320	H50
3381617	KSEM3500HPLM KC7320	H51
3381618	KSEM2507HPLM KC7320	H50
3381619	KSEM3600HPLM KC7320	H51
3381620	KSEM2540HPLM KC7320	H50
3381621	KSEM3700HPLM KC7320	H51
3381622	KSEM2550HPLM KC7320	H50
3381623	KSEM3750HPLM KC7320	H51
3381624	KSEM2560HPLM KC7320	H50
3381625	KSEM3800HPLM KC7320	H51
3381626	KSEM2565HPLM KC7320	H51

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
3381627	KSEM3900HPLM KC7320	H51
3381628	KSEM2567HPLM KC7320	H51
3381630	KSEM2600HPLM KC7320	H51
3381631	KSEM4000HPLM KC7320	H51
3381632	KSEM2581HPLM KC7320	H51
3381633	KSEM2619HPLM KC7320	H51
3381634	KSEM1311HPLM KC7320	H50
3381635	KSEM2650HPLM KC7320	H51
3381636	KSEM2659HPLM KC7320	H51
3381637	KSEM2779HPLM KC7320	H51
3381638	KSEM2670HPLM KC7320	H51
3381639	KSEM2817HPLM KC7320	H51
3381640	KSEM2700HPLM KC7320	H51
3381641	KSEM3254HPLM KC7320	H51
3381642	KSEM2750HPLM KC7320	H51
3381643	KSEM3335HPLM KC7320	H51
3381644	KSEM2800HPLM KC7320	H51
3382970	B707A12100FBG KC7315	G115
3383028	CNGA120408S01020MT KB1345	B290
3383030	CNGA120408S02020MT KB1345	B290
3383031	DNGA150408S01020MT KB1345	B290
3383294	CCGW09T308EC KB1345	B290
3383296	TPGW110204EC KB1345	B291
3383298	DCGW11T304S01015MT KB1345	B291
3383314	DCGW11T308S01015MT KB1345	B291
3383760	B707A09800FBG KC7315	G115
3387725	RCGT2006M0SGF KC725M	V83
3387910	NR2M050L KC5010	C158
3387928	NR3M150L KC5010	C158
3387935	NR2M050R KC5010	C158
3387936	NR2M075R KC5010	C158
3387937	NR2M100R KC5010	C158
3388407	NR2M100L KC5025	C158
3388409	NR2M150L KC5025	C158
3388411	NR3M100L KC5025	C158
3388453	NR3M150L KC5025	C158
3388455	NR3M200L KC5025	C158
3388460	NR2M050R KC5025	C158
3388462	NR2M100R KC5025	C158
3388463	NR2M125R KC5025	C158
3388464	NR2M150R KC5025	C158
3388465	NR2M175R KC5025	C158
3388466	NR3M100R KC5025	C158
3388468	NR3M150R KC5025	C158
3388470	NR3M200R KC5025	C158
3397222	NGD2M200LK KC5010	C149
3397223	NGD2M250LK KC5010	C149
3397226	NGD3M300LK KC5010	C149
3397243	NGD2M150RK KC5010	C149
3397244	NGD2M200RK KC5010	C149
3397246	NGD3M200RK KC5010	C149
3397247	NGD3M250RK KC5010	C149
3397248	NGD3M300RK KC5010	C149
3397250	NGD3M400RK KC5010	C149
3397259	NGD2M150LK KC5025	C149
3397273	NGD2M200LK KC5025	C149
3397274	NGD2M250LK KC5025	C149
3397275	NGD3M200LK KC5025	C149
3397276	NGD3M250LK KC5025	C149
3397277	NGD3M300LK KC5025	C149
3397279	NGD3M350LK KC5025	C149
3397280	NGD3M400LK KC5025	C149
3397286	NGD2M150RK KC5025	C149
3397287	NGD2M200RK KC5025	C149
3397288	NGD2M250RK KC5025	C149
3397289	NGD3M200RK KC5025	C149
3397290	NGD3M250RK KC5025	C149
3397291	NGD3M300RK KC5025	C149
3397293	NGD3M400RK KC5025	C149
3397369	NG2M050LK KC5010	C147
3397370	NG2M050RK KC5010	C146
3397613	NF3M200LK KC5025	C159
3397614	NF3M300LK KC5025	C159
3397615	NFD3M300LK KC5025	C160
3397616	NF3M200RK KC5025	C159
3397617	NF3M300RK KC5025	C159
3397618	NFD3M300RK KC5025	C160
3398457	B978F09500 KC7315	G149
3398461	B978F04700 KC7315	G149
3398487	B978F07000 KC7315	G149
3398489	B978F07500 KC7315	G149
3399619	KSEM3700PCM KC7135	H56, H87
3400552	MS2197	V137–139
3400611	MS2191C00	T58–59, V72, V137–138, V140
3400612	MS2191C06	T58–59, V137–138, V140
3400613	MS2191C08	T58–59, V137–138, V140
3400616	MS2191C12	T58–59, V137–140
3400617	MS2191C14	T58–59, V137–138, V140
3400618	MS2191C16	T58–59, V137–138, V140
3400619	MS2191C18	T58–59, V137–138, V140
3400620	MS2191C20	T57–59, V137–140
3400879	12748500500	S95
3402143	32M2R040A25SSD12PL	V138
3402144	40M3R040A32SSD12PL	V138
3403362	CNMG120404UP KC5010	B54
3403423	CNMG120408UP KC5010	B54
3403424	CNMG120412UP KC5010	B54
3403430	DNMG150408UP KC5010	B82
3403433	DNMG150608UP KC5010	B82
3403435	SNMG120408UP KC5010	B102
3403444	VNMG160404UP KC5010	B147
3403445	VNMG160408UP KC5010	B147
3403448	WNMG080408UP KC5010	B160
3403449	WNMG080412UP KC5010	B160
3450355	MS1234CG	S21, V64
3450356	MS2189C	S10, S14, S17, S21, S25, S48, S53, S60, S62, T17, V139
3480435	B977A03250 KC7315	G138
3482532	CCMT09T308FP KCU10	B176
3482959	T331NC2500-20R3BX KC7542	M22
3482960	T331NF2500-28R3BX KC7542	M22
3482961	T331NC3125-18R3BX KC7542	M22
3482962	T331NC3750-16R3BX KC7542	M22
3483053	T331NC4375-14R3BX KC7542	M22
3483054	T331NC5000-13R3BX KC7542	M22
3483057	T331M060X100R6HX KC7542	M23
3483058	T331M080X125R6HX KC7542	M23
3483059	T331M100X150R6HX KC7542	M23
3483061	T331M120X175R6HX KC7542	M23
3483062	T331MF120X150R6HX KC7542	M23
3483073	T331M140X200R6HX KC7542	M23
3483074	T331MF140X150R6HX KC7542	M23
3483075	T331M160X200R6HX KC7542	M23
3491692	B978A13100 KC7315	G148
3492007	MCCM16001	S62, V60, V82, V139
3492010	MCC080001	V82
3496233	B977F05558 KC7315	G143
3503895	EDCT180564PDERLDJ KC422M	T73
3503901	MS2187C	S62, T17, V60, V78, V82, V139
3503902	MS2195C	V56, V60, V72, V78
3505052	B707A03175FBG KC7315	G114
3505133	B707A03970FBG KC7315	G114
3505134	B707A04763FBG KC7315	G114
3505135	B707A06350FBG KC7315	G114
3505136	B707A07145FBG KC7315	G114
3505137	B707A07938FBG KC7315	G114
3505138	B707A08334FBG KC7315	G114
3505139	B707A09129FBG KC7315	G115
3505140	B707A09525FBG KC7315	G115
3505141	B707A10320FBG KC7315	G115
3505142	B707A11111FBG KC7315	G115
3505143	B707A11509FBG KC7315	G115
3505144	B707A11908FBG KC7315	G115
3505145	B707A14288FBG KC7315	G115
3505146	B707A15875FBG KC7315	G115
3505147	B707A17463FBG KC7315	G115
3505148	B707A19050FBG KC7315	G115
3505149	B707A15500FBG KC7315	G115
3505150	B707A16500FBG KC7315	G115
3505151	B707A17500FBG KC7315	G115
3505152	B707A18500FBG KC7315	G115
3505952	B966A20000 KC7315	G134
3519355	B707A10800FBG KC7315	G115
3521303	KSEM2330HPGM KC7315	H43
3524411	UCDE0400A5ARA KC643M	P30
3524412	UCDE0500A5ASA KC643M	P30
3524433	UCDE0500A5ARA KC643M	P30
3524434	UCDE0600A5ASA KC643M	P30
3524435	UCDE0600A5ARA KC643M	P30
3524436	UCDE0700A5ASA KC643M	P30
3524437	UCDE0700A5ARA KC643M	P30
3524438	UCDE0800A5ASA KC643M	P30
3524439	UCDE0800A5ARA KC643M	P30
3524440	UCDE0900A5ASA KC643M	P30
3524441	UCDE0900A5ARA KC643M	P30
3524442	UCDE1000A5ASA KC643M	P30
3524443	UCDE1000A5ARA KC643M	P30
3524444	UCDE1200A5ASA KC643M	P30
3524445	UCDE1200A5ARA KC643M	P30
3524446	UCDE1400A5ASA KC643M	P30
3524447	UCDE1400A5ARA KC643M	P30
3524448	UCDE1600A5ASA KC643M	P30
3524449	UCDE1600A5ARA KC643M	P30
3524450	UCDE1800A5ASA KC643M	P30
3524451	UCDE1800A5ARA KC643M	P30
3524452	UCDE2000A5ASA KC643M	P30
3524453	UCDE2000A5ARA KC643M	P30
3524454	UCDE2500A5ASA KC643M	P30
3524455	UCDE2500A5ARA KC643M	P30
3524456	UCDE0400A5ASA KC643M	P30
3524462	UCDE0400B5ARA KC643M	P30
3524473	UCDE0500B5ARA KC643M	P30
3524474	UCDE0600B5ARA KC643M	P30
3524475	UCDE0700B5ARA KC643M	P30
3524476	UCDE0800B5ARA KC643M	P30
3524477	UCDE0900B5ARA KC643M	P30
3524478	UCDE1000B5ARA KC643M	P30
3524479	UCDE1200B5ARA KC643M	P30
3524480	UCDE1400B5ARA KC643M	P30
3524481	UCDE1600B5ARA KC643M	P30
3524482	UCDE1800B5ARA KC643M	P30
3524483	UCDE2000B5ARA KC643M	P30
3524484	UCDE2500B5ARA KC643M	P30
3524485	UDDE0600A5ASA KC643M	P31
3524486	UDDE0600A5ARA KC643M	P31
3524487	UDDE0600A5ARB KC643M	P31
3524488	UDDE0600A5ARC KC643M	P31
3524489	UDDE0800A5ASA KC643M	P31
3524490	UDDE0800A5ARA KC643M	P31
3524491	UDDE0800A5ARB KC643M	P31
3524492	UDDE0800A5ARC KC643M	P31
3524513	UDDE1000A5ASA KC643M	P31
3524514	UDDE1000A5ARA KC643M	P31
3524515	UDDE1000A5ARB KC643M	P31
3524516	UDDE1000A5ARC KC643M	P31
3524517	UDDE1000A5ARD KC643M	P31
3524518	UDDE1200A5ASA KC643M	P31
3524519	UDDE1200A5ARA KC643M	P31
3524520	UDDE1200A5ARB KC643M	P31
3524521	UDDE1200A5ARC KC643M	P31
3524522	UDDE1200A5ARD KC643M	P31
3524523	UDDE1600A5ASA KC643M	P32
3524524	UDDE1600A5ARA KC643M	P31
3524525	UDDE1600A5ARB KC643M	P31
3524526	UDDE1600A5ARC KC643M	P31
3524527	UDDE1600A5ARD KC643M	P32
3524528	UDDE1600A5ARE KC643M	P32
3524529	UDDE2000A5ASA KC643M	P32
3524530	UDDE2000A5ARA KC643M	P32
3524531	UDDE2000A5ARB KC643M	P32
3524532	UDDE2000A5ARC KC643M	P32
3524533	UDDE2000A5ARD KC643M	P32
3524534	UDDE2000A5ARE KC643M	P32
3524535	UDDE2500A5ASA KC643M	P32
3524536	UDDE2500A5ARA KC643M	P32
3524537	UDDE2500A5ARB KC643M	P32
3524538	UDDE2500A5ARC KC643M	P32
3524539	UDDE2500A5ARD KC643M	P32
3524540	UDDE2500A5ARE KC643M	P32
3524542	UDDE0600B5ARA KC643M	P31
3524543	UDDE0600B5ARB KC643M	P31
3524544	UDDE0600B5ARC KC643M	P31
3524545	UDDE0600B5ARD KC643M	P31
3524546	UDDE0800B5ARA KC643M	P31
3524547	UDDE0800B5ARB KC643M	P31
3524548	UDDE0800B5ARC KC643M	P31
3524549	UDDE0800B5ARD KC643M	P31
3524550	UDDE1000B5ARA KC643M	P31
3524551	UDDE1000B5ARB KC643M	P31
3524552	UDDE1000B5ARC KC643M	P31
3524553	UDDE1000B5ARD KC643M	P31
3524554	UDDE1200B5ARA KC643M	P31
3524555	UDDE1200B5ARB KC643M	P31
3524556	UDDE1200B5ARC KC643M	P31
3524557	UDDE1200B5ARD KC643M	P31
3524558	UDDE1600B5ARA KC643M	P31
3524559	UDDE1600B5ARB KC643M	P31
3524560	UDDE1600B5ARC KC643M	P31
3524561	UDDE1600B5ARD KC643M	P32
3524562	UDDE1600B5ARE KC643M	P32
3524563	UDDE2000B5ARA KC643M	P32
3524564	UDDE2000B5ARB KC643M	P32
3524565	UDDE2000B5ARC KC643M	P32
3524566	UDDE2000B5ARD KC643M	P32
3524567	UDDE2000B5ARE KC643M	P32
3524568	UDDE2500B5ARA KC643M	P32
3524569	UDDE2500B5ARB KC643M	P32
3524570	UDDE2500B5ARC KC643M	P32
3524571	UDDE2500B5ARD KC643M	P32
3524572	UDDE2500B5ARE KC643M	P32
3526417	KSEM1935HPGM KC7315	H42
3528124	B976A03180 KC7315	G138
3528125	B976A03500 KC7315	G138
3528126	B976A04620 KC7315	G139
3528127	B976A05250 KC7315	G139
3528128	B976A06530 KC7315	G139
3528129	B976A06750 KC7315	G139
3528131	B976A08430 KC7315	G140
3528132	B976A09750 KC7315	G140
3547022	XNGJ0905ANSNGD3W KCK15	S22
3547033	XNGJ0905ANSNGD3W KC725M	S22
3547035	XNGJ0905ANSNGD3W KCPK30	S22
3553429	KGMSR2525M65	C129
3553430	KGMSL2525M65	C129
3553431	KGMSR3232P65	C129
3553432	KGMSL3232P65	C129
3553453	KGMER2525M65	C130
3553454	KGMEL2525M65	C130
3553455	KGMER3232P65	C130
3553456	KGMEL3232P65	C130
3553503	B976A07600 KC7315	G140
3554366	CV40BKR32157	K86
3554367	CV40BKR50236	K86
3554368	CV50BKR32157	K86
3554369	CV50BKR50157	K86
3554370	CV50BKR63236	K86
3554371	CV50BKR80275	K86
3554372	BT40BKR32030M	K86
3554373	BT40BKR50050M	K86
3554374	BT50BKR32040M	K86
3554375	BT50BKR50040M	K86
3554376	BT50BKR63060M	K86
3554377	BT50BKR80060M	K86
3556330	HNGJ0905ANSNHD KCK15	S19, S23
3556331	HNGJ0905ANSNHD KC725M	S19, S23
3556332	HNGJ0905ANSNHD KCPK30	S19, S23
3556346	MB24RBHT06F	K120
3556347	MB30RBHT06F	K120
3556348	MB40RBHT09F	K120
3556349	MB50RBHT09F	K120
3556350	MB66RBHT12F	K120
3556352	MB66RBHT12LF	K120
3556373	HNGJ090543ANSNHD KCK15	S19, S23
3556374	HNGJ090543ANSNHD KC725M	S19, S23
3556375	HNGJ090543ANSNHD KCPK30	S19, S23
3556393	MB87RBHT12F	K120
3556394	MB87RBHT16LF	K120
3556395	MB115RBHT12F	K120
3556396	MB115RBHT16LF	K120
3556397	MB24RBHT06K	K121

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
3556398	MB30RBHT06K	K121
3556399	MB40RBHT09K	K121
3556400	MB50RBHT09K	K121
3556401	MB66RBHT12K	K121
3556402	MB66RBHT12LK	K121
3556403	MB87RBHT12K	K121
3556404	MB87RBHT16LK	K121
3556405	MB115RBHT16LK	K121
3557114	A4M65R0620M	C124
3557115	A4M65L0620M	C124
3557116	A4M65R0626M	C124
3557117	A4M65L0626M	C124
3557119	A4M65L0820M	C124
3557120	A4M65R0826M	C124
3557121	A4M65L0826M	C124
3557123	A4M65L1020M	C124
3557124	A4M65R1026M	C124
3557125	A4M65L1026M	C124
3557131	A4M65R0624A070-112	C125
3557132	A4M65L0624A070-112	C126
3557163	A4M65R0624A100-212	C125
3557164	A4M65L0624A100-212	C126
3557165	A4M65R0624A200-999	C125
3557166	A4M65L0624A200-999	C126
3557167	A4M65R0824A090-200	C125
3557169	A4M65R0824A184-999	C125
3557173	A4M65R1024A200-999	C125
3557174	A4M65L1024A200-999	C126
3557175	A4M65R0624B070-112	C127
3557176	A4M65L0624B070-112	C128
3557177	A4M65R0624B100-212	C127
3557178	A4M65L0624B100-212	C128
3557179	A4M65R0624B200-999	C127
3557180	A4M65L0624B200-999	C128
3557181	A4M65R0824B090-200	C127
3557182	A4M65L0824B090-200	C128
3557193	A4M65R0824B184-999	C127
3557194	A4M65L0824B184-999	C128
3557195	A4M65R1024B100-220	C127
3557197	A4M65R1024B200-999	C127
3557198	A4M65L1024B200-999	C128
3557310	12147629800	K111–113
3559794	B967A14500 KC7315	G134
3560480	SDCT120464ENLD2 KC725M	T104, T111, U51
3560482	SDET120464SNGB2 KCPK30	T104, T111, U52
3563231	B707A12700FBG KC7315	G115
3575847	193.531	S25
3577119	KTMS21S25SD06H	U3
3577121	KTMS25S25SD06H	U3
3577133	KTMS32S32SD08H	U3
3577135	KTMS40S32SD12H	U3
3577137	KTMS50S32SD12H	U3
3579858	KSEM2070HPGM KC7315	H42
3583765	SDMT060304EGG KC735M	U4
3583766	SDMT060304EGG KC730M	U4
3583768	SDMT080308EGG KC505M	U4
3583769	SDMT080308EGG KC735M	U4
3583770	SDMT080308EGG KC730M	U4
3583784	SDMT120408EGG KC505M	U4
3583785	SDMT120408EGG KC735M	U4
3583786	SDMT120408EGG KC730M	U4
3585206	B531A03300SPF KDF400	G105
3585207	B531A03600SPF KDF400	G105
3585208	B531A04000SPF KDF400	G105
3585209	B531A04366SPF KDF400	G105
3585210	B531A04851SPF KDF400	G105
3585211	B531A04864SPF KDF400	G105
3585212	B531A05200SPF KDF400	G105
3585213	B531A06375SPF KDF400	G105
3585214	B531A06400SPF KDF400	G105
3585215	B531A07938SPF KDF400	G105
3585217	B531A09550SPF KDF400	G105
3585218	B531A09563SPF KDF400	G105
3585219	B531A11125SPF KDF400	G105
3585220	B531A12725SPF KDF400	G105
3585221	B532A03300SPF KDF400	G105
3585222	B532A03600SPF KDF400	G105
3585224	B532A04366SPF KDF400	G105
3585225	B532A04851SPF KDF400	G105
3585227	B532A05200SPF KDF400	G105
3585228	B532A06375SPF KDF400	G105
3585229	B532A06400SPF KDF400	G105
3585230	B532A07938SPF KDF400	G105
3585233	B532A09563SPF KDF400	G105
3585235	B532A12725SPF KDF400	G105
3586088	KSEM125SEFM	H64
3586089	KSEM130SEFM	H64
3586090	KSEM135SEFM	H64
3586091	KSEM140SEFM	H64
3586092	KSEM145SEFM	H64
3586183	KSEM150SEFM	H64
3586184	KSEM155SEFM	H64
3586185	KSEM160SEFM	H64
3586186	KSEM165SEFM	H64
3586187	KSEM170SEFM	H64
3586188	KSEM175SEFM	H64
3586189	KSEM180SEFM	H64
3586190	KSEM185SEFM	H64
3586191	KSEM190SEFM	H64
3586192	KSEM195SEFM	H64
3586193	KSEM200SEFM	H64
3586194	KSEM205SEFM	H64
3586195	KSEM210SEFM	H64
3586196	KSEM215SEFM	H64
3586197	KSEM220SEFM	H64
3586198	KSEM225SEFM	H64
3586199	KSEM230SEFM	H64
3586200	KSEM235SEFM	H64
3586201	KSEM240SEFM	H64
3586202	KSEM245SEFM	H64
3586203	KSEM250SEFM	H64
3586204	KSEM255SEFM	H64
3586205	KSEM260SEFM	H64
3586206	KSEM265SEFM	H64
3586207	KSEM270SEFM	H64
3586208	KSEM275SEFM	H64
3586209	KSEM280SEFM	H64
3586210	KSEM285SEFM	H64
3586211	KSEM290SEFM	H64
3586212	KSEM295SEFM	H64
3586213	KSEM300SEFM	H64
3586214	KSEM305SEFM	H64
3586215	KSEM310SEFM	H64
3586216	KSEM315SEFM	H64
3586217	KSEM320SEFM	H64
3586519	KM32RBHT24	K118
3586520	KM32RBHT30	K118
3586521	KM40RBHT40	K118
3586522	KM50RBHT50	K118
3586543	KM50RBHT66	K118
3586544	KM50RBHT87	K118
3586545	KM63UTRBHT87	K118
3586546	KM63UTRBHT115	K118
3586547	HSK63RBHT24	K118
3586548	HSK63RBHT30	K118
3586549	HSK63RBHT40	K118
3586550	HSK63RBHT50	K118
3586551	HSK63RBHT66	K118
3586563	HSK63RBHT87	K118
3586564	SF075RBHT24	K119
3586565	SF100RBHT30	K119
3586566	SF125RBHT40	K119
3586567	SF100RBHT50	K119
3586569	SF125RBHT66	K119
3586570	SF150RBHT87	K119
3586571	SF200RBHT115	K119
3586572	KM32FBHS24	K133
3586573	KM32FBHS31	K133
3586574	KM40FBHS40	K133
3586575	KM50FBHS51	K133
3586576	KM50FBHS67	K133
3586577	KM50FBHS87	K133
3586578	KM63UTFBHS87	K133
3586579	KM63UTFBHS116	K133
3586580	HSK63FBHS24	K133
3586581	HSK63FBHS31	K133
3586582	HSK63FBHS40	K133
3586583	HSK63FBHS51	K133
3586584	HSK63FBHS67	K133
3586585	HSK63FBHS87	K133
3587211	881.252.250	K133, K135
3587212	880.252.250	K133, K135
3587695	880.252.320	K133–134
3587698	881.252.420	K133–134
3587699	880.252.420	K133–134
3587703	881.252.940	K133
3587704	841.342.200	K118–120
3587705	848.200.005	K121
3587706	848.200.407	K120–122
3587707	848.250.005	K121
3587708	848.250.409	K120–122
3587709	848.320.005	K121
3587710	848.320.413	K120–122
3587711	841.342.420	K118–119
3587712	848.420.005	K121
3587713	848.420.614	K120–122
3587714	841.142.550	K118–119
3587715	848.550.620	K120–122
3587716	848.550.005	K121
3587717	843.012.000	K120–122
3587718	844.012.000	K120–122
3587719	845.012.000	K120–122
3587720	846.012.000	K120–122
3587721	847.012.000	K120–122
3587722	841.142.720	K118–119
3587723	848.720.000	K120–122
3587724	848.720.005	K121
3587725	844.016.000	K120–122
3587726	845.016.000	K120–122
3587727	846.016.000	K120–122
3587728	847.016.000	K120–122
3587729	841.142.940	K118–119
3587730	848.940.640	K120, K122
3587732	KSHR200C16RS45HN09	S21
3587753	KSHR250C20RS45HN09	S21
3587754	KSHR315C24RS45HN09	S21
3588387	KSEM1604HPGM KC7315	H42
3592190	B978A05600 KC7315	G146
3593089	B978A04500 KC7315	G146
3593675	MS2206	U3
3593676	MS2207	U3
3593681	MS2208	U3
3593911	MS2205	T29–33, T38–41
3594435	B977F04550 KC7315	G143
3594438	B977F03600 KC7315	G143
3595785	MCLNR3232P12	B62
3595786	MCLNL3232P12	B62
3595787	MCLNR3232P16	B62
3595788	MCLNL3232P16	B62
3597589	MS2219	V38–40
3598160	B256A10200 KC7315	G63
3598188	B967A06500 KC7315	G133
3609446	KSEM2325HPGM KC7315	H43
3612090	H40SCLCR12	B183
3612136	H40SDUCR11	B213
3612138	H50SDUCR11	B213
3612139	H50SDUCL11	B213
3612156	H32MCLNR12	B68
3612178	H50MCLNR12	B68
3612192	H50MDUNL19	B91
3612215	H40MVUNR16	B153
3612219	H50MVUNR16	B153
3612259	MWLNR3232P08	B162
3612260	MWLNL3232P08	B162
3612649	MVJNR3232P16	B151
3612650	MVJNL3232P16	B151
3613695	MS2072CG	S21, V72, V139
3613696	MS2038CG	S21, V64, V72, V78, V139
3615883	B976A09400 KC7315	G140
3616778	KSEM3220HPGM KC7315	H43
3617131	RIQ06E1306 KC6305	K55
3617415	KIPR025RP09CF03	V154
3617416	KIPR020RP06CF03	V154
3617418	KIPR016RP06CF02	V154
3636039	RPGN060200E KYSP30	V155
3636818	B978F03600 KC7315	G149
3637389	ABDE0600A3ARA K600	P112
3637390	ABDE0600A3ARB K600	P112
3637391	ABDE0600A3ARC K600	P112
3637392	ABDE0800A3ARA K600	P112
3637413	ABDE0800A3ARB K600	P112
3637414	ABDE0800A3ARC K600	P112
3637415	ABDE1000A3ARA K600	P112
3637416	ABDE1000A3ARB K600	P112
3637417	ABDE1000A3ARC K600	P112
3637418	ABDE1200A3ARA K600	P112
3637419	ABDE1200A3ARB K600	P112
3637420	ABDE1200A3ARC K600	P112
3637421	ABDE1600A3ARA K600	P112
3637422	ABDE1600A3ARB K600	P112
3637423	ABDE1600A3ARC K600	P112
3637424	ABDE1600A3ARD K600	P112
3637425	ABDE2000A3ARA K600	P113
3637426	ABDE2000A3ARB K600	P113
3637427	ABDE2000A3ARC K600	P113
3637428	ABDE2000A3ARD K600	P113
3637429	ABDE0300A3AS K600	P111
3637430	ABDE0400A3AS K600	P111
3637431	ABDE0500A3AS K600	P111
3637432	ABDE0600A3AS K600	P111
3637463	ABDE0800A3AS K600	P111
3637464	ABDE1000A3AS K600	P111
3637465	ABDE1200A3AS K600	P111
3637466	ABDE1400A3AS K600	P111
3637467	ABDE1600A3AS K600	P111
3637468	ABDE1800A3AS K600	P111
3637469	ABDE2000A3AS K600	P111
3637552	ABDF0150A2AS K600	P110
3637553	ABDF0200A2AS K600	P110
3637554	ABDF0250A2AS K600	P110
3637555	ABDF0300A2AS K600	P110
3637556	ABDF0400A2AS K600	P110
3637557	ABDF0500A2AS K600	P110
3637558	ABDF0600A2AS K600	P110
3637559	ABDF0800A2AS K600	P110
3637560	ABDF1000A2AS K600	P110
3637561	ABDF1200A2AS K600	P110
3637562	ABDF1400A2AS K600	P110
3637563	ABDF1600A2AS K600	P110
3637564	ABDF1800A2AS K600	P110
3637565	ABDF2000A2AS K600	P110
3637636	D40MTTB560KM40	B387
3637637	D50MTTB737KM40	B387
3637638	D60MTTB1000KM40	B387
3638550	MDJNR3232P15	B86
3638551	MDJNL3232P15	B86
3638615	B256A05000 KC7315	G63
3638616	B256A05500 KC7315	G63
3638617	B256A05800 KC7315	G63
3638618	B256A06000 KC7315	G63
3638619	B256A06500 KC7315	G63
3638620	B256A06800 KC7315	G63
3638621	B256A07800 KC7315	G63
3638622	B256A08500 KC7315	G63
3638623	B256A09000 KC7315	G63
3638624	B256A10000 KC7315	G63
3638625	B256A11800 KC7315	G63
3638626	B256A12000 KC7315	G63
3638627	B256A13000 KC7315	G63
3638628	B256A15000 KC7315	G63
3639212	NG3062LEST KD1425	C163
3639213	NG3062REST KD1425	C163
3639214	NG3094LEST KD1425	C163
3639215	NG3094REST KD1425	C163
3639217	NG3125REST KD1425	C163
3639219	NG3189REST KD1425	C163
3639221	NGP3088R KD1425	C152
3639223	NGP3125R KD1425	C152
3639344	NG3062LEST KB1630	C163
3639345	NG3062REST KB1630	C163
3639346	NG3094LEST KB1630	C163
3639347	NG3094REST KB1630	C163
3639348	NG3125LEST KB1630	C163
3639349	NG3125REST KB1630	C163
3639350	NG4189LEST KB1630	C155, C163
3639351	NG4189REST KB1630	C163
3639762	SCMT09T308MP KCP25	B231
3639874	SCMT09T308MP KCU10	B231
3639875	DCMT11T308MP KCK20	B208
3639877	DCMT11T308MP KCP25	B208
3639878	DCMT11T308MP KCU10	B208
3639881	TCMT16T308MP KCP25	B245

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
3639883	TCMT16T308MP KCU10	B245
3640677	B291A03000YPL KC7315	G94
3640678	B291A04000YPL KC7315	G94
3640679	B291A04500YPL KC7315	G94
3640680	B291A05000YPL KC7315	G94
3640681	B291A05100YPL KC7315	G94
3640682	B291A05500YPL KC7315	G94
3640703	B291A06000YPL KC7315	G94
3640704	B291A06350YPL KC7315	G95
3640705	B291A06500YPL KC7315	G95
3640706	B291A06800YPL KC7315	G95
3640707	B291A07000YPL KC7315	G95
3640708	B291A07500YPL KC7315	G95
3640709	B291A08000YPL KC7315	G95
3640710	B291A08334YPL KC7315	G95
3640711	B291A08500YPL KC7315	G95
3640712	B291A09000YPL KC7315	G95
3640713	B291A09500YPL KC7315	G95
3640714	B291A09525YPL KC7315	G95
3640715	B291A10000YPL KC7315	G95
3640716	B291A10320YPL KC7315	G95
3640717	B291A10500YPL KC7315	G95
3640718	B291A11000YPL KC7315	G95
3640719	B291A11500YPL KC7315	G95
3640720	B291A12000YPL KC7315	G96
3640721	B291A12500YPL KC7315	G96
3640722	B291A12700YPL KC7315	G96
3640723	B291A13000YPL KC7315	G96
3640724	B291A14000YPL KC7315	G96
3640725	B291A14500YPL KC7315	G96
3640726	B291A15000YPL KC7315	G96
3640727	B291A16000YPL KC7315	G96
3640728	B291A17000YPL KC7315	G96
3640729	B291A18000YPL KC7315	G96
3640730	B292A03000YPL KC7315	G94
3640731	B292A03175YPL KC7315	G94
3640732	B292A03500YPL KC7315	G94
3640743	B292A04000YPL KC7315	G94
3640744	B292A04200YPL KC7315	G94
3640745	B292A04300YPL KC7315	G94
3640746	B292A04500YPL KC7315	G94
3640747	B292A04800YPL KC7315	G94
3640748	B292A05000YPL KC7315	G94
3640749	B292A05100YPL KC7315	G94
3640750	B292A05200YPL KC7315	G94
3640751	B292A05410YPL KC7315	G94
3640752	B292A05500YPL KC7315	G94
3640753	B292A05558YPL KC7315	G94
3640754	B292A05600YPL KC7315	G94
3640755	B292A05800YPL KC7315	G94
3640756	B292A06000YPL KC7315	G94
3640757	B292A06350YPL KC7315	G95
3640758	B292A06500YPL KC7315	G95
3640759	B292A06528YPL KC7315	G95
3640760	B292A06746YPL KC7315	G95
3640761	B292A06800YPL KC7315	G95
3640762	B292A06900YPL KC7315	G95
3640763	B292A07000YPL KC7315	G95
3640764	B292A07100YPL KC7315	G95
3640765	B292A07145YPL KC7315	G95
3640766	B292A07500YPL KC7315	G95
3640767	B292A07938YPL KC7315	G95
3640768	B292A08000YPL KC7315	G95
3640769	B292A08334YPL KC7315	G95
3640770	B292A08433YPL KC7315	G95
3640771	B292A08500YPL KC7315	G95
3640772	B292A08733YPL KC7315	G95
3640773	B292A08800YPL KC7315	G95
3640774	B292A09000YPL KC7315	G95
3640775	B292A09200YPL KC7315	G95
3640776	B292A09347YPL KC7315	G95
3640777	B292A09500YPL KC7315	G95
3640778	B292A09525YPL KC7315	G95
3640779	B292A10000YPL KC7315	G95
3640780	B292A10200YPL KC7315	G95
3640781	B292A10320YPL KC7315	G95
3640782	B292A10500YPL KC7315	G95
3640783	B292A10716YPL KC7315	G95
3640784	B292A11000YPL KC7315	G95
3640785	B292A11112YPL KC7315	G95
3640786	B292A11500YPL KC7315	G95
3640787	B292A12000YPL KC7315	G96
3640788	B292A12304YPL KC7315	G96
3640789	B292A12500YPL KC7315	G96
3640790	B292A13000YPL KC7315	G96
3640791	B292A13500YPL KC7315	G96
3640792	B292A14000YPL KC7315	G96
3640793	B292A14500YPL KC7315	G96
3640794	B292A15000YPL KC7315	G96
3640795	B292A15500YPL KC7315	G96
3640796	B292A16000YPL KC7315	G96
3640797	B292A16500YPL KC7315	G96
3640798	B292A17000YPL KC7315	G96
3640799	B292A17500YPL KC7315	G96
3640800	B292A18000YPL KC7315	G96
3640801	B292A18500YPL KC7315	G96
3640802	B292A19000YPL KC7315	G96
3640803	B292A19050YPL KC7315	G96
3640806	B292A20000YPL KC7315	G96
3640807	B292A20500YPL KC7315	G96
3640808	B292A21000YPL KC7315	G96
3641465	DTQ3054	S116, S120, S122
3641473	BTQT25	S116, S120, S122
3641712	EDPT10T308PDERHD KC522M	T36, T43
3641734	EDPT10T308PDERHD KC725M	T36, T43
3641735	EDPT10T308PDERHD KCK15	T36, T43
3641736	EDPT10T308PDERHD KCPK30	T36, T43
3641740	EDPT10T304PDERHD KC522M	T36, T43
3641741	EDPT10T304PDERHD KC725M	T36, T43
3641742	EDPT10T304PDERHD KCK15	T36, T43
3641783	EDPT10T304PDERHD KCPK30	T36, T43
3642028	EDPT10T312PDERHD KC522M	T36, T43
3642029	EDPT10T312PDERHD KC725M	T36, T43
3642031	EDPT10T312PDERHD KCPK30	T36, T43
3642093	EDPT10T316PDERHD KC522M	T36, T43
3642094	EDPT10T316PDERHD KC725M	T36, T43
3642096	EDPT10T316PDERHD KCPK30	T36, T43
3642097	EDPT10T320PDERHD KC725M	T36, T43
3642098	EDPT10T320PDERHD KCPK30	T36, T43
3642102	EDPT10T324PDERHD KC725M	T36, T43
3642133	EDPT10T324PDERHD KCPK30	T36, T43
3642134	D80MTTB1120KM63	B387
3642135	D100MTTB1330KM63	B387
3642136	EDPT10T331PDERHD KC522M	T36, T43
3642137	EDPT10T331PDERHD KC725M	T36, T43
3642138	EDPT10T331PDERHD KCPK30	T36, T43
3642141	EDPT10T304PDSRGD KC725M	T36, T44
3642142	EDPT10T304PDSRGD KCK15	T36, T44
3642163	EDPT10T304PDSRGD KCPK30	T36, T44
3642170	EDPT10T308PDSRGD KC725M	T36, T44
3642171	EDPT10T308PDSRGD KCK15	T36, T44
3642172	EDPT10T308PDSRGD KCPK30	T36, T44
3642193	EDPT10T312PDSRGD KC725M	T36, T44
3642194	EDPT10T312PDSRGD KCK15	T36, T44
3642195	EDPT10T312PDSRGD KCPK30	T36, T44
3642196	EDPT10T316PDSRGD KC725M	T36, T44
3642198	EDPT10T316PDSRGD KCPK30	T36, T44
3642247	CRDPN2525M06V	B168, B370
3642248	CRDPN2525M09V	B168, B370
3642249	CRDPN3232P09V	B168, B370
3642251	CRDPN3232P12V	B168, B370
3642252	CRDPN3232P15V	B168, B370
3642276	CRGPR2525M06V	B168, B370
3642277	CRGPL2525M06V	B168, B370
3642280	CRGPR3232P09V	B168, B370
3642281	CRGPL3232P09V	B168, B370
3643846	KCGR110304R08 KD1425	E29
3643847	KCGR110308L08 KD1425	E29
3643849	KCGX110301L15 KD1425	E31
3643850	KCGX110301R15 KD1425	E31
3643851	KCGX110302L15 KD1425	E31
3643852	KCGX110302R15 KD1425	E31
3643853	KCGX110304L15 KD1425	E31
3643854	KCGX110304R15 KD1425	E31
3643855	VCGN160404 KD1425	B351, E34
3643856	VCGN160408 KD1425	B351, E34
3643858	VCGR160404 KD1425	B351, E34
3643859	VCGR160408 KD1425	B351, E34
3643860	VCGR160412 KD1425	B351, E34
3643862	DCGR150408 KD1425	E28
3644073	DT7IP	T30–33, T39–41
3644452	KSHR40D03R50A25SHN09	S20
3645083	KSHR40D04R50A25SHN09	S20
3646911	SNMG250924RM KC5010	B100
3647201	KSHR40A04RS45HN09	S21
3648330	CPGN120304F KD1425	B345
3648331	CPGN120308F KD1425	B345
3648332	TPGN110304F KD1425	B349
3648428	DFT06T308D36MD KC7140	H89
3648430	DFT05T308D32MD KC7140	H89
3648474	DFT070408D45MD KC7140	H89
3648478	DFT090508D56MD KC7140	H89
3648584	TPGN160304F KD1425	B349
3648585	TPGN160308F KD1425	B349
3648588	TPGN220408F KD1425	B349
3649187	EDCT10T308PDFRLDJ KC410M	T35, T42
3649188	EDCT10T308PDERLDJ KC422M	T35, T43
3649189	EDCT10T308PDERLD KC520M	T35, T43
3649190	EDCT10T308PDERLD KC522M	T35, T43
3649191	EDCT10T308PDERLD KC725M	T35, T43
3649192	EDCT10T308PDERLD KCPK30	T35, T43
3649213	EDCT10T308PDERLD KCK15	T35, T43
3650831	SCMT120408MP KCK20	B231
3650903	SCMT120408MP KCP25	B231
3654372	SPET10T304PPERGB2 KC725M	T100, U37
3654503	SPET10T304PPERGB2 KCPK30	T100, U37
3654504	SPET10T304PPERGB2 KCK15	T100, U37
3654505	SPET10T304PPELGB2 KC725M	T100, U37
3654506	SPET10T304PPELGB2 KCPK30	T100, U37
3654507	SPET10T304PPELGB2 KCK15	T100, U37
3655880	CNGA120404FST KD1400	B344
3655881	CNGA120408FST KD1400	B344
3655882	CNMS120404FST KD1400	B345
3656063	CNMS120408FST KD1400	B345
3656064	DNGA150404FST KD1400	B347
3656065	DNGA150408FST KD1400	B347
3656066	DNMS150404FST KD1400	B347
3656067	DNMS150408FST KD1400	B347
3656068	TNMS160404FST KD1400	B348
3656069	TNMS160408FST KD1400	B348
3656070	VNGA160404FST KD1400	B350
3656071	VNGA160408FST KD1400	B350
3656072	VNMS160404FST KD1400	B350
3656073	VNMS160408FST KD1400	B350
3656449	CNGA120404FST KD1425	B344
3656450	CNGA120408FST KD1425	B344
3656452	CNMS120408FST KD1425	B345
3656463	DNGA150404FST KD1425	B347
3656464	DNGA150408FST KD1425	B347
3656466	DNMS150408FST KD1425	B347
3656467	TNMS160404FST KD1425	B348
3656468	TNMS160408FST KD1425	B348
3656470	VNGA160408FST KD1425	B350
3656471	VNMS160404FST KD1425	B350
3656472	VNMS160408FST KD1425	B350
3656474	WNGA080408FST KD1425	B351
3659002	KLSSM22-39-CG	S14, S21, S32, S34, V21, V28, V40, V147
3659963	CDHBS4T002FST KD1400	B344
3659964	CDHBS4T0X0FST KD1400	B344
3659965	CCGW060204FST KD1400	B344
3659966	CCGW09T304FST KD1400	B344
3659967	CCGW09T308FST KD1400	B344
3659968	CPGW060202FST KD1400	B346
3659969	CPGW060204FST KD1400	B346
3659970	CPGW060208FST KD1400	B346
3659971	CPGW09T304FST KD1400	B346
3659972	CPGW09T308FST KD1400	B346
3659975	CPGW060204FWST KD1400	B346
3659976	CPGW09T308FWST KD1400	B346
3659977	CPGW120408FWST KD1400	B346
3659978	DCGW070204FST KD1400	B346
3659979	DCGW11T304FST KD1400	B346
3659980	DPGW070202FST KD1400	B348
3659981	DPGW070204FST KD1400	B348
3659982	DPGW11T304FST KD1400	B348
3659985	TCGW110204FST KD1400	B348
3659986	TCGW16T304FST KD1400	B348
3659987	TPGW110204FST KD1400	B349
3659988	TPGW110208FST KD1400	B349
3659990	TPGW16T308FST KD1400	B349
3659991	VBGW110304FST KD1400	B350
3659992	VBGW160404FST KD1400	B350
3659994	CDHBS4T002FST KD1425	B344
3659996	CCGW060204FST KD1425	B344
3659997	CCGW09T304FST KD1425	B344
3659998	CCGW09T308FST KD1425	B344
3659999	CPGW060202FST KD1425	B346
3660000	CPGW060204FST KD1425	B346
3660001	CPGW060208FST KD1425	B346
3660002	CPGW09T304FST KD1425	B346
3660003	CPGW09T308FST KD1425	B346
3660006	CPGW060204FWST KD1425	B346
3660007	CPGW09T308FWST KD1425	B346
3660008	CPGW120408FWST KD1425	B346
3660009	DCGW070204FST KD1425	B346
3660010	DCGW11T304FST KD1425	B346
3660011	DPGW070202FST KD1425	B348
3660012	DPGW070204FST KD1425	B348
3660013	DPGW11T304FST KD1425	B348
3660015	DPGW11T304FWST KD1425	B348
3660016	TCGW110204FST KD1425	B348
3660018	TPGW110204FST KD1425	B349
3660020	TPGW16T304FST KD1425	B349
3660021	TPGW16T308FST KD1425	B349
3660022	VBGW110304FST KD1425	B350
3660023	VBGW160404FST KD1425	B350
3660154	KSEMP1300HPGM KC7315	H87
3660156	KSEMP2000HPGM KC7315	H87
3660157	KSEMP3400HPGM KC7315	H87
3660312	KSOM32R03A20OF06	S47
3660590	CM214	B168, B370
3660591	CM219	B168, B370
3660592	CM216	B168, B370
3660593	CM217	B168, B370
3667056	SIF70HC12090M	K47
3667057	SIF70HC20100M	K47

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
3667058	SIF80HC12090M	K47
3667059	SIF80HC20100M	K47
3667060	SIF80HC25100M	K47
3667061	SIF100HC12090M	K47
3667062	SIF100HC20100M	K47
3667918	B707A11350FBG KC7315	G115
3668023	SIF100HC25100M	K47
3668057	B291A07200YPL KC7315	G95
3668058	B292A07200YPL KC7315	G95
3668624	RMS05000H7HF K605	K9
3668625	RMS05500H7HF K605	K9
3668626	RMS06000H7HF K605	K9
3668627	RMS06500H7HF K605	K9
3668628	RMS07000H7HF K605	K9
3668629	RMS08000H7HF K605	K9
3668630	RMS09000H7HF K605	K9
3668631	RMS10000H7HF K605	K9
3668632	RMS11000H7HF K605	K9
3668883	RMS12000H7HF K605	K9
3668884	RMS13000H7HF K605	K9
3668885	RMS14000H7HF K605	K9
3668886	RMS05000H7SF K605	K8
3668887	RMS05500H7SF K605	K8
3668888	RMS06000H7SF K605	K8
3668889	RMS06500H7SF K605	K8
3668890	RMS07000H7SF K605	K8
3668891	RMS08000H7SF K605	K8
3668892	RMS09000H7SF K605	K8
3668903	RMS10000H7SF K605	K8
3668904	RMS11000H7SF K605	K8
3668905	RMS12000H7SF K605	K8
3668906	RMS13000H7SF K605	K8
3668907	RMS14000H7SF K605	K8
3668908	RMS05000H7HF KC6305	K9
3668909	RMS05500H7HF KC6305	K9
3668910	RMS06000H7HF KC6305	K9
3668911	RMS06500H7HF KC6305	K9
3668912	RMS07000H7HF KC6305	K9
3668913	RMS08000H7HF KC6305	K9
3668914	RMS09000H7HF KC6305	K9
3668915	RMS10000H7HF KC6305	K9
3668916	RMS11000H7HF KC6305	K9
3668917	RMS12000H7HF KC6305	K9
3668918	RMS13000H7HF KC6305	K9
3668919	RMS14000H7HF KC6305	K9
3668920	RMS05000H7SF KC6305	K8
3668921	RMS05500H7SF KC6305	K8
3668922	RMS06000H7SF KC6305	K8
3668923	RMS06500H7SF KC6305	K8
3668924	RMS07000H7SF KC6305	K8
3668925	RMS08000H7SF KC6305	K8
3668926	RMS09000H7SF KC6305	K8
3668927	RMS10000H7SF KC6305	K8
3668928	RMS11000H7SF KC6305	K8
3668929	RMS12000H7SF KC6305	K8
3668930	RMS13000H7SF KC6305	K8
3668931	RMS14000H7SF KC6305	K8
3669000	DFT05T308D33MD KC7140	H89
3669001	DFT06T308D39MD KC7140	H89
3669002	DFT06T308D44MD KC7140	H89
3669071	NST1	B168, B370
3669072	NST2	B168, B370
3669083	DFT070408D50MD KC7140	H89
3669084	DFT090508D63MD KC7140	H89
3669183	NST3	B168, B370
3669184	NST4	B168, B370
3681262	B976F03900 KC7315	G143
3682450	EDCT10T304PDFRLDJ KC410M	T35, T42
3682451	EDCT10T304PDERLDJ KC422M	T35, T43
3682452	EDCT10T304PDERLD KC520M	T35, T43
3682513	EDCT10T304PDERLD KC522M	T35, T43
3682514	EDCT10T304PDERLD KC725M	T35, T43
3682515	EDCT10T304PDERLD KCPK30	T35, T43
3682520	EDCT10T312PDFRLDJ KC410M	T35, T42
3682653	EDCT10T312PDERLD KC522M	T35, T43
3682655	EDCT10T312PDERLD KC725M	T35, T43
3682777	EDCT10T316PDFRLDJ KC410M	T35, T42
3682778	EDCT10T316PDERLDJ KC422M	T35, T43
3682780	EDCT10T316PDERLD KC522M	T35, T43
3682781	EDCT10T316PDERLD KC725M	T35, T43
3682782	EDCT10T316PDERLD KCPK30	T35, T43
3683704	B707A03700FBG KC7315	G114
3683843	KSEM3975HPGM KC7315	H43
3684779	EDCT10T302PDFRLDJ KC410M	T35, T42
3684824	EDCT10T331PDFRLDJ KC410M	T35, T42
3684828	EDCT10T331PDERLD KC725M	T35
3684829	EDCT10T331PDERLD KCPK30	T35, T43
3690478	KSEMP1400HPGM KC7315	H87
3690479	KSEMP1500HPGM KC7315	H87
3690480	KSEMP1600HPGM KC7315	H87
3690481	KSEMP1700HPGM KC7315	H87
3690482	KSEMP1800HPGM KC7315	H87
3690713	KSEMP1900HPGM KC7315	H87
3690714	KSEMP2100HPGM KC7315	H87
3690715	KSEMP2200HPGM KC7315	H87
3690716	KSEMP2300HPGM KC7315	H87
3690717	KSEMP2400HPGM KC7315	H87
3690718	KSEMP2500HPGM KC7315	H87
3690719	KSEMP2600HPGM KC7315	H87
3690720	KSEMP2700HPGM KC7315	H87
3690721	KSEMP2800HPGM KC7315	H87
3690722	KSEMP2900HPGM KC7315	H87
3690723	KSEMP3000HPGM KC7315	H87
3690724	KSEMP3100HPGM KC7315	H87
3690725	KSEMP3200HPGM KC7315	H87
3690726	KSEMP3300HPGM KC7315	H87
3700622	KDMB06R100A06HN	V114
3727352	ASPM07001802	T57–59
3732218	B707A05200FBG KC7315	G114
3732889	M1HR125E14W125Z2L200C4	T65
3732890	M1HR150E14W125Z3L200C6	T65
3732891	M1HR150E14W125Z3L250C9	T65
3732892	M1HR150E14W125Z3L300C12	T65
3732933	M1HR200E14S075Z3L200C6	T65
3732934	M1HR200E14S075Z3L250C9	T65
3732935	M1HR200E14W150Z3L300C12	T65
3732937	M1HR250E14S100Z3L250C9	T65
3732938	M1HR250E14S100Z4L250C12	T65
3732939	M1HR250E14S100Z3L300C12	T65
3733337	CNGA120412S01020MT KB5630	B290, B310
3733417	DNGA150404S01025MT KB5630	B290, B314
3737769	KSEM2110HPGM KC7315	H42
3738473	A4G0605M06U04GMN KCP25	C96
3738488	DV40BSIF80061M	K45
3738490	DV50BSIF70060M	K45
3738491	DV50BSIF100060M	K45
3738492	BT40BSIF80063M	K44
3738503	BT50BSIF70063M	K45
3738504	BT50BSIF100068M	K45
3738505	CV40BSIF80248	K44
3738506	CV50BSIF70236	K44
3738507	CV50BSIF100236	K44
3738508	HSK63ASIF70066M	K46
3738510	HSK80ASIF70066M	K46
3738511	HSK100ASIF70050M	K46
3738512	HSK100ASIF100070M	K46
3739296	B292A15600YPL KC7315	G96
3742210	KSEMP3300FDS32A1M	H80, H91, H98
3742211	KSEMP5000FDS50A1M	H81, H92, H98
3742212	KSEMP7000FDS63A1M	H81, H92, H99
3742293	WD32FDS32321M	H103
3742294	WD50FDS50503M	H103
3742296	WD50FDS63779M	H103
3742932	M1H32J2R50B32S90ED14C4	T57
3743033	M1H40J3R50B32S90ED14C6	T57
3743034	M1H40J3R65B32S90ED14C9	T57
3743035	M1H40J3R80B32S90ED14C12	T57
3743036	M1H50T3R50A22S90ED14C6	T58
3743037	M1H50T3R65A22S90ED14C9	T58
3743038	M1H50J3R80B40S90ED14C12	T57
3743039	M1H63T3R50A27S90ED14C6	T58
3743040	M1H63T3R65A27S90ED14C9	T58
3743041	M1H63T4R65A27S90ED14C12	T58
3743042	M1H63T3R75A27S90ED14C12	T58
3744538	12A01R020A16ED10	T31
3744539	16A02R025A16ED10	T31
3744540	20A02R028A20ED10	T31
3744541	20A03R028A20ED10	T31
3744542	25A03R032A25ED10	T31
3744613	25A04R032A25ED10	T31
3744614	32A04R040A32ED10	T31
3744615	32A05R040A32ED10	T31
3744616	16A02R025A16ED10-170	T32
3744617	16A02R025A16ED10R31-170	T32
3744618	18A02R028A16ED10-170	T32
3744619	20A02R032A20ED10-170	T32
3744620	20A02R032A20ED10R31-170	T32
3744621	20A03R032A20ED10-170	T32
3744622	20A03R032A20ED10R31-170	T32
3744623	22A03R032A20ED10-170	T32
3744624	25A03R040A25ED10-200	T32
3744625	25A03R040A25ED10R31-200	T32
3744626	25A04R040A25ED10-200	T32
3744627	25A04R040A25ED10R31-200	T32
3744628	28A04R040A25ED10-200	T32
3744629	32A04R048A32ED10-200	T32
3744630	32A04R048A32ED10R31-200	T32
3744631	32A05R048A32ED10-200	T32
3744632	32A05R048A32ED10R31-200	T32
3744633	16A02R025B16ED10	T30
3744634	20A02R028B20ED10	T30
3744635	20A03R028B20ED10	T30
3744636	25A03R032B25ED10	T30
3744637	25A04R032B25ED10	T30
3744638	32A04R040B32ED10	T30
3744639	32A05R040B32ED10	T30
3744865	CCMT060204MP KCM15	B177
3744872	DCMT11T308MP KCM15	B208
3744873	SCMT09T304MP KCM15	B231
3744874	SCMT09T308MP KCM15	B231
3744878	SPMT09T308MP KCM15	B239
3744880	TCMT16T308MP KCM15	B245
3744884	CCMT060204MP KCP25	B177
3744886	CCMT09T304MP KCP25	B177
3744887	CCMT09T308MP KCP25	B177
3744888	CCMT09T312MP KCP25	B177
3744890	CCMT120408MP KCP25	B177
3744891	CCMT120412MP KCP25	B177
3744893	CPMT09T308MP KCP25	B190
3744895	DCMT11T304MP KCP25	B208
3744896	DCMT11T312MP KCP25	B208
3744897	DPMT11T308MP KCP25	B216
3744898	SCMT09T304MP KCP25	B231
3744900	SCMT120412MP KCP25	B231
3744903	SPMT120408MP KCP25	B239
3744904	TCMT110208MP KCP25	B245
3744906	TCMT16T304MP KCP25	B245
3744907	TCMT16T312MP KCP25	B245
3744908	TPMT110208MP KCP25	B255
3744909	TPMT16T308MP KCP25	B255
3744910	TPMT16T312MP KCP25	B255
3744911	VBMT160404MP KCP25	B265
3744912	VBMT160408MP KCP25	B265
3744917	CCMT060204MP KCM25	B177
3744918	CCMT09T304MP KCM25	B177
3744919	CCMT09T308MP KCM25	B177
3744920	CCMT09T312MP KCM25	B177
3744923	CCMT120412MP KCM25	B177
3744924	CPMT09T308MP KCM25	B190
3744925	DCMT11T308MP KCM25	B208
3744926	SCMT09T304MP KCM25	B231
3744927	SCMT09T308MP KCM25	B231
3744928	SCMT120404MP KCM25	B231
3744929	SCMT120408MP KCM25	B231
3744930	SCMT120412MP KCM25	B231
3744931	TCMT16T304MP KCM25	B245
3744932	TCMT16T308MP KCM25	B245
3744935	VBMT160404MP KCM25	B265
3744936	VBMT160408MP KCM25	B265
3744940	CCMT060204MP KCP10	B177
3744941	CCMT09T304MP KCP10	B177
3744942	CCMT09T308MP KCP10	B177
3744943	CCMT120408MP KCP10	B177
3744945	CPMT09T308MP KCP10	B190
3744946	DCMT11T304MP KCP10	B208
3744947	DCMT11T308MP KCP10	B208
3744949	SCMT09T308MP KCP10	B231
3744950	SCMT120408MP KCP10	B231
3744951	TCMT16T308MP KCP10	B245
3744955	CCMT09T308MP KCK20	B177
3744956	CCMT120408MP KCK20	B177
3744957	CCMT120412MP KCK20	B177
3744958	CPMT09T308MP KCK20	B190
3744962	SCMT09T304MP KCK20	B231
3744965	SPMT09T308MP KCK20	B239
3744974	VBMT160408MP KCK20	B265
3744975	CCMT060204MP KCU10	B177
3744976	CCMT09T304MP KCU10	B177
3744977	CCMT09T308MP KCU10	B177
3744978	CCMT120408MP KCU10	B177
3744979	CPMT060208MP KCU10	B190
3744980	CPMT09T308MP KCU10	B190
3744981	DCMT11T304MP KCU10	B208
3744982	DCMT11T312MP KCU10	B208
3744983	DPMT11T308MP KCU10	B216
3744984	SCMT09T304MP KCU10	B231
3744985	SCMT120404MP KCU10	B231
3744986	SCMT120408MP KCU10	B231
3744987	SPMT09T308MP KCU10	B239
3744988	SPMT120408MP KCU10	B239
3744989	TCMT110208MP KCU10	B245
3744990	TCMT16T304MP KCU10	B245
3745674	40A04RS90ED10D	T33
3745675	40A06RS90ED10D	T33
3745676	50A05RS90ED10D	T33
3745677	50A08RS90ED10D	T33
3745678	63A06RS90ED10D	T33
3745679	63A09RS90ED10D	T33
3745680	80A08RS90ED10D	T33
3745681	80A10RS90ED10D	T33
3745682	100B08RS90ED10D	T33
3745703	100B12RS90ED10D	T33
3745708	16A02R025M08ED10	T29
3745709	20A02R028M10ED10	T29
3745710	20A03R028M10ED10	T29
3745711	25A03R032M12ED10	T29
3745712	25A04R032M12ED10	T29
3745723	32A04R040M16ED10	T29
3745724	32A05R040M16ED10	T29
3745725	40A06R040M16ED10	T29
3745726	42A06R040M16ED10	T29
3746074	DNMG110404MN KCP05	B78
3746075	DNMG110408MN KCP05	B78
3746077	DNMG150412MN KCP05	B78
3746083	VNMG160408MN KCP05	B145
3746085	CNMG120412MW KCP05	B52
3746086	DNMG150608MW KCP05	B80
3746087	TNMG160408MW KCP05	B127
3746089	WNMG080408MW KCP05	B158
3746090	DNMG150408MW KCP05	B80
3746091	DNMG150412MW KCP05	B80
3746092	DNMG150612MW KCP05	B80
3746114	CNMG120412RP KCP05	B53
3746116	DNMG150608RP KCP05	B81
3746118	SNMG120408RP KCP05	B101
3746119	SNMG120412RP KCP05	B101
3746120	TNMG160408RP KCP05	B128
3746121	TNMG160412RP KCP05	B128
3746122	WNMG080408RP KCP05	B159
3746123	WNMG080412RP KCP05	B159
3746125	CCMT060204UF KCP05	B178
3746126	CCMT09T302UF KCP05	B178
3746132	DCMT11T302UF KCP05	B208
3746133	DCMT11T304UF KCP05	B208
3746134	DCMT11T308UF KCP05	B208
3746135	SCMT09T308UF KCP05	B231
3746137	TPMT110202UF KCP05	B256
3746138	TPMT110204UF KCP05	B256

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
3747113	EDPT10T310PDERHD KC522M	T36, T43
3747114	EDPT10T310PDERHD KC725M	T36, T43
3747115	EDPT10T310PDERHD KCK15	T36, T43
3747116	EDPT10T310PDERHD KCPK30	T36, T43
3747140	CNGA120404S01025MT KB5630	B290, B310
3747141	CNGA120408S01025MT KB5630	B290, B310
3747142	CNGA120412S01025MT KB5630	B290, B310
3747223	CNGA120404S01025FWMT KB5630	B289, B310
3747224	CNGA120408S01025FWMT KB5630	B289, B310
3747225	DNGA150408S01025MT KB5630	B290, B314
3747226	VNGA160404S01025MT KB5630	B292, B323
3747227	VNGA160408S01025MT KB5630	B292, B323
3747228	RNGN090300S02015C KB5630	B317
3747231	CCGW060202S01015C KB5630	B290, B308
3747232	CCGW060204S01015C KB5630	B290, B308
3747233	CCGW09T304S01015MT KB5630	B291, B308
3747234	CCGW09T308S01015MT KB5630	B291, B308
3747237	CPGW09T304S01015MT KB5630	B311
3747238	CPGW09T308S01015MT KB5630	B311
3747239	DCGW070202S01015C KB5630	B291, B312
3747240	DCGW070204S01015C KB5630	B291, B312
3747241	DCGW11T304S01015MT KB5630	B291, B312
3747242	DCGW11T308S01015MT KB5630	B291, B312
3747244	TPGW110208S01015C KB5630	B291, B321
3747245	VBGW160404S01015MT KB5630	B292, B322
3747246	VBGW160408S01015MT KB5630	B292, B322
3747373	MS1235	T58, T109
3747374	MS1233	T58
3747375	MS1198	S110, T58
3748345	CNMG120408CT KCP05	B48
3748348	DNMG110408CT KCP05	B76
3748363	DNMG150612CT KCP05	B76
3748366	CNMG120404FF KCP05	B48
3748367	CNMG120408FF KCP05	B48
3748368	DNMG110408FF KCP05	B76
3748374	TNMG160408FF KCP05	B124
3748375	VNMG160404FF KCP05	B145
3748376	VNMG160408FF KCP05	B145
3748377	CNMG120404FW KCP05	B49
3748378	CNMG120408FW KCP05	B49
3748379	CNMG120412FW KCP05	B49
3748381	DNMG110408FW KCP05	B78
3748383	DNMG150408FW KCP05	B78
3748384	DNMG150604FW KCP05	B78
3748385	DNMG150608FW KCP05	B78
3748386	SNMG120408FW KCP05	B98
3748388	TNMG160404FW KCP05	B125
3748389	TNMG160408FW KCP05	B125
3748390	TNMG160412FW KCP05	B125
3748391	VNMG060404FW KCP05	B156
3748392	WNMG060408FW KCP05	B156
3748394	WNMG080404FW KCP05	B156
3748395	WNMG080408FW KCP05	B156
3748396	WNMG080412FW KCP05	B156
3748397	CCMT060208LF KCP05	B177
3748401	CPMT09T304LF KCP05	B190
3748422	VBMT110304LF KCP05	B265
3748423	VBMT110308LF KCP05	B265
3748425	VBMT160408LF KCP05	B265
3749127	HNGJ0905ANSNHD KC520M	S19, S23
3749128	HNGJ090543ANSNHD KC520M	S19, S23
3749198	CNMG120412MW KCP10	B52
3749200	DNMG150608MW KCP10	B80
3749253	SNMG120412MW KCP10	B100
3749254	TNMG160408MW KCP10	B127
3749255	TNMG160412MW KCP10	B127
3749256	WNMG060408MW KCP10	B158
3749258	WNMG080408MW KCP10	B158
3749259	CNMG120404RP KCP10	B53
3749260	CNMG120412RP KCP10	B53
3749261	CNMG120416RP KCP10	B53
3749262	CNMG160608RP KCP10	B53
3749263	CNMG160612RP KCP10	B53
3749264	CNMG160616RP KCP10	B53
3749266	CNMG190616RP KCP10	B53
3749267	DNMG110408RP KCP10	B81
3749269	DNMG150408RP KCP10	B81
3749271	DNMG150608RP KCP10	B81
3749272	DNMG150612RP KCP10	B81
3749273	DNMG150616RP KCP10	B81
3749274	RCMT1204M0RP KCP10	B226
3749277	SNMG120408RP KCP10	B101
3749278	SNMG120412RP KCP10	B101
3749279	SNMG120416RP KCP10	B101
3749282	SNMG190612RP KCP10	B101
3749283	SNMG190616RP KCP10	B101
3749284	TNMG160408RP KCP10	B128
3749285	TNMG160412RP KCP10	B128
3749286	TNMG160416RP KCP10	B128
3749288	TNMG220412RP KCP10	B128
3749289	TNMG220416RP KCP10	B128
3749290	TNMG270612RP KCP10	B128
3749291	VNMG160408RP KCP10	B147
3749292	VNMG160412RP KCP10	B147
3749293	WNMG060408RP KCP10	B159
3749294	WNMG060412RP KCP10	B159
3749295	WNMG080408RP KCP10	B159
3749296	WNMG080412RP KCP10	B159
3749297	WNMG080416RP KCP10	B159
3749298	CCMT060204UF KCP10	B178
3749299	CCMT09T302UF KCP10	B178
3749300	CCMT09T304UF KCP10	B178
3749307	DCMT11T308UF KCP10	B208
3749309	DPMT11T304UF KCP10	B216
3749310	DPMT11T308UF KCP10	B216
3749311	SCMT09T308UF KCP10	B231
3749318	TPMT16T308UF KCP10	B256
3749336	CNMG120416CT KCP10	B48
3749337	DNMG110408CT KCP10	B76
3749338	DNMG150404CT KCP10	B76
3749339	DNMG150408CT KCP10	B76
3749341	DNMG150604CT KCP10	B76
3749342	DNMG150608CT KCP10	B76
3749344	DNMG150612CT KCP10	B76
3749347	CNMG120404FF KCP10	B48
3749348	CNMG120408FF KCP10	B48
3749349	DNMG110408FF KCP10	B76
3749350	DNMG150404FF KCP10	B76
3749352	DNMG150608FF KCP10	B76
3749353	SNMG090308FF KCP10	B97
3749355	TNMG160404FF KCP10	B124
3749357	VNMG160404FF KCP10	B145
3749358	VNMG160408FF KCP10	B145
3749359	CNMG120404FW KCP10	B49
3749360	CNMG120408FW KCP10	B49
3749361	CNMG120412FW KCP10	B49
3749362	DNMG110404FW KCP10	B78
3749363	DNMG110408FW KCP10	B78
3749364	DNMG150404FW KCP10	B78
3749367	DNMG150608FW KCP10	B78
3749368	SNMG120408FW KCP10	B98
3749369	SNMG120412FW KCP10	B98
3749370	TNMG160404FW KCP10	B125
3749374	WNMG060408FW KCP10	B156
3749375	WNMG060412FW KCP10	B156
3749376	WNMG080404FW KCP10	B156
3749377	WNMG080408FW KCP10	B156
3749378	WNMG080412FW KCP10	B156
3749379	CCMT060208LF KCP10	B177
3749380	CCMT120408LF KCP10	B177
3749381	CPMT060204LF KCP10	B190
3749382	CPMT060208LF KCP10	B190
3749383	CPMT09T304LF KCP10	B190
3749384	CPMT09T308LF KCP10	B190
3749386	DCMT070204LF KCP10	B207
3749387	DCMT11T308LF KCP10	B207
3749388	DCMT11T312LF KCP10	B207
3749389	DCMT150404LF KCP10	B207
3749390	DCMT150408LF KCP10	B207
3749391	DPMT070204LF KCP10	B215
3749392	DPMT11T304LF KCP10	B215
3749393	DPMT11T308LF KCP10	B215
3749394	SCMT09T304LF KCP10	B230
3749395	SCMT09T308LF KCP10	B230
3749396	SCMT120404LF KCP10	B230
3749399	SPMT09T304LF KCP10	B238
3749401	TCMT110204LF KCP10	B244
3749402	TCMT110208LF KCP10	B244
3749403	TCMT16T304LF KCP10	B244
3749404	TCMT16T308LF KCP10	B244
3749408	TPMT110204LF KCP10	B255
3749410	TPMT16T304LF KCP10	B255
3749412	VBMT110304LF KCP10	B265
3749413	VBMT110308LF KCP10	B265
3749414	VBMT160404LF KCP10	B265
3749415	VBMT160408LF KCP10	B265
3749416	WPMT040204LF KCP10	B272
3749422	CCMT060204MF KCP10	B177
3749444	CCMT09T312MF KCP10	B177
3749447	CPMT09T308MF KCP10	B190
3749449	DCMT11T304MF KCP10	B208
3749450	DCMT11T308MF KCP10	B208
3749451	DCMT11T312MF KCP10	B208
3749453	SCMT09T308MF KCP10	B231
3749454	SCMT120408MF KCP10	B231
3749455	SCMT120412MF KCP10	B231
3749456	SPMT09T308MF KCP10	B239
3749459	TCMT16T308MF KCP10	B245
3749460	TCMT16T312MF KCP10	B245
3749462	TPMT16T308MF KCP10	B255
3749463	CNMG090304MN KCP10	B50
3749464	CNMG090308MN KCP10	B50
3749465	CNMG120404MN KCP10	B50
3749466	CNMG120416MN KCP10	B50
3749467	CNMG160608MN KCP10	B50
3749468	CNMG160612MN KCP10	B50
3749469	CNMG160616MN KCP10	B50
3749470	CNMG190608MN KCP10	B50
3749471	CNMG190612MN KCP10	B50
3749474	DNMG110408MN KCP10	B78
3749475	DNMG110412MN KCP10	B78
3749476	DNMG150404MN KCP10	B78
3749479	DNMG150604MN KCP10	B78
3749480	DNMG150612MN KCP10	B78
3749481	DNMG150616MN KCP10	B78
3749483	SNMG090308MN KCP10	B98
3749484	SNMG090312MN KCP10	B98
3749486	SNMG120408MN KCP10	B98
3749487	SNMG120412MN KCP10	B98
3749490	SNMG190612MN KCP10	B98
3749491	TNMG160404MN KCP10	B125
3749493	TNMG220404MN KCP10	B125
3749494	TNMG220408MN KCP10	B125
3749496	VNMG160404MN KCP10	B145
3749497	VNMG160408MN KCP10	B145
3749498	VNMG160412MN KCP10	B145
3749499	WNMG060404MN KCP10	B157
3749500	WNMG060408MN KCP10	B157
3749501	WNMG060412MN KCP10	B157
3749502	WNMG080412MN KCP10	B157
3749503	CNMP120408K KCP10	B57
3749507	TNMP160408K KCP10	B130
3749508	VNMP160408K KCP10	B148
3749959	KSHR63A05RS45HN09	S21
3749960	KSHR80A05RS45HN09	S21
3749961	KSHR100B06RS45HN09	S21
3749962	KSHR125B08RS45HN09	S21
3750013	KSHR160C10RS45HN09	S21
3750568	B292A09600YPL KC7315	G95
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3751568	CPMT09T308FW KCP25	B189
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3751570	DCMT11T308FW KCP25	B207
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3751583	DCMT11T312LF KCP25	B207
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3751587	DPMT11T304LF KCP25	B215
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3751591	SCMT120404LF KCP25	B230
3751592	SCMT120408LF KCP25	B230
3751594	SPMT09T304LF KCP25	B238
3751595	SPMT09T308LF KCP25	B238
3751596	TCMT110204LF KCP25	B244

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
3751597	TCMT110208LF KCP25	B244
3751598	TCMT16T304LF KCP25	B244
3751599	TCMT16T308LF KCP25	B244
3751600	TCMT16T312LF KCP25	B244
3751601	TCMT220408LF KCP25	B244
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3751603	TPMT110204LF KCP25	B255
3751604	TPMT110208LF KCP25	B255
3751605	TPMT16T304LF KCP25	B255
3751606	TPMT16T308LF KCP25	B255
3751607	VBMT110304LF KCP25	B265
3751608	VBMT110308LF KCP25	B265
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3751610	VBMT160408LF KCP25	B265
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3751616	CCMT120404MW KCP25	B178
3751617	CCMT120408MW KCP25	B178
3751618	CNMG120412MW KCP25	B52
3751620	CPMT09T308MW KCP25	B191
3751622	DCMT11T308MW KCP25	B208
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3751635	DNMG150608MW KCP25	B80
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3751639	TNMG160408MW KCP25	B127
3751640	TNMG160412MW KCP25	B127
3751641	WNMG060408MW KCP25	B158
3751643	WNMG080408MW KCP25	B158
3751644	CNMG120404RP KCP25	B53
3751645	CNMG120412RP KCP25	B53
3751646	CNMG120416RP KCP25	B53
3751647	CNMG160608RP KCP25	B53
3751648	CNMG160612RP KCP25	B53
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3751650	CNMG190612RP KCP25	B53
3751652	CNMM250924RP KCP25	B56
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3751656	DNMG150412RP KCP25	B81
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3751659	DNMG150616RP KCP25	B81
3751661	RCGT1204M0RP KCP25	B223
3751673	RCMT1204M0RP KCP25	B226
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3751692	TNMG270612RP KCP25	B128
3751694	TNMG330924RP KCP25	B128
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3751703	CCMT09T304UF KCP25	B178
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3751710	DCMT11T308UF KCP25	B208
3751711	DPMT070204UF KCP25	B216
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3751714	TCMT16T308UF KCP25	B245
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3751716	CNMM120412RM KCP25	B55
3751718	CNMM160612RM KCP25	B55
3751719	CNMM160616RM KCP25	B55
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3752014	SCMT120408LF KCK15	B230
3752015	SPMT09T308LF KCK15	B238
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3752017	TCMT110208LF KCK15	B244
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3752019	TCMT16T308LF KCK15	B244
3752020	TCMT16T312LF KCK15	B244
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3752025	TPMT16T308LF KCK15	B255
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3752027	VBMT160408LF KCK15	B265
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3752029	CCMT09T304MF KCK15	B177
3752030	CCMT09T312MF KCK15	B177
3752031	CCMT120412MF KCK15	B177
3752032	CPMT060208MF KCK15	B190
3752033	CPMT09T308MF KCK15	B190
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3752036	DCMT11T308MF KCK15	B208
3752037	DCMT11T312MF KCK15	B208
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3752049	TPMT16T312MF KCK15	B255
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3752059	RCMT1606M0RP KCK15	B226
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3752067	VNMG160408RP KCK15	B147
3752068	VNMG160412RP KCK15	B147
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3752070	WNMG080412RP KCK15	B159
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3752074	CPMT060204LF KCK05	B190
3752075	CPMT060208LF KCK05	B190
3752076	CPMT09T304LF KCK05	B190
3752077	CPMT09T308LF KCK05	B190
3752079	DCMT11T308LF KCK05	B207
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3752084	DPMT11T304LF KCK05	B215
3752086	SCMT09T304LF KCK05	B230
3752087	SCMT09T308LF KCK05	B230
3752089	SCMT120408LF KCK05	B230
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3752094	TCMT110208LF KCK05	B244
3752095	TCMT16T304LF KCK05	B244
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3752102	TPMT16T304LF KCK05	B255
3752103	TPMT16T308LF KCK05	B255
3752106	VBMT110304LF KCK05	B265
3752107	VBMT110308LF KCK05	B265
3752109	VBMT160408LF KCK05	B265
3752110	VBMT160412LF KCK05	B265
3752113	WPMT06T308LF KCK05	B272
3752114	CNMG120412RP KCK05	B53
3752115	CNMG160612RP KCK05	B53
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3752119	DNMG150612RP KCK05	B81
3752121	SNMG120412RP KCK05	B101
3752122	TNMG160408RP KCK05	B128
3752124	WNMG080408RP KCK05	B159
3752125	WNMG080412RP KCK05	B159
3752127	CNMA120404 KCK15	B47
3752128	CNMA120408 KCK15	B47
3752129	CNMA120412 KCK15	B47
3752130	CNMA120416 KCK15	B47
3752131	CNMA160608 KCK15	B47
3752132	CNMA160612 KCK15	B47
3752143	CNMA160616 KCK15	B47
3752144	CNMA190612 KCK15	B47
3752145	DNMA150408 KCK15	B75
3752146	DNMA150412 KCK15	B75
3752147	DNMA150608 KCK15	B75
3752152	SNMA120412 KCK15	B96
3752157	TNMA160408 KCK15	B123
3752158	TNMA160412 KCK15	B123
3752159	TNMA160416 KCK15	B123
3752163	TNMA270616 KCK15	B123
3752164	VNMA160408 KCK15	B144
3752165	WNMA060408 KCK15	B155
3752167	WNMA080408 KCK15	B155
3752168	WNMA080412 KCK15	B155
3752170	CCMT060204LF KCK15	B177
3752171	CCMT09T304LF KCK15	B177
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3752178	CNMG120408UN KCK15	B54
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3752181	CNMG160608UN KCK15	B54
3752182	CNMG160612UN KCK15	B54
3752183	CNMG160616UN KCK15	B54
3752184	CNMG190608UN KCK15	B54
3752185	CNMG190612UN KCK15	B54
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3752214	WNMG080408UN KCK15	B160
3752215	WNMG080412UN KCK15	B160
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3753206	WNMG060404FF KCP10	B155
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3753209	CNMG090304FN KCP10	B49
3753210	CNMG090308FN KCP10	B49
3753211	CNMG120404FN KCP10	B49
3753212	CNMG120408FN KCP10	B49

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
3753214	CNMG120416FN KCP10	B49
3753215	DNMG110404FN KCP10	B77
3753216	DNMG110408FN KCP10	B77
3753218	DNMG150404FN KCP10	B77
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3753308	RNMG120400RN KCP10	B94
3753311	RNMG250900RN KCP10	B94
3753312	SNMG090412RN KCP10	B101
3753313	SNMG120408RN KCP10	B101
3753314	WNMG080412MW KCP10	B158
3753315	SNMG120412RN KCP10	B101
3753319	CNMM190624RH KCP10	B55
3753321	SNMG150608RN KCP10	B101
3753322	SNMM190616RH KCP10	B102
3753323	SNMM190624RH KCP10	B102
3753325	CNMM120408RM KCP10	B55
3753326	CNMM120412RM KCP10	B55
3753328	CNMM160612RM KCP10	B55
3753329	CNMM160616RM KCP10	B55
3753331	CNMM160624RM KCP10	B55
3753332	CNMM190612RM KCP10	B55
3753333	CNMM190616RM KCP10	B55
3753334	SNMG190616RN KCP10	B101
3753335	DNMM150608RM KCP10	B82
3753336	DNMM150612RM KCP10	B82
3753337	TNMG160408RN KCP10	B127
3753339	SNMM150612RM KCP10	B103
3753341	SNMM150616RM KCP10	B103
3753342	SNMM190612RM KCP10	B103
3753343	SNMM190616RM KCP10	B103
3753347	TNMG220412RN KCP10	B127
3753348	CNMG120408RN KCP10	B53
3753349	CNMG120416RN KCP10	B53
3753351	CNMG120408RP KCP10	B53
3753352	CNMM120408RP KCP10	B56
3753354	TNMG270608RN KCP10	B127
3753356	CNMM160612RP KCP10	B56
3753357	TNMG270612RN KCP10	B127
3753358	CNMM160616RP KCP10	B56
3753360	CNMM190616RP KCP10	B56
3753361	TNMG270616RN KCP10	B127
3753364	DNMM150608RP KCP10	B83
3753367	VNMG160408RN KCP10	B147
3753368	SNMM150616RP KCP10	B103
3753371	VNMG160412RN KCP10	B147
3753372	TNMM220408RP KCP10	B130
3753374	VNMG220408RN KCP10	B147
3753375	TNMM220416RP KCP10	B130
3753376	VNMG220412RN KCP10	B147
3753379	WNMG080408RN KCP10	B159
3753380	WNMG080412RN KCP10	B159
3753381	WNMG080416RN KCP10	B159
3753386	EDPT10T308PDSRGD KC520M	T36, T44
3753387	EDPT10T312PDSRGD KC520M	T36, T44
3753389	CCMT060204MF KCP25	B177
3753390	CCMT09T304MF KCP25	B177
3753391	CCMT09T312MF KCP25	B177
3753413	CCMT120412MF KCP25	B177
3753415	CPMT09T308MF KCP25	B190
3753416	CPMT09T312MF KCP25	B190
3753417	EDCT10T308PDERLD KC510M	T35, T43
3753418	DCMT11T304MF KCP25	B208
3753419	DCMT11T308MF KCP25	B208
3753421	DPMT11T308MF KCP25	B215
3753422	SCMT09T308MF KCP25	B231
3753423	SCMT120408MF KCP25	B231
3753424	SCMT120412MF KCP25	B231
3753425	SPMT09T308MF KCP25	B239
3753426	SPMT120408MF KCP25	B239
3753427	TCMT110208MF KCP25	B245
3753428	TCMT16T308MF KCP25	B245
3753430	TPMT110208MF KCP25	B255
3753431	TPMT16T308MF KCP25	B255
3753432	TPMT16T312MF KCP25	B255
3753434	CNMG090308MN KCP25	B50
3753435	CNMG090312MN KCP25	B50
3753436	CNMG120404MN KCP25	B50
3753437	CNMG120416MN KCP25	B50
3753438	CNMG160608MN KCP25	B50
3753439	CNMG160612MN KCP25	B50
3753440	CNMG160616MN KCP25	B50
3753441	CNMG190608MN KCP25	B50
3753442	CNMG190612MN KCP25	B50
3753443	CNMG190616MN KCP25	B50
3753444	DNMG110404MN KCP25	B78
3753445	DNMG110408MN KCP25	B78
3753446	DNMG110412MN KCP25	B78
3753447	DNMG150404MN KCP25	B78
3753448	DNMG150412MN KCP25	B78
3753450	DNMG150604MN KCP25	B78
3753451	DNMG150612MN KCP25	B78
3753453	SNMG090308MN KCP25	B98
3753454	SNMG090312MN KCP25	B98
3753456	SNMG120408MN KCP25	B98
3753457	SNMG120412MN KCP25	B98
3753458	SNMG120416MN KCP25	B98
3753459	SNMG150612MN KCP25	B98
3753462	SNMG190616MN KCP25	B98
3753463	TNMG160404MN KCP25	B125
3753464	TNMG160412MN KCP25	B125
3753465	TNMG220404MN KCP25	B125
3753466	TNMG220408MN KCP25	B125
3753467	TNMG220412MN KCP25	B125
3753469	VNMG160404MN KCP25	B145
3753470	VNMG160408MN KCP25	B145
3753471	VNMG160412MN KCP25	B145
3753472	WNMG060404MN KCP25	B157
3753473	WNMG060408MN KCP25	B157
3753474	WNMG060412MN KCP25	B157
3753475	WNMG080412MN KCP25	B157
3753476	WNMG080416MN KCP25	B157
3753477	CNMP120404K KCP25	B57
3753478	CNMP120408K KCP25	B57
3753481	DNMP150404K KCP25	B83
3753482	DNMP150408K KCP25	B83
3753483	DNMP150412K KCP25	B83
3753484	SNMP120408K KCP25	B104
3753487	TNMP160408K KCP25	B130
3753489	TNMP220408K KCP25	B130
3753491	VNMP160404K KCP25	B148
3753494	VNMP160408K KCP25	B148
3753502	SNMG250924RM KCP25	B100
3753504	CNMG120412RN KCP25	B53
3753505	CNMG160608RN KCP25	B53
3753506	CNMG160612RN KCP25	B53
3753507	CNMG160616RN KCP25	B53
3753508	CNMG190608RN KCP25	B53
3753509	CNMG190612RN KCP25	B53
3753510	CNMG190616RN KCP25	B53
3753511	CNMG190624RN KCP25	B53
3753512	DNMG150408RN KCP25	B81
3753513	DNMG150412RN KCP25	B81
3753514	DNMG150416RN KCP25	B81
3753515	DNMG150608RN KCP25	B81
3753516	DNMG150612RN KCP25	B81
3753517	DNMG150616RN KCP25	B81
3753518	DNMG190608RN KCP25	B81
3753519	DNMG190612RN KCP25	B81
3753520	RNMG090300RN KCP25	B94
3753523	RNMG190600RN KCP25	B94
3753525	RNMG250900RN KCP25	B94
3753526	SNMG120408RN KCP25	B101
3753527	SNMG120412RN KCP25	B101
3753528	SNMG120416RN KCP25	B101
3753529	SNMG150608RN KCP25	B101
3753530	SNMG150612RN KCP25	B101
3753531	SNMG150616RN KCP25	B101
3753543	SNMG190612RN KCP25	B101
3753544	SNMG190616RN KCP25	B101
3753545	SNMG190624RN KCP25	B101
3753546	TNMG160408RN KCP25	B127
3753547	TNMG160412RN KCP25	B127
3753548	TNMG220408RN KCP25	B127
3753549	TNMG220412RN KCP25	B127
3753550	TNMG220416RN KCP25	B127
3753551	TNMG270608RN KCP25	B127
3753552	TNMG270612RN KCP25	B127
3753553	TNMG270616RN KCP25	B127
3753554	TNMG330924RN KCP25	B127
3753555	VNMG160408RN KCP25	B147
3753556	VNMG160412RN KCP25	B147
3753557	VNMG220408RN KCP25	B147
3753558	VNMG220412RN KCP25	B147
3753559	WNMG060408RN KCP25	B159
3753560	WNMG060412RN KCP25	B159
3753561	WNMG080408RN KCP25	B159
3753562	WNMG080412RN KCP25	B159
3753563	WNMG080416RN KCP25	B159
3753592	EDPT10T304PDERHD KC520M	T36, T43
3753593	EDPT10T308PDERHD KC520M	T36, T43
3753594	EDPT10T312PDERHD KC520M	T36, T43
3753608	CNMG120412RN KCP30	B53
3753609	CNMG160608RN KCP30	B53
3753610	CNMG160612RN KCP30	B53
3753611	CNMG190612RN KCP30	B53
3753612	CNMG190616RN KCP30	B53
3753633	CNMG190624RN KCP30	B53
3753636	DNMG150608RN KCP30	B81
3753637	DNMG150612RN KCP30	B81
3753639	DNMG190608RN KCP30	B81
3753640	DNMG190612RN KCP30	B81
3753641	RNMG120400RN KCP30	B94
3753642	RNMG150600RN KCP30	B94
3753650	SNMG190608RN KCP30	B101
3753653	SNMG190624RN KCP30	B101
3753654	TNMG160408RN KCP30	B127
3753655	TNMG160412RN KCP30	B127
3753656	TNMG220408RN KCP30	B127
3753658	TNMG270608RN KCP30	B127
3753662	VNMG220408RN KCP30	B147
3753663	VNMG220412RN KCP30	B147
3753664	WNMG080408RN KCP30	B159
3753665	WNMG080412RN KCP30	B159
3753699	CNMG120404FN KCP25	B49
3753700	CNMG120408FN KCP25	B49
3753701	CNMG120412FN KCP25	B49
3753702	CNMG120416FN KCP25	B49
3753705	DNMG150404FN KCP25	B77
3753706	DNMG150408FN KCP25	B77
3753707	DNMG150604FN KCP25	B77
3753708	DNMG150608FN KCP25	B77
3753709	DNMG150612FN KCP25	B77
3753713	SNMG120412FN KCP25	B97
3753714	TNMG110304FN KCP25	B124
3753715	TNMG110308FN KCP25	B124
3753716	TNMG160404FN KCP25	B124
3753717	TNMG160408FN KCP25	B124
3753718	TNMG160412FN KCP25	B124
3753719	TNMG220404FN KCP25	B124
3753720	TNMG220408FN KCP25	B124
3753721	TNMG220412FN KCP25	B124
3753722	VNMG160404FN KCP25	B145
3753723	VNMG160408FN KCP25	B145
3753724	WNMG060408FN KCP25	B155
3753726	WNMG080408FN KCP25	B155
3753727	CCMT060204LF KCP25	B177
3753728	CCMT09T304LF KCP25	B177
3753729	CCMT09T308LF KCP25	B177
3753730	CCMT120404LF KCP25	B177
3753732	DCMT11T304LF KCP25	B207
3753733	CCMT09T308MF KCP25	B177
3753734	CCMT120408MF KCP25	B177
3753735	RCMT0602M0 KCP30	B224
3753737	RCMT10T3M0 KCP30	B224
3753739	CCMT060208LF KCP30	B177
3753742	CPMT060208LF KCP30	B190
3753743	CPMT09T304LF KCP30	B190
3753744	CPMT09T308LF KCP30	B190
3753745	DCMT070204LF KCP30	B207
3753750	SCMT09T304LF KCP30	B230
3753751	SCMT09T308LF KCP30	B230
3753752	SCMT120404LF KCP30	B230
3753753	SCMT120408LF KCP30	B230
3753754	TCMT110204LF KCP30	B244
3753755	TCMT110208LF KCP30	B244
3753757	TCMT16T308LF KCP30	B244
3753760	VBMT160404LF KCP30	B265
3753761	VBMT160408LF KCP30	B265
3753762	CCMT060204MF KCP30	B177
3753763	CCMT09T304MF KCP30	B177
3753765	DCMT11T304MF KCP30	B208
3753766	DCMT11T308MF KCP30	B208
3753767	SCMT120408MF KCP30	B231
3753768	SPMT120408MF KCP30	B239
3753769	TCMT16T308MF KCP30	B245
3753770	TPMT16T308MF KCP30	B255
3753771	CNMG090304MN KCP30	B50
3753772	CNMG090308MN KCP30	B50
3753773	CNMG120404MN KCP30	B50
3753774	CNMG160608MN KCP30	B50
3753775	CNMG160612MN KCP30	B50
3753776	CNMG190608MN KCP30	B50
3753777	CNMG190612MN KCP30	B50
3753778	CNMG190616MN KCP30	B50
3753779	DNMG110404MN KCP30	B78
3753780	DNMG110408MN KCP30	B78
3753781	DNMG150404MN KCP30	B78
3753782	DNMG150604MN KCP30	B78
3753783	DNMG190612MN KCP30	B78
3753784	SNMG090308MN KCP30	B98
3753786	SNMG120408MN KCP30	B98
3753787	SNMG120412MN KCP30	B98
3753789	TNMG160404MN KCP30	B125
3753791	TNMG220404MN KCP30	B125
3753793	TNMG220412MN KCP30	B125
3753794	VNMG160404MN KCP30	B145
3753795	VNMG160408MN KCP30	B145
3753796	VNMG160412MN KCP30	B145
3753797	WNMG060408MN KCP30	B157
3753798	CNMG120412RP KCP30	B53
3753799	CNMG160612RP KCP30	B53
3753801	CNMG190612RP KCP30	B53
3753802	CNMG190616RP KCP30	B53
3753804	DNMG150412RP KCP30	B81
3753805	DNMG150608RP KCP30	B81
3753810	RCMX2507M0RP KCP30	B226
3753812	SNMG120412RP KCP30	B101
3753816	TNMG160408RP KCP30	B128
3753819	TNMG220432RP KCP30	B128
3753821	CNMG120408MN KCP25	B50
3753822	WNMG080412RP KCP30	B159
3753823	CNMG120412MN KCP25	B50
3753825	DNMG150408MN KCP25	B78
3753827	DNMG150608MN KCP25	B78

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
3753828	TNMG160408MN KCP25	B125
3753829	WNMG080408MN KCP25	B157
3753830	CNMG120408MW KCP25	B52
3753831	WNMG080412MW KCP25	B158
3753832	CNMM190612RH KCP25	B55
3753834	CNMM190624RH KCP25	B55
3753836	SNMM190616RH KCP25	B102
3753837	SNMM190624RH KCP25	B102
3753867	CCMT09T308MW KCK20	B178
3753871	CPMT09T308MW KCK20	B191
3753875	CNMG120412RP KCK20	B53
3753877	CNMG160608RP KCK20	B53
3753878	CNMG160612RP KCK20	B53
3753879	CNMG160616RP KCK20	B53
3753884	DNMG150408RP KCK20	B81
3753887	DNMG150608RP KCK20	B81
3753888	DNMG150612RP KCK20	B81
3753891	SNMG120408RP KCK20	B101
3753892	SNMG120412RP KCK20	B101
3753897	SNMG190616RP KCK20	B101
3753898	TNMG160408RP KCK20	B128
3753899	TNMG160412RP KCK20	B128
3753904	TNMG220432RP KCK20	B128
3753909	VNMG160412RP KCK20	B147
3753912	WNMG080408RP KCK20	B159
3753923	WNMG080412RP KCK20	B159
3753926	CCMT060208FW KCK20	B176
3753929	CCMT09T308FW KCK20	B176
3753931	CPMT060204FW KCK20	B189
3753932	CPMT060208FW KCK20	B189
3753934	CPMT09T308FW KCK20	B189
3753935	DCMT11T304FW KCK20	B207
3753981	CNMG120408RN KCP40	B53
3753982	CNMG120412RN KCP40	B53
3753993	CNMG120416RN KCP40	B53
3753994	CNMG160612RN KCP40	B53
3753996	CNMG190608RN KCP40	B53
3753997	CNMG190612RN KCP40	B53
3753998	CNMG190616RN KCP40	B53
3753999	DNMG150408RN KCP40	B81
3754004	SNMG120412RN KCP40	B101
3754005	SNMG120416RN KCP40	B101
3754006	SNMG150612RN KCP40	B101
3754008	SNMG190612RN KCP40	B101
3754010	TNMG220408RN KCP40	B127
3754012	TNMG270612RN KCP40	B127
3754014	VNMG220408RN KCP40	B147
3754015	WNMG080408RN KCP40	B159
3754059	RCMT1204M0 KCP30	B224
3754060	CCMT060204LF KCP30	B177
3754061	CCMT09T304LF KCP30	B177
3754062	CCMT09T308LF KCP30	B177
3754343	CCMT120404LF KCP30	B177
3754344	DCMT11T304LF KCP30	B207
3754345	CCMT09T308MF KCP30	B177
3754346	CCMT120408MF KCP30	B177
3754347	CNMG120408MN KCP30	B50
3754349	DNMG150408MN KCP30	B78
3754351	TNMG160408MN KCP30	B125
3754352	WNMG080408MN KCP30	B157
3754363	CNMG120408RN KCP30	B53
3754365	CNMG120408RP KCP30	B53
3754367	CNMM120412RP KCP30	B56
3754374	CNMM190616RH KCP30	B55
3754375	CNMM190624RH KCP30	B55
3754376	SNMM190612RH KCP30	B102
3754377	SNMM190616RH KCP30	B102
3754378	SNMM190624RH KCP30	B102
3754379	CNMM120408RM KCP30	B55
3754383	CNMM160616RM KCP30	B55
3754385	CNMM190616RM KCP30	B55
3754386	CNMM190624RM KCP30	B55
3754388	DNMM150608RM KCP30	B82
3754396	TNMM160408RM KCP30	B129
3754398	TNMM220412RM KCP30	B129
3754399	TNMM270612RM KCP30	B129
3754815	CNMM190612RH KCP40	B55
3754818	CNMM250924RH KCP40	B55
3754819	SNMM190616RH KCP40	B102
3754821	SNMM250724RH KCP40	B102
3754822	SNMM250924RH KCP40	B102
3754856	CNMM190612RM KCP40	B55
3754858	CNMM250924RM KCP40	B55
3754861	DNMM150612RM KCP40	B82
3754863	SNMM190612RM KCP40	B103
3754864	SNMM250924RM KCP40	B103
3755331	WNMG080404FF KCP10	B155
3755332	CNMM250924RH KCP10	B55
3755363	LNUX191940RRH KCP10	E51
3755366	RCMT2006M0RH KCP10	B225
3755367	RCMX2507M0RH KCP10	B225
3755369	SNMM250724RH KCP10	B102
3755370	SNMM250924RH KCP10	B102
3755371	CNMM250924RM KCP10	B55
3755372	SNMM250724RM KCP10	B103
3755475	RCMT1605M0 KCK20	B224
3755479	RCMT120400 KCK20	B224
3755481	CCMT120408LF KCK20	B177
3755482	CPMT060204LF KCK20	B190
3755484	CPMT09T304LF KCK20	B190
3755485	CPMT09T308LF KCK20	B190
3755486	DCMT070204LF KCK20	B207
3755487	DCMT11T308LF KCK20	B207
3755490	DCMT150408LF KCK20	B207
3755491	DPMT070204LF KCK20	B215
3755492	DPMT11T304LF KCK20	B215
3755503	DPMT11T308LF KCK20	B215
3755504	SCMT09T304LF KCK20	B230
3755505	SCMT09T308LF KCK20	B230
3755507	SCMT120408LF KCK20	B230
3755508	SCMT120412LF KCK20	B230
3755509	SPMT09T304LF KCK20	B238
3755510	SPMT09T308LF KCK20	B238
3755511	TCMT110204LF KCK20	B244
3755512	TCMT110208LF KCK20	B244
3755513	TCMT16T304LF KCK20	B244
3755514	TCMT16T308LF KCK20	B244
3755515	TCMT16T312LF KCK20	B244
3755517	TPMT110204LF KCK20	B255
3755520	TPMT16T308LF KCK20	B255
3755522	TPMT220408LF KCK20	B255
3755526	VBMT160408LF KCK20	B265
3755527	VBMT160412LF KCK20	B265
3755528	WPMT040204LF KCK20	B272
3755531	CCMT060204MF KCK20	B177
3755532	CCMT09T304MF KCK20	B177
3755533	CCMT09T312MF KCK20	B177
3755534	CCMT120412MF KCK20	B177
3755535	CPMT060208MF KCK20	B190
3755536	CPMT09T308MF KCK20	B190
3755538	DCMT11T304MF KCK20	B208
3755539	DCMT11T308MF KCK20	B208
3755540	DCMT11T312MF KCK20	B208
3755542	SCMT09T308MF KCK20	B231
3755543	SCMT120408MF KCK20	B231
3755544	SCMT120412MF KCK20	B231
3755545	SPMT09T308MF KCK20	B239
3755546	SPMT120408MF KCK20	B239
3755547	TCMT110208MF KCK20	B245
3755548	TCMT16T308MF KCK20	B245
3755549	TCMT16T312MF KCK20	B245
3755550	TPMT110208MF KCK20	B255
3755551	TPMT16T308MF KCK20	B255
3755552	TPMT16T312MF KCK20	B255
3755565	CCMT060204LF KCM15	B177
3755570	DCMT11T304LF KCM15	B207
3755593	CNMG120408RP KCM15	B53
3755632	CNMM250924RH KCP25	B55
3755635	CPMT060204LF KCM15	B190
3755637	CPMT09T304LF KCM15	B190
3755638	CPMT09T308LF KCM15	B190
3755639	DCMT070204LF KCM15	B207
3755640	DCMT11T308LF KCM15	B207
3755648	SCMT120408LF KCM15	B230
3755649	TCMT110204LF KCM15	B244
3755650	TCMT110208LF KCM15	B244
3755651	TCMT16T304LF KCM15	B244
3755655	TPMT110204LF KCM15	B255
3755657	TPMT16T304LF KCM15	B255
3755659	VBMT110304LF KCM15	B265
3755661	VBMT160404LF KCM15	B265
3755662	VBMT160408LF KCM15	B265
3755664	WPMT06T308LF KCM15	B272
3755670	CPMT09T308MF KCM15	B190
3755672	DCMT11T304MF KCM15	B208
3755673	DCMT11T308MF KCM15	B208
3755677	SCMT120408MF KCM15	B231
3755682	TPMT16T308MF KCM15	B255
3755684	CNMG120404MP KCM15	B51
3755685	CNMG120408MP KCM15	B51
3755686	CNMG120412MP KCM15	B51
3755689	CNMG160612MP KCM15	B51
3755691	CNMG190612MP KCM15	B51
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3757918	CCMW120412 KCK20	B178
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3758110	SNMM190616RP KCM25	B103
3758111	SNMM190624RP KCM25	B103
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3758134	CNMA120408 KCK20	B47
3758135	CNMA120412 KCK20	B47
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3758137	CNMA160608 KCK20	B47
3758138	CNMA160612 KCK20	B47
3758141	CNMA190612 KCK20	B47
3758142	CNMA190616 KCK20	B47
3758143	DNMA150408 KCK20	B75
3758144	DNMA150412 KCK20	B75
3758145	DNMA150608 KCK20	B75
3758146	DNMA150612 KCK20	B75
3758149	SNMA120408 KCK20	B96
3758150	SNMA120412 KCK20	B96
3758152	SNMA150612 KCK20	B96
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3758155	SNMA190616 KCK20	B96
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3758157	TNMA160412 KCK20	B123
3758158	TNMA160416 KCK20	B123
3758162	VNMA160408 KCK20	B144
3758163	WNMA080408 KCK20	B155
3758164	WNMA080412 KCK20	B155
3758165	WNMA080416 KCK20	B155
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3758791	DNMG150604FP KCM15	B77
3758792	DNMG150608FP KCM15	B77
3758794	SNMG120404FP KCM15	B97

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
3758795	SNMG120408FP KCM15	B97
3758797	TNMG160404FP KCM15	B124
3758798	TNMG160408FP KCM15	B124
3758799	TNMG160412FP KCM15	B124
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3758830	SNMM250924RH KCP30	B102
3758873	SNMM250924RM KCP30	B103
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3759084	EDCT10T308PDFR-PCD KD1410	T34
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3759627	B292A03100YPL KC7315	G94
3759628	B291A03175YPL KC7315	G94
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3759630	B292A03200YPL KC7315	G94
3759654	B291A03300YPL KC7315	G94
3759655	B292A03300YPL KC7315	G94
3759656	B291A03400YPL KC7315	G94
3759657	B292A03400YPL KC7315	G94
3759661	B291A03500YPL KC7315	G94
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3759716	B291A03800YPL KC7315	G94
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3759718	B291A03900YPL KC7315	G94
3759722	B292A03900YPL KC7315	G94
3759763	B291A04100YPL KC7315	G94
3759764	B292A04100YPL KC7315	G94
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3760254	CCMT09T304LF KCM35	B177
3760257	CCMT09T308LF KCM35	B177
3760261	CCMT09T308MF KCM35	B177
3760262	CCMT120408MF KCM35	B177
3760273	CNMG120408RP KCM35	B53
3760277	SNMM120408RP KCM35	B103
3760279	RCMT0602M0 KCM25	B224
3760280	RCMT0803M0 KCM25	B224
3760281	RCMT10T3M0 KCM25	B224
3760282	RCMT1605M0 KCM25	B224
3760286	RCMT120400 KCM25	B224
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3760290	CPMT060204LF KCM25	B190
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3760293	CPMT09T308LF KCM25	B190
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3760300	SCMT09T308LF KCM25	B230
3760302	SCMT120408LF KCM25	B230
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3760306	TCMT16T308LF KCM25	B244
3760307	TCMT16T312LF KCM25	B244
3760310	TPMT110208LF KCM25	B255
3760312	TPMT16T308LF KCM25	B255
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3760315	VBMT160404LF KCM25	B265
3760316	VBMT160408LF KCM25	B265
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3760324	CPMT09T308MF KCM25	B190
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3760327	DCMT11T308MF KCM25	B208
3760329	DPMT11T308MF KCM25	B215
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3760331	SCMT120408MF KCM25	B231
3760334	SPMT120408MF KCM25	B239
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3760395	DCMT070204LF KCM35	B207
3760398	TCMT110204LF KCM35	B244
3760399	TCMT16T304LF KCM35	B244
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3760403	VBMT160408LF KCM35	B265
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3760414	CNMG120408MP KCM35	B51
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3761006	CNMG160616RP KCM25	B53
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3761066	WNMG080412UP KCM25	B160
3763185	HNPJ0905ANSNHD KCK15	S19, S24
3763632	HNPJ0905ANSNHD KC520M	S19, S24
3763723	HNPJ0905ANSNHD KC725M	S19, S24
3763724	HNPJ0905ANSNHD KCPK30	S19, S24
3763725	HNPJ0905ANSNGD KCK15	S19, S23
3763726	HNPJ0905ANSNGD KC520M	S19, S23
3763727	HNPJ0905ANSNGD KC725M	S19, S23
3763728	HNPJ0905ANSNGD KCPK30	S19, S23
3763729	HNPJ090543ANSNHD KCK15	S19, S24
3763730	HNPJ090543ANSNHD KC725M	S19, S24
3763731	HNPJ090543ANSNHD KCPK30	S19, S24
3764792	CNMA120408S02020 KB1340	B289
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3764824	B292A10100YPL KC7315	G95
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3764836	CNMN120408S02020 KB1340	B284
3764837	CNMN120412S02020 KB1340	B284
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3764839	DNMA110412S02020 KB1340	B289
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3764842	RNMN120400S02020 KB1340	B285
3764844	SNMA120412S02020 KB1340	B289
3764845	SNMN090308S02020 KB1340	B286
3764847	SNMN090316S02020 KB1340	B286
3764850	SNMN120316S02020 KB1340	B286
3764851	SNMN120416T02020 KB1340	B286
3765830	EDCT10T320PDFRLDJ KC410M	T35, T42
3765831	EDCT10T320PDERLDJ KC422M	T35, T43
3766023	EDCT10T320PDERLD KC725M	T35, T43
3766024	EDCT10T320PDERLD KCPK30	T35, T43
3766027	EDCT10T324PDERLDJ KC422M	T35, T43
3766028	EDCT10T324PDERLD KC522M	T35, T43
3766029	EDCT10T324PDERLD KC725M	T35, T43
3766820	RIQ09E1306 KC6305	K55
3767813	OFKT06L5AFFNLBJ KC410M	S49
3767814	OFKT06L5AFENLBJ KC422M	S49
3768928	CCMT060204FP KCP05	B176
3768930	CCMT09T304FP KCP05	B176
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3768972	DCMT11T308FP KCP05	B207
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3769054	CCMT09T308FP KTP10	B176
3769055	CPMT060202FP KTP10	B189
3769056	CPMT060204FP KTP10	B189
3769057	CPMT060208FP KTP10	B189
3769060	CPMT09T308FP KTP10	B189
3769061	DCMT070202FP KTP10	B207
3769063	DCMT11T302FP KTP10	B207
3769064	DCMT11T304FP KTP10	B207
3769065	DCMT11T308FP KTP10	B207
3769066	DPMT070204FP KTP10	B214
3769068	DPMT11T308FP KTP10	B214
3769069	SCMT09T308FP KTP10	B230
3769071	TCMT110202FP KTP10	B244
3769072	TCMT110204FP KTP10	B244
3769076	TCMT16T308FP KTP10	B244
3769082	VBMT110304FP KTP10	B265
3769083	VBMT160402FP KTP10	B265
3769084	VBMT160404FP KTP10	B265
3769085	VBMT160408FP KTP10	B265
3769093	CCMT060202FP KCP25	B176
3769094	CCMT060204FP KCP25	B176
3769095	CCMT060204FP KCM15	B176
3769096	CCMT060208FP KCP25	B176
3769097	CCMT09T302FP KCP25	B176
3769099	CCMT09T304FP KCM15	B176
3769103	CCMT09T304FP KCP25	B176
3769106	CCMT09T308FP KCP25	B176
3769107	CPMT09T304FP KCM15	B189
3769109	DCMT070204FP KCM15	B207
3769111	DCMT11T304FP KCM15	B207
3769112	DCMT11T308FP KCM15	B207

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
3769114	DPMT070204FP KCM15	B214
3769118	SCMT09T308FP KCM15	B230
3769121	CPMT050204FP KCP25	B189
3769122	TCMT110208FP KCM15	B244
3769124	CPMT060202FP KCP25	B189
3769128	CPMT060204FP KCP25	B189
3769130	VBMT110304FP KCM15	B265
3769131	VBMT110308FP KCM15	B265
3769132	CPMT060208FP KCP25	B189
3769133	VBMT160404FP KCM15	B265
3769134	VBMT160408FP KCM15	B265
3769139	DCMT070204FP KCP25	B207
3769140	DCMT070208FP KCP25	B207
3769141	DCMT11T302FP KCP25	B207
3769142	DCMT11T304FP KCP25	B207
3769143	DCMT11T308FP KCP25	B207
3769146	DCMT150408FP KCP25	B207
3769147	DPMT070204FP KCP25	B214
3769148	DPMT11T304FP KCP25	B214
3769150	SCMT09T304FP KCP25	B230
3769151	SCMT09T308FP KCP25	B230
3769152	SCMT120404FP KCP25	B230
3769154	SCMT120412FP KCP25	B230
3769155	SPMT09T304FP KCP25	B238
3769157	TCMT110204FP KCP25	B244
3769158	TCMT110208FP KCP25	B244
3769159	TCMT16T304FP KCP25	B244
3769160	TCMT16T308FP KCP25	B244
3769161	TCMT220408FP KCP25	B244
3769162	TPMT090208FP KCP25	B254
3769163	TPMT110204FP KCP25	B254
3769165	TPMT16T304FP KCP25	B254
3769166	TPMT16T308FP KCP25	B254
3769168	VBMT110302FP KCP25	B265
3769169	VBMT110304FP KCP25	B265
3769170	VBMT110308FP KCP25	B265
3769171	VBMT160402FP KCP25	B265
3769172	VBMT160404FP KCP25	B265
3769173	VBMT160408FP KCP25	B265
3769174	VBMT160412FP KCP25	B265
3769175	WCMT06T308FP KCP25	B270
3769176	WPMT040204FP KCP25	B272
3769178	WPMTS3T104FP KCP25	B272
3769203	CCMT060202FP KCM25	B176
3769204	CCMT060204FP KCM25	B176
3769205	CCMT060208FP KCM25	B176
3769206	CCMT09T302FP KCM25	B176
3769207	CCMT09T304FP KCM25	B176
3769208	CCMT09T308FP KCM25	B176
3769210	CCMT120408FP KCM25	B176
3769223	CPMT060202FP KCM25	B189
3769224	CPMT060204FP KCM25	B189
3769226	CPMT09T302FP KCM25	B189
3769227	CPMT09T304FP KCM25	B189
3769228	CPMT09T308FP KCM25	B189
3769229	DCMT070202FP KCM25	B207
3769230	DCMT070204FP KCM25	B207
3769231	DCMT070208FP KCM25	B207
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3769233	DCMT11T304FP KCM25	B207
3769234	DCMT11T308FP KCM25	B207
3769235	DCMT150404FP KCM25	B207
3769236	DCMT150408FP KCM25	B207
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3769243	SCMT120408FP KCM25	B230
3769248	TCMT110204FP KCM25	B244
3769251	TCMT16T308FP KCM25	B244
3769253	TCMT220408FP KCM25	B244
3769257	TPMT16T304FP KCM25	B254
3769260	VBMT110304FP KCM25	B265
3769262	VBMT160402FP KCM25	B265
3769283	VBMT160404FP KCM25	B265
3769284	VBMT160408FP KCM25	B265
3769285	WPMT040204FP KCM25	B272
3769290	CCMT060202FP KCU10	B176
3769291	CCMT060204FP KCU10	B176
3769292	CCMT060208FP KCU10	B176
3769310	CPMT060204FP KCK20	B189
3769320	SCMT09T308FP KCK20	B230
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3769337	VBMT160408FP KCK20	B265
3769343	CCMT09T302FP KCU10	B176
3769344	CCMT09T304FP KCU10	B176
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3769346	CCMT120408FP KCU10	B176
3769347	CPMT050202FP KCU10	B189
3769348	CPMT050204FP KCU10	B189
3769349	CPMT060202FP KCU10	B189
3769350	CPMT060204FP KCU10	B189
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3769353	CPMT09T304FP KCU10	B189
3769354	CPMT09T308FP KCU10	B189
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3769356	DCMT070204FP KCU10	B207
3769357	DCMT070208FP KCU10	B207
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3769359	DCMT11T304FP KCU10	B207
3769360	DCMT11T308FP KCU10	B207
3769363	DCMT150408FP KCU10	B207
3769364	DPMT070202FP KCU10	B214
3769365	DPMT070204FP KCU10	B214
3769366	DPMT070208FP KCU10	B214
3769368	DPMT11T304FP KCU10	B214
3769369	DPMT11T308FP KCU10	B214
3769370	SCMT09T304FP KCU10	B230
3769371	SCMT09T308FP KCU10	B230
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3769373	SCMT120408FP KCU10	B230
3769374	SCMT120412FP KCU10	B230
3769375	SPMT09T304FP KCU10	B238
3769376	SPMT09T308FP KCU10	B238
3769377	TCMT090204FP KCU10	B244
3769378	TCMT090208FP KCU10	B244
3769380	TCMT110204FP KCU10	B244
3769381	TCMT110208FP KCU10	B244
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3769383	TCMT110308FP KCU10	B244
3769384	TCMT110312FP KCU10	B244
3769386	TCMT16T304FP KCU10	B244
3769387	TCMT16T308FP KCU10	B244
3769388	TCMT16T312FP KCU10	B244
3769389	TCMT220408FP KCU10	B244
3769390	TPMT090204FP KCU10	B254
3769391	TPMT090208FP KCU10	B254
3769392	TPMT110202FP KCU10	B254
3769393	TPMT110204FP KCU10	B254
3769394	TPMT110208FP KCU10	B254
3769395	TPMT110304FP KCU10	B254
3769396	TPMT110308FP KCU10	B254
3769397	TPMT16T304FP KCU10	B254
3769401	VBMT110302FP KCU10	B265
3769402	VBMT110304FP KCU10	B265
3769403	VBMT110308FP KCU10	B265
3769404	VBMT160402FP KCU10	B265
3769405	VBMT160404FP KCU10	B265
3769406	VBMT160408FP KCU10	B265
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3769408	WCMT06T308FP KCU10	B270
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3769411	WPMT06T308FP KCU10	B272
3769412	WPMTS3T104FP KCU10	B272
3769413	CCMT060202FP KCU25	B176
3769414	CCMT060204FP KCU25	B176
3769415	CCMT060208FP KCU25	B176
3769416	CCMT09T302FP KCU25	B176
3769417	CCMT09T304FP KCU25	B176
3769418	CCMT09T308FP KCU25	B176
3769419	CCMT120404FP KCU25	B176
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3769422	CPMT050204FP KCU25	B189
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3769428	CPMT09T308FP KCU25	B189
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3769432	DCMT11T304FP KCU25	B207
3769433	DCMT11T308FP KCU25	B207
3769435	DPMT070204FP KCU25	B214
3769436	DPMT070208FP KCU25	B214
3769438	DPMT11T304FP KCU25	B214
3769440	SCMT09T304FP KCU25	B230
3769441	SCMT09T308FP KCU25	B230
3769444	SPMT09T304FP KCU25	B238
3769446	TCMT090204FP KCU25	B244
3769447	TCMT090208FP KCU25	B244
3769448	TCMT110202FP KCU25	B244
3769449	TCMT110204FP KCU25	B244
3769450	TCMT110208FP KCU25	B244
3769451	TCMT110304FP KCU25	B244
3769452	TCMT110308FP KCU25	B244
3769454	TCMT16T304FP KCU25	B244
3769455	TCMT16T308FP KCU25	B244
3769456	TCMT16T312FP KCU25	B244
3769457	TCMT220408FP KCU25	B244
3769458	TPMT090208FP KCU25	B254
3769460	TPMT110204FP KCU25	B254
3769461	TPMT110304FP KCU25	B254
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3769465	VBMT110308FP KCU25	B265
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3769467	VBMT160404FP KCU25	B265
3769468	VBMT160408FP KCU25	B265
3769469	WCMT040204FP KCU25	B270
3773118	M1H20J02R36B20ED10C6	T39
3773119	M1H25J02R46B25ED10C8	T39
3773120	M1H32J02R54B32ED10C10	T39
3773121	M1H32J03R54B32ED10C15	T39
3773122	M1H20J02R36A20ED10C6	T40
3773323	B967A05000 KC7315	G132
3773803	M1H25J02R46A25ED10C8	T40
3773805	M1H32J03R54A32ED10C15	T40
3773806	M1H20J02R28A20ED10C4	T40
3773807	M1H25J02R28A25ED10C4	T40
3773808	M1H32J02R28A32ED10C4	T40
3773809	M1H32J03R28A32ED10C6	T40
3773810	M1H20J02R28M10ED10C4	T38
3773811	M1H25J02R32M12ED10C4	T38
3773813	M1H32J03R40M16ED10C6	T38
3773814	M1H40T03R50A16ED10C12	T41
3773815	M1H40T05R50A16ED10C20	T41
3773816	M1H50T03R60A22ED10C15	T41
3773817	M1H50T05R60A22ED10C25	T41
3774249	HNPJ0905ANSNHD KC522M...	S19, S24
3774250	HNPJ0905ANSNGD KC522M...	S19, S23
3774251	HNPJ090543ANSNHD KC522M...	S19, S24
3774691	A4G0405M04U04GUP KCU25	C92
3774692	A4G0405M04U08GUP KCU25	C92
3774723	A4G0505M05U08GUP KCU25	C92
3774724	A4G0805M08U12GUP KCU25	C92
3774906	SPPX15T508RHP KC7140	J89
3774919	EDPT10T316PDSRGE KC522M...	T36, T44
3774920	EDPT10T316PDSRGE KC725M...	T36, T44
3774921	EDPT10T316PDSRGE KCPK30...	T36, T44
3775003	EDPT10T312PDSRGE KC522M...	T36, T44
3775004	EDPT10T312PDSRGE KC725M...	T36, T44
3775005	EDPT10T312PDSRGE KCPK30...	T36, T44
3775016	EDPT10T308PDSRGE KC522M...	T36, T44
3775017	EDPT10T308PDSRGE KC725M...	T36, T44
3775018	EDPT10T308PDSRGE KCPK30...	T36, T44
3775022	EDPT10T331PDSRGE KC522M...	T36, T44
3775063	EDPT10T331PDSRGE KC725M...	T36, T44
3775064	EDPT10T331PDSRGE KCPK30...	T36, T44
3776430	B291A12900YPL KC7315	G96
3779249	EDPT10T304PDSRGE KC522M...	T36, T44
3779250	EDPT10T304PDSRGE KC725M...	T36, T44
3779251	EDPT10T304PDSRGE KCPK30...	T36, T44
3780360	MS-2071	T14–17, V77–78
3781192	A4G0200M02P02GUP KCU10	C93
3781252	A4G0200M02P02GUP KCU25	C93
3781253	A4G0300M03P02GUP KCU25	C93
3781254	A4G0300M03P04GUP KCU25	C93
3781255	A4G0400M04P02GUP KCU25	C93
3781256	A4G0400M04P04GUP KCU25	C93
3781257	A4G0400M04P08GUP KCU25	C93
3781258	A4G0500M05P04GUP KCU25	C93
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3781260	A4G0600M06P04GUP KCU25	C93
3781261	A4G0600M06P08GUP KCU25	C93
3781262	A4G0800M08P08GUP KCU25	C93
3781263	A4G0800M08P12GUP KCU25	C93
3781264	A4G1000M10P08GUP KCU25	C93
3781265	A4G1000M10P12GUP KCU25	C93
3781278	A4G0300M03P02GUP KCU10	C93
3781279	A4G0300M03P04GUP KCU10	C93
3781280	A4G0400M04P02GUP KCU10	C93
3781281	A4G0400M04P04GUP KCU10	C93
3781282	A4G0400M04P08GUP KCU10	C93
3781283	A4G0500M05P04GUP KCU10	C93
3781284	A4G0500M05P08GUP KCU10	C93
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3781286	A4G0600M06P08GUP KCU10	C93
3781287	A4G0800M08P08GUP KCU10	C93
3781288	A4G0800M08P12GUP KCU10	C93
3781289	A4G1000M10P08GUP KCU10	C93
3781290	A4G1000M10P12GUP KCU10	C93
3781678	MS1499	B386
3781679	MS1130	B386
3782458	B978A03000 KC7315	G146
3784063	193.523	H102–103
3784064	193.524	H102–103
3784065	193.525	H102–103
3784066	193.526	H102–103
3784326	170.350	H98
3784327	170.353	H98
3784328	170.355	H98–99
3784329	170.356	H98–99
3784330	170.345	H98
3784331	170.346	H98
3784332	170.347	H98–99
3784473	170.348	H99
3784474	FBSCFCR09CA06F	K111
3784475	FBSCFCL09CA06F	K111
3784476	FBSCLCR09CA06F	K111
3784477	FBSCLCL09CA06F	K111
3787461	RPGX060400MP KCS10	B167
3787462	RPGX090700MP KCS10	B167
3787483	RPGX120700MP KCS10	B167
3787484	RCGX060400MP KCS10	B166
3787486	RCGX120700MP KCS10	B166
3787488	RPGT060400MP KCS10	B229
3787492	RCMT0803M0MP KCS10	B224
3787503	RCMT10T3M0MP KCS10	B224
3787504	RCMT120400MP KCS10	B224
3787505	RCMT1606M0MP KCS10	B224
3787507	RCMK060400MP KCS10	E64
3787508	RCMK090700MP KCS10	E64
3787509	RCMK120800MP KCS10	E64
3787512	RCGH120400MP KCS10	B222
3790401	KTIP210R3SS25M	H31
3790402	KTIP220R3SS25M	H31
3790443	KTIP230R3SS25M	H31
3790444	KTIP240R3SS25M	H31
3790445	KTIP250R3SS32M	H31
3790446	KTIP210R3SCF25M	H32
3790447	KTIP220R3SCF25M	H32
3790448	KTIP230R3SCF25M	H32
3790449	KTIP240R3SCF25M	H32
3790450	KTIP250R3SCF25M	H32
3790451	KTIP210R5SS25M	H31
3790452	KTIP220R5SS25M	H31
3790453	KTIP230R5SS25M	H31
3790454	KTIP240R5SS25M	H31
3790455	KTIP250R5SS32M	H31
3790456	KTIP210R5SCF25M	H32
3790457	KTIP220R5SCF25M	H32
3790458	KTIP230R5SCF25M	H32
3790459	KTIP240R5SCF25M	H32
3790460	KTIP250R5SCF25M	H32
3790461	KTIP210R8SS25M	H31
3790462	KTIP220R8SS25M	H31
3790463	KTIP230R8SS25M	H31
3790464	KTIP240R8SS25M	H31
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3790466	KTIP210R8SCF25M	H32
3790467	KTIP220R8SCF25M	H32
3790468	KTIP230R8SCF25M	H32
3790469	KTIP240R8SCF25M	H32
3790470	KTIP250R8SCF25M	H32
3791263	A4G0205M02U02GUP KCU10	C92
3791265	A4G0305M03U02GUP KCU10	C92
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3791267	A4G0405M04U04GUP KCU10	C92
3791268	A4G0405M04U08GUP KCU10	C92

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
3791269	A4G0505M05U04GUP KCU10	C92
3791270	A4G0505M05U08GUP KCU10	C92
3791271	A4G0605M06U04GUP KCU10	C92
3791272	A4G0605M06U08GUP KCU10	C92
3791273	A4G0605M06U12GUP KCU10	C92
3791275	A4G0805M08U08GUP KCU10	C92
3791276	A4G0805M08U12GUP KCU10	C92
3791277	A4G1005M10U08GUP KCU10	C92
3791279	A4G0205M02U02GUP KCU25	C92
3791280	A4G0305M03U02GUP KCU25	C92
3791281	A4G0305M03U04GUP KCU25	C92
3791282	A4G0505M05U04GUP KCU25	C92
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3791288	A4G1005M10U12GUP KCU25	C92
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3791303	A4G0205M02U02GUP KCP25	C92
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3791305	A4G0305M03U04GUP KCP25	C92
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3791311	A4G0605M06U08GUP KCP25	C92
3791312	A4G0605M06U12GUP KCP25	C92
3791313	A4G0805M08U08GUP KCP25	C92
3791314	A4G0805M08U12GUP KCP25	C92
3791316	A4G1005M10U12GUP KCP25	C92
3791545	B976A11600 KC7315	G141
3793949	KSEMP3320FDS32A1M	H80, H91, H98
3793950	KSEMP3920FDS36A1M	H80, H92, H98
3794291	KSEMP3200FDS32A1M	H80, H91, H98
3794292	KSEMP3400FDS32A1M	H80, H91, H98
3794393	KSEMP3500FDS32A1M	H80, H91, H98
3794394	KSEMP3600FDS36A1M	H80, H92, H98
3794395	KSEMP3700FDS36A1M	H80, H92, H98
3794396	KSEMP3800FDS36A1M	H80, H92, H98
3794397	KSEMP3900FDS36A1M	H80, H92, H98
3794398	KSEMP4000FDS40A1M	H80, H92, H98
3794399	KSEMP4100FDS40A1M	H80, H92, H98
3794400	KSEMP4200FDS40A1M	H80, H92, H98
3794401	KSEMP4300FDS40A1M	H80, H92, H98
3794402	KSEMP4400FDS40A1M	H80, H92, H98
3794403	KSEMP4500FDS45A1M	H81, H92, H98
3794404	KSEMP4600FDS45A1M	H81, H92, H98
3794405	KSEMP4700FDS45A1M	H81, H92, H98
3794406	KSEMP4800FDS45A1M	H81, H92, H98
3794407	KSEMP4900FDS45A1M	H81, H92, H98
3794408	KSEMP5100FDS50A1M	H81, H92, H98
3794409	KSEMP5200FDS50A1M	H81, H92, H98
3794410	KSEMP5300FDS50A1M	H81, H92, H98
3794411	KSEMP5400FDS50A1M	H81, H92, H98
3794412	KSEMP5500FDS50A1M	H81, H92, H98
3794413	KSEMP5600FDS56A1M	H81, H92, H98
3794414	KSEMP5700FDS56A1M	H81, H92, H98
3794415	KSEMP5800FDS56A1M	H81, H92, H98
3794416	KSEMP5900FDS56A1M	H81, H92, H98
3794417	KSEMP6000FDS56A1M	H81, H92, H98
3794418	KSEMP6100FDS56A1M	H81, H92, H98
3794419	KSEMP6200FDS56A1M	H81, H92, H98
3794420	KSEMP6300FDS63A1M	H81, H92, H98
3794421	KSEMP6400FDS63A1M	H81, H92, H99
3794422	KSEMP6500FDS63A1M	H81, H92, H99
3794423	KSEMP6600FDS63A1M	H81, H92, H99
3794424	KSEMP6700FDS63A1M	H81, H92, H99
3794425	KSEMP6800FDS63A1M	H81, H92, H99
3794426	KSEMP6900FDS63A1M	H81, H92, H99
3794427	KSEMP3750FDS36A1M	H80, H92, H98
3794428	WD32FDS32216M	H103
3794429	WD32FDS32391M	H103
3794430	WD32FDS36244M	H103
3794431	WD32FDS36361M	H103
3794432	WD32FDS36439M	H103
3794443	WD50FDS40271M	H103
3794444	WD50FDS40403M	H103
3794445	WD50FDS40491M	H103
3794446	WD50FDS45304M	H103
3794447	WD50FDS45451M	H103
3794448	WD50FDS45549M	H103
3794449	WD50FDS50338M	H103
3794450	WD50FDS50613M	H103
3794451	WD50FDS56383M	H103
3794452	WD50FDS56569M	H103
3794453	WD50FDS56693M	H103
3794454	WD50FDS63429M	H103
3794455	WD50FDS63639M	H103
3794916	KSEMP3175FDS32A1M	H80, H91, H98
3794917	KSEMP3334FDS32A1M	H80, H91, H98
3794918	KSEMP3493FDS32A1M	H80, H91, H98
3794919	KSEMP3651FDS36A1M	H80, H92, H98
3794920	KSEMP3810FDS36A1M	H80, H92, H98
3794921	KSEMP3970FDS36A1M	H80, H92, H98
3794922	KSEMP4128FDS40A1M	H80, H92, H98
3794933	KSEMP4445FDS40A1M	H80, H92, H98
3794934	KSEMP4763FDS45A1M	H81, H92, H98
3794935	KSEMP5080FDS50A1M	H81, H92, H98
3794936	KSEMP5398FDS50A1M	H81, H92, H98
3794937	KSEMP5715FDS56A1M	H81, H92, H98
3794938	KSEMP6033FDS56A1M	H81, H92, H98
3794939	KSEMP6350FDS63A1M	H81, H92, H99
3794940	KSEMP6668FDS63A1M	H81, H92, H99
3794941	KSEMP6985FDS63A1M	H81, H92, H99
3795256	RMB14000H7HF KT6215	K18
3795257	RMB15000H7HF KT6215	K18
3795258	RMB16000H7HF KT6215	K18
3795260	RMB18000H7HF KT6215	K18
3795261	RMB19000H7HF KT6215	K18
3795262	RMB20000H7HF KT6215	K18
3795311	B978F18000 KC7315	G149
3795333	RMB14000H7SF KT6215	K17
3795334	RMB15000H7SF KT6215	K17
3795335	RMB16000H7SF KT6215	K17
3795336	RMB17000H7SF KT6215	K17
3795337	RMB18000H7SF KT6215	K17
3795338	RMB19000H7SF KT6215	K17
3795339	RMB20000H7SF KT6215	K17
3812186	DNMG150612MP KCP10	B79
3830321	B976A08020 KC7315	G140
3831819	M1H63T5R75A27S90ED14C20	T59
3838225	WNMG080412MP KCP10	B157
3842812	B291A13800YPL KC7315	G96
3842895	H32LSER5	D82
3842897	H40LSER5	D82
3842905	H50LSER27	D82
3848433	B967A15500 KC7315	G134
3849319	XNGJ0905ANFNLDJ3W KC410M	S22
3849320	HNGJ0905ANFNLDJ KC410M	S18, S22
3852200	RPET1204M0ELE KC725M	V73
3852233	RPET1204M0SGE KCPK30	V74
3852235	RPET1204M0ELE KCPK30	V73
3852284	RPPT1605M0SHP KC725M	V80
3852285	RPPT1605M0SHP KCPK30	V80
3852395	RPPT1204M0SGP KC725M	V74
3852396	RPPT1204M0SGP KCPK30	V74
3854146	RIR04EDS06 KD1415	K53
3854265	A4SMR2020K0208	C114
3854266	A4SML2020K0208	C114
3854267	A4SMR2020K0308	C114
3854268	A4SML2020K0308	C114
3854269	A4SMR2020K0408	C114
3854270	A4SML2020K0408	C114
3854271	A4SMR2525M0510	C114
3854272	A4SML2525M0510	C114
3854273	A4SMR2525M0610	C114
3854274	A4SML2525M0610	C114
3855176	EDPT140416PDSRGE KC522M	T53, T62
3855177	EDPT140416PDSRGE KC725M	T53, T62
3855178	EDPT140416PDSRGE KCPK30	T53, T62
3855180	EDPT140431PDSRGE KC725M	T53, T62
3855181	EDPT140431PDSRGE KCPK30	T53, T62
3855209	EDPT140404PDSRGE KC522M	T53, T62
3855210	EDPT140404PDSRGE KC725M	T53, T62
3855211	EDPT140404PDSRGE KCPK30	T53, T62
3855236	EDPT140408PDSRGE KC522M	T53, T62
3855237	EDPT140408PDSRGE KC725M	T53, T62
3855238	EDPT140408PDSRGE KCPK30	T53, T62
3855240	EDPT140412PDSRGE KC522M	T53, T62
3855241	EDPT140412PDSRGE KC725M	T53, T62
3855242	EDPT140412PDSRGE KCPK30	T53, T62
3855383	B291A04300YPL KC7315	G94
3855561	CNMG120408MP KCP10	B51
3855796	CM234R ASSY	B58–60, B66, B85, B89–90, B105–107, B132, B137, B152, B161, B163
3855854	B291A08800YPL KC7315	G95
3856322	LT27ER4API502 KC5025	D55
3856324	LT27ER4API382 KC5025	D55
3856327	LT27NR4API502 KC5025	D68
3856329	LT27NR4API382 KC5025	D68
3856518	DNGX120712T02020 KYK25	B296
3856520	DNGX150712T02020 KYK25	B296
3856521	SNGX120712T02020 KYK25	B297
3856522	SNGX120716T02020 KYK25	B297
3856532	SNGN120408T02020 KYK25	B297
3856553	SNGN120412T02020 KYK25	B297
3856554	SNGN120712T02020 KYK25	B297
3856558	CNGA120408T02020 KYK25	B292
3856559	CNGA120412T02020 KYK25	B292
3856560	CNGA120416T02020 KYK25	B292
3856561	CNGA120408T01020FW KYK25	B293
3856562	CNGA120412T01020FW KYK25	B293
3856604	CNGA190616T02020 KYK25	B292
3856607	DNGA150416T02020 KYK25	B293
3856608	SNGA120408T02020 KYK25	B293
3856609	SNGA120412T02020 KYK25	B293
3856611	SNGA150612T02020 KYK25	B293
3856614	VNGA220408T02020 KYK25	B294
3856615	WNGA080408T02020 KYK25	B294
3856616	WNGA080412T02020 KYK25	B294
3856618	CNGA160612T02020 KYK25	B292
3856793	RIR04E1312 KC6005	K53
3856806	RIR02E1312 KC6305	K53
3856807	RIR03E1312 KC6305	K53
3856827	RIRT4C4512 KC6005	K54
3858114	EDPT180508PDSRGE KCPK30	T75
3858115	EDPT180508PDSRGE KC522M	T75
3858116	EDPT180508PDSRGE KC725M	T75
3858210	B978A04200 KC7315	G146
3858724	RIR01E1312 KC6105	K53
3858725	RIR02E1312 KC6105	K53
3858727	RIR01EGU00 KC6105	K53
3858731	RIR05EGU00 KC6105	K53
3858814	KST175CS	K39
3858815	KST200CS	K39
3858817	KST250CS	K39
3858818	KST300CS	K39
3858819	KST350CS	K39
3859000	B292A07400YPL KC7315	G95
3859044	SDET120464SNGB KC725M	T105, T112, U51
3859155	B292A08100YPL KC7315	G95
3860364	RHM20000KST175H7HF KT325	K31
3860365	RHM20640KST175H7HF KT325	K31
3860366	RHM21000KST175H7HF KT325	K31
3860367	RHM22000KST175H7HF KT325	K31
3860368	RHM22230KST175H7HF KT325	K31
3860369	RHM22500KST200H7HF KT325	K31
3860370	RHM23000KST200H7HF KT325	K31
3860371	RHM23810KST200H7HF KT325	K31
3860372	RHM24000KST200H7HF KT325	K31
3860383	RHM25000KST200H7HF KT325	K31
3860384	RHM25400KST200H7HF KT325	K31
3860385	RHM26000KST200H7HF KT325	K31
3860386	RHM26990KST200H7HF KT325	K31
3860387	RHM27000KST200H7HF KT325	K31
3860388	RHM27500KST250H7HF KT325	K31
3860389	RHM28000KST250H7HF KT325	K32
3860390	RHM28580KST250H7HF KT325	K32
3860391	RHM29000KST250H7HF KT325	K32
3860392	RHM30000KST250H7HF KT325	K32
3860393	RHM30160KST250H7HF KT325	K32
3860394	RHM31000KST250H7HF KT325	K32
3860395	RHM31750KST250H7HF KT325	K32
3860396	RHM32000KST250H7HF KT325	K32
3860397	RHM32500KST300H7HF KT325	K32
3860398	RHM33000KST300H7HF KT325	K32
3860399	RHM33340KST300H7HF KT325	K32
3860401	RHM34930KST300H7HF KT325	K32
3860402	RHM35000KST300H7HF KT325	K32
3860403	RHM36000KST300H7HF KT325	K32
3860404	RHM36510KST300H7HF KT325	K32
3860405	RHM37000KST300H7HF KT325	K32
3860406	RHM37500KST350H7HF KT325	K32
3860408	RHM38100KST350H7HF KT325	K32
3860409	RHM39000KST350H7HF KT325	K32
3860410	RHM39690KST350H7HF KT325	K32
3860411	RHM40000KST350H7HF KT325	K32
3860412	RHM41000KST350H7HF KT325	K32
3860413	RHM41280KST350H7HF KT325	K32
3860414	RHM42000KST350H7HF KT325	K32
3860476	RHM20000KST175H7SF KT325	K29
3860477	RHM20640KST175H7SF KT325	K29
3860478	RHM21000KST175H7SF KT325	K29
3860480	RHM22230KST175H7SF KT325	K29
3860481	RHM22500KST200H7SF KT325	K29
3860482	RHM23000KST200H7SF KT325	K29
3860513	RHM23810KST200H7SF KT325	K29
3860514	RHM24000KST200H7SF KT325	K29
3860515	RHM25000KST200H7SF KT325	K29
3860516	RHM25400KST200H7SF KT325	K29
3860517	RHM26000KST200H7SF KT325	K29
3860518	RHM26990KST200H7SF KT325	K29
3860519	RHM27000KST200H7SF KT325	K29
3860520	RHM27500KST250H7SF KT325	K30
3860521	RHM28000KST250H7SF KT325	K30
3860522	RHM28580KST250H7SF KT325	K30
3860523	RHM29000KST250H7SF KT325	K30
3860524	RHM30000KST250H7SF KT325	K30
3860525	RHM30160KST250H7SF KT325	K30
3860526	RHM31000KST250H7SF KT325	K30
3860527	RHM31750KST250H7SF KT325	K30
3860528	RHM32000KST250H7SF KT325	K30
3860529	RHM32500KST300H7SF KT325	K30
3860530	RHM33000KST300H7SF KT325	K30
3860531	RHM33340KST300H7SF KT325	K30
3860532	RHM34000KST300H7SF KT325	K30
3860533	RHM34930KST300H7SF KT325	K30
3860534	RHM35000KST300H7SF KT325	K30
3860535	RHM36000KST300H7SF KT325	K30
3860536	RHM36510KST300H7SF KT325	K30
3860537	RHM37000KST300H7SF KT325	K30
3860538	RHM37500KST350H7SF KT325	K30
3860539	RHM38000KST350H7SF KT325	K30
3860540	RHM38100KST350H7SF KT325	K30
3860541	RHM39000KST350H7SF KT325	K30
3860542	RHM39690KST350H7SF KT325	K30
3860544	RHM41000KST350H7SF KT325	K30
3860545	RHM41280KST350H7SF KT325	K30
3860546	RHM42000KST350H7SF KT325	K30
3860625	RHM20000KST175H7SF KT6215	K29
3860626	RHM20640KST175H7SF KT6215	K29
3860627	RHM21000KST175H7SF KT6215	K29
3860628	RHM22000KST175H7SF KT6215	K29
3860629	RHM22230KST175H7SF KT6215	K29

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
3860630	RHM22500KST200H7SF KT6215	K29
3860631	RHM23000KST200H7SF KT6215	K29
3860632	RHM23810KST200H7SF KT6215	K29
3860643	RHM24000KST200H7SF KT6215	K29
3860644	RHM25000KST200H7SF KT6215	K29
3860645	RHM25400KST200H7SF KT6215	K29
3860647	RHM26990KST200H7SF KT6215	K29
3860648	RHM27000KST200H7SF KT6215	K29
3860649	RHM27500KST250H7SF KT6215	K30
3860650	RHM28000KST250H7SF KT6215	K30
3860651	RHM28580KST250H7SF KT6215	K30
3860652	RHM29000KST250H7SF KT6215	K30
3860653	RHM30000KST250H7SF KT6215	K30
3860655	RHM31000KST250H7SF KT6215	K30
3860656	RHM31750KST250H7SF KT6215	K30
3860658	RHM32500KST300H7SF KT6215	K30
3860659	RHM33000KST300H7SF KT6215	K30
3860660	RHM33340KST300H7SF KT6215	K30
3860662	RHM34930KST300H7SF KT6215	K30
3860663	RHM35000KST300H7SF KT6215	K30
3860664	RHM36000KST300H7SF KT6215	K30
3860665	RHM36510KST300H7SF KT6215	K30
3860667	RHM37500KST350H7SF KT6215	K30
3860668	RHM38000KST350H7SF KT6215	K30
3860669	RHM38100KST350H7SF KT6215	K30
3860670	RHM39000KST350H7SF KT6215	K30
3860671	RHM39690KST350H7SF KT6215	K30
3860672	RHM40000KST350H7SF KT6215	K30
3860673	RHM41000KST350H7SF KT6215	K30
3860674	RHM41280KST350H7SF KT6215	K30
3860675	RHM42000KST350H7SF KT6215	K30
3860855	RHM20000KST175H7HF KT6215	K31
3860856	RHM20640KST175H7HF KT6215	K31
3860857	RHM21000KST175H7HF KT6215	K31
3860858	RHM22000KST175H7HF KT6215	K31
3860859	RHM22230KST175H7HF KT6215	K31
3860860	RHM22500KST200H7HF KT6215	K31
3860861	RHM23000KST200H7HF KT6215	K31
3860862	RHM23810KST200H7HF KT6215	K31
3860863	RHM24000KST200H7HF KT6215	K31
3860864	RHM25000KST200H7HF KT6215	K31
3860865	RHM25400KST200H7HF KT6215	K31
3860867	RHM26990KST200H7HF KT6215	K31
3860868	RHM27000KST200H7HF KT6215	K31
3860869	RHM27500KST250H7HF KT6215	K31
3860870	RHM28000KST250H7HF KT6215	K32
3860872	RHM29000KST250H7HF KT6215	K32
3860873	RHM30000KST250H7HF KT6215	K32
3860874	RHM30160KST250H7HF KT6215	K32
3860875	RHM31000KST250H7HF KT6215	K32
3860876	RHM31750KST250H7HF KT6215	K32
3860877	RHM32000KST250H7HF KT6215	K32
3860878	RHM32500KST300H7HF KT6215	K32
3860879	RHM33000KST300H7HF KT6215	K32
3860880	RHM33340KST300H7HF KT6215	K32
3860881	RHM34000KST300H7HF KT6215	K32
3860882	RHM34930KST300H7HF KT6215	K32
3860883	RHM35000KST300H7HF KT6215	K32
3860885	RHM36510KST300H7HF KT6215	K32
3860886	RHM37000KST300H7HF KT6215	K32
3860887	RHM37500KST350H7HF KT6215	K32
3860890	RHM39000KST350H7HF KT6215	K32
3860891	RHM39690KST350H7HF KT6215	K32
3860892	RHM40000KST350H7HF KT6215	K32
3860893	RHM41000KST350H7HF KT6215	K32
3860894	RHM41280KST350H7HF KT6215	K32
3860895	RHM42000KST350H7HF KT6215	K32
3861185	SS20KST175AR3M	K38
3861186	SS20KST200AR3M	K38
3861187	SS25KST250AR3M	K38
3861188	SS32KST300AR3M	K38
3861189	SS32KST350AR3M	K38
3861190	SS20KST175AR5M	K38
3861191	SS20KST200AR5M	K38
3861192	SS25KST250AR5M	K38
3861193	SS32KST300AR5M	K38
3861194	SS32KST350AR5M	K38
3861195	SS20KST175RR3M	K39
3861196	SS20KST200RR3M	K39
3861197	SS25KST250RR3M	K39
3861198	SS32KST300RR3M	K39
3861199	SS32KST350RR3M	K39
3861200	SS20KST175RR5M	K39
3861201	SS20KST200RR5M	K39
3861202	SS25KST250RR5M	K39
3861203	SS32KST300RR5M	K39
3861204	SS32KST350RR5M	K39
3861272	B977F03100 KC7315	G143
3861630	KST175200RK	K39
3861631	KST250250RK	K39
3861632	KST300350RK	K39
3861774	DNGA150416T02020 KYK10	B293
3861775	RNGN120400T02020 KYK10	B296
3861781	TPGN160312T02020 KYK10	B299
3862224	KST175200AS	K38
3862225	KST250250AS	K38
3862226	KST300350AS	K38
3864351	B292A06200YPL KC7315	G94
3865920	A4SBR2020K2S12016020	C115
3865921	A4SBR2020K2S12020025	C115
3865922	A4SBR2020K2S12025036	C115
3865923	A4SBR2020K3S14020025	C115
3865924	A4SBR2020K3S14025036	C115
3865926	A4SBR2020K4S14035048	C115
3865927	A4SBR2525M5S19028038	C115
3865928	A4SBR2525M5S19038058	C115
3865929	A4SBL2020K2S12016020	C115
3865931	A4SBL2020K2S12025036	C115
3865932	A4SBL2020K3S14020025	C115
3865934	A4SBL2020K4S14025035	C115
3865937	A4SBL2525M5S19038058	C115
3867457	A4M50R2S12B016020	C127
3867458	A4M50R2S12B020025	C127
3867459	A4M50R2S12B025036	C127
3867460	A4M50R3S14B020025	C127
3867461	A4M50R3S14B025036	C127
3867462	A4M50R4S14B025035	C127
3867464	A4M50R5S17B028038	C127
3867466	A4M50L2S12B016020	C128
3867467	A4M50L2S12B020025	C128
3867468	A4M50L2S12B025036	C128
3867469	A4M50L3S14B020025	C128
3867470	A4M50L3S14B025036	C128
3867472	A4M50L4S14B035048	C128
3867484	A4M50L5S17B028038	C128
3867715	B271Z03000HPS KN25	G74
3867716	B271Z03175HPS KN25	G74
3867717	B271Z03200HPS KN25	G74
3867718	B271Z03500HPS KN25	G74
3867719	B271Z03970HPS KN25	G74
3867720	B271Z04000HPS KN25	G74
3867721	B271Z04500HPS KN25	G74
3867722	B271Z04763HPS KN25	G74
3867753	B271Z05000HPS KN25	G74
3867754	B271Z05500HPS KN25	G74
3867755	B271Z06000HPS KN25	G74
3867756	B271Z06200HPS KN25	G74
3867757	B271Z06350HPS KN25	G74
3867758	B271Z06500HPS KN25	G75
3867759	B271Z06746HPS KN25	G75
3867760	B271Z07000HPS KN25	G75
3867761	B271Z07145HPS KN25	G75
3867762	B271Z07500HPS KN25	G75
3867763	B271Z08000HPS KN25	G75
3867765	B271Z08500HPS KN25	G75
3867766	B271Z08733HPS KN25	G75
3867767	B271Z09000HPS KN25	G75
3867768	B271Z09500HPS KN25	G75
3867769	B271Z09525HPS KN25	G75
3867770	B271Z10000HPS KN25	G75
3867771	B272Z03000HPS KN25	G76
3867772	B272Z03175HPS KN25	G76
3867803	B272Z03300HPS KN25	G76
3867804	B272Z03500HPS KN25	G76
3867805	B272Z03970HPS KN25	G76
3867806	B272Z04000HPS KN25	G76
3867807	B272Z04500HPS KN25	G76
3867808	B272Z04763HPS KN25	G76
3867809	B272Z05000HPS KN25	G76
3867810	B272Z05500HPS KN25	G76
3867811	B272Z06000HPS KN25	G76
3867812	B272Z06200HPS KN25	G76
3867813	B272Z06350HPS KN25	G76
3867814	B272Z06500HPS KN25	G76
3867815	B272Z06746HPS KN25	G76
3867816	B272Z07000HPS KN25	G77
3867817	B272Z07145HPS KN25	G77
3867818	B272Z07500HPS KN25	G77
3867819	B272Z08000HPS KN25	G77
3867820	B272Z08500HPS KN25	G77
3867821	B272Z08733HPS KN25	G77
3867822	B272Z09000HPS KN25	G77
3867823	B272Z09525HPS KN25	G77
3867824	B272Z09750HPS KN25	G77
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3867828	B274Z03000HPS KN25	G79
3867829	B274Z03175HPS KN25	G79
3867830	B274Z03500HPS KN25	G79
3867831	B274Z04000HPS KN25	G79
3867832	B274Z04500HPS KN25	G79
3867833	B273Z03000HPS KN25	G78
3867834	B273Z03175HPS KN25	G78
3867835	B273Z03500HPS KN25	G78
3867836	B273Z04000HPS KN25	G78
3867837	B273Z04500HPS KN25	G78
3867838	B273Z05000HPS KN25	G78
3867839	B273Z05500HPS KN25	G78
3867840	B273Z06000HPS KN25	G78
3867841	B273Z06350HPS KN25	G78
3867842	B273Z06500HPS KN25	G78
3867843	B273Z06746HPS KN25	G78
3867844	B273Z07000HPS KN25	G78
3867845	B273Z08000HPS KN25	G78
3867846	B273Z08500HPS KN25	G78
3867847	B273Z08733HPS KN25	G78
3867849	B273Z09525HPS KN25	G78
3867850	B273Z10000HPS KN25	G78
3867873	B274Z05000HPS KN25	G79
3867874	B274Z05500HPS KN25	G79
3867875	B274Z06000HPS KN25	G79
3867876	B274Z06350HPS KN25	G79
3867877	B274Z06500HPS KN25	G79
3867878	B274Z06746HPS KN25	G79
3867879	B274Z07000HPS KN25	G79
3867880	B274Z08000HPS KN25	G80
3867881	B274Z08500HPS KN25	G80
3867882	B274Z08733HPS KN25	G80
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3868079	T620M030X050R6HX-D1 KM6515	M6
3868080	T620M040X070R6HX-D1 KM6515	M6
3868081	T620M050X080R6HX-D1 KM6515	M6
3868082	T620M060X100R6HX-D1 KM6515	M6
3868093	T620M080X125R6HX-D1 KM6515	M6
3868094	T620M100X150R6HX-D1 KM6515	M6
3868095	T620M120X175R6HX-D6 KM6515	M6
3868096	T620M140X200R6HX-D6 KM6515	M6
3868097	T620M160X200R6HX-D6 KM6515	M6
3868099	T620M200X250R6HX-D6 KM6515	M6
3868110	T620MF080X100R6HX-D4 KM6515	M6
3868111	T620MF100X100R6HX-D4 KM6515	M6
3868114	T620MF120X150R6HX-D4 KM6515	M6
3868116	T620MF140X150R6HX-D4 KM6515	M6
3868117	T620MF160X150R6HX-D4 KM6515	M6
3868118	T620MF180X150R6HX-D4 KM6515	M6
3868174	T620M030X050R6HX-D1 KP6525	M6
3868175	T620M040X070R6HX-D1 KP6525	M6
3868176	T620M050X080R6HX-D1 KP6525	M6
3868177	T620M060X100R6HX-D1 KP6525	M6
3868178	T620M080X125R6HX-D1 KP6525	M6
3868179	T620M100X150R6HX-D1 KP6525	M6
3868180	T620M120X175R6HX-D6 KP6525	M6
3868181	T620M140X200R6HX-D6 KP6525	M6
3868182	T620M160X200R6HX-D6 KP6525	M6
3868204	T620M200X250R6HX-D6 KP6525	M6
3868215	T620MF080X100R6HX-D4 KP6525	M6
3868216	T620MF100X100R6HX-D4 KP6525	M6
3868217	T620MF100X125R6HX-D4 KP6525	M6
3868219	T620MF120X150R6HX-D4 KP6525	M6
3868221	T620MF140X150R6HX-D4 KP6525	M6
3868222	T620MF160X150R6HX-D4 KP6525	M6
3868223	T620MF180X150R6HX-D4 KP6525	M6
3868469	B291A04800YPL KC7315	G94
3868571	T630M030X050R6HX-D1 KP6525	M24
3868572	T630M040X070R6HX-D1 KP6525	M24
3868825	T630M030X050R6HX-D1 KM6515	M24
3868826	T630M040X070R6HX-D1 KM6515	M24
3868827	T630M050X080R6HX-D1 KM6515	M24
3868828	T630M060X100R6HX-D1 KM6515	M24
3868829	T630M080X125R6HX-D1 KM6515	M24
3868830	T630M100X150R6HX-D1 KM6515	M24
3868831	T630M120X175R6HX-D6 KM6515	M24
3868832	T630M140X200R6HX-D6 KM6515	M24
3868843	T630M160X200R6HX-D6 KM6515	M24
3868844	T630M180X250R6HX-D6 KM6515	M24
3868856	T630MF080X100R6HX-D4 KM6515	M24
3868857	T630MF100X100R6HX-D4 KM6515	M24
3868858	T630MF100X125R6HX-D4 KM6515	M24
3868860	T630MF120X150R6HX-D4 KM6515	M24
3868862	T630MF140X150R6HX-D4 KM6515	M24
3868863	T630MF160X150R6HX-D4 KM6515	M24
3868864	T630MF180X150R6HX-D4 KM6515	M24
3868923	T630M050X080R6HX-D1 KP6525	M24
3868924	T630M060X100R6HX-D1 KP6525	M24
3868925	T630M080X125R6HX-D1 KP6525	M24
3868926	T630M100X150R6HX-D1 KP6525	M24
3868927	T630M120X175R6HX-D6 KP6525	M24
3868928	T630M140X200R6HX-D6 KP6525	M24
3868929	T630M160X200R6HX-D6 KP6525	M24
3868930	T630M180X250R6HX-D6 KP6525	M24
3868933	T630M240X300R6HX-D6 KP6525	M28
3868942	T630MF080X100R6HX-D4 KP6525	M24
3868943	T630MF100X100R6HX-D4 KP6525	M24
3868944	T630MF100X125R6HX-D4 KP6525	M24
3868946	T630MF120X150R6HX-D4 KP6525	M24
3868948	T630MF140X150R6HX-D4 KP6525	M24
3868949	T630MF160X150R6HX-D4 KP6525	M24
3868950	T630MF180X150R6HX-D4 KP6525	M24
3868976	T631M050X080R6HX-D1 KP6525	M25
3868977	T631M060X100R6HX-D1 KP6525	M25
3868978	T631M080X125R6HX-D1 KP6525	M25
3868979	T631M100X150R6HX-D1 KP6525	M25
3868980	T631M120X175R6HX-D6 KP6525	M25
3868981	T631M140X200R6HX-D6 KP6525	M25
3868982	T631M160X200R6HX-D6 KP6525	M25
3868993	T631M180X250R6HX-D6 KP6525	M25
3869003	T631MF080X100R6HX-D4 KP6525	M25
3869004	T631MF100X100R6HX-D4 KP6525	M25
3869005	T631MF100X125R6HX-D4 KP6525	M25
3869006	T631MF120X125R6HX-D4 KP6525	M25
3869007	T631MF120X150R6HX-D4 KP6525	M25
3869008	T631MF140X125R6HX-D4 KP6525	M25
3869009	T631MF140X150R6HX-D4 KP6525	M25
3869010	T631MF160X150R6HX-D4 KP6525	M25
3869011	T631MF180X150R6HX-D4 KP6525	M25
3871002	A4G0205M2SU02GMN KCU10	C99
3871033	A16RA4SAL2S12M017021	C120
3871034	A20RA4SAL2S12M021026	C120
3871035	A25RA4SAL2S12M026036	C120
3871037	A25RA4SAL3S14M026036	C120
3871038	A16RA4SAR2S12M017021	C120
3871039	A20RA4SAR2S12M021026	C120
3871040	A25RA4SAR2S12M026036	C120
3871041	A20RA4SAR3S14M021026	C120
3871042	A25RA4SAR3S14M026036	C120
3871064	A4G0305M3SU04GMN KCU10	C99
3871065	A4G0405M4SU04GMN KCU10	C99
3871067	A4G0505M5SU04GMN KCU10	C99
3871069	A4G0200M2SP02GUP KCU10	C98
3871070	A4G0300M3SP02GUP KCU10	C98
3871071	A4G0300M3SP04GUP KCU10	C98
3871072	A4G0400M4SP04GUP KCU10	C98
3871073	A4G0400M4SP08GUP KCU10	C98
3871075	A4G0500M5SP08GUP KCU10	C98
3871076	A4G0205M2SU02GUP KCU10	C99
3871077	A4G0305M3SU02GUP KCU10	C99
3871078	A4G0305M3SU04GUP KCU10	C99
3871079	A4G0405M4SU04GUP KCU10	C99
3871081	A4G0505M5SU04GUP KCU10	C99
3871083	A4G0205M2SU02GMN KCU25	C99
3871084	A4G0305M3SU02GMN KCU25	C99
3871085	A4G0305M3SU04GMN KCU25	C99
3871086	A4G0405M4SU04GMN KCU25	C99
3871087	A4G0405M4SU08GMN KCU25	C99
3871088	A4G0505M5SU04GMN KCU25	C99
3871090	A4G0200M2SP02GUP KCU25	C98
3871091	A4G0300M3SP02GUP KCU25	C98

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
3871092	A4G0300M3SP04GUP KCU25	C98
3871105	A4G0500M5SP04GUP KCU25	C98
3871107	A4G0205M2SU02GUP KCU25	C99
3871108	A4G0305M3SU02GUP KCU25	C99
3871109	A4G0305M3SU04GUP KCU25	C99
3871110	A4G0405M4SU04GUP KCU25	C99
3871112	A4G0505M5SU04GUP KCU25	C99
3871114	A4G0505M5SU08GUP KCU25	C99
3871115	A4R0200M2SP00GMP KCU25	C99
3871116	A4R0300M3SP00GMP KCU25	C99
3871118	A4R0500M5SP00GMP KCU25	C99
3872075	WD50FDS40183M	H102
3872079	WD50FDS45206M	H102
3872564	B292A14200YPL KC7315	G96
3873005	B292A07600YPL KC7315	G95
3873028	B976A11800 KC7315	G141
3873438	50A05RS90SD12PLHF	V139
3873464	52A05RS90SD12PLHF	V139
3873467	63A06RS90SD12PLHF	V139
3873469	66A06RS90SD12PLHF	V139
3873520	80A07RS90SD12PLHF	V139
3873931	UDDE1400A5ASA KC643M	P31
3873932	UDDE1400A5ARA KC643M	P31
3874034	UDDE1400A5ARC KC643M	P31
3874035	UDDE1400A5ARD KC643M	P31
3874037	UDDE1400B5ARB KC643M	P31
3876021	B967A08700 KC7315	G133
3876314	CNGN120716T02020 KYK10	B295
3876315	CNGA120408T02020 KYK10	B292
3876316	CNGA120412T01020FW KYK10	B293
3876317	CNGA120412T02020 KYK10	B292
3876318	CNGA120412T02020FW KYK10	B293
3876319	CNGA120416T02020 KYK10	B292
3876328	SNGX120712T02020 KYK10	B297
3876329	SNGX120716T02020 KYK10	B297
3876331	TNGA160408T02020 KYK10	B294
3876333	WNGX080712T02020 KYK10	B298
3876334	SNGA120408T02020 KYK10	B293
3876843	CNGF120408 KB1340	B286
3877207	CFM0402R30RHP KCU40	H34
3877688	B272Z11000HPS KN25	G77
3877827	B967A11500 KC7315	G134
3878037	B292A09800YPL KC7315	G95
3878347	HSK63ASIF80063M	K46
3883100	RIQ06E1312 KC6305	K55
3884395	KSEM1250HPCCLM KC7410	H48
3884396	KSEM1300HPCCLM KC7410	H48, H87
3884397	KSEM1350HPCCLM KC7410	H48
3884398	KSEM1400HPCCLM KC7410	H48, H87
3884399	KSEM1450HPCCLM KC7410	H48
3884400	KSEM1500HPCCLM KC7410	H48, H87
3884401	KSEM1550HPCCLM KC7410	H48
3884402	KSEM1600HPCCLM KC7410	H48, H87
3884433	KSEM1650HPCCLM KC7410	H48
3884434	KSEM1700HPCCLM KC7410	H48, H87
3884435	KSEM1750HPCCLM KC7410	H48
3884436	KSEM1800HPCCLM KC7410	H48, H87
3884437	KSEM1850HPCCLM KC7410	H48
3884438	KSEM1900HPCCLM KC7410	H48, H87
3884439	KSEM1950HPCCLM KC7410	H48
3884440	KSEM2000HPCCLM KC7410	H48, H87
3884441	KSEM2050HPCCLM KC7410	H48
3884442	KSEM2100HPCCLM KC7410	H48, H87
3884443	KSEM2150HPCCLM KC7410	H48
3884444	KSEM2200HPCCLM KC7410	H48, H87
3884445	KSEM2250HPCCLM KC7410	H48
3884446	KSEM2300HPCCLM KC7410	H48, H87
3884447	KSEM2350HPCCLM KC7410	H48
3884448	KSEM2400HPCCLM KC7410	H48, H87
3884449	KSEM2450HPCCLM KC7410	H48
3884450	KSEM2500HPCCLM KC7410	H48, H87
3884451	KSEM2550HPCCLM KC7410	H48
3884452	KSEM2600HPCCLM KC7410	H48, H87
3884453	KSEM2650HPCCLM KC7410	H48
3884454	KSEM2700HPCCLM KC7410	H48, H87
3884455	KSEM2750HPCCLM KC7410	H48
3884456	KSEM2800HPCCLM KC7410	H49, H87
3884457	KSEM2850HPCCLM KC7410	H49
3884458	KSEM2900HPCCLM KC7410	H49, H87
3884459	KSEM2950HPCCLM KC7410	H49
3884460	KSEM3000HPCCLM KC7410	H49, H87
3884461	KSEM3050HPCCLM KC7410	H49
3884462	KSEM3100HPCCLM KC7410	H49, H87
3884463	KSEM3200HPCCLM KC7410	H49, H87
3884464	KSEM1270HPCCLM KC7410	H48
3884465	KSEM1293HPCCLM KC7410	H48
3884466	KSEM1310HPCCLM KC7410	H48
3884467	KSEM1389HPCCLM KC7410	H48
3884468	KSEM1429HPCCLM KC7410	H48
3884469	KSEM1468HPCCLM KC7410	H48
3884470	KSEM1548HPCCLM KC7410	H48
3884471	KSEM1588HPCCLM KC7410	H48
3884472	KSEM1609HPCCLM KC7410	H48
3884473	KSEM1627HPCCLM KC7410	H48
3884474	KSEM1667HPCCLM KC7410	H48
3884475	KSEM1707HPCCLM KC7410	H48
3884476	KSEM1746HPCCLM KC7410	H48
3884477	KSEM1826HPCCLM KC7410	H48
3884478	KSEM1905HPCCLM KC7410	H48
3884479	KSEM1927HPCCLM KC7410	H48
3884480	KSEM1945HPCCLM KC7410	H48
3884481	KSEM1984HPCCLM KC7410	H48
3884482	KSEM2024HPCCLM KC7410	H48
3884483	KSEM2064HPCCLM KC7410	H48
3884484	KSEM2143HPCCLM KC7410	H48
3884485	KSEM2223HPCCLM KC7410	H48
3884486	KSEM2244HPCCLM KC7410	H48
3884487	KSEM2342HPCCLM KC7410	H48
3884488	KSEM2381HPCCLM KC7410	H48
3884489	KSEM2461HPCCLM KC7410	H48
3884490	KSEM2540HPCCLM KC7410	H48
3884491	KSEM2567HPCCLM KC7410	H48
3884492	KSEM2619HPCCLM KC7410	H48
3884493	KSEM2659HPCCLM KC7410	H48
3884494	KSEM2778HPCCLM KC7410	H48
3884495	KSEM2818HPCCLM KC7410	H49
3884496	KSEM2858HPCCLM KC7410	H49
3884497	KSEM2937HPCCLM KC7410	H49
3884498	KSEM2977HPCCLM KC7410	H49
3884499	KSEM3016HPCCLM KC7410	H49
3884500	KSEM3175HPCCLM KC7410	H49
3884540	B291A06200YPL KC7315	G94
3884541	B291A11800YPL KC7315	G95
3884593	B291A15800YPL KC7315	G96
3884594	B291A19800YPL KC7315	G96
3884596	B291A05200YPL KC7315	G94
3884923	RCMT1204M0MP KCS10	B224
3885689	B707A03000FBL KCMS15	G114
3885690	B707A03175FBL KCMS15	G114
3885691	B707A03500FBL KCMS15	G114
3885692	B707A04000FBL KCMS15	G114
3885823	B707A04400FBL KCMS15	G114
3885824	B707A04500FBL KCMS15	G114
3885825	B707A04800FBL KCMS15	G114
3885826	B707A05000FBL KCMS15	G114
3885827	B707A05560FBL KCMS15	G114
3885828	B707A05900FBL KCMS15	G114
3885829	B707A06000FBL KCMS15	G114
3885830	B707A06350FBL KCMS15	G114
3885831	B707A06500FBL KCMS15	G114
3885832	B707A06800FBL KCMS15	G114
3885833	B707A07000FBL KCMS15	G114
3885834	B707A07500FBL KCMS15	G114
3885835	B707A07938FBL KCMS15	G114
3885836	B707A08000FBL KCMS15	G114
3885837	B707A08500FBL KCMS15	G114
3885838	B707A08800FBL KCMS15	G115
3885839	B707A09000FBL KCMS15	G115
3885840	B707A09500FBL KCMS15	G115
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3885847	B707A11509FBL KCMS15	G115
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3885850	B707A11800FBL KCMS15	G115
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3885862	B707A15500FBL KCMS15	G115
3885863	B707A15875FBL KCMS15	G115
3885864	B707A16000FBL KCMS15	G115
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3885866	B707A17000FBL KCMS15	G115
3885867	B707A17500FBL KCMS15	G115
3885868	B707A18000FBL KCMS15	G115
3885869	B707A19000FBL KCMS15	G115
3885870	B707A19050FBL KCMS15	G115
3885871	B707A20000FBL KCMS15	G115
3885872	B707A21000FBL KCMS15	G115
3886527	B292A13900YPL KC7315	G96
3890197	B967A07500 KC7315	G133
3891349	B272Z16000HPS KN25	G77
3891648	RPET1605M0SGE KCPK30	V79
3891649	RPET1605M0ELE KCPK30	V79
3891661	B271Z10200HPS KN25	G75
3891662	B271Z10500HPS KN25	G75
3891682	B271Z13500HPS KN25	G75
3891683	B271Z10720HPS KN25	G75
3891684	B271Z11000HPS KN25	G75
3891685	B271Z11500HPS KN25	G75
3891686	B271Z12000HPS KN25	G75
3891687	B271Z12500HPS KN25	G75
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3902171	B291A17900YPL KC7315	G96
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3902287	KM40TSNER4	D31
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3902293	KM40TSNSR2	D33
3902294	KM40TSNSR3	D33
3902295	KM40TSNSR4	D33
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3903995	B291A08600YPL KC7315	G95
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3904144	B291A03970YPL KC7315	G94
3904146	B291A04851YPL KC7315	G94
3904147	B291A04915YPL KC7315	G94
3904148	B291A05410YPL KC7315	G94
3904149	B291A06747YPL KC7315	G95
3904150	B291A07144YPL KC7315	G95
3904151	B291A07938YPL KC7315	G95
3904152	B291A08733YPL KC7315	G95
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3904155	B291A09700YPL KC7315	G95
3904156	B291A10716YPL KC7315	G95
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3904158	B291A11908YPL KC7315	G95
3904159	B291A12300YPL KC7315	G96
3904160	B291A14288YPL KC7315	G96
3904161	B291A15875YPL KC7315	G96
3904162	B291A16100YPL KC7315	G96
3904163	B291A17463YPL KC7315	G96

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
3904164	B291A17500YPL KC7315	G96
3904165	B291A19050YPL KC7315	G96
3904168	B292A03970YPL KC7315	G94
3904169	B292A04763YPL KC7315	G94
3904170	B292A04851YPL KC7315	G94
3904171	B292A04915YPL KC7315	G94
3904172	B292A08600YPL KC7315	G95
3904173	B292A08900YPL KC7315	G95
3904174	B292A09130YPL KC7315	G95
3904175	B292A09700YPL KC7315	G95
3904176	B292A11509YPL KC7315	G95
3904177	B292A11908YPL KC7315	G95
3904178	B292A12700YPL KC7315	G96
3904179	B292A14288YPL KC7315	G96
3904180	B292A15875YPL KC7315	G96
3904182	B292A17463YPL KC7315	G96
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3950220	WD32FDS36166M	H102
3950221	WD50FDS50228M	H102
3950222	WD50FDS56259M	H102
3950333	WD50FDS63289M	H102
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3950688	B291A05900YPL KC7315	G94
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3950854	KM40TSLSER22N	D85
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3950857	KM40TSLSSR16	D84
3950858	KM40TSLSSR22	D84
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3951836	KM40TSE16JNER2 KWH	D40
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3955464	KM40TSS10DLSER11	D86
3955465	KM40TSS12ELSEL11	D86
3955466	KM40TSS12ELSER11	D86
3955468	KM40TSS16FLSER16	D86
3955469	KM40TSS20GLSEL16	D86
3955470	KM40TSS20GLSER16	D86
3955471	KM40TSS25HLSEL16	D86
3955472	KM40TSS25HLSER16	D86
3955473	KM40TSS32JLSEL16	D86
3955474	KM40TSS32JLSER16	D86
3955475	KM40TSS32JLSEL22	D86
3955476	KM40TSS32JLSER22	D86
3955480	KM40TSS12ENEL2	D38–39
3955481	KM40TSS12ENER2	D38–39
3955482	KM40TSS16FNEL2	D38–39
3955483	KM40TSS16FNER2	D38–39
3955484	KM40TSS20GNEL2	D38–39
3955485	KM40TSS20GNER2	D38–39
3955486	KM40TSS25ENEL2	D38–39
3955487	KM40TSS25ENER2	D38–39
3955489	KM40TSS25HNER2	D38–39
3955490	KM40TSS25ENEL3	D38–39
3955491	KM40TSS25ENER3	D38–39
3955492	KM40TSS25HNEL3	D38–39
3955493	KM40TSS25HNER3	D38–39
3955495	KM40TSS32JNER3	D38–39
3955496	KM40TSS32GNEL3	D38–39
3955497	KM40TSS32GNER3	D38–39
3955980	B967A12700 KC7315	G134
3956013	B967A06000 KC7315	G132
3956014	B967A07000 KC7315	G133
3956017	B967A07400 KC7315	G133
3956018	B967A06700 KC7315	G133
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3958816	EDPT180512PDSRGE KCPK30	T75
3958876	EDPT180532PDSRGE KCPK30	T75
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3959401	KM40TSLSSR27	D84
3959611	EDCT10T302PDERLD KC725M	T35, T43
3959612	EDCT10T302PDERLD KCPK30	T35, T43
3959613	EDCT180512PDERLDJ KC422M	T73
3959614	EDCT180516PDERLDJ KC422M	T73
3959615	EDCT180532PDERLDJ KC422M	T73
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3964217	KDMB20M0ERGN KC505M	V118
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3964248	KDMB32M0ERHC KC530M	V118
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3964256	KDMT10R150A10HNC	V130
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3964259	KDMB08R150A10HN	V115
3964260	KDMB10R100A12HNC	V115
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3965922	KDMT1615SRHF K115M	V133
3965923	KDMT2020SRHF K115M	V133
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3967136	A4BHCL32K0217L	C122
3967137	A4BHCL32K0317L	C122
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3993991	KCI2	V153–154
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4003521	B966A17500 KC7315	G134
4003522	B966A18000 KC7315	G134
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4004752	100B15RF84SN12B3W	S103
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4004794	160C24RF84SN12B3W	S103
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4005706	LNUX191940RRP KCP25	E52
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4025498	63A07RS90RP12	V72
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4028922	B274Z02600KMS KN25	G79
4028923	B274Z02642KMS KN25	G79
4028925	B274Z02779KMS KN25	G79
4028926	B274Z02800KMS KN25	G79
4028928	B274Z02870KMS KN25	G79
4028929	B274Z02900KMS KN25	G79
4028930	B274Z02947KMS KN25	G79
4029315	HNPJ130720ANSNGD KC725M	S26
4029316	HNPJ130720ANSNGD KCPK30	S26
4032304	UEBE0200A3A KC643M	P195
4032305	UEBE0300A3A KC643M	P195
4032306	UEBE0400A3A KC643M	P195
4032307	UEBE0500A3A KC643M	P195
4032308	UEBE0600A3A KC643M	P195
4032309	UEBE0800A3A KC643M	P195
4032310	UEBE1000A3A KC643M	P195
4032311	UEBE1200A3A KC643M	P195
4032783	UEDE0200A3AS KC643M	P192
4032784	UEDE0300A3AS KC643M	P192
4032785	UEDE0400A3AS KC643M	P192
4032786	UEDE0500A3AS KC643M	P192
4032787	UEDE0600A3AS KC643M	P192
4032788	UEDE0800A3AS KC643M	P192
4032789	UEDE1000A3AS KC643M	P192
4032790	UEDE1200A3AS KC643M	P192
4032791	UEDE0200B3AS KC643M	P192
4032792	UEDE0300B3AS KC643M	P192
4032793	UEDE0400B3AS KC643M	P192
4032794	UEDE0500B3AS KC643M	P192
4032795	UEDE0600B3AS KC643M	P192
4032796	UEDE0800B3AS KC643M	P192
4032797	UEDE1000B3AS KC643M	P192
4032798	UEDE1200B3AS KC643M	P192
4032802	UEDE0400A4AH KC643M	P193
4032813	UEDE0600A4AH KC643M	P193
4032814	UEDE0800A4AH KC643M	P193
4032815	UEDE1000A4AH KC643M	P193
4032816	UEDE1200A4AH KC643M	P193
4032817	UEDE0400B4AH KC643M	P193
4032820	UEDE0600B4AH KC643M	P193
4032821	UEDE0800B4AH KC643M	P193
4032822	UEDE1000B4AH KC643M	P193
4032823	UEDE1200B4AH KC643M	P193

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
4033713	B707A12700FBS KN15	G115
4033714	B707A12700FBL KCMS15	G115
4033829	NA4L8 KCU25	D12
4033830	NA4R4 KCU25	D12
4033833	NA6L2 KCU25	D12
4033834	NA6L25 KCU25	D12
4033835	NA6L3 KCU25	D12
4033836	NA6R2 KCU25	D12
4033838	NA6R3 KCU25	D12
4033841	ND4050R KCU25	D14
4033845	NDC38RDL75 KCU25	D15
4033846	NDC38RDR75 KCU25	D15
4033852	NG1031L KCU25	C155
4033853	NG1047L KCU25	C155
4033854	NG1062L KCU25	C155
4033855	NG1094L KCU25	C155
4033856	NG5312R KCU25	C154
4033858	NG6375R KCU25	C154
4033859	NT1L KCU25	D25
4033863	NTB3RB KCU25	D20
4033872	NTC3R12E KCU25	D22
4033877	NTC3R18E KCU25	D22
4033882	NTU4R KCU25	D24
4033883	NU3094L KCU25	C161
4033886	NU3125R KCU25	C161
4033887	NV3RJ KCU25	C162
4033888	NV4LL KCU25	C162
4033889	NV4RL KCU25	C162
4033892	NWC3R14E KCU25	D25
4034717	A4G0200M02P02GMP KCU10	C95
4034718	A4G0205M02U02GMN KCU10	C96
4034720	A4G0250M2BP02GMP KCU10	C95
4034721	A4G0300M03P02GMP KCU10	C95
4034722	A4G0300M03P04GMP KCU10	C95
4034773	A4G0305M03U02GMN KCU10	C96
4034774	A4G0305M03U02GMP KCU10	C95
4034775	A4G0305M03U04GMN KCU10	C96
4034776	A4G0305M03U04GMP KCU10	C95
4034777	A4G0400M04P02GMP KCU10	C95
4034778	A4G0400M04P04GMP KCU10	C95
4034779	A4G0400M04P08GMP KCU10	C95
4034780	A4G0405M04U04GMN KCU10	C96
4034781	A4G0405M04U04GMP KCU10	C95
4034782	A4G0405M04U08GMN KCU10	C96
4034784	A4G0500M05P04GMP KCU10	C95
4034785	A4G0500M05P08GMP KCU10	C95
4034786	A4G0505M05U04GMN KCU10	C96
4034787	A4G0505M05U04GMP KCU10	C95
4034788	A4G0505M05U08GMN KCU10	C96
4034790	A4G0600M06P04GMP KCU10	C95
4034791	A4G0600M06P08GMP KCU10	C95
4034792	A4G0605M06U04GMN KCU10	C96
4034794	A4G0605M06U08GMN KCU10	C96
4034799	A4G0800M08P12GMP KCU10	C95
4034800	A4G0805M08U08GMN KCU10	C96
4034802	A4G094I2BP05GMN KCU10	C97
4034805	A4G1005M10U08GMP KCU10	C95
4034806	A4G125I03P05GMN KCU10	C97
4034807	A4G125I03P1GMN KCU10	C97
4034808	A4G187I04P1GMN KCU10	C97
4034809	A4G187I04P2GMN KCU10	C97
4034810	A4G250I06P1GMN KCU10	C97
4034811	A4G250I06P2GMN KCU10	C97
4034812	A4G375I10P2GMN KCU10	C97
4034813	A4R0200M02P00GMP KCU10	C96
4034815	A4R0300M03P00GMP KCU10	C96
4034816	A4R0305M03U00GMN KCU10	C97
4034817	A4R0400M04P00GMP KCU10	C96
4034818	A4R0405M04U00GMN KCU10	C97
4034819	A4R0500M05P00GMP KCU10	C96
4034820	A4R0505M05U00GMN KCU10	C97
4034821	A4R0600M06P00GMP KCU10	C96
4034822	A4R0605M06U00GMN KCU10	C97
4034823	A4R0800M08P00GMP KCU10	C96
4034824	A4R0805M08U00GMN KCU10	C97
4034825	A4R1005M10U00GMN KCU10	C97
4034826	A4R125I03P00GMN KCU10	C97
4034827	A4R187I04P00GMN KCU10	C97
4034828	A4R250I06P00GMN KCU10	C97
4034829	A4R312I08P00GMN KCU10	C97
4034878	WOEJ090512SRHD KC522M	V41
4034880	WOEJ090512SRHD KC725M	V41
4034881	WOEJ090512SRHD KCPK30	V41
4034882	WOEJ090512SRGD KC522M	V41
4034925	WOEJ090512SRGD KC725M	V41
4034927	WOEJ090512SRGD KCPK30	V41
4035459	T640M040X070R6HX-D1 KP6525	M63
4035460	T640M050X080R6HX-D1 KP6525	M63
4035461	T640M060X100R6HX-D1 KP6525	M63
4035462	T640M080X125R6HX-D1 KP6525	M63
4035463	T640M100X150R6HX-D1 KP6525	M63
4035464	T640M120X175R6HX-D6 KP6525	M63
4035465	T640M140X200R6HX-D6 KP6525	M63
4035466	T640M160X200R6HX-D6 KP6525	M63
4035467	T640M180X250R6HX-D6 KP6525	M63
4035468	T640M200X250R6HX-D6 KP6525	M63
4035469	T640M220X250R6HX-D6 KP6525	M63
4035525	T641M050X080R6HX-D1 KP6525	M64
4035526	T641M060X100R6HX-D1 KP6525	M64
4035527	T641M080X125R6HX-D1 KP6525	M64
4035528	T641M100X150R6HX-D1 KP6525	M64
4035529	T641M120X175R6HX-D6 KP6525	M64
4035530	T641M140X200R6HX-D6 KP6525	M64
4035531	T641M160X200R6HX-D6 KP6525	M64
4035532	T641M180X250R6HX-D6 KP6525	M64
4035533	T641M200X250R6HX-D6 KP6525	M64
4035585	RCMX3209M0RU KCP10	E61
4035586	RCMX3209M0RU KCK20	E61
4035593	RCMX2507M0RU KCK20	E61
4035595	RCMH2507M0RU KCP25	E60
4035698	LNUX191940RRF KCP10	E51
4036621	RPGN090300E KYSP30	V155
4036916	LNUX191940RRF KCP25	E51
4038003	LNPU2410ANSRHD KCPK30	S117
4038004	LNPU2410ANSRHD KCK15	S117
4038005	LNPU2410ANSRHD KC725M	S117
4039608	SM-906 KC720	S116, S120, S122
4039774	MS2236	V114–115
4040133	SPGX070308MD KCU25	J89
4040135	SPGX070308HP KCU25	J89
4040138	SPPX09T310MD KCU25	J89
4040139	SPPX120412MD KCU25	J89
4040141	SPPX120412HP KCU25	J89
4040142	SPPX15T512MD KCU25	J89
4040758	RPET1204M0ELEJ KC422M	V73
4040905	KCI3M	V153–154
4040931	MEGA45D125B06LN24	S116
4040932	MEGA45D160C07LN24	S116
4040954	MEGA45D250C11LN24	S116
4040955	MEGA45D315C13LN24	S116
4042332	KSHRHF50A04RS15HN09	S17
4042533	KSHRHF63A05RS15HN09	S17
4042534	KSHRHF80A06RS15HN09	S17
4042535	KSHRHF100B08RS15HN09	S17
4042536	KSHRHF125B09RS15HN09	S17
4042537	KSHRHF160C12RS15HN09	S17
4042538	B976Z02383 KC7315	G138
4042539	B976Z02400 KC7315	G138
4042540	B976Z02439 KC7315	G138
4042541	B976Z02489 KC7315	G138
4042542	B976Z02500 KC7315	G138
4042543	B976Z02578 KC7315	G138
4042544	B976Z02600 KC7315	G138
4042545	B976Z02642 KC7315	G138
4042546	B976Z02705 KC7315	G138
4042547	B976Z02779 KC7315	G138
4042548	B976Z02800 KC7315	G138
4042549	B976Z02820 KC7315	G138
4042550	B976Z02870 KC7315	G138
4042551	B976Z02900 KC7315	G138
4042552	B976Z02947 KC7315	G138
4042581	40E03R045M16RP16	V77
4042582	40E02R040A32RP16L200	V77
4042693	52A04RS90RP16	V78
4042694	63A04RS90RP16	V78
4042695	63A06RS90RP16	V78
4042696	80A05RS90RP16	V78
4042697	80A07RS90RP16	V78
4042698	100B06RS90RP16	V78
4042699	100B08RS90RP16	V78
4042700	125B09RS90RP16	V78
4042840	SPGX070308FP KCU25	J90
4042841	SPPX09T310FP KCU25	J90
4042842	SPPX09T310HP KCU25	J89
4042887	SPGX070308FP KCPK10	J90
4042888	SPGX070308MD KCPK10	J89
4042889	SPGX070308HP KCPK10	J89
4042890	SPPX09T310FP KCPK10	J90
4042891	SPPX09T310MD KCPK10	J89
4042892	SPPX09T310HP KCPK10	J89
4042903	SPPX120412FP KCPK10	J90
4042904	SPPX120412MD KCPK10	J89
4042905	SPPX120412HP KCPK10	J89
4042906	SPPX15T512FP KCPK10	J90
4042907	SPPX15T512MD KCPK10	J89
4042908	SPPX15T512HP KCPK10	J89
4042913	SPPX120412FP KCU25	J90
4042914	SPPX15T512FP KCU25	J90
4042915	SPPX15T512HP KCU25	J89
4042933	SPGX070308FP KCU40	J90
4042934	SPGX070308MD KCU40	J89
4042935	SPGX070308HP KCU40	J89
4042936	SPPX09T310FP KCU40	J90
4042937	SPPX09T310MD KCU40	J89
4042938	SPPX09T310HP KCU40	J89
4042939	SPPX120412FP KCU40	J90
4042940	SPPX120412MD KCU40	J89
4042941	SPPX120412HP KCU40	J89
4042942	SPPX15T512FP KCU40	J90
4042943	SPPX15T512MD KCU40	J89
4042944	SPPX15T512HP KCU40	J89
4043046	32E03R045M16RP12	V70
4043047	40E04R045M16RP12	V70
4043048	32A03R040B32RP12	V70
4043049	32A03R040A32RP12L190	V71
4043050	40A04RS90RP12	V72
4043051	50A04RS90RP12	V72
4043052	50A05RS90RP12	V72
4043063	63A05RS90RP12	V72
4043064	80A06RS90RP12	V72
4043065	100B07RS90RP12	V72
4044264	B532A07200SPF KDF400	G105
4044820	TCGT110201LF KCU10	B243
4044821	TCGT110204HP KCU10	B243
4044822	TCGT110204LF KCU10	B243
4045101	VNGG160402LF KCU10	B143
4045102	VNGG160404LF KCU10	B143
4045134	CCGT060202HP KCU10	B175
4045135	CCGT060202LF KCU10	B175
4045136	CCGT060201LF KCU10	B175
4045137	CCGT060204HP KCU10	B175
4045138	CCGT060204LF KCU10	B175
4045140	CCGT060208LF KCU10	B175
4045141	CCGT09T302HP KCU10	B175
4045142	CCGT09T302LF KCU10	B175
4045143	VNGG160408LF KCU10	B143
4045144	VNGG220408LF KCU10	B143
4045145	VNGP160401 KCU10	B143
4045146	VNGP160402 KCU10	B143
4045147	VNGP220404 KCU10	B143
4045148	VNGP220408 KCU10	B143
4045149	VNMG160404FF KCU10	B145
4045150	VNMG160404MP KCU10	B146
4045151	VNMG160404P KCU10	B146
4045163	VNMG160408FF KCU10	B145
4045164	VNMG160408MP KCU10	B146
4045166	VNMG160408P KCU10	B146
4045167	VNMG160408RP KCU10	B147
4045168	VNMG160408UP KCU10	B147
4045169	VNMG160412MP KCU10	B146
4045170	WNGG080402LF KCU10	B154
4045172	WNGG080404LF KCU10	B154
4045174	WNMG060404FW KCU10	B156
4045175	WNMG060404MP KCU10	B157
4045176	WNMG060408FW KCU10	B156
4045177	WNMG060408MP KCU10	B157
4045178	WNMG060408RP KCU10	B159
4045179	WNMG080404FW KCU10	B156
4045180	WNMG080404P KCU10	B158
4045181	WNMG080408FW KCU10	B156
4045182	WNMG080408MP KCU10	B157
4045184	WNMG080408P KCU10	B158
4045185	WNMG080408RP KCU10	B159
4045186	WNMG080408UP KCU10	B160
4045187	WNMG080412MP KCU10	B157
4045188	WNMG080412RP KCU10	B159
4045189	WNMG080412UP KCU10	B160
4045193	CCGT09T301LF KCU10	B175
4045194	CCGT09T304HP KCU10	B175
4045195	CCGT09T304LF KCU10	B175
4045196	CCGT09T308HP KCU10	B175
4045197	CCGT09T308LF KCU10	B175
4045198	CCGT120402HP KCU10	B175
4045199	CCGT120404HP KCU10	B175
4045200	CCGT120408HP KCU10	B175
4045202	CCMT060204FW KCU10	B176
4045204	CCMT09T304FW KCU10	B176
4045205	CCMT09T304MW KCU10	B178
4045206	CCMT09T308FW KCU10	B176
4045207	CCMT09T308MW KCU10	B178
4045210	CPGH09T301 KCU10	B188
4045211	CPGH09T302 KCU10	B188
4045212	CPGH09T304 KCU10	B188
4045213	CPGH09T308 KCU10	B188
4045214	CPGT060202HP KCU10	B188
4045215	CPGT060202LF KCU10	B189
4045216	CPGT060201LF KCU10	B189
4045217	CPGT060204HP KCU10	B188
4045218	CPGT060204LF KCU10	B189
4045220	CPGT060208LF KCU10	B189
4045221	CPGT09T302HP KCU10	B188
4045222	CPGT09T302LF KCU10	B189
4045223	CPGT09T304HP KCU10	B188
4045224	CPGT09T304LF KCU10	B189
4045225	CPGT09T308HP KCU10	B188
4045226	CPGT09T308LF KCU10	B189
4045228	CPMT060204FW KCU10	B189
4045229	CPMT060208FW KCU10	B189
4045231	CPMT09T304MW KCU10	B191
4045232	CPMT09T308FW KCU10	B189
4045237	DCGT070202HP KCU10	B206
4045238	DCGT070201LF KCU10	B206
4045239	DCGT070204HP KCU10	B206
4045240	DCGT070208HP KCU10	B206
4045241	DCGT11T302HP KCU10	B206
4045242	DCGT11T301LF KCU10	B206
4045245	DCGR150404 KCU10	E28
4045246	DCGR150408 KCU10	E28
4045248	KCGR110304L08 KCU10	E29
4045249	KCGR110304R08 KCU10	E29
4045250	KCGR110308L08 KCU10	E29
4045251	KCGR110308R08 KCU10	E29
4045263	DCGT11T304HP KCU10	B206
4045264	DCGT11T308HP KCU10	B206
4045265	DCGT150408LF KCU10	B206
4045266	DCMT11T304FW KCU10	B207
4045267	DCMT11T304MW KCU10	B208
4045268	DCMT11T308FW KCU10	B207
4045269	DCMT11T308LF KCU10	B207
4045270	DCMT11T308MW KCU10	B208
4045272	DPGT070202LF KCU10	B214
4045274	DPGT070204HP KCU10	B214
4045275	DPGT070204LF KCU10	B214
4045277	DPGT11T302LF KCU10	B214
4045279	DPGT11T304HP KCU10	B214
4045280	DPGT11T304LF KCU10	B214
4045281	DPGT11T308HP KCU10	B214
4045282	DPGT11T308LF KCU10	B214
4045283	DPMT070208FW KCU10	B215
4045284	RCGT10T3M0HP KCU10	B222
4045285	RCGT1204M0HP KCU10	B222
4045286	RCMT0602M0 KCU10	B224
4045288	RCMT10T3M0 KCU10	B224
4045289	RCMT1204M0 KCU10	B224
4045290	RCMT1605M0 KCU10	B224
4045291	RCMT2006M0 KCU10	B224
4045292	RCMT060200 KCU10	B224
4045293	RCMT09T300 KCU10	B224
4045294	SPGT09T304LF KCU10	B238
4045295	SPGT09T308LF KCU10	B238
4045316	TCGT16T304HP KCU10	B243
4045317	TCGT16T304LF KCU10	B243
4045318	TCGT16T308HP KCU10	B243
4045319	TCGT16T308LF KCU10	B243
4045321	TPGT090202LF KCU10	B254
4045322	TPGT090204LF KCU10	B254
4045323	TPGT110202HP KCU10	B254

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
4045324	TPGT110202LF KCU10	B254
4045325	TPGT110201LF KCU10	B254
4045327	TPGT110204LF KCU10	B254
4045329	TPGT110208LF KCU10	B254
4045330	TPGT16T302HP KCU10	B254
4045331	TPGT16T304HP KCU10	B254
4045333	TPGT16T308HP KCU10	B254
4045334	TPGT16T308LF KCU10	B254
4045335	VBGT110302HP KCU10	B264
4045336	VBGT110302LF KCU10	B264
4045337	VBGT110301LF KCU10	B264
4045338	VBGT110304HP KCU10	B264
4045339	VBGT110304LF KCU10	B264
4045340	VBGT160402LF KCU10	B264
4045341	VBGT160401LF KCU10	B264
4045342	VBGT160404HP KCU10	B264
4045343	VBGT160404LF KCU10	B264
4045344	VBGT160408HP KCU10	B264
4045345	WPGTS30102UF KCU10	B272
4045346	WPGTS30101UF KCU10	B272
4045347	WPGT040202UF KCU10	B272
4045406	KNGX220408L20 KCU10	E30
4045409	KCGX110302L15 KCU10	E31
4045410	KCGX110304L15 KCU10	E31
4045412	KNGX150401R15 KCU10	E30
4045413	KNGX150402R15 KCU10	E30
4045415	KNGX150408R20 KCU10	E30
4045416	KNGX220408R32 KCU10	E30
4045417	KCGX110301R15 KCU10	E31
4045418	KCGX110302R15 KCU10	E31
4045419	KCGX110304R15 KCU10	E31
4045420	KCGX110308R15 KCU10	E31
4045425	VCMR160408 KCU10	E33
4045426	VCGR160402 KCU10	E34
4045427	VCGR160404 KCU10	E34
4045428	VCGR160408 KCU10	E34
4045429	VCGR160412 KCU10	E34
4045430	VCGR160416 KCU10	E34
4046029	F4BS0600AWM38R050 KCPM15	P19
4046030	F4BS0600AWM38R100 KCPM15	P19
4046031	F4BS0800AWM38R050 KCPM15	P19
4046032	F4BS0800AWM38R100 KCPM15	P19
4046063	B291A04763YPL KC7315	G94
4046064	B291A11113YPL KC7315	G95
4046234	F4AS0600AWM38R050 KCPM15	P18
4046235	F4AS0600AWM38R100 KCPM15	P18
4046236	F4AS0600BWM38R050 KCPM15	P18
4046237	F4AS0600BWM38R100 KCPM15	P18
4046238	F4AS0800AWM38R050 KCPM15	P18
4046239	F4AS0800AWM38R100 KCPM15	P18
4046240	F4AS0800BWM38R050 KCPM15	P18
4046241	F4AS0800BWM38R100 KCPM15	P18
4046242	F4AS1000AWL38R050 KCPM15	P18
4046263	F4AS0400ADL38 KCPM15	P16
4046264	F4AS0400BDL38 KCPM15	P16
4046265	F4AS0500ADL38 KCPM15	P16
4046266	F4AS0500BDL38 KCPM15	P16
4046267	F4AS0600ADL38 KCPM15	P16
4046268	F4AS0600BDL38 KCPM15	P16
4046269	F4AS0800ADL38 KCPM15	P16
4046270	F4AS0800BDL38 KCPM15	P16
4046271	F4AS1000ADL38 KCPM15	P16
4046272	F4AS1000BDL38 KCPM15	P16
4046273	F4AS1200ADL38 KCPM15	P16
4046274	F4AS1200BDL38 KCPM15	P16
4046275	F4AS1400BDL38 KCPM15	P16
4046276	F4AS1600ADL38 KCPM15	P16
4046277	F4AS1600BDL38 KCPM15	P16
4046278	F4AS1800ADL38 KCPM15	P16
4046279	F4AS1800BDL38 KCPM15	P16
4046280	F4AS2000ADL38 KCPM15	P16
4046281	F4AS2000BDL38 KCPM15	P16
4046282	F4AS2500ADL38 KCPM15	P16
4046283	F4AS2500BDL38 KCPM15	P16
4046284	UCDE0400A5ARA KCPM15	P30
4046285	UCDE0400A5ASA KCPM15	P30
4046286	UCDE0400B5ARA KCPM15	P30
4046288	UCDE0500A5ARA KCPM15	P30
4046289	UCDE0500A5ASA KCPM15	P30
4046290	UCDE0500B5ARA KCPM15	P30
4046291	UCDE0600A5ARA KCPM15	P30
4046292	UCDE0600A5ASA KCPM15	P30
4046303	F4BS1000AWL38R050 KCPM15	P19
4046304	F4BS1000AWL38R100 KCPM15	P19
4046305	F4BS1000AWL38R200 KCPM15	P19
4046306	F4BS1000AWL38R300 KCPM15	P19
4046307	F4BS1000AWL38R400 KCPM15	P19
4046308	F4BS1200AWL38R050 KCPM15	P19
4046309	F4BS1200AWL38R100 KCPM15	P19
4046310	F4BS1200AWL38R200 KCPM15	P19
4046311	F4BS1200AWL38R300 KCPM15	P19
4046312	F4BS1200AWL38R400 KCPM15	P19
4046313	F4BS1600AWX38R050 KCPM15	P19
4046314	F4BS1600AWX38R100 KCPM15	P19
4046315	F4BS1600AWX38R200 KCPM15	P19
4046316	F4BS1600AWX38R300 KCPM15	P19
4046317	F4BS1600AWX38R400 KCPM15	P19
4046318	F4BS2000AWX38R050 KCPM15	P19
4046319	F4BS2000AWX38R100 KCPM15	P19
4046320	F4BS2000AWX38R200 KCPM15	P19
4046321	F4BS2000AWX38R300 KCPM15	P19
4046322	F4BS2000AWX38R400 KCPM15	P19
4046323	F4BS2500AWX38R050 KCPM15	P19
4046324	F4BS2500AWX38R100 KCPM15	P19
4046325	F4BS2500AWX38R200 KCPM15	P19
4046326	F4BS2500AWX38R300 KCPM15	P19
4046327	F4BS2500AWX38R400 KCPM15	P19
4046328	F4BS0600BWM38R050 KCPM15	P19
4046329	F4BS0600BWM38R100 KCPM15	P19
4046330	F4BS0800BWM38R050 KCPM15	P19
4046331	F4BS0800BWM38R100 KCPM15	P19
4046332	F4BS1000BWL38R050 KCPM15	P19
4046333	F4BS1000BWL38R100 KCPM15	P19
4046334	F4BS1000BWL38R200 KCPM15	P19
4046335	F4BS1000BWL38R300 KCPM15	P19
4046336	F4BS1000BWL38R400 KCPM15	P19
4046337	F4BS1200BWL38R050 KCPM15	P19
4046338	F4BS1200BWL38R100 KCPM15	P19
4046339	F4BS1200BWL38R200 KCPM15	P19
4046340	F4BS1200BWL38R300 KCPM15	P19
4046341	F4BS1200BWL38R400 KCPM15	P19
4046342	F4BS1600BWX38R050 KCPM15	P19
4046343	F4BS1600BWX38R100 KCPM15	P19
4046344	F4BS1600BWX38R200 KCPM15	P19
4046345	F4BS1600BWX38R300 KCPM15	P19
4046346	F4BS1600BWX38R400 KCPM15	P19
4046347	F4BS2000BWX38R050 KCPM15	P19
4046348	F4BS2000BWX38R100 KCPM15	P19
4046349	F4BS2000BWX38R200 KCPM15	P19
4046350	F4BS2000BWX38R300 KCPM15	P19
4046351	F4BS2000BWX38R400 KCPM15	P19
4046352	F4BS2500BWX38R050 KCPM15	P19
4046353	F4BS2500BWX38R100 KCPM15	P19
4046354	F4BS2500BWX38R200 KCPM15	P19
4046355	F4BS2500BWX38R300 KCPM15	P19
4046356	F4BS2500BWX38R400 KCPM15	P19
4046357	F3AS0300BDK35 KCPM15	P102
4046358	F3AS0400BDK35 KCPM15	P102
4046359	F3AS0500BDK35 KCPM15	P102
4046360	F3AS0600BDK35 KCPM15	P102
4046361	F3AS0800BDK35 KCPM15	P102
4046362	F3AS1000BDK35 KCPM15	P102
4046363	F4AS1000AWL38R100 KCPM15	P18
4046364	F4AS1000AWL38R200 KCPM15	P18
4046365	F4AS1000AWL38R300 KCPM15	P18
4046366	F4AS1000AWL38R400 KCPM15	P18
4046367	F4AS1000BWL38R050 KCPM15	P18
4046368	F4AS1000BWL38R100 KCPM15	P18
4046369	F4AS1000BWL38R200 KCPM15	P18
4046370	F4AS1000BWL38R300 KCPM15	P18
4046371	F4AS1000BWL38R400 KCPM15	P18
4046372	F4AS1200AWL38R050 KCPM15	P18
4046373	UCDE0600B5ARA KCPM15	P30
4046374	UCDE0700A5ARA KCPM15	P30
4046375	UCDE0700A5ASA KCPM15	P30
4046376	UCDE0700B5ARA KCPM15	P30
4046377	UCDE0800A5ARA KCPM15	P30
4046378	UCDE0800A5ASA KCPM15	P30
4046379	UCDE0800B5ARA KCPM15	P30
4046380	UCDE0900A5ARA KCPM15	P30
4046381	UCDE0900A5ASA KCPM15	P30
4046382	UCDE0900B5ARA KCPM15	P30
4046383	UCDE1000A5ARA KCPM15	P30
4046384	UCDE1000A5ASA KCPM15	P30
4046385	UCDE1000B5ARA KCPM15	P30
4046386	UCDE1200A5ARA KCPM15	P30
4046387	UCDE1200A5ASA KCPM15	P30
4046388	UCDE1200B5ARA KCPM15	P30
4046389	UCDE1400A5ARA KCPM15	P30
4046390	UCDE1400A5ASA KCPM15	P30
4046391	UCDE1400B5ARA KCPM15	P30
4046392	UCDE1600A5ARA KCPM15	P30
4046393	UCDE1600A5ASA KCPM15	P30
4046394	UCDE1600B5ARA KCPM15	P30
4046395	UCDE1800A5ARA KCPM15	P30
4046396	UCDE1800A5ASA KCPM15	P30
4046397	UCDE1800B5ARA KCPM15	P30
4046398	UCDE2000A5ARA KCPM15	P30
4046399	UCDE2000A5ASA KCPM15	P30
4046400	UCDE2000B5ARA KCPM15	P30
4046401	UCDE2500A5ARA KCPM15	P30
4046402	UCDE2500A5ASA KCPM15	P30
4046403	UCDE2500B5ARA KCPM15	P30
4046413	F4AS1200AWL38R100 KCPM15	P18
4046414	F4AS1200AWL38R200 KCPM15	P18
4046415	F4AS1200AWL38R300 KCPM15	P18
4046416	F4AS1200AWL38R400 KCPM15	P18
4046417	F4AS1200BWL38R050 KCPM15	P18
4046418	F4AS1200BWL38R100 KCPM15	P18
4046419	F4AS1200BWL38R200 KCPM15	P18
4046420	F4AS1200BWL38R300 KCPM15	P18
4046421	F4AS1200BWL38R400 KCPM15	P18
4046422	F4AS1600AWX38R050 KCPM15	P18
4046423	F4AS1600AWX38R100 KCPM15	P18
4046424	F4AS1600AWX38R200 KCPM15	P18
4046425	F4AS1600AWX38R300 KCPM15	P18
4046426	F4AS1600AWX38R400 KCPM15	P18
4046427	F4AS1600BWX38R050 KCPM15	P18
4046428	F4AS1600BWX38R100 KCPM15	P18
4046429	F4AS1600BWX38R200 KCPM15	P18
4046430	F4AS1600BWX38R300 KCPM15	P18
4046431	F4AS1600BWX38R400 KCPM15	P18
4046432	F4AS2000AWX38R050 KCPM15	P18
4046433	F4AS2000AWX38R100 KCPM15	P18
4046434	F4AS2000AWX38R200 KCPM15	P18
4046435	F4AS2000AWX38R300 KCPM15	P18
4046436	F4AS2000AWX38R400 KCPM15	P18
4046437	F4AS2000BWX38R050 KCPM15	P18
4046438	F4AS2000BWX38R100 KCPM15	P18
4046439	F4AS2000BWX38R200 KCPM15	P18
4046440	F4AS2000BWX38R300 KCPM15	P18
4046441	F4AS2000BWX38R400 KCPM15	P18
4046442	F4AS2500AWX38R050 KCPM15	P18
4046443	F4AS2500AWX38R100 KCPM15	P18
4046444	F4AS2500AWX38R200 KCPM15	P18
4046446	F4AS2500AWX38R400 KCPM15	P18
4046447	F4AS2500BWX38R050 KCPM15	P18
4046449	F4AS2500BWX38R200 KCPM15	P18
4046450	F4AS2500BWX38R300 KCPM15	P18
4046451	F4AS2500BWX38R400 KCPM15	P18
4046452	F3AW0600AWL35E120 KCPM15	P103
4046453	F3AS1200BDK35 KCPM15	P102
4046454	F3AS1400BDK35 KCPM15	P102
4046455	F3AS1600BDK35 KCPM15	P102
4046457	F3AS2000BDK35 KCPM15	P102
4046458	F3BH0400BDL30 KCPM15	P81
4046459	F3BH0500BDL30 KCPM15	P81
4046460	F3BH0600BDL30 KCPM15	P81
4046461	F3BH0800BDL30 KCPM15	P81
4046462	F3BH1000BDL30 KCPM15	P81
4046463	F3BH1200BDL30 KCPM15	P81
4046464	F3BH1600BDL30 KCPM15	P81
4046465	F3BH2000BDL30 KCPM15	P81
4046466	F3BH2500BDL30 KCPM15	P81
4046467	F3BH0800BWM20C160 KCPM15	P79
4046468	F3BH0800BWS20C110 KCPM15	P79
4046469	F4BJ1000BWM20C130 KCPM15	P79
4046470	F4BJ1000BWM20C220 KCPM15	P79
4046471	F4BJ1200BWL20C260 KCPM15	P79
4046472	F4BJ1200BWM20C160 KCPM15	P79
4046473	F3AW0800AWL35E160 KCPM15	P103
4046474	F3AW1000AWX35E200 KCPM15	P103
4046475	F3AW1200AWX35E240 KCPM15	P103
4046476	F3AW1600AWX35E320 KCPM15	P103
4046478	F3BS0600BDK35 KCPM15	P82
4046479	F3BS0600BDL35 KCPM15	P82
4046480	F3BS0800BDK35 KCPM15	P82
4046481	F3BS0800BDL35 KCPM15	P82
4046482	F3BS1000BDK35 KCPM15	P82
4046483	F4BJ1600BWL20C190 KCPM15	P79
4046484	F4BJ1600BWL20C320 KCPM15	P79
4046485	F4BJ2000BWL20C220 KCPM15	P79
4046486	F4BJ2000BWX20C380 KCPM15	P79
4046487	F4AW0600AWL38E120 KCPM15	P21
4046488	F4AW0800AWL38E160 KCPM15	P21
4046489	F4AW1000AWX38E200 KCPM15	P21
4046490	F4AW1200AWX38E240 KCPM15	P21
4046491	F4AW1600AWX38E320 KCPM15	P21
4046493	F3BS1000BDL35 KCPM15	P82
4046494	F3BS1200BDK35 KCPM15	P82
4046495	F3BS1200BDL35 KCPM15	P82
4046497	F3BS1400BDL35 KCPM15	P82
4046498	F3BS1600BDK35 KCPM15	P82
4046499	F3BS1600BDL35 KCPM15	P82
4046500	F3BS2000BDK35 KCPM15	P82
4046501	F3BS2000BDL35 KCPM15	P82
4046524	F6AJ0600AWM45 KCPM15	P105
4046525	F6AJ0800AWM45 KCPM15	P105
4046526	F6AJ1000AWL45 KCPM15	P105
4046527	F6AJ1200AWL45 KCPM15	P105
4046528	F6AJ1600AWX45 KCPM15	P105
4046529	F8AJ2000AWX45 KCPM15	P105
4046530	F8AJ2500AWX45 KCPM15	P105
4046531	F10AJ1600ADK45E320 KCPM15	P104
4046532	F10AJ2000ADK45E400 KCPM15	P104
4046856	F4BJ0600BDL30 KCPM15	P83
4046857	F4BJ0800BDL30 KCPM15	P83
4046858	F4BJ1000BDL30 KCPM15	P83
4046859	F4BJ1200BDL30 KCPM15	P83
4046860	F4BJ1400BDL30 KCPM15	P83
4046861	F4BJ1600BDL30 KCPM15	P83
4046862	F4BJ1800BDL30 KCPM15	P83
4047063	F4BJ2000BDL30 KCPM15	P83
4047065	F3BH0400BWS20L110 KCPM15	P78
4047066	F3BH0500BWS20L130 KCPM15	P78
4047067	F3BH0600BWS20L080 KCPM15	P78
4047068	F3BH0600BWS20L130 KCPM15	P78
4047069	F3BH0800BWM20L160 KCPM15	P78
4047070	F3BH0800BWS20L110 KCPM15	P78
4047071	F4BJ1000BWM20L130 KCPM15	P78
4047072	F4BJ1000BWM20L220 KCPM15	P78
4047073	F4BJ1200BWL20L260 KCPM15	P78
4047074	F4BJ1200BWM20L160 KCPM15	P78
4047075	F4BJ1400BWL20L260 KCPM15	P78
4047076	F4BJ1600BWL20L190 KCPM15	P78
4047077	F4BJ1600BWL20L320 KCPM15	P78
4047078	F4BJ2000BWL20L220 KCPM15	P78
4047079	F4BJ2000BWX20L380 KCPM15	P78
4047080	F5BJ2500BWX20L450 KCPM15	P78
4047083	F8AJ0800ADK45E160 KCPM15	P104
4047084	F8AJ1000ADK45E200 KCPM15	P104
4047085	F8AJ1200ADK45E240 KCPM15	P104
4047275	F4BJ0600BDL45 KCPM15	P84
4047276	F4BJ0800BDL45 KCPM15	P84
4047277	F4BJ1000BDL45 KCPM15	P84
4047278	F4BJ1200BDL45 KCPM15	P84
4047279	F6BJ1600BDL45 KCPM15	P84
4047280	F6BJ2000BDL45 KCPM15	P84
4047281	F6BJ2500BDL45 KCPM15	P84
4047282	F6AJ0600ADL45 KCPM15	P105
4047293	F6AJ0800ADL45 KCPM15	P105
4047294	F6AJ1000ADL45 KCPM15	P105
4047295	F6AJ1200ADL45 KCPM15	P105
4047296	F6AJ1400ADL45 KCPM15	P105
4047297	F6AJ1600ADL45 KCPM15	P105
4047811	KSEMP2858FDS28A1M	H80, H91, H98
4047812	KSEMP2900FDS28A1M	H80, H91, H98
4047823	KSEMP2937FDS28A1M	H80, H91, H98
4047824	KSEMP3000FDS28A1M	H80, H91, H98
4047825	KSEMP3017FDS28A1M	H80, H91, H98
4047826	KSEMP3096FDS28A1M	H80, H91, H98

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
4047827	KSEMP3100FDS28A1M	H80, H91, H98
4047829	SPGX060304MD KC7140	J89
4047830	SPGX070304MD KC7140	J89
4047831	SPPX09T308MD KC7140	J89
4047832	SPPX120408MD KC7140	J89
4047843	SPPX15T508MD KC7140	J89
4047845	D2FIX110404RHP KCU25	E9
4047849	D2FIX150504RHP KCU25	E9
4047850	D2FIX150508RHP KCU25	E9
4047864	C2FIX150512RMN KCU25	E8
4047865	C2FIX110404LMN KCU25	E8
4047867	C2FIX150504LMN KCU25	E8
4047868	C2FIX150508LMN KCU25	E8
4047870	D4FIX140604RMN KCU25	E11
4047871	D4FIX140608RMN KCU25	E11
4050057	CNMG120408RP KCU25	B53
4050058	RCGT0803M0HP KCU25	B222
4050060	CNGP120408 KCU10	B46
4050061	CNMG120408FP KCU10	B49
4050062	CNMG120412FP KCU10	B49
4050332	KSEM1932HPGM KC7315	H42
4050372	CCGT060202HP KCU25	B175
4050395	CNGG120402FS KCU25	B46
4050397	CNGG120404FS KCU25	B46
4050398	CNGG120408FS KCU25	B46
4050399	CNMG120402MS KCU25	B52
4050400	CNMG120401MS KCU25	B52
4050402	CNMG120404MS KCU25	B52
4050403	CCGT060204HP KCU25	B175
4050404	CCGT060208HP KCU25	B175
4050405	CCGT09T302HP KCU25	B175
4050406	CCGT09T304HP KCU25	B175
4050407	CCGT09T308HP KCU25	B175
4050408	CCGT120402HP KCU25	B175
4050410	CCGT120408HP KCU25	B175
4050412	CPGH09T302 KCU25	B188
4050413	CPGH09T304 KCU25	B188
4050414	CPGH09T308 KCU25	B188
4050415	CPGT060202HP KCU25	B188
4050416	CPGT060204HP KCU25	B188
4050417	CPGT060208HP KCU25	B188
4050419	CPGT09T304HP KCU25	B188
4050420	CPGT09T308HP KCU25	B188
4050421	DCGT070202HP KCU25	B206
4050422	DCGT070204HP KCU25	B206
4050424	DCGT11T302HP KCU25	B206
4050425	DCGT11T304HP KCU25	B206
4050426	DCGT11T308HP KCU25	B206
4050428	DPGT070204HP KCU25	B214
4050429	DPGT070208HP KCU25	B214
4050430	DPGT11T304HP KCU25	B214
4050431	DPGT11T308HP KCU25	B214
4050432	RCGT10T3M0HP KCU25	B222
4050434	TCGT110202HP KCU25	B243
4050435	TCGT110204HP KCU25	B243
4050437	TCGT16T302HP KCU25	B243
4050441	TPGT110204HP KCU25	B254
4050444	TPGT16T304HP KCU25	B254
4050445	TPGT16T308HP KCU25	B254
4050447	VBGT110304HP KCU25	B264
4050448	VBGT160404HP KCU25	B264
4050449	VBGT160408HP KCU25	B264
4050451	CNMG120408MP KCU25	B51
4050452	CNMG120412MP KCU25	B51
4050453	CNMG120404RP KCU25	B53
4050454	CNMG120408MS KCU25	B52
4050455	CNMG120412MS KCU25	B52
4050456	CNMG120412RP KCU25	B53
4050458	CNMG120416MS KCU25	B52
4050459	CNMG120416RP KCU25	B53
4050460	CNMG160608MS KCU25	B52
4050461	CNMG160608RP KCU25	B53
4050462	CNMG160612MS KCU25	B52
4050463	CNMG160612RP KCU25	B53
4050465	CNMG160616RP KCU25	B53
4050466	CNMG190608MS KCU25	B52
4050468	CNMG190612RP KCU25	B53
4050469	CNMG190616MS KCU25	B52
4050470	CNMG190616RP KCU25	B53
4050475	DNGG150408FS KCU25	B74
4050477	DNMG110408MS KCU25	B79
4050478	DNMG110408RP KCU25	B81
4050479	DNMG150402MS KCU25	B79
4050480	DNMG150404MS KCU25	B79
4050481	DNMG150408MS KCU25	B79
4050482	DNMG150408RP KCU25	B81
4050484	DNMG150412MS KCU25	B79
4050485	DNMG150412RP KCU25	B81
4050486	DNMG150604MS KCU25	B79
4050487	DNMG150608MS KCU25	B79
4050488	DNMG150608RP KCU25	B81
4050489	DNMG150612MS KCU25	B79
4050490	DNMG150612RP KCU25	B81
4050491	DNMG150616RP KCU25	B81
4050513	CNMG160612MP KCU25	B51
4050514	CNMG190612MP KCU25	B51
4050515	DNMG150608MP KCU25	B79
4050516	DNMG150612MP KCU25	B79
4050517	SNMG120412MP KCU25	B98
4050518	SNMG120412RP KCU25	B101
4050519	SNMG150612RP KCU25	B101
4050520	SNMG190612RP KCU25	B101
4050521	DCGR150404 KCU25	E28
4050522	DCGR150408 KCU25	E28
4050523	DCGR150412 KCU25	E28
4050524	KCGR110304L08 KCU25	E29
4050525	KCGR110304R08 KCU25	E29
4050526	KCGR110308L08 KCU25	E29
4050527	KCGR110308R08 KCU25	E29
4050528	KNGX150404L20 KCU25	E30
4050529	KNGX150408L20 KCU25	E30
4050531	KCGX110301L15 KCU25	E31
4050532	KCGX110302L15 KCU25	E31
4050533	KCGX110304L15 KCU25	E31
4050534	KCGX110308L15 KCU25	E31
4050535	KNGX150404R20 KCU25	E30
4050536	KNGX150408R20 KCU25	E30
4050537	KNGX220404R25 KCU25	E30
4050539	KCGX110302R15 KCU25	E31
4050540	KCGX110304R15 KCU25	E31
4050544	VCMR160404 KCU25	E33
4050545	VCMR160408 KCU25	E33
4050546	VCGR160402 KCU25	E34
4050547	VCGR160404 KCU25	E34
4050548	VCGR160408 KCU25	E34
4050549	VCGR160412 KCU25	E34
4050607	CDHBS4T0S0 KCU25	B184
4050608	CDHBS4T002 KCU25	B184
4050609	CDHBS4T004 KCU25	B184
4050611	CDHHS4T002L KCU25	B184
4050613	CDHHS4T004L KCU25	B184
4050615	GPCD050102 KCU25	B222
4050616	GPCD050104 KCU25	B222
4050619	TDHB07T12S0 KCU25	B249
4050620	TDHB07T1202 KCU25	B249
4050621	TDHB07T1204 KCU25	B249
4050623	TDHH07T1202L KCU25	B249
4050624	TDHH07T1204L KCU25	B249
4050628	TPGH160304 KCU25	B253
4050632	RCGK040300FS KCU10	E63
4050653	RCGK040300HP KCU10	E63
4050654	RCGK060400FS KCU10	E63
4050655	RCGK060400HP KCU10	E63
4050656	RCGK090700FS KCU10	E63
4050657	RCGK090700HP KCU10	E63
4050658	RCGK120800FS KCU10	E63
4050659	RCGK120800HP KCU10	E63
4050661	RCMK060400 KCU10	E63
4050664	CNGG120402LF KCU10	B46
4050665	CNGG120401LF KCU10	B46
4050666	CNGG120404LF KCU10	B46
4050667	CNGG120408LF KCU10	B46
4050668	CNGG120412LF KCU10	B46
4050671	CNGP120401 KCU10	B46
4050672	CNGP120402 KCU10	B46
4050673	CNGP120404 KCU10	B46
4050674	CNGP120412 KCU10	B46
4050676	CNMG090308MP KCU10	B51
4050677	CNMG120404FF KCU10	B48
4050678	CNMG120404FW KCU10	B49
4050679	CNMG120404MP KCU10	B51
4050681	CNMG120404P KCU10	B52
4050682	CNMG120404RP KCU10	B53
4050683	CNMG120408CT KCU10	B48
4050684	CNMG120408FF KCU10	B48
4050685	CNMG120408FW KCU10	B49
4050686	CNMG120408MP KCU10	B51
4050688	CNMG120408P KCU10	B52
4050689	CNMG120408RP KCU10	B53
4050690	CNMG120408UP KCU10	B54
4050691	CNMG120412FW KCU10	B49
4050692	CNMG120412MP KCU10	B51
4050695	CNMG120412RP KCU10	B53
4050696	CNMG120412UP KCU10	B54
4050699	CNMG120416RP KCU10	B53
4050700	CNMG160608MP KCU10	B51
4050701	CNMG160608RP KCU10	B53
4050702	CNMG160612MP KCU10	B51
4050704	CNMG160612RP KCU10	B53
4050705	CNMG160612UP KCU10	B54
4050709	CNMG190612 KCU10	B47
4050711	CNMG190612P KCU10	B52
4050712	CNMG190612RP KCU10	B53
4050713	CNMG190616MP KCU10	B51
4050714	CNMG190616RP KCU10	B53
4050743	DNMG110408FP KCU10	B77
4050744	DNMG150408FF KCU10	B76
4050746	WNMG060404FP KCU10	B156
4050748	RCGV060400 KCU10	B166
4050764	SPGN120304 KCU10	B169
4050765	SPGN120308 KCU10	B169
4050768	SPGN120412 KCU10	B169
4050769	SPGN190412 KCU10	B169
4050770	SPGR090308K KCU10	B169
4050771	TPGN110304 KCU10	B171
4050772	TPGN110308 KCU10	B171
4050774	TPGN160304 KCU10	B171
4050775	TPGN160308 KCU10	B171
4050778	TPGN220404 KCU10	B171
4050779	TPGN220408 KCU10	B171
4050780	TPGN220412 KCU10	B171
4050783	TPGR110308K KCU10	B171
4050784	TPGR160304K KCU10	B171
4050785	TPGR160308K KCU10	B171
4050786	TPGR220404K KCU10	B171
4050787	TPGR220408K KCU10	B171
4050895	D2FIX150504RHP KCU10	E9
4050896	D2FIX150508RHP KCU10	E9
4050899	D2FIX150508LHP KCU10	E9
4051036	C8FIX120505RRP KCU25	E12
4051038	C8FIX120503RMP KCU25	E12
4051039	C8FIX150605LRN KCU25	E11
4051040	C8FIX150608LRN KCU25	E11
4051041	C8FIX150605RRN KCU25	E11
4051042	C8FIX150608RRN KCU25	E11
4051044	C8FIX150603RMP KCU25	E12
4051048	C8FIX180812RRN KCU25	E11
4051051	MS2190CG	V82
4051052	MS2188C	V82
4051066	C2FIX110404RMN KCU10	E8
4051074	C2FIX150508LMN KCU10	E8
4051077	D4FIX140608RMN KCU10	E11
4051088	D2FIX110403LHP KCU10	E9
4051089	D2FIX110403RHP KCU10	E9
4051090	C2FIX110405LMN KCU10	E8
4051091	E2FIX100505LHP KCU10	E10
4051092	E2FIX100505RHP KCU10	E10
4051104	D2FIX150503LHP KCU10	E9
4051106	D2FIX150503LMS KCU10	E10
4051107	D2FIX150505LMS KCU10	E10
4051109	D2FIX150503RHP KCU10	E9
4051110	D2FIX150505RFN KCU10	E10
4051111	D2FIX150503RMS KCU10	E10
4051112	D2FIX150505RMS KCU10	E10
4051114	C2FIX150505LMN KCU10	E8
4051115	C2FIX180610LMN KCU10	E8
4051121	C8FIX120503LMP KCU10	E12
4051122	C8FIX120503RMP KCU10	E12
4051125	C8FIX150605RRN KCU10	E11
4051128	C8FIX150603RMP KCU10	E12
4051136	WD32FDS28190M	H103
4051137	WD32FDS28283M	H103
4051189	D2FIX150505RMN KCP10	E9
4051190	D2FIX150505RRN KCP10	E10
4051203	D4FIX140605RMN KCP10	E11
4051204	D4FIX140603RMN KCP10	E11
4051209	C8FIX120503LMP KCP10	E12
4051213	C8FIX150605RRN KCP10	E11
4051214	C8FIX150608RRN KCP10	E11
4051216	C8FIX150603RMP KCP10	E12
4051515	170.352	H98
4051516	B254A03000YPC KCK10	G58
4051517	B254A03048YPC KCK10	G58
4051519	B254A03200YPC KCK10	G58
4051521	B254A03300YPC KCK10	G58
4051522	B254A03454YPC KCK10	G58
4051797	B255A09300YPC KCK10	G59
4051798	B255A09400YPC KCK10	G59
4051799	B255A09500YPC KCK10	G60
4051800	B255A09525YPC KCK10	G60
4051801	B255A09600YPC KCK10	G60
4051802	B255A09700YPC KCK10	G60
4051826	D4FIX140608RMN KCP10	E11
4051829	C8FIX120504RRP KCP10	E12
4051830	C8FIX120508RRP KCP10	E12
4051837	B254A10200YPC KCK10	G60
4051838	B254A10262YPC KCK10	G60
4051839	B254A10300YPC KCK10	G60
4051840	B254A10320YPC KCK10	G60
4051842	B254A10490YPC KCK10	G60
4051843	B255A09800YPC KCK10	G60
4051844	B255A09921YPC KCK10	G60
4051845	B255A10000YPC KCK10	G60
4051846	B255A10200YPC KCK10	G60
4051847	B255A10262YPC KCK10	G60
4051848	B255A10300YPC KCK10	G60
4051849	B255A10320YPC KCK10	G60
4051850	B255A10400YPC KCK10	G60
4051852	B255A10500YPC KCK10	G60
4051853	B255A10600YPC KCK10	G60
4051854	B255A10716YPC KCK10	G60
4051855	B255A10800YPC KCK10	G60
4051856	B255A10900YPC KCK10	G60
4051857	B255A11000YPC KCK10	G60
4051858	B255A11100YPC KCK10	G60
4051859	B255A11113YPC KCK10	G60
4051860	B255A11200YPC KCK10	G60
4051862	B255A11500YPC KCK10	G60
4051865	B255A11700YPC KCK10	G60
4051866	B255A11800YPC KCK10	G60
4051867	B255A11900YPC KCK10	G60
4051868	B255A11908YPC KCK10	G60
4051869	B255A12000YPC KCK10	G60
4051870	B255A12100YPC KCK10	G60
4051871	B255A12200YPC KCK10	G60
4051872	B255A12251YPC KCK10	G60
4051873	B255A12300YPC KCK10	G60
4051874	B255A12304YPC KCK10	G60
4051875	B255A12500YPC KCK10	G60
4051876	B255A12700YPC KCK10	G60
4051878	B255A13000YPC KCK10	G60
4051879	B255A13096YPC KCK10	G60
4051881	B255A13495YPC KCK10	G60
4051882	B255A13500YPC KCK10	G60
4051884	B255A14000YPC KCK10	G60
4051885	B255A14100YPC KCK10	G60
4051886	B255A14288YPC KCK10	G60
4051887	B255A14500YPC KCK10	G60
4051888	B255A14600YPC KCK10	G60
4051889	B255A14684YPC KCK10	G60
4051893	B255A15000YPC KCK10	G60
4051894	B255A15083YPC KCK10	G60
4051896	B255A15250YPC KCK10	G60
4051897	B255A15400YPC KCK10	G61
4051899	B255A15500YPC KCK10	G61
4051900	B255A15800YPC KCK10	G61
4051901	B255A15875YPC KCK10	G61
4051902	B255A16000YPC KCK10	G61
4051904	B255A16300YPC KCK10	G61
4051905	B255A16500YPC KCK10	G61
4051906	B255A16670YPC KCK10	G61
4051907	B255A16800YPC KCK10	G61
4051909	B255A17000YPC KCK10	G61
4051910	B255A17200YPC KCK10	G61
4051913	B255A17463YPC KCK10	G61
4051914	B255A17500YPC KCK10	G61
4051915	B255A17800YPC KCK10	G61

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
4051916	B255A17859YPC KCK10	G61
4051917	B255A18000YPC KCK10	G61
4051918	B255A18258YPC KCK10	G61
4051919	B255A18500YPC KCK10	G61
4051920	B255A18800YPC KCK10	G61
4051921	B255A19000YPC KCK10	G61
4051924	B255A19500YPC KCK10	G61
4051925	B255A19700YPC KCK10	G61
4051926	B255A19800YPC KCK10	G61
4051927	B255A20000YPC KCK10	G61
4051928	B255A20500YPC KCK10	G61
4051929	B255A20638YPC KCK10	G61
4051930	B255A21000YPC KCK10	G61
4051931	B255A22000YPC KCK10	G61
4051932	B255A22225YPC KCK10	G61
4051933	B255A23416YPC KCK10	G61
4051934	B255A24000YPC KCK10	G61
4051935	B255A25000YPC KCK10	G61
4051963	B254A03500YPC KCK10	G58
4051965	B254A03600YPC KCK10	G58
4051969	B254A03800YPC KCK10	G58
4051970	B254A03861YPC KCK10	G58
4051972	B254A04000YPC KCK10	G58
4051973	B254A04039YPC KCK10	G58
4051974	B254A04100YPC KCK10	G58
4051975	B254A04200YPC KCK10	G58
4051978	B254A04500YPC KCK10	G58
4051979	B254A04572YPC KCK10	G58
4051981	B254A04763YPC KCK10	G58
4051982	B254A04800YPC KCK10	G58
4051983	B254A05000YPC KCK10	G58
4051984	B254A05055YPC KCK10	G58
4051985	B254A05100YPC KCK10	G58
4051986	B254A05106YPC KCK10	G58
4051988	B254A05300YPC KCK10	G58
4051990	B254A05500YPC KCK10	G59
4051991	B254A05558YPC KCK10	G59
4051994	B254A05791YPC KCK10	G59
4051995	B254A05800YPC KCK10	G59
4051998	B254A06000YPC KCK10	G59
4051999	B254A06100YPC KCK10	G59
4052000	B254A06200YPC KCK10	G59
4052002	B254A06500YPC KCK10	G59
4052003	B254A06528YPC KCK10	G59
4052004	B254A06600YPC KCK10	G59
4052005	B254A06700YPC KCK10	G59
4052006	B254A06746YPC KCK10	G59
4052007	B254A06800YPC KCK10	G59
4052008	B254A06900YPC KCK10	G59
4052010	B254A07000YPC KCK10	G59
4052011	B254A07100YPC KCK10	G59
4052012	B254A07366YPC KCK10	G59
4052014	B254A07493YPC KCK10	G59
4052015	B254A07500YPC KCK10	G59
4052017	B254A07600YPC KCK10	G59
4052018	B254A07800YPC KCK10	G59
4052020	B254A07938YPC KCK10	G59
4052021	B254A08000YPC KCK10	G59
4052022	B254A08100YPC KCK10	G59
4052023	B254A08200YPC KCK10	G59
4052024	B254A08334YPC KCK10	G59
4052025	B254A08400YPC KCK10	G59
4052026	B254A08433YPC KCK10	G59
4052027	B254A08500YPC KCK10	G59
4052028	B254A08600YPC KCK10	G59
4052029	B254A08700YPC KCK10	G59
4052031	B254A08800YPC KCK10	G59
4052032	B254A08839YPC KCK10	G59
4052034	B254A09000YPC KCK10	G59
4052036	B254A09100YPC KCK10	G59
4052038	B254A09200YPC KCK10	G59
4052039	B254A09400YPC KCK10	G59
4052040	B254A09500YPC KCK10	G60
4052041	B254A09525YPC KCK10	G60
4052042	B254A09800YPC KCK10	G60
4052043	B254A09921YPC KCK10	G60
4052044	B254A10000YPC KCK10	G60
4052053	B254A10500YPC KCK10	G60
4052054	B254A10700YPC KCK10	G60
4052056	B254A10800YPC KCK10	G60
4052058	B254A11000YPC KCK10	G60
4052059	B254A11100YPC KCK10	G60
4052060	B254A11113YPC KCK10	G60
4052061	B254A11200YPC KCK10	G60
4052062	B254A11500YPC KCK10	G60
4052064	B254A11800YPC KCK10	G60
4052066	B254A11908YPC KCK10	G60
4052067	B254A12000YPC KCK10	G60
4052068	B254A12200YPC KCK10	G60
4052070	B254A12304YPC KCK10	G60
4052071	B254A12500YPC KCK10	G60
4052073	B254A12800YPC KCK10	G60
4052074	B254A13000YPC KCK10	G60
4052076	B254A13100YPC KCK10	G60
4052077	B254A13200YPC KCK10	G60
4052081	B254A13500YPC KCK10	G60
4052082	B254A13800YPC KCK10	G60
4052083	B254A13891YPC KCK10	G60
4052084	B254A14000YPC KCK10	G60
4052085	B254A14100YPC KCK10	G60
4052086	B254A14288YPC KCK10	G60
4052087	B254A14500YPC KCK10	G60
4052090	B254A14800YPC KCK10	G60
4052091	B254A15000YPC KCK10	G60
4052093	B254A15200YPC KCK10	G60
4052094	B254A15250YPC KCK10	G60
4052095	B254A15400YPC KCK10	G61
4052097	B254A15500YPC KCK10	G61
4052099	B254A15800YPC KCK10	G61
4052101	B254A16000YPC KCK10	G61
4052102	B254A16500YPC KCK10	G61
4052103	B254A16670YPC KCK10	G61
4052104	B254A16800YPC KCK10	G61
4052105	B254A17000YPC KCK10	G61
4052107	B254A17463YPC KCK10	G61
4052108	B254A17500YPC KCK10	G61
4052109	B254A17800YPC KCK10	G61
4052110	B254A17859YPC KCK10	G61
4052111	B254A18000YPC KCK10	G61
4052112	B254A18200YPC KCK10	G61
4052113	B254A18258YPC KCK10	G61
4052114	B254A18500YPC KCK10	G61
4052115	B254A18800YPC KCK10	G61
4052116	B254A19000YPC KCK10	G61
4052117	B254A19050YPC KCK10	G61
4052121	B254A19800YPC KCK10	G61
4052122	B254A20000YPC KCK10	G61
4052123	B254A20638YPC KCK10	G61
4052124	B254A21000YPC KCK10	G61
4052125	B254A22000YPC KCK10	G61
4052126	B254A22225YPC KCK10	G61
4052127	B254A23416YPC KCK10	G61
4052129	B254A25000YPC KCK10	G61
4052130	B255A03000YPC KCK10	G58
4052131	B255A03048YPC KCK10	G58
4052132	B255A03175YPC KCK10	G58
4052133	B255A03200YPC KCK10	G58
4052134	B255A03250YPC KCK10	G58
4052135	B255A03300YPC KCK10	G58
4052136	B255A03400YPC KCK10	G58
4052138	B255A03500YPC KCK10	G58
4052140	B255A03600YPC KCK10	G58
4052141	B255A03700YPC KCK10	G58
4052143	B255A03797YPC KCK10	G58
4052144	B255A03800YPC KCK10	G58
4052145	B255A03861YPC KCK10	G58
4052146	B255A03970YPC KCK10	G58
4052147	B255A04000YPC KCK10	G58
4052148	B255A04039YPC KCK10	G58
4052149	B255A04100YPC KCK10	G58
4052150	B255A04200YPC KCK10	G58
4052151	B255A04217YPC KCK10	G58
4052152	B255A04300YPC KCK10	G58
4052153	B255A04366YPC KCK10	G58
4052155	B255A04500YPC KCK10	G58
4052156	B255A04572YPC KCK10	G58
4052157	B255A04600YPC KCK10	G58
4052158	B255A04700YPC KCK10	G58
4052160	B255A04800YPC KCK10	G58
4052161	B255A04900YPC KCK10	G58
4052162	B255A05000YPC KCK10	G58
4052163	B255A05055YPC KCK10	G58
4052164	B255A05100YPC KCK10	G58
4052166	B255A05159YPC KCK10	G58
4052167	B255A05200YPC KCK10	G58
4052168	B255A05250YPC KCK10	G58
4052169	B255A05300YPC KCK10	G58
4052170	B255A05400YPC KCK10	G59
4052171	B255A05410YPC KCK10	G59
4052172	B255A05500YPC KCK10	G59
4052173	B255A05558YPC KCK10	G59
4052174	B255A05600YPC KCK10	G59
4052175	B255A05700YPC KCK10	G59
4052176	B255A05791YPC KCK10	G59
4052177	B255A05800YPC KCK10	G59
4052180	B255A06000YPC KCK10	G59
4052181	B255A06100YPC KCK10	G59
4052182	B255A06200YPC KCK10	G59
4052183	B255A06300YPC KCK10	G59
4052184	B255A06350YPC KCK10	G59
4052185	B255A06400YPC KCK10	G59
4052186	B255A06500YPC KCK10	G59
4052188	B255A06600YPC KCK10	G59
4052189	B255A06630YPC KCK10	G59
4052190	B255A06700YPC KCK10	G59
4052191	B255A06746YPC KCK10	G59
4052192	B255A06800YPC KCK10	G59
4052193	B255A06900YPC KCK10	G59
4052194	B255A06909YPC KCK10	G59
4052195	B255A07000YPC KCK10	G59
4052196	B255A07145YPC KCK10	G59
4052197	B255A07200YPC KCK10	G59
4052200	B255A07400YPC KCK10	G59
4052201	B255A07493YPC KCK10	G59
4052202	B255A07500YPC KCK10	G59
4052203	B255A07541YPC KCK10	G59
4052204	B255A07600YPC KCK10	G59
4052205	B255A07700YPC KCK10	G59
4052206	B255A07800YPC KCK10	G59
4052207	B255A07900YPC KCK10	G59
4052208	B255A07938YPC KCK10	G59
4052209	B255A08000YPC KCK10	G59
4052210	B255A08100YPC KCK10	G59
4052211	B255A08200YPC KCK10	G59
4052212	B255A08300YPC KCK10	G59
4052214	B255A08433YPC KCK10	G59
4052215	B255A08500YPC KCK10	G59
4052216	B255A08600YPC KCK10	G59
4052217	B255A08700YPC KCK10	G59
4052219	B255A08800YPC KCK10	G59
4052220	B255A08839YPC KCK10	G59
4052221	B255A08900YPC KCK10	G59
4052222	B255A09000YPC KCK10	G59
4052223	B255A09093YPC KCK10	G59
4052224	B255A09100YPC KCK10	G59
4052225	B255A09129YPC KCK10	G59
4052226	B255A09200YPC KCK10	G59
4052592	KRM018030CLB004NE	K89
4052780	KIPR020RP09CF02	V154
4052781	KIPR020RP06MF03	V153
4052782	KIPR020RP09MF02	V153
4052843	KIPR025RP09MF03	V153
4052845	B256A10200YPC KCK10	G60
4052846	B256A10300YPC KCK10	G60
4052847	B256A10400YPC KCK10	G60
4052848	B256A10500YPC KCK10	G60
4052849	B256A10700YPC KCK10	G60
4052850	B256A10800YPC KCK10	G60
4052851	B256A11000YPC KCK10	G60
4052852	B256A11200YPC KCK10	G60
4052863	B256A11300YPC KCK10	G60
4052864	B256A11500YPC KCK10	G60
4052865	B256A11600YPC KCK10	G60
4052866	B256A11800YPC KCK10	G60
4052867	B256A12000YPC KCK10	G60
4052868	B256A12200YPC KCK10	G60
4052869	B256A12300YPC KCK10	G60
4052870	B256A12400YPC KCK10	G60
4052871	B256A12500YPC KCK10	G60
4052872	B256A12700YPC KCK10	G60
4052873	B256A12800YPC KCK10	G60
4052874	B256A13000YPC KCK10	G60
4052875	B256A13096YPC KCK10	G60
4052876	B256A13200YPC KCK10	G60
4052877	B256A13495YPC KCK10	G60
4052878	B256A13500YPC KCK10	G60
4052879	B256A13700YPC KCK10	G60
4052880	B256A13800YPC KCK10	G60
4052881	B256A13891YPC KCK10	G60
4052882	B256A14000YPC KCK10	G60
4052883	B256A14500YPC KCK10	G60
4052884	B256A14684YPC KCK10	G60
4052885	B256A14800YPC KCK10	G60
4052886	B256A15000YPC KCK10	G60
4052887	B256A15083YPC KCK10	G60
4052888	B256A15200YPC KCK10	G60
4052889	B256A15300YPC KCK10	G61
4052892	B256A15500YPC KCK10	G61
4052893	B256A15800YPC KCK10	G61
4052894	B256A16000YPC KCK10	G61
4052896	B256A16300YPC KCK10	G61
4052897	B256A16500YPC KCK10	G61
4052899	B256A16800YPC KCK10	G61
4052900	B256A17000YPC KCK10	G61
4052902	B256A17500YPC KCK10	G61
4052903	B256A17800YPC KCK10	G61
4052905	B256A18000YPC KCK10	G61
4052906	B256A18258YPC KCK10	G61
4052907	B256A18500YPC KCK10	G61
4052908	B256A18800YPC KCK10	G61
4052909	B256A19000YPC KCK10	G61
4052911	B256A19500YPC KCK10	G61
4052912	B256A19800YPC KCK10	G61
4052913	B256A20000YPC KCK10	G61
4052914	B256A20638YPC KCK10	G61
4052915	B256A22000YPC KCK10	G61
4052916	B256A22225YPC KCK10	G61
4052917	B256A25004YPC KCK10	G61
4053226	B256A03000YPC KCK10	G58
4053228	B256A03175YPC KCK10	G58
4053230	B256A03264YPC KCK10	G58
4053232	B256A03500YPC KCK10	G58
4053235	B256A03700YPC KCK10	G58
4053236	B256A03800YPC KCK10	G58
4053238	B256A04000YPC KCK10	G58
4053240	B256A04100YPC KCK10	G58
4053241	B256A04200YPC KCK10	G58
4053242	B256A04300YPC KCK10	G58
4053243	B256A04366YPC KCK10	G58
4053244	B256A04500YPC KCK10	G58
4053245	B256A04623YPC KCK10	G58
4053246	B256A04700YPC KCK10	G58
4053247	B256A04800YPC KCK10	G58
4053248	B256A04852YPC KCK10	G58
4053249	B256A05000YPC KCK10	G58
4053250	B256A05100YPC KCK10	G58
4053252	B256A05200YPC KCK10	G58
4053254	B256A05500YPC KCK10	G59
4053255	B256A05600YPC KCK10	G59
4053258	B256A05800YPC KCK10	G59
4053259	B256A05900YPC KCK10	G59
4053261	B256A06000YPC KCK10	G59
4053262	B256A06200YPC KCK10	G59
4053263	B256A06350YPC KCK10	G59
4053264	B256A06400YPC KCK10	G59
4053265	B256A06500YPC KCK10	G59
4053266	B256A06600YPC KCK10	G59
4053267	B256A06700YPC KCK10	G59
4053268	B256A06800YPC KCK10	G59
4053269	B256A07000YPC KCK10	G59
4053270	B256A07300YPC KCK10	G59
4053271	B256A07500YPC KCK10	G59
4053272	B256A07600YPC KCK10	G59
4053273	B256A07800YPC KCK10	G59
4053274	B256A08000YPC KCK10	G59
4053275	B256A08200YPC KCK10	G59
4053276	B256A08300YPC KCK10	G59
4053277	B256A08500YPC KCK10	G59
4053278	B256A08600YPC KCK10	G59
4053279	B256A08700YPC KCK10	G59
4053280	B256A08800YPC KCK10	G59
4053281	B256A09000YPC KCK10	G59
4053282	B256A09100YPC KCK10	G59
4053284	B256A09300YPC KCK10	G59
4053285	B256A09347YPC KCK10	G59
4053287	B256A09500YPC KCK10	G60
4053288	B256A09600YPC KCK10	G60
4053289	B256A09700YPC KCK10	G60

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
4053290	B256A09800YPC KCK10	G60
4053291	B256A10000YPC KCK10	G60
4053312	CDHBS4T0X0 KCU10	B184
4053323	CDHBS4T002 KCU10	B184
4053324	CDHBS4T004 KCU10	B184
4053325	CDHHS4T002L KCU10	B184
4053326	CDHHS4T002R KCU10	B184
4053327	CDHHS4T004L KCU10	B184
4053328	CDHHS4T004R KCU10	B184
4053336	TDHB07T1202 KCU10	B249
4053337	TDHB07T1204 KCU10	B249
4053339	TDHH07T1202L KCU10	B249
4053340	TDHH07T1202R KCU10	B249
4053341	TDHH07T1204L KCU10	B249
4053342	TDHH07T1204R KCU10	B249
4053344	TPGH160304 KCU10	B253
4053352	DNGG150402LF KCU10	B74
4053363	DNGG150404LF KCU10	B74
4053364	DNGG150408LF KCU10	B74
4053366	DNGP150402 KCU10	B74
4053367	DNGP150404 KCU10	B74
4053368	DNGP150408 KCU10	B74
4053369	DNGP150604 KCU10	B74
4053370	DNGP150608 KCU10	B74
4053371	DNMG110404FW KCU10	B78
4053372	DNMG110408FF KCU10	B76
4053373	DNMG110408MP KCU10	B79
4053374	DNMG110408RP KCU10	B81
4053376	DNMG150404CT KCU10	B76
4053377	DNMG150404FF KCU10	B76
4053378	DNMG150404FW KCU10	B78
4053379	DNMG150404MP KCU10	B79
4053380	DNMG150404P KCU10	B81
4053381	DNMG150404UP KCU10	B82
4053383	DNMG150408FW KCU10	B78
4053384	DNMG150408MP KCU10	B79
4053386	DNMG150408P KCU10	B81
4053387	DNMG150408RP KCU10	B81
4053388	DNMG150408UP KCU10	B82
4053389	DNMG150412CT KCU10	B76
4053390	DNMG150412MP KCU10	B79
4053391	DNMG150412RP KCU10	B81
4053393	DNMG150416RP KCU10	B81
4053395	DNMG150604FW KCU10	B78
4053396	DNMG150604MP KCU10	B79
4053399	DNMG150608FW KCU10	B78
4053400	DNMG150608MP KCU10	B79
4053403	DNMG150608RP KCU10	B81
4053404	DNMG150608UP KCU10	B82
4053406	DNMG150612MP KCU10	B79
4053407	DNMG150612RP KCU10	B81
4053408	RNMG120400RN KCU10	B94
4053409	RNMG190600RN KCU10	B94
4054272	D2FIX110405LMN KCP25	E9
4054299	D2FIX110405LMN KCP40	E9
4054300	D2FIX110405RMN KCP40	E9
4054301	C2FIX110405LMN KCP40	E8
4054302	C2FIX110405RMN KCP40	E8
4054355	D2FIX150505RMN KCP40	E9
4054356	D2FIX150505RRN KCP40	E10
4054358	C2FIX150505LMN KCP40	E8
4054359	C2FIX150510LMN KCP40	E8
4054362	C2FIX180610LMN KCP40	E8
4054368	C8FIX120503RRP KCP40	E12
4054372	C8FIX150605LRN KCP40	E11
4054374	C8FIX150605RRN KCP40	E11
4054375	C8FIX150608RRN KCP40	E11
4054377	C8FIX150603RMP KCP40	E12
4054380	C8FIX180808RRN KCP40	E11
4054381	C8FIX180812RRN KCP40	E11
4054386	C2FIX150510LMN KCP25	E8
4054387	C2FIX150505RMN KCP25	E8
4054388	C2FIX150510RMN KCP25	E8
4054391	C2FIX180610LMN KCP25	E8
4054397	D4FIX140605RMN KCP25	E11
4054398	D4FIX140603RMN KCP25	E11
4054401	C8FIX120503RRP KCP25	E12
4054402	C8FIX120505RRP KCP25	E12
4054403	C8FIX120503LMP KCP25	E12
4054404	C8FIX120503RMP KCP25	E12
4054405	C8FIX150605LRN KCP25	E11
4054406	C8FIX150608LRN KCP25	E11
4054407	C8FIX150605RRN KCP25	E11
4054408	C8FIX150608RRN KCP25	E11
4054409	C8FIX150603LMP KCP25	E12
4054410	C8FIX150603RMP KCP25	E12
4054412	C8FIX180812LRN KCP25	E11
4054413	C8FIX180808RRN KCP25	E11
4054414	C8FIX180812RRN KCP25	E11
4054416	C8FIX180805RMP KCP25	E12
4054421	D2FIX150504RMN KCP25	E9
4054422	D2FIX150508RMN KCP25	E9
4054435	D2FIX150508LMN KCP25	E9
4054442	C2FIX110408LMN KCP25	E8
4054444	C2FIX150508LMN KCP25	E8
4054447	D4FIX140608RMN KCP25	E11
4054449	D4FIX140608LMN KCP25	E11
4054450	C8FIX120504RRP KCP25	E12
4054451	C8FIX120508RRP KCP25	E12
4054453	C8FIX150612RRN KCP25	E11
4054455	C8FIX120508LRP KCP25	E12
4054456	C8FIX150612LRN KCP25	E11
4054474	D2FIX110403RHP KCP25	E9
4054475	D2FIX110405RMN KCP25	E9
4054477	C2FIX110405LMN KCP25	E8
4054478	C2FIX110405RMN KCP25	E8
4054483	D2FIX150505LMN KCP25	E9
4054484	D2FIX150505LRN KCP25	E10
4054486	D2FIX150503RHP KCP25	E9
4054487	D2FIX150505RRN KCP25	E10
4054488	D2FIX150505RMN KCP25	E9
4054490	D2FIX150503RMN KCP25	E9
4054491	C2FIX150505LMN KCP25	E8
4054494	B976A03175 KC7315	G138
4054495	B976A03454 KC7315	G138
4054496	B976A03734 KC7315	G138
4054497	B976A03797 KC7315	G138
4054498	B976A04039 KC7315	G138
4054499	B976A04366 KC7315	G139
4054500	B976A04496 KC7315	G139
4054501	B976A04700 KC7315	G139
4054502	B976A05106 KC7315	G139
4054503	B976A05410 KC7315	G139
4054504	B976A05791 KC7315	G139
4054505	B976A05944 KC7315	G139
4054506	B976A06528 KC7315	G139
4054507	B976A06909 KC7315	G139
4054508	B976A07366 KC7315	G140
4054509	B976A08433 KC7315	G140
4054510	B976A08839 KC7315	G140
4054511	B976A09093 KC7315	G140
4054512	B976A10262 KC7315	G140
4054513	B976A13495 KC7315	G141
4054514	B976A16670 KC7315	G142
4054515	B977A03175 KC7315	G138
4054516	B977A03734 KC7315	G138
4054517	B977A03797 KC7315	G138
4054518	B977A04039 KC7315	G138
4054519	B977A04366 KC7315	G139
4054520	B977A04496 KC7315	G139
4054521	B977A05106 KC7315	G139
4054522	B977A05791 KC7315	G139
4054523	B977A05944 KC7315	G139
4054524	B977A07366 KC7315	G140
4054525	B977A08839 KC7315	G140
4054526	B977A09093 KC7315	G140
4054527	B977A10262 KC7315	G140
4054528	B977A13495 KC7315	G141
4054648	C2FIX150504LMN KCP40	E8
4054651	D4FIX140604RMN KCP40	E11
4054660	C8FIX120508LRP KCP40	E12
4054680	DFR040304D28MD KC7140	H89, J84
4054681	DFR040304D28LD KC7225	H89
4054733	HSK100ASVUBB2124MCLB	K74
4054734	HSK63ASVUBB1095MCLB	K72
4054735	HSK63ASVUBB2116MCLB	K74
4054736	KM50TSSVUBB2100MCLB	K73
4054737	KR32SVUBB1060MCLB	K72
4054738	KR32SVUBB2085MCLB	K73
4054739	KR50SVUBB2075MCLB	K73
4054740	KR80SVU92152MCLB	K84
4054889	A4G0605M06U08GMN KCP10	C96
4054890	A4R0605M06U00GMN KCP10	C97
4056174	SS16KST115AR3M	K38
4056175	SS20KST135AR3M	K38
4056176	SS20KST155AR3M	K38
4056177	SS16KST115AR5M	K38
4056178	SS20KST135AR5M	K38
4056179	SS20KST155AR5M	K38
4056390	RHM14000KST115H7HF KT6215	K31
4056513	RPGN120400E KYSP30	V155
4056980	RHM14000KST115H7HF KT325	K31
4056981	RHM14288KST115H7HF KT325	K31
4056983	RHM15875KST115H7HF KT325	K31
4056984	RHM16000KST135H7HF KT325	K31
4056985	RHM17000KST135H7HF KT325	K31
4056986	RHM17463KST135H7HF KT325	K31
4056987	RHM18000KST155H7HF KT325	K31
4056988	RHM19000KST155H7HF KT325	K31
4056989	RHM19050KST155H7HF KT325	K31
4056990	RHM14288KST115H7HF KT6215	K31
4056993	RHM16000KST135H7HF KT6215	K31
4056994	RHM17000KST135H7HF KT6215	K31
4056995	RHM17463KST135H7HF KT6215	K31
4056996	RHM18000KST155H7HF KT6215	K31
4056997	RHM19000KST155H7HF KT6215	K31
4056998	RHM19050KST155H7HF KT6215	K31
4057034	RHM14000KST115H7SF KT325	K29
4057035	RHM14288KST115H7SF KT325	K29
4057036	RHM15000KST115H7SF KT325	K29
4057037	RHM15875KST115H7SF KT325	K29
4057038	RHM16000KST135H7SF KT325	K29
4057039	RHM17000KST135H7SF KT325	K29
4057040	RHM17463KST135H7SF KT325	K29
4057041	RHM18000KST155H7SF KT325	K29
4057042	RHM19000KST155H7SF KT325	K29
4057044	RHM14000KST115H7SF KT6215	K29
4057045	RHM14288KST115H7SF KT6215	K29
4057047	RHM15875KST115H7SF KT6215	K29
4057048	RHM16000KST135H7SF KT6215	K29
4057049	RHM17000KST135H7SF KT6215	K29
4057051	RHM18000KST155H7SF KT6215	K29
4057053	RHM19050KST155H7SF KT6215	K29
4057057	HSK63FBHM1696	K128
4057058	DV40FBHM1691	K129
4057059	BT40FBHM1691	K129
4057060	KM50TSFBHM1677	K128
4057061	AFM29115	K131
4057062	AFM47115	K131
4057093	AFM29SCFPR06	K132
4057094	AFM47SCFPR09	K132
4057095	EBM8015086	K132
4057096	886038045	K132
4057097	PKG-8001	K128–130
4057098	HSK63FBHMKIT164M	K123, K127
4057099	DV40FBHMKIT164M	K123, K127
4057100	BT40FBHMKIT164M	K123, K127
4057101	KM50TSFBHMKIT164M	K123, K127
4057204	EB630128650	K140
4057205	EB10801281100	K140
4057206	EB16301281650	K140
4057207	EBSLD1105	K140
4057208	EBSLD2205	K140
4057639	HNPJ1307ANSNHD KCPK30	S27
4057640	HNPJ1307ANSNHD KCK15	S27
4057641	HNPJ1307ANSNHD KC725M	S27
4057828	HNPJ130720ANSNHD KCPK30	S27
4057830	HNPJ130720ANSNHD KC725M	S27
4057854	HNPJ130735ANSNHD KCPK30	S27
4057855	HNPJ130735ANSNHD KCK15	S27
4057865	HNGJ1307ANENGD KCPK30	S26
4057867	HNGJ1307ANENGD KC725M	S26
4058547	LNEQ1235R03 4 KCK15	U20
4058551	LNEU1240R03SGP 4 KC725M	U20
4058763	LNEQ1240R03 4 KCPK30	U20
4059040	T620M240X300R6H-XL KP6525	M9
4059042	T620M300X350R6H-XL KP6525	M9
4059043	T620M330X350R6H-XL KP6525	M9
4059045	T620M360X400R6H-XL KP6525	M9
4059047	T620M420X450R6H-XL KP6525	M9
4059051	T630M240X300R6HX-XL KP6525	M30
4059053	T630M300X350R6HX-XL KP6525	M30
4059054	T630M330X350R6HX-XL KP6525	M30
4059056	T630M360X400R6HX-XL KP6525	M30
4059058	T630M420X450R6HX-XL KP6525	M30
4059062	T631M240X300R6HX-XL KP6525	M31
4059064	T631M300X350R6HX-XL KP6525	M31
4059065	T631M330X350R6HX-XL KP6525	M31
4059067	T631M360X400R6HX-XL KP6525	M31
4059069	T631M420X450R6HX-XL KP6525	M31
4059090	T620M240X300R6HX-D6 KP6525	M8
4059092	T620M300X350R6HX-D6 KP6525	M8
4059113	T620M330X350R6HX-D6 KP6525	M8
4059115	T620M360X400R6HX-D6 KP6525	M8
4059117	T620M420X450R6HX-D6 KP6525	M8
4059121	T630M300X350R6HX-D6 KP6525	M28
4059122	T630M330X350R6HX-D6 KP6525	M28
4059124	T630M360X400R6HX-D6 KP6525	M28
4059126	T630M420X450R6HX-D6 KP6525	M28
4059129	T631M240X300R6HX-D6 KP6525	M29
4059131	T631M300X350R6HX-D6 KP6525	M29
4059132	T631M330X350R6HX-D6 KP6525	M29
4059134	T631M360X400R6HX-D6 KP6525	M29
4059136	T631M420X450R6HX-D6 KP6525	M29
4059463	KSHR80A04RS45HN13	S25
4059485	KSHR160C09RS45HN13	S25
4059486	KSHR315C18RS45HN13	S25
4059938	LNEU1240R08 4 KC725M	U19
4059939	LNEU1240R16 4 KC725M	U19
4059940	LNEU1235R03 4 KC725M	U19
4059941	LNEU1240R03 4 KC725M	U19
4059942	LNEQ1235R03 4 KC725M	U20
4060093	LNEQ1240R03 4 KC725M	U20
4060099	LNEU1235R03 4 KC520M	U19
4060100	LNEU1240R08 4 KC520M	U19
4060101	LNEU1240R03 4 KC520M	U19
4060102	LNEU1235R03SGP 4 KC725M	U20
4060528	KST115115AS	K38
4060529	KST135155AS	K38
4060912	KSHR200C10RS45HN13	S25
4060933	KSHR250C12RS45HN13	S25
4060934	KSHR315C14RS45HN13	S25
4060935	KSHR100B05RS45HN13	S25
4060936	KSHR125B06RS45HN13	S25
4060937	KSHR200C12RS45HN13	S25
4060938	KSHR250C14RS45HN13	S25
4061407	XNXF1204ZNENW KY3500	S106
4062112	HSK100BT13075	K139
4062443	EBUCW0074	K141
4062902	KTIP260R3SCF25M	H32
4063183	KTIP270R3SCF25M	H32
4063184	KTIP260R5SCF25M	H32
4063185	KTIP270R5SCF25M	H32
4063186	KTIP260R8SCF25M	H32
4063187	KTIP270R8SCF25M	H32
4063188	KTIP260R3SS32M	H31
4063189	KTIP270R3SS32M	H31
4063190	KTIP260R5SS32M	H31
4063191	KTIP270R5SS32M	H31
4063192	KTIP260R8SS32M	H31
4063996	SDB24RBHT06F	K122
4063997	SDB30RBHT06F	K122
4063998	SDB40RBHT09F	K122
4063999	SDB50RBHT09F	K122
4064000	SDB66RBHT12F	K122
4064001	SDB66RBHT12LF	K122
4064002	SDB87RBHT12F	K122
4064203	SDB87RBHT16LF	K122
4064204	SDB115RBHT16LF	K122
4064205	SDB115RBHT12F	K122
4064258	TTP25	S25
4065057	A4G0605M06U08GMN KCP25	C96
4068604	RCMH3209M0RU KCP25	E60
4071037	B967A13000 KC7315	G134
4071041	A4G0505M05U08GMN KCP10	C96
4071068	A4R0505M05U00GMN KCP10	C97
4075269	CNMG120412MP KCP10	B51
4075270	DNMG150408MP KCP10	B79
4075271	DNMG150608MP KCP10	B79
4075304	WNMG080408MP KCP10	B157
4075305	CNMG120408MP KCP25	B51
4075306	CNMG120412MP KCP25	B51
4075307	DNMG150408MP KCP25	B79
4075308	DNMG150608MP KCP25	B79
4075309	TNMG160408MP KCP25	B125
4075310	WNMG060408MP KCP25	B157
4075311	WNMG080408MP KCP25	B157
4078132	B967A15300 KC7315	G134

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
4078652	CNMG120404FP KCP10	B49
4078704	DNMG110408FP KCP10	B77
4078705	DNMG150408FP KCP10	B77
4078706	DNMG150608FP KCP10	B77
4078708	VNMG160408FP KCP10	B145
4078709	WNMG080404FP KCP10	B156
4078710	WNMG080408FP KCP10	B156
4078711	CNMG120408FP KCP25	B49
4078712	DNMG150408FP KCP25	B77
4078723	DNMG150608FP KCP25	B77
4078724	WNMG080404FP KCP25	B156
4078725	WNMG080408FP KCP25	B156
4080356	B967A10200 KC7315	G133
4080393	B967A12800 KC7315	G134
4080395	B967A15000 KC7315	G134
4081832	RIQ09E1306 KC6005	K55
4086429	B976A05558 KC7315	G139
4086430	B977A03454 KC7315	G138
4086431	B977A16670 KC7315	G142
4086935	A4G0405M04U08GMN KCP10	C96
4086956	A4R0405M04U00GMN KCP10	C97
4089831	B967A11300 KC7315	G133
4090567	F3AU0280ADK38 KC643M	P187
4090568	F3AU0380ADK38 KC643M	P187
4090569	F3AU0480ADK38 KC643M	P187
4090570	F3AU0575ADK38 KC643M	P187
4090571	F3AU0775ADK38 KC643M	P187
4090572	F3AU0970ADK38 KC643M	P187
4090773	F3AU1170ADK38 KC643M	P187
4090774	F3AU1370ADK38 KC643M	P187
4090775	F3AU1570ADK38 KC643M	P187
4090776	F3AU1770ADK38 KC643M	P187
4090777	F3AU1970ADK38 KC643M	P187
4090779	F2AU0180ADK38 KC643M	P186
4090780	F2AU0280ADK38 KC643M	P186
4090781	F2AU0380ADK38 KC643M	P186
4090782	F2AU0480ADK38 KC643M	P186
4090783	F2AU0575ADK38 KC643M	P186
4090784	F2AU0775ADK38 KC643M	P186
4090785	F2AU0970ADK38 KC643M	P186
4090786	F2AU1170ADK38 KC643M	P186
4090787	F2AU1370ADK38 KC643M	P186
4090788	F2AU1570ADK38 KC643M	P186
4090789	F2AU1770ADK38 KC643M	P186
4090790	F2AU1970ADK38 KC643M	P186
4102923	MEGA45D200C07LN24	S116
4102924	MEGA45D250C09LN24	S116
4102925	MEGA45D315C10LN24	S116
4106399	B707A07400FBS KN15	G114
4109624	NA3L10 KCU25	D12
4109625	NA3L4 KCU25	D12
4109626	NA3L5 KCU25	D12
4109627	NA3L6 KCU25	D12
4109628	NA3L8 KCU25	D12
4109629	NA3R10 KCU25	D12
4109630	NA3R4 KCU25	D12
4109631	NA3R5 KCU25	D12
4109632	NA3R6 KCU25	D12
4109633	NA3R8 KCU25	D12
4109636	NAS3L4 KCU25	D13
4109637	NAS3L6 KCU25	D13
4109638	NAS3L8 KCU25	D13
4109640	NAS3R12 KCU25	D13
4109641	NAS3R4 KCU25	D13
4109644	NAS3R8 KCU25	D13
4109645	NF3125LK KCU25	C159
4109646	NF3125RK KCU25	C159
4109647	NF3156LK KCU25	C159
4109648	NF3156RK KCU25	C159
4109649	NF3188L KCU25	C161
4109650	NF3188R KCU25	C161
4109651	NFD3125LK KCU25	C160
4109652	NFD3125LKI KCU25	C160
4109653	NFD3125RK KCU25	C160
4109654	NFD3125RKI KCU25	C160
4109655	NFD3189LKI KCU25	C160
4109656	NFD3189RKI KCU25	C160
4109657	NFD4189LK KCU25	C160
4109658	NFD4189RK KCU25	C160
4109659	NFD4250LK KCU25	C160
4109660	NFD4250RK KCU25	C160
4109661	NG2031L KCU25	C155
4109662	NG2031LK KCU25	C147
4109663	NG2031R KCU25	C154
4109664	NG2031RK KCU25	C146
4109665	NG2041L KCU25	C155
4109666	NG2041R KCU25	C154
4109667	NG2047L KCU25	C155
4109668	NG2047LK KCU25	C147
4109669	NG2047R KCU25	C154
4109670	NG2047RK KCU25	C146
4109671	NG2058L KCU25	C155
4109672	NG2058R KCU25	C154
4109673	NG2062L KCU25	C155
4109674	NG2062LK KCU25	C147
4109675	NG2062R KCU25	C154
4109676	NG2062RK KCU25	C146
4109677	NG2094L KCU25	C155
4109678	NG2094LK KCU25	C147
4109679	NG2094R KCU25	C154
4109680	NG2094RK KCU25	C146
4109681	NG2125L KCU25	C155
4109682	NG2125LK KCU25	C148
4109683	NG2125R KCU25	C154
4109684	NG2125RK KCU25	C146
4109685	NG2M050RK KCU25	C146
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4109690	NG2M120LK KCU25	C147
4109691	NG2M120RK KCU25	C146
4109692	NG2M140LK KCU25	C147
4109698	NG3M100LK KCU25	C148
4109699	NG3M100RK KCU25	C146
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4109713	NG3M150RK KCU25	C146
4109714	NG3M175LK KCU25	C148
4109715	NG3M175RK KCU25	C146
4109716	NG3M200LK KCU25	C148
4109717	NG3M200RK KCU25	C146
4109718	NG3M220LK KCU25	C148
4109719	NG3M220RK KCU25	C146
4109720	NG3M225LK KCU25	C148
4109721	NG3M225RK KCU25	C146
4109722	NG3M250LK KCU25	C148
4109723	NG2M140RK KCU25	C146
4109724	NG2M150LK KCU25	C147
4109725	NG2M150RK KCU25	C146
4109726	NG2M170LK KCU25	C147
4109727	NG2M170RK KCU25	C146
4109728	NG2M175LK KCU25	C147
4109729	NG2M175RK KCU25	C146
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4109733	NG3M250RK KCU25	C146
4109734	NG3M275LK KCU25	C148
4109735	NG3M275RK KCU25	C147
4109736	NG3M300LK KCU25	C148
4109737	NG3M300RK KCU25	C147
4109738	NG3M320LK KCU25	C148
4109739	NG3M320RK KCU25	C147
4109740	NG3M325LK KCU25	C148
4109741	NG3M325RK KCU25	C147
4109742	NG3M350LK KCU25	C148
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4109744	NG2M220LK KCU25	C147
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4109755	NG3M400RK KCU25	C147
4109756	NG3M425LK KCU25	C148
4109757	NG3M425RK KCU25	C147
4109758	NG3M450LK KCU25	C148
4109759	NG3M450RK KCU25	C147
4109760	NG4125L KCU25	C155
4109761	NG4125LK KCU25	C148
4109762	NG4125R KCU25	C154
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4109764	NG2M325LK KCU25	C148
4109765	NG2M325RK KCU25	C146
4109766	NG3047L KCU25	C155
4109767	NG3047LK KCU25	C148
4109768	NG3047R KCU25	C154
4109769	NG3047RK KCU25	C146
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4109771	NG3062LK KCU25	C148
4109772	NG3062R KCU25	C154
4109773	NG4125RK KCU25	C147
4109774	NG4189L KCU25	C155
4109775	NG4189LK KCU25	C148
4109776	NG4189R KCU25	C154
4109777	NG4189RK KCU25	C147
4109778	NG4213R KCU25	C154
4109779	NG4250L KCU25	C155
4109780	NG4250LK KCU25	C148
4109781	NG4250R KCU25	C154
4109782	NG4250RK KCU25	C147
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4109787	NG3078RK KCU25	C146
4109788	NG3088L KCU25	C155
4109789	NG3088R KCU25	C154
4109790	NG3094L KCU25	C155
4109791	NG3094LK KCU25	C148
4109792	NG3094R KCU25	C154
4109793	NG4M300LK KCU25	C148
4109794	NG4M300RK KCU25	C147
4109795	NG4M350LK KCU25	C148
4109796	NG4M350RK KCU25	C147
4109797	NG4M400LK KCU25	C148
4109798	NG4M400RK KCU25	C147
4109799	NG4M450RK KCU25	C147
4109800	NG4M500LK KCU25	C148
4109801	NG4M500RK KCU25	C147
4109803	NG3094RK KCU25	C146
4109804	NG3097L KCU25	C155
4109805	NG3097R KCU25	C154
4109806	NG3105L KCU25	C155
4109807	NG3105R KCU25	C154
4109808	NG3110L KCU25	C155
4109809	NG3110R KCU25	C154
4109810	NG3122L KCU25	C155
4109811	NG3122R KCU25	C154
4109812	NG3125L KCU25	C155
4109814	NG4M600LK KCU25	C148
4109815	NG4M600RK KCU25	C147
4109823	NG3125LK KCU25	C148
4109824	NG3125R KCU25	C154
4109825	NG3125RK KCU25	C147
4109826	NG3142L KCU25	C155
4109827	NG3142R KCU25	C154
4109828	NG3156L KCU25	C155
4109829	NG3156LK KCU25	C148
4109830	NG3156R KCU25	C154
4109831	NG3156RK KCU25	C147
4109832	NG3178L KCU25	C155
4109833	NG3185R KCU25	C154
4109834	NG3189L KCU25	C155
4109835	NG3189LK KCU25	C148
4109836	NG3189R KCU25	C154
4109837	NG3189RK KCU25	C147
4109838	NGC2C130L055K KCU25	C152
4109839	NGC2C130R055K KCU25	C152
4109840	NGC2C185L125K KCU25	C152
4109841	NGC2C215L150K KCU25	C152
4109842	NGC2C215R150K KCU25	C152
4109844	NGD3062LK KCU25	C149
4109845	NGD3062RK KCU25	C149
4109846	NGD3094LK KCU25	C149
4109847	NGD3094RK KCU25	C149
4109848	NGD3125LK KCU25	C149
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4109856	NGD4250LK KCU25	C149
4109857	NGD4250RK KCU25	C149
4109858	NJ3010R16 KCU25	D17
4109860	NJ3014R12 KCU25	D17
4109864	NJF3009R18 KCU25	D17
4109866	NJF3012R14 KCU25	D17
4109868	NJK3006R28 KCU25	D18
4109869	NJK3007R24 KCU25	D18
4109871	NJK3008R20 KCU25	D18
4109873	NJK3010R16 KCU25	D18
4109876	NJP3014R12 KCU25	D18
4109878	NJP3020R8 KCU25	D18
4109879	NP2002RK KCU25	C151
4109880	NP2012RK KCU25	C151
4109881	NP3002RK KCU25	C151
4109882	NP3012RK KCU25	C151
4109883	NPD2002RK KCU25	C151
4109884	NPD3002RK KCU25	C151
4109885	NPD3012RK KCU25	C151
4109887	NR2031L KCU25	C158
4109888	NR2031R KCU25	C158
4109889	NR2047L KCU25	C158
4109890	NR2047R KCU25	C158
4109891	NR2062L KCU25	C158
4109892	NR2062R KCU25	C158
4109903	NR2M050L KCU25	C158
4109904	NR2M050R KCU25	C158
4109905	NR3031L KCU25	C158
4109906	NR3031LK KCU25	C150
4109907	NR3031R KCU25	C158
4109908	NR3031RK KCU25	C150
4109909	NR3047L KCU25	C158
4109910	NR3047LK KCU25	C150
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4109914	NR3062LK KCU25	C150
4109915	NR3062R KCU25	C158
4109916	NR3062RK KCU25	C150
4109917	NR3078LK KCU25	C150
4109918	NR3078RK KCU25	C150
4109919	NR3094L KCU25	C158
4109920	NR3094R KCU25	C158
4109921	NR4062LK KCU25	C150
4109922	NR4062RK KCU25	C150
4109923	NR4094LK KCU25	C150
4109924	NR4094RK KCU25	C150
4109925	NR4125L KCU25	C158
4109926	NR4125LK KCU25	C150
4109927	NR4125R KCU25	C158
4109928	NR4125RK KCU25	C150
4109929	NRD3031L KCU25	C159
4109930	NRD3031R KCU25	C159
4109931	NRD3062L KCU25	C159
4109932	NRD3062R KCU25	C159
4109933	NRD4062L KCU25	C159
4109934	NRD4062R KCU25	C159
4109935	NRD4094L KCU25	C159
4109936	NRD4125L KCU25	C159
4109937	NRD4125R KCU25	C159
4109938	NT2L KCU25	D19
4109939	NT2LK KCU25	D24
4109940	NT2R KCU25	D19
4109941	NT2RK KCU25	D24
4109942	NT3L KCU25	D19
4109943	NT3LCK KCU25	D21
4109944	NT3LK KCU25	D24
4109945	NT3R KCU25	D19
4109946	NT3RCK KCU25	D21
4109947	NT3RK KCU25	D24
4109948	NT4L KCU25	D19
4109949	NT4LCK KCU25	D21
4109950	NT4LK KCU25	D24
4109951	NT4R KCU25	D19
4109952	NT4RCK KCU25	D21
4109953	NT4RK KCU25	D24
4109954	NTF2L KCU25	D23

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
4109955	NTF2R KCU25	D23
4109956	NTF3L KCU25	D23
4109957	NTF3R KCU25	D23
4109958	NTK2L KCU25	D23
4109959	NTK2R KCU25	D23
4109960	NTK3L KCU25	D23
4109961	NTK3R KCU25	D23
4109962	NTP2L KCU25	D24
4109963	NTP2R KCU25	D24
4109964	NTP3L KCU25	D24
4109965	NTP3R KCU25	D24
4109967	NTP4R KCU25	D24
4111714	B221A03048HP KCPK15	G46
4111715	B221A03100HP KCPK15	G46
4111716	B221A03175HP KCPK15	G46
4111717	B221A03200HP KCPK15	G46
4111718	B221A03264HP KCPK15	G46
4111719	B221A03300HP KCPK15	G46
4111720	B221A03400HP KCPK15	G46
4111721	B221A03455HP KCPK15	G46
4111722	B221A03500HP KCPK15	G46
4111727	B221A09600HP KCPK15	G48
4111728	B221A09700HP KCPK15	G48
4111729	B221A09800HP KCPK15	G48
4111730	B221A09900HP KCPK15	G48
4111731	B221A09921HP KCPK15	G48
4111732	B221A10000HP KCPK15	G48
4111733	B221A03571HP KCPK15	G46
4111734	B221A03600HP KCPK15	G46
4111736	B221A03700HP KCPK15	G46
4111737	B221A03734HP KCPK15	G46
4111738	B221A03800HP KCPK15	G46
4111739	B221A03900HP KCPK15	G46
4111740	B221A03970HP KCPK15	G46
4111741	B221A04000HP KCPK15	G46
4111742	B221A04039HP KCPK15	G46
4111743	B221A04090HP KCPK15	G46
4111744	B221A04100HP KCPK15	G46
4111745	B221A04200HP KCPK15	G46
4111746	B221A04217HP KCPK15	G46
4111747	B221A04300HP KCPK15	G46
4111748	B221A04366HP KCPK15	G46
4111749	B221A04400HP KCPK15	G46
4111750	B221A04500HP KCPK15	G46
4111751	B221A04600HP KCPK15	G46
4111752	B221A04623HP KCPK15	G46
4111753	B221A04700HP KCPK15	G46
4111754	B221A04763HP KCPK15	G46
4111755	B221A04800HP KCPK15	G46
4111756	B221A04852HP KCPK15	G46
4111757	B221A04900HP KCPK15	G46
4111758	B221A05000HP KCPK15	G46
4111759	B221A05100HP KCPK15	G46
4111760	B221A05106HP KCPK15	G47
4111761	B221A05159HP KCPK15	G47
4111762	B221A05200HP KCPK15	G47
4111763	B221A05300HP KCPK15	G47
4111764	B221A05400HP KCPK15	G47
4111765	B221A05410HP KCPK15	G47
4111766	B221A05500HP KCPK15	G47
4111767	B221A05558HP KCPK15	G47
4111768	B221A05600HP KCPK15	G47
4111769	B221A05616HP KCPK15	G47
4111770	B221A05700HP KCPK15	G47
4111771	B221A05800HP KCPK15	G47
4111772	B221A05900HP KCPK15	G47
4111774	B221A06000HP KCPK15	G47
4111775	B221A06100HP KCPK15	G47
4111776	B221A06200HP KCPK15	G47
4111777	B221A06300HP KCPK15	G47
4111778	B221A06350HP KCPK15	G47
4111779	B221A06400HP KCPK15	G47
4111780	B221A06500HP KCPK15	G47
4111781	B221A06528HP KCPK15	G47
4111782	B221A06600HP KCPK15	G47
4111783	B221A06630HP KCPK15	G47
4111784	B221A06700HP KCPK15	G47
4111785	B221A06746HP KCPK15	G47
4111786	B221A06800HP KCPK15	G47
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4111792	B221A07200HP KCPK15	G47
4111793	B221A07300HP KCPK15	G47
4111794	B221A07400HP KCPK15	G47
4111795	B221A07500HP KCPK15	G47
4111796	B221A07541HP KCPK15	G47
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4111799	B221A07800HP KCPK15	G47
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4111802	B221A08000HP KCPK15	G47
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4111805	B221A08300HP KCPK15	G47
4111806	B221A08334HP KCPK15	G47
4111807	B221A08400HP KCPK15	G47
4111808	B221A08433HP KCPK15	G47
4111809	B221A08500HP KCPK15	G47
4111810	B221A08600HP KCPK15	G47
4111811	B221A08700HP KCPK15	G47
4111812	B221A08733HP KCPK15	G47
4111813	B221A08800HP KCPK15	G48
4111814	B221A08900HP KCPK15	G48
4111815	B221A09000HP KCPK15	G48
4111816	B221A09100HP KCPK15	G48
4111817	B221A09129HP KCPK15	G48
4111818	B221A09200HP KCPK15	G48
4111819	B221A09300HP KCPK15	G48
4111820	B221A09347HP KCPK15	G48
4111821	B221A09400HP KCPK15	G48
4111822	B221A09500HP KCPK15	G48
4111823	B221A09525HP KCPK15	G48
4111824	B221A03000HP KCPK15	G46
4111833	B221A10100HP KCPK15	G48
4111834	B221A10200HP KCPK15	G48
4111835	B221A10300HP KCPK15	G48
4111836	B221A10320HP KCPK15	G48
4111837	B221A10400HP KCPK15	G48
4111838	B221A10500HP KCPK15	G48
4111839	B221A10600HP KCPK15	G48
4111840	B221A10700HP KCPK15	G48
4111841	B221A10716HP KCPK15	G48
4111842	B221A10800HP KCPK15	G48
4111843	B221A10900HP KCPK15	G48
4111844	B221A11000HP KCPK15	G48
4111845	B221A11100HP KCPK15	G48
4111846	B221A11113HP KCPK15	G48
4111847	B221A11200HP KCPK15	G48
4111848	B221A11300HP KCPK15	G48
4111849	B221A11400HP KCPK15	G48
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4111851	B221A11509HP KCPK15	G48
4111852	B221A11600HP KCPK15	G48
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4111854	B221A11800HP KCPK15	G48
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4111944	B222A04500HP KCPK15	G46
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4111946	B222A04763HP KCPK15	G46
4111947	B222A04800HP KCPK15	G46
4111948	B222A05000HP KCPK15	G46
4111949	B222A05100HP KCPK15	G46
4111950	B222A05106HP KCPK15	G47
4111951	B222A05159HP KCPK15	G47
4111952	B222A05410HP KCPK15	G47
4111953	B222A05500HP KCPK15	G47
4111954	B222A05558HP KCPK15	G47
4111955	B222A05800HP KCPK15	G47
4111957	B222A05954HP KCPK15	G47
4111958	B222A06000HP KCPK15	G47
4111959	B222A06350HP KCPK15	G47
4111960	B222A06500HP KCPK15	G47
4111961	B222A06528HP KCPK15	G47
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4111968	B222A07800HP KCPK15	G47
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4111971	B222A08200HP KCPK15	G47
4111972	B222A08334HP KCPK15	G47
4111973	B222A08433HP KCPK15	G47
4111974	B222A08500HP KCPK15	G47
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4111998	B222A12304HP KCPK15	G48
4111999	B222A12500HP KCPK15	G48
4112000	B222A12700HP KCPK15	G48
4112001	B222A13000HP KCPK15	G49
4112002	B222A13500HP KCPK15	G49
4112003	B222A14000HP KCPK15	G49
4112004	B222A14288HP KCPK15	G49
4112005	B222A14500HP KCPK15	G49
4112006	B222A15000HP KCPK15	G49
4112007	B222A15500HP KCPK15	G49
4112008	B222A15875HP KCPK15	G49
4112009	B222A16000HP KCPK15	G49
4112010	B222A16500HP KCPK15	G49
4112011	B222A17000HP KCPK15	G49
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4112013	B222A17500HP KCPK15	G49
4112014	B222A18000HP KCPK15	G49
4112015	B222A18500HP KCPK15	G49
4112016	B222A19000HP KCPK15	G49
4112017	B222A19050HP KCPK15	G49
4112018	B222A20000HP KCPK15	G49
4112019	B222A06700HP KCPK15	G47
4112241	B225A10100HP KCPK15	G53
4112242	B225A10200HP KCPK15	G53
4112416	B224A04496HP KCPK15	G51
4112417	B224A04700HP KCPK15	G51
4112418	B224A05106HP KCPK15	G52
4112419	B224A05600HP KCPK15	G52
4112420	B224A05791HP KCPK15	G52
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4112443	B224A06700HP KCPK15	G52
4112444	B224A06909HP KCPK15	G52
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4112446	B224A07400HP KCPK15	G52
4112447	B224A08839HP KCPK15	G53
4112448	B224A09093HP KCPK15	G53
4112449	B224A09400HP KCPK15	G53
4112450	B224A12800HP KCPK15	G54
4112451	B224A13100HP KCPK15	G54
4112452	B224A13495HP KCPK15	G54
4112453	B224A14500HP KCPK15	G54
4112454	B225A03797HP KCPK15	G51
4112455	B225A04496HP KCPK15	G51
4112456	B225A05106HP KCPK15	G52
4112457	B225A05791HP KCPK15	G52
4112458	B225A05944HP KCPK15	G52
4112459	B225A06909HP KCPK15	G52
4112460	B225A07366HP KCPK15	G52
4112461	B225A08839HP KCPK15	G53
4112462	B225A09093HP KCPK15	G53
4112463	B225A12304HP KCPK15	G54
4112464	B225A13495HP KCPK15	G54
4112465	B225A03048HP KCPK15	G51
4112466	B225A03000HP KCPK15	G51
4112467	B225A03100HP KCPK15	G51
4112468	B225A03175HP KCPK15	G51
4112469	B225A03200HP KCPK15	G51
4112470	B225A03264HP KCPK15	G51
4112471	B225A03300HP KCPK15	G51
4112472	B225A03400HP KCPK15	G51
4112483	B225A10300HP KCPK15	G53
4112484	B225A10320HP KCPK15	G53
4112485	B225A10400HP KCPK15	G53
4112486	B225A10500HP KCPK15	G53

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
4112487	B225A10600HP KCPK15	G53
4112488	B225A10700HP KCPK15	G53
4112489	B225A10716HP KCPK15	G53
4112490	B225A10800HP KCPK15	G53
4112491	B225A10900HP KCPK15	G53
4112492	B225A11000HP KCPK15	G53
4112493	B225A11100HP KCPK15	G53
4112494	B225A11113HP KCPK15	G53
4112495	B225A11200HP KCPK15	G53
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4112498	B225A11500HP KCPK15	G53
4112499	B225A11509HP KCPK15	G53
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4112501	B225A11700HP KCPK15	G53
4112502	B225A11800HP KCPK15	G53
4112503	B225A11900HP KCPK15	G53
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4112507	B225A12200HP KCPK15	G54
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4112510	B225A12500HP KCPK15	G54
4112511	B225A12600HP KCPK15	G54
4112512	B225A12700HP KCPK15	G54
4112513	B225A12800HP KCPK15	G54
4112514	B225A12900HP KCPK15	G54
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4112567	B225A19500HP KCPK15	G55
4112568	B225A20000HP KCPK15	G55
4112569	B225A20500HP KCPK15	G55
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4112692	B224A04090HP KCPK15	G51
4112693	B224A04200HP KCPK15	G51
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4112696	B224A04623HP KCPK15	G51
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4112698	B224A04852HP KCPK15	G51
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4112705	B224A05616HP KCPK15	G52
4112706	B224A05954HP KCPK15	G52
4112707	B224A06000HP KCPK15	G52
4112708	B224A06350HP KCPK15	G52
4112709	B224A06500HP KCPK15	G52
4112710	B224A06630HP KCPK15	G52
4112711	B224A06746HP KCPK15	G52
4112712	B224A06800HP KCPK15	G52
4112713	B224A07000HP KCPK15	G52
4112714	B224A07145HP KCPK15	G52
4112715	B224A07500HP KCPK15	G52
4112716	B224A07541HP KCPK15	G52
4112717	B224A07938HP KCPK15	G52
4112718	B224A08000HP KCPK15	G52
4112719	B224A08200HP KCPK15	G52
4112720	B224A08334HP KCPK15	G53
4112721	B224A08433HP KCPK15	G53
4112722	B224A08500HP KCPK15	G53
4112723	B224A08700HP KCPK15	G53
4112724	B224A08733HP KCPK15	G53
4112725	B224A08800HP KCPK15	G53
4112726	B224A09000HP KCPK15	G53
4112727	B224A09129HP KCPK15	G53
4112728	B224A09500HP KCPK15	G53
4112729	B224A09525HP KCPK15	G53
4112730	B224A09921HP KCPK15	G53
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4112732	B224A10200HP KCPK15	G53
4112733	B224A10300HP KCPK15	G53
4112734	B224A10320HP KCPK15	G53
4112735	B224A10400HP KCPK15	G53
4112736	B224A10500HP KCPK15	G53
4112737	B224A10716HP KCPK15	G53
4112738	B224A10800HP KCPK15	G53
4112739	B224A11000HP KCPK15	G53
4112740	B224A11113HP KCPK15	G53
4112741	B224A11500HP KCPK15	G53
4112742	B224A11509HP KCPK15	G53
4112743	B224A11908HP KCPK15	G53
4112744	B224A12000HP KCPK15	G53
4112745	B224A12300HP KCPK15	G54
4112746	B224A12304HP KCPK15	G54
4112747	B224A12500HP KCPK15	G54
4112748	B224A12700HP KCPK15	G54
4112749	B224A13000HP KCPK15	G54
4112750	B224A13096HP KCPK15	G54
4112751	B224A13500HP KCPK15	G54
4112752	B224A13891HP KCPK15	G54
4112753	B224A14000HP KCPK15	G54
4112754	B224A14288HP KCPK15	G54
4112755	B224A14684HP KCPK15	G54
4112756	B224A15083HP KCPK15	G54
4112758	B224A15500HP KCPK15	G54
4112759	B224A15600HP KCPK15	G54
4112760	B224A15875HP KCPK15	G54
4112761	B224A16000HP KCPK15	G54
4112762	B224A16500HP KCPK15	G54
4112763	B224A17000HP KCPK15	G55
4112764	B224A17463HP KCPK15	G55
4112765	B224A17500HP KCPK15	G55
4112766	B224A18000HP KCPK15	G55
4112767	B224A19000HP KCPK15	G55
4112768	B224A19050HP KCPK15	G55
4112769	B224A20000HP KCPK15	G55
4113708	A4C0155N00CF01 KCU25	C102
4113709	A4C0155R10CF01 KCU25	C103
4113710	A4C0205L06CF02 KCU25	C103
4113711	A4C0205N00CF02 KCU25	C102
4113712	A4C0205R06CF02 KCU25	C103
4113983	KF2X25Z02M12W009	V38
4113984	KF2X32Z03M16W009	V38
4113985	KF2X35Z03M16W009	V38
4113986	KF2X42Z04M16W009	V38
4113987	KF2X25Z02A25W009L140	V39
4113988	KF2X25Z02A25W009L200	V39
4113989	KF2X25Z02A25W009L300	V39
4113990	KF2X28Z02A25W009L200	V39
4113991	KF2X32Z03A32W009L150	V39
4113992	KF2X32Z03A32W009L200	V39
4113993	KF2X32Z03A32W009L300	V39
4113994	KF2X35Z03A32W009L200	V39
4113995	KF2X40Z04W009	V40
4113996	KF2X50Z05W009	V40
4113997	KF2X52Z05W009	V40
4113998	KF2X63Z05W009	V40
4113999	KF2X66Z06W009	V40
4114000	KF2X80Z07W009	V40
4114283	A4C0205R10CF02 KCU25	C103
4114284	A4C0255N00CF02 KCU25	C102
4114285	A4C0305L06CF02 KCU25	C103
4114286	A4C0305L10CF02 KCU25	C103
4114287	A4C0305N00CF02 KCU25	C102
4114288	A4C0305R06CF02 KCU25	C103
4114289	A4C0305R10CF02 KCU25	C103
4114290	A4C0405L06CF02 KCU25	C103
4114291	A4C0405L10CF02 KCU25	C103
4114292	A4C0405N00CF02 KCU25	C102
4114293	A4C0405R06CF02 KCU25	C103
4114294	A4C0405R10CF02 KCU25	C103
4114295	A4G0200M02P02GMP KCU25	C95
4114296	A4G0205M02U02GMN KCU25	C96
4114297	A4G0205M02U02GMP KCU25	C95
4114298	A4G0255M2BU02GMP KCU25	C95
4114299	A4G0300M03P02GMP KCU25	C95
4114300	A4G0300M03P04GMP KCU25	C95
4114301	A4G0305M03U02B KCU25	C98
4114302	A4G0305M03U02GMN KCU25	C96
4114303	A4G0305M03U02GMP KCU25	C95
4114304	A4G0305M03U04GMN KCU25	C96
4114305	A4G0305M03U04GMP KCU25	C95
4114306	A4G0400M04P02GMP KCU25	C95
4114307	A4G0400M04P04GMP KCU25	C95
4114308	A4G0400M04P08GMP KCU25	C95
4114309	A4G0405M04U04GMN KCU25	C96
4114310	A4G0405M04U04GMP KCU25	C95
4114311	A4G0405M04U08GMN KCU25	C96
4114312	A4G0405M04U08GMP KCU25	C95
4114313	A4G0500M05P04GMP KCU25	C95
4114315	A4G0505M05U04B KCU25	C98
4114316	A4G0505M05U04GMN KCU25	C96
4114317	A4G0505M05U04GMP KCU25	C95
4114318	A4G0505M05U08GMN KCU25	C96
4114319	A4G0505M05U08GMP KCU25	C95
4114320	A4G0600M06P04GMP KCU25	C95
4114321	A4G0600M06P08GMP KCU25	C95

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
4114322	A4G0605M06U04B KCU25	C98
4114323	A4G0605M06U04GMN KCU25	C96
4114325	A4G0605M06U08GMN KCU25	C96
4114328	A4G0800M08P08GMP KCU25	C95
4114329	A4G0805M08U08GMN KCU25	C96
4114330	A4G0805M08U08GMP KCU25	C95
4114331	A4G0805M08U12GMN KCU25	C96
4114333	A4G1005M10U08GMN KCU25	C96
4114334	A4G1005M10U08GMP KCU25	C95
4114335	A4G125I03P05GMN KCU25	C97
4114336	A4G125I03P1GMN KCU25	C97
4114337	A4G187I04P1GMN KCU25	C97
4114338	A4G187I04P2GMN KCU25	C97
4114339	A4G250I06P1GMN KCU25	C97
4114340	A4G250I06P2GMN KCU25	C97
4114341	A4G312I08P1GMN KCU25	C97
4114343	A4R0200M02P00GMP KCU25	C96
4114344	A4R0205M02U00GMN KCU25	C97
4114345	A4R0300M03P00GMP KCU25	C96
4114346	A4R0305M03U00GMN KCU25	C97
4114347	A4R0400M04P00GMP KCU25	C96
4114348	A4R0405M04U00GMN KCU25	C97
4114349	A4R0500M05P00GMP KCU25	C96
4114350	A4R0505M05U00GMN KCU25	C97
4114351	A4R0600M06P00GMP KCU25	C96
4114352	A4R0605M06U00GMN KCU25	C97
4114353	A4R0800M08P00GMP KCU25	C96
4114354	A4R0805M08U00GMN KCU25	C97
4114355	A4R1005M10U00GMN KCU25	C97
4114356	A4R125I03P00GMN KCU25	C97
4114357	A4R187I04P00GMN KCU25	C97
4114358	A4R250I06P00GMN KCU25	C97
4114696	B967A09800 KC7315	G133
4114713	B967A11800 KC7315	G134
4115401	DFR040304ST KD1425	J85
4115433	DFT05T308ST KD1425	J85
4115434	DFT06T308ST KD1425	J85
4115435	DFT070408ST KD1425	J85
4115436	DFT090508ST KD1425	J85
4115437	DFT110508ST KD1425	J85
4118347	VCGR160404 KCP25	E34
4119190	HNGJ0604ANENLD KCPK30	S6, S12, S15
4119224	HNGJ0604ANENLD KC725M	S6, S12, S15
4119227	HNGJ0604ANENLD KCK15	S6, S12, S15
4119228	HNPJ0604ANSNHD KCPK30	S7, S13, S16
4119229	HNPJ0604ANSNHD KC725M	S7, S13, S16
4119230	HNPJ0604ANSNHD KCK15	S7, S13, S16
4119253	XNGJ0604ANENLD3W KC725M	S12
4119639	HNGJ060432ANENLD KCPK30	S6, S12, S15
4119640	HNGJ060432ANENLD KC725M	S6, S12, S15
4119696	HNPJ0604ANSNGD KC520M	S7, S13, S16
4119697	HNPJ0604ANSNGD KC522M	S7, S13, S16
4119699	HNPJ0604ANSNGD KCK15	S7, S13, S16
4119700	HNPJ0604ANSNGD KCPK30	S7, S13, S16
4119701	HNPJ0604ANSNGD KC725M	S7, S13, S16
4119702	HNPJ0604ANSNHD KC520M	S7, S13, S16
4119703	HNPJ0604ANSNHD KC522M	S7, S13, S16
4119989	HNPJ060432ANSNHD KC522M	S7, S13, S16
4119991	HNPJ060432ANSNHD KCK15	S7, S13, S16
4119992	HNPJ060432ANSNHD KCPK30	S7, S13, S16
4120003	HNPJ060432ANSNHD KC725M	S7, S13, S16
4120661	A4G0305M03U04GMN KCP25	C96
4121491	B051A14000CPG KC7325	G21
4121505	B052A03300CPG KC7325	G19
4121528	B051A03200CPG KC7325	G19
4121529	B051A04000CPG KC7325	G19
4121532	B051A05900CPG KC7325	G19
4121534	B051A06000CPG KC7325	G20
4121574	HNGJ0604ANFNLDJ K313	S6, S11, S15
4121575	HNGJ0604ANFNLDJ KC410M	S6, S11, S15
4121576	HNGJ0604ANENLD KC510M	S6, S12, S15
4121577	HNGJ0604ANENLD KC520M	S6, S12, S15
4121578	HNGJ0604ANENLD KC522M	S6, S12, S15
4121604	XNGJ0604ANFNLDJ3W KC410M	S11
4121605	XNGJ0604ANENLD3W KC510M	S12
4121607	XNGJ0604ANENLD3W KC522M	S12
4121683	SNMG120408MS KCU25	B99
4121684	SNMG120408RP KCU25	B101
4121685	SNMG120412MS KCU25	B99
4121686	SNMG150608MS KCU25	B99
4121687	SNMG150612MS KCU25	B99
4121688	SNMG150616RP KCU25	B101
4121689	SNMG190612MS KCU25	B99
4121690	SNMG190616RP KCU25	B101
4121695	TNMG160402MS KCU25	B126
4121696	TNMG160404MS KCU25	B126
4121697	TNMG160408MS KCU25	B126
4121698	TNMG160408RP KCU25	B128
4121699	TNMG160412RP KCU25	B128
4121700	TNMG220404MS KCU25	B126
4121701	TNMG220408MS KCU25	B126
4121702	TNMG220408RP KCU25	B128
4121703	TNMG220412MS KCU25	B126
4121704	TNMG220412RP KCU25	B128
4121705	TNMG220416RP KCU25	B128
4121706	TNMG270608MS KCU25	B126
4121707	TNMG270612RP KCU25	B128
4121708	VNGG160402FS KCU25	B143
4121710	VNGG160404FS KCU25	B143
4121711	VNGG160408FS KCU25	B143
4121712	VNMG160402MS KCU25	B146
4121713	VNMG160401MS KCU25	B146
4121714	VNMG160404MS KCU25	B146
4121715	VNMG160408MS KCU25	B146
4121716	VNMG160408RP KCU25	B147
4121717	VNMG160412RP KCU25	B147
4121718	VNMG220404MS KCU25	B146
4121719	VNMG220408MS KCU25	B146
4121720	WNMG060408MS KCU25	B158
4121721	WNMG060408RP KCU25	B159
4121722	WNMG080402MS KCU25	B158
4121723	WNMG080404MS KCU25	B158
4121724	WNMG080408MS KCU25	B158
4121725	WNMG080408RP KCU25	B159
4121726	WNMG080412RP KCU25	B159
4121727	WNMG080416RP KCU25	B159
4122886	KSHR050A05RS45HN06	S10
4122887	KSHR063A04RS45HN06	S10
4122889	KSHR063A06RS45HN06	S10
4124262	KSHR125B16RS45HN06	S10
4124313	KSHR040A05RS45HN06	S10
4124324	UGDE0600A5ARA KC643M	P36
4124325	UGDE0600A5ARB KC643M	P36
4124326	UGDE0600A5ARC KC643M	P36
4124327	UGDE0600A5BRA KC643M	P37
4124328	UGDE0600A5BRB KC643M	P37
4124329	UGDE0600A5BRC KC643M	P37
4124330	UGDE0800A5ARA KC643M	P36
4124331	UGDE0800A5ARB KC643M	P36
4124332	UGDE0800A5ARC KC643M	P36
4124343	UGDE0800A5BRA KC643M	P37
4124344	UGDE0800A5BRB KC643M	P37
4124345	UGDE0800A5BRC KC643M	P37
4124346	UGDE1000A5ARA KC643M	P36
4124347	UGDE1000A5ARB KC643M	P36
4124348	UGDE1000A5ARC KC643M	P36
4124349	UGDE1000A5ARD KC643M	P36
4124350	UGDE1000A5BRA KC643M	P37
4124351	UGDE1000A5BRB KC643M	P37
4124352	UGDE1000A5BRC KC643M	P37
4124353	UGDE1000A5BRD KC643M	P37
4124354	UGDE1200A5ARA KC643M	P36
4124355	UGDE1200A5ARB KC643M	P36
4124356	UGDE1200A5ARC KC643M	P36
4124357	UGDE1200A5ARD KC643M	P36
4124358	UGDE1200A5BRA KC643M	P37
4124359	UGDE1200A5BRB KC643M	P37
4124360	UGDE1200A5BRC KC643M	P37
4124361	UGDE1200A5BRD KC643M	P37
4124362	UGDE1600A5ARA KC643M	P36
4124363	UGDE1600A5ARB KC643M	P36
4124364	UGDE1600A5ARC KC643M	P36
4124365	UGDE1600A5ARD KC643M	P36
4124366	UGDE1600A5ARE KC643M	P36
4124367	UGDE1600A5BRA KC643M	P37
4124368	UGDE1600A5BRB KC643M	P37
4124369	UGDE1600A5BRC KC643M	P37
4124370	UGDE1600A5BRD KC643M	P37
4124371	UGDE1600A5BRE KC643M	P37
4124372	UGDE2000A5ARA KC643M	P36
4124373	UGDE2000A5ARB KC643M	P36
4124374	UGDE2000A5ARC KC643M	P36
4124375	UGDE2000A5ARD KC643M	P36
4124376	UGDE2000A5ARE KC643M	P36
4124377	UGDE2000A5BRA KC643M	P37
4124378	UGDE2000A5BRB KC643M	P37
4124379	UGDE2000A5BRC KC643M	P37
4124380	UGDE2000A5BRD KC643M	P37
4124381	UGDE2000A5BRE KC643M	P37
4124382	UGDE2500A5ARA KC643M	P36
4124383	UGDE2500A5ARB KC643M	P36
4124384	UGDE2500A5ARC KC643M	P36
4124385	UGDE2500A5ARD KC643M	P36
4124386	UGDE2500A5ARE KC643M	P36
4124387	UGDE2500A5BRA KC643M	P37
4124388	UGDE2500A5BRB KC643M	P37
4124389	UGDE2500A5BRC KC643M	P37
4124390	UGDE2500A5BRD KC643M	P37
4124391	UGDE2500A5BRE KC643M	P37
4124962	B051A02000CPG KC7325	G18
4125849	A4G0505M05U04GMN KCP10	C96
4125882	KSHR025D03M16HN06	S8
4126343	KSHR032D03M16HN06	S8
4126344	KSHR032D04M16HN06	S8
4126348	KSHR025D03B20HN06	S8
4126349	KSHR032D03B25HN06	S8
4126350	KSHR032D04B25HN06	S8
4126351	KSHR025D02A20HN06L120	S9
4126352	KSHR025D03A20HN06L120	S9
4126383	KSHR032D03A25HN06L130	S9
4126384	KSHR032D04A25HN06L130	S9
4126386	KSHR025D03A25HN06L200	S9
4126387	KSHR040A04RS45HN06	S10
4126388	KSHR050A04RS45HN06	S10
4126389	KSHR050A06RS45HN06	S10
4126390	KSHR063A08RS45HN06	S10
4126391	KSHR080A05RS45HN06	S10
4126392	KSHR080A08RS45HN06	S10
4126403	KSHR080A10RS45HN06	S10
4126404	KSHR100B06RS45HN06	S10
4126405	KSHR100B09RS45HN06	S10
4126406	KSHR100B12RS45HN06	S10
4126407	KSHR125B08RS45HN06	S10
4126408	KSHR125B12RS45HN06	S10
4129398	RCGX120700E KYS25	B333
4129399	RCGX120700T01020 KYS25	B333
4129400	RPGX090700E KYS25	B334
4129402	RPGX120700E KYS25	B334
4129443	KTIP080R1SS10M	H31
4129444	KTIP085R1SS10M	H31
4129445	KTIP090R1SS10M	H31
4129446	KTIP095R1SS10M	H31
4129447	KTIP100R1SS12M	H31
4129448	KTIP105R1SS12M	H31
4129449	KTIP110R1SS12M	H31
4129450	KTIP115R1SS12M	H31
4129451	KTIP120R1SS14M	H31
4129452	KTIP125R1SS14M	H31
4129453	KTIP130R1SS14M	H31
4129454	KTIP135R1SS14M	H31
4129455	KTIP140R1SS16M	H31
4129456	KTIP145R1SS16M	H31
4129457	KTIP150R1SS16M	H31
4129458	KTIP160R1SS18M	H31
4129459	KTIP170R1SS18M	H31
4129460	KTIP180R1SS20M	H31
4129461	KTIP190R1SS20M	H31
4129462	KTIP200R1SS25M	H31
4129463	KTIP210R1SS25M	H31
4129464	KTIP220R1SS25M	H31
4129465	KTIP230R1SS25M	H31
4129466	KTIP240R1SS25M	H31
4129467	KTIP250R1SS32M	H31
4129468	KTIP260R1SS32M	H31
4129469	KTIP270R1SS32M	H31
4129470	KTIP080R1SCF12M	H32
4129471	KTIP085R1SCF12M	H32
4129472	KTIP090R1SCF12M	H32
4129483	KTIP095R1SCF12M	H32
4129484	KTIP100R1SCF16M	H32
4129485	KTIP105R1SCF16M	H32
4129486	KTIP110R1SCF16M	H32
4129487	KTIP115R1SCF16M	H32
4129488	KTIP120R1SCF16M	H32
4129489	KTIP125R1SCF16M	H32
4129490	KTIP130R1SCF16M	H32
4129491	KTIP135R1SCF16M	H32
4129492	KTIP140R1SCF16M	H32
4129493	KTIP145R1SCF16M	H32
4129494	KTIP150R1SCF20M	H32
4129495	KTIP160R1SCF20M	H32
4129496	KTIP170R1SCF20M	H32
4129497	KTIP180R1SCF25M	H32
4129498	KTIP190R1SCF25M	H32
4129499	KTIP200R1SCF25M	H32
4129500	KTIP210R1SCF25M	H32
4129501	KTIP220R1SCF25M	H32
4129502	KTIP230R1SCF25M	H32
4129503	KTIP240R1SCF25M	H32
4129504	KTIP250R1SCF25M	H32
4129505	KTIP260R1SCF25M	H32
4129506	KTIP270R1SCF25M	H32
4129542	CNGN120416T01020 KYS25	B332
4129546	SNGN120416T01020 KYS25	B335
4129549	SNGN190616E KYS25	B335
4129552	TNGN220412T01020 KYS25	B336
4129553	TNGN220416T01020 KYS25	B336
4129554	CNGA120408E KYS25	B332
4129555	CNGA120408T01020 KYS25	B332
4129557	CNGA120412T01020 KYS25	B332
4129562	SNGA120412T01020 KYS25	B335
4129563	RCGX060400E KYS25	B333
4129567	CNGN120712T01020 KYS25	B332
4129568	CNGX120708T01020 KYS25	B332
4129569	CNGX120712T01020 KYS25	B332
4129570	DNGX150708T01020 KYS25	B333
4129571	DNGX150712T01020 KYS25	B333
4129576	RNGN120700T01025 KYS25	B334
4129577	RCGX120700T01025 KYS25	B333
4129656	MEGA90D125B06LN22	S122
4129657	MEGA90D160C07LN22	S122
4129658	MEGA90D200C07LN22	S122
4129659	MEGA90D200C09LN22	S122
4129660	MEGA90D250C09LN22	S122
4129661	MEGA90D250C11LN22	S122
4129662	MEGA90D315C10LN22	S122
4129664	MEGA90D315C13LN22	S122
4130392	RCGX090700E KYS25	B333
4130423	RCGX090700T01020 KYS25	B333
4132602	1.18025R110	E15
4132633	1.78025L100	E18
4132634	1.78025R100	E18
4132877	B977A06150 KC7315	G139
4133732	RNGN120700T01025 KYS30	B334
4135418	LNPU221012PNSRHD KCPK30	S121, S123
4135419	LNPU221012PNSRHD KCK15	S121, S123
4135420	LNPU221012PNSRHD KC725M	S121, S123
4135435	HNPJ130720ANSNGD KC520M	S26
4135438	HNPJ130735ANSNHD KC520M	S27
4135574	TM711M030X050R2DHA KCU33	M85
4135575	TM711M040X070R2DHA KCU33	M85

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
4135576	TM711M050X080R2DHA KCU33	M85
4135577	TM711M060X100R2DHA KCU33	M85
4135578	TM711M080X125R2DHA KCU33	M85
4135579	TM711M100X150R2DHA KCU33	M85
4135580	TM711M120X175R2DHA KCU33	M85
4135581	TM711M140X200R2DHA KCU33	M85
4135582	TM711M160X200R2DHA KCU33	M85
4135663	TM711M180X250R2DHA KCU33	M85
4135664	TM711M200X250R2DHA KCU33	M85
4135665	TM711MF040X050R2DHA KCU33	M85
4135666	TM711MF050X050R2DHA KCU33	M85
4135667	TM711MF060X075R2DHA KCU33	M85
4135668	TM711MF080X075R2DHA KCU33	M85
4135669	TM711MF080X100R2DHA KCU33	M85
4135670	TM711MF100X100R2DHA KCU33	M85
4135671	TM711MF120X100R2DHA KCU33	M85
4135672	TM711MF120X150R2DHA KCU33	M85
4135673	TM711MF140X150R2DHA KCU33	M85
4135674	TM711MF160X150R2DHA KCU33	M85
4135675	TM711MF180X150R2DHA KCU33	M85
4135676	TM711MF200X150R2DHA KCU33	M85
4135763	TM721M060X100R2DHA KCU32	M87
4135764	TM721M080X125R2DHA KCU32	M87
4135765	TM721M100X150R2DHA KCU32	M87
4135766	TM721M120X175R2DHA KCU32	M87
4135767	TM721M140X200R2DHA KCU32	M87
4135768	TM721M160X200R2DHA KCU32	M87
4135770	TM721MF080X100R2DHA KCU32	M87
4135774	TM721MF120X125R2DHA KCU32	M87
4135776	TM721MF140X150R2DHA KCU32	M87
4135778	TM721NC2500-20R2DHA KCU32	M86
4135779	TM721NC3125-18R2DHA KCU32	M86
4135780	TM721NC3750-16R2DHA KCU32	M86
4135781	TM721NC4375-14R2DHA KCU32	M86
4135782	TM721NC0500-13R2DHA KCU32	M86
4135783	TM721NC5625-12R2DHA KCU32	M86
4135784	TM721NC0625-11R2DHA KCU32	M86
4135823	TM731M040X070R2DHA KCU32	M88
4135824	TM731M050X080R2DHA KCU32	M88
4135825	TM731M060X100R2DHA KCU32	M88
4135826	TM731M080X125R2DHA KCU32	M88
4135827	TM731M100X150R2DHA KCU32	M88
4135828	TM731M120X175R2DHA KCU32	M88
4135830	TM731M160X200R2DHA KCU32	M88
4135832	TM731MF080X100R2DHA KCU32	M88
4136208	B269A03000HP KCPK15	G68
4136209	B269A08500HP KCPK15	G69
4136210	B269A14000HP KCPK15	G70
4137020	A4G0305M03U02GMN KCP25	C96
4137022	A4G0405M04U04GMN KCP25	C96
4137043	A4G0405M04U08GMN KCP25	C96
4137044	A4G0505M05U04GMN KCP25	C96
4137045	A4G0505M05U08GMN KCP25	C96
4137047	A4G0805M08U08GMN KCP25	C96
4137052	A4G0805M08U12GMN KCP25	C96
4137281	CCNC1000A4AH KCN05	P130
4137282	CCNC1000A4BH KCN05	P130
4137443	CCNC1200A4AH KCN05	P130
4137444	CCNC1200A4BH KCN05	P130
4137452	CCNC0600A3AH KCN05	P130
4137453	CCNC0600A3BH KCN05	P130
4137475	CBDB0600AXAS KCN05	P132
4137476	CBDB0600AXBS KCN05	P132
4137477	CBDB1000AXAS KCN05	P132
4137478	CBDB1000AXBS KCN05	P132
4137479	CBDB1200AXAS KCN05	P132
4137480	CBDB1200AXBS KCN05	P132
4137735	CDDC0600A6AH KCN05	P131
4137736	CDDC0600A6BH KCN05	P131
4137737	CDDC1000A6AH KCN05	P131
4137738	CDDC1000A6BH KCN05	P131
4137739	CDDC1200A6AH KCN05	P131
4137740	CDDC1200A6BH KCN05	P131
4138292	TM741M060X100R2DHA KCU36	M90
4138344	TM741M080X125R2DHA KCU36	M90
4138346	TM741M100X150R2DHA KCU36	M90
4138348	TM741MF120X150R2DHA KCU36	M90
4138349	TM741M120X175R2DHA KCU36	M90
4138350	TM741M140X200R2DHA KCU36	M90
4138351	TM741M160X200R2DHA KCU36	M90
4138352	TM741M180X250R2DHA KCU36	M90
4138353	TM741M200X250R2DHA KCU36	M90
4138354	TM741MF100X125R2DHA KCU36	M90
4138355	TM741MF080X100R2DHA KCU36	M90
4138357	TM741MF100X100R2DHA KCU36	M90
4138366	TM741NC2500-20R2DHA KCU36	M89
4138367	TM741NC3125-18R2DHA KCU36	M89
4138368	TM741NC3750-16R2DHA KCU36	M89
4138370	TM741NC0500-13R2DHA KCU36	M89
4138373	TM741NC0750-10R2DHA KCU36	M89
4138374	TM741NF2500-28R2DHA KCU36	M89
4138375	TM741NF3125-24R2DHA KCU36	M89
4138376	TM741NF3750-24R2DHA KCU36	M89
4138378	TM741NF0500-20R2DHA KCU36	M89
4138380	TM741NF0625-18R2DHA KCU36	M89
4138381	TM741NC0750-16R2DHA KCU36	M89
4139437	KSEM1760HPCCLM KC7410	H48
4140842	KSEM3920HPCCLM KC7410	H49
4141558	SSP8	S126
4142614	KSEM2210HPCCLM KC7410	H48
4146399	WNGA080408T01020 KYS30	B336
4146400	WNGA080416T01020 KYS30	B336
4146401	CNGA120408E KYS30	B332
4146402	CNGA120408T01020 KYS30	B332
4146424	CNGA120412T01020 KYS30	B332
4146427	DNGA150408T01020 KYS30	B333
4146428	DNGA150412T01020 KYS30	B333
4146429	SNGA120412T01020 KYS30	B335
4146436	CNGN120712T01020 KYS30	B332
4146437	CNGN120716T01020 KYS30	B332
4146438	RCGX120700T01025 KYS30	B333
4146440	RNGN120400T01020 KYS30	B334
4146442	RNGN120700T00525 KYS30	B334
4146443	RNGN120700T01020 KYS30	B334
4146445	RNGN190700T01020 KYS30	B334
4146446	SNGN120408T01020 KYS30	B335
4146447	SNGN120412T01020 KYS30	B335
4146448	SNGN120416T01020 KYS30	B335
4146451	SNGN120716T01020 KYS30	B335
4146453	SNGN190616T01020 KYS30	B335
4146454	SNGN190724E KYS30	B335
4146459	CNGX120708T01020 KYS30	B332
4146461	CNGX120712T01020 KYS30	B332
4146462	CNGX120716E KYS30	B332
4146464	DNGX150712T01020 KYS30	B333
4146465	DNGX150716T01020 KYS30	B333
4146466	SNGX120712T01020 KYS30	B335
4146467	SNGX120716T01020 KYS30	B335
4146468	RPGN090300E KYS30	B334, V155
4146469	RCGX060400E KYS30	B333
4146470	RCGX090700E KYS30	B333
4146471	RCGX090700T00525 KYS30	B333
4146472	RCGX090700T01020 KYS30	B333
4146473	RCGX120700E KYS30	B333
4146474	RCGX120700T01020 KYS30	B333
4146475	RPGX090700E KYS30	B334
4146476	RPGX090700T01020 KYS30	B334
4146477	RPGX120700E KYS30	B334
4146478	RPGX120700T01020 KYS30	B334
4146482	RNGJ1204M0FLDJ KC422M	V57
4146583	RNGJ1204M0ELD KCPK30	V57
4146584	RNGJ1204M0ELD KC522M	V57
4146585	RNGJ1204M0ELD KC725M	V57
4146586	RNGJ1204M0SGD KCPK30	V57
4146587	RNGJ1204M0SGD KC522M	V57
4146588	RNGJ1204M0SGD KC725M	V57
4147001	KDR32Z03M16RN12	V53
4147002	KDR35Z03M16RN12	V53
4147022	KSHR040A04RS60HN06	S14
4147033	KDR42Z04M16RN12	V53
4147035	KDR32Z03B32RN12	V54
4147037	KDR32Z03A32RN12L200	V55
4147038	KDR32Z02A32RN12L250	V55
4147039	KDR40Z04S16RN12	V56
4147040	KDR50Z04S22RN12	V56
4147041	KDR50Z05S22RN12	V56
4147042	KDR52Z05S22RN12	V56
4147043	KDR63Z05S22RN12	V56
4147044	KDR63Z07S22RN12	V56
4147045	KDR66Z07S27RN12	V56
4147046	KDR80Z06S27RN12	V56
4147047	KDR80Z08S27RN12	V56
4147048	KDR100Z07S32RN12	V56
4147049	KDR100Z09S32RN12	V56
4147458	MEGA60D125B06LN22	S120
4147459	MEGA60D160C07LN22	S120
4147460	MEGA60D200C07LN22	S120
4147461	MEGA60D200C09LN22	S120
4147462	MEGA60D250C09LN22	S120
4147474	RNGJ1204M0SHD KCPK30	V58
4147477	RNGJ1204M0SHD KC725M	V58
4147483	MEGA60D250C11LN22	S120
4147484	MEGA60D315C10LN22	S120
4147485	MEGA60D315C13LN22	S120
4147713	KSHR040A05RS60HN06	S14
4147714	KSHR050A04RS60HN06	S14
4147715	KSHR050A05RS60HN06	S14
4147716	KSHR063A04RS60HN06	S14
4147717	KSHR063A06RS60HN06	S14
4147718	KSHR080A05RS60HN06	S14
4147719	KSHR080A08RS60HN06	S14
4147720	KSHR100B06RS60HN06	S14
4147721	KSHR100B09RS60HN06	S14
4147722	KSHR125B08RS60HN06	S14
4147723	KSHR125B12RS60HN06	S14
4148475	B051A18000CPG KC7325	G22
4148476	B051A18100CPG KC7325	G22
4148477	B051A18200CPG KC7325	G22
4148478	B051A18258CPG KC7325	G22
4148479	B051A18300CPG KC7325	G22
4148480	B051A18400CPG KC7325	G23
4148481	B051A18500CPG KC7325	G23
4148482	B051A18600CPG KC7325	G23
4148583	B051A18654CPG KC7325	G23
4148584	B051A18700CPG KC7325	G23
4148585	B051A18800CPG KC7325	G23
4148586	B051A18900CPG KC7325	G23
4148587	B051A19000CPG KC7325	G23
4148588	B051A19050CPG KC7325	G23
4148589	B051A19100CPG KC7325	G23
4148590	B051A19200CPG KC7325	G23
4148591	B051A19300CPG KC7325	G23
4148592	B051A19400CPG KC7325	G23
4148593	B051A19500CPG KC7325	G23
4148594	B051A19600CPG KC7325	G23
4148595	B051A19700CPG KC7325	G23
4148596	B051A19800CPG KC7325	G23
4148597	B051A19900CPG KC7325	G23
4148598	B051A20000CPG KC7325	G23
4148804	B051A01500CPG KC7325	G18
4148805	B051A01600CPG KC7325	G18
4148806	B051A01700CPG KC7325	G18
4148807	B051A01800CPG KC7325	G18
4148808	B051A01900CPG KC7325	G18
4148809	B051A01984CPG KC7325	G18
4148810	B051A02100CPG KC7325	G18
4148811	B051A02200CPG KC7325	G18
4148812	B051A02300CPG KC7325	G18
4148839	B051F03000CPG KC7325	G24
4148840	B051F03100CPG KC7325	G24
4148841	B051F03200CPG KC7325	G24
4148842	B051F03300CPG KC7325	G24
4148843	B051A02383CPG KC7325	G18
4148844	B051A02400CPG KC7325	G18
4148845	B051A02439CPG KC7325	G18
4148846	B051A02489CPG KC7325	G18
4148847	B051A02500CPG KC7325	G18
4148848	B051A02578CPG KC7325	G18
4148849	B051A02600CPG KC7325	G18
4148850	B051A02642CPG KC7325	G18
4148851	B051A02700CPG KC7325	G18
4148852	B051A02705CPG KC7325	G18
4148853	B051A02779CPG KC7325	G18
4148854	B051A02800CPG KC7325	G18
4148855	B051A02820CPG KC7325	G18
4148856	B051A02870CPG KC7325	G18
4148857	B051A02900CPG KC7325	G18
4148858	B051A02947CPG KC7325	G19
4148872	B269A12500HP KCPK15	G70
4148913	B051F03400CPG KC7325	G24
4148914	B051F03500CPG KC7325	G24
4148915	B051F03600CPG KC7325	G24
4148916	B051F03700CPG KC7325	G24
4148917	B051F03800CPG KC7325	G24
4148918	B051F03900CPG KC7325	G24
4148919	B051F04000CPG KC7325	G24
4148920	B051F04100CPG KC7325	G24
4148921	B051F04200CPG KC7325	G24
4148922	B051F04300CPG KC7325	G24
4148923	B051F04400CPG KC7325	G24
4148924	B051F04500CPG KC7325	G24
4148925	B051F04600CPG KC7325	G24
4148926	B051F04700CPG KC7325	G24
4148927	B051F04800CPG KC7325	G24
4148928	B051F04900CPG KC7325	G24
4148929	B051F05000CPG KC7325	G24
4148930	B051F05100CPG KC7325	G24
4148931	B051F05200CPG KC7325	G24
4148932	B051F05300CPG KC7325	G24
4148933	B051F05400CPG KC7325	G24
4148934	B051F05500CPG KC7325	G24
4148935	B051F05600CPG KC7325	G24
4148936	B051F05700CPG KC7325	G24
4148937	B051F05800CPG KC7325	G24
4148938	B051F05900CPG KC7325	G24
4148939	B051F06000CPG KC7325	G24
4148940	B051F06100CPG KC7325	G24
4148941	B051F06200CPG KC7325	G25
4148942	B051F06300CPG KC7325	G25
4148943	B051F06400CPG KC7325	G25
4148944	B051F06500CPG KC7325	G25
4148945	B051F06600CPG KC7325	G25
4148946	B051F06700CPG KC7325	G25
4148947	B051F06800CPG KC7325	G25
4148948	B051F06900CPG KC7325	G25
4148949	B051F07000CPG KC7325	G25
4148950	B051F07100CPG KC7325	G25
4148951	B051F07200CPG KC7325	G25
4148952	B051F07300CPG KC7325	G25
4148953	B051F07400CPG KC7325	G25
4148954	B051F07500CPG KC7325	G25
4148955	B051F07600CPG KC7325	G25
4148956	B051F07700CPG KC7325	G25
4148957	B051F07800CPG KC7325	G25
4148958	B051F07900CPG KC7325	G25
4148959	B051F08000CPG KC7325	G25
4148960	B051F08100CPG KC7325	G25
4148961	B051F08200CPG KC7325	G25
4148962	B051F08300CPG KC7325	G25
4148963	B051F08400CPG KC7325	G25
4148964	B051F08500CPG KC7325	G25
4148965	B051F08600CPG KC7325	G25
4148966	B051F08700CPG KC7325	G25
4148967	B051F08800CPG KC7325	G25
4148968	B051F08900CPG KC7325	G25
4148969	B051F09000CPG KC7325	G25
4148970	B051F09100CPG KC7325	G25
4148971	B051F09200CPG KC7325	G25
4148972	B051F09300CPG KC7325	G25
4148973	B051F09400CPG KC7325	G25
4148974	B051F09500CPG KC7325	G25
4148975	B051F09600CPG KC7325	G25
4148976	B051F09700CPG KC7325	G25
4148977	B051F09800CPG KC7325	G25
4148978	B051F09900CPG KC7325	G25
4148995	B051F10000CPG KC7325	G25
4148996	B051F10100CPG KC7325	G25
4148997	B051F10200CPG KC7325	G25
4148998	B051F10300CPG KC7325	G25
4148999	B051F10400CPG KC7325	G25
4149000	B051F10500CPG KC7325	G25
4149001	B051F10600CPG KC7325	G25
4149002	B051F10700CPG KC7325	G25
4149013	B051F10800CPG KC7325	G25
4149014	B051F10900CPG KC7325	G25
4149015	B051F11000CPG KC7325	G25
4149016	B051F11100CPG KC7325	G25
4149017	B051F11200CPG KC7325	G25
4149018	B051F11300CPG KC7325	G25
4149019	B051F11400CPG KC7325	G26
4149020	B051F11500CPG KC7325	G26
4149021	B051F11600CPG KC7325	G26
4149022	B051F11700CPG KC7325	G26
4149023	B051F11800CPG KC7325	G26
4149024	B051F11900CPG KC7325	G26
4149025	B051F12000CPG KC7325	G26
4149026	B051F12100CPG KC7325	G26
4149027	B051F12200CPG KC7325	G26

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
4149028	B051F12300CPG KC7325	G26
4149029	B051F12400CPG KC7325	G26
4149030	B051F12500CPG KC7325	G26
4149031	B051F12600CPG KC7325	G26
4149032	B051F12700CPG KC7325	G26
4149033	B051F12800CPG KC7325	G26
4149034	B051F12900CPG KC7325	G26
4149035	B051F13000CPG KC7325	G26
4149036	B051F13100CPG KC7325	G26
4149037	B051F13200CPG KC7325	G26
4149038	B051F13300CPG KC7325	G26
4149039	B051F13400CPG KC7325	G26
4149040	B051F13500CPG KC7325	G26
4149041	B051F13600CPG KC7325	G26
4149042	B051F13700CPG KC7325	G26
4149043	B051F13800CPG KC7325	G26
4149044	B051F13900CPG KC7325	G26
4149045	B051F14000CPG KC7325	G26
4149046	B051F14100CPG KC7325	G26
4149047	B051F14200CPG KC7325	G26
4149048	B051F14300CPG KC7325	G26
4149049	B051F14400CPG KC7325	G26
4149050	B051F14500CPG KC7325	G26
4149051	B051F14600CPG KC7325	G26
4149052	B051F14700CPG KC7325	G26
4149053	B051F14800CPG KC7325	G26
4149054	B051F14900CPG KC7325	G26
4149055	B051F15000CPG KC7325	G26
4149056	B051F15100CPG KC7325	G26
4149057	B051F15200CPG KC7325	G26
4149058	B051F15300CPG KC7325	G26
4149059	B051F15400CPG KC7325	G26
4149060	B051F15500CPG KC7325	G26
4149061	B051F15600CPG KC7325	G26
4149062	B051F15700CPG KC7325	G26
4149063	B051F15800CPG KC7325	G26
4149064	B051F15900CPG KC7325	G26
4149065	B051F16000CPG KC7325	G26
4149066	B051F16100CPG KC7325	G26
4149067	B051F16200CPG KC7325	G26
4149068	B051F16300CPG KC7325	G26
4149069	B051F16400CPG KC7325	G26
4149070	B051F16500CPG KC7325	G26
4149071	B051F16600CPG KC7325	G27
4149072	B051F16700CPG KC7325	G27
4149073	B051F16800CPG KC7325	G27
4149074	B051F16900CPG KC7325	G27
4149075	B051F17000CPG KC7325	G27
4149076	B051F17100CPG KC7325	G27
4149077	B051F17200CPG KC7325	G27
4149078	B051F17300CPG KC7325	G27
4149079	B051F17400CPG KC7325	G27
4149080	B051F17500CPG KC7325	G27
4149081	B051F17600CPG KC7325	G27
4149082	B051F17700CPG KC7325	G27
4149083	B051F17800CPG KC7325	G27
4149084	B051F17900CPG KC7325	G27
4149085	B051F18000CPG KC7325	G27
4149086	B051F18100CPG KC7325	G27
4149087	B051F18200CPG KC7325	G27
4149088	B051F18300CPG KC7325	G27
4149089	B051F18400CPG KC7325	G27
4149090	B051F18500CPG KC7325	G27
4149091	B051F18600CPG KC7325	G27
4149092	B051F18700CPG KC7325	G27
4149093	B051F18800CPG KC7325	G27
4149094	B051F18900CPG KC7325	G27
4149095	B051F19000CPG KC7325	G27
4149096	B051F19100CPG KC7325	G27
4149097	B051F19200CPG KC7325	G27
4149098	B051F19300CPG KC7325	G27
4149099	B051F19400CPG KC7325	G27
4149100	B051F19500CPG KC7325	G27
4149101	B051F19600CPG KC7325	G27
4149102	B051F19700CPG KC7325	G27
4149103	B051F19800CPG KC7325	G27
4149104	B051F19900CPG KC7325	G27
4149105	B051F20000CPG KC7325	G27
4149110	B052A10000CPG KC7325	G21
4149111	B052A10100CPG KC7325	G21
4149112	B052A10200CPG KC7325	G21
4149125	B052A03000CPG KC7325	G19
4149126	B052A03048CPG KC7325	G19
4149128	B052A03100CPG KC7325	G19
4149129	B052A03175CPG KC7325	G19
4149130	B052A03200CPG KC7325	G19
4149131	B052A03264CPG KC7325	G19
4149132	B052A03400CPG KC7325	G19
4149143	B052A01500CPG KC7325	G18
4149144	B052A01600CPG KC7325	G18
4149145	B052A01700CPG KC7325	G18
4149146	B052A01800CPG KC7325	G18
4149147	B052A01900CPG KC7325	G18
4149148	B052A01984CPG KC7325	G18
4149149	B052A02000CPG KC7325	G18
4149150	B052A02100CPG KC7325	G18
4149151	B052A02200CPG KC7325	G18
4149152	B052A02300CPG KC7325	G18
4149153	B052A02383CPG KC7325	G18
4149154	B052A02400CPG KC7325	G18
4149155	B052A02439CPG KC7325	G18
4149156	B052A02489CPG KC7325	G18
4149157	B052A02500CPG KC7325	G18
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4149391	B052F03100CPG KC7325	G24
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4149413	B052A19200CPG KC7325	G23
4149414	B052A19300CPG KC7325	G23
4149415	B052A19400CPG KC7325	G23
4149416	B052A19500CPG KC7325	G23
4149417	B052A19600CPG KC7325	G23

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
4149418	B052A19700CPG KC7325	G23
4149419	B052A19800CPG KC7325	G23
4149420	B052A19900CPG KC7325	G23
4149421	B052A20000CPG KC7325	G23
4149422	B052F10000CPG KC7325	G25
4149423	B052F03300CPG KC7325	G24
4149424	B052F03400CPG KC7325	G24
4149425	B052F03500CPG KC7325	G24
4149426	B052F03600CPG KC7325	G24
4149427	B052F03700CPG KC7325	G24
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4149429	B052F03900CPG KC7325	G24
4149430	B052F04000CPG KC7325	G24
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4149432	B052F04200CPG KC7325	G24
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4149439	B052F04900CPG KC7325	G24
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4149452	B052F06200CPG KC7325	G25
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4149783	B053A14200CPG KC7325	G22

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
4149784	B053A14288CPG KC7325	G22
4149785	B053A14300CPG KC7325	G22
4149786	B053A14400CPG KC7325	G22
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4150462	B051A10700CPG KC7325	G21
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4150516	B041F03100CPG KC7325	G14
4150517	B041F03200CPG KC7325	G14
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4150519	B041F03400CPG KC7325	G14
4150520	B041F03500CPG KC7325	G14
4150521	B041F03600CPG KC7325	G14
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4150533	B041F03800CPG KC7325	G14
4150534	B041F03900CPG KC7325	G14
4150535	B041F04000CPG KC7325	G14
4150536	B041F04100CPG KC7325	G14
4150537	B041F04200CPG KC7325	G14
4150538	B041F04300CPG KC7325	G14
4150539	B041F04400CPG KC7325	G14
4150540	B041F04500CPG KC7325	G14
4150541	B041F04600CPG KC7325	G14
4150542	B041F04700CPG KC7325	G14
4150543	B041F04800CPG KC7325	G14
4150544	B041F04900CPG KC7325	G14
4150545	B041F05000CPG KC7325	G14
4150546	B041F05100CPG KC7325	G14
4150547	B041F05200CPG KC7325	G14
4150548	B041F05300CPG KC7325	G14
4150549	B041F05400CPG KC7325	G14

Index

Order No.	Catalogue No.	Page(s)
4150550	B041F05500CPG KC7325	G14
4150551	B041F05600CPG KC7325	G14
4150552	B041F05700CPG KC7325	G14
4150553	B041F05800CPG KC7325	G14
4150554	B041F05900CPG KC7325	G14
4150555	B041F06000CPG KC7325	G14
4150556	B041F06100CPG KC7325	G14
4150557	B041F06200CPG KC7325	G14
4150558	B041F06300CPG KC7325	G14
4150559	B041F06400CPG KC7325	G14
4150560	B041F06500CPG KC7325	G14
4150561	B041F06600CPG KC7325	G15
4150562	B041F06700CPG KC7325	G15
4150563	B041F06800CPG KC7325	G15
4150564	B041F06900CPG KC7325	G15
4150565	B041F07000CPG KC7325	G15
4150566	B041F07100CPG KC7325	G15
4150567	B041F07200CPG KC7325	G15
4150568	B041F07300CPG KC7325	G15
4150569	B041F07400CPG KC7325	G15
4150570	B041F07500CPG KC7325	G15
4150571	B041F07600CPG KC7325	G15
4150572	B041F07700CPG KC7325	G15
4150573	B041F07800CPG KC7325	G15
4150574	B041F07900CPG KC7325	G15
4150575	B041F08000CPG KC7325	G15
4150576	B041F08100CPG KC7325	G15
4150577	B041F08200CPG KC7325	G15
4150578	B041F08300CPG KC7325	G15
4150579	B041F08400CPG KC7325	G15
4150580	B041F08500CPG KC7325	G15
4150581	B041F08600CPG KC7325	G15
4150582	B041F08700CPG KC7325	G15
4150583	B041F08800CPG KC7325	G15
4150584	B041F08900CPG KC7325	G15
4150585	B041F09000CPG KC7325	G15
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4150587	B041F09200CPG KC7325	G15
4150588	B041F09300CPG KC7325	G15
4150589	B041F09400CPG KC7325	G15
4150590	B041F09500CPG KC7325	G15
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4150594	B041F09900CPG KC7325	G15
4150602	B042A03000CPG KC7325	G9
4150617	B041F10000CPG KC7325	G15
4150618	B041F10100CPG KC7325	G15
4150619	B041F10200CPG KC7325	G15
4150620	B041F10300CPG KC7325	G15
4150621	B041F10400CPG KC7325	G15
4150622	B041F10500CPG KC7325	G15
4150633	B042A03048CPG KC7325	G9
4150634	B042A03100CPG KC7325	G9
4150635	B042A03175CPG KC7325	G9
4150636	B042A03200CPG KC7325	G9
4150637	B042A03264CPG KC7325	G9
4150638	B042A03300CPG KC7325	G9
4150639	B042A03400CPG KC7325	G9
4150640	B042A03455CPG KC7325	G9
4150641	B042A03500CPG KC7325	G9
4150642	B042A03571CPG KC7325	G9
4150643	B042A03600CPG KC7325	G9
4150644	B042A03658CPG KC7325	G9
4150645	B042A03700CPG KC7325	G9
4150646	B042A03734CPG KC7325	G9
4150647	B042A03800CPG KC7325	G9
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4150649	B042A03970CPG KC7325	G9
4150650	B042A04000CPG KC7325	G9
4150651	B042A04039CPG KC7325	G9
4150652	B042A04090CPG KC7325	G9
4150653	B042A04100CPG KC7325	G9
4150654	B042A04200CPG KC7325	G9
4150655	B042A04217CPG KC7325	G9
4150656	B042A04300CPG KC7325	G9
4150657	B042A04366CPG KC7325	G9
4150658	B042A04400CPG KC7325	G9
4150659	B042A04500CPG KC7325	G9
4150660	B042A04600CPG KC7325	G9
4150661	B042A04623CPG KC7325	G9
4150662	B042A04700CPG KC7325	G9
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4150664	B042A04800CPG KC7325	G9
4150665	B042A04852CPG KC7325	G9
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4150668	B042A05100CPG KC7325	G9
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4150670	B042A05159CPG KC7325	G9
4150671	B042A05200CPG KC7325	G9
4150672	B042A05300CPG KC7325	G9
4150673	B042A05400CPG KC7325	G9
4150674	B042A05410CPG KC7325	G9
4150675	B042A05500CPG KC7325	G9
4150676	B042A05558CPG KC7325	G9
4150677	B042A05600CPG KC7325	G10
4150678	B042A05616CPG KC7325	G10
4150679	B042A05700CPG KC7325	G10
4150680	B042A05800CPG KC7325	G10
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4150837	B042A18100CPG KC7325	G13
4150838	B042A18200CPG KC7325	G13
4150839	B042A18258CPG KC7325	G13
4150840	B042A18300CPG KC7325	G13
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4150842	B042A18500CPG KC7325	G13
4150873	B042A18600CPG KC7325	G13
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4150875	B042A18700CPG KC7325	G13
4150876	B042A18800CPG KC7325	G13
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4150881	B042A19200CPG KC7325	G13
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4150886	B042A19700CPG KC7325	G13
4150887	B042A19800CPG KC7325	G13
4150888	B042A19900CPG KC7325	G13
4150889	B042A20000CPG KC7325	G13
4150890	B042F03000CPG KC7325	G14
4150891	B042F03100CPG KC7325	G14
4150892	B042F03200CPG KC7325	G14
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4150918	B042F04800CPG KC7325	G14
4150919	B042F04900CPG KC7325	G14
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4150922	B042F05200CPG KC7325	G14
4150923	B042F05300CPG KC7325	G14
4150924	B042F05400CPG KC7325	G14
4150925	B042F05500CPG KC7325	G14
4150926	B042F05600CPG KC7325	G14
4150927	B042F05700CPG KC7325	G14
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4150931	B042F06100CPG KC7325	G14
4150932	B042F06200CPG KC7325	G14
4150933	B042F06300CPG KC7325	G14
4150934	B042F06400CPG KC7325	G14
4150935	B042F06500CPG KC7325	G14
4150936	B042F06600CPG KC7325	G15
4150937	B042F06700CPG KC7325	G15
4150938	B042F06800CPG KC7325	G15
4150939	B042F06900CPG KC7325	G15
4150940	B042F07000CPG KC7325	G15
4150941	B042F07100CPG KC7325	G15
4150942	B042F07200CPG KC7325	G15
4150943	B042F07300CPG KC7325	G15
4150944	B042F07400CPG KC7325	G15
4150945	B042F07500CPG KC7325	G15
4150946	B042F07600CPG KC7325	G15
4150947	B042F07700CPG KC7325	G15
4150948	B042F07800CPG KC7325	G15
4150949	B042F07900CPG KC7325	G15
4150950	B042F08000CPG KC7325	G15

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
4150951	B042F08100CPG KC7325	G15
4150952	B042F08200CPG KC7325	G15
4150953	B042F08300CPG KC7325	G15
4150954	B042F08400CPG KC7325	G15
4150955	B042F08500CPG KC7325	G15
4150956	B042F08600CPG KC7325	G15
4150957	B042F08700CPG KC7325	G15
4150958	B042F08800CPG KC7325	G15
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4150998	B042F11800CPG KC7325	G16
4150999	B042F11900CPG KC7325	G16
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4151001	B042F12100CPG KC7325	G16
4151002	B042F12200CPG KC7325	G16
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4151004	B042F12400CPG KC7325	G16
4151005	B042F12500CPG KC7325	G16
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4151009	B042F12900CPG KC7325	G16
4151010	B042F13000CPG KC7325	G16
4151011	B042F13100CPG KC7325	G16
4151012	B042F13200CPG KC7325	G16
4151013	B042F13300CPG KC7325	G16
4151014	B042F13400CPG KC7325	G16
4151015	B042F13500CPG KC7325	G16
4151016	B042F13600CPG KC7325	G16
4151017	B042F13700CPG KC7325	G16
4151018	B042F13800CPG KC7325	G16
4151019	B042F13900CPG KC7325	G16
4151020	B042F14000CPG KC7325	G16
4151021	B042F14100CPG KC7325	G16
4151022	B042F14200CPG KC7325	G16
4151023	B042F14300CPG KC7325	G16
4151024	B042F14400CPG KC7325	G16
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4151026	B042F14600CPG KC7325	G16
4151027	B042F14700CPG KC7325	G16
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4151029	B042F14900CPG KC7325	G16
4151030	B042F15000CPG KC7325	G16
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4151458	B041F12100CPG KC7325	G16
4151459	B041F12200CPG KC7325	G16
4151460	B041F12300CPG KC7325	G16

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
4151461	B041F12400CPG KC7325	G16
4151462	B041F12500CPG KC7325	G16
4151463	B041F12600CPG KC7325	G16
4151464	B041F12700CPG KC7325	G16
4151465	B041F12800CPG KC7325	G16
4151466	B041F12900CPG KC7325	G16
4151467	B041F13000CPG KC7325	G16
4151468	B041F13100CPG KC7325	G16
4151469	B041F13200CPG KC7325	G16
4151470	B041F13300CPG KC7325	G16
4151471	B041F13400CPG KC7325	G16
4151472	B041F13500CPG KC7325	G16
4151473	B041F13600CPG KC7325	G16
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4151802	B042A02500CPG KC7325	G8
4151803	B042A02578CPG KC7325	G8
4151804	B042A02600CPG KC7325	G8
4151805	B042A02642CPG KC7325	G8
4151806	B042A02700CPG KC7325	G8
4151807	B042A02705CPG KC7325	G9
4151808	B042A02779CPG KC7325	G9
4151809	B042A02800CPG KC7325	G9
4151810	B042A02820CPG KC7325	G9
4151811	B042A02870CPG KC7325	G9
4151812	B042A02900CPG KC7325	G9
4151813	B042A02947CPG KC7325	G9
4152204	UEBC0200A2A KC643M	P194
4152205	UEBC0300A2A KC643M	P194
4152206	UEBC0400A2A KC643M	P194
4152207	UEBC0500A2A KC643M	P194
4152208	UEBC0600A2A KC643M	P194
4152209	UEBC0800A2A KC643M	P194
4152210	UEBC1000A2A KC643M	P194
4152211	UEBC1200A2A KC643M	P194
4153687	KSHRHF025D03M16HN06	S4
4153689	KSHRHF032D04M16HN06	S4
4153703	KSHRHF025D03A20HN06L120	S4
4153704	KSHRHF032D03A25HN06L130	S4
4153706	KSHRHF040A05RS15HN06	S5
4153707	KSHRHF050A05RS15HN06	S5
4153708	KSHRHF063A06RS15HN06	S5
4153709	KSHRHF080A08RS15HN06	S5
4153778	T321M100X150R6HX KC7542	M5
4153779	T321M120X175R6HX KC7542	M5
4153780	T321M140X200R6HX KC7542	M5
4153781	T321M160X200R6HX KC7542	M5
4153782	T321MF120X150R6HX KC7542	M5
4153874	T650M240X300R6HX-D6 KP6525	M32
4153875	T650M300X350R6HX-D6 KP6525	M32
4153876	T650M330X350R6HX-D6 KP6525	M32
4153877	T650M360X400R6HX-D6 KP6525	M32
4153878	T650M420X450R6HX-D6 KP6525	M32
4153879	T650M240X300R6HX-XL KP6525	M34
4153880	T650M300X350R6HX-XL KP6525	M34
4153881	T650M330X350R6HX-XL KP6525	M34
4153882	T650M360X400R6HX-XL KP6525	M34
4153883	T650M420X450R6HX-XL KP6525	M34
4153884	T651M240X300R6HX-D6 KP6525	M33
4153885	T651M300X350R6HX-D6 KP6525	M33
4153886	T651M330X350R6HX-D6 KP6525	M33
4153887	T651M360X400R6HX-D6 KP6525	M33
4153888	T651M420X450R6HX-D6 KP6525	M33
4153889	T651M240X300R6HX-XL KP6525	M35
4153890	T651M300X350R6HX-XL KP6525	M35
4153891	T651M330X350R6HX-XL KP6525	M35
4153892	T651M360X400R6HX-XL KP6525	M35
4153893	T651M420X450R6HX-XL KP6525	M35
4153903	T321MF140X150R6HX KC7542	M5
4154007	T632M050X080R6HX-D1 KP6525	M26
4154008	T632M060X100R6HX-D1 KP6525	M26
4154009	T632M080X125R6HX-D1 KP6525	M26
4154010	T632M100X150R6HX-D1 KP6525	M26
4154011	T632M120X175R6HX-D6 KP6525	M26
4154012	T632M140X200R6HX-D6 KP6525	M26
4154013	T632MF120X150R6HX-D4 KP6525	M26
4154014	T632MF140X150R6HX-D4 KP6525	M26
4154015	T632MF160X150R6HX-D4 KP6525	M26
4154016	T633M050X080R6HX-D1 KP6525	M27
4154017	T633M060X100R6HX-D1 KP6525	M27
4154018	T633M080X125R6HX-D1 KP6525	M27
4154019	T633M100X150R6HX-D1 KP6525	M27
4154020	T633M120X175R6HX-D6 KP6525	M27
4154021	T633M140X200R6HX-D6 KP6525	M27
4154022	T633MF120X150R6HX-D4 KP6525	M27
4154023	T633MF140X150R6HX-D4 KP6525	M27
4154024	T633MF160X150R6HX-D4 KP6525	M27
4154103	T600M030X050R6HX-D1 KSP21	M13
4154104	T600M040X070R6HX-D1 KSP21	M13
4154105	T600M050X080R6HX-D1 KSP21	M13
4154106	T600M060X100R6HX-D1 KSP21	M13
4154107	T600M080X125R6HX-D1 KSP21	M13
4154108	T600M100X150R6HX-D1 KSP21	M13
4154109	T600M120X175R6HX-D6 KSP21	M13
4154110	T600M140X200R6HX-D6 KSP21	M13
4154111	T600M160X200R6HX-D6 KSP21	M13
4154112	T600M180X250R6HX-D6 KSP21	M13
4154113	T600M200X250R6HX-D6 KSP21	M13
4154114	T600MF080X100R6HX-D4 KSP21	M13
4154115	T600MF100X100R6HX-D4 KSP21	M13
4154116	T600MF100X125R6HX-D4 KSP21	M13
4154117	T600MF120X125R6HX-D4 KSP21	M13
4154118	T600MF120X150R6HX-D4 KSP21	M13
4154119	T600MF140X150R6HX-D4 KSP21	M13
4154120	T600MF160X150R6HX-D4 KSP21	M13
4154647	T622M030X050R6HX-D74 KSN28	M74
4154648	T622M040X070R6HX-D74 KSN28	M74
4154649	T622M050X080R6HX-D74 KSN28	M74
4154650	T622M060X100R6HX-D74 KSN28	M74
4154651	T622M080X125R6HX-D74 KSN28	M74
4154652	T622M100X150R6HX-D74 KSN28	M74
4154693	T622M120X175R6HX-D74 KSN28	M74
4154694	T622M160X200R6HX-D74 KSN28	M74
4154695	T622MF080X100R6HX-D74 KSN28	M74
4154696	T622MF100X100R6HX-D74 KSN28	M74
4154697	T622MF100X125R6HX-D74 KSN28	M74
4154698	T622MF120X125R6HX-D74 KSN28	M74
4154699	T622MF120X150R6HX-D74 KSN28	M74
4154700	T622MF140X150R6HX-D74 KSN28	M74
4154701	T622MF160X150R6HX-D74 KSN28	M74
4155723	EDPT140408PDSRGD2 KC725M	T54, T63
4155725	EDPT140408PDSRGD2 KCPK30	T54, T63
4155726	EDPT140408PDSRGD2 KC520M	T54, T63
4156131	UGDE1400A5ARD KC643M	P36
4156132	UGDE1400A5BRD KC643M	P37
4156451	T642M050X080R6HX-D1 KP6525	M65
4156452	T642M060X100R6HX-D1 KP6525	M65
4156543	T642M080X125R6HX-D1 KP6525	M65
4156544	T642M100X150R6HX-D1 KP6525	M65
4156545	T642M120X175R6HX-D6 KP6525	M65
4156546	T642M140X200R6HX-D6 KP6525	M65
4156547	T642MF120X150R6HX-D4 KP6525	M65
4156548	T642MF140X150R6HX-D4 KP6525	M65
4156549	T642MF160X150R6HX-D4 KP6525	M65
4156550	T643M050X080R6HX-D1 KP6525	M66
4156551	T643M060X100R6HX-D1 KP6525	M66
4156552	T643M080X125R6HX-D1 KP6525	M66
4156553	T643M100X150R6HX-D1 KP6525	M66
4156554	T643M120X175R6HX-D6 KP6525	M66
4156555	T643M140X200R6HX-D6 KP6525	M66
4156556	T643MF120X150R6HX-D4 KP6525	M66
4156557	T643MF140X150R6HX-D4 KP6525	M66
4156558	T643MF160X150R6HX-D4 KP6525	M66
4157734	T410M030X050R6HX-D1 KCU36	M62
4157735	T410M040X070R6HX-D1 KCU36	M62
4157736	T410M050X080R6HX-D1 KCU36	M62
4157737	T410M060X100R6HX-D1 KCU36	M62
4157738	T410M080X125R6HX-D1 KCU36	M62
4157739	T410M100X150R6HX-D1 KCU36	M62
4157740	T410M120X175R6HX-D6 KCU36	M62
4157741	T410M140X200R6HX-D6 KCU36	M62
4157742	T410MF080X100R6HX-D4 KCU36	M62
4157963	T410MF100X100R6HX-D4 KCU36	M62
4157964	T410MF120X150R6HX-D4 KCU36	M62
4157965	T410MF140X150R6HX-D4 KCU36	M62
4157966	T410MF160X150R6HX-D4 KCU36	M62
4158449	T622M030X050R6HX-D74 KSP21	M74
4158450	T622M040X070R6HX-D74 KSP21	M74
4158451	T622M050X080R6HX-D74 KSP21	M74
4158452	T622M060X100R6HX-D74 KSP21	M74
4158483	T622M080X125R6HX-D74 KSP21	M74
4158484	T622M100X150R6HX-D74 KSP21	M74
4158485	T622M120X175R6HX-D74 KSP21	M74
4158486	T622M160X200R6HX-D74 KSP21	M74
4158487	T622MF080X100R6HX-D74 KSP21	M74
4158488	T622MF100X100R6HX-D74 KSP21	M74
4158489	T622MF100X125R6HX-D74 KSP21	M74
4158490	T622MF120X125R6HX-D74 KSP21	M74
4158491	T622MF120X150R6HX-D74 KSP21	M74
4158492	T622MF140X150R6HX-D74 KSP21	M74
4158493	T622MF160X150R6HX-D74 KSP21	M74

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
4158728	KTIP0794HPM KCP15	H26
4158729	KTIP0800HPM KCP15	H26
4158730	KTIP0810HPM KCP15	H26
4158731	KTIP0816HPM KCP15	H26
4158732	KTIP0820HPM KCP15	H26
4158893	KTIP0830HPM KCP15	H26
4158894	KTIP0833HPM KCP15	H26
4158895	KTIP0840HPM KCP15	H26
4158896	KTIP0843HPM KCP15	H26
4158897	KTIP0850HPM KCP15	H26
4158898	KTIP0860HPM KCP15	H26
4158899	KTIP0861HPM KCP15	H26
4158900	KTIP0870HPM KCP15	H26
4158901	KTIP0873HPM KCP15	H26
4158902	KTIP0880HPM KCP15	H26
4158903	KTIP0884HPM KCP15	H26
4158904	KTIP0890HPM KCP15	H26
4158905	KTIP0900HPM KCP15	H26
4158906	KTIP0909HPM KCP15	H26
4158907	KTIP0910HPM KCP15	H26
4158908	KTIP0913HPM KCP15	H26
4158909	KTIP0920HPM KCP15	H26
4158910	KTIP0930HPM KCP15	H26
4158911	KTIP0935HPM KCP15	H26
4158912	KTIP0940HPM KCP15	H26
4158913	KTIP0950HPM KCP15	H26
4158914	KTIP0953HPM KCP15	H26
4158915	KTIP0956HPM KCP15	H26
4158916	KTIP0958HPM KCP15	H26
4158917	KTIP0960HPM KCP15	H26
4158918	KTIP0970HPM KCP15	H26
4158919	KTIP0980HPM KCP15	H26
4158920	KTIP0990HPM KCP15	H26
4158921	KTIP0992HPM KCP15	H26
4158922	KTIP1000HPM KCP15	H26
4158923	KTIP1002HPM KCP15	H26
4158924	KTIP1008HPM KCP15	H26
4158925	KTIP1010HPM KCP15	H26
4158926	KTIP1020HPM KCP15	H26
4158927	KTIP1026HPM KCP15	H26
4158928	KTIP1030HPM KCP15	H26
4158929	KTIP1032HPM KCP15	H26
4158930	KTIP1040HPM KCP15	H26
4158931	KTIP1049HPM KCP15	H26
4158932	KTIP1050HPM KCP15	H26
4158933	KTIP1060HPM KCP15	H26
4158934	KTIP1070HPM KCP15	H26
4158935	KTIP1072HPM KCP15	H26
4158936	KTIP1080HPM KCP15	H26
4158937	KTIP1090HPM KCP15	H26
4158938	KTIP1100HPM KCP15	H26
4158939	KTIP1110HPM KCP15	H26
4158940	KTIP1111HPM KCP15	H26
4158941	KTIP1120HPM KCP15	H26
4158942	KTIP1130HPM KCP15	H26
4158943	KTIP1140HPM KCP15	H26
4158944	KTIP1150HPM KCP15	H26
4158945	KTIP1151HPM KCP15	H26
4158946	KTIP1160HPM KCP15	H26
4158947	KTIP1170HPM KCP15	H26
4158948	KTIP1180HPM KCP15	H26
4158949	KTIP1190HPM KCP15	H26
4158950	KTIP1191HPM KCP15	H27
4158951	KTIP1200HPM KCP15	H27
4158952	KTIP1210HPM KCP15	H27
4158953	KTIP1220HPM KCP15	H27
4158954	KTIP1230HPM KCP15	H27
4158955	KTIP1240HPM KCP15	H27
4158956	KTIP1247HPM KCP15	H27
4158957	KTIP1250HPM KCP15	H27
4158958	KTIP1260HPM KCP15	H27
4158959	KTIP1270HPM KCP15	H27
4158960	KTIP1280HPM KCP15	H27
4158961	KTIP1290HPM KCP15	H27
4158962	KTIP1300HPM KCP15	H27
4158963	KTIP1310HPM KCP15	H27
4158964	KTIP1320HPM KCP15	H27
4158965	KTIP1330HPM KCP15	H27
4158966	KTIP1340HPM KCP15	H27
4158967	KTIP1349HPM KCP15	H27
4158968	KTIP1350HPM KCP15	H27
4158969	KTIP1360HPM KCP15	H27
4158970	KTIP1370HPM KCP15	H27
4158971	KTIP1380HPM KCP15	H27
4158972	KTIP1389HPM KCP15	H27
4158973	KTIP1390HPM KCP15	H27
4158974	KTIP1400HPM KCP15	H27
4158975	KTIP1410HPM KCP15	H27
4158976	KTIP1420HPM KCP15	H27
4158977	KTIP1429HPM KCP15	H27
4158978	KTIP1430HPM KCP15	H27
4158979	KTIP1440HPM KCP15	H27
4158980	KTIP1450HPM KCP15	H27
4158981	KTIP1460HPM KCP15	H27
4158982	KTIP1467HPM KCP15	H27
4158983	KTIP1468HPM KCP15	H27
4158984	KTIP1470HPM KCP15	H27
4158985	KTIP1480HPM KCP15	H27
4158986	KTIP1500HPM KCP15	H27
4158987	KTIP1508HPM KCP15	H27
4159030	KTIP1520HPM KCP15	H27
4159031	KTIP1530HPM KCP15	H27
4159032	KTIP1540HPM KCP15	H27
4159205	KTIP1510HPM KCP15	H27
4159223	KTIP1548HPM KCP15	H27
4159224	KTIP1550HPM KCP15	H27
4159225	KTIP1560HPM KCP15	H27
4159226	KTIP1570HPM KCP15	H27
4159227	KTIP1580HPM KCP15	H27
4159228	KTIP1588HPM KCP15	H27
4159229	KTIP1600HPM KCP15	H27
4159230	KTIP1603HPM KCP15	H27
4159231	KTIP1608HPM KCP15	H27
4159232	KTIP1610HPM KCP15	H27
4159233	KTIP1620HPM KCP15	H27
4159234	KTIP1627HPM KCP15	H27
4159235	KTIP1630HPM KCP15	H27
4159236	KTIP1640HPM KCP15	H27
4159237	KTIP1650HPM KCP15	H27
4159238	KTIP1660HPM KCP15	H27
4159239	KTIP1667HPM KCP15	H27
4159240	KTIP1670HPM KCP15	H27
4159241	KTIP1680HPM KCP15	H27
4159242	KTIP1690HPM KCP15	H27
4159243	KTIP1700HPM KCP15	H27
4159244	KTIP1707HPM KCP15	H27
4159245	KTIP1710HPM KCP15	H27
4159246	KTIP1720HPM KCP15	H27
4159247	KTIP1730HPM KCP15	H27
4159248	KTIP1740HPM KCP15	H27
4159249	KTIP1748HPM KCP15	H27
4159250	KTIP1750HPM KCP15	H27
4159251	KTIP1760HPM KCP15	H27
4159252	KTIP1770HPM KCP15	H27
4159253	KTIP1780HPM KCP15	H27
4159254	KTIP1786HPM KCP15	H27
4159255	KTIP1790HPM KCP15	H27
4159256	KTIP1800HPM KCP15	H27
4159257	KTIP1810HPM KCP15	H27
4159258	KTIP1820HPM KCP15	H27
4159259	KTIP1826HPM KCP15	H27
4159260	KTIP1850HPM KCP15	H27
4159261	KTIP1860HPM KCP15	H27
4159262	KTIP1865HPM KCP15	H27
4159263	KTIP1870HPM KCP15	H27
4159264	KTIP1880HPM KCP15	H27
4159265	KTIP1890HPM KCP15	H27
4159266	KTIP1900HPM KCP15	H27
4159267	KTIP1905HPM KCP15	H27
4159268	KTIP1910HPM KCP15	H27
4159269	KTIP1920HPM KCP15	H27
4159270	KTIP1923HPM KCP15	H27
4159271	KTIP1925HPM KCP15	H27
4159272	KTIP1930HPM KCP15	H27
4159273	KTIP1940HPM KCP15	H27
4159274	KTIP1946HPM KCP15	H27
4159275	KTIP1950HPM KCP15	H27
4159276	KTIP1960HPM KCP15	H27
4159277	KTIP1970HPM KCP15	H28
4159278	KTIP1980HPM KCP15	H28
4159279	KTIP1984HPM KCP15	H28
4159280	KTIP1990HPM KCP15	H28
4159281	KTIP2000HPM KCP15	H28
4159282	KTIP2010HPM KCP15	H28
4159283	KTIP2020HPM KCP15	H28
4159284	KTIP2024HPM KCP15	H28
4159285	KTIP2030HPM KCP15	H28
4159286	KTIP2050HPM KCP15	H28
4159287	KTIP2060HPM KCP15	H28
4159288	KTIP2064HPM KCP15	H28
4159289	KTIP2070HPM KCP15	H28
4159290	KTIP2080HPM KCP15	H28
4159291	KTIP2090HPM KCP15	H28
4159292	KTIP2099HPM KCP15	H28
4159293	KTIP2100HPM KCP15	H28
4159294	KTIP2143HPM KCP15	H28
4159295	KTIP2150HPM KCP15	H28
4159296	KTIP2200HPM KCP15	H28
4159297	KTIP2223HPM KCP15	H28
4159298	KTIP2250HPM KCP15	H28
4159299	KTIP2300HPM KCP15	H28
4159300	KTIP2350HPM KCP15	H28
4159301	KTIP2381HPM KCP15	H28
4159302	KTIP2400HPM KCP15	H28
4159303	KTIP2450HPM KCP15	H28
4159304	KTIP2461HPM KCP15	H28
4159305	KTIP2500HPM KCP15	H28
4159306	KTIP2540HPM KCP15	H28
4159307	KTIP2550HPM KCP15	H28
4159308	KTIP2567HPM KCP15	H28
4159309	KTIP2581HPM KCP15	H28
4159310	KTIP2599HPM KCP15	H28
4159311	KTIP2600HPM KCP15	H28
4159312	KTIP2619HPM KCP15	H28
4159313	KTIP2650HPM KCP15	H28
4159314	KTIP2659HPM KCP15	H28
4159315	KTIP2700HPM KCP15	H28
4159316	KTIP2750HPM KCP15	H28
4159317	KTIP2778HPM KCP15	H28
4159318	KTIP2799HPM KCP15	H28
4159441	T623M050X080R6HX-D74 KSN28	M75
4159442	T623M060X100R6HX-D74 KSN28	M75
4159623	T623M080X125R6HX-D74 KSN28	M75
4159624	T623M100X150R6HX-D74 KSN28	M75
4159625	T623M120X175R6HX-D74 KSN28	M75
4159626	T623M160X200R6HX-D74 KSN28	M75
4159627	T623MF080X100R6HX-D74 KSN28	M75
4159628	T623MF100X100R6HX-D74 KSN28	M75
4159629	T623MF120X150R6HX-D74 KSN28	M75
4159630	T623MF140X150R6HX-D74 KSN28	M75
4159631	T623MF160X150R6HX-D74 KSN28	M75
4159820	T623M050X080R6HX-D74 KSP21	M75
4159821	T623M060X100R6HX-D74 KSP21	M75
4159822	T623M080X125R6HX-D74 KSP21	M75
4159843	T623M100X150R6HX-D74 KSP21	M75
4159844	T623M120X175R6HX-D74 KSP21	M75
4159845	T623M160X200R6HX-D74 KSP21	M75
4159846	T623MF080X100R6HX-D74 KSP21	M75
4159847	T623MF100X100R6HX-D74 KSP21	M75
4159848	T623MF120X150R6HX-D74 KSP21	M75
4159849	T623MF140X150R6HX-D74 KSP21	M75
4159850	T623MF160X150R6HX-D74 KSP21	M75
4159851	T670M030X050R6H-D1 KSN38	M12
4159852	T670M040X070R6H-D1 KSN38	M12
4159933	T670M050X080R6H-D1 KSN38	M12
4159934	T670M060X100R6H-D1 KSN38	M12
4159935	T670M080X125R6H-D1 KSN38	M12
4159936	T670M100X150R6H-D1 KSN38	M12
4159937	T670M120X175R6H-D6 KSN38	M12
4159938	T670M160X200R6H-D6 KSN38	M12
4159939	T680M030X050R6H-D1 KSN38	M38
4159940	T680M040X070R6H-D1 KSN38	M38
4159941	T680M050X080R6H-D1 KSN38	M38
4159942	T680M060X100R6H-D1 KSN38	M38
4159953	T680M080X125R6H-D1 KSN38	M38
4159954	T680M100X150R6H-D1 KSN38	M38
4159955	T680M120X175R6H-D6 KSN38	M38
4159956	T680M160X200R6H-D6 KSN38	M38
4159957	T680M200X250R6H-D6 KSN38	M38
4160768	RCGT1204M0MS KCU25	B223
4160769	RCGT1606M0MS KCU25	B223
4161098	T604M030X050R6H-D1 KSH26	M39
4161099	T604M040X070R6H-D1 KSH26	M39
4161100	T604M050X080R6H-D1 KSH26	M39
4161101	T604M060X100R6H-D1 KSH26	M39
4161102	T604M080X125R6H-D1 KSH26	M39
4161343	T604M100X150R6H-D1 KSH26	M39
4161344	T604M120X175R6H-D6 KSH26	M39
4161345	T604M140X200R6H-D6 KSH26	M39
4161346	T604M160X200R6H-D6 KSH26	M39
4161347	T604M180X250R6H-D6 KSH26	M39
4161348	T604M200X250R6H-D6 KSH26	M39
4161349	T604MF080X100R6H-D4 KSH26	M39
4161350	T604MF100X100R6H-D4 KSH26	M39
4161351	T604MF100X125R6H-D4 KSH26	M39
4161352	T604MF120X125R6H-D4 KSH26	M39
4161353	T604MF120X150R6H-D4 KSH26	M39
4161354	T604MF140X150R6H-D4 KSH26	M39
4161355	T604MF160X150R6H-D4 KSH26	M39
4164868	50A04RS90RP16	V78
4164987	RIQ09E1300 KC6005	K55
4165042	NGD3M350LK KCU25	C149
4167881	CV40FBHM1691	K130
4167882	CV40FBHMKIT645	K123, K127
4168063	EBM1580160162	K132
4168669	A4G0300M03P04S02025ST KB1630	C101
4168670	A4G0400M04P04S02025ST KB1630	C101
4168753	A4G0300M03P04EST KB1630	C101
4168755	A4G0500M05P08EST KB1630	C101
4168756	A4G0600M06P08EST KB1630	C101
4168757	A4R0300M03P00EST KB1630	B337, C102
4168758	A4R0400M04P00EST KB1630	B337, C102
4168759	A4R0500M05P00EST KB1630	B337, C102
4168760	A4R0600M06P00EST KB1630	B337, C102
4168928	A4G0300M03P04S02025ST KB5625	C101
4168929	A4G0400M04P04S02025ST KB5625	C101
4168930	A4G0500M05P08S02025ST KB5625	C101
4168931	A4G0600M06P08S02025ST KB5625	C101
4168932	NG3M200LS02020ST KB5625	C163
4168945	NG3M200RS02020ST KB5625	C163
4168946	NG3M300RS02020ST KB5625	C163
4168947	NG3M400RS02020ST KB5625	C163
4168948	NG3125RS0820ST KB5625	C163
4169239	B269A03175HP KCPK15	G68
4169240	B269A03264HP KCPK15	G68
4169241	B269A03500HP KCPK15	G68
4169242	B269A03970HP KCPK15	G68
4169243	B269A04000HP KCPK15	G68
4169244	B269A04500HP KCPK15	G68
4169245	B269A04600HP KCPK15	G68
4169246	B269A04763HP KCPK15	G68
4169247	B269A04800HP KCPK15	G68
4169248	B269A05000HP KCPK15	G68
4169249	B269A05100HP KCPK15	G68
4169250	B269A05200HP KCPK15	G68
4169251	B269A05300HP KCPK15	G68
4169252	B269A05410HP KCPK15	G68
4169253	B269A05500HP KCPK15	G68
4169254	B269A05558HP KCPK15	G68
4169255	B269A05600HP KCPK15	G69
4169256	B269A05700HP KCPK15	G69
4169257	B269A05800HP KCPK15	G69
4169258	B269A06000HP KCPK15	G69
4169259	B269A06200HP KCPK15	G69
4169260	B269A06350HP KCPK15	G69
4169261	B269A06500HP KCPK15	G69
4169262	B269A06528HP KCPK15	G69
4169263	B269A06600HP KCPK15	G69
4169264	B269A06746HP KCPK15	G69
4169265	B269A06800HP KCPK15	G69
4169266	B269A06909HP KCPK15	G69
4169267	B269A07000HP KCPK15	G69
4169268	B269A07145HP KCPK15	G69
4169269	B269A07500HP KCPK15	G69
4169270	B269A07541HP KCPK15	G69
4169271	B269A07700HP KCPK15	G69
4169272	B269A07800HP KCPK15	G69
4169273	B269A07938HP KCPK15	G69

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
4169274	B269A08000HP KCPK15	G69
4169275	B269A08100HP KCPK15	G69
4169276	B269A08334HP KCPK15	G69
4169277	B269A08433HP KCPK15	G69
4169278	B269A08700HP KCPK15	G69
4169279	B269A08733HP KCPK15	G69
4169280	B269A09000HP KCPK15	G69
4169281	B269A09100HP KCPK15	G69
4169282	B269A09129HP KCPK15	G69
4169283	B269A09500HP KCPK15	G69
4169284	B269A09525HP KCPK15	G69
4169285	B269A09921HP KCPK15	G69
4169286	B269A10000HP KCPK15	G69
4169287	B269A10200HP KCPK15	G69
4169288	B269A10300HP KCPK15	G69
4169289	B269A10320HP KCPK15	G69
4169290	B269A10500HP KCPK15	G69
4169291	B269A10716HP KCPK15	G69
4169292	B269A10800HP KCPK15	G69
4169293	B269A11000HP KCPK15	G69
4169294	B269A11113HP KCPK15	G69
4169295	B269A11500HP KCPK15	G70
4169296	B269A11800HP KCPK15	G70
4169297	B269A12000HP KCPK15	G70
4169298	B269A12100HP KCPK15	G70
4169299	B269A12304HP KCPK15	G70
4169300	B269A12700HP KCPK15	G70
4169301	B269A13000HP KCPK15	G70
4169302	B269A13100HP KCPK15	G70
4169303	B269A13500HP KCPK15	G70
4169304	B269A14100HP KCPK15	G70
4169305	B269A14288HP KCPK15	G70
4169306	B269A14500HP KCPK15	G70
4169307	B269A14684HP KCPK15	G70
4169308	B269A15000HP KCPK15	G70
4169309	B269A15500HP KCPK15	G70
4169310	B269A15875HP KCPK15	G70
4169311	B269A16000HP KCPK15	G70
4169312	B269A16500HP KCPK15	G70
4169313	B269A17000HP KCPK15	G70
4169314	B269A17463HP KCPK15	G70
4169315	B269A17500HP KCPK15	G70
4169316	B269A18000HP KCPK15	G70
4169317	B269A18500HP KCPK15	G70
4169318	B269A19000HP KCPK15	G70
4169319	B269A19050HP KCPK15	G70
4169320	B269A19500HP KCPK15	G70
4169321	B269A20000HP KCPK15	G70
4169337	NG3M200RS02020ST KB1630	C163
4169338	NG3M300RS02020ST KB1630	C163
4169341	NG3125RS0820ST KB1630	C163
4169343	NG3125LS0820ST KB1630	C163
4169745	A4SCR1212K0214	C114
4169746	A4SCR1616K0217	C114
4169747	A4SCR1212K0314	C114
4169748	A4SCR1616K0317	C114
4169749	A4SCL1212K0214	C114
4169750	A4SCL1616K0217	C114
4169752	A4SCL1616K0317	C114
4170385	CM209R ASSY	B58–60, B66, B105
4170386	CM210R ASSY	B59–60, B105
4170387	CM236R ASSY	B105–106
4170408	KSCMCA90QF KD1420	S134
4170410	KSCMCA90UNBF KD1420	S134
4170411	KSCMCA90QFBF KD1420	S134
4171227	LNUX301940RRF KCP10	E51
4171768	RCGT0803M0MS KCU10	B223
4171769	RCGT1204M0MS KCU10	B223
4171770	RCGT1606M0MS KCU10	B223
4171823	CNMG120402FN KCU10	B49
4171824	CNMG120404FP KCU10	B49
4171825	DNMG110404FF KCU10	B76
4171826	DNMG110404FP KCU10	B77
4171827	DNMG150404FP KCU10	B77
4171828	DNMG150408FP KCU10	B77
4171829	DNMG150412FP KCU10	B77
4171830	DNMG150604FP KCU10	B77
4171831	DNMG150608FP KCU10	B77
4171833	SNMG090304FF KCU10	B97
4171835	SNMG120404FP KCU10	B97
4171836	SNMG120408FP KCU10	B97
4171837	TNMG110304FF KCU10	B124
4171838	TNMG160404FP KCU10	B124
4171839	TNMG160408FP KCU10	B124
4171840	TNMG160412FP KCU10	B124
4171841	TNMG220404FP KCU10	B124
4171842	TNMG220408FP KCU10	B124
4171843	VNMG160404FP KCU10	B145
4171844	VNMG160408FP KCU10	B145
4171845	WNMG060404FF KCU10	B155
4171848	WNMG080404FF KCU10	B155
4171849	WNMG080404FP KCU10	B156
4171851	WNMG080408FP KCU10	B156
4171853	KNUX150405L25 KCU10	E31
4171854	KNUX150410L25 KCU10	E31
4171855	KCUX110302L15 KCU10	E32
4171856	KCUX110305L15 KCU10	E32
4171857	KNUX150405R20 KCU10	E31
4171858	KNUX150410R25 KCU10	E31
4171860	KCUX110305R15 KCU10	E32
4175270	B731A04200HP KCPK15	G120
4175271	B731A05000HP KCPK15	G120
4175272	B731A06800HP KCPK15	G120
4175403	B731A08500HP KCPK15	G120
4175404	B731A10200HP KCPK15	G120
4175405	B731A10500HP KCPK15	G120
4175406	B731A12000HP KCPK15	G120
4175407	B731A12500HP KCPK15	G120
4175408	B731A14000HP KCPK15	G120
4175409	B732A04200HP KCPK15	G121
4175410	B732A05000HP KCPK15	G121
4175411	B732A06800HP KCPK15	G121
4175412	B732A08500HP KCPK15	G121
4175413	B732A10200HP KCPK15	G121
4175414	B732A10500HP KCPK15	G121
4175415	B732A12000HP KCPK15	G121
4175416	B732A12500HP KCPK15	G121
4175417	B732A14000HP KCPK15	G121
4175418	B731A03734HP KCPK15	G120
4175419	B731A04496HP KCPK15	G120
4175420	B731A05106HP KCPK15	G120
4175421	B731A05410HP KCPK15	G120
4175422	B731A06528HP KCPK15	G120
4175423	B731A06909HP KCPK15	G120
4175424	B731A07938HP KCPK15	G120
4175425	B731A08433HP KCPK15	G120
4175426	B731A09921HP KCPK15	G120
4175427	B731A10716HP KCPK15	G120
4175428	B731A12304HP KCPK15	G120
4175429	B731A13096HP KCPK15	G120
4175430	B731A13495HP KCPK15	G120
4175431	B731A16670HP KCPK15	G120
4175432	B731A17463HP KCPK15	G120
4175433	B731A19446HP KCPK15	G120
4175434	B732A03734HP KCPK15	G121
4175435	B732A04496HP KCPK15	G121
4175436	B732A05106HP KCPK15	G121
4175437	B732A05410HP KCPK15	G121
4175438	B732A06528HP KCPK15	G121
4175439	B732A06909HP KCPK15	G121
4175440	B732A07938HP KCPK15	G121
4175441	B732A08433HP KCPK15	G121
4175442	B732A09921HP KCPK15	G121
4175443	B732A10716HP KCPK15	G121
4175445	B732A13096HP KCPK15	G121
4175446	B732A13495HP KCPK15	G121
4175447	B732A16670HP KCPK15	G121
4175448	B732A17463HP KCPK15	G121
4175834	NGD3125RK KCU10	C149
4175835	NGD3189L KCU10	C157
4175836	NGD3189LK KCU10	C149
4175837	NGD3189R KCU10	C157
4175838	NGD3189RK KCU10	C149
4175839	NGD3M200RK KCU10	C149
4175840	NGP3088L KCU10	C152
4175841	NGP3088R KCU10	C152
4175843	NG2031L KCU10	C155
4175844	NG2031LK KCU10	C147
4175845	NG2031R KCU10	C154
4175846	NG2031RK KCU10	C146
4175847	NG2041R KCU10	C154
4175848	NG2047L KCU10	C155
4175849	NG2047LK KCU10	C147
4175850	NG2047R KCU10	C154
4175851	NG2047RK KCU10	C146
4175852	NG2062L KCU10	C155
4175853	NG2062LK KCU10	C147
4175854	NG2062R KCU10	C154
4175855	NG2062RK KCU10	C146
4175856	NG2094L KCU10	C155
4175857	NG2094LK KCU10	C147
4175858	NG2094R KCU10	C154
4175859	NG2094RK KCU10	C146
4175860	NG2125L KCU10	C155
4175861	NG2125LK KCU10	C148
4175862	NG2125R KCU10	C154
4175863	NG2125RK KCU10	C146
4175864	NG2M080LK KCU10	C147
4175865	NG2M080RK KCU10	C146
4175866	NG2M100LK KCU10	C147
4175867	NG2M100RK KCU10	C146
4175868	NG2M120LK KCU10	C147
4175869	NG2M120RK KCU10	C146
4175870	NG2M140LK KCU10	C147
4175871	NG2M140RK KCU10	C146
4175873	NG2M170RK KCU10	C146
4175875	NG2M195RK KCU10	C146
4175876	NG2M200LK KCU10	C147
4175877	NG2M200RK KCU10	C146
4175878	NG2M225LK KCU10	C147
4175879	NG2M225RK KCU10	C146
4175880	NG2M275RK KCU10	C146
4175881	NG2M300LK KCU10	C148
4175882	NG2M300RK KCU10	C146
4175883	NGP3125R KCU10	C152
4175884	NGP3156R KCU10	C152
4175886	NJ3014R12 KCU10	D17
4175888	NJF3005R32 KCU10	D17
4175893	NGP2031L KCU10	C152
4175894	NGP2031R KCU10	C152
4175895	NGP2062L KCU10	C152
4175896	NGP2062R KCU10	C152
4175897	NGP2125L KCU10	C152
4175898	NGP2125R KCU10	C152
4175899	NP2002RK KCU10	C151
4175901	NR2031L KCU10	C158
4175902	NR2031R KCU10	C158
4175903	NR2062L KCU10	C158
4175904	NR2062R KCU10	C158
4175905	NR2M050L KCU10	C158
4175906	NR2M050R KCU10	C158
4175907	NR2M075R KCU10	C158
4175908	NR2M100R KCU10	C158
4175909	NT2L KCU10	D19
4175910	NT2LK KCU10	D24
4175911	NT2R KCU10	D19
4175912	NT2RK KCU10	D24
4175928	NJK3008R20 KCU10	D18
4175932	NJP3010R16 KCU10	D18
4175933	NTF2L KCU10	D23
4175934	NTF2R KCU10	D23
4175935	NTK2L KCU10	D23
4175936	NTK2R KCU10	D23
4175937	NTP2L KCU10	D24
4175938	NTP2R KCU10	D24
4175944	NJP3014R12 KCU10	D18
4175946	NP3002RK KCU10	C151
4175947	NPD3012RK KCU10	C151
4175948	NR3031L KCU10	C158
4175949	NR3031LK KCU10	C150
4175950	NR3031R KCU10	C158
4175951	NR3031RK KCU10	C150
4175952	NR3047L KCU10	C158
4175953	NR3047LK KCU10	C150
4175954	NR3047R KCU10	C158
4175955	NR3047RK KCU10	C150
4175956	NR3062L KCU10	C158
4175957	NR3062LK KCU10	C150
4175958	NR3062R KCU10	C158
4175959	NR3062RK KCU10	C150
4175961	NR3078RK KCU10	C150
4175963	NR3094R KCU10	C158
4175964	NR3M150L KCU10	C158
4175965	NRD3031L KCU10	C159
4175966	NRD3031R KCU10	C159
4175967	NRD3062L KCU10	C159
4175968	NRD3062R KCU10	C159
4175969	NRP3031L KCU10	C153
4175970	NRP3031R KCU10	C153
4175971	NRP3047L KCU10	C153
4175972	NRP3047R KCU10	C153
4175975	NRP3062R KCU10	C153
4175976	NRP3094L KCU10	C153
4175977	NRP3094R KCU10	C153
4175978	NT3L KCU10	D19
4175979	NT3LCK KCU10	D21
4175980	NT3LK KCU10	D24
4175981	NT3R KCU10	D19
4175982	NT3RCK KCU10	D21
4175983	NT3RK KCU10	D24
4175984	NTF3L KCU10	D23
4175985	NTF3R KCU10	D23
4175986	NTK3L KCU10	D23
4175987	NTK3R KCU10	D23
4175988	NTP3L KCU10	D24
4175989	NTP3R KCU10	D24
4176009	NG4125L KCU10	C155
4176010	NG4125LK KCU10	C148
4176011	NG4125R KCU10	C154
4176012	NG4125RK KCU10	C147
4176015	NA3L4 KCU10	D12
4176018	NA3L8 KCU10	D12
4176019	NA3R10 KCU10	D12
4176020	NA3R12 KCU10	D12
4176021	NA3R16 KCU10	D12
4176023	NA3R5 KCU10	D12
4176024	NA3R6 KCU10	D12
4176025	NA3R8 KCU10	D12
4176026	NAS3L10 KCU10	D13
4176027	NAS3L5 KCU10	D13
4176028	NAS3L6 KCU10	D13
4176029	NAS3L8 KCU10	D13
4176030	NAS3R10 KCU10	D13
4176031	NAS3R5 KCU10	D13
4176032	NAS3R6 KCU10	D13
4176033	NAS3R8 KCU10	D13
4176034	NG3047L KCU10	C155
4176035	NG3047LK KCU10	C148
4176036	NG3047R KCU10	C154
4176037	NG3047RK KCU10	C146
4176038	NG3062L KCU10	C155
4176039	NG3062LK KCU10	C148
4176040	NG3062R KCU10	C154
4176041	NG3062RK KCU10	C146
4176042	NG3072L KCU10	C155
4176043	NG3072LK KCU10	C148
4176044	NG3072R KCU10	C154
4176045	NG3072RK KCU10	C146
4176046	NG3078L KCU10	C155
4176047	NG3078LK KCU10	C148
4176048	NG3078R KCU10	C154
4176049	NG3078RK KCU10	C146
4176050	NG3088L KCU10	C155
4176051	NG3088R KCU10	C154
4176052	NG3094L KCU10	C155
4176053	NG3094LK KCU10	C148
4176054	NG3094R KCU10	C154
4176055	NG3094RK KCU10	C146
4176056	NG3097L KCU10	C155
4176057	NG3097R KCU10	C154
4176058	NG3105L KCU10	C155
4176059	NG3105R KCU10	C154
4176060	NG3125L KCU10	C155
4176061	NG3125LK KCU10	C148
4176062	NG3125R KCU10	C154
4176063	NG3125RK KCU10	C147
4176064	NG3142L KCU10	C155
4176065	NG3156LK KCU10	C148
4176066	NG3156R KCU10	C154
4176067	NG3156RK KCU10	C147
4176068	NG3189L KCU10	C155
4176069	NG3189LK KCU10	C148
4176070	NG3189R KCU10	C154
4176071	NG3189RK KCU10	C147
4176072	NG3M120LK KCU10	C148
4176073	NG4189L KCU10	C155
4176074	NG4189LK KCU10	C148
4176075	NG4189R KCU10	C154

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
4176076	NG4189RK KCU10	C147
4176077	NG4250L KCU10	C155
4176078	NG4250LK KCU10	C148
4176079	NG4250R KCU10	C154
4176081	NG4M400LK KCU10	C148
4176083	NG4M500LK KCU10	C148
4176084	NG4M500RK KCU10	C147
4176085	NGD4125LK KCU10	C149
4176086	NGD4125RK KCU10	C149
4176087	NGD4189LK KCU10	C149
4176088	NGD4189RK KCU10	C149
4176089	NGD4250L KCU10	C157
4176090	NGD4250LK KCU10	C149
4176091	NGD4250R KCU10	C157
4176092	NGD4250RK KCU10	C149
4176093	NG3M120RK KCU10	C146
4176094	NG3M225LK KCU10	C148
4176095	NG3M225RK KCU10	C146
4176096	NG3M275LK KCU10	C148
4176097	NG3M275RK KCU10	C147
4176098	NG3M300LK KCU10	C148
4176099	NG3M300RK KCU10	C147
4176100	NG3M400LK KCU10	C148
4176101	NG3M400RK KCU10	C147
4176102	NG3M425LK KCU10	C148
4176104	NGP4189R KCU10	C152
4176105	NGP4250L KCU10	C152
4176107	NR4062LK KCU10	C150
4176108	NR4062RK KCU10	C150
4176109	NR4094LK KCU10	C150
4176110	NR4094RK KCU10	C150
4176112	NR4125LK KCU10	C150
4176113	NR4125R KCU10	C158
4176114	NR4125RK KCU10	C150
4176115	NRD4062L KCU10	C159
4176116	NRD4062R KCU10	C159
4176117	NRD4094L KCU10	C159
4176118	NRD4094R KCU10	C159
4176119	NRD4125L KCU10	C159
4176121	NT4L KCU10	D19
4176122	NT4LK KCU10	D24
4176123	NG3M425RK KCU10	C147
4176124	NGD3062LK KCU10	C149
4176125	NGD3062RK KCU10	C149
4176126	NGD3094LK KCU10	C149
4176127	NGD3094RK KCU10	C149
4176128	NGD3125LK KCU10	C149
4176133	NT4R KCU10	D19
4176135	NT4RK KCU10	D24
4176137	NTP4R KCU10	D24
4176138	NA4L4 KCU10	D12
4176141	NA6R2 KCU10	D12
4176164	NDC3115VL75 KCU10	D16
4176165	NDC3115VR75 KCU10	D16
4176166	NDC314VR75 KCU10	D16
4176167	NDC327VR75 KCU10	D16
4176177	NDC68RDR75M KCU10	D15
4176178	NDC8115VR75M KCU10	D16
4176180	NDC88VR75M KCU10	D16
4176181	NT1L KCU10	D25
4176182	NTB2LB KCU10	D20
4176186	NTB3LB KCU10	D20
4176187	NTB3RA KCU10	D19
4176188	NTB3RB KCU10	D20
4176190	NTB4RA KCU10	D19
4176191	NTB4RB KCU10	D20
4176192	NTC3L10E KCU10	D22
4176193	NTC3L12E KCU10	D22
4176194	NTC3L16E KCU10	D22
4176195	NTC3MR150E KCU10	D21
4176198	NTC3R11E KCU10	D22
4176204	NTC3R20E KCU10	D22
4176206	NTC3R32E KCU10	D22
4176207	NTC3R8E KCU10	D22
4176208	NTC3R9E KCU10	D22
4177052	35E04R050A32RP12L200	V71
4177163	42A04RS90RP12	V72
4177597	VBMT160412LF KCP25	B265
4177622	KDMT0604SRHF KC515M	V133
4177633	KDMT0806SRHF KC515M	V133
4181068	RIQ09R0400S KB1610	K54
5000493	B707A12600FBG KC7315	G115
5001994	A4R0405M04U00GMN KCP25	C97
5004291	RIQ09R0400FB KT6225	K55
5006833	B978A03800 KC7315	G146
5015690	193.545	H102–103
5023558	B269A03700HP KCPK15	G68
5025597	SF300M1LA1RA	K64
5025598	SF750M1LA1RA	K64
5025599	SF300M1RS	K64
5025670	SF750M1RS	K64
5025671	SFSLRS	K65
5025672	SFSLLS	K65
5025673	SFSLRA	K65
5025674	SFSLLA	K65
5025675	SFMGS	K67
5025676	SFCR20	K67
5025677	SFCRHSK3263	K67
5025678	SFCRHSK63100	K67
5025679	SFCR20S	K67
5025680	SFVB	K65
5025681	SFEBS	K66
5025682	SFEBCH	K66
5025683	SFSLSS	K65
5025684	SFSB450	K66
5025685	SFSB900	K66
5025686	SFCPS	K66
5039055	B269A04300HP KCPK15	G68
5048735	CNMU120612MN KCP10	B51
5057900	B976A10600 KC7315	G141
5058500	KSEM2653HPGM KC7315	H43
5059278	B978A03400 KC7315	G146
5062104	SNMG090308FF KCU10	B97
5062106	SNMG120408MP KCU10	B98
5062108	SNMG120408RP KCU10	B101
5062109	SNMG120412MP KCU10	B98
5062110	SNMG120412P KCU10	B100
5062111	SNMG120412RP KCU10	B101
5062112	SNMG150612MP KCU10	B98
5062113	SNMG150612RP KCU10	B101
5062114	SNMG150612UP KCU10	B102
5062115	SNMG190612 KCU10	B96
5062117	SNMG190612RP KCU10	B101
5062120	SNMG190616RP KCU10	B101
5062121	SNMG250924 KCU10	B96
5062122	SNMG250924RM KCU10	B100
5062123	TNGG160402LF KCU10	B122
5062126	TNGP160402 KCU10	B122
5062127	TNGP160404 KCU10	B122
5062128	TNGP160408 KCU10	B122
5062129	TNMG160404FF KCU10	B124
5062130	TNMG160404FW KCU10	B125
5062131	TNMG160404MP KCU10	B125
5062132	TNMG160404P KCU10	B127
5062133	TNMG160408FF KCU10	B124
5062135	TNMG160408MP KCU10	B125
5062136	TNMG160408P KCU10	B127
5062137	TNMG160408RP KCU10	B128
5062139	TNMG220404P KCU10	B127
5062140	TNMG220408MP KCU10	B125
5062141	TNMG220408P KCU10	B127
5062142	TNMG220408RP KCU10	B128
5062144	TNMG220412P KCU10	B127
5062145	TNMG220412RP KCU10	B128
5062147	TNMG270612RP KCU10	B128
5062148	TNMG330924RP KCU10	B128
5062149	CNMG190612MS KCU25	B52
5063675	RPET1204M0ELEJ KC522M	V73
5063676	RPET1204M0ELEJ KC725M	V73
5063677	RPET1204M0SGEJ KC522M	V73
5063678	RPET1204M0SGEJ KC725M	V73
5063701	RPET1605M0ELEJ KC725M	V79
5063702	RPET1605M0SGEJ KC522M	V79
5063704	RPET1605M0SGEJ KC725M	V79
5065400	KTIP1338HPM KCP15	H27
5065401	KTIP1538HPM KCP15	H27
5065552	DFR020204LD KCU40	J84
5065554	DFR020204GD KCU40	J84
5065556	DFR020204MD KCU40	J84
5065557	DFR030204LD KCU40	J84
5065558	DFR030204GD KCU40	J84
5065559	DFR030204MD KCU40	J84
5065660	DFR040304LD KCU40	J84
5065661	DFR040304GD KCU40	J84
5065662	DFR040304MD KCU40	J84
5065663	DFT030204HP KCU40	J87
5065664	DFT030204MD KCU40	J87
5065665	DFT030204GD KCU40	J87
5065666	DFT030304HP KCU40	J87
5065667	DFT030304MD KCU40	J87
5065916	DFT030304GD KCU40	J87
5066013	DFT05T308HP KCU40	J87
5066014	DFT05T308MD KCU40	J87
5066015	DFT05T308GD KCU40	J87
5066016	DFT06T308HP KCU40	J87
5066019	DFT06T308MD KCU40	J87
5066064	DFT06T308GD KCU40	J87
5066146	DFT070408HP KCU40	J87
5066147	DFT070408MD KCU40	J87
5066148	DFT070408GD KCU40	J87
5066149	DFT090508HP KCU40	J87
5066190	DFT090508MD KCU40	J87
5066191	DFT090508GD KCU40	J87
5066192	DFR040304D28GD KCU40	H89
5066193	DFT05T308D32HP KCU40	H88
5066195	DFT05T308D33HP KCU40	H88
5066196	DFT06T308D36HP KCU40	H88
5066197	DFT06T308D39HP KCU40	H88
5066198	DFT06T308D44HP KCU40	H88
5066199	DFT070408D45HP KCU40	H88
5066220	DFT070408D50HP KCU40	H88
5066221	DFT090508D56HP KCU40	H88
5066222	DFT090508D63HP KCU40	H88
5066798	DFR020204GD KCU25	J84
5066799	DFR020204MD KCU25	J84
5067312	DFR030204GD KCU25	J84
5067313	DFR030204MD KCU25	J84
5067314	DFR040304GD KCU25	J84
5067316	DFR040304MD KCU25	J84
5067318	DFT030204HP KCU25	J87
5067319	DFT030204MD KCU25	J87
5067401	DFT030204GD KCU25	J87
5067402	DFT030304HP KCU25	J87
5067403	DFT030304MD KCU25	J87
5067404	DFT030304GD KCU25	J87
5067406	DFT05T308HP KCU25	J87
5067408	DFT05T308MD KCU25	J87
5067470	DFT05T308GD KCU25	J87
5067473	DFT06T308HP KCU25	J87
5067474	DFT06T308MD KCU25	J87
5067475	DFT06T308GD KCU25	J87
5067476	DFT070408HP KCU25	J87
5067478	DFT070408MD KCU25	J87
5067479	DFT070408GD KCU25	J87
5067480	DFT090508HP KCU25	J87
5067482	DFT090508MD KCU25	J87
5067485	DFT090508GD KCU25	J87
5067486	DFR040304D28GD KCU25	H89
5067487	DFT05T308D32HP KCU25	H88
5067488	DFT05T308D33HP KCU25	H88
5067489	DFT06T308D36HP KCU25	H88
5067520	DFT06T308D39HP KCU25	H88
5067522	DFT06T308D44HP KCU25	H88
5067523	DFT070408D45HP KCU25	H88
5067524	DFT070408D50HP KCU25	H88
5067526	DFT090508D56HP KCU25	H88
5067527	DFT090508D63HP KCU25	H88
5068267	DFR020204GD KCPK10	J84
5068268	DFR030204GD KCPK10	J84
5068280	DFR040304GD KCPK10	J84
5068281	DFT030204HP KCPK10	J87
5068282	DFT030204GD KCPK10	J87
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5068289	DFT06T308GD KCPK10	J87
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5068323	DFT070408GD KCPK10	J87
5068325	DFT090508HP KCPK10	J87
5068326	DFT090508GD KCPK10	J87
5069150	A4G0405M04U04GMP KCP25	C95
5069154	A4G0605M06U04GMP KCP25	C95
5069158	A4G0605M06U12GMN KCP25	C96
5069159	A4G1005M10U08GMN KCP25	C96
5069160	A4G1005M10U12GMN KCP25	C96
5069161	A4R0305M03U00GMN KCP25	C97
5069162	A4R0505M05U00GMN KCP25	C97
5069163	A4R0605M06U00GMN KCP25	C97
5069164	A4R0805M08U00GMN KCP25	C97
5069354	A4G0405M04U04GMP KCP10	C95
5069359	A4G0505M05U04GMP KCP10	C95
5069390	A4G0505M05U08GMP KCP10	C95
5069394	A4G0205M02U02GMN KCP10	C96
5069430	A4G0305M03U02GMN KCP10	C96
5069431	A4G0305M03U04GMN KCP10	C96
5069432	A4G0605M06U04GMN KCP10	C96
5069433	A4G0805M08U08GMN KCP10	C96
5069435	A4G0805M08U12GMN KCP10	C96
5069437	A4G1005M10U08GMN KCP10	C96
5069439	A4R0205M02U00GMN KCP10	C97
5069470	A4R0305M03U00GMN KCP10	C97
5069471	A4R0805M08U00GMN KCP10	C97
5077334	B269A03300HP KCPK15	G68
5077336	B269A04200HP KCPK15	G68
5077337	B269A08200HP KCPK15	G69
5078982	NGD2M200LK KCU10	C149
5080992	SPGX060304MD KCPK10	J89
5085631	M1H40J4R80B32S90ED14C12	T57
5090284	RPGN060200E KYS30	B334, V155
5090285	RPGN090300T01020 KYS30	B334, V155
5090286	RPGN120400E KYS30	B334, V155
5090287	RPGN120400T01020 KYS30	B334, V155
5090494	CNMG120402MS KCU10	B52
5090495	CNMG120401MS KCU10	B52
5090496	CNMG120404MS KCU10	B52
5090497	CNMG120408MS KCU10	B52
5090498	CNMG120412MS KCU10	B52
5090499	CNMG120416MS KCU10	B52
5090680	CNMG160608MS KCU10	B52
5090681	CNMG160612MS KCU10	B52
5090682	CNMG190608MS KCU10	B52
5090684	CNMG190616MS KCU10	B52
5090685	DNMG110408MS KCU10	B79
5090686	DNMG150402MS KCU10	B79
5090687	DNMG150401MS KCU10	B79
5090688	DNMG150404MS KCU10	B79
5090689	DNMG150408MS KCU10	B79
5090740	DNMG150412MS KCU10	B79
5090741	DNMG150604MS KCU10	B79
5090742	DNMG150608MS KCU10	B79
5090743	DNMG150612MS KCU10	B79
5090744	RCGH120400 KCU10	B222
5090760	SNMG120408MS KCU10	B99
5090761	SNMG120412MS KCU10	B99
5090763	SNMG120416RP KCU10	B101
5090764	TNGG160404FS KCU10	B122
5090765	TNGG220408FS KCU10	B122
5090767	TNMG160402MS KCU10	B126
5090768	TNMG160404MS KCU10	B126
5090769	TNMG160408MS KCU10	B126
5090810	TNMG220404MS KCU10	B126
5090811	TNMG220408MS KCU10	B126
5090812	TNMG220412MS KCU10	B126
5090815	VNGG160402FS KCU10	B143
5090816	VNGG160401FS KCU10	B143
5090817	VNGG160404FS KCU10	B143
5090819	VNGG160408FS KCU10	B143
5090851	VNMG160402MS KCU10	B146
5090852	VNMG160401MS KCU10	B146
5090853	VNMG160404MS KCU10	B146
5090854	VNMG160408MS KCU10	B146
5090855	VNMG220404MS KCU10	B146
5090856	VNMG220408MS KCU10	B146
5090857	VNMG160412RP KCU10	B147
5090858	WNGG080404FS KCU10	B154
5090859	WNGG080408FS KCU10	B154
5090890	WNMG060408MS KCU10	B158
5090891	WNMG080402MS KCU10	B158
5090892	WNMG080401MS KCU10	B158
5090893	WNMG080404MS KCU10	B158
5090894	WNMG080408MS KCU10	B158
5104314	RNGJ1204M0ENLDJX KC522M	V65

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
5104318	RNGJ1204M0SNGDJX KC725M	V65
5104420	KDR40Z04S16RN12X	V64
5104421	KDR50Z05S22RN12X	V64
5104424	KDR63Z06S22RN12X	V64
5104426	KDR80Z07S27RN12X	V64
5109130	A4G094I2BP05GUP KCU25	C93
5109131	A4G125I03P05GUP KCU25	C93
5109132	A4G125I03P1GUP KCU25	C93
5109133	A4G187I04P1GUP KCU25	C93
5109135	A4G250I06P1GUP KCU25	C93
5109136	A4G250I06P2GUP KCU25	C93
5109137	A4G312I08P1GUP KCU25	C93
5109138	A4G375I10P1GUP KCU25	C93
5109290	DNGG110402FS KCU10	B74
5109291	DNGG110404FS KCU10	B74
5109292	DNGG110408FS KCU10	B74
5109293	DNGG150401FS KCU10	B74
5109294	DNGG150402FS KCU10	B74
5109295	DNGG150604FS KCU10	B74
5109296	DNGG150404FS KCU10	B74
5109297	DNGG150608FS KCU10	B74
5109298	DNGG150408FS KCU10	B74
5115736	KSEMP2800FDS28B1M	H84, H94
5115737	KSEMP2858FDS28B1M	H84, H94
5115738	KSEMP2900FDS28B1M	H84, H94
5115739	KSEMP2937FDS28B1M	H84, H94
5116010	KSEMP3000FDS28B1M	H84, H94
5116011	KSEMP3017FDS28B1M	H84, H94
5116012	KSEMP3096FDS28B1M	H84, H94
5116013	KSEMP3100FDS28B1M	H84, H94
5116014	KSEMP3175FDS32B1M	H84, H94
5116015	KSEMP3200FDS32B1M	H84, H94
5116016	KSEMP3300FDS32B1M	H84, H94
5116017	KSEMP3320FDS32B1M	H84, H94
5116018	KSEMP3334FDS32B1M	H84, H94
5116019	KSEMP3400FDS32B1M	H84, H94
5116030	KSEMP3493FDS32B1M	H84, H94
5116031	KSEMP3500FDS32B1M	H84, H94
5116032	KSEMP3600FDS36B1M	H84, H94
5116033	KSEMP3651FDS36B1M	H84, H94
5116034	KSEMP3700FDS36B1M	H84, H94
5116035	KSEMP3750FDS36B1M	H84, H94
5116036	KSEMP3800FDS36B1M	H84, H95
5116037	KSEMP3810FDS36B1M	H84, H95
5116038	KSEMP3900FDS36B1M	H84, H95
5116039	KSEMP3920FDS36B1M	H84, H95
5116040	KSEMP3970FDS36B1M	H84, H95
5116041	KSEMP4000FDS40B1M	H84, H95
5116042	KSEMP4100FDS40B1M	H84, H95
5116043	KSEMP4128FDS40B1M	H84, H95
5116044	KSEMP4200FDS40B1M	H84, H95
5116045	KSEMP4300FDS40B1M	H84, H95
5116046	KSEMP4400FDS40B1M	H84, H95
5116047	KSEMP4445FDS40B1M	H84, H95
5116098	KSEMP4500FDS45B1M	H85, H95
5116099	KSEMP4600FDS45B1M	H85, H95
5116110	KSEMP4700FDS45B1M	H85, H95
5116111	KSEMP4763FDS45B1M	H85, H95
5116112	KSEMP4800FDS45B1M	H85, H95
5116113	KSEMP4900FDS45B1M	H85, H95
5116114	KSEMP5000FDS50B1M	H85, H95
5116115	KSEMP5080FDS50B1M	H85, H95
5116116	KSEMP5100FDS50B1M	H85, H95
5116117	KSEMP5200FDS50B1M	H85, H95
5116118	KSEMP5300FDS50B1M	H85, H95
5116119	KSEMP5398FDS50B1M	H85, H95
5116120	KSEMP5400FDS50B1M	H85, H95
5116121	KSEMP5500FDS50B1M	H85, H95
5116122	KSEMP5600FDS56B1M	H85, H95
5116123	KSEMP5700FDS56B1M	H85, H95
5116124	KSEMP5715FDS56B1M	H85, H95
5116125	KSEMP5800FDS56B1M	H85, H95
5116126	KSEMP5900FDS56B1M	H85, H95
5116127	KSEMP6000FDS56B1M	H85, H95
5116128	KSEMP6033FDS56B1M	H85, H95
5116129	KSEMP6100FDS56B1M	H85, H95
5116130	KSEMP6200FDS56B1M	H85, H95
5116131	KSEMP6300FDS63B1M	H85, H95
5116132	KSEMP6350FDS63B1M	H85, H95
5116133	KSEMP6400FDS63B1M	H85, H95
5116134	KSEMP6500FDS63B1M	H85, H95
5116135	KSEMP6600FDS63B1M	H85, H95
5116136	KSEMP6668FDS63B1M	H85, H95
5116137	KSEMP6700FDS63B1M	H85, H95
5116138	KSEMP6800FDS63B1M	H85, H95
5116139	KSEMP6900FDS63B1M	H85, H95
5116140	KSEMP6985FDS63B1M	H85, H95
5116141	KSEMP7000FDS63B1M	H85, H95
5116887	B224A14200HP KCPK15	G54
5117311	B269A09800HP KCPK15	G69
5118324	DPA07T3D25 KCU40	H90
5118325	DPA09T4D32 KCU40	H90
5118326	DPA13T5D50 KCU40	H90
5118327	DFC040310D28HP KCU25	H90
5118328	DFC05T312D32HP KCU25	H90
5118329	DFC06T312D36HP KCU25	H90
5118450	DFC070416D45HP KCU25	H90
5118451	DFC090520D56HP KCU25	H90
5118452	DFC040310D28HP KCU40	H90
5118453	DFC05T312D32HP KCU40	H90
5118454	DFC06T312D36HP KCU40	H90
5118455	DFC070416D45HP KCU40	H90
5118456	DFC090520D56HP KCU40	H90
5118457	DFC040310D28MD KC7140	H90
5118458	DFC05T312D32MD KC7140	H90
5118459	DFC06T312D36MD KC7140	H90
5118460	DFC070416D45MD KC7140	H90
5118461	DFC090520D56MD KC7140	H90
5118592	B976F17500 KC7315	G145
5123821	KTIP2280HPM KCP15	H28
5124334	SDET120464SNGB KCPK30	T105, T112, U51
5124576	HSK63AAVS00B126MCLB	K79
5124577	HSK63AAVS0B143MCLB	K79
5124578	HSK63AAVS1B127MCLB	K79
5124579	HSK63AAVS2B139MCLB	K79
5124800	HSK63AAVS3B139MCLB	K79
5124801	KM40TSAVS00B111MCLB	K78
5124802	KM40TSAVS0B128MCLB	K78
5124803	KM40TSAVS1B112MCLB	K78
5124804	KM40TSAVS2B127MCLB	K78
5124805	KM50TSAVS00B117MCLB	K78
5124807	KM50TSAVS0B134MCLB	K78
5124808	KM50TSAVS1B118MCLB	K78
5124809	KM50TSAVS2B128MCLB	K78
5124810	KM50TSAVS3B128MCLB	K78
5124811	KM63TSAVS3B130MCLB	K78
5124812	KR32AVS00B099MCLB	K78
5124814	KR32AVS0B116MCLB	K78
5124816	KR32AVS1B100MCLB	K78
5124818	KR32AVS2B115MCLB	K78
5124820	KR32AVS3B115MCLB	K78
5124822	KRCSCFPR061Y	K81
5124823	KRCSCFPR062Y	K81
5124824	KRCSCFPR063Y	K81
5124825	KRCSCFPR061X	K81
5124826	KRCSCFPR062X	K81
5124827	KRCSCFPR063X	K81
5124828	KRCSCFPR061W	K81
5124829	KRCSCFPR062W	K81
5124850	KRCSCFPR063W	K81
5126960	RCMT2006M0UP KCPK05	E60
5127885	RIQ06R0400S KB1610	K54
5128566	C8FIX150608LRP KCU25	E12
5128598	C8FIX150612LRP KCP25	E12
5129621	B269A10400HP KCPK15	G69
5130229	B707A17900FBL KCMS15	G115
5131942	B269A03600HP KCPK15	G68
5132051	B978A03600 KC7315	G146
5133402	RMBE14000H6SF KC6305	K19
5133403	RMBE15000H6SF KC6305	K19
5133404	RMBE16000H6SF KC6305	K19
5133405	RMBE17000H6SF KC6305	K19
5133406	RMBE18000H6SF KC6305	K19
5133407	RMBE19000H6SF KC6305	K19
5133408	RMBE20000H6SF KC6305	K19
5133409	RMBE14000H6SF KC6005	K19
5133540	RMBE15000H6SF KC6005	K19
5133541	RMBE16000H6SF KC6005	K19
5133542	RMBE17000H6SF KC6005	K19
5133543	RMBE18000H6SF KC6005	K19
5133544	RMBE19000H6SF KC6005	K19
5133545	RMBE20000H6SF KC6005	K19
5133546	RMBE14000H6HF KC6305	K20
5133547	RMBE15000H6HF KC6305	K20
5133548	RMBE16000H6HF KC6305	K20
5133549	RMBE17000H6HF KC6305	K20
5133560	RMBE18000H6HF KC6305	K20
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5133563	RMBE14000H6HF KC6005	K20
5133564	RMBE15000H6HF KC6005	K20
5133565	RMBE16000H6HF KC6005	K20
5133566	RMBE17000H6HF KC6005	K20
5133567	RMBE18000H6HF KC6005	K20
5133568	RMBE19000H6HF KC6005	K20
5133569	RMBE20000H6HF KC6005	K20
5133590	RHME14000KST115H6SF KC6305	K33
5133591	RHME14288KST115H6SF KC6305	K33
5133592	RHME15000KST115H6SF KC6305	K33
5133593	RHME16000KST135H6SF KC6305	K33
5133594	RHME17000KST135H6SF KC6305	K33
5133595	RHME17463KST135H6SF KC6305	K33
5133596	RHME18000KST155H6SF KC6305	K33
5133597	RHME19000KST155H6SF KC6305	K33
5133598	RHME19050KST155H6SF KC6305	K33
5133599	RHME20000KST175H6SF KC6305	K33
5133600	RHME21000KST175H6SF KC6305	K33
5133601	RHME22000KST175H6SF KC6305	K33
5133602	RHME22225KST175H6SF KC6305	K33
5133603	RHME23000KST200H6SF KC6305	K33
5133604	RHME23813KST200H6SF KC6305	K33
5133605	RHME24000KST200H6SF KC6305	K33
5133606	RHME25000KST200H6SF KC6305	K33
5133607	RHME25400KST200H6SF KC6305	K33
5133609	RHME26000KST200H6SF KC6305	K33
5133610	RHME27000KST200H6SF KC6305	K33
5133611	RHME28000KST250H6SF KC6305	K33
5133612	RHME30000KST250H6SF KC6305	K33
5133613	RHME31750KST250H6SF KC6305	K33
5133614	RHME32000KST250H6SF KC6305	K33
5133615	RHME34000KST300H6SF KC6305	K33
5133616	RHME36000KST300H6SF KC6305	K33
5133617	RHME38000KST350H6SF KC6305	K33
5133618	RHME40000KST350H6SF KC6305	K33
5133619	RHME42000KST350H6SF KC6305	K33
5133818	RHME14000KST115H6SF KC6005	K33
5133819	RHME14288KST115H6SF KC6005	K33
5133960	RHME15000KST115H6SF KC6005	K33
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5133962	RHME17000KST135H6SF KC6005	K33
5133963	RHME17463KST135H6SF KC6005	K33
5133964	RHME18000KST155H6SF KC6005	K33
5133965	RHME19000KST155H6SF KC6005	K33
5133966	RHME19050KST155H6SF KC6005	K33
5133967	RHME20000KST175H6SF KC6005	K33
5133968	RHME21000KST175H6SF KC6005	K33
5133969	RHME22000KST175H6SF KC6005	K33
5133970	RHME22225KST175H6SF KC6005	K33
5133971	RHME23000KST200H6SF KC6005	K33
5133972	RHME23813KST200H6SF KC6005	K33
5133973	RHME24000KST200H6SF KC6005	K33
5133974	RHME25000KST200H6SF KC6005	K33
5133975	RHME25400KST200H6SF KC6005	K33
5133976	RHME26000KST200H6SF KC6005	K33
5133977	RHME27000KST200H6SF KC6005	K33
5133978	RHME28000KST250H6SF KC6005	K33
5133979	RHME30000KST250H6SF KC6005	K33
5133990	RHME31750KST250H6SF KC6005	K33
5133991	RHME32000KST250H6SF KC6005	K33
5133992	RHME34000KST300H6SF KC6005	K33
5133993	RHME36000KST300H6SF KC6005	K33
5133994	RHME38000KST350H6SF KC6005	K33
5133995	RHME40000KST350H6SF KC6005	K33
5133996	RHME42000KST350H6SF KC6005	K33
5133997	RHME14000KST115H6HF KC6305	K34
5133998	RHME14288KST115H6HF KC6305	K34
5133999	RHME15000KST115H6HF KC6305	K34
5134030	RHME16000KST135H6HF KC6305	K34
5134031	RHME17000KST135H6HF KC6305	K34
5134032	RHME17463KST135H6HF KC6305	K34
5134033	RHME18000KST155H6HF KC6305	K34
5134034	RHME19000KST155H6HF KC6305	K34
5134035	RHME19050KST155H6HF KC6305	K34
5134036	RHME20000KST175H6HF KC6305	K34
5134037	RHME21000KST175H6HF KC6305	K34
5134038	RHME22000KST175H6HF KC6305	K34
5134039	RHME22225KST175H6HF KC6305	K34
5134040	RHME23000KST200H6HF KC6305	K34
5134041	RHME23813KST200H6HF KC6305	K34
5134042	RHME24000KST200H6HF KC6305	K34
5134043	RHME25000KST200H6HF KC6305	K34
5134044	RHME25400KST200H6HF KC6305	K34
5134045	RHME26000KST200H6HF KC6305	K34
5134046	RHME27000KST200H6HF KC6305	K34
5134047	RHME28000KST250H6HF KC6305	K34
5134048	RHME30000KST250H6HF KC6305	K34
5134049	RHME31750KST250H6HF KC6305	K34
5134050	RHME32000KST250H6HF KC6305	K34
5134051	RHME34000KST300H6HF KC6305	K34
5134052	RHME36000KST300H6HF KC6305	K34
5134053	RHME38000KST350H6HF KC6305	K34
5134054	RHME40000KST350H6HF KC6305	K34
5134055	RHME42000KST350H6HF KC6305	K34
5134072	RHME14000KST115H6HF KC6005	K34
5134073	RHME14288KST115H6HF KC6005	K34
5134074	RHME15000KST115H6HF KC6005	K34
5134075	RHME16000KST135H6HF KC6005	K34
5134076	RHME17000KST135H6HF KC6005	K34
5134077	RHME17463KST135H6HF KC6005	K34
5134078	RHME18000KST155H6HF KC6005	K34
5134079	RHME19000KST155H6HF KC6005	K34
5134120	RHME19050KST155H6HF KC6005	K34
5134121	RHME20000KST175H6HF KC6005	K34
5134122	RHME21000KST175H6HF KC6005	K34
5134123	RHME22000KST175H6HF KC6005	K34
5134124	RHME22225KST175H6HF KC6005	K34
5134125	RHME23000KST200H6HF KC6005	K34
5134126	RHME23813KST200H6HF KC6005	K34
5134127	RHME24000KST200H6HF KC6005	K34
5134128	RHME25000KST200H6HF KC6005	K34
5134129	RHME25400KST200H6HF KC6005	K34
5134130	RHME26000KST200H6HF KC6005	K34
5134131	RHME27000KST200H6HF KC6005	K34
5134132	RHME28000KST250H6HF KC6005	K34
5134133	RHME30000KST250H6HF KC6005	K34
5134134	RHME31750KST250H6HF KC6005	K34
5134135	RHME32000KST250H6HF KC6005	K34
5134136	RHME34000KST300H6HF KC6005	K34
5134137	RHME36000KST300H6HF KC6005	K34
5134138	RHME38000KST350H6HF KC6005	K34
5134139	RHME40000KST350H6HF KC6005	K34
5134140	RHME42000KST350H6HF KC6005	K34
5134141	KGIP0125N0189GD KCU45	H76
5134143	KGEM1905R1WN20M	H76
5134145	KGEM1905R3WN20M	H76
5136359	A4R0405M04U00GUP KCU25	C92
5136407	A4R0605M06U00GUP KCU25	C92
5136420	A4R0600M06P00GUP KCU10	C94
5136423	A4R0805M08U00GUP KCU25	C92
5140368	B269A12200HP KCPK15	G70
5144597	A4R125I03P00GUP KCU25	C94
5144598	A4R187I04P00GUP KCU25	C94
5144599	A4R250I06P00GUP KCU25	C94
5144664	KSEM2262HPGM KC7315	H43
5144793	CNMG120412RP KCPK05	B53
5146918	A4R0305M03U00GUP KCU25	C94
5146919	A4R0505M05U00GUP KCU25	C94
5147210	A4R1005M10U00GUP KCU25	C94
5147211	A4R0300M03P00GUP KCU25	C94
5147212	A4R0400M04P00GUP KCU25	C94
5147213	A4R0500M05P00GUP KCU25	C94
5147214	A4R0600M06P00GUP KCU25	C94
5147215	A4R0800M08P00GUP KCU25	C94
5147216	A4R1000M10P00GUP KCU25	C94
5148480	KSEM1619HPGM KC7315	H42
5152563	RNGJ10T3M0FLDJ KC422M	V50
5152566	RNGJ10T3M0ELDJ KC725M	V50
5152600	RNGJ10T3M0SGDJ KC725M	V51
5152606	RNGJ1605M0ELDJ KC522M	V61
5152607	RNGJ1605M0ELDJ KC725M	V61
5152621	KDR25Z03M12RN10	V46
5152622	KDR32Z04M16RN10	V46
5152623	KDR35Z05M16RN10	V46
5152624	KDR40Z05M16RN10	V46
5152626	KDR25Z03B25RN10	V47
5152629	KDR25Z03A25RN10L150	V48
5152680	KDR25Z03A25RN10L200	V48

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
5152681	KDR25Z03A32RN10L250	V48
5152683	KDR32Z04A32RN10L200	V48
5152684	KDR32Z03A32RN10L250	V48
5152685	KDR40Z04S16RN10	V49
5152686	KDR40Z06S16RN10	V49
5152687	KDR50Z05S22RN10	V49
5152688	KDR50Z06S22RN10	V49
5152689	KDR52Z06S22RN10	V49
5152690	KDR63Z07S22RN10	V49
5152691	KDR66Z07S27RN10	V49
5152692	KDR80Z08S27RN10	V49
5153837	KDR50Z04S22RN16	V60
5153838	KDR52Z04S22RN16	V60
5153839	KDR63Z04S22RN16	V60
5153890	KDR63Z06S22RN16	V60
5153891	KDR66Z05S27RN16	V60
5153892	KDR80Z05S27RN16	V60
5153893	KDR80Z07S27RN16	V60
5153894	KDR100Z06S32RN16	V60
5153895	KDR100Z08S32RN16	V60
5153897	KDR125Z08S40RN16	V60
5153898	KDR125Z10S40RN16	V60
5158428	RIQ09E1300 KC6305	K55
5159761	RIQ06R0500FT KT6315	K55
5161120	NA3L16 KCU10	D12
5161475	B978F14500 KC7315	G149
5169173	EDPT070308PDSRGE KC725M	T25
5169174	EDPT070308PDSRGE KC522M	T25
5169175	EDPT070308PDSRGE KCPK30	T25
5172862	RPPT1204M0SGDX KC725M	V74
5175059	B977F07100 KC7315	G144
5178669	B978F16000 KC7315	G149
5182481	KTIP1490HPM KCP15	H27
5182869	SNMG120412RN KCPK05	B101
5182893	SNMG150612RN KCPK05	B101
5189859	B269A08600HP KCPK15	G69
5190190	12A02R018A12ED07	T24
5190191	16A03R020A16ED07	T24
5190192	20A05R020A20ED07	T24
5190197	12A02R020M08ED07	T24
5201519	LS103	S126
5202233	SALS080	S126
5202234	SALS100	S126
5202235	SALS125	S126
5202236	SALS160	S126
5202514	SWSM515	S126
5211960	T630NC#06-32R2BX-D1 KP6525	M36
5211961	T630NC#08-32R2BX-D1 KP6525	M36
5211962	T630NC#10-24R2BX-D1 KP6525	M36
5211964	T630NC02500-20R3BX-D1 KP6525	M36
5211965	T630NC03125-18R3BX-D1 KP6525	M36
5211966	T630NC03750-16R3BX-D1 KP6525	M36
5211967	T630NC04375-14R3BX-D6 KP6525	M36
5211968	T630NC05000-13R3BX-D6 KP6525	M36
5211981	T630NF#06-40R2BX-D1 KP6525	M36
5211983	T630NF#10-32R2BX-D1 KP6525	M36
5211985	T630NF02500-28R3BX-D1 KP6525	M36
5211987	T630NF03125-24R3BX-D1 KP6525	M36
5211988	T630NF03750-24R3BX-D1 KP6525	M36
5211989	T630NF04375-20R3BX-D6 KP6525	M36
5211990	T630NF05000-20R3BX-D6 KP6525	M36
5211991	T631NC02500-20R3BX-D1 KP6525	M37
5211992	T631NC03125-18R3BX-D1 KP6525	M37
5211993	T631NC03750-16R3BX-D1 KP6525	M37
5211994	T631NC04375-14R3BX-D6 KP6525	M37
5211995	T631NC05000-13R3BX-D6 KP6525	M37
5211996	T631NF02500-28R3BX-D1 KP6525	M37
5211997	T631NF03125-24R3BX-D1 KP6525	M37
5211998	T631NF03750-24R3BX-D1 KP6525	M37
5211999	T631NF04375-20R3BX-D6 KP6525	M37
5212000	T631NF05000-20R3BX-D6 KP6525	M37
5212152	T620NC#06-32R2BX-D1 KP6525	M10
5212155	T620NC#08-32R2BX-D1 KP6525	M10
5212156	T620NC#10-24R2BX-D1 KP6525	M10
5212158	T620NC02500-20R3BX-D1 KP6525	M10
5212159	T620NC03125-18R3BX-D1 KP6525	M10
5212210	T620NC03750-16R3BX-D1 KP6525	M10
5212211	T620NC04375-14R3BX-D6 KP6525	M10
5212212	T620NC05000-13R3BX-D6 KP6525	M10
5212213	T620NF#06-40R2BX-D1 KP6525	M10
5212215	T620NF#10-32R2BX-D1 KP6525	M10
5212217	T620NF02500-28R3BX-D1 KP6525	M10
5212218	T620NF03125-24R3BX-D1 KP6525	M10
5212219	T620NF03750-24R3BX-D1 KP6525	M10
5212230	T620NF04375-20R3BX-D6 KP6525	M10
5212231	T620NF05000-20R3BX-D6 KP6525	M10
5212232	T621NC02500-20R3BX-D1 KP6525	M11
5212233	T621NC03125-18R3BX-D1 KP6525	M11
5212234	T621NC03750-16R3BX-D1 KP6525	M11
5212235	T621NC04375-14R3BX-D6 KP6525	M11
5212236	T621NC05000-13R3BX-D6 KP6525	M11
5212237	T621NF02500-28R3BX-D1 KP6525	M11
5212238	T621NF03125-24R3BX-D1 KP6525	M11
5212239	T621NF03750-24R3BX-D1 KP6525	M11
5212240	T621NF04375-20R3BX-D6 KP6525	M11
5212241	T621NF05000-20R3BX-D6 KP6525	M11
5212248	T640NC#06-32R2BX-D1 KP6525	M67
5212249	T640NC#08-32R2BX-D1 KP6525	M67
5212270	T640NC#10-24R2BX-D1 KP6525	M67
5212272	T640NC02500-20R3BX-D1 KP6525	M67
5212273	T640NC03125-18R3BX-D1 KP6525	M67
5212274	T640NC03750-16R3BX-D1 KP6525	M67
5212275	T640NC04375-14R3BX-D6 KP6525	M67
5212276	T640NC05000-13R3BX-D6 KP6525	M67
5212277	T640NF#06-40R2BX-D1 KP6525	M67
5212279	T640NF#10-32R2BX-D1 KP6525	M67
5212281	T640NF02500-28R3BX-D1 KP6525	M67
5212282	T640NF03125-24R3BX-D1 KP6525	M67
5212283	T640NF03750-24R3BX-D1 KP6525	M67
5212284	T640NF04375-20R3BX-D6 KP6525	M67
5212285	T640NF05000-20R3BX-D6 KP6525	M67
5212286	T641NC02500-20R3BX-D1 KP6525	M68
5212287	T641NC03125-18R3BX-D1 KP6525	M68
5212288	T641NC03750-16R3BX-D1 KP6525	M68
5212289	T641NC04375-14R3BX-D6 KP6525	M68
5212290	T641NC05000-13R3BX-D6 KP6525	M68
5212291	T641NF02500-28R3BX-D1 KP6525	M68
5212292	T641NF03125-24R3BX-D1 KP6525	M68
5212293	T641NF03750-24R3BX-D1 KP6525	M68
5212294	T641NF04375-20R3BX-D6 KP6525	M68
5212295	T641NF05000-20R3BX-D6 KP6525	M68
5214053	B269A03800HP KCPK15	G68
5274660	RNPJ10T3M0SGD KCPK30	V51
5274661	RNPJ10T3M0SGD KC522M	V51
5274663	RNPJ10T3M0SHD KCPK30	V51
5274665	RNPJ10T3M0SHD KCK15	V51
5274690	RNPJ1204M0SGD KCPK30	V58
5274691	RNPJ1204M0SGD KC522M	V58
5274693	RNPJ1204M0SHD KCPK30	V58
5274699	RNPJ1605M0SGD KCPK30	V61
5274720	RNPJ1605M0SGD KC725M	V61
5274721	RNPJ1605M0SGD KC522M	V61
5274722	RNPJ1605M0SHD KCPK30	V61
5274724	RNPJ1605M0SHD KCK15	V61
5274725	RNPJ1605M0SHD KC520M	V61
5276844	KEGT25L516PEERLDJ2 KC410M	T83
5309298	B977A16300 KC7315	G142
5314920	KTIP2110HPM KCP15	H28
5314951	B707A03800FBL KCMS15	G114
5324450	DCGR150404FP KCP25	E28
5324453	DCGR150404FP KCU10	E28
5324456	DCGR150408FP KCP10	E28
5324458	DCGR150408FP KCM25	E28
5324773	KCGR110304L08FP KCP10	E29
5324774	KCGR110304L08FP KCP25	E29
5324775	KCGR110304L08FP KCM25	E29
5324777	KCGR110304L08FP KCU25	E29
5324778	KCGR110304R08FP KCP10	E29
5324780	KCGR110304R08FP KCP25	E29
5324782	KCGR110304R08FP KCM25	E29
5324786	KCGR110308L08FP KCP10	E29
5324787	KCGR110308L08FP KCP25	E29
5324791	KCGR110308R08FP KCP10	E29
5324794	KCGR110308R08FP KCU10	E29
5324906	VBMR110302FP KCP25	E32
5324911	VBMR110304FP KCP10	E32
5324912	VBMR110304FP KCP25	E32
5324915	VBMR110304FP KCU25	E32
5324916	VBMR110308FP KCP10	E32
5324921	VBMR110308FP KCU10	E32
5324923	VCMR160404FP KCP10	E33
5324924	VCMR160404FP KCP25	E33
5324925	VCMR160404FP KCM25	E33
5324927	VCMR160404FP KCU10	E33
5324928	VCMR160404FP KCU25	E33
5324929	VCMR160408FP KCP10	E33
5324930	VCMR160408FP KCP25	E33
5324931	VCMR160408FP KCM25	E33
5324932	VCMR160408FP KCK05	E33
5327662	A4R0305M03U00GUP KCU10	C94
5327663	A4R0505M05U00GUP KCU10	C94
5327664	A4R1005M10U00GUP KCU10	C94
5327665	A4R0300M03P00GUP KCU10	C94
5327666	A4R1000M10P00GUP KCU10	C94
5327684	A4R125I03P00GUP KCU10	C94
5327686	A4R250I06P00GUP KCU10	C94
5327687	A4R312I08P00GUP KCU10	C94
5327912	VCGR160404HP K313	E35
5327919	VCGR160402FP KCP10	E35
5327936	VCGR160404FP KCP10	E35
5327937	VCGR160404FP KCP25	E35
5327938	VCGR160404FP KCM25	E35
5327940	VCGR160404FP KCU10	E35
5327942	VCGR160408FP KCP10	E35
5327943	VCGR160408FP KCP25	E35
5327944	VCGR160408FP KCM25	E35
5327945	VCGR160408FP KCK05	E35
5327948	VCGR160412FP KCP10	E35
5327949	VCGR160412FP KCP25	E35
5327961	VCGR160412FP KCK05	E35
5327965	VCGR160416FP KCP25	E35
5328738	DNGA150408S01225MT KBH20	B314
5329836	WNGA080404S01015MT KBH20	B324
5329837	WNGA080408S01015MT KBH20	B324
5329838	WNGA080408S01225MT KBH20	B324
5329839	WNGA080408S01735MT KBH20	B324
5330130	WNGA080408S01015FWMT KBH20	B323
5330131	CCGW060202S01225MT KBH20	B308
5330132	CCGW060204S01225MT KBH20	B308
5330133	CCGW09T302S01225MT KBH20	B308
5330134	CCGW09T304S01225MT KBH20	B308
5330135	CCGW09T304S01015MT KBH20	B308
5330136	CCGW09T304S01015FWMT KBH20	B308
5330137	CCGW09T308S01225MT KBH20	B308
5330138	CCGW09T308S01015MT KBH20	B308
5330139	CCGW09T308S01015FWMT KBH20	B308
5330140	CCGW120408S01015MT KBH20	B308
5330141	DCGW070202S01225MT KBH20	B312
5330142	DCGW070204S01225MT KBH20	B312
5330143	DCGW070204S01015MT KBH20	B312
5330144	DCGW11T302S01225MT KBH20	B312
5330145	DCGW11T304S01225MT KBH20	B312
5330146	DCGW11T304S01015MT KBH20	B312
5330147	DCGW11T308S01225MT KBH20	B312
5330148	DCGW11T308S01015MT KBH20	B312
5330149	DCGW11T308S01015FWMT KBH20	B312
5330150	TPGW110202S01015MT KBH20	B321
5330151	TPGW110204S01015MT KBH20	B321
5330152	TPGW110208S01015MT KBH20	B321
5330153	TCGW110202S01015MT KBH20	B319
5330154	TCGW110204S01015MT KBH20	B319
5330155	TCGW110208S01015MT KBH20	B319
5330156	TCGW090202S01015MT KBH20	B319
5330157	TCGW090204S01015 MT KBH20	B319
5330159	TPGW16T304S01015MT KBH20	B321
5330160	TPGW16T308S01225MT KBH20	B321
5330161	TPGW16T308S01015MT KBH20	B321
5330162	VBGW110304S01225MT KBH20	B322
5330163	VBGW110304S01015MT KBH20	B322

Index

Order No.	Catalogue No.	Page(s)
5330164	VBGW160408S01015MT KBH20	B322
5330165	VBGW160412S01015MT KBH20	B322
5330166	VBGW110308S01225MT KBH20	B322
5330167	VCGW160404S01225MT KBH20	B322
5330168	VCGW160404S01015MT KBH20	B322
5330169	VCGW160408S01225MT KBH20	B322
5330180	VCGW160408S01015MT KBH20	B322
5330695	CNGA120404S01225MT KBH20	B310
5330696	CNGA120404S01015MT KBH20	B310
5330697	CNGA120404S01735MT KBH20	B310
5330698	CNGA120404S01015FWMT KBH20	B310
5330699	CNGA120408S01225MT KBH20	B310
5330830	CNGA120408S01015MT KBH20	B310
5330831	CNGA120408S01735MT KBH20	B310
5330832	CNGA120408S01015FWMT KBH20	B310
5330833	CNGA120412S01225MT KBH20	B310
5330834	CNGA120412S01015MT KBH20	B310
5330835	CNGA120412S01735MT KBH20	B310
5330836	CNGA120412S01015FWMT KBH20	B310
5330837	DNGA150404S01225MT KBH20	B314
5330838	DNGA150404S01015MT KBH20	B314
5330839	DNGA150404S01735MT KBH20	B314
5330840	DNGA150408S01015MT KBH20	B314
5330841	DNGA150408S01735MT KBH20	B314
5330842	DNGA150412S01225MT KBH20	B314
5330843	DNGA150412S01015MT KBH20	B314
5330844	DNGA150412S01735MT KBH20	B314
5330845	DNGA150408S01015FWMT KBH20	B313
5330846	DNGA150412S01015FWMT KBH20	B313
5330847	DNGA150604S01225MT KBH20	B314
5330848	DNGA150604S01015MT KBH20	B314
5330849	DNGA150604S01735MT KBH20	B314
5330850	DNGA150608S01225MT KBH20	B314
5330851	DNGA150608S01015MT KBH20	B314
5330852	DNGA150608S01735MT KBH20	B314
5330853	DNGA150612S01225MT KBH20	B314
5330854	DNGA150612S01015MT KBH20	B314
5330855	DNGA150612S01735MT KBH20	B314
5330856	SNGA120408S01225MT KBH20	B318
5330857	SNGA120412S01225MT KBH20	B318
5330858	TNGA160404S01225MT KBH20	B320
5330859	TNGA160404S01015MT KBH20	B320
5330860	TNGA160404S01735MT KBH20	B320
5330861	TNGA160408S01225MT KBH20	B320
5330862	TNGA160408S01015MT KBH20	B320
5330863	TNGA160408S01735MT KBH20	B320
5330864	TNGA160412S01225MT KBH20	B320
5330865	TNGA160412S01015MT KBH20	B320
5330866	TNGA160412S01735MT KBH20	B320
5330867	VNGA160404S01225MT KBH20	B323
5330868	VNGA160404S01015MT KBH20	B323
5330869	VNGA160404S01735MT KBH20	B323
5330870	VNGA160408S01225MT KBH20	B323
5330871	VNGA160408S01015MT KBH20	B323
5330872	VNGA160408S01735MT KBH20	B323
5330873	VNGA160412S01225MT KBH20	B323
5337754	KM4X100NEL3	D32
5337755	KM4X100NEL4	D32
5337756	KM4X100NEL5	D32
5337757	KM4X100NEL6	D32
5337758	KM4X100NER3	D32
5337759	KM4X100NER4	D32
5337770	KM4X100NER5	D32
5337771	KM4X100NER6	D32
5338057	KDR160Z12S40RN16	V60
5341813	KSEM3125HPGM KC7315	H43
5344687	F4AS1400ADL38 KCPM15	P16
5347999	EADE0380A4AQE KYS40	P176
5348060	EADE0400A4AQE KYS40	P176
5348061	EADE0570A4AQF KYS40	P176
5348062	EADE0600A4AQF KYS40	P176
5348063	EADE0760A4AQG KYS40	P176
5348064	EADE0800A4AQG KYS40	P176
5348065	EADE0950A4AQH KYS40	P176
5348066	EADE1000A4AQH KYS40	P176
5348067	EADE1140A4AQJ KYS40	P176
5348068	EADE1200A4AQJ KYS40	P176
5348069	EADE0400A6ARE KYS40	P177
5348070	EADE0600A6ARF KYS40	P177
5348071	EADE0800A6ARG KYS40	P177
5348072	EADE1000A6ARH KYS40	P177
5348073	EADE1200A6ARJ KYS40	P177
5348571	CNGM120408S01325MTCB1 KBH20	B310
5348572	CNGM120412S01325MTCB1 KBH20	B310
5348573	CNGM120404S01325MTCB1 KBH20	B310
5348574	DNGM150408S01325MTCB1 KBH20	B314
5348575	DNGM150412S01325MTCB1 KBH20	B314
5348576	DNGM150608S01325MTCB1 KBH20	B314
5348577	DNGM150612S01325MTCB1 KBH20	B314
5348579	TNGM160408S01325MTCB1 KBH20	B320
5348582	VNGM160408S01325MTCB1 KBH20	B323
5348583	VNGM160412S01325MTCB1 KBH20	B323
5348584	CCGM09T304S01325MTCB1 KBH20	B308
5348585	CCGM09T308S01325MTCB1 KBH20	B308
5348586	DCGM11T304S01325MTCB1 KBH20	B311
5350287	UJDE1000A6ARE KCSM15	P48
5350288	UJDE1000A6AS KCSM15	P48
5350289	UJDE1000A6AQE KCSM15	P49
5350320	UJDE1000A6AQG KCSM15	P49
5350321	UJDE1000A6AQK KCSM15	P49
5350322	UJDE1000A6AQM KCSM15	P49
5350323	UJDE1000A6ANS KCSM15	P49
5350324	UJDE1200A6ARF KCSM15	P48
5350325	UJDE1200A6AS KCSM15	P48
5350326	UJDE1200E6ARF KCSM15	P48
5350327	UJDE1200A6AQE KCSM15	P49
5350328	UJDE1200A6AQG KCSM15	P49
5350329	UJDE1200A6AQK KCSM15	P49
5350330	UJDE1200A6AQM KCSM15	P49
5350331	UJDE1200A6ANS KCSM15	P49
5350332	UJDE1200E6AQE KCSM15	P49
5350333	UJDE1200E6AQG KCSM15	P49
5350334	UJDE1200E6AQK KCSM15	P49
5350335	UJDE1200E6AQM KCSM15	P49
5350336	UJDE1400A6ARF KCSM15	P48
5350337	UJDE1400E6ARF KCSM15	P48
5350338	UJDE1400A6AS KCSM15	P48
5350339	UJDE1600A6ARF KCSM15	P48
5350340	UJDE1600E6ARF KCSM15	P48
5350341	UJDE1600A6AS KCSM15	P48
5350342	UJDE1600A6AQE KCSM15	P49
5350343	UJDE1600A6AQG KCSM15	P49
5350344	UJDE1600A6AQK KCSM15	P49
5350345	UJDE1600A6AQM KCSM15	P49
5350346	UJDE1600A6AQN KCSM15	P49
5350347	UJDE1600A6ANS KCSM15	P49
5350348	UJDE1600E6AQE KCSM15	P49
5350349	UJDE1600E6AQG KCSM15	P49
5350350	UJDE1600E6AQK KCSM15	P49
5350351	UJDE1600E6AQM KCSM15	P49
5350352	UJDE1600E6AQN KCSM15	P49
5350437	RIQ06E1306 KC6005	K55
5350613	UJDE2000A6ARF KCSM15	P48
5350615	UJDE2000E6ARF KCSM15	P48
5350616	UJDE2000A6AS KCSM15	P48
5350617	UJDE2000A6AQE KCSM15	P49
5350618	UJDE2000A6AQG KCSM15	P49
5350619	UJDE2000A6AQK KCSM15	P49
5350640	UJDE2000A6AQM KCSM15	P49
5350641	UJDE2000A6AQN KCSM15	P49
5350642	UJDE2000A6ANS KCSM15	P49
5350644	UJDE2000E6AQE KCSM15	P49
5350645	UJDE2000E6AQG KCSM15	P49
5350646	UJDE2000E6AQK KCSM15	P49
5350647	UJDE2000E6AQM KCSM15	P49
5350648	UJDE2000E6AQN KCSM15	P49
5350649	UJDE2500A6ARF KCSM15	P48
5350650	UJDE2500E6ARF KCSM15	P48
5350651	UJDE2500A6AS KCSM15	P48
5350652	UJDE2500A6AQE KCSM15	P49
5350653	UJDE2500A6AQG KCSM15	P49
5350654	UJDE2500A6AQK KCSM15	P49
5350655	UJDE2500A6AQM KCSM15	P49
5350656	UJDE2500A6AQN KCSM15	P49
5350658	UJDE2500E6AQE KCSM15	P49
5350659	UJDE2500E6AQG KCSM15	P49
5350660	UJDE2500E6AQK KCSM15	P49
5350661	UJDE2500E6AQM KCSM15	P49
5350662	UJDE2500E6AQN KCSM15	P49
5356982	UADE0600B4AL KCPM15	P20
5356983	UADE0800B4AL KCPM15	P20
5356984	UADE1000B4AL KCPM15	P20
5356985	UADE1200B4AL KCPM15	P20
5356986	UADE1600B4AL KCPM15	P20
5356987	UADE2000B4AL KCPM15	P20
5356988	UADE0600A4AL KCPM15	P20
5356989	UADE0800A4AL KCPM15	P20
5357000	UADE1000A4AL KCPM15	P20
5357001	UADE1200A4AL KCPM15	P20
5357002	UADE1600A4AL KCPM15	P20
5357003	UADE2000A4AL KCPM15	P20
5357041	RUDC0400B3BN KCPM15	P80
5357042	RUDC0500B3BN KCPM15	P80
5357043	RUDC0600B3BN KCPM15	P80
5357044	RUDC0800B3BN KCPM15	P80
5357045	RUDC1000B4BN KCPM15	P80
5357046	RUDC1200B4BN KCPM15	P80
5357047	RUDC1400B4BN KCPM15	P80
5357048	RUDC1600B4BN KCPM15	P80
5357049	RUDC1800B4BN KCPM15	P80
5357090	RUDC2000B4BN KCPM15	P80
5357091	RUDC2500B5BN KCPM15	P80
5357097	UBDE1200E4AQE KCSM15	P18
5357098	UBDE1200E4AQG KCSM15	P18
5357099	UBDE1200E4AQK KCSM15	P18
5357150	UBDE1200E4AQM KCSM15	P18
5357151	UBDE1200E4AQN KCSM15	P18
5357152	UBDE1600E4AQE KCSM15	P18
5357153	UBDE1600E4AQG KCSM15	P18
5357154	UBDE1600E4AQK KCSM15	P18
5357155	UBDE1600E4AQM KCSM15	P18
5357156	UBDE1600E4AQN KCSM15	P18
5357157	UBDE2000E4AQE KCSM15	P18
5357158	UBDE2000E4AQG KCSM15	P18
5357159	UBDE2000E4AQK KCSM15	P18
5357160	UBDE2000E4AQM KCSM15	P18
5357161	UBDE2000E4AQN KCSM15	P18
5357162	UBDE2500E4AQE KCSM15	P18
5357163	UBDE2500E4AQG KCSM15	P18
5357164	UBDE2500E4AQK KCSM15	P18
5357165	UBDE2500E4AQM KCSM15	P18
5357166	UBDE2500E4AQN KCSM15	P18
5358354	UDDE1200E5AQE KCSM15	P31
5358355	UDDE1200E5AQG KCSM15	P31
5358356	UDDE1200E5AQK KCSM15	P31
5358357	UDDE1200E5AQM KCSM15	P31
5358358	UDDE1600E5AQE KCSM15	P31
5358359	UDDE1600E5AQG KCSM15	P31
5358390	UDDE1600E5AQK KCSM15	P31
5358392	UDDE1600E5AQM KCSM15	P32
5358393	UDDE1600E5AQN KCSM15	P32
5358394	UDDE2000E5AQE KCSM15	P32
5358395	UDDE2000E5AQG KCSM15	P32
5358396	UDDE2000E5AQK KCSM15	P32
5358397	UDDE2000E5AQM KCSM15	P32
5358398	UDDE2000E5AQN KCSM15	P32
5358399	UDDE2500E5AQE KCSM15	P32
5358400	UDDE2500E5AQG KCSM15	P32
5358401	UDDE2500E5AQK KCSM15	P32
5358402	UDDE2500E5AQM KCSM15	P32
5358403	UDDE2500E5AQN KCSM15	P32
5358886	KSOM32Z03M160F06X	S46
5358887	KSOM40Z04M160F06X	S46
5358888	KSOM32Z03A320F06X	S47
5358889	KSOM40Z040F06X	S48
5358930	KSOM50Z060F06X	S48
5358931	KSOM63Z070F06X	S48
5358932	KSOM80Z090F06X	S48
5362754	CCMT09T312MP KCU10	B177
5366566	B269A17100HP KCPK15	G70
5377581	B269A04700HP KCPK15	G68
5377582	B269A06100HP KCPK15	G69
5378294	B269A11200HP KCPK15	G69
5387230	CNMG120412FM KCP10B	B50
5387231	CNMG120412FM KCP25B	B50
5387540	DNMG150612CT KCP25B	B76
5387541	DNMG150612MN KCP25B	B78
5387542	DNMG150612RN KCP25B	B81
5387543	DNMG150612RP KCP25B	B81
5387544	DNMG150616RN KCP25B	B81
5387545	DNMG150616RP KCP25B	B81
5387547	DPMT11T308LF KCP25B	B215
5387550	SCMT09T304LF KCP25B	B230
5387551	SCMT09T308FP KCP25B	B230
5387553	SCMT09T308MF KCP25B	B231
5387554	SCMT09T308MP KCP25B	B231
5387555	SCMT09T312MF KCP25B	B231
5387556	SCMT120408FP KCP25B	B230
5387557	SCMT120408MF KCP25B	B231
5387558	SCMT120412LF KCP25B	B230
5387559	SCMT120412MF KCP25B	B231
5387563	SNMG120412RP KCP25B	B101
5387567	SNMG150612RP KCP25B	B101
5387571	SPMT09T308LF KCP25B	B238
5387575	TNMG160412RP KCP25B	B128
5387577	TNMG220416RP KCP25B	B128
5387579	TPMT110208LF KCP25B	B255
5387580	TPMT110208MF KCP25B	B255
5387581	TPMT16T308LF KCP25B	B255
5387584	VBMT160404FP KCP25B	B265
5387587	VBMT160408MP KCP25B	B265
5387588	VBMT160412FP KCP25B	B265
5387610	WNMG060408RN KCP25B	B159
5387611	WNMG080408MN KCP25B	B157
5387612	WNMG080408MW KCP25B	B158
5387614	WNMG080412MN KCP25B	B157
5387615	WNMG080412MW KCP25B	B158
5387616	WNMG080412RN KCP25B	B159
5387618	WNMG080416RN KCP25B	B159
5387627	CCMT09T304LF KCP25B	B177
5387628	CCMT09T308LF KCP25B	B177
5387629	CCMT09T308MF KCP25B	B177
5387661	CCMT120408MF KCP25B	B177
5387662	CNMG120408MN KCP25B	B50
5387663	CNMG120408MW KCP25B	B52
5387664	CNMG120408RN KCP25B	B53
5387665	CNMG120408RP KCP25B	B53
5387667	CNMG120412MN KCP25B	B50
5387668	CNMG120412RN KCP25B	B53
5387681	CNMG120416RN KCP25B	B53
5387688	CNMG190612MN KCP25B	B50
5387689	CNMG190612RN KCP25B	B53
5387691	CNMG190616RN KCP25B	B53
5387692	CNMM120412RM KCP25B	B55
5387693	CNMM120412RP KCP25B	B56
5387694	CNMM120416RP KCP25B	B56
5387695	CNMM160612RM KCP25B	B55
5387696	CNMM160616RP KCP25B	B56
5387697	CNMM190616RM KCP25B	B55
5387698	CNMM190624RH KCP25B	B55
5387699	CNMM190624RM KCP25B	B55
5387727	DCMT11T308LF KCP25B	B207
5387729	DCMT11T312MF KCP25B	B208
5387732	DNMG150408MN KCP25B	B78
5387733	DNMG150408RN KCP25B	B81
5387737	DNMG150608MN KCP25B	B78
5387753	CNMG120408FN KCK15B	B49

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
5387754	VNMG160408FN KCK15B	B145
5387755	CNMG120408MW KCK15B	B52
5387801	CNMG120412UN KCK15B	B54
5387802	CNMG120408UN KCK15B	B54
5387804	TNMG160408UN KCK15B	B128
5387805	SNMG120412UN KCK15B	B102
5387806	RNMG120400UN KCK15B	B94
5387807	TNMG160412UN KCK15B	B128
5387808	WNMG080408UN KCK15B	B160
5387809	WNMG080416UN KCK15B	B160
5387810	DNMG110408UN KCK15B	B82
5387811	CNMG160616UN KCK15B	B54
5387812	DNMG150616UN KCK15B	B82
5387851	DNMG150616RP KCP10B	B81
5387853	DPMT11T308LF KCP10B	B215
5387856	SCMT09T304LF KCP10B	B230
5387858	SCMT09T308MF KCP10B	B231
5387864	SCMT120412LF KCP10B	B230
5387874	SNMG120412RP KCP10B	B101
5387882	SNMG150612RP KCP10B	B101
5387884	SPMT09T308LF KCP10B	B238
5387896	TNMG160412RP KCP10B	B128
5387901	TNMG220432RP KCP10B	B128
5387903	TPMT110208LF KCP10B	B255
5387905	TPMT16T308LF KCP10B	B255
5387907	VBMT160404FP KCP10B	B265
5387910	VBMT160412FP KCP10B	B265
5387915	WNMG080408RP KCP10B	B159
5387919	WNMG080412RP KCP10B	B159
5388031	CCMT09T304LF KCP10B	B177
5388032	CCMT09T308LF KCP10B	B177
5388033	CCMT09T308MF KCP10B	B177
5388035	CCMT120408MF KCP10B	B177
5388036	CNMG120408MN KCP10B	B50
5388037	CNMG120408MW KCP10B	B52
5388038	CNMG120408RN KCP10B	B53
5388039	CNMG120408RP KCP10B	B53
5388061	CNMG120412MN KCP10B	B50
5388062	CNMG120412RN KCP10B	B53
5388064	CNMG120416RN KCP10B	B53
5388082	CNMG190612RN KCP10B	B53
5388084	CNMG190616RN KCP10B	B53
5388085	CNMM120412RM KCP10B	B55
5388086	CNMM120412RP KCP10B	B56
5388088	CNMM160612RM KCP10B	B55
5388089	CNMM160616RP KCP10B	B56
5388090	CNMM190616RM KCP10B	B55
5388095	DCMT11T308LF KCP10B	B207
5388097	DCMT11T312MF KCP10B	B208
5388111	DNMG150408MN KCP10B	B78
5388112	DNMG150408RN KCP10B	B81
5388116	DNMG150608FN KCP10B	B77
5388117	DNMG150608MN KCP10B	B78
5393242	CNMG120408RN KCK15B	B53
5393244	CNMG120408RN KCP40B	B53
5396014	KF2X63Z05S22WO09	V40
5396015	KF2X66Z06S22WO09	V40
5397385	KSEM1270HPGM KCPM45	H45
5397386	KSEM1293HPGM KCPM45	H45
5397387	KSEM1400HPGM KCPM45	H45
5397388	KSEM1429HPGM KCPM45	H45
5397389	KSEM1609HPGM KCPM45	H45
5397470	KSEM1620HPGM KCPM45	H45
5397471	KSEM1667HPGM KCPM45	H45
5397473	KSEM1746HPGM KCPM45	H45
5397474	KSEM1800HPGM KCPM45	H45
5397475	KSEM1826HPGM KCPM45	H45
5397476	KSEM1900HPGM KCPM45	H45
5397477	KSEM1920HPGM KCPM45	H45
5397478	KSEM1905HPGM KCPM45	H45
5397479	KSEM1925HPGM KCPM45	H45
5397480	KSEM1927HPGM KCPM45	H45
5397481	KSEM1950HPGM KCPM45	H45
5397482	KSEM1984HPGM KCPM45	H45
5397483	KSEM2000HPGM KCPM45	H45
5397484	KSEM2064HPGM KCPM45	H45
5397485	KSEM2100HPGM KCPM45	H45
5397486	KSEM2200HPGM KCPM45	H45
5397487	KSEM2223HPGM KCPM45	H45
5397488	KSEM2300HPGM KCPM45	H45
5397489	KSEM2381HPGM KCPM45	H45
5397490	KSEM2400HPGM KCPM45	H45
5397491	KSEM2500HPGM KCPM45	H46
5397492	KSEM2540HPGM KCPM45	H46
5397493	KSEM2560HPGM KCPM45	H46
5397494	KSEM2565HPGM KCPM45	H46
5397495	KSEM2567HPGM KCPM45	H46
5397496	KSEM2581HPGM KCPM45	H46
5397497	KSEM2600HPGM KCPM45	H46
5397498	KSEM2619HPGM KCPM45	H46
5397499	KSEM2700HPGM KCPM45	H46
5397500	KSEM2800HPGM KCPM45	H46
5397501	KSEM2858HPGM KCPM45	H46
5397502	KSEM3000HPGM KCPM45	H46
5397503	KSEM3016HPGM KCPM45	H46
5397504	KSEM3175HPGM KCPM45	H46
5397505	KSEM3200HPGM KCPM45	H46
5397506	KSEM3300HPGM KCPM45	H46
5397507	KSEM3334HPGM KCPM45	H46
5397508	KSEM3600HPGM KCPM45	H46
5397509	KSEM3810HPGM KCPM45	H46
5397510	KSEM4000HPGM KCPM45	H46
5397513	KSEMP7200FDS71A1M	H82, H92, H99
5397514	KSEMP7400FDS71A1M	H82, H92, H99
5397515	KSEMP7600FDS71A1M	H82, H93, H99
5397516	KSEMP7620FDS71A1M	H82, H93, H99
5397517	KSEMP7800FDS71A1M	H82, H93, H99
5397518	KSEMP8000FDS80A1M	H82, H93, H99
5397519	KSEMP8200FDS80A1M	H82, H93, H99
5397550	KSEMP8255FDS80A1M	H82, H93, H99
5397551	KSEMP8400FDS80A1M	H82, H93, H99
5397552	KSEMP8600FDS80A1M	H82, H93, H99
5397553	KSEMP8800FDS80A1M	H82, H93, H99
5397554	KSEMP8890FDS80A1M	H82, H93, H99
5397555	KSEMP9000FDS90A1M	H82, H93, H99
5397556	KSEMP9200FDS90A1M	H82, H93, H99
5397557	KSEMP9400FDS90A1M	H82, H93, H99
5397558	KSEMP9525FDS90A1M	H82, H93, H99
5397559	KSEMP9600FDS90A1M	H82, H93, H99
5397560	KSEMP9800FDS90A1M	H82, H93, H99
5397561	KSEMP10160FDS90A1M	H82, H93, H99
5397562	KSEMP7620FDS71B1M	H86, H95
5397563	KSEMP8255FDS80B1M	H86, H96
5397564	KSEMP8890FDS80B1M	H86, H96
5397565	KSEMP9525FDS90B1M	H86, H96
5397566	KSEMP10160FDS90B1M	H86, H96
5397942	WD50FDS71292M	H102
5397943	WD50FDS71452M	H103
5397944	WD50FDS80327M	H102
5397945	WD50FDS80507M	H103
5397946	WD50FDS90362M	H102
5397947	WD50FDS90562M	H103
5400814	B272Z06400HPS KN25	G76
5402877	SNMG120412MR KCM25	B99
5402879	SNMG120412MR KCP10B	B99
5402920	SNMG120412MR KCP25B	B99
5402924	TNMG160408MR KCM25	B126
5402926	TNMG160408MR KCP10B	B126
5402927	TNMG160408MR KCP25B	B126
5402930	TNMG160412MR KCP10B	B126
5402931	TNMG160412MR KCP25B	B126
5402932	TNMG160412MR KCK15B	B126
5402935	WNMG080408MR KCM25	B157
5402936	WNMG080408MR KCM35	B157
5402937	WNMG080408MR KCP10B	B157
5402938	WNMG080408MR KCP25B	B157
5402960	WNMG080408MR KCK15B	B157
5402963	WNMG080412MR KCM35	B157
5402964	WNMG080412MR KCP10B	B157
5402965	WNMG080412MR KCP25B	B157
5402966	DNMG150408MR KCM15	B80
5402969	DNMG150408MR KCP10B	B80
5402980	DNMG150408MR KCP25B	B80
5402983	DNMG150608MR KCM25	B80
5402985	DNMG150608MR KCP10B	B80
5402986	DNMG150608MR KCP25B	B80
5402987	DNMG150608MR KCK15B	B80
5402990	DNMG150412MR KCP10B	B80
5402995	DNMG150616MR KCP25B	B80
5403016	CNMG120408MR KCM15	B51
5403017	CNMG120408MR KCM25	B51
5403018	CNMG120408MR KCM35	B51
5403019	CNMG120408MR KCP10B	B51
5403090	CNMG120408MR KCP25B	B51
5403091	CNMG120408MR KCP40	B51
5403092	CNMG120408MR KCK15B	B51
5403093	CNMG120412MR KCM15	B51
5403094	CNMG120412MR KCM25	B51
5403095	CNMG120412MR KCM35	B51
5403096	CNMG120412MR KCP10B	B51
5403097	CNMG120412MR KCP25B	B51
5403099	CNMG120412MR KCK15B	B51
5403103	CNMG160612MR KCP10B	B51
5403104	CNMG160612MR KCP25B	B51
5403105	CNMG160612MR KCP40	B51
5403108	CNMG120416MR KCP10B	B51
5403112	CNMG160616MR KCP10B	B51
5403113	CNMG160616MR KCP25B	B51
5403116	CNMG190612MR KCM25	B51
5403119	CNMG190612MR KCP25B	B51
5405652	PSC50KGMER65C	C65, C135
5405653	PSC50KGMEL65C	C65, C135
5405654	PSC50KGMSR65C	C64, C134
5405655	PSC50KGMSL65C	C64, C134
5406563	170.365	H99
5408657	KGEM1588R1WN20M	H76
5413058	CNMG120416UN KCK15B	B54
5413059	CNMM250924RH KCP25B	B55
5413170	CCMT09T312MF KCP25B	B177
5413171	CNMG120412CT KCP10B	B48
5413172	CNMG120412CT KCP25B	B48
5413173	CNMG120412MW KCK15B	B52
5413174	CNMG120412RP KCP10B	B53
5413175	CNMG120412RP KCP25B	B53
5413176	CNMG120416RP KCP10B	B53
5413177	CNMG120416RP KCP25B	B53
5413178	CNMG160612MN KCP10B	B50
5413179	CNMG160612MN KCP25B	B50
5413180	CNMG160612RP KCP10B	B53
5413181	CNMG160612RP KCP25B	B53
5413182	CNMG160616RP KCP10B	B53
5413183	CNMG160616RP KCP25B	B53
5413184	CPMT060208MP KCP25B	B190
5413185	CPMT09T308LF KCP10B	B190
5413186	CPMT09T308LF KCP25B	B190
5413187	CPMT09T308MF KCP10B	B190
5413188	CPMT09T308MF KCP25B	B190
5413189	CPMT09T308MP KCP25B	B190
5413190	DCMT11T308MF KCP10B	B208
5413191	DCMT11T308MF KCP25B	B208
5413193	DNMG110412MN KCP25B	B78
5413194	DNMG150404CT KCP25B	B76
5413195	DNMG150412RP KCP10B	B81
5413196	DNMG150412RP KCP25B	B81
5413197	DNMG150608RP KCP10B	B81
5413198	DNMG150608RP KCP25B	B81
5413199	DNMG150612CT KCP10B	B76
5413200	DNMG150612MN KCP10B	B78
5413201	DNMG150612RP KCP10B	B81
5413202	DNMG150612RP KCP10B	B81
5413203	SNMG120412RP KCK15B	B101
5413205	VNMG160412RP KCK15B	B147
5413206	WNMG080408RP KCP25B	B159
5413207	WNMG080412RP KCP25B	B159
5413208	WNMG080416RP KCP25B	B159
5413209	DNMM150616RP KCP10B	B83
5413210	CNMM250924RM KCP25B	B55
5413211	SNMM250724RH KCP25B	B102
5413212	SNMM250924RH KCP25B	B102
5413242	SCMT09T308LF KCP10B	B230
5413249	TNMG160408FN KCP10B	B124
5413250	TNMG160408MN KCP10B	B125
5413251	TNMG160412FN KCP10B	B124
5413255	VBMT110304LF KCP10B	B265
5413256	VBMT160404LF KCP10B	B265
5413257	VBMT160408LF KCP10B	B265
5413260	WNMG080408MN KCP10B	B157
5413261	WNMG080408MW KCP10B	B158
5413263	WNMG080412MW KCP10B	B158
5413269	SCMT09T308LF KCP25B	B230
5413276	SNMM190616RM KCP25B	B103
5413277	TNMG160408MN KCP25B	B125
5413291	VBMT110304LF KCP25B	B265
5413292	VBMT160404LF KCP25B	B265
5413293	VBMT160408LF KCP25B	B265
5413746	RNPJ10T3M0SHD KC725M	V51
5413747	RNPJ1204M0SGD KC725M	V58
5413748	RNPJ1204M0SHD KC725M	V58
5413749	RNPJ1605M0SHD KC725M	V61
5414455	ABDE1000A3ARG K600	P112
5414456	ABDE1000A3ARK K600	P112
5414458	ABDE1000A3ARN K600	P112
5414459	ABDE1200A3ARG K600	P112
5414470	ABDE1200A3ARK K600	P112
5414471	ABDE1200A3ARM K600	P112
5414473	ABDE1200A3ARN K600	P112
5414474	ABDE1600A3ARN K600	P113
5414475	ABDE1600A3ARN K600	P113
5414476	ABDE2000A3ARG K600	P113
5414477	ABDE2000A3ARK K600	P113
5414478	ABDE2000A3ARM K600	P113
5414479	ABDE2500A3ARE K600	P113
5414480	ABDE2500A3ARG K600	P113
5414481	ABDE2500A3ARK K600	P113
5414482	ABDE2500A3ARM K600	P113
5414483	ABDE2500A3ARN K600	P113
5415049	RIQ06EGR06 KD1415	K56
5417205	T820M020X040R6H-D1 KSP32	M14
5417206	T820M020X040R6H-D1 KSP39	M14
5417207	T820M020X040R6G-D1 KSP39	M14
5417208	T820M025X045R6H-D1 KSP39	M14
5417209	T820M025X045R6G-D1 KSP39	M14
5417220	T820M030X050R6H-D1 KSP32	M14
5417221	T820M030X050R6H-D1 KSP39	M14
5417222	T820M030X050R6G-D1 KSP39	M14
5417223	T820M035X060R6H-D1 KSP39	M14
5417224	T820M040X070R6H-D1 KSP32	M14
5417225	T820M040X070R6H-D1 KSP39	M14
5417226	T820MF040X050R6H-D4 KSP39	M14
5417227	T820M040X070R6G-D1 KSP39	M14
5417228	T820M050X080R6H-D1 KSP32	M14
5417229	T820M050X080R6H-D1 KSP39	M14
5417230	T820MF050X050R6H-D4 KSP39	M14
5417231	T820M050X080R6G-D1 KSP39	M14
5417232	T820M060X100R6H-D1 KSP32	M14
5417233	T820M060X100R6H-D1 KSP39	M14
5417234	T820MF060X050R6H-D4 KSP39	M14
5417235	T820MF060X075R6H-D4 KSP39	M14
5417236	T820M060X100R6G-D1 KSP39	M14
5417237	T820M070X100R6H-D1 KSP32	M14
5417238	T820M070X100R6H-D1 KSP39	M14
5417239	T820M070X100R6G-D1 KSP39	M14
5417240	T820M080X125R6H-D1 KSP32	M14
5417241	T820M080X125R6H-D1 KSP39	M14
5417242	T820MF080X100R6H-D4 KSP39	M14
5417243	T820M080X125R6G-D1 KSP39	M14
5417244	T820M100X150R6H-D1 KSP32	M14
5417245	T820M100X150R6H-D1 KSP39	M14
5417246	T820MF100X125R6H-D4 KSP39	M14
5417247	T820M100X150R6G-D1 KSP39	M14
5417248	T820M060X100R6H-D6 KSP39	M14
5417249	T820M080X125R6H-D6 KSP39	M14
5417250	T820M100X150R6H-D6 KSP39	M14
5417251	T820M120X175R6H-D6 KSP32	M15
5417252	T820M120X175R6H-D6 KSP39	M15
5417253	T820MF120X125R6H-D4 KSP39	M14
5417254	T820MF120X150R6H-D4 KSP39	M14
5417255	T820M120X175R6G-D6 KSP39	M15
5417256	T820M140X200R6H-D6 KSP32	M15
5417257	T820M140X200R6H-D6 KSP39	M15
5417258	T820MF140X125R6H-D4 KSP39	M15
5417259	T820MF140X150R6H-D4 KSP39	M15
5417260	T820M140X200R6G-D6 KSP39	M15
5417261	T820M160X200R6H-D6 KSP32	M15
5417262	T820M160X200R6H-D6 KSP39	M15
5417263	T820MF160X150R6H-D4 KSP39	M15
5417264	T820M160X200R6G-D6 KSP39	M15
5417265	T820M180X250R6H-D6 KSP32	M15
5417266	T820M180X250R6H-D6 KSP39	M15
5417267	T820MF180X150R6H-D4 KSP39	M15
5417268	T820M200X250R6H-D6 KSP32	M15
5417269	T820M200X250R6H-D6 KSP39	M15
5417270	T820M220X250R6H-D6 KSP39	M15
5417271	T820M240X300R6H-D6 KSP39	M15
5417272	T820M270X300R6H-D6 KSP39	M15
5417273	T820M300X350R6H-D6 KSP39	M15
5417274	T820M330X350R6H-D6 KSP39	M15
5417275	T820M360X400R6H-D6 KSP39	M15

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
5417276	T830M020X040R6H-D1 KSP39	M40
5417277	T830M020X040R6G-D1 KSP39	M40
5417278	T830M025X045R6H-D1 KSP39	M40
5417279	T830M025X045R6G-D1 KSP39	M40
5417280	T830M030X050R6H-D1 KSP32	M40
5417281	T830M030X050R6H-D1 KSP39	M40
5417282	T830M030X050R6G-D1 KSP39	M40
5417283	T830M035X060R6H-D1 KSP39	M40
5417284	T830M040X070R6H-D1 KSP32	M40
5417285	T830M040X070R6H-D1 KSP39	M40
5417286	T830M040X070R6G-D1 KSP39	M40
5417287	T830M050X080R6H-D1 KSP32	M40
5417288	T830M050X080R6H-D1 KSP39	M40
5417289	T830M050X080R6G-D1 KSP39	M40
5417290	T830M060X100R6H-D1 KSP32	M40
5417291	T830M060X100R6H-D1 KSP39	M40
5417292	T830M060X100R6G-D1 KSP39	M40
5417293	T830M070X100R6H-D1 KSP39	M40
5417294	T830M080X125R6H-D1 KSP32	M40
5417295	T830M080X125R6H-D1 KSP39	M40
5417296	T830MF080X100R6H-D4 KSP32	M40
5417297	T830MF080X100R6H-D4 KSP39	M40
5417298	T830M080X125R6G-D1 KSP39	M40
5417299	T830M100X150R6H-D1 KSP32	M40
5417300	T830M100X150R6H-D1 KSP39	M40
5417301	T830MF100X125R6H-D4 KSP32	M40
5417302	T830MF100X125R6H-D4 KSP39	M40
5417303	T830M100X150R6G-D1 KSP39	M40
5417304	T830M060X100R6H-D6 KSP39	M40
5417305	T830M080X125R6H-D6 KSP39	M40
5417306	T830M100X150R6H-D6 KSP39	M40
5417307	T830M120X175R6H-D6 KSP32	M40
5417308	T830M120X175R6H-D6 KSP39	M40
5417309	T830MF120X125R6H-D4 KSP39	M40
5417310	T830MF120X150R6H-D4 KSP32	M40
5417311	T830MF120X150R6H-D4 KSP39	M40
5417312	T830M120X175R6G-D6 KSP39	M40
5417313	T830M140X200R6H-D6 KSP32	M41
5417314	T830M140X200R6H-D6 KSP39	M41
5417315	T830MF140X150R6H-D4 KSP32	M41
5417316	T830MF140X150R6H-D4 KSP39	M41
5417317	T830M140X200R6G-D6 KSP39	M41
5417318	T830M160X200R6H-D6 KSP39	M41
5417319	T830MF160X150R6H-D4 KSP39	M41
5417330	T830M160X200R6G-D6 KSP39	M41
5417331	T830M180X250R6H-D6 KSP39	M41
5417332	T830MF180X150R6H-D4 KSP39	M41
5417333	T830M200X250R6H-D6 KSP39	M41
5417334	T830M220X250R6H-D6 KSP39	M41
5417335	T830M240X300R6H-D6 KSP39	M41
5417336	T830M270X300R6H-D6 KSP39	M41
5417337	T830M300X350R6H-D6 KSP39	M41
5417338	T830M330X350R6H-D6 KSP39	M41
5417339	T830M360X400R6H-D6 KSP39	M41
5417350	T820M030X050R6H-J KSU31	M18
5417351	T820M030X050R6H-J KSU30	M18
5417352	T820M040X070R6H-J KSU31	M18
5417353	T820M040X070R6H-J KSU30	M18
5417354	T820M050X080R6H-J KSU31	M18
5417355	T820M050X080R6H-J KSU30	M18
5417356	T820M060X100R6H-J KSU31	M18
5417357	T832M030X050R6H-D1 KSP32	M42
5417358	T820M060X100R6H-J KSU30	M18
5417359	T832M030X050R6H-D1 KSP39	M42
5417370	T820M080X125R6H-J KSU31	M18
5417371	T832M040X070R6H-D1 KSP32	M42
5417372	T820M080X125R6H-J KSU30	M18
5417373	T832M040X070R6H-D1 KSP39	M42
5417374	T820M100X150R6H-J KSU31	M18
5417375	T832M050X080R6H-D1 KSP32	M42
5417376	T820M100X150R6H-J KSU30	M18
5417377	T832M050X080R6H-D1 KSP39	M42
5417378	T820M120X175R6H-J KSU30	M18
5417379	T832M060X100R6H-D1 KSP32	M42
5417380	T820MF120X125R6H-J KSU30	M18
5417381	T832M060X100R6H-D1 KSP39	M42
5417382	T820MF120X150R6H-J KSU30	M18
5417383	T832M080X125R6H-D1 KSP32	M42
5417384	T820M140X200R6H-J KSU30	M18
5417385	T832M080X125R6H-D1 KSP39	M42
5417386	T820MF140X150R6H-J KSU30	M18
5417387	T832MF080X100R6H-D4 KSP32	M42
5417388	T820M160X200R6H-J KSU30	M18
5417389	T832MF080X100R6H-D4 KSP39	M42
5417390	T820MF160X150R6H-J KSU30	M18
5417391	T832M100X150R6H-D1 KSP32	M42
5417392	T820M180X250R6H-J KSU30	M18
5417393	T832M100X150R6H-D1 KSP39	M42
5417394	T820M200X250R6H-J KSU30	M18
5417395	T832MF100X125R6H-D4 KSP32	M42
5417396	T832MF100X125R6H-D4 KSP39	M42
5417397	T832M120X175R6H-D6 KSP32	M42
5417398	T832M120X175R6H-D6 KSP39	M42
5417399	T832MF120X150R6H-D4 KSP32	M42
5417400	T832MF120X150R6H-D4 KSP39	M42
5417401	T832M140X200R6H-D6 KSP32	M42
5417402	T832M140X200R6H-D6 KSP39	M42
5417403	T832MF140X150R6H-D4 KSP32	M42
5417404	T832MF140X150R6H-D4 KSP39	M42
5417405	T832M160X200R6H-D6 KSP39	M42
5417406	T832M180X250R6H-D6 KSP32	M42
5417407	T832M180X250R6H-D6 KSP39	M42
5417408	T832M200X250R6H-D6 KSP32	M42
5417409	T832M200X250R6H-D6 KSP39	M42
5417410	T830M030X050R6H-J KSU31	M50
5417411	T830M030X050R6H-J KSU30	M50
5417412	T830M040X070R6H-J KSU31	M50
5417413	T830M040X070R6H-J KSU30	M50
5417414	T830M050X080R6H-J KSU31	M50
5417415	T830M050X080R6H-J KSU30	M50
5417416	T830M060X100R6H-J KSU31	M50
5417417	T830M060X100R6H-J KSU30	M50
5417418	T830M080X125R6H-J KSU30	M50
5417419	T830M080X125R6H-J KSU31	M50
5417420	T830M100X150R6H-J KSU30	M50
5417421	T830M100X150R6H-J KSU31	M50
5417422	T830M120X175R6H-J KSU30	M50
5417423	T830MF120X125R6H-J KSU30	M50
5417424	T830MF120X150R6H-J KSU30	M50
5417425	T830MF140X150R6H-J KSU30	M50
5417426	T830M140X200R6H-J KSU30	M50
5417427	T830MF160X150R6H-J KSU30	M50
5417428	T830M160X200R6H-J KSU30	M50
5417429	T830M180X250R6H-J KSU30	M50
5417430	T830M200X250R6H-J KSU30	M50
5418689	SNHJ120616ENLD KC520M	S63
5418800	SNHJ120616ENLD KC725M	S63
5418801	SNHJ120616ENLD KCK15	S63
5418802	SNHJ120616ENLD KCPK30	S63
5418803	SNHJ120608ENLD KC520M	S63
5418804	SNHJ120608ENLD KC725M	S63
5418805	SNHJ120608ENLD KCK15	S63
5418806	SNHJ120608ENLD KCPK30	S63
5418807	SNHJ10T308ENLD KC520M	S61
5418808	SNHJ10T308ENLD KC725M	S61
5418809	SNHJ10T308ENLD KCK15	S61
5418810	SNHJ10T308ENLD KCPK30	S61
5418811	SNHJ10T312ENLD KC725M	S61
5418812	SNHJ10T312ENLD KCK15	S61
5419993	SNPF120412SNGP KCK15	S105
5419998	KSSM87D050Z05SN12	S62
5420110	KSSM87D063Z05SN12	S62
5420111	KSSM87D063Z07SN12	S62
5420112	KSSM87D080Z07SN12	S62
5420113	KSSM87D080Z09SN12	S62
5420114	KSSM87D100Z08SN12	S62
5420115	KSSM87D100Z11SN12	S62
5420116	KSSM87D125Z09SN12	S62
5420117	KSSM87D125Z14SN12	S62
5420118	KSSM87D160Z12SN12	S62
5420163	KSSM88D050Z05SN10	S60
5420164	KSSM88D050Z06SN10	S60
5420165	KSSM88D063Z05SN10	S60
5420166	KSSM88D063Z07SN10	S60
5420167	KSSM88D080Z07SN10	S60
5420168	KSSM88D080Z09SN10	S60
5420169	KSSM88D100Z08SN10	S60
5420250	KSSM88D100Z11SN10	S60
5420672	B551A04763DAL KN15	G108
5420673	B551A06350DAL KN15	G108
5420674	B551A07938DAL KN15	G108
5420675	B551A09525DAL KN15	G108
5420676	B551A11113DAL KN15	G108
5420677	B551A12700DAL KN15	G108
5420678	B551A14288DAL KN15	G108
5420679	B551A15875DAL KN15	G108
5420800	B556A04763DAL KN15	G108
5420801	B556A04826DAL KN15	G108
5420802	B556A06350DAL KN15	G108
5420803	B556A06375DAL KN15	G108
5420804	B556A07938DAL KN15	G108
5420805	B556A09525DAL KN15	G108
5420806	B556A11113DAL KN15	G108
5420807	B556A12700DAL KN15	G108
5420808	B556A14288DAL KN15	G108
5420809	B556A15875DAL KN15	G108
5420832	HNGX090530MCI KCK15	S91, S97
5420836	SNXF120412ENLD KCK15	S104
5420837	SNXF1204ZNENLD KCK15	S104
5420838	SNXF120412SNGP KCK15	S104
5420839	SNXF1204ZNSNGP KCK15	S104
5420840	SNXF120412SNHE KCK15	S104
5420841	SNXF1204ZNSNHE KCK15	S104
5420842	XNXF1204ZNENLDW KCK15	S106
5424912	WNMG080408RN KCP25B	B159
5425545	CNMG160612RN KCP25B	B53
5425546	CNMG160616RN KCP25B	B53
5425547	CNMG190616MN KCP25B	B50
5425548	DNMG150412MN KCP25B	B78
5425549	DNMG150412RN KCP25B	B81
5425581	RNMG120400RN KCP10B	B94
5425582	SNMG090308MN KCP10B	B98
5425583	SNMG120412MN KCP10B	B98
5425584	SNMG120412RN KCP10B	B101
5425585	SNMG120416RN KCP10B	B101
5425586	SNMG150612MN KCP10B	B98
5425587	SNMG150612RN KCP10B	B101
5425588	TNMG160412MN KCP10B	B125
5425589	TNMG160412RN KCP10B	B127
5425591	VNMG160408MN KCP10B	B145
5425592	WNMG060408RN KCP10B	B159
5425593	WNMG080412MN KCP10B	B157
5425594	WNMG080412RN KCP10B	B159
5425595	WNMG080416RN KCP10B	B159
5425596	RNMG090300RN KCP25B	B94
5425597	RNMG120400RN KCP25B	B94
5425598	SNMG090308MN KCP25B	B98
5425599	SNMG120412MN KCP25B	B98
5425600	SNMG120412RN KCP25B	B101
5425601	SNMG120416RN KCP25B	B101
5425602	SNMG150612MN KCP25B	B98
5425603	SNMG150612RN KCP25B	B101
5425604	TNMG160412MN KCP25B	B125
5425605	TNMG160412RN KCP25B	B127
5425606	TNMG220416RN KCP25B	B127
5425607	VNMG160408MN KCP25B	B145
5430965	WNMG080412RP KCK15B	B159
5430966	CNMG160612RN KCP10B	B53
5430967	CNMG160616RN KCP10B	B53
5430968	CNMG190616MN KCP10B	B50
5430969	DNMG150404MN KCP10B	B78
5431070	DNMG150412MN KCP10B	B78
5431071	DNMG150412RN KCP10B	B81
5431591	CW16	S32–33
5434658	PDC251A04763DA KD1415	G110
5434659	PDC251A06350DA KD1415	G110
5434690	PDC251A07938DA KD1415	G110
5434691	PDC251A09525DA KD1415	G110
5434692	PDC251A11113DA KD1415	G110
5434693	PDC251A12700DA KD1415	G110
5434697	B284D03000HPS KN15	G88
5434699	B284D03175HPS KN15	G88
5434700	B284D03200HPS KN15	G88
5434701	B284D03300HPS KN15	G88
5434703	B284D03500HPS KN15	G88
5434704	B284D03571HPS KN15	G88
5434706	B284D03970HPS KN15	G88
5434707	B284D04000HPS KN15	G88
5434709	B284D04200HPS KN15	G88
5434710	B284D04366HPS KN15	G88
5434712	B284D04500HPS KN15	G88
5434713	B284D04763HPS KN15	G88
5434714	B284D04800HPS KN15	G88
5434715	B284D05000HPS KN15	G88
5434716	B284D05100HPS KN15	G88
5434717	B284D05159HPS KN15	G88
5434718	B284D05558HPS KN15	G88
5434719	B284D05600HPS KN15	G89
5434721	B284D05800HPS KN15	G89
5434722	B284D05954HPS KN15	G89
5434723	B284D06000HPS KN15	G89
5434724	B284D06400HPS KN15	G89
5434725	B284D06500HPS KN15	G89
5434726	B284D06746HPS KN15	G89
5434727	B284D06800HPS KN15	G89
5434728	B284D07000HPS KN15	G89
5434729	B284D07145HPS KN15	G89
5434730	B284D07400HPS KN15	G89
5434731	B284D07500HPS KN15	G89
5434732	B284D07541HPS KN15	G89
5434733	B284D07938HPS KN15	G89
5434734	B284D08000HPS KN15	G89
5434735	B284D08334HPS KN15	G89
5434736	B284D08500HPS KN15	G89
5434737	B284D08733HPS KN15	G89
5434738	B284D09000HPS KN15	G89
5434739	B284D09129HPS KN15	G89
5434740	B284D09500HPS KN15	G89
5434741	B284D09525HPS KN15	G89
5434742	B284D09921HPS KN15	G89
5434743	B284D10000HPS KN15	G89
5434744	B284D10200HPS KN15	G89
5434745	B284D10320HPS KN15	G89
5434746	B284D10500HPS KN15	G89
5434747	B284D10716HPS KN15	G90
5434748	B284D11000HPS KN15	G90
5434749	B284D11113HPS KN15	G90
5434750	B284D11908HPS KN15	G90
5434751	B284D12000HPS KN15	G90
5434752	B284D12500HPS KN15	G90
5434753	B284D12700HPS KN15	G90
5434754	B284D14000HPS KN15	G90
5434755	B284D14288HPS KN15	G90
5434756	B284D15875HPS KN15	G90
5434757	B284D19050HPS KN15	G90
5434758	B284D20000HPS KN15	G90
5434759	B285D03000HPS KN15	G88
5434760	B285D03175HPS KN15	G88
5434761	B285D03200HPS KN15	G88
5434762	B285D03300HPS KN15	G88
5434763	B285D03970HPS KN15	G88
5434764	B285D04000HPS KN15	G88
5434765	B285D04200HPS KN15	G88
5434766	B285D04500HPS KN15	G88
5434767	B285D04763HPS KN15	G88
5434768	B285D04800HPS KN15	G88
5434769	B285D04900HPS KN15	G88
5434770	B285D05000HPS KN15	G88
5434771	B285D05100HPS KN15	G88
5434772	B285D05200HPS KN15	G88
5434773	B285D05500HPS KN15	G88
5434774	B285D05558HPS KN15	G88
5434775	B285D05600HPS KN15	G89
5434776	B285D06000HPS KN15	G89
5434777	B285D06300HPS KN15	G89
5434778	B285D06400HPS KN15	G89
5434779	B285D06500HPS KN15	G89
5434780	B285D06600HPS KN15	G89
5434781	B285D06700HPS KN15	G89
5434782	B285D07000HPS KN15	G89
5434783	B285D07145HPS KN15	G89
5434785	B285D07700HPS KN15	G89
5434786	B285D07800HPS KN15	G89
5434787	B285D07938HPS KN15	G89
5434788	B285D08334HPS KN15	G89
5434789	B285D08400HPS KN15	G89
5434790	B285D08500HPS KN15	G89
5434791	B285D08733HPS KN15	G89
5434792	B285D09000HPS KN15	G89
5434793	B285D09300HPS KN15	G89
5434794	B285D09500HPS KN15	G89
5434795	B285D09525HPS KN15	G89
5434796	B285D10000HPS KN15	G89
5434797	B285D10500HPS KN15	G89
5434798	B285D11000HPS KN15	G90
5434799	B285D11113HPS KN15	G90
5434800	B285D11500HPS KN15	G90
5434801	B285D12000HPS KN15	G90

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
5434802	B285D14000HPS KN15	G90
5434803	B285D14500HPS KN15	G90
5434804	B285D18000HPS KN15	G90
5477295	EDPT140408PDERHD2 KC725M	T53, T62
5477296	EDPT140408PDERHD2 KCPK30	T53, T62
5477297	EDPT140408PDERHD2 KCK15	T53, T62
5477299	EDPT140408PDERHD2 KC522M	T53, T62
5479648	T820NC#04-40R2B-D1 KSP39	M16
5479649	T820NC#04-40R3B-D1 KSP39	M17
5479690	T820NC#05-40R2B-D1 KSP39	M16
5479691	T820NC#06-32R2B-D1 KSP39	M16
5479692	T820NC#06-32R3B-D1 KSP39	M17
5479693	T820NF#06-40R2B-D1 KSP39	M16
5479694	T820NC#08-32R2B-D1 KSP39	M16
5479695	T820NC#08-32R3B-D1 KSP39	M17
5479696	T820NC#10-24R2B-D1 KSP39	M16
5479697	T820NF#10-32R2B-D1 KSP39	M16
5479698	T820NF#10-32R3B-D1 KSP39	M17
5479699	T820NC02500-20R2B-D1 KSP39	M16
5479700	T820NF02500-28R2B-D1 KSP39	M16
5479701	T820NF02500-28R3B-D1 KSP39	M17
5479702	T820NC03125-18R2B-D1 KSP39	M16
5479703	T820NF03125-24R2B-D1 KSP39	M16
5479704	T820NF03125-24R3B-D1 KSP39	M17
5479705	T820NC03750-16R2B-D1 KSP39	M16
5479706	T820NF03750-24R2B-D1 KSP39	M16
5479707	T820NF03750-24R3B-D1 KSP39	M17
5479708	T820NC04375-14R2B-D6 KSP39	M16
5479709	T820NF04375-20R2B-D6 KSP39	M16
5479710	T820NF04375-20R3B-D6 KSP39	M17
5479711	T820NC05000-13R2B-D6 KSP39	M16
5479712	T820NF05000-20R2B-D6 KSP39	M16
5479713	T820NF05000-20R3B-D6 KSP39	M17
5479714	T820NC05625-12R2B-D6 KSP39	M16
5479715	T820NF05625-18R2B-D6 KSP39	M16
5479716	T820NC06250-11R2B-D6 KSP39	M16
5479717	T820NF06250-18R2B-D6 KSP39	M16
5479718	T820NC07500-10R2B-D6 KSP39	M16
5479719	T820NF07500-16R2B-D6 KSP39	M16
5479720	T820NC08750-9R2B-D6 KSP39	M16
5479721	T820NF08750-14R2B-D6 KSP39	M16
5479722	T820NC10000-8R2B-D6 KSP39	M16
5479723	T820NF10000-12R2B-D6 KSP39	M16
5479724	T830NC#04-40R2B-D1 KSP39	M46
5479725	T830NC#04-40R3B-D1 KSP39	M49
5479726	T830NC#05-40R2B-D1 KSP39	M46
5479727	T830NC#06-32R2B-D1 KSP39	M46
5479728	T830NC#06-32R3B-D1 KSP39	M49
5479729	T830NF#06-40R2B-D1 KSP39	M46
5479730	T830NC#08-32R2B-D1 KSP39	M46
5479732	T830NC#08-32R3B-D1 KSP39	M49
5479733	T830NC#10-24R2B-D1 KSP39	M46
5479734	T830NF#10-32R2B-D1 KSP39	M46
5479735	T830NF#10-32R3B-D1 KSP39	M49
5479736	T830NC02500-20R2B-D1 KSP39	M46
5479737	T830NF02500-28R2B-D1 KSP39	M46
5479738	T830NF02500-28R3B-D1 KSP39	M49
5479739	T830NC03125-18R2B-D1 KSP39	M46
5479760	T830NF03125-24R2B-D1 KSP39	M46
5479761	T830NF03125-24R3B-D1 KSP39	M49
5479762	T830NC03750-16R2B-D1 KSP39	M46
5479763	T830NF03750-24R2B-D1 KSP39	M46
5479764	T830NF03750-24R3B-D1 KSP39	M49
5479765	T830NC04375-14R2B-D6 KSP39	M46
5479766	T830NF04375-20R2B-D6 KSP39	M46
5479767	T830NF04375-20R3B-D6 KSP39	M49
5479768	T830NC05000-13R2B-D6 KSP39	M46
5479769	T830NF05000-20R2B-D6 KSP39	M46
5479770	T830NF05000-20R3B-D6 KSP39	M49
5479771	T830NC05625-12R2B-D6 KSP39	M46
5479772	T830NF05625-18R2B-D6 KSP39	M46
5479773	T830NC06250-11R2B-D6 KSP39	M46
5479774	T830NF06250-18R2B-D6 KSP39	M46
5479775	T830NC07500-10R2B-D6 KSP39	M46
5479776	T830NF07500-16R2B-D6 KSP39	M46
5479777	T830NF08750-9R2B-D6 KSP39	M46
5479778	T830NF08750-14R2B-D6 KSP39	M46
5479779	T830NC10000-8R2B-D6 KSP39	M46
5479780	T830NF10000-12R2B-D6 KSP39	M46
5479781	T820MF100X100R6H-D4 KSP39	M14
5479782	T820MF120X100R6H-D4 KSP39	M14
5479783	T820MF140X100R6H-D4 KSP39	M15
5479784	T820MF160X100R6H-D4 KSP39	M15
5479785	T820MF180X200R6H-D4 KSP39	M15
5479786	T820MF200X150R6H-D4 KSP39	M15
5479787	T820MF200X200R6H-D4 KSP39	M15
5479788	T820MF220X150R6H-D4 KSP39	M15
5479789	T820MF220X200R6H-D4 KSP39	M15
5479790	T820MF240X150R6H-D4 KSP39	M15
5479864	KTIP0983HPM KCP15	H26
5489410	WNMG080416MN KCP25B	B157
5490089	CNMG190616RP KCPK05	B53
5491717	RIQ06EDR06 KD1415	K56
5492520	B269A04550HP KCPK15	G68
5497332	RIQ09EDR06 KD1415	K56
5497351	CFM0402R00RHP KCU40	H34
5505778	B271Z02383KMG KCPK20	G74
5505779	B271Z02500KMG KCPK20	G74
5505938	KTMDUSCREW1	W29–31
5506030	B271Z02642KMG KCPK20	G74
5506031	B271Z02705KMG KCPK20	G74
5506032	B271Z02779KMG KCPK20	G74
5506033	B271Z02820KMG KCPK20	G74
5506034	B271Z03000HPG KCPK20	G74
5506035	B271Z03175HPG KCPK20	G74
5506036	B271Z03200HPG KCPK20	G74
5506037	B271Z03500HPG KCPK20	G74
5506038	B271Z03600HPG KCPK20	G74
5506039	B271Z03700HPG KCPK20	G74
5506040	B271Z03970HPG KCPK20	G74
5506041	B271Z04000HPG KCPK20	G74
5506042	B271Z04500HPG KCPK20	G74
5506043	B271Z04623HPG KCPK20	G74
5506044	B271Z04763HPG KCPK20	G74
5506045	B271Z04800HPG KCPK20	G74
5506046	B271Z05000HPG KCPK20	G74
5506047	B271Z05060HPG KCPK20	G74
5506048	B271Z05260HPG KCPK20	G74
5506049	B271Z05410HPG KCPK20	G74
5506060	B271Z05500HPG KCPK20	G74
5506061	B271Z05558HPG KCPK20	G74
5506062	B274Z02383KMG KCPK20	G79
5506063	B271Z05800HPG KCPK20	G74
5506064	B274Z02500KMG KCPK20	G79
5506065	B271Z05900HPG KCPK20	G74
5506067	B271Z06000HPG KCPK20	G74
5506068	B274Z02600KMG KCPK20	G79
5506069	B271Z06200HPG KCPK20	G74
5506070	B274Z02800KMG KCPK20	G79
5506071	B271Z06350HPG KCPK20	G74
5506072	B274Z03000HPG KCPK20	G79
5506073	B271Z06500HPG KCPK20	G75
5506074	B274Z03175HPG KCPK20	G79
5506075	B271Z06528HPG KCPK20	G75
5506076	B274Z03500HPG KCPK20	G79
5506077	B271Z06746HPG KCPK20	G75
5506078	B274Z03970HPG KCPK20	G79
5506079	B271Z06909HPG KCPK20	G75
5506080	B274Z04000HPG KCPK20	G79
5506081	B271Z07000HPG KCPK20	G75
5506082	B274Z04300HPG KCPK20	G79
5506083	B271Z07145HPG KCPK20	G75
5506084	B274Z04500HPG KCPK20	G79
5506085	B271Z07500HPG KCPK20	G75
5506086	B274Z04763HPG KCPK20	G79
5506087	B271Z07541HPG KCPK20	G75
5506088	B274Z05000HPG KCPK20	G79
5506089	B271Z07938HPG KCPK20	G75
5506090	B274Z05100HPG KCPK20	G79
5506091	B271Z08000HPG KCPK20	G75
5506092	B274Z05500HPG KCPK20	G79
5506093	B271Z08200HPG KCPK20	G75
5506094	B274Z05700HPG KCPK20	G79
5506095	B271Z08334HPG KCPK20	G75
5506096	B274Z06000HPG KCPK20	G79
5506098	B274Z06350HPG KCPK20	G79
5506099	B271Z08500HPG KCPK20	G75
5506100	B274Z06500HPG KCPK20	G79
5506101	B271Z08733HPG KCPK20	G75
5506102	B274Z06800HPG KCPK20	G79
5506105	B274Z07000HPG KCPK20	G79
5506106	B271Z09000HPG KCPK20	G75
5506107	B274Z07700HPG KCPK20	G80
5506108	B271Z09100HPG KCPK20	G75
5506109	B274Z07938HPG KCPK20	G80
5506110	B271Z09200HPG KCPK20	G75
5506111	B274Z08000HPG KCPK20	G80
5506112	B271Z09500HPG KCPK20	G75
5506113	B274Z08334HPG KCPK20	G80
5506114	B271Z09525HPG KCPK20	G75
5506115	B274Z08500HPG KCPK20	G80
5506116	B271Z09750HPG KCPK20	G75
5506117	B274Z08700HPG KCPK20	G80
5506118	B271Z10000HPG KCPK20	G75
5506119	B274Z09000HPG KCPK20	G80
5506120	B271Z10200HPG KCPK20	G75
5506121	B274Z09525HPG KCPK20	G80
5506122	B271Z10500HPG KCPK20	G75
5506123	B274Z10000HPG KCPK20	G80
5506124	B271Z10716HPG KCPK20	G75
5506125	B274Z10200HPG KCPK20	G80
5506126	B271Z10800HPG KCPK20	G75
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5506319	RCMT2006M0UP KCP25B	E60
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5507610	TNMG220408FN KCP10B	B124
5507611	WNMG080408FW KCP10B	B156
5507612	WNMG080408RN KCP10B	B159
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5511789	B273Z02500KMG KCPK20	G78
5511930	B273Z02600KMG KCPK20	G78
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5511965	B273Z15000HPG KCPK20	G78
5512462	CNMG160612RN KCPK05	B53
5513477	CNMG120408RP KCPK05	B53
5513478	CNMG160612RP KCPK05	B53
5514452	TNMG220412MN KCP10B	B125
5515172	KSEM3300HPCCLM KC7410	H49, H87
5515173	KSEM3400HPCCLM KC7410	H49, H87
5515174	KSEM3500HPCCLM KC7410	H49, H87
5515175	KSEM3600HPCCLM KC7410	H49, H87
5515176	KSEM3700HPCCLM KC7410	H49, H87
5515177	KSEM3800HPCCLM KC7410	H49, H87
5515178	KSEM3900HPCCLM KC7410	H49, H87

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
5515179	KSEM4000HPCCLM KC7410	H49, H87
5515220	KSEMP3500HPGM KC7315	H87
5515221	KSEMP3600HPGM KC7315	H87
5515222	KSEMP3700HPGM KC7315	H87
5515223	KSEMP3800HPGM KC7315	H87
5515224	KSEMP3900HPGM KC7315	H87
5515225	KSEMP4000HPGM KC7315	H87
5515226	KSEM2900HPGM KCPM45	H46
5515746	LNGU15T612SRGE KC520M	T19
5515747	LNGU15T612SRGE KC522M	T19
5515748	LNGU15T612SRGE KC725M	T19
5515749	LNGU15T612SRGE KCK15	T19
5515759	LNGU15T608SRGE KC520M	T19
5515890	LNGU15T608SRGE KC522M	T19
5515891	LNGU15T608SRGE KC725M	T19
5515892	LNGU15T608SRGE KCK15	T19
5515893	LNGU15T608SRGE KCPK30	T19
5516070	LNGU15T612SRGE KCPK30	T19
5516073	LNGU15T604SRGE KC520M	T19
5516074	LNGU15T604SRGE KC522M	T19
5516075	LNGU15T604SRGE KC725M	T19
5516076	LNGU15T604SRGE KCK15	T19
5516077	LNGU15T604SRGE KCPK30	T19
5517575	RCGT2006M0SGFJ KCSM30	V83
5517600	SNMM190624RW KCP25B	B103
5517760	RPET1204M0ELEJ KCSM30	V73
5517761	RPET1204M0SGEJ KCSM30	V73
5517764	RPET1605M0SGEJ KCSM30	V79
5517767	W0EJ090512SRGD KCSM30	V41
5517773	RNGJ1204M0ELDJ KCSM30	V57
5517778	RNGJ10T3M0SGDJ KCSM30	V51
5518566	DNMG150612MR KCP25B	B80
5519287	EDPT070308PDSRGE KCSM30	T25
5519923	SDET1204PDSRGB KCSM30	T105, T112, U51
5519967	SDCT120432ENLD2 KCSM30	T104, T111, U51
5519983	EDPT140431PDERHD KCSM30	T53, T62
5520493	EDPT140416PDERHD KCSM30	T53, T62
5520494	EDPT140440PDERHD KCSM30	T53, T62
5520684	EDPT10T316PDERHD KCSM30	T36
5520687	SPCT10T316ENLD2 KCSM30	T100, U36
5520736	T353M040X070R6HX-D1 KCK17	M59
5520737	T353M050X080R6HX-D1 KCK17	M59
5520738	T353M060X100R6HX-D1 KCK17	M59
5520739	T353M080X125R6HX-D1 KCK17	M59
5520790	T353M100X150R6HX-D1 KCK17	M59
5520791	T353M120X175R6HX-D6 KCK17	M59
5520792	T353M140X200R6HX-D6 KCK17	M59
5520793	T351M060X100R6HX-D1 KCK17	M58
5520794	T351M070X100R6HX-D1 KCK17	M58
5520795	T351M080X125R6HX-D1 KCK17	M58
5520796	T351M090X125R6HX-D1 KCK17	M58
5520798	T351M100X150R6HX-D1 KCK17	M58
5520799	T351MF100X100R6HX-D4 KCK17	M58
5520800	T351MF100X125R6HX-D4 KCK17	M58
5520801	T351M120X175R6HX-D6 KCK17	M58
5520802	T351MF120X125R6HX-D4 KCK17	M58
5520803	T351MF120X150R6HX-D4 KCK17	M58
5520804	T351M140X200R6HX-D6 KCK17	M58
5520805	T351MF140X125R6HX-D4 KCK17	M58
5520806	T351MF140X150R6HX-D4 KCK17	M58
5520807	T471M060X100R6HX-D1 KCN14	M61
5520808	T471M080X125R6HX-D1 KCN14	M61
5520809	T471M100X150R6HX-D1 KCN14	M61
5520810	T491M060X100R6HX-D74 KCN14	M73
5520811	T491M080X125R6HX-D74 KCN14	M73
5520812	T491M100X150R6HX-D74 KCN14	M73
5523116	RIQ06EGR06 KC6305	K56
5523306	CNMG090308FN KCP10B	B49
5523588	DNMG150612MR KCP10B	B80
5524447	KTIP1161HPM KCP15	H26
5524448	KTIP1830HPM KCP15	H27
5524449	KTIP1840HPM KCP15	H27
5524610	KTIP1935HPM KCP15	H27
5528599	M4D035Z04M16LN15	T14
5528630	M4D025Z02B25LN15	T15
5528631	M4D032Z03B32LN15	T15
5528632	M4D040Z04S16LN15	T17
5528633	M4D050Z05S22LN15	T17
5528634	M4D050Z06S22LN15	T17
5528635	M4D063Z06S22LN15	T17
5528636	M4D063Z07S22LN15	T17
5528637	M4D080Z07S27LN15	T17
5528638	M4D100Z08S32LN15	T17
5528977	OFKT07L6AFENGB KCSM30	S55
5531233	CNGG120401FS KCU10	B46
5531234	CNGG120402FS KCU10	B46
5531235	CNGG120404FS KCU10	B46
5531236	CNGG120408FS KCU10	B46
5531238	CNMG190612MS KCU10	B52
5531240	SNMG150616MP KCU10	B98
5531241	TCGT16T301LF KCU10	B243
5531835	CNMG120404FP KCP25B	B49
5531836	CNMG120404FN KCP10B	B49
5531837	CNMG120404FN KCK15B	B49
5531838	CNMG120404FN KCP25B	B49
5531839	CNMG120408FN KCP10B	B49
5531890	CNMG120408FN KCP25B	B49
5531891	CNMG120408FP KCP10B	B49
5531892	CNMG120408FP KCP25B	B49
5531893	CNMG120412FN KCP25B	B49
5531894	CNMG120412FN KCP10B	B49
5531896	DNMG110404FN KCP10B	B77
5531897	DNMG110408FN KCP25B	B77
5531898	DNMG150404FN KCK15B	B77
5531899	DNMG150404FN KCP25B	B77
5531900	DNMG150408FN KCP10B	B77
5531901	DNMG150604FN KCP10B	B77
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5531904	DNMG150608FP KCP10B	B77
5531905	DNMG150608FP KCP25B	B77
5531906	DNMG150608FN KCP25B	B77
5531907	DNMG150608FN KCK15B	B77
5531908	DNMG150612FN KCP10B	B77
5531909	SNMG090308FN KCK15B	B97
5531910	SNMG120404FN KCP10B	B97
5531911	M4D025Z02M12LN15	T14
5531912	M4D032Z03M16LN15	T14
5531913	M4D040Z05M16LN15	T14
5531914	M4D040Z03B32LN15	T15
5531915	M4D025Z02A25LN15L100	T16
5531916	M4D025Z02A25LN15L170	T16
5531917	M4D032Z03A32LN15L110	T16
5531918	M4D032Z03A32LN15L200	T16
5531919	M4D040Z03A32LN15L200	T16
5532000	M4D125Z12S40LN15	T17
5532930	EG0212M02U02GUP KCU25	C17
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5532937	EG0251M02U02GUN KCU25	C22
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5532942	EG0812M08U12GUP KCU25	C17
5532944	EG0812M08U08GUN KCU25	C22
5532945	EG0812M08U12GUN KCU25	C22
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5533013	EG255I06U2GUP KCU25	C19
5533015	EG255I06U1GUN KCU25	C23
5533016	EG255I06U2GUN KCU25	C23
5533080	EC030M03N00CL02 KCU25	C25
5533081	EC014M1BN00CF01 KCU25	C24
5533082	EC020M02N00CF02 KCU25	C24
5533089	EC014M1BN00CM01 KCU25	C26
5533090	EC020M02N00CM02 KCU25	C26
5533093	EC060M06N00CM03 KCU25	C26
5533096	EC060M06N00CR03 KCU25	C27
5533097	EC080M08N00CR04 KCU25	C27
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5533124	EG0612M06U08GUP KCU25	C17
5533125	EG0612M06U04GUN KCU25	C22
5533127	EG0612M06U08GUN KCU25	C22
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5533136	EG317I08U3GUN KCU25	C23
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5533139	EC040M04N00CL02 KCU25	C25
5533150	EC020M02L06CF02 KCU25	C24
5533151	EC020M02R06CF02 KCU25	C24
5533156	EC020M02N00CR02 KCU25	C27
5533171	EC060M06L06CR04 KCU25	C27
5533172	EC060M06R06CR04 KCU25	C27
5533173	EC080M08L06CR04 KCU25	C27
5533174	EC080M08R06CR04 KCU25	C27
5533178	EG380I10U3GUP KCU25	C19
5533179	EG063I1FU05GUN KCU25	C23
5533210	EG380I10U3GUN KCU25	C23
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5533214	EG0512M05U08GUP KCU25	C17
5533216	EG0712M06U08GUP KCU25	C17
5533220	EG1012M10U12GUP KCU25	C17
5533221	EG0512M05U04GUN KCU25	C22
5533222	EG0512M05U08GUN KCU25	C22
5533223	EG1012M10U12GUN KCU25	C22
5533361	ER130I03U00GUP KCU25	C21
5533363	ER192I04U00GUP KCU25	C21
5533365	ER255I06U00GUP KCU25	C21
5533367	ER317I08U00GUP KCU25	C21
5533368	ER130I03U00GUN KCU25	C24
5533369	ER192I04U00GUN KCU25	C24
5533370	ER255I06U00GUN KCU25	C24
5533371	ER317I08U00GUN KCU25	C24
5533448	EC014M1BL06CL01 KCU25	C25
5533449	EC014M1BR06CL01 KCU25	C25
5533510	EC020M02L06CL02 KCU25	C25
5533511	EC020M02R06CL02 KCU25	C25
5533512	EC030M03L06CL02 KCU25	C25
5533513	EC030M03R06CL02 KCU25	C25
5533514	EC040M04L06CL02 KCU25	C25
5533515	EC040M04R06CL02 KCU25	C25
5533516	EC014M1BL06CF01 KCU25	C24
5533517	EC014M1BR06CF01 KCU25	C24
5533518	EC050M05N00CF03 KCU25	C24
5533519	EC014M1BL06CM01 KCU25	C26
5533520	EC014M1BR06CM01 KCU25	C26
5533521	EC020M02L06CM02 KCU25	C26
5533522	EC020M02R06CM02 KCU25	C26
5533523	EC050M05N00CM03 KCU25	C26
5533524	EC070M06N00CM04 KCU25	C26
5533525	EC080M08N00CM04 KCU25	C26
5533526	EC050M05N00CR03 KCU25	C27
5533527	EC070M06N00CR04 KCU25	C27
5533528	EC020M02L06CR02 KCU25	C27
5533529	EC020M02R06CR02 KCU25	C27
5533546	DFR020204LD KCU25	J84
5533547	DFR030204LD KCU25	J84
5533548	DFR040304LD KCU25	J84
5533549	DFR020204LD KCPK10	J84
5533630	DFR030204LD KCPK10	J84
5533631	DFR040304LD KCPK10	J84
5533632	DFR030204LD KC7140	J84
5533633	DFR040304LD KC7140	J84
5533634	SPHX060204R21 KCPK10	J100
5533635	SPHX070304R21 KCPK10	J100
5533636	SPHX070308R21 KCPK10	J100
5533637	SPHX090304R21 KCPK10	J100
5533638	SPHX090308R21 KCPK10	J100
5533639	SPHX120404R21 KCPK10	J100
5533640	SPHX060204R20 KCU25	J99
5533641	SPHX070304R20 KCU25	J99
5533642	SPHX090304R20 KCU25	J99
5533643	SPHX090308R20 KCU25	J99
5533644	SPHX120404R20 KCU25	J99
5533645	SPHX120408R20 KCU25	J99
5533646	SPHX150504R20 KCU25	J99
5533647	SPHX150508R20 KCU25	J99
5533648	SPHX060204R20 KCU40	J99
5533649	SPHX060204R21 KCU40	J100
5533650	SPHX070304R20 KCU40	J99
5533651	SPHX070304R21 KCU40	J100
5533652	SPHX070308R21 KCU40	J100
5533653	SPHX090304R20 KCU40	J99
5533654	SPHX090304R21 KCU40	J100
5533655	SPHX090308R20 KCU40	J99
5533656	SPHX090308R21 KCU40	J100
5533657	SPHX120404R20 KCU40	J99
5533658	SPHX120404R21 KCU40	J100
5533659	SPHX120408R20 KCU40	J99
5533660	SPHX150504R20 KCU40	J99
5533661	SPHX150508R20 KCU40	J99
5534147	SPGX060304FP KCU40	J90
5534148	SPGX060304RHP KCU40	J89
5534149	SPGX060304MD KCU40	J89
5534230	SPGX070304FP KCU40	J90
5534231	SPGX070304RHP KCU40	J89
5534232	SPGX070304MD KCU40	J89
5534233	SPPX09T308FP KCU40	J90
5534234	SPPX09T308RHP KCU40	J89
5534235	SPPX09T308MD KCU40	J89
5534236	SPPX120408FP KCU40	J90
5534237	SPPX120408RHP KCU40	J89
5534238	SPPX120408MD KCU40	J89
5534239	SPPX15T508FP KCU40	J90
5534250	SPPX15T508RHP KCU40	J89
5534251	SPPX15T508MD KCU40	J89
5534252	SPGX060304FP KCU25	J90
5534253	SPGX060304RHP KCU25	J89
5534254	SPGX060304MD KCU25	J89
5534255	SPGX070304FP KCU25	J90
5534256	SPGX070304RHP KCU25	J89
5534257	SPGX070304MD KCU25	J89
5534258	SPPX09T308FP KCU25	J90
5534259	SPPX09T308RHP KCU25	J89
5534260	SPPX09T308MD KCU25	J89
5534261	SPPX120408FP KCU25	J90
5534262	SPPX120408RHP KCU25	J89
5534263	SPPX120408MD KCU25	J89
5534264	SPPX15T508FP KCU25	J90
5534265	SPPX15T508RHP KCU25	J89
5534266	SPPX15T508MD KCU25	J89
5534267	SPGX060304FP KCPK10	J90
5534268	SPGX070304FP KCPK10	J90
5534269	SPPX09T308FP KCPK10	J90
5534270	SPPX120408FP KCPK10	J90
5534271	SPPX15T508FP KCPK10	J90
5534274	ER0312M03U00GUP KCU25	C20
5534276	ER0412M04U00GUP KCU25	C20
5534278	ER0512M05U00GUP KCU25	C20
5534290	ER0612M06U00GUP KCU25	C20
5534292	ER0812M08U00GUP KCU25	C20
5534293	ER0312M03U00GUN KCU25	C23
5534294	ER0412M04U00GUN KCU25	C23
5534295	ER0512M05U00GUN KCU25	C23
5534296	ER0612M06U00GUN KCU25	C23
5534297	ER0812M08U00GUN KCU25	C23
5534828	CNMG120404FF KCP10B	B48
5535020	CNMG120408CT KCP25B	B48
5535021	CNMG120408CT KCP10B	B48
5535022	CNMG120408FF KCP10B	B48
5535025	DNMG110408CT KCP10B	B76
5535026	DNMG110408FF KCP10B	B76
5535027	DNMG150408CT KCP10B	B76
5535028	DNMG150408FW KCP10B	B78
5535029	DNMG150604FF KCP10B	B76
5535040	DNMG150604FW KCP10B	B78
5535041	DNMG150608CT KCP10B	B76
5535042	DNMG150608FF KCP10B	B76
5535043	DNMG150608FW KCK15B	B78
5535044	DNMG150608FW KCP10B	B78
5535045	DNMP150604K KCP25B	B83
5535046	DNMP150608K KCP25B	B83
5537375	CCMT060204FP KCP10B	B176
5537376	CCMT060204FP KCP25B	B176
5537378	CCMT060208FP KCP25B	B176
5537379	CCMT09T302FP KCP25B	B176
5537420	CCMT09T304FP KCP10B	B176
5537421	CCMT09T304FP KCP25B	B176
5537422	CCMT09T308FP KCP10B	B176
5537423	CCMT09T308FP KCP25B	B176
5537425	CCMT120404FP KCP10B	B176
5537426	CCMT120404FP KCP25B	B176
5537427	CCMT120408FP KCP25B	B176
5537429	CPMT060204FP KCP25B	B189
5537430	CPMT060204UF KCP25B	B191
5537431	CPMT060204UF KCP10B	B191
5537432	CPMT09T304FP KCP25B	B189
5537433	CPMT09T304UF KCP25B	B191
5537435	CPMT09T308FP KCP25B	B189
5537436	DCMT070202FP KCP25B	B207
5537437	DCMT070208FP KCP25B	B207
5537438	DCMT11T302FP KCP25B	B207
5537439	DCMT11T302FP KCP10B	B207

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
5537442	DCMT11T304FP KCP10B	B207
5537443	DCMT11T304FP KCP25B	B207
5537444	DCMT11T304UF KCP10B	B208
5538857	DCMT11T304UF KCP25B	B208
5538858	DCMT11T308FP KCP10B	B207
5538891	TCMT090204FP KCP25B	B244
5538894	TCMT110304FP KCP10B	B244
5538900	TPMT110304FP KCP10B	B254
5538903	VBMT160408FP KCP10B	B265
5538904	VBMT160408FP KCP25B	B265
5542022	SDET120412PDENGDZ KCPM40	V141
5542023	SDET120412PDSNGDZ KCPM40	V141
5542024	SDPT120412PDENHPZ KCPM40	V141
5542025	SDPT120412PDSNHPZ KCPM40	V141
5542028	RNPJ10T3M0SGD KCPM40	V51
5542029	RNPJ10T3M0SHD KCPM40	V51
5542179	CNMA120412 KCK15B	B47
5542190	RNPJ1204M0SGD KCPM40	V58
5542191	RNPJ1204M0SHD KCPM40	V58
5542192	RNPJ1605M0SGD KCPM40	V61
5542193	RNPJ1605M0SHD KCPM40	V61
5542210	CNMA160612 KCK15B	B47
5542242	WOEJ090512SRHD KCPM40	V41
5542243	WOEJ090512SRGD KCPM40	V41
5542246	RPPT1204M0SGP KCPM40	V74
5542247	RPPT1204M0SGDX KCPM40	V74
5542248	RPPT1605M0SHP KCPM40	V80
5542321	RCGT2006M0SHFJ KCPM40	V83
5542324	RCGT2006M0SGFJ KCPM40	V83
5543553	KM4X63KGMEL65C	C63, C133
5543555	KM4X63KGMER65C	C63, C133
5543558	KM4X63KGMSL65C	C62, C133
5543560	KM4X63KGMSR65C	C62, C133
5544143	SS20RBHT24	K120
5544144	SS20FBHS24	K135
5544145	SS25RBHT30	K120
5544146	SS25FBHS31	K135
5544148	ER25RBHT40	K119
5544149	ER25FBHS40	K134
5544190	ER32RBHT50	K119
5544191	ER32FBHS51	K134
5544192	ER40RBHT66	K119
5544193	ER40FBHS67	K134
5544755	DNMG110412FN KCP10B	B77
5545061	EDPT140408PDSRGD2 KCPM40	T54, T63
5545066	EDPT140412PDSRGD KCPM40	T54, T63
5545067	EDCT140408PDERGD KCPM40	T52, T61
5545068	EDCT140404PDERGD KCPM40	T52, T61
5545069	EDPT140412PDERHD KCPM40	T53, T62
5545160	EDPT140408PDERHD KCPM40	T53, T62
5545161	EDPT140408PDSRGE KCPM40	T53, T62
5545162	SDET1204PDSRGB KCPM40	T105, T112, U51
5545163	SDCT1204PDERLD2 KCPM40	T104, T111, U51
5545164	SDET1204PDERGB2 KCPM40	T104, T111, U52
5545167	SPCT10T3PPERLD2 KCPM40	T100, U36
5545168	SPET10T3PPERGB2 KCPM40	T100, U37
5545169	EDPT070308PDSRGE KCPM40	T25
5545214	EDPT10T308PDERHD KCPM40	T36
5545215	EDPT10T304PDERHD KCPM40	T36
5545216	EDPT10T308PDSRGD KCPM40	T36, T44
5545217	EDCT10T308PDERLD KCPM40	T35
5545398	EDPT180516PDERGD KCPM40	T74
5545399	EDPT180508PDERGD KCPM40	T74
5545400	EDPT180512PDERGD KCPM40	T74
5545401	EDPT180512PDSRGD KCPM40	T75
5545402	EDPT180508PDSRGD KCPM40	T75
5545403	EDPT180516PDSRGD KCPM40	T75
5545562	EDPT140408PDERHD2 KCPM40	T53, T62
5546298	VNMG160412MN KCP25B	B145
5547848	LNPU15T608SRGE KC520M	T19
5547849	LNPU15T608SRGE KC522M	T19
5548040	LNPU15T608SRGE KC725M	T19
5548041	LNPU15T608SRGE KCK15	T19
5548042	LNPU15T608SRGE KCPK30	T19
5548378	B967A09300 KC7315	G133
5550701	HNGJ0604ANENLD KCPM40	S6, S12, S15
5550702	HNPJ0604ANSNHD KCPM40	S7, S13, S16
5550703	HNPJ0604ANSNGD KCPM40	S7, S13, S16
5550793	HNGJ0905ANSNGD KCPM40	S18, S23
5550794	HNGJ0905ANSNHD KCPM40	S19, S23
5550795	HNPJ0905ANSNGD KCPM40	S19, S23
5550796	HNPJ0905ANSNHD KCPM40	S19, S24
5550797	HNPJ090543ANSNHD KCPM40	S19, S24
5550815	HNPJ1307ANSNHD KCPM40	S27
5550816	HNPJ130720ANSNHD KCPM40	S27
5550817	HNGJ1307ANENGD KCPM40	S26
5550819	0FPT07L6AFENGB KCPM40	S55
5550901	0FPT06L5AFENGB KCPM40	S51
5551030	T340NC#6-32R3BX KCK17	M54
5551031	T340NC#8-32R3BX KCK17	M54
5551032	T340NC#10-24R3BX KCK17	M54
5551033	T340NF#10-32R3BX KCK17	M54
5551034	T340NC02500-20R3BX KCK17	M54
5551035	T340NC03125-18R3BX KCK17	M54
5551036	T340NC03750-16R3BX KCK17	M54
5551037	T340NF03750-24R3BX KCK17	M54
5551038	T340NC05000-13R3BX KCK17	M54
5551039	T340NF05000-20R3BX KCK17	M54
5551040	T340NF05625-18R3BX KCK17	M54
5551041	T340M040X070R6HX KCK17	M55
5551042	T340M050X080R6HX KCK17	M55
5551043	T340M060X100R6HX KCK17	M55
5551044	T340M080X125R6HX KCK17	M55
5551045	T340MF100X100R6HX KCK17	M55
5551046	T340M100X150R6HX KCK17	M55
5551047	T340MF120X150R6HX KCK17	M55
5551048	T340M120X175R6HX KCK17	M55
5551049	T340MF140X150R6HX KCK17	M55
5551050	T340M140X200R6HX KCK17	M55
5551051	T340M160X200R6HX KCK17	M55
5551052	T340M200X250R6HX KCK17	M55
5551053	T351NC#6-32R3BX KCK17	M56
5551054	T351NC#8-32R3BX KCK17	M56
5551055	T351NF#10-32R3BX KCK17	M56
5551056	T351NC02500-20R3BX KCK17	M56
5551057	T351NC03125-18R3BX KCK17	M56
5551058	T351NC03750-16R3BX KCK17	M56
5551059	T351NC04375-14R3BX KCK17	M56
5551060	T351NC05000-13R3BX KCK17	M56
5551061	T351NC06250-11R3BX KCK17	M56
5551062	T351NC07500-10R3BX KCK17	M56
5551063	T351M040X070R6HX KCK17	M57
5551064	T351M050X080R6HX KCK17	M57
5551065	T351M060X100R6HX KCK17	M57
5551066	T351M080X125R6HX KCK17	M57
5551067	T351MF100X100R6HX KCK17	M57
5551068	T351M100X150R6HX KCK17	M57
5551069	T351MF120X150R6HX KCK17	M57
5551070	T351M120X175R6HX KCK17	M57
5551071	T351MF140X150R6HX KCK17	M57
5551072	T351M140X200R6HX KCK17	M57
5551073	T351M160X200R6HX KCK17	M57
5551077	T471M060X100R6HX KCN14	M60
5551078	T471M080X125R6HX KCN14	M60
5551079	T471M100X150R6HX KCN14	M60
5551080	T471M120X175R6HX KCN14	M60
5551081	T471M140X200R6HX KCN14	M60
5551082	T491M050X080R6HX KCN14	M72
5551083	T491M060X100R6HX KCN14	M72
5551084	T491M080X125R6HX KCN14	M72
5551085	T491M100X150R6HX KCN14	M72
5551086	T491M120X175R6HX KCN14	M72
5551479	RIQ09EGR06 KD1415	K56
5555606	M4D032Z04M16LN15	T14
5555607	M4D040Z04B32LN15	T15
5555608	M4D032Z04A32LN15L110	T16
5555609	M4D032Z04A32LN15L200	T16
5555716	B224A04100HP KCPK15	G51
5555800	M4D040Z04A32LN15L200	T16
5555801	M4D040Z05S16LN15	T17
5555802	M4D080Z09S27LN15	T17
5555803	M4D100Z11S32LN15	T17
5555804	M4D125Z09S40LN15	T17
5555805	M4D160Z12S40LN15	T17
5555806	M4D160Z16S40LN15	T17
5556965	SDET120464SNGB KCSM30	T105, T112, U51
5566274	RCMT1204M0RP KCP25B	B226
5572826	SDPT1204PDERGB2 KCPM40	T105, T112, U52
5572827	SDPT1204PDSRGB2 KCPM40	T105, T112, U52
5573990	DCMT150408LF KCP10B	B207
5575827	LNGU15T608SRGEM KC520M	T19
5575828	LNGU15T608SRGEM KCK15	T19
5575829	LNGU15T608SRGEM KCPK30	T19
5576320	VNMG160408FF KCP25B	B145
5577076	LNEU1245R08 KCPM40	U19
5577077	LNEU1255R08 KCPM40	U19
5577078	LNEU1245R04 KCPM40	U19
5577079	LNEU1255R04 KCPM40	U19
5577120	LNEU1245R08SGP KCPM40	U20
5577121	LNEU1240R08 4 KCPM40	U19
5577122	LNEU1240R03 4 KCPM40	U19
5577123	LNEQ1260R04 KCPM40	U20
5577124	LNEU1260R04 KCPM40	U19
5580585	WNMG080412MP KCP25B	B157
5585495	B224A05050HP KCPK15	G52
5586046	SNHX1102T KCPM40	U14
5586047	SNHX1103T KCPM40	U14
5586048	SNHX1203T KCPM40	U14
5586060	SNHX11T3PZTNGP KCPM40	U15
5586061	SNHX1102PZTNGP KCPM40	U15
5586062	SNHX1203PZTNGP KCPM40	U15
5586626	LNUX301940RRH KCP10B	E51
5588385	LNGU15T608ERGE KC725M	T18
5588386	LNGU15T608ERGE KCSM30	T18
5588387	LNGU15T608ERGE KCPM40	T18
5588388	LNGU15T608ERGE KC522M	T18
5588513	LNGU15T604ERGE KC725M	T18
5588514	LNGU15T604ERGE KCSM30	T18
5588515	LNGU15T604ERGE KCPM40	T18
5588516	LNGU15T604ERGE KC522M	T18
5588517	LNGU15T612ERGE KC725M	T18
5588518	LNGU15T612ERGE KCSM30	T18
5588519	LNGU15T612ERGE KCPM40	T18
5588550	LNGU15T612ERGE KC522M	T18
5588937	DFT110508MD KC7140	J87
5588973	RIQ09EDR00 KC6005	K56
5589680	LNPU221012PNSRHD KCPM40	S121, S123
5589965	B978F09000 KC7315	G149
5590137	410.091	E17–18
5590777	EDPT180508PDERHD KCPM40	T75
5591123	DCMT11T308FP KCM25B	B207
5591124	DCMT11T304FP KCM25B	B207
5591126	CCMT060208FP KCM25B	B176
5591127	DCMT070208FP KCM25B	B207
5591128	CCMT09T304FP KCM25B	B176
5591129	DCMT11T302FP KCM25B	B207
5591140	CCMT060204FP KCM25B	B176
5591141	CCMT060202FP KCM25B	B176
5591142	CCMT09T308FP KCM25B	B176
5591143	DCMT070204FP KCM25B	B207
5591144	CCMT09T302FP KCM25B	B176
5591146	CCMT120404FP KCM25B	B176
5591149	TCMT110204LF KCM25B	B244
5591151	DCMT070204LF KCM25B	B207
5591152	SCMT120408LF KCM25B	B230
5591154	VBMT110304LF KCM25B	B265
5591155	DPMT11T304LF KCM25B	B215
5591156	TCMT16T304LF KCM25B	B244
5591157	CPMT09T304LF KCM25B	B190
5591158	SCMT120404LF KCM25B	B230
5591159	TCMT16T308LF KCM25B	B244
5591160	TCMT110208LF KCM25B	B244
5591161	TPMT16T304LF KCM25B	B255
5591162	TPMT110204LF KCM25B	B255
5591164	TPMT16T308MF KCM25B	B255
5591166	SCMT120408MF KCM25B	B231
5591167	TCMT16T308MF KCM25B	B245
5591168	SPMT09T308MF KCM25B	B239
5591169	CPMT09T308MF KCM25B	B190
5591170	TCMT16T312MF KCM25B	B245
5591172	CCMT09T304MF KCM25B	B177
5591173	DCMT11T304MF KCM25B	B208
5591174	CCMT060204MF KCM25B	B177
5591175	SCMT09T308MF KCM25B	B231
5591256	CCMT09T312MF KCM25B	B177
5591610	TNMG220404FP KCM25B	B124
5591611	SNMG120408FP KCM25B	B97
5591612	SNMM250724RH KCP40B	B102
5591613	SNMM250924RH KCP40B	B102
5591615	CNMM190616RH KCP40B	B55
5591616	SNMM190624RH KCP40B	B102
5591617	SNMM190624RM KCP40B	B103
5591633	CNMM190624RP KCM25B	B56
5591634	SNMM250924RP KCM25B	B103
5591711	CPMT060208MF KCM25B	B190
5591712	CPMT09T312MF KCM25B	B190
5591713	TCMT110208MF KCM25B	B245
5591714	SNMG120408MN KCP40B	B98
5591716	CNMG120412MN KCP40B	B50
5591718	WNMG080412MN KCP40B	B157
5591720	TNMG220412MN KCP40B	B125
5591721	DNMG150412MN KCP40B	B78
5591727	DNMG150612MN KCP40B	B78
5591773	CNMG120404MN KCP40B	B50
5591774	WNMG080408MP KCM25B	B157
5591775	CNMG160616MP KCM25B	B51
5591776	SCMT09T308MP KCM25B	B231
5591777	CCMT120408MP KCM25B	B177
5591778	VBMT160408MP KCM25B	B265
5591779	CNMG120404MP KCM25B	B51
5591780	CNMG160612MP KCM25B	B51
5591781	VNMG160408MP KCM25B	B146
5591782	DNMG150408MP KCM25B	B79
5591783	CCMT09T308MP KCM25B	B177
5591784	DCMT11T308MP KCM25B	B208
5591785	TNMG160404MP KCM25B	B125
5591786	VBMT160404MP KCM25B	B265
5591787	CNMG190608MP KCM25B	B51
5591788	DNMG150604MP KCM25B	B79
5591789	VNMG160404MP KCM25B	B146
5591790	WNMG080412MP KCM25B	B157
5591791	DNMG110408MP KCM25B	B79
5591792	CCMT09T304MP KCM25B	B177
5591793	CCMT120412MP KCM25B	B177
5591794	SCMT120408MP KCM25B	B231
5591795	DNMG150612MP KCM25B	B79
5591796	TNMG220412MP KCM25B	B125
5591799	CNMG190612MP KCM25B	B51
5591900	DNMG150608MP KCM25B	B79
5591901	CNMG120412MP KCM25B	B51
5591902	DNMG150404MP KCM25B	B79
5591903	DNMG150612RN KCP40B	B81
5591904	TCMT16T304MP KCM25B	B245
5591906	TCMT16T308MP KCM25B	B245
5591907	SNMG120408MP KCM25B	B98
5591908	DNMG150416RN KCP40B	B81
5591910	TNMG220408MP KCM25B	B125
5591911	SNMG250924RN KCP40B	B101
5591912	WNMG060408MP KCM25B	B157
5591913	CNMG160616RN KCP40B	B53
5591914	CCMT060204MP KCM25B	B177
5591916	CPMT09T308MP KCM25B	B190
5591919	CNMG160612RP KCM25B	B53
5591930	DNMG110412MP KCM25B	B79
5591931	CNMG190612RP KCM25B	B53
5591932	DNMG150608RP KCM25B	B81

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
5591933	SNMG120412MP KCM25B	B98
5591934	SNMG190612MP KCM25B	B98
5591935	SNMG190612RP KCM25B	B101
5591936	SNMG190616RP KCM25B	B101
5591937	WNMG060404MP KCM25B	B157
5591938	WNMG080412RP KCM25B	B159
5591939	SNMG150608MP KCM25B	B98
5591950	CNMG120404RP KCM25B	B53
5591952	SNMG120416MP KCM25B	B98
5591953	SNMG150616RP KCM25B	B101
5591954	SNMG150612MP KCM25B	B98
5591955	CNMG190616RP KCM25B	B53
5591956	TNMG160412MP KCM25B	B125
5591957	CNMG120416RP KCM25B	B53
5591959	WNMG080408RP KCM25B	B159
5591960	CNMG160616RP KCM25B	B53
5591962	TNMG220408RP KCM25B	B128
5591963	CNMG120408MW KCM25B	B52
5591964	TNMG220412RP KCM25B	B128
5591967	TNMG270612RP KCM25B	B128
5591968	SNMG150612RN KCP40B	B101
5591970	TNMG330924RN KCP40B	B127
5591971	CNMG190612RP KCP40B	B53
5591972	WNMG080408RP KCP40B	B159
5591973	CNMG190612RN KCP40B	B53
5591974	TNMG330924RP KCP40B	B128
5591975	CNMG190616RN KCP40B	B53
5591976	DNMG150408RP KCM25B	B81
5591977	SNMG190616RN KCP40B	B101
5591979	WNMG080412RN KCP40B	B159
5591982	SNMG120412RP KCM25B	B101
5591983	CNMG160612RN KCP40B	B53
5591986	TNMG220408RN KCP40B	B127
5591987	CNMG120408UP KCM25B	B54
5591988	SNMG120412RN KCP40B	B101
5591989	CNMG190612UP KCM25B	B54
5591990	SNMG120416RN KCP40B	B101
5591991	CNMG120412UP KCM25B	B54
5591992	TNMG270616RN KCP40B	B127
5591993	CNMG120404UP KCM25B	B54
5591995	DNMG150408UP KCM25B	B82
5591998	DNMG150616RN KCP40B	B81
5592000	SNMG120408RN KCP40B	B101
5592003	WNMG060408UP KCM25B	B160
5592005	WNMG080408UP KCM25B	B160
5592006	RNMG190600RN KCP40B	B94
5592007	DNMG150608UP KCM25B	B82
5592008	DNMG150608RN KCP40B	B81
5592010	TNMG220412RN KCP40B	B127
5592012	CNMG160612UP KCM25B	B54
5592103	CNMG160608MR KCP25B	B51
5592107	WNMG060408MR KCP25B	B157
5592121	TNMG220408MR KCP25B	B126
5592123	TNMG220408MR KCM25	B126
5592124	SNMG120408MR KCP25B	B99
5592128	CNMG190616MR KCP25B	B51
5592141	DNMG110408MR KCP25B	B80
5592142	DNMG110408MR KCP10B	B80
5592146	TNMG270612MR KCP25B	B126
5592160	VNMG160412MR KCM15	B146
5592162	WNMG080416MR KCP10B	B157
5592163	WNMG080416MR KCP25B	B157
5593078	KTMDUWD15L040Z1	W29
5593079	KTMDUWD20L060Z2	W29
5593100	KTMDUWD23L070Z2	W29
5593101	KTMDUWD26L080Z3	W29
5593102	KTMDUWD36L095Z3	W34
5593103	KTMDUWD31L095Z4	W29
5593104	KTMDUWD42L120Z4	W34
5593122	KTMDUCD15L060Z1	W30
5593123	KTMDUCD17L065Z2	W30
5593124	KTMDUCD20L080Z2	W30
5593128	KTMDUED23L086Z2	W31
5593129	KTMDUED26L105Z3	W31
5593130	KTMDUED36L144Z3	W34
5593131	KTMDUED31L115Z4	W31
5593136	KTMDUSD42L400Z4	W35
5593137	KTMDUSD48L400Z5	W35
5593138	KTMDUSD56L400Z6	W35
5593141	TMS25D52L40Z8	W12
5593142	TMS25D36L34Z5	W12
5593143	TMS25D44L38Z6	W12
5593144	TMST25D36L34Z5	W13
5593149	TM24D14L26Z1	W4
5593150	TM24D15L30Z1	W4
5593151	TM24D16L28Z2	W4
5593152	TM24D16L36Z1	W4
5593153	TMT24D14L26Z1	W5
5593159	TM41D21L45Z1	W24
5593170	TM41D25L43Z2	W24
5593171	TM41D30L43Z3	W24
5593172	TM41D30L65Z3	W24
5593173	TM41D36L43Z5	W24
5593174	TM41D36L65Z4	W24
5593175	TMS41D48L50Z5	W25
5593176	TMS41D58L50Z6	W25
5593184	TM40D22L43Z3	W17
5593185	TM40D22L65Z3	W17
5593186	TM40D30L55Z4	W17
5593187	TM40D30L80Z3	W17
5593188	TMS40D44L48Z6	W18
5593189	TMS40D52L50Z8	W18
5593190	TMST40D45L48Z6	W19
5593383	KTMDU11L0515N60 KC635M	W32
5593385	KTMDU11L1520N60 KC635M	W32
5593386	KTMDU11L2025N60 KC635M	W32
5593387	KTMDU11L2525N60 KC635M	W32
5593388	KTMDU11L2540N60 KC635M	W32
5593389	KTMDU16L1520N60 KC635M	W36
5593680	KTMDU16L2535N60 KC635M	W36
5593681	KTMDU16L4060N60 KC635M	W36
5593682	KTMDU11L4816N55 KC635M	W32
5593683	KTMDU11L1612N55 KC635M	W32
5593684	KTMDU11L1107N55 KC635M	W32
5593686	KTMDU16L1107N55 KC635M	W36
5593687	KTMDU16L0604N55 KC635M	W36
5593688	KTMDU11L0515N60 KC610M	W32
5593689	KTMDU11L1520N60 KC610M	W32
5593690	KTMDU11L2025N60 KC610M	W32
5593691	KTMDU11L2525N60 KC610M	W32
5593692	KTMDU11L2540N60 KC610M	W32
5593693	KTMDU16L1520N60 KC610M	W36
5593694	KTMDU16L2535N60 KC610M	W36
5593695	KTMDU16L4060N60 KC610M	W36
5593696	KTMDU11L4816N55 KC610M	W32
5593697	KTMDU11L1612N55 KC610M	W32
5593698	KTMDU11L1107N55 KC610M	W32
5593699	KTMDU16L1612N55 KC610M	W36
5593710	KTMDU16L1107N55 KC610M	W36
5593711	KTMDU16L0604N55 KC610M	W36
5593712	TM24N32UN KC635M	W6
5593713	TM24N28UN KC635M	W6
5593714	TM24N24UN KC635M	W6
5593715	TM24N20UN KC635M	W6
5593716	TM24N18UN KC635M	W6
5593717	TM24N16UN KC635M	W6
5593718	TM24N14UN KC635M	W6
5593719	TM24N12UN KC635M	W6
5593720	TM24N10UN KC635M	W6
5593721	TM24N050ISO KC635M	W6
5593722	TM24N075ISO KC635M	W6
5593723	TM24N100ISO KC635M	W6
5593724	TM24N125ISO KC635M	W6
5593725	TM24N150ISO KC635M	W6
5593726	TM24N175ISO KC635M	W6
5593727	TM24N200ISO KC635M	W6
5593728	TM24N250ISO KC635M	W6
5593729	TM24EN18NPT KC635M	W6
5593740	TM24EN18NPTF KC635M	W7
5593741	TM24EN19BSF KC635M	W6
5593742	TM24EN14BSF KC635M	W6
5593743	TM24EN19BSPT KC635M	W7
5593744	TM24ENBLANK	W7
5593745	TM41N8UN KC635M	W26
5593746	TM41N7UN KC635M	W26
5593747	TM41N6UN KC635M	W26
5593748	TM41N5UN KC635M	W26
5593749	TM41N45UN KC635M	W26
5593750	TM41N4UN KC635M	W26
5593751	TM41N300ISO KC635M	W26
5593752	TM41N350ISO KC635M	W26
5593753	TM41N400ISO KC635M	W26
5593754	TM41N450ISO KC635M	W26
5593755	TM41N500ISO KC635M	W26
5593756	TM41N550ISO KC635M	W26
5593757	TM41N600ISO KC635M	W26
5593758	TM41EN8NPT KC635M	W26
5593759	TM41ENBLANK	W26
5593760	TM40N20UN KC635M	W20
5593762	TM40N16UN KC635M	W20
5593764	TM40N12UN KC635M	W20
5593767	TM40N8UN KC635M	W20
5593768	TM40N100ISO KC635M	W20
5593769	TM40N150ISO KC635M	W20
5593780	TM40N200ISO KC635M	W20
5593782	TM40N300ISO KC635M	W20
5593786	TM40EN11BSF KC635M	W20
5593788	TM40EN008NPT KC635M	W20
5593790	TM40EN008NPTF KC635M	W21
5593791	TM40EN011BSPT KC635M	W21
5593792	TM40ENBLANK	W21
5593793	TM24N32UN KC610M	W6
5593794	TM24N28UN KC610M	W6
5593795	TM24N24UN KC610M	W6
5593797	TM24N20UN KC610M	W6
5593798	TM24N18UN KC610M	W6
5593799	TM24N16UN KC610M	W6
5593800	TM24N14UN KC610M	W6
5593801	TM24N12UN KC610M	W6
5593802	TM24N10UN KC610M	W6
5593803	TM24N050ISO KC610M	W6
5593804	TM24N075ISO KC610M	W6
5593805	TM24N100ISO KC610M	W6
5593806	TM24N125ISO KC610M	W6
5593807	TM24N150ISO KC610M	W6
5593808	TM24N175ISO KC610M	W6
5593809	TM24N200ISO KC610M	W6
5593830	TM24N250ISO KC610M	W6
5593831	TM24EN18NPT KC610M	W6
5593832	TM24EN18NPTF KC610M	W7
5593833	TM24EN19BSF KC610M	W6
5593834	TM24EN14BSF KC610M	W6
5593835	TM24EN19BSPT KC610M	W7
5593837	TM41N8UN KC610M	W26
5593838	TM41N7UN KC610M	W26
5593839	TM41N6UN KC610M	W26
5593840	TM41N5UN KC610M	W26
5593841	TM41N45UN KC610M	W26
5593842	TM41N4UN KC610M	W26
5593843	TM41N300ISO KC610M	W26
5593844	TM41N350ISO KC610M	W26
5593845	TM41N400ISO KC610M	W26
5593846	TM41N450ISO KC610M	W26
5593847	TM41N500ISO KC610M	W26
5593848	TM41N550ISO KC610M	W26
5593850	TM41N600ISO KC610M	W26
5593851	TM41EN8NPT KC610M	W26
5593853	TM40N20UN KC610M	W20
5593854	TM40N18UN KC610M	W20
5593855	TM40N16UN KC610M	W20
5593856	TM40N14UN KC610M	W20
5593857	TM40N12UN KC610M	W20
5593858	TM40N10UN KC610M	W20
5593859	TM40N9UN KC610M	W20
5593870	TM40N8UN KC610M	W20
5593871	TM40N100ISO KC610M	W20
5593872	TM40N150ISO KC610M	W20
5593873	TM40N200ISO KC610M	W20
5593874	TM40N250ISO KC610M	W20
5593875	TM40N300ISO KC610M	W20
5593876	TM40EN16BSF KC610M	W20
5593877	TM40EN14BSF KC610M	W20
5593878	TM40EN12BSF KC610M	W20
5593879	TM40EN11BSF KC610M	W20
5593880	TM40EN115NPT KC610M	W20
5593881	TM40EN008NPT KC610M	W20
5593882	TM40EN115NPTF KC610M	W21
5593883	TM40EN008NPTF KC610M	W21
5593884	TM40EN011BSPT KC610M	W21
5593886	CNMG120408MR KCU10	B51
5593887	DNMG150408MR KCU10	B80
5593888	CNMG120412MR KCU10	B51
5593931	WNMG080408MR KCU10	B157
5593933	SNMG120408MR KCU10	B99
5593934	SNMG120412MR KCU10	B99
5593937	DNMG150608MR KCU10	B80
5595038	VNMG160408FF KCP10B	B145
5596414	CCMT120408LF KCM25B	B177
5596415	CCMT09T308LF KCM25B	B177
5596416	VBMT160408LF KCM25B	B265
5596417	DCMT11T308LF KCM25B	B207
5596418	VBMT160404LF KCM25B	B265
5596419	DCMT11T304LF KCM25B	B207
5596450	CCMT09T304LF KCM25B	B177
5596451	CCMT060204LF KCM25B	B177
5596455	CCMT09T308MF KCM25B	B177
5596456	CCMT120408MF KCM25B	B177
5596457	CNMG120408MN KCP40B	B50
5596460	CNMG120408MP KCM25B	B51
5596461	TNMG160408MP KCM25B	B125
5596462	CNMM190624RH KCP40B	B55
5596463	SNMM190616RM KCP40B	B103
5596465	CNMG120412RN KCP40B	B53
5596466	CNMG120416RN KCP40B	B53
5596468	CNMG120408RP KCM25B	B53
5596469	CNMG120412RP KCM25B	B53
5596480	TNMM220412RP KCM25B	B130
5596481	CNMM120408RP KCM25B	B56
5596483	SNMM190616RP KCM25B	B103
5596485	CNMM190616RP KCM25B	B56
5596488	CNMM160612RP KCM25B	B56
5596489	CNMM190612RP KCM25B	B56
5596859	KTIP1328HPM KCP15	H27
5596899	LNUX301940RRP KCP25	E52
5602422	KSEM3234HPGM KC7315	H43
5604719	B269A13800HP KCPK15	G70
5606542	UJBE1000A6AL KCSM15	P54
5606543	UJBE1200A6AL KCSM15	P54
5606544	UJBE1600A6AL KCSM15	P54
5606545	UJBE2000A6AL KCSM15	P54
5606546	UJBE1000A6AN KCSM15	P54
5606547	UJBE1200A6AN KCSM15	P54
5606548	UJBE1600A6AN KCSM15	P54
5606549	UJBE2000A6AN KCSM15	P54
5607996	LNPU15T612SRGE KC520M	T19
5607997	LNPU15T612SRGE KC522M	T19
5607998	LNPU15T612SRGE KC725M	T19
5608030	LNPU15T612SRGE KCPK30	T19
5608034	LNPU15T604SRGE KC520M	T19
5608035	LNPU15T604SRGE KC522M	T19
5608036	LNPU15T604SRGE KC725M	T19
5608037	LNPU15T604SRGE KCK15	T19
5608038	LNPU15T604SRGE KCPK30	T19
5608090	CNMM190616RP KCP25B	B56
5615509	HNHX090516ENLE KCK15	S90, S96
5615514	HNPX090530SNGE KCK15	S91, S97
5615518	HNHX090516SNGE KCK15	S91, S97
5615519	HNHX090516SNGE KC514M	S91, S97
5615534	VNMP160408K KCP10B	B148
5615608	VNMG160408FP KCP25B	B145
5615609	VNMG160408FN KCP10B	B145
5615610	HNHX090516ENLE KC514M	S90, S96
5615650	VNMG160408FN KCP25B	B145
5615680	HNPX090520SNGE KCK15	S91, S97
5615682	HNHX090520SNGE KCK15	S91, S97
5615683	HNHX090520SNGE KC514M	S91, S97
5615684	HNPX090516SNGE KCK15	S91, S97
5615687	HNHX090530SNGE KCK15	S91, S97
5616165	HNHX090520ENLE KCK15	S90, S96
5616166	HNHX090520ENLE KC514M	S90, S96
5616167	HNHX0905ANSNGE KCK15	S90, S96
5616168	HNHX0905ANSNGE KC514M	S90, S96
5618002	SNMM150612RM KCP25B	B103
5619961	SDET120464ENGB KC725M	T105, T112, U51
5619962	SDET120448SNGB KC725M	T105, T112, U51
5619963	SDET120448ENGB KC725M	T105, T112, U51
5619964	SDET120432ENGB KC725M	T105, T112, U51
5620156	LNPU221012PNSLHD2 KC520M	S121, S123
5620157	LNPU221012PNSLHD2 KCPK30	S121, S123
5620158	LNPU221012PNSRHD2 KCPM40	S121, S123

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
5620360	LNPU221012PNSRHD2 KCPK30	S121, S123
5620745	LNPU2410ANSRHD2 KCPM40	S117
5620747	LNPU2410ANSRHD2 KCPK30	S117
5620748	SM-906LH KC720	S116, S120, S122
5626642	KSEM1250HPGM KCPM45	H45
5626643	KSEM1280HPGM KCPM45	H45
5626644	KSEM1300HPGM KCPM45	H45
5626645	KSEM1350HPGM KCPM45	H45
5626647	KSEM1360HPGM KCPM45	H45
5626648	KSEM1380HPGM KCPM45	H45
5626649	KSEM1389HPGM KCPM45	H45
5626700	KSEM1410HPGM KCPM45	H45
5626701	KSEM1450HPGM KCPM45	H45
5626702	KSEM1468HPGM KCPM45	H45
5626703	KSEM1500HPGM KCPM45	H45
5626704	KSEM1508HPGM KCPM45	H45
5626705	KSEM1550HPGM KCPM45	H45
5626706	KSEM1580HPGM KCPM45	H45
5626707	KSEM1588HPGM KCPM45	H45
5626708	KSEM1600HPGM KCPM45	H45
5626709	KSEM1627HPGM KCPM45	H45
5626710	KSEM1650HPGM KCPM45	H45
5626711	KSEM1700HPGM KCPM45	H45
5626712	KSEM1707HPGM KCPM45	H45
5626713	KSEM1750HPGM KCPM45	H45
5626714	KSEM1786HPGM KCPM45	H45
5626715	KSEM1850HPGM KCPM45	H45
5626716	KSEM1865HPGM KCPM45	H45
5626717	KSEM1923HPGM KCPM45	H45
5626718	KSEM1945HPGM KCPM45	H45
5626719	KSEM2024HPGM KCPM45	H45
5626720	KSEM2050HPGM KCPM45	H45
5626721	KSEM2143HPGM KCPM45	H45
5626722	KSEM2150HPGM KCPM45	H45
5626723	KSEM2183HPGM KCPM45	H45
5626724	KSEM2244HPGM KCPM45	H45
5626725	KSEM2250HPGM KCPM45	H45
5626726	KSEM2342HPGM KCPM45	H45
5626727	KSEM2350HPGM KCPM45	H45
5626728	KSEM2450HPGM KCPM45	H45
5626729	KSEM2461HPGM KCPM45	H46
5626730	KSEM2550HPGM KCPM45	H46
5626731	KSEM2650HPGM KCPM45	H46
5626732	KSEM2659HPGM KCPM45	H46
5626733	KSEM2750HPGM KCPM45	H46
5626734	KSEM2778HPGM KCPM45	H46
5626735	KSEM2818HPGM KCPM45	H46
5626736	KSEM2850HPGM KCPM45	H46
5626737	KSEM2937HPGM KCPM45	H46
5626738	KSEM2950HPGM KCPM45	H46
5626739	KSEM2977HPGM KCPM45	H46
5626740	KSEM3050HPGM KCPM45	H46
5626741	KSEM3096HPGM KCPM45	H46
5626742	KSEM3100HPGM KCPM45	H46
5626743	KSEM3150HPGM KCPM45	H46
5626746	KSEM3250HPGM KCPM45	H46
5626747	KSEM3254HPGM KCPM45	H46
5626748	KSEM3350HPGM KCPM45	H46
5626749	KSEM3400HPGM KCPM45	H46
5626760	KSEM3450HPGM KCPM45	H46
5626761	KSEM3493HPGM KCPM45	H46
5626762	KSEM3500HPGM KCPM45	H46
5626763	KSEM3651HPGM KCPM45	H46
5626764	KSEM3700HPGM KCPM45	H46
5626765	KSEM3731HPGM KCPM45	H46
5626766	KSEM3750HPGM KCPM45	H46
5626767	KSEM3800HPGM KCPM45	H46
5626768	KSEM3846HPGM KCPM45	H46
5626769	KSEM3900HPGM KCPM45	H46
5627784	LNGU15T616SRGE KC520M	T19
5627785	LNGU15T616SRGE KC522M	T19
5627786	LNGU15T616SRGE KC725M	T19
5627787	LNGU15T616SRGE KCK15	T19
5627788	LNGU15T616SRGE KCPK30	T19
5627789	LNGU15T616ERGE KC725M	T18
5627870	LNGU15T616ERGE KCSM30	T18
5627871	LNGU15T616ERGE KCPM40	T18
5628796	CNMG120408MR KCPK05	B51
5628797	CNMG120412MR KCPK05	B51
5628831	CNMG160616RN KCPK05	B53
5628832	CNMG160616RP KCPK05	B53
5628833	DNMG150408MR KCPK05	B80
5628835	DNMG150412RN KCPK05	B81
5628837	DNMG150412MR KCPK05	B80
5628838	DNMG150608MW KCPK05	B80
5628839	DNMG150612RN KCPK05	B81
5628841	SNMG150616RN KCPK05	B101
5628844	WNMG080408RP KCPK05	B159
5628845	WNMG080408MR KCPK05	B157
5628847	WNMG080412RN KCPK05	B159
5628849	WNMG080412RP KCPK05	B159
5628850	WNMG080412MR KCPK05	B157
5629530	CNMG120412RN KCPK05	B53
5629532	CNMG190616RN KCPK05	B53
5629534	CNMM160616RP KCPK05	B56
5629536	DNMG150408MN KCPK05	B78
5629538	WNMG080408MW KCPK05	B158
5630018	LNGU15T616SRGEM KC520M	T19
5630019	LNGU15T616SRGEM KCK15	T19
5630070	LNGU15T616SRGEM KCPK30	T19
5630740	SNPJ10T308SNGD KC520M	S61
5630741	SNPJ10T308SNGD KCPM40	S61
5630742	SNPJ10T308SNGD KCK15	S61
5630743	SNPJ10T308SNGD KCPK30	S61
5630744	SNPJ10T312SNGD KCPM40	S61
5630745	SNPJ10T312SNGD KCK15	S61
5630746	SNPJ120608SNGD KC520M	S64
5630747	SNPJ120608SNGD KCPM40	S64
5630748	SNPJ120608SNGD KCK15	S64
5630751	SNPJ120616SNGD KCPM40	S64
5630752	SNPJ120616SNGD KCK15	S64
5631151	SNMG120408RP KCP25B	B101
5631155	SNMG120408RN KCP25B	B101
5635433	ND3040L KCU25	D14
5639385	DCMT11T308FP KCK20B	B207
5639388	DCMT11T308MP KCK20B	B208
5639660	DCMT11T312MF KCK20B	B208
5639663	DNMA150408 KCK20B	B75
5639666	DNMA150612 KCK20B	B75
5639667	DNMG110408RP KCK20B	B81
5639668	DNMG150408RP KCK20B	B81
5639681	DNMG150612RP KCK20B	B81
5639683	DPMT070208FW KCK20B	B215
5639689	RCMT0803M0 KCK20B	B224
5639690	RCMT10T3M0 KCK20B	B224
5639691	RCMT1204M0 KCK20B	B224
5639693	RCMT2006M0 KCK20B	B224
5639699	SCMT09T308MF KCK20B	B231
5639700	SCMT09T308MP KCK20B	B231
5639701	SCMT120408LF KCK20B	B230
5639702	SCMT120408MF KCK20B	B231
5639703	SCMT120408MP KCK20B	B231
5639705	SCMT120412MF KCK20B	B231
5639707	SCMW09T308 KCK20B	B232
5639708	SCMW120408 KCK20B	B232
5639709	SCMW120412 KCK20B	B232
5639710	SNMA120408 KCK20B	B96
5639761	SNMG120408RP KCK20B	B101
5639767	SPMT09T308LF KCK20B	B238
5639781	TCMT110204FP KCK20B	B244
5639782	TCMT110204LF KCK20B	B244
5639784	TCMT110208LF KCK20B	B244
5639785	TCMT110208MF KCK20B	B245
5639786	TCMT110208MP KCK20B	B245
5639787	TCMT16T304LF KCK20B	B244
5639788	TCMT16T304MP KCK20B	B245
5639790	TCMT16T308LF KCK20B	B244
5639791	TCMT16T308MF KCK20B	B245
5639792	TCMT16T308MP KCK20B	B245
5639793	TCMT16T312LF KCK20B	B244
5639794	TCMT16T312MF KCK20B	B245
5639795	TCMT220408LF KCK20B	B244
5639796	TCMW16T304 KCK20B	B246
5639797	TCMW16T308 KCK20B	B246
5639799	TNMA160408 KCK20B	B123
5639822	TNMA220408 KCK20B	B123
5639823	TNMA220412 KCK20B	B123
5639826	TNMG220408RP KCK20B	B128
5639834	TPMT16T308LF KCK20B	B255
5639837	TPMT16T308MP KCK20B	B255
5639838	TPMT16T312MF KCK20B	B255
5639840	VBMT110308LF KCK20B	B265
5639845	CCMT060204FW KCK20B	B176
5639849	CCMT060208LF KCK20B	B177
5640382	CCMT09T304MF KCK20B	B177
5640383	CCMT09T304MP KCK20B	B177
5640386	CCMT09T308MP KCK20B	B177
5640387	CCMT09T308MW KCK20B	B178
5640388	CCMT09T312MF KCK20B	B177
5640391	CCMT120408MF KCK20B	B177
5640392	CCMT120408MP KCK20B	B177
5640393	CCMT120408MW KCK20B	B178
5640394	CCMT120412LF KCK20B	B177
5640397	CCMW060204 KCK20B	B178
5640399	CCMW09T308 KCK20B	B178
5640400	CCMW120408 KCK20B	B178
5640401	CCMW120412 KCK20B	B178
5640402	CNMA120404 KCK20B	B47
5640403	CNMA160616 KCK20B	B47
5640406	CNMA190616 KCK20B	B47
5640408	CNMG120416RP KCK20B	B53
5640409	CNMG160612RP KCK20B	B53
5640416	CPMT060208MF KCK20B	B190
5640418	CPMT09T304FW KCK20B	B189
5640419	CPMT09T304LF KCK20B	B190
5640421	CPMT09T308LF KCK20B	B190
5640422	CPMT09T308MF KCK20B	B190
5640424	CPMT09T308MW KCK20B	B191
5640425	VBMT160404FP KCK20B	B265
5640427	VBMT160408FP KCK20B	B265
5640428	VBMT160408MP KCK20B	B265
5640429	VBMT160412LF KCK20B	B265
5640431	VNMG160408RP KCK20B	B147
5640436	WNMG080408RP KCK20B	B159
5640437	WNMG080412RP KCK20B	B159
5640442	CCMT060204LF KCM15B	B177
5640443	CCMT09T304LF KCM15B	B177
5640444	CCMT09T308LF KCM15B	B177
5640445	CCMT09T308MF KCM15B	B177
5640448	CCMT120408MF KCM15B	B177
5640449	CNMG120408FP KCM15B	B49
5640480	CNMG120408MP KCM15B	B51
5640482	CNMG120408RP KCM15B	B53
5640483	CNMG120412RP KCM15B	B53
5640484	DCMT11T304LF KCM15B	B207
5640485	DCMT11T308LF KCM15B	B207
5640486	DNMG110404FP KCM15B	B77
5640487	DNMG150612FP KCM15B	B77
5640490	TNMG160408MP KCM15B	B125
5640491	TPMT090204LF KCM15B	B255
5640492	VBMT160404LF KCM15B	B265
5640493	VBMT160408LF KCM15B	B265
5640494	WNMG080408FP KCM15B	B156
5640496	WNMG080412MW KCM15B	B158
5640904	CCMT060204FP KCM15B	B176
5640905	CCMT060204MF KCM15B	B177
5640906	CCMT060204MP KCM15B	B177
5640907	CCMT060208LF KCM15B	B177
5640908	CCMT09T304FP KCM15B	B176
5640909	CCMT09T304MF KCM15B	B177
5640960	CCMT09T304MP KCM15B	B177
5640961	CCMT09T304MW KCM15B	B178
5640962	CCMT09T308FP KCM15B	B176
5640963	CCMT09T308FW KCM15B	B176
5640964	CCMT09T308MP KCM15B	B177
5640965	CCMT09T308MW KCM15B	B178
5640969	CNMG090308MP KCM15B	B51
5640970	CNMG120404FF KCM15B	B48
5640971	CNMG120404MP KCM15B	B51
5640973	CNMG120404UP KCM15B	B54
5640974	CNMG120408FF KCM15B	B48
5640975	CNMG120408FW KCM15B	B49
5640976	CNMG120408MR KCM15B	B51
5640977	CNMG120408P KCM15B	B52
5640978	CNMG120408UP KCM15B	B54
5640979	CNMG120412MP KCM15B	B51
5640980	CNMG120412MR KCM15B	B51
5640981	CNMG120416MP KCM15B	B51
5640982	CNMG160608MP KCM15B	B51
5640985	CNMG160612MP KCM15B	B51
5640986	CNMG160612RP KCM15B	B53
5640988	CNMG190608MP KCM15B	B51
5640997	WNGA080408S01015FWHBMT KBH20	B324
5641044	SNMG150612MR KCM15B	B99
5641046	WNMG080408MR KCM15B	B157
5641047	WNMG080412MR KCM15B	B157
5641048	CNMG120404MR KCM15B	B51
5641055	DNMG150608MR KCM15B	B80
5641062	VNMG160408MR KCM15B	B146
5641064	WNMG060408MR KCM15B	B157
5641067	CPGH09T304 KCM15B	B188
5641069	CPMT060208MF KCM15B	B190
5641090	CPMT09T304LF KCM15B	B190
5641091	CPMT09T308MF KCM15B	B190
5641093	DCMT070204LF KCM15B	B207
5641094	DCMT11T308MF KCM15B	B208
5641095	DNMG110408FW KCM15B	B78
5641096	DNMG150404FF KCM15B	B76
5641098	DNMG150404MP KCM15B	B79
5641099	DNMG150408MP KCM15B	B79
5641101	DNMG150604MP KCM15B	B79
5641102	DNMG150608MP KCM15B	B79
5641105	SNMG120408MP KCM15B	B98
5641107	SNMG150616RP KCM15B	B101
5641108	TCMT110204LF KCM15B	B244
5641109	TNMG160404FF KCM15B	B124
5641110	TNMG160404MP KCM15B	B125
5641111	TNMG160412MP KCM15B	B125
5641113	TNMG220408MP KCM15B	B125
5641114	VNMG160404FF KCM15B	B145
5641115	VNMG160404MP KCM15B	B146
5641116	VNMG160408MP KCM15B	B146
5641117	VNMG160412MP KCM15B	B146
5641118	WNMG080404FW KCM15B	B156
5641119	WNMG080404P KCM15B	B158
5641120	WNMG080408MP KCM15B	B157
5641121	WNMG080408P KCM15B	B158
5641122	WNMG080408RP KCM15B	B159
5641123	WPMT06T304LF KCM15B	B272
5641236	CCMT060204LF KCK20B	B177
5641237	CCMT09T308LF KCK20B	B177
5641238	CCMT09T308MF KCK20B	B177
5641239	CCMT120408LF KCK20B	B177
5641360	CNMA120408 KCK20B	B47
5641361	CNMA120412 KCK20B	B47
5641363	CNMA160612 KCK20B	B47
5641364	CNMG120404UN KCK20B	B54
5641365	CNMG120408RP KCK20B	B53
5641366	CNMG120408UN KCK20B	B54
5641367	CNMG120412RP KCK20B	B53
5641369	DCMT11T304LF KCK20B	B207
5641370	DCMT11T308LF KCK20B	B207
5641371	SCMT09T308LF KCK20B	B230
5641372	SNMA120412 KCK20B	B96
5641373	SNMG120412UN KCK20B	B102
5641375	VBMT160404LF KCK20B	B265
5641377	WNMA080408 KCK20B	B155
5641379	WNMG060408UN KCK20B	B160
5642146	CNMG120412UN KCK20B	B54
5642147	CNMG120416UN KCK20B	B54
5642148	CNMG160608UN KCK20B	B54
5642149	CNMG160612UN KCK20B	B54
5642150	CNMG160616UN KCK20B	B54
5642154	DNMA110408 KCK20B	B75
5642155	DNMA150416 KCK20B	B75
5642158	DNMG150408UN KCK20B	B82
5642159	DNMG150412UN KCK20B	B82
5642160	DNMG150416UN KCK20B	B82
5642161	DNMG150608UN KCK20B	B82
5642162	DNMG150612UN KCK20B	B82
5642165	RCMT2006M0RP KCK20B	B226
5642167	SNMG120408UN KCK20B	B102
5642168	SNMG120416UN KCK20B	B102
5642173	TNMG160408UN KCK20B	B128
5642174	TNMG160412UN KCK20B	B128
5642182	WNMA060412 KCK20B	B155
5642185	WNMG080408UN KCK20B	B160
5642186	WNMG080412UN KCK20B	B160
5650846	TPUN110304 KCK15B	B171
5650847	TPUN160304 KCK15B	B171
5650848	TPUN160308 KCK15B	B171
5651220	RPHT1204M0TX4 X700	V96
5651222	XDLW090408SRD X500	V16

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
5651223	XDLW120508SRD X400	V25
5651479	RPHT1204M0E421X4 X500	V95
5652131	XPNT2020T306RF SP6519	V105
5652140	SDHT120412EN422 SP6519	T119
5652239	XDLW090408SRD X400	V16
5652248	XDLT120512ERD411 X500	V24
5652249	XDLT090412ERD411 SP6519	V15
5652489	RPHT1204M0TX4 SP6519	V96
5652490	XDLT090408ERD41 SP6519	V14
5652729	XDLT120508ERD41 SC6525	V23
5652800	RPEX10T3M0F701X4 SP4019	V90
5652874	XPNT32320612RF SP6519	V105
5652878	XPNT4040T716RF SP6519	V105
5652899	XDLT120512ERD411 SP6519	V24
5653062	XPNT16160308RF SP6519	V105
5653064	XPNT5050T716RF SP6519	V105
5653106	XDLT090408ERD41 SC6525	V14
5653137	SDHT120412EN423 X500	T119
5653138	SDHT09T308EN422 X500	T116
5653139	XELT160512ERD41 X500	V30
5653140	XELT160512ERD41 SP6519	V30
5653576	SDHT09T308EN422 SP6519	T116
5653885	SDHT120412EN422 X500	T119
5653890	SDHT09T3AEEN422 SP6519	T116
5653930	XDLT120508ERD41 X500	V23
5653967	XELW160512SRD X400	V31
5654214	XPNT25250408RF SP6519	V105
5654220	XDLT120508ERD41 SP6519	V23
5654267	XPLT060308ERD41 SP6519	V7
5654371	RPHT1204M0TX4 X500	V96
5654377	XPLT060308ERD41 X400	V7
5654397	XPLT060308ERD41 X500	V7
5654405	SDHT09T308EN423 X500	T116
5654744	RPMT1204M0E41X4 SP6519	V96
5654896	XDLT090408ERD41 X500	V14
5655031	SDHT120412EN423 SP6519	T119
5655035	RPHT10T3M0TX4 SP6519	V91
5655104	XELT160512ERD41 SC6525	V30
5655105	SDHT09T308EN423 SP6519	T116
5655109	XDLW120508SRD X500	V25
5655128	RPHT10T3M0TX4 X500	V91
5655172	XDLT090412ERD411 X500	V15
5655255	XDLW090408SRD SC6525	V16
5655265	XPLT060308ERD41 SC6525	V7
5655472	XDLT090408ERD721 GH2	V14
5655817	XELW160512SRD SC3025	V31
5656081	XDLW090408SRD SC3025	V16
5656214	XDLW120508SRD SC3025	V25
5656242	RPEX10T3M0F701X4 GH1	V90
5656252	XDLT120508ERD721 GH2	V23
5656377	7792VXD09-A050Z6R	V12–13
5656380	7792VXD12-A125Z8R	V20–22
5656381	RPMT10T3M0E41X4 X500	V91
5656383	7792VXD12-A052Z5R	V20–22
5656533	SDMT120412EN41 MP91M	T120
5656727	7792VXD09-A040Z3R	V12–13
5656728	7792VXD12-A052Z3R	V20–22
5656729	7792VXD12-A063Z4R	V20–22
5656730	7792VXD12-A080Z5R	V20–22
5656765	SDMT09T308EN41 X500	T117
5656911	RPHT10T3M0E421X4 X700	V90
5656914	7792VXD09-A050Z5R	V12–13
5656917	RPMW10T3M0TX4 X500	V91
5657226	RPMT1204M0E41X4 X500	V96
5657234	7792VXD09-A040Z4R	V12–13
5657235	7792VXD12-A063Z5R	V20–22
5657271	SDMT120412EN41 X500	T120
5657681	RPHT1204M0E442X5 X500	V96
5657863	F3510T S	V9–12
5657893	7792VXD09WA025Z2R	V10, V13
5658074	7792VXD09WA032Z3R	V10, V13
5658181	XER050NTN4-E SP4060	P73
5658182	XER080NN4-C SP4060	P73
5658183	XER080NN4-G SP4060	P73
5658184	XER100NN4-E SP4060	P73
5658186	XER120NN4-J SP4060	P73
5658187	XER160NN4-G SP4060	P73
5658324	RPHT1204M0E442X5 SP6519	V96
5658492	XER160NN4-P SP4060	P73
5658650	ZDET16M540ER721 GH1	T90
5658651	7792VXE16CA040Z2R102	V27, V29
5659130	7792VXD12-160Z7R	V20–22
5659132	7792VXD12SA032Z2R43 S	V18, V22
5659264	RPHT1204M0E442X4 SP6519	V95
5659355	SDMW120412TN SP6519	T120
5659561	RPHT1204M0E442X5 X700	V96
5659562	RPHT10T3M0E422X8 X700	V91
5659563	7792VXE16CA050Z3R102	V27
5659603	ZDET16M525ER721 GH1	T90
5659867	RPHT10T3M0E422X4 SP6519	V91
5659912	ZDET16M520FR721 GH1	T90
5659913	ZDET16M532FR721 GH1	T90
5659914	ZDET16M560FR721 GH1	T90
5659947	7792VXD09CA025Z2R50	V11, V13
5659955	7792VXE16-A063Z5R	V28–29
5659956	7792VXE16-A100Z8R	V28–29
5660025	XE060MN4-C SP4060	P72
5660042	RPMW1204M0TX4 SP6519	V97
5660062	7792VXP06SA032Z5R43 S	V4, V6
5660064	7792VXD12-A066Z4R	V20–22
5660065	7792VXD12-A066Z5R	V20–22
5660220	XER060NN4-G SP4060	P73
5660221	XER120NN4-C SP4060	P73
5660222	XER120NN4-G SP4060	P73
5660223	XER160NN4-J SP4060	P73
5660351	RPHT1204M0E442X4 X500	V95
5660353	XER120NN4-L SP4060	P73
5660448	7792VXD09SA032Z3R43 S	V9, V13
5660462	RPHT10T3M0E422X4 X500	V91
5660778	RPHT10T3M0E422X8 SP6519	V91
5661016	7792VXD09CA032Z3R70	V11, V13
5661017	7792VXD12CA032Z2R70	V19, V22
5661028	7792VXE16-A125Z10R	V28–29
5661037	ZDET16M512FR721 GH1	T90
5661186	SDMT09T308EN41 SP6519	T117
5665481	XE080MN4-C SP4060	P72
5665491	RPHT10T3M0E422X4 X700	V91
5665735	XE040MTN4-C SP4060	P72
5665736	XE050MTN4-C SP4060	P72
5665737	XE160MN4-C SP4060	P72
5665740	SDMT120412EN41 SP6519	T120
5665786	RPMW1204M0TX4 X500	V97
5665804	ZDET16M5PDFR721 GH1	T90
5665820	7792VXP06SA020Z2R35 S	V4, V6
5665928	RPEX1204M0E701X4 X500	V95
5665943	7792VXD12-A125Z11R	V20–22
5665949	ZDET16M508FR721 GH1	T90
5665950	ZDET16M540FR721 GH1	T90
5665957	7792VXE16-160Z12R	V28–29
5665960	XE025MTN4-C SP4060	P72
5665964	7792VXP06SA025Z3R35 S	V4, V6
5665970	XER030NTN4-C SP4060	P73
5665971	XER060NN4-C SP4060	P73
5666016	RPHT10T3M0E421X4 X500	V90
5666144	7792VXD12-A100Z9R	V20–22
5666187	7792VXD12-A052Z4R	V20–22
5666264	SDMT09T308EN41 MP91M	T117
5666365	XE200MN4-C SP4060	P72
5666376	ZDET16M516FR721 GH1	T90
5666394	RPMT10T3M0E41X4 MP91M	V91
5666409	7792VXP06CA025Z4R154	V5–6
5666519	RPHT10T3M0E422X8 X500	V91
5666838	XER200NN4-M SP4060	P73
5666871	XER160NN4-L SP4060	P73
5667006	7792VXE16-A080Z6R	V28–29
5667023	7792VXP06SA025Z4R35 S	V4, V6
5667132	RPMT10T3M0E41X4 SP6519	V91
5667156	XER100NN4-C SP4060	P73
5667399	RPMT1204M0E41X4 MP91M	V96
5667400	RPMW1204M0TX4 MP91M	V97
5667475	7792VXD09-A040Z5R	V12–13
5667478	7792VXD12-A080Z8R	V20–22
5667498	ZDET16M530FR721 GH1	T90
5667591	XER040NTN4-C SP4060	P73
5667592	XER100NN4-G SP4060	P73
5667593	XER160NN4-M SP4060	P73
5667617	XER060NN4-E SP4060	P73
5667618	XER120NN4-E SP4060	P73
5667619	XER200NN4-J SP4060	P73
5667834	7792VXD12-A100Z6R	V20–22
5667884	XER080NN4-E SP4060	P73
5667885	XER160NN4-C SP4060	P73
5667909	XE020MTN4-C SP4060	P72
5667916	7792VXD09SA025Z2R35 S	V9, V13
5667922	ZDET16M525FR721 GH1	T90
5667944	XE030MTN4-C SP4060	P72
5667946	ZDET16M504FR721 GH1	T90
5668058	XER020NTN4-C SP4060	P73
5668059	XER040NTN4-E SP4060	P73
5668061	XER200NN4-G SP4060	P73
5668072	RPHT1204M0E442X4 X700	V95
5671376	M8 1.25 X 25 SHCS	T88, V12, V89, V94
5671642	TB15	V9, V11–12, V21, V87–89
5671643	M20 X 2.5 X 50 SHCS	T118, V21, V28
5672230	7713VR10SA025Z2R35 S	V87, V89
5672231	7713VR10SA032Z3R35 S	V87, V89
5672232	7713VR12-A040Z04R	V94
5672233	7713VR12-A050Z05R	V94
5672234	7713VR12-A063Z06R	V94
5672235	7713VR12-A066Z06R	V94
5672236	7713VR12SA025Z2R35 S	V93–94
5672271	5720VZ16CA032Z2R75 S	T87
5672329	D6014T S	V102
5672330	NLW-16SP S	T118
5672332	FP2506T	V4–5
5672365	SB3230	T118
5672367	SB3413	T115
5672374	D4008T S	V87–89, V93–94
5672375	D4010T S	V18–19, V21, V94, V101–104
5672376	D5013T S	V101–102, V104
5672378	F4011T S	T118
5672381	T9 S	T115, T118
5672387	D4012T S	V21
5672404	FP3007T S	V101, V103–104
5672405	TP20	T86–89, V27–28
5672409	D4007T S	V87–89
5672410	NLW12SP WASHER	T118
5672412	SB3232	T118
5672414	FP3006T	V101, V104
5672415	TP7	V4–5
5672416	SB3621	T115
5672468	M-21-M12-CA25-156 S	V35
5672625	7713VR10-A042Z06R	V89
5672627	5505VX20CA25/020R40	V104
5672766	5720VZ16HA032Z3R75	T89
5672811	7713VR10CA020Z2R40	V88–89
5672812	7713VR10CA032Z3R70	V88–89
5672813	7713VR10-A040Z05R	V89
5672829	M-13-M8-CA16-130 S	V35
5672830	M-18-M10-CA20-190 S	V35
5672831	M-21-M12-CA25-206 S	V35
5672832	M-29-M16-CA32-160 S	V35
5672842	5505VX32WA032R100	V102
5672843	5505VX20SA020R35	V101
5672864	5230VS12-A063Z4R57	T118
5672869	5720VZ16-A050Z03R	T88
5672870	5720VZ16-A063Z4R S	T88
5672876	5230VS09-A050Z4R51	T115
5672883	5230VS12-A080Z5R65	T118
5672892	5720VZ16CA025Z2R75	T87
5672893	5720VZ16SA025Z2R50	T86
5672894	5720VZ16SA032Z2R50	T86
5672984	M-18-M10-CA20-170 S	V35
5672985	M-21-M12-CA25-131 S	V35
5672986	M-21-M12-CA25-181 S	V35
5672987	M-21-M12-CA25-231 S	V35
5672988	M-29-M16-CA32-210 S	V35
5672989	M-29-M16-CA32-310 S	V35
5673047	7713VR10CA025Z3R50	V88–89
5673048	7713VR10CA032Z4R70	V88–89
5673049	7713VR10SA020Z2R25 S	V87, V89
5673050	7713VR10SA032Z4R35 S	V87, V89
5673051	7713VR12-A050Z06R	V94
5673052	7713VR12SA032Z3R35 S	V93–94
5673053	7713VR12SA040Z5R43 S	V93–94
5673112	5505VX25WA025R60	V102
5673113	5505VX40WA040R100	V102
5673114	5505VX50WA050R100	V102
5673115	5505VX25SA025R40	V101
5673141	5505VX32CA032R65	V104
5673167	5230VS12-A063Z4R94	T118
5673169	5230VS12-A100Z6R133	T118
5673174	5720VZ16-A050Z04R	T88
5673236	5230VS12-A080Z5R110	T118
5673237	7792VXP06CA020Z3R154	V5–6
5673238	5720VZ16SA032Z3R50	T86
5673240	7792VXP06CA016Z2R140	V5–6
5673275	F8017S S	V102
5673297	5505VX50WA050R150	V102
5673316	5720VZ16-A080Z5R	T88
5673329	5505VX32WA032R75	V102
5673340	7713VR10-A050Z06R	V89
5673341	7713VR10SA035Z5R35 S	V87, V89
5673342	7713VR12-A052Z06R	V94
5673343	FP2507T	V4–5
5673352	M-13-M8-CA16-110 S	V35
5673360	7713VR12-A040Z05R	V94
5673438	7713VR10-A063Z08R	V89
5673439	7713VR12SA040Z4R43 S	V93–94
5673479	7713VR12-A066Z07R	V94
5673490	5720VZ16-A040Z3R	T88
5673503	7792VXD09SA035Z3R43	V9
5673504	7792VXD12-A050Z4R	V20–21
5673519	M-18-M10-CA20-130 S	V35
5673521	5505VX40WA040R150	V102
5673528	5720VZ16-A063Z5R S	T88
5673542	TP8	V101, V103–104
5673544	T20 S	T118, V101–102, V104
5673546	T15 S	T115, V9–12, V18–19, V21, V93–94, V101–104
5673548	DP5009A S	T86–89
5673587	M-13-M8-CA16-170 S	V35
5673599	7713VR12-A063Z07R	V94
5673610	5505VX25CA025R55	V104
5673616	5720VZ16-A080Z04R	T88
5673629	5720VZ16HA040Z4R75	T89
5673632	5505VX32SA032R50	V101
5673703	M-18-M10-CA20-110 S	V35
5673711	5505VX16SA016R25	V101
5673712	5505VX16CA20/016R30	V104
5673742	5230VS12-A100Z6R76	T118
5673749	5505VX25WA025R69	V103
5673750	5505VX20WA020R34	V103
5673768	7713VR10SA025Z3R35 S	V87, V89
5673769	7713VR12-A052Z05R	V94
5673770	7713VR12CA025Z2R50	V93–94
5673782	M-13-M8-CA16-090 S	V35
5673783	M-29-M16-CA32-260 S	V35
5673785	5505VX25CA32/025R55	V104
5673796	DP5013T S	V27–28
5673801	5230VS09-A050Z4R80	T115
5673828	7713VR10-A050Z07R	V89
5673829	7713VR12-A080Z08R	V94
5673830	7713VR12CA032Z3R70	V93–94
5673899	F3508T S	T115, V9–11
5674437	RPHT1204M0E442X5 SC6525	V96
5674698	RPPT1204M0E432X5 SC6525	V97
5674780	RPHT1204M0E442X8 SC6525	V96
5674803	RPPT1204M0E432X5 X700	V97
5674959	RPPT1204M0E432X8 X500	V97
5675037	RPPT1204M0E432X5 SP6519	V97
5675038	RPPT1204M0E432X5 X500	V97
5675140	RPPT1204M0E432X8 SP6519	V97
5675237	ZDET16M530ER721 GH1	T90
5676726	RIR01E1306 KC6105	K53
5676727	RIR04E1312 KC6105	K53
5676728	RIQ06E1306 KC6105	K55
5676729	RIQ06R0400FB KT6225	K55
5676760	RIQ06E1300 KC6005	K55
5676761	RIQ06E1300 KC6105	K55
5676762	RIQ06E1312 KC6005	K55
5676763	RIQ06E1312 KC6105	K55
5676764	RIQ09E1300 KC6105	K55
5676765	RIQ09E1306 KC6105	K55
5676766	RIQ09E1312 KC6005	K55
5676767	RIQ09E1312 KC6105	K55
5676768	RIQ06EGR00 KC6105	K56
5676769	RIQ06EGR00 KC6305	K56
5676770	RIQ06EGR00 KC6005	K56
5676771	RIQ06EGR06 KC6005	K56
5676772	RIQ06EGR06 KC6105	K56
5676773	RIQ06EGR12 KC6005	K56
5676774	RIQ06EGR12 KC6105	K56
5676775	RIQ06EGR12 KC6305	K56

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
5676776	RIQ09EGR00 KC6105	K56
5676777	RIQ09EGR00 KC6305	K56
5676778	RIQ09EGR00 KC6005	K56
5676779	RIQ09EGR06 KC6005	K56
5676780	RIQ09EGR06 KC6105	K56
5676781	RIQ09EGR06 KC6305	K56
5676782	RIQ09EGR12 KC6005	K56
5676783	RIQ09EGR12 KC6105	K56
5676784	RIQ09EGR12 KC6305	K56
5676785	RIQ06EDR00 KC6105	K56
5676786	RIQ06EDR00 KC6305	K56
5676787	RIQ06EDR00 KC6005	K56
5676788	RIQ06EDR06 KC6005	K56
5676790	RIQ06EDR06 KC6105	K56
5676791	RIQ06EDR06 KC6305	K56
5676792	RIQ06EDR12 KC6005	K56
5676794	RIQ06EDR12 KC6105	K56
5676795	RIQ06EDR12 KC6305	K56
5676796	RIQ09EDR06 KC6005	K56
5676797	RIQ09EDR06 KC6105	K56
5676798	RIQ09EDR06 KC6305	K56
5676799	RIQ09EDR12 KC6005	K56
5676800	RIQ09EDR12 KC6105	K56
5676801	RIQ09EDR12 KC6305	K56
5681105	7792VXP06SA016Z2R25 S	V4, V6
5681115	5720VZ16CA032Z3R75 S	T87
5681122	7792VXP06SA020Z3R35 S	V4, V6
5681124	7792VXP06CA032Z5R190 S	V5–6
5682154	ZDET16M550FR721 GH1	T90
5682157	XE100MN4-C SP4060	P72
5682563	RPEX1204M0F701X4 GH1	V95
5682725	M16X2X40 LHSCS S	V28
5682757	TB20	V28
5682767	M12 X 1.75 X 30 SHCS S	T88, T115, T118, V12, V21, V28, V94
5682768	M10 1.5 X 25 SHCS S	T88, V12, V21, V28, V89, V94
5682773	M16 X 2 X 40 SHCS S	T118, V21
5682897	NLW-0.375 S	T115, T118
5684657	LNPU15T608SRGE KCPM40	T19
5684744	RNGN120400TGN KYSP30	V148
5684745	RNGN120400EGN KYSP30	V148
5684746	RNGN120400TGN KYS30	V148
5684747	RNGN120400EGN KYS30	V148
5685937	CNMG120408MN KCPK05	B50
5686413	RCMH3209M0TUP KCP25B	E60
5687543	KSEM1938HPLM KC7320	H50
5689447	DFSP240R5WD32M	J28
5689448	DFSP250R5WD32M	J28–29
5689449	DFSP260R5WD32M	J28
5689500	DFSP265R5WD32M	J28
5689501	DFSP270R5WD32M	J28
5689502	DFSP280R5WD32M	J28
5689503	DFSP290R5WD32M	J28
5689504	DFSP300R5WD32M	J28
5689505	DFSP310R5WD32M	J28
5689506	DFSP320R5WD32M	J28–29
5689507	DFSP330R5WD32M	J28
5689508	DFSP340R5WD32M	J28
5689509	DFSP350R5WD32M	J28
5689510	DFSP360R5WD32M	J28
5689511	DFSP370R5WD32M	J28
5689512	DFSP375R5WD32M	J28
5689513	DFSP380R5WD32M	J28
5689514	DFSP390R5WD32M	J28
5689515	DFSP400R5WD32M	J28–29
5689516	DFSP410R5WD32M	J28
5689517	DFSP420R5WD32M	J28
5689518	DFSP430R5WD32M	J28–29
5689519	DFSP440R5WD32M	J28
5689530	DFSP450R5WD40M	J28
5689531	DFSP460R5WD40M	J28
5689532	DFSP470R5WD40M	J28
5689533	DFSP480R5WD40M	J28–29
5689534	DFSP490R5WD40M	J28
5689535	DFSP500R5WD40M	J28
5689536	DFSP510R5WD40M	J28
5689537	DFSP140R2WD20M	J22
5689538	DFSP520R5WD40M	J28
5689539	DFSP145R2WD20M	J22
5689540	DFSP530R5WD40M	J28
5689541	DFSP150R2WD20M	J22
5689542	DFSP540R5WD40M	J28
5689543	DFSP155R2WD20M	J22
5689544	DFSP550R5WD50M	J28–29
5689545	DFSP160R2WD20M	J22
5689546	DFSP165R2WD32M	J22
5689548	DFSP170R2WD32M	J22–23
5689549	DFSP175R2WD32M	J22
5689550	DFSP180R2WD32M	J22
5689551	DFSP185R2WD32M	J22
5689552	DFSP190R2WD32M	J22
5689553	DFSP195R2WD32M	J22
5689554	DFSP200R2WD32M	J22
5689555	DFSP210R2WD32M	J22–23
5689556	DFSP220R2WD32M	J22
5689557	DFSP230R2WD32M	J22
5689630	DFSP140R3WD20M	J24
5689631	DFSP145R3WD20M	J24
5689632	DFSP150R3WD20M	J24
5689633	DFSP155R3WD20M	J24
5689634	DFSP160R3WD20M	J24
5689635	DFSP165R3WD32M	J24
5689636	DFSP170R3WD32M	J24–25
5689637	DFSP175R3WD32M	J24
5689638	DFSP180R3WD32M	J24
5689639	DFSP185R3WD32M	J24
5689640	DFSP190R3WD32M	J24
5689641	DFSP195R3WD32M	J24
5689642	DFSP200R3WD32M	J24
5689643	DFSP210R3WD32M	J24–25
5689644	DFSP220R3WD32M	J24
5689645	DFSP230R3WD32M	J24
5689684	DFSP175R4WD32M	J26
5689685	DFSP180R4WD32M	J26
5689686	DFSP185R4WD32M	J26
5689687	DFSP190R4WD32M	J26
5689688	DFSP195R4WD32M	J26
5689689	DFSP200R4WD32M	J26
5689690	DFSP210R4WD32M	J26–27
5689691	DFSP220R4WD32M	J26
5689692	DFSP230R4WD32M	J26
5689905	DFSP200R5WD32M	J28
5689906	DFSP210R5WD32M	J28–29
5689907	DFSP220R5WD32M	J28
5689908	DFSP230R5WD32M	J28
5691861	DFSP240R3WD32M	J24
5691862	DFSP250R3WD32M	J24–25
5691863	DFSP260R3WD32M	J24
5691864	DFSP265R3WD32M	J24
5691865	DFSP270R3WD32M	J24
5691866	DFSP280R3WD32M	J24
5691867	DFSP290R3WD32M	J24
5691868	DFSP300R3WD32M	J24
5691869	DFSP310R3WD32M	J24
5691870	DFSP320R3WD32M	J24–25
5691871	DFSP330R3WD32M	J24
5691872	DFSP340R3WD32M	J24
5691873	DFSP350R3WD32M	J24
5691874	DFSP360R3WD32M	J24
5691875	DFSP370R3WD32M	J24
5691876	DFSP375R3WD32M	J24
5691877	DFSP380R3WD32M	J24
5691878	DFSP390R3WD32M	J24
5691879	DFSP400R3WD32M	J24–25
5691880	DFSP410R3WD32M	J24
5691881	DFSP420R3WD32M	J25
5691882	DFSP430R3WD32M	J25
5691883	DFSP440R3WD32M	J25
5691884	DFSP450R3WD40M	J25
5691885	DFSP460R3WD40M	J25
5691886	DFSP470R3WD40M	J25
5691887	DFSP480R3WD40M	J25
5691888	DFSP490R3WD40M	J25
5691889	DFSP500R3WD40M	J25
5691900	DFSP505R3WD40M	J25
5691901	DFSP510R3WD40M	J25
5691902	DFSP520R3WD40M	J25
5691903	DFSP530R3WD40M	J25
5691904	DFSP540R3WD40M	J25
5691905	DFSP550R3WD50M	J25
5692238	DFSP240R4WD32M	J26
5692239	DFSP250R4WD32M	J26–27
5692271	DFSP260R4WD32M	J26
5692272	DFSP265R4WD32M	J26
5692273	DFSP270R4WD32M	J26
5692274	DFSP280R4WD32M	J26
5692275	DFSP290R4WD32M	J26
5692277	DFSP300R4WD32M	J26
5692278	DFSP310R4WD32M	J26
5692279	DFSP320R4WD32M	J26–27
5692291	DFSP330R4WD32M	J26
5692292	DFSP340R4WD32M	J26
5692294	DFSP350R4WD32M	J26
5692295	DFSP360R4WD32M	J26
5692296	DFSP370R4WD32M	J26
5692298	DFSP375R4WD32M	J26
5692299	DFSP380R4WD32M	J26
5692300	DFSP390R4WD32M	J26
5692302	DFSP400R4WD32M	J26–27
5692303	DFSP410R4WD32M	J26
5692304	DFSP420R4WD32M	J27
5692305	DFSP430R4WD32M	J27
5692306	DFSP440R4WD32M	J27
5692307	DFSP450R4WD40M	J27
5692308	DFSP460R4WD40M	J27
5692309	DFSP470R4WD40M	J27
5692310	DFSP480R4WD40M	J27
5692311	DFSP490R4WD40M	J27
5692312	DFSP500R4WD40M	J27
5692313	DFSP510R4WD40M	J27
5692314	DFSP520R4WD40M	J27
5692315	DFSP530R4WD40M	J27
5692316	DFSP540R4WD40M	J27
5692317	DFSP550R4WD50M	J27
5692319	DFSP240R2WD32M	J22
5692320	DFSP250R2WD32M	J22–23
5692321	DFSP260R2WD32M	J22
5692322	DFSP265R2WD32M	J22
5692323	DFSP270R2WD32M	J22
5692324	DFSP280R2WD32M	J22
5692325	DFSP290R2WD32M	J22
5692326	DFSP300R2WD32M	J22
5692327	DFSP310R2WD32M	J22
5692329	DFSP320R2WD32M	J22–23
5692330	DFSP330R2WD32M	J22
5692331	DFSP340R2WD32M	J22
5692332	DFSP350R2WD32M	J22
5692333	DFSP360R2WD32M	J22
5692334	DFSP370R2WD32M	J22
5692335	DFSP375R2WD32M	J22
5692336	DFSP380R2WD32M	J22
5692337	DFSP390R2WD32M	J22
5692338	DFSP400R2WD32M	J22–23
5692339	DFSP410R2WD32M	J22
5692340	DFSP420R2WD32M	J23
5692341	DFSP430R2WD32M	J23
5692342	DFSP440R2WD32M	J23
5692343	DFSP450R2WD40M	J23
5692344	DFSP460R2WD40M	J23
5692345	DFSP470R2WD40M	J23
5692346	DFSP480R2WD40M	J23
5692347	DFSP490R2WD40M	J23
5692348	DFSP500R2WD40M	J23
5692349	DFSP505R2WD40M	J23
5692350	DFSP510R2WD40M	J23
5692351	DFSP520R2WD40M	J23
5692352	DFSP530R2WD40M	J23
5692353	DFSP540R2WD40M	J23
5692354	DFSP550R2WD50M	J23
5692727	SPGX050204HP KCU25	J89
5692728	SPGX050204MD KCU25	J89
5692729	SPGX050204HP KCU40	J89
5692800	SPGX050204MD KCU40	J89
5692801	SPGX050204HP KC7140	J89
5692802	SPGX050204MD KC7140	J89
5692803	DFTX20204HP KCU25	J87
5692804	DFTX20204MD KCU25	J87
5692805	DFTX20204HP KCU40	J87
5692806	DFTX20204MD KCU40	J87
5692807	DFTX20204HP KC7140	J87
5692808	DFTX20204MD KC7140	J87
5692809	SPHX060204R21 KCU25	J100
5692810	SPHX070304R21 KCU25	J100
5692811	SPHX090304R21 KCU25	J100
5692812	SPHX090308R21 KCU25	J100
5692813	SPHX120404R21 KCU25	J100
5694055	CCMT060204MF KCP25B	B177
5694056	CCMT060204UF KCP25B	B178
5694057	CCMT060208LF KCP25B	B177
5694058	CCMT09T304MF KCP25B	B177
5694059	CCMT120412MF KCP25B	B177
5694080	CNMG090304MN KCP25B	B50
5694081	CNMG090308MN KCP25B	B50
5694082	CNMG120404MN KCP25B	B50
5694083	CNMG120404RP KCP25B	B53
5694084	CNMG120412MW KCP25B	B52
5694085	CNMG120416MN KCP25B	B50
5694086	CNMG160608MN KCP25B	B50
5694087	CNMG160608RN KCP25B	B53
5694088	CNMG160608RP KCP25B	B53
5694090	CNMG190608MN KCP25B	B50
5694091	CNMG190608RN KCP25B	B53
5694092	CNMG190612RP KCP25B	B53
5694093	CNMG190616RP KCP25B	B53
5694094	CNMG190624RN KCP25B	B53
5694095	CNMP120404K KCP25B	B57
5694096	CNMP120408K KCP25B	B57
5694097	CPGH09T308 KCP25B	B188
5694098	CPMT060208LF KCP25B	B190
5694100	CPMT060208MF KCP25B	B190
5694101	CPMT09T304LF KCP25B	B190
5694102	DCMT070204LF KCP25B	B207
5694103	DCMT11T304MF KCP25B	B208
5694104	DCMT150404LF KCP25B	B207
5694105	DCMT150408LF KCP25B	B207
5694106	DNMG110404MN KCP25B	B78
5694107	DNMG110408MN KCP25B	B78
5694108	DNMG110408RP KCP25B	B81
5694109	DNMG110412RP KCP25B	B81
5694120	DNMG150404MN KCP25B	B78
5694121	DNMG150408RP KCP25B	B81
5694122	DNMG150604MN KCP25B	B78
5694123	DNMG150608RN KCP25B	B81
5694125	DNMP150404K KCP25B	B83
5694126	DNMP150408K KCP25B	B83
5694127	DPMT070204LF KCP25B	B215
5694128	DPMT11T304LF KCP25B	B215
5694157	RCGT0602M0RP KCP25B	B223
5694158	RCGT0803M0RP KCP25B	B223
5694170	RCMT1606M0RP KCP25B	B226
5694171	RCMX1003M0RP KCP25B	B226
5694172	SNMM250724RW KCP25B	B103
5694175	CNMM250924RW KCP25B	B56
5694176	TNMM330924MR KCP25B	B129
5694202	170.370	J23, J25, J31, J33, J35, J37
5694627	RCMT1204M0RP KCP10B	B226
5694628	RCMX1003M0RP KCP10B	B226
5694629	SNMM250724RH KCP10B	B102
5694740	SNMM250924RH KCP10B	B102
5694866	CNMG120404UN KCK15B	B54
5694867	CNMG160608UN KCK15B	B54
5694868	CNMG160612UN KCK15B	B54
5694871	CNMG190612UN KCK15B	B54
5694872	DNMG110412UN KCK15B	B82
5694873	DNMG150408UN KCK15B	B82
5694874	DNMG150608UN KCK15B	B82
5694875	DNMG150612UN KCK15B	B82
5694876	SNMG120408UN KCK15B	B102
5694877	SNMG150612UN KCK15B	B102
5694882	VNMG160408UN KCK15B	B147
5694883	WNMG080412UN KCK15B	B160
5696853	TNMP160404K KCP25B	B130
5696854	TNMP160408K KCP25B	B130
5696855	TNMP220408K KCP25B	B130
5696856	TPMT110204LF KCP25B	B255
5696857	TPMT16T304LF KCP25B	B255
5696859	VBMT110308LF KCP25B	B265
5696930	VNMG160404MN KCP25B	B145
5696931	VNMG160408RN KCP25B	B147
5696932	VNMG160412RN KCP25B	B147
5696933	VNMG220408RN KCP25B	B147
5696935	WNMG060408MN KCP25B	B157
5696936	WNMG080408MP KCP25B	B157
5696937	WPMT06T308LF KCP25B	B272

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
5696938	CNMG190624MN KCP25B	B50
5696939	SNMG190608RN KCP25B	B101
5696940	CNMP120408 KCP25B	B56
5696941	VNMG220408LF KCP25B	B144
5696942	VNMG220404LF KCP25B	B144
5697010	CCMT060204LF KCP10B	B177
5697011	CCMT120408LF KCP10B	B177
5697012	CNMM160612RP KCP10B	B56
5697013	CNMM160616RM KCP10B	B55
5697014	CNMM190616RH KCP10B	B55
5697015	CNMM190616RP KCP10B	B56
5697016	CNMM190624RH KCP10B	B55
5697017	CNMM190624RW KCP10B	B56
5697018	CPMT060204LF KCP10B	B190
5697019	DCMT11T304LF KCP10B	B207
5697020	DNMG110408FN KCP10B	B77
5697021	DNMG150404FN KCP10B	B77
5697022	DNMG150408FF KCP10B	B76
5697023	DNMG150412FN KCP10B	B77
5697027	SNMG120408FN KCP10B	B97
5697029	TNMG160404FN KCP10B	B124
5697030	TNMG160408RP KCP10B	B128
5697031	TNMG220412FN KCP10B	B124
5697032	TNMM220408RP KCP10B	B130
5697034	TPMT090204LF KCP10B	B255
5697035	VNMG160404FN KCP10B	B145
5697036	WNMG080404FN KCP10B	B155
5697037	WNMG080408FN KCP10B	B155
5697119	RCMT120400 KCP10B	B224
5697160	SCMT120408LF KCP10B	B230
5697161	SNMG120408MN KCP10B	B98
5697163	SNMG150616RP KCP10B	B101
5697164	SNMG190612RN KCP10B	B101
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5704054	KCRA50Z04S22RN12	V147
5704055	KCRA50Z06S22RN12	V147
5704056	KCRA63Z06S22RN12	V147
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5824224	4CH0400MX031A KC633M	Q27
5824225	4CH0500MR030A KC633M	Q27
5824226	4CH0600MR016A KC633M	Q27

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
5824227	4CH0600ML028A KC633M	Q27
5824228	4CH0600MX038A KC633M	Q27
5824229	4CH0800MR020A KC633M	Q27
5824230	4CH0800ML028A KC633M	Q27
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5824238	4CH1400MR032A KC633M	Q27
5824239	4CH1400ML050A KC633M	Q27
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5824241	4CH1600MR032A KC633M	Q27
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5873014	2CH0300MX025A KC633M	Q9
5873015	2CH0350MR012A KC633M	Q9
5873016	2CH0400MR012A KC633M	Q9
5873017	2CH0400ML019A KC633M	Q9
5873018	2CH0400MX031A KC633M	Q9
5873019	2CH0450MR014A KC633M	Q9
5873020	2CH0480MR014A KC633M	Q9
5873021	2CH0500MR014A KC633M	Q9
5873022	2CH0500ML020A KC633M	Q9
5873023	2CH0500MX031A KC633M	Q9
5873024	2CH0550MR014A KC633M	Q9
5873025	2CH0600MR016A KC633M	Q9
5873026	2CH0600ML028A KC633M	Q9
5873027	2CH0600MX038A KC633M	Q9
5873028	2CH0700MR020A KC633M	Q9
5873029	2CH0800MR020A KC633M	Q9
5873031	2CH0800ML028A KC633M	Q9
5873032	2CH0800MX041A KC633M	Q9
5873033	2CH0900MR020A KC633M	Q9
5873034	2CH1000MR022A KC633M	Q9
5873035	2CH1000ML032A KC633M	Q9
5873036	2CH1000MX045A KC633M	Q9
5873037	2CH1100MR025A KC633M	Q9
5873038	2CH1200MR025A KC633M	Q9
5873039	2CH1200ML045A KC633M	Q10
5873040	2CH1200MX075A KC633M	Q10
5873041	2CH1400MR032A KC633M	Q10
5873042	2CH1400ML050A KC633M	Q10
5873043	2CH1400MX075A KC633M	Q10
5873044	2CH1600MR032A KC633M	Q10
5873045	2CH1600ML056A KC633M	Q10
5873046	2CH1600MX075A KC633M	Q10
5873049	2CH1800MX075A KC633M	Q10
5873050	2CH2000MR038A KC633M	Q10
5873051	2CH2000ML056A KC633M	Q10
5873052	2CH2000MX075A KC633M	Q10
5873053	2CH1200MR025B KC633M	Q9
5873054	2CH1200ML045B KC633M	Q10
5873055	2CH1200MX075B KC633M	Q10
5873056	2CH1400MR032B KC633M	Q10
5873057	2CH1400ML050B KC633M	Q10
5873058	2CH1400MX075B KC633M	Q10
5873059	2CH1600MR032B KC633M	Q10
5873060	2CH1600ML056B KC633M	Q10
5873061	2CH1600MX075B KC633M	Q10
5873065	2CH2000MR038B KC633M	Q10
5873066	2CH2000ML056B KC633M	Q10
5873067	2CH2000MX075B KC633M	Q10
5874065	2BN0200DL006A KC633M	Q11
5874066	2BN0300DK004A KC633M	Q11
5874067	2BN0300DL007A KC633M	Q11
5874068	2BN0400DK005A KC633M	Q11
5874069	2BN0400DL008A KC633M	Q11
5874070	2BN0500DL010A KC633M	Q11
5874161	2BN0600DL010A KC633M	Q11
5874162	2BN0700DL013A KC633M	Q11
5874163	2BN0800DL016A KC633M	Q11
5874164	2BN1000DL019A KC633M	Q11
5874165	2BN1200DL022A KC633M	Q11
5874166	2BN1400DL022A KC633M	Q11
5874167	2BN1600DL026A KC633M	Q11
5874168	2BN2000DK020A KC633M	Q11
5874169	2BN2000DL032A KC633M	Q11
5874170	2BN0200DD007A KC633M	Q12
5874171	2BN0300DD007A KC633M	Q12
5874172	2BN0400DD008A KC633M	Q12
5874173	2BN0500DD010A KC633M	Q12
5874174	2BN0600DD010A KC633M	Q12
5874175	2BN0800DD016A KC633M	Q12
5874176	2BN1000DD019A KC633M	Q12
5874177	2BN1200DD022A KC633M	Q12
5874178	2BN1400DD022A KC633M	Q12
5874179	2BN1600DD026A KC633M	Q12
5874180	2BN2000DD032A KC633M	Q12
5874191	2BN0100MR004A KC633M	Q13
5874192	2BN0200MR006A KC633M	Q13
5874193	2BN0300MR009A KC633M	Q13
5874194	2BN0350MR012A KC633M	Q13
5874195	2BN0400MR012A KC633M	Q13
5874196	2BN0500MR014A KC633M	Q13
5874197	2BN0600MR038A KC633M	Q13
5874198	2BN0800MR040A KC633M	Q13
5874199	2BN1000MR045A KC633M	Q13
5874200	2BN1200MR025A KC633M	Q13
5874201	2BN1200ML045A KC633M	Q13
5874202	2BN1200MX075A KC633M	Q13
5874203	2BN1400MR032A KC633M	Q13
5874204	2BN1600MR032A KC633M	Q13
5874205	2BN2000MR038A KC633M	Q13
5874206	2BN2000ML075A KC633M	Q13
5874646	CNMM160624RP KCP10B	B56
5878707	SPGX070304MD KCPK10	J89
5879813	XNGJ0604ANENLD3W KCPM40	S12
5879814	LNPU2410ANSLHD2 KCPM40	S117
5879816	LNPU2410ANSLHD2 KCPK30	S117
5882266	CNMM250924RH KCP30B	B55
5882267	CNMG120412RN KCP30B	B53
5882268	CNMG120408MN KCP30B	B50
5882269	CNMG120408RN KCP30B	B53
5882270	WNMG080408MN KCP30B	B157
5882322	CNMG120408RP KCP30B	B53
5882323	TNMG160408MN KCP30B	B125
5882324	DNMG150408MN KCP30B	B78
5882580	DT3IP	W34–35
5882752	MS9000	W17–19, W24–25
5882754	MS5001	W12–13
5882756	MS5004	W12
5882757	MS5003	W18–19, W25
5882758	MS5002	W12
5882863	CNMG120408MP KCM35B	B51
5882865	CNMG120412RP KCM35B	B53
5882866	CNMG120408RP KCM35B	B53
5882870	CNMG120408UP KCM35B	B54
5882881	TNMG160404MP KCM35B	B125
5882884	TNMG160408MP KCM35B	B125
5882886	WNMG080408RP KCM35B	B159
5882890	WNMG060408MP KCM35B	B157
5882891	WNMG080408MP KCM35B	B157
5882892	CNMG160612RP KCM35B	B53
5882893	CNMG120404MP KCM35B	B51
5882899	DNMG150612RP KCM35B	B81
5882905	SNMG120408MP KCM35B	B98
5882906	WNMG080412RP KCM35B	B159
5882924	TCMT16T308LF KCK05B	B244
5882925	WNMG080408RP KCK05B	B159
5882934	CCMT060208LF KCK05B	B177
5882966	WNMG080408UN KCK05B	B160
5882972	CNMG120412UN KCK05B	B54
5882973	CNMA120416 KCK05B	B47
5882976	TNMG160412UN KCK05B	B128
5883000	CNMA120404 KCK05B	B47
5883011	CNMG120412FN KCK05B	B49
5883013	VNMG160408UN KCK05B	B147
5883017	SCMT09T308LF KCK05B	B230
5883018	SNMG120412UN KCK05B	B102
5883022	CNMG120416UN KCK05B	B54
5883025	WNMG080404FN KCK05B	B155
5883443	RPPT1204M0SGDX5 KCM40	V97
5883444	RPPT1204M0SGDX8 KCM40	V97
5883445	RPHT1204M0SGDX5 KCM40	V96
5883446	RPHT1204M0SGDX8 KCM40	V96
5883520	CNMG120408RP KCP05B	B53
5883573	DNMG150608MN KCP05B	B78
5883576	CNMG120408MN KCP05B	B50
5883577	DNMG150408MN KCP05B	B78
5883581	TNMG160408FN KCP05B	B124
5886541	CNMG120412RP KCP40B	B53
5886542	CNMG160612RP KCP40B	B53
5886544	SNMG190612RP KCP40B	B101
5886545	TNMG220408RP KCP40B	B128
5887614	SNMG190616RP KCPK05	B101
5892306	CNMG120408MR KCP30B	B51
5892307	DNMG150408RN KCP30B	B81
5892308	SNMG120408MN KCP30B	B98
5892411	CNMG120412MN KCP30B	B50
5892412	WNMG080408RN KCP30B	B159
5892413	CNMG160612RN KCP30B	B53
5892414	TNMG270612RN KCP30B	B127
5892415	SNMG120412RN KCP30B	B101
5892416	TNMG220408RN KCP30B	B127
5892417	CNMG190612RN KCP30B	B53
5892418	CNMG190616RN KCP30B	B53
5892419	TNMG330924RN KCP30B	B127
5892420	WNMG080412RN KCP30B	B159
5892432	CNMM120408MR KCP30B	B54
5892433	CNMG120412P KCP30B	B52
5892434	CNMG120408P KCP30B	B52
5892435	SNMG190616RN KCP30B	B101
5892436	DNMG150408MR KCP30B	B80
5892437	WNMG080408RP KCP30B	B159
5892438	TNMG270616RN KCP30B	B127
5892441	CNMM160612MR KCP30B	B54
5892442	SNMG120408RN KCP30B	B101
5892443	TNMG220412RN KCP30B	B127
5892445	SNMG190612RN KCP30B	B101
5892446	WNMG060412MN KCP30B	B157
5892447	DNMG150412MN KCP30B	B78
5892450	SNMG150616RN KCP30B	B101
5892453	CNMG120412RP KCP30B	B53
5892558	DNMG150612CT KCP05B	B76
5892560	VNMG160408MN KCP05B	B145
5892655	CNMG120408FW KCP05B	B49
5892659	DNMG110408FF KCP05B	B76
5894139	RPPT10T3M0E432X5 X500	V91
5894140	RPPT10T3M0E432X5 SC6525	V91
5894201	RPPT10T3M0E432X5 SP6519	V91
5894202	RPPT10T3M0E432X5 X700	V91
5894258	SDET120412PDSRGB KC725M	T105, T112, U51
5894812	SDET120424ENGB KC725M	T105, T112, U51

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
5894813	SDET120424SNGB KC725M	T105, T112, U51
5894815	SDET120416SNGB KC725M	T105, T112, U51
5897007	B967A16500 KC7315	G134
5903579	SNMG150612MR KCPK05	B99
5904367	CNMG160616MG KCP10B	B57
5904368	DNMG150616MG KCP10B	B80
5904369	DNMG150612MG KCP10B	B80
5910213	CPMT060208MF KCP10B	B190
5914006	SCW5E	C49
5914007	SCW8E	C49
5914680	NG3094RK KCP10B	C146
5914889	NGD4M400LK KCU25	C149
5939432	EVSML3232P0432C	C37
5939433	EVSML3232P0426C	C37
5939435	EVSML2525M0426C	C37
5939436	EVSML2525M0416C	C37
5939437	EVSML2525M0326C	C37
5939438	EVSML2525M0316C	C37
5939439	EVSML2020K0422C	C37
5939440	EVSML2020K0416C	C37
5939441	EVSML2020K0322C	C37
5939442	EVSML2020K0316C	C37
5939443	EVSMR3232P0432C	C36
5939444	EVSMR3232P0426C	C36
5939445	EVSMR2525M0426C	C36
5939446	EVSMR2525M0416C	C36
5939447	EVSMR2525M0326C	C36
5939448	EVSMR2525M0316C	C36
5939449	EVSMR2020K0422C	C36
5939450	EVSMR2020K0416C	C36
5939451	EVSMR2020K0322C	C36
5939452	EVSMR2020K0316C	C36
5940092	TPMR160304 KCP25B	B171
5940093	TPMR110304 KCP25B	B171
5941012	LNUX301940RRSM KCP10B	E52
5941056	EG0312M03U02GUP KCU25	C17
5941057	EG0312M03U04GUP KCU25	C17
5941058	EG0312M03U02GUN KCU25	C22
5941059	EG0312M03U04GUN KCU25	C22
5941071	EG0412M04U04GUP KCU25	C17
5941072	EG0412M04U04GUN KCU25	C22
5941073	EC030M03N00CF02 KCU25	C24
5941074	EC030M03L06CF02 KCU25	C24
5941075	EC030M03R06CF02 KCU25	C24
5941076	EC040M04N00CF02 KCU25	C24
5941077	EC040M04L06CF02 KCU25	C24
5941078	EC040M04R06CF02 KCU25	C24
5941079	EC030M03N00CM02 KCU25	C26
5941080	EC040M04N00CM02 KCU25	C26
5941081	EC030M03N00CR02 KCU25	C27
5941082	EC040M04N00CR02 KCU25	C27
5941083	EG0412M04U08GUP KCU25	C17
5941084	EG0412M04U08GUN KCU25	C22
5941085	EC030M03L06CM02 KCU25	C26
5941086	EC030M03R06CM02 KCU25	C26
5941087	EC040M04L06CM02 KCU25	C26
5941088	EC040M04R06CM02 KCU25	C26
5941089	EC030M03L06CR02 KCU25	C27
5941090	EC030M03R06CR02 KCU25	C27
5941091	EC040M04L06CR02 KCU25	C27
5941092	EC040M04R06CR02 KCU25	C27
5941093	EG130I03U05GUP KCU25	C19
5941094	EG130I03U1GUP KCU25	C19
5941095	EG130I03U05GUN KCU25	C23
5941096	EG130I03U1GUN KCU25	C23
5941097	EG192I04U1GUP KCU25	C19
5941098	EG192I04U1GUN KCU25	C23
5941099	EG192I04U2GUP KCU25	C19
5941100	EG192I04U2GUN KCU25	C23
5941101	EG0300M03P02GUP KCU25	C18
5941102	EG0300M03P04GUP KCU25	C18
5941103	EG0400M04P04GUP KCU25	C18
5941104	EG0400M04P08GUP KCU25	C18
5941105	EG0300M03P02GUP K313	C18
5941107	EG0300M03P04GUP K313	C18
5941108	EG0400M04P04GUP K313	C18
5941109	EG0400M04P08GUP K313	C18
5941110	EG125I03P05GUP KCU25	C20
5941111	EG125I03P1GUP KCU25	C20
5941112	EG187I04P1GUP KCU25	C20
5941113	EG187I04P2GUP KCU25	C20
5941114	EG125I03P05GUP K313	C20
5941115	EG125I03P1GUP K313	C20
5941116	EG187I04P1GUP K313	C20
5941117	EG187I04P2GUP K313	C20
5941706	EVBSN19G1B14	C49
5941707	EVBSN19G0220	C49
5941708	EVBSN26J1B15	C49
5941709	EVBSN26J0230	C49
5941710	EVBSN26M0230	C49
5941721	EVBSN26J0340	C49
5941722	EVBSN26M0340	C49
5941723	EVBSN26J0440	C49
5941724	EVBSN32M0250	C49
5941725	EVBSN32M0350	C49
5941726	EVBSN32M0450	C49
5947280	LNGU15T612SRGEM KC520M	T19
5947511	LNGU15T612SRGEM KCK15	T19
5947517	KTIP0794FEGM KCPM45	H29
5947518	KTIP2000FEGM KCPM45	H29
5949101	RCMT1204M0 KCM25B	B224
5949288	KSEM2955HPGM KC7315	H43
5949382	KSEM1600FEGM KCPM45	H54
5949383	KSEM2800FEGM KCPM45	H54
5949384	KSEM4000FEGM KCPM45	H55
5953953	EVSML2525M0226	C37
5953954	EVSML2525M0216	C37
5953955	EVSML2020K0222	C37
5953956	EVSML2020K0216	C37
5953957	EVSMR2525M0226	C36
5953958	EVSMR2525M0216	C36
5953959	EVSMR2020K0222	C36
5953960	EVSMR2020K0216	C36
5954211	EVSML4040R1040C	C38
5954212	EVSML4040R0840C	C38
5954213	EVSML4040R0640C	C38
5954214	EVSML3232P1032C	C38
5954215	EVSML3232P0832C	C38
5954216	EVSML3232P0826C	C38
5954217	EVSML3232P0632C	C38
5954218	EVSML3232P0626C	C38
5954219	EVSML3232P0532C	C37
5954220	EVSML3232P0526C	C37
5954231	EVSML2525M0826C	C38
5954232	EVSML2525M0626C	C37
5954233	EVSML2525M0616C	C37
5954234	EVSML2525M0526C	C37
5954235	EVSML2525M0516C	C37
5954236	EVSML2020K0622C	C37
5954237	EVSML2020K0616C	C37
5954238	EVSML2020K0522C	C37
5954239	EVSML2020K0516C	C37
5954240	EVSMR4040R1040C	C37
5954241	EVSMR4040R0840C	C37
5954242	EVSMR4040R0640C	C37
5954243	EVSMR3232P1032C	C37
5954244	EVSMR3232P0832C	C37
5954245	EVSMR3232P0826C	C37
5954246	EVSMR3232P0632C	C37
5954247	EVSMR3232P0626C	C37
5954248	EVSMR3232P0532C	C37
5954249	EVSMR3232P0526C	C36
5954250	EVSMR2525M0826C	C37
5954251	EVSMR2525M0626C	C37
5954252	EVSMR2525M0616C	C37
5954253	EVSMR2525M0526C	C36
5954254	EVSMR2525M0516C	C36
5954255	EVSMR2020K0622C	C37
5954256	EVSMR2020K0616C	C37
5954257	EVSMR2020K0522C	C36
5954258	EVSMR2020K0516C	C36
5954259	A16MEVEMR0307M	C46
5954260	A20QEVEMR0307M	C46
5954281	A25REVEMR0310M	C46
5954282	A25REVEMR0410M	C46
5954283	A32SEVEMR0312M	C46
5954284	A32SEVEMR0412M	C46
5954285	A16MEVEML0307M	C47
5954286	A20QEVEML0307M	C47
5954287	A25REVEML0310M	C47
5954288	A25REVEML0410M	C47
5954289	A32SEVEML0312M	C47
5954290	A32SEVEML0412M	C47
5955391	EVBSN19G1F16	C49
5955392	EVBSN26J1F17	C49
5955415	EVM50R0526MC	C50
5955416	EVM50R0532MC	C50
5955417	EVM65R0626MC	C50
5955418	EVM65R0826MC	C50
5955419	EVM50L0526MC	C51
5955420	EVM50L0532MC	C51
5955421	EVM65L0626MC	C51
5955422	EVM65L0826MC	C51
5955423	EVM50R0216M	C50
5955424	EVM50L0216M	C51
5955479	NG2M050LK KCU10	C147
5955480	NG2M050RK KCU10	C146
5955491	NG2M275LK KCU10	C147
5955492	NGD2M150LK KCU10	C149
5955493	NGD2M150RK KCU10	C149
5955494	NGD2M200RK KCU10	C149
5955495	NGD2M250LK KCU10	C149
5955496	NGD2M250RK KCU10	C149
5955498	NGD3M300LK KCU10	C149
5955499	NGD3M300RK KCU10	C149
5955500	NGD3M400LK KCU10	C149
5955502	NGD3M400RK KCU10	C149
5955505	NG2M050LK KCU25	C147
5955506	NG4M450LK KCU25	C148
5955507	NGD2M150LK KCU25	C149
5955508	NGD2M150RK KCU25	C149
5955509	NGD2M200LK KCU25	C149
5955510	NGD2M200RK KCU25	C149
5955621	NGD2M250LK KCU25	C149
5955622	NGD2M250RK KCU25	C149
5955623	NGD3M200LK KCU25	C149
5955624	NGD3M200RK KCU25	C149
5955625	NGD3M250LK KCU25	C149
5955626	NGD3M250RK KCU25	C149
5955627	NGD3M300LK KCU25	C149
5955628	NGD3M300RK KCU25	C149
5955629	NGD3M400LK KCU25	C149
5955630	NGD3M400RK KCU25	C149
5955631	NGD4M500LK KCU25	C149
5955632	NGD4M550RK KCU25	C149
5956374	UADE1200A4BV KCPM15	P17
5956375	UADE1600A4BV KCPM15	P17
5956376	UADE2000A4BV KCPM15	P17
5956377	UADE2500A4BV KCPM15	P17
5956378	UADE1200B4BV KCPM15	P17
5956379	UADE1600B4BV KCPM15	P17
5956380	UADE2000B4BV KCPM15	P17
5956421	UADE2500B4BV KCPM15	P17
5956817	M4KITD25Z02A25SGEKCPM40	T21
5956818	M4KITD32Z03A32SGEKCPM40	T21
5956819	M4KITD40Z04S16SGEKCPM40	T21
5956820	M4KITD50Z05S22SGEKCPM40	T21
5956872	M4KITD50Z06S22SGEKCPM40	T21
5956873	M4KITD63Z06S22SGEKCPM40	T21
5956874	M4KITD80Z07S27SGEKCPM40	T21
5956875	M4KITD100Z08S32SGEKCPM40	T21
5956876	M4KITD25Z02A25EGEKC725M	T21
5956877	M4KITD32Z03A32EGEKC725M	T21
5956878	M4KITD40Z04S16EGEKC725M	T21
5956879	M4KITD50Z05S22EGEKC725M	T21
5956880	M4KITD50Z06S22EGEKC725M	T21
5956891	M4KITD63Z06S22EGEKC725M	T21
5956892	M4KITD80Z07S27EGEKC725M	T21
5956893	M4KITD25Z02A25SGEMKC520M	T21
5956894	M4KITD32Z03A32SGEMKC520M	T21
5956896	M4KITD40Z04S16SGEMKC520M	T21
5956897	M4KITD50Z05S22SGEMKC520M	T21
5956898	M4KITD50Z06S22SGEMKC520M	T21
5956899	M4KITD63Z07S22SGEMKC520M	T21
5956900	M4KITD80Z09S27SGEMKC520M	T21
5956901	M4KITD100Z11S32SGEMKC520M	T21
5957724	FSDE0600A7DYA KC643M	P94
5957726	FSDE0600A7DYE KC643M	P94
5957728	FSDE0800A7DYA KC643M	P94
5957730	FSDE0800A7DYE KC643M	P94
5957772	FSDE1000A9DYE KC643M	P94
5957774	FSDE1000A9DYG KC643M	P94
5957776	FSDE1200E9DYE KC643M	P94
5957778	FSDE1200E9DYG KC643M	P94
5957780	FSDE1200E9DYL KC643M	P94
5957782	FSDE1600EBDYG KC643M	P94
5957784	FSDE1600EBDYM KC643M	P94
5957786	FSDE2000EFDYG KC643M	P94
5957788	FSDE2000EFDYK KC643M	P94
5957790	FSDE2000EFDYL KC643M	P94
5957792	FSDE2500EJDYG KC643M	P94
5964045	KSEM1250SPLM KCMS35	H52
5964046	KSEM1270SPLM KCMS35	H52
5964047	KSEM1300SPLM KCMS35	H52
5964048	KSEM1350SPLM KCMS35	H52
5964049	KSEM1400SPLM KCMS35	H52
5964050	KSEM1429SPLM KCMS35	H52
5964101	KSEM1450SPLM KCMS35	H52
5964102	KSEM1500SPLM KCMS35	H52
5964103	KSEM1550SPLM KCMS35	H52
5964104	KSEM1588SPLM KCMS35	H52
5964105	KSEM1600SPLM KCMS35	H52
5964106	KSEM1609SPLM KCMS35	H52
5964107	KSEM1615SPLM KCMS35	H52
5964108	KSEM1627SPLM KCMS35	H52
5964109	KSEM1650SPLM KCMS35	H52
5964110	KSEM1667SPLM KCMS35	H52
5964111	KSEM1700SPLM KCMS35	H52
5964112	KSEM1746SPLM KCMS35	H52
5964113	KSEM1750SPLM KCMS35	H52
5964115	KSEM1800SPLM KCMS35	H52
5964117	KSEM1850SPLM KCMS35	H52
5964119	KSEM1900SPLM KCMS35	H52
5964121	KSEM1905SPLM KCMS35	H52
5964123	KSEM1920SPLM KCMS35	H52
5964125	KSEM1923SPLM KCMS35	H52
5964127	KSEM1925SPLM KCMS35	H52
5964129	KSEM1927SPLM KCMS35	H52
5964131	KSEM1935SPLM KCMS35	H52
5964133	KSEM1945SPLM KCMS35	H52
5964135	KSEM1950SPLM KCMS35	H52
5964137	KSEM1984SPLM KCMS35	H52
5964139	KSEM2000SPLM KCMS35	H52
5964151	KSEM2050SPLM KCMS35	H52
5964153	KSEM2064SPLM KCMS35	H52
5964155	KSEM2100SPLM KCMS35	H52
5964157	KSEM2150SPLM KCMS35	H52
5964159	KSEM2200SPLM KCMS35	H52
5964161	KSEM2223SPLM KCMS35	H52
5964163	KSEM2300SPLM KCMS35	H52
5964165	KSEM2381SPLM KCMS35	H52
5964167	KSEM2400SPLM KCMS35	H52
5964169	KSEM2500SPLM KCMS35	H52
5964171	KSEM2540SPLM KCMS35	H52
5964173	KSEM2560SPLM KCMS35	H52
5964175	KSEM2565SPLM KCMS35	H52
5964177	KSEM2567SPLM KCMS35	H52
5964179	KSEM2581SPLM KCMS35	H52
5964181	KSEM2600SPLM KCMS35	H52
5964183	KSEM2619SPLM KCMS35	H52
5964184	KSEM2700SPLM KCMS35	H52
5964185	KSEM2858SPLM KCMS35	H53
5964186	KSEM3000SPLM KCMS35	H53
5964187	KSEM3175SPLM KCMS35	H53
5964188	KSEM3200SPLM KCMS35	H53
5964189	KSEM3846SPLM KCMS35	H53
5964190	KSEM4000SPLM KCMS35	H53
5964798	UADE0600A4BV KCPM15	P17
5964799	UADE0800A4BV KCPM15	P17
5964800	UADE1000A4BV KCPM15	P17
5964801	UADE0600B4BV KCPM15	P17
5964802	UADE0800B4BV KCPM15	P17
5964803	UADE1000B4BV KCPM15	P17
5964865	RPPT1204M0E432X8 X700	V97
5967744	NG2031LK KCP10B	C147
5967745	NG2031RK KCP10B	C146
5967747	NG2047LK KCP10B	C147
5967748	NG2047RK KCP10B	C146
5967749	NG2062LK KCP10B	C147
5967750	NG2062RK KCP10B	C146
5967802	NG2094LK KCP10B	C147
5967803	NG2094RK KCP10B	C146
5967804	NG2125LK KCP10B	C148
5967805	NG2125RK KCP10B	C146

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
5967806	NG2M080LK KCP10B	C147
5967807	NG2M080RK KCP10B	C146
5967808	NG2M100LK KCP10B	C147
5967810	NG2M100RK KCP10B	C146
5967821	NG2M120LK KCP10B	C147
5967822	NG2M120RK KCP10B	C146
5967823	NG2M140LK KCP10B	C147
5967825	NG2M140RK KCP10B	C146
5967826	NG2M170LK KCP10B	C147
5967827	NG2M170RK KCP10B	C146
5967828	NG2M195LK KCP10B	C147
5967829	NG2M195RK KCP10B	C146
5967830	NG2M200LK KCP10B	C147
5967831	NG2M200RK KCP10B	C146
5967832	NG2M225LK KCP10B	C147
5967833	NG2M225RK KCP10B	C146
5967834	NG2M275RK KCP10B	C146
5967835	NG2M300LK KCP10B	C148
5967836	NG2M300RK KCP10B	C146
5967837	NG3047LK KCP10B	C148
5967838	NG3047RK KCP10B	C146
5967839	NG3062RK KCP10B	C146
5967840	NG3072LK KCP10B	C148
5967841	NG3072RK KCP10B	C146
5967842	NG3078LK KCP10B	C148
5967843	NG3078RK KCP10B	C146
5967844	NG3094LK KCP10B	C148
5967845	NG3125LK KCP10B	C148
5967846	NG3125RK KCP10B	C147
5967847	NG3156LK KCP10B	C148
5967848	NG3156RK KCP10B	C147
5967849	NG3189LK KCP10B	C148
5967850	NG3189RK KCP10B	C147
5967872	NG3M120LK KCP10B	C148
5967873	NG3M120RK KCP10B	C146
5967874	NG3M225LK KCP10B	C148
5967875	NG3M225RK KCP10B	C146
5967876	NG3M275LK KCP10B	C148
5967877	NG3M275RK KCP10B	C147
5967878	NG3M300LK KCP10B	C148
5967879	NG3M300RK KCP10B	C147
5967880	NG3M400LK KCP10B	C148
5967881	NG3M400RK KCP10B	C147
5967882	NG3M425LK KCP10B	C148
5967883	NG3M425RK KCP10B	C147
5967884	NG4125LK KCP10B	C148
5967885	NG4125RK KCP10B	C147
5967886	NG4189LK KCP10B	C148
5967887	NG4189RK KCP10B	C147
5967888	NG4250LK KCP10B	C148
5967889	NG4250RK KCP10B	C147
5967891	NG4M400LK KCP10B	C148
5967892	NG4M400RK KCP10B	C147
5967893	NG4M500LK KCP10B	C148
5967894	NG4M500RK KCP10B	C147
5967943	NG2031LK KCP25B	C147
5967944	NG2031RK KCP25B	C146
5967945	NG2047LK KCP25B	C147
5967946	NG2047RK KCP25B	C146
5967947	NG2062LK KCP25B	C147
5967948	NG2062RK KCP25B	C146
5967949	NG2094LK KCP25B	C147
5967950	NG2094RK KCP25B	C146
5967991	NG2125LK KCP25B	C148
5967992	NG2125RK KCP25B	C146
5967993	NG2M050LK KCP25B	C147
5967994	NG2M050RK KCP25B	C146
5967995	NG2M080LK KCP25B	C147
5967996	NG2M080RK KCP25B	C146
5967997	NG2M100LK KCP25B	C147
5967998	NG2M100RK KCP25B	C146
5967999	NG2M120LK KCP25B	C147
5968000	NG2M120RK KCP25B	C146
5968001	NG2M140LK KCP25B	C147
5968002	NG2M140RK KCP25B	C146
5968003	NG2M150LK KCP25B	C147
5968004	NG2M150RK KCP25B	C146
5968005	NG2M170LK KCP25B	C147
5968006	NG2M170RK KCP25B	C146
5968007	NG2M175LK KCP25B	C147
5968008	NG2M175RK KCP25B	C146
5968009	NG2M195LK KCP25B	C147
5968010	NG2M195RK KCP25B	C146
5968011	NG2M200LK KCP25B	C147
5968012	NG2M200RK KCP25B	C146
5968013	NG2M220LK KCP25B	C147
5968014	NG2M220RK KCP25B	C146
5968015	NG2M225LK KCP25B	C147
5968016	NG2M225RK KCP25B	C146
5968017	NG2M250LK KCP25B	C147
5968018	NG2M250RK KCP25B	C146
5968019	NG2M275LK KCP25B	C147
5968020	NG2M275RK KCP25B	C146
5968021	NG2M300LK KCP25B	C148
5968022	NG2M300RK KCP25B	C146
5968023	NG2M320RK KCP25B	C146
5968024	NG2M325LK KCP25B	C148
5968025	NG2M325RK KCP25B	C146
5968026	NG3047LK KCP25B	C148
5968027	NG3047RK KCP25B	C146
5968028	NG3062RK KCP25B	C146
5968029	NG3072LK KCP25B	C148
5968030	NG3072RK KCP25B	C146
5968031	NG3078LK KCP25B	C148
5968032	NG3078RK KCP25B	C146
5968034	NG3094LK KCP25B	C148
5968035	NG3125LK KCP25B	C148
5968036	NG3125RK KCP25B	C147
5968037	NG3156LK KCP25B	C148
5968038	NG3156RK KCP25B	C147
5968039	NG3189LK KCP25B	C148
5968040	NG3189RK KCP25B	C147
5968041	NG3M100LK KCP25B	C148
5968042	NG3M100RK KCP25B	C146
5968043	NG3M120LK KCP25B	C148
5968044	NG3M120RK KCP25B	C146
5968045	NG3M150LK KCP25B	C148
5968047	NG3M150RK KCP25B	C146
5968048	NG3M175LK KCP25B	C148
5968049	NG3M175RK KCP25B	C146
5968050	NG3M200LK KCP25B	C148
5968051	NG3M200RK KCP25B	C146
5968052	NG3M220LK KCP25B	C148
5968053	NG3M220RK KCP25B	C146
5968054	NG3M225LK KCP25B	C148
5968055	NG3M225RK KCP25B	C146
5968056	NG3M250LK KCP25B	C148
5968057	NG3M250RK KCP25B	C146
5968058	NG3M275LK KCP25B	C148
5968059	NG3M275RK KCP25B	C147
5968060	NG3M300LK KCP25B	C148
5968061	NG3M300RK KCP25B	C147
5968062	NG3M320LK KCP25B	C148
5968063	NG3M320RK KCP25B	C147
5968064	NG3M325LK KCP25B	C148
5968065	NG3M325RK KCP25B	C147
5968066	NG3M350LK KCP25B	C148
5968067	NG3M350RK KCP25B	C147
5968068	NG3M400LK KCP25B	C148
5968069	NG3M400RK KCP25B	C147
5968071	NG3M425LK KCP25B	C148
5968072	NG3M425RK KCP25B	C147
5968073	NG3M450LK KCP25B	C148
5968074	NG3M450RK KCP25B	C147
5968075	NG4125LK KCP25B	C148
5968076	NG4125RK KCP25B	C147
5968077	NG4189LK KCP25B	C148
5968078	NG4189RK KCP25B	C147
5968079	NG4250LK KCP25B	C148
5968080	NG4250RK KCP25B	C147
5968081	NG4M300LK KCP25B	C148
5968082	NG4M300RK KCP25B	C147
5968083	NG4M320LK KCP25B	C148
5968084	NG4M350LK KCP25B	C148
5968085	NG4M350RK KCP25B	C147
5968086	NG4M400LK KCP25B	C148
5968087	NG4M400RK KCP25B	C147
5968088	NG4M450LK KCP25B	C148
5968089	NG4M450RK KCP25B	C147
5968090	NG4M500LK KCP25B	C148
5968101	NG4M500RK KCP25B	C147
5968102	NG4M550LK KCP25B	C148
5968103	NG4M550RK KCP25B	C147
5968104	NG4M600LK KCP25B	C148
5968105	NG4M600RK KCP25B	C147
5968391	KTIP0800FEGM KCPM45	H29
5968392	KTIP0850FEGM KCPM45	H29
5968393	KTIP0900FEGM KCPM45	H29
5968394	KTIP0950FEGM KCPM45	H29
5968395	KTIP1000FEGM KCPM45	H29
5968396	KTIP1050FEGM KCPM45	H29
5968397	KTIP1100FEGM KCPM45	H29
5968398	KTIP1150FEGM KCPM45	H29
5968399	KTIP1200FEGM KCPM45	H29
5968400	KTIP1250FEGM KCPM45	H29
5968401	KTIP1270FEGM KCPM45	H29
5968402	KTIP1300FEGM KCPM45	H29
5968403	KTIP1350FEGM KCPM45	H29
5968404	KTIP1400FEGM KCPM45	H29
5968405	KTIP1450FEGM KCPM45	H29
5968406	KTIP1500FEGM KCPM45	H29
5968407	KTIP1550FEGM KCPM45	H29
5968408	KTIP1600FEGM KCPM45	H29
5968409	KTIP1650FEGM KCPM45	H29
5968410	KTIP1700FEGM KCPM45	H29
5968411	KTIP1750FEGM KCPM45	H29
5968412	KTIP1800FEGM KCPM45	H29
5968413	KTIP1850FEGM KCPM45	H29
5968414	KTIP1900FEGM KCPM45	H29
5968416	KTIP1905FEGM KCPM45	H29
5968417	KTIP1950FEGM KCPM45	H29
5970180	UJBE0400A6CP KCSM15	P62
5970211	UJBE0400A6BP KCSM15	P62
5970212	UJBE0500A6CP KCSM15	P62
5970213	UJBE0500A6BP KCSM15	P62
5970214	UJBE0600A6BP KCSM15	P62
5970215	UJBE0600A6CP KCSM15	P62
5970216	UJBE0700A6BP KCSM15	P62
5970217	UJBE0700A6CP KCSM15	P62
5970218	UJBE0800A6CP KCSM15	P62
5970219	UJBE0800A6BP KCSM15	P62
5970220	UJBE1000A6CP KCSM15	P62
5970221	UJBE1000A6BP KCSM15	P62
5970234	RPPT1204M0E432X4 X700	V97
5970235	RPPT1204M0E432X4 X500	V97
5970237	RPPT1204M0E432X4 SC6525	V97
5971570	200C09RS90RC20CHP	V82
5971596	160C08RS90RC20CHP	V82
5971597	160C07RS90RC20CHP	V82
5972039	KTIP1394HPM KCP15	H27
5975092	LNEU1235R03 4 KCPM40	U19
5975093	LNEU1250R04 KCPM40	U19
5975094	LNEU1250R08 KCPM40	U19
5976169	LNPU15T612SRGE KCPM40	T19
5976170	LNGU15T608SRGEM KCPM40	T19
5976671	LNGU15T612SRGEM KCPM40	T19
5976672	LNGU15T616SRGEM KCPM40	T19
5976676	MCC0800HP	V82
5976677	MCCM160HP	V82
5976678	SDSW66	V82
5977291	LNUX301960RRP KCP10B	E48
5977292	LNUX301960RRP KCP25B	E48
5977635	EVBSN26J0540	C49
5977636	EVBSN26J0640	C49
5977637	EVBSN32M0560	C49
5977638	EVBSN32M0660	C49
5977639	EVBSN32M0860	C49
5977640	EVBSN52X06120	C49
5977721	EVBSN52X08120	C49
5979010	EVM50R0316MC	C50
5979181	EVM50R0322MC	C50
5979182	EVM50R0416MC	C50
5979183	EVM50R0422MC	C50
5979184	EVM50R0432MC	C50
5979185	EVM50L0316MC	C51
5979186	EVM50L0322MC	C51
5979187	EVM50L0416MC	C51
5979188	EVM50L0422MC	C51
5979189	EVM50L0432MC	C51
5979190	KGMSR2525M50C	C58
5979191	KGMSL2525M50C	C58
5979192	KGMER2525M50C	C59
5979193	KGMEL2525M50C	C59
5979198	EVM50R0426MC	C50
5979199	EVM50L0426MC	C51
5979200	EVM50R0312MC	C50
5979201	EVM50R0412MC	C50
5979202	EVM50L0312MC	C51
5979203	EVM50L0412MC	C51
5979745	KGMSR2525M65C	C58
5979746	KGMSR3232P50C	C58
5979747	KGMSR3232P65C	C58
5979748	KGMSL2525M65C	C58
5979749	KGMSL3232P50C	C58
5979750	KGMSL3232P65C	C58
5979765	KGMER2525M65C	C59
5979766	KGMER3232P50C	C59
5979767	KGMER3232P65C	C59
5979768	KGMEL2525M65C	C59
5979769	KGMEL3232P50C	C59
5979770	KGMEL3232P65C	C59
5979852	WNMG080408MG KCP10B	B156
5979853	WNMG080408MG KCP25B	B156
5980138	EVSCTR2525M0316C	C39
5980139	EVSCTR1616K0216	C39
5980140	EVSCTR1616K0316C	C39
5980518	A12KEVEMR1F05M	C46
5980519	A12KEVEMR0205M	C46
5980520	A16MEVEMR1F07M	C46
5980621	A16MEVEMR0207M	C46
5980622	A20QEVEMR1F07M	C46
5980623	A20QEVEMR0207M	C46
5980624	A25REVEMR0210M	C46
5980625	A12KEVEML1F05M	C47
5980626	A12KEVEML0205M	C47
5980627	A16MEVEML1F07M	C47
5980628	A16MEVEML0207M	C47
5980629	A20QEVEML1F07M	C47
5980630	A20QEVEML0207M	C47
5980631	A25REVEML0210M	C47
5980761	EVSCTR1616K0416C	C39
5980762	EVSCTR2020K0216	C39
5980763	EVSCTR2020K0316C	C39
5980764	EVSCTR2020K0326C	C39
5980765	EVSCTR2020K0416C	C39
5980766	EVSCTR2020K0426C	C39
5980767	EVSCTR2525M0216	C39
5980768	EVSCTR2525M0226	C39
5980769	EVSCTR2525M0326C	C39
5980770	EVSCTR2525M0426C	C39
5980771	EVSCTR2525M0432C	C39
5980772	EVSCTR2525M0526C	C39
5980773	EVSCTR2525M0532C	C39
5980774	EVSCTR3232P0432C	C39
5980775	EVSCTR3232P0540C	C39
5980776	EVSCTL2525M0316C	C40
5980777	EVSCTL1616K0216	C40
5980778	EVSCTL1616K0316C	C40
5980779	EVSCTL1616K0416C	C40
5980780	EVSCTL2020K0216	C40
5980801	EVSCTL2020K0316C	C40
5980802	EVSCTL2020K0326C	C40
5980803	EVSCTL2020K0416C	C40
5980804	EVSCTL2020K0426C	C40
5980805	EVSCTL2525M0216	C40
5980806	EVSCTL2525M0226	C40
5980807	EVSCTL2525M0326C	C40
5980808	EVSCTL2525M0426C	C40
5980809	EVSCTL2525M0432C	C40
5980810	EVSCTL2525M0526C	C40
5980811	EVSCTL2525M0532C	C40
5980812	EVSCTL3232P0432C	C40
5980813	EVSCTL3232P0540C	C40
5981500	KSEM1650FEGM KCPM45	H54
5981571	KSEM1700FEGM KCPM45	H54
5981572	KSEM1750FEGM KCPM45	H54
5981573	KSEM1800FEGM KCPM45	H54
5981574	KSEM1850FEGM KCPM45	H54
5981575	KSEM1900FEGM KCPM45	H54
5981576	KSEM1905FEGM KCPM45	H54
5981577	KSEM1950FEGM KCPM45	H54
5981578	KSEM2000FEGM KCPM45	H54
5981579	KSEM2050FEGM KCPM45	H54
5981580	KSEM2100FEGM KCPM45	H54
5981581	KSEM2150FEGM KCPM45	H54
5981582	KSEM2200FEGM KCPM45	H54
5981583	KSEM2250FEGM KCPM45	H54
5981584	KSEM2300FEGM KCPM45	H54

Index

Order No.	Catalogue No.	Page(s)
5981585	KSEM2350FEGM KCPM45	H54
5981586	KSEM2400FEGM KCPM45	H54
5981587	KSEM2450FEGM KCPM45	H54
5981588	KSEM2500FEGM KCPM45	H54
5981589	KSEM2540FEGM KCPM45	H54
5981591	KSEM2550FEGM KCPM45	H54
5981592	KSEM2600FEGM KCPM45	H54
5981593	KSEM2650FEGM KCPM45	H54
5981594	KSEM2700FEGM KCPM45	H54
5981595	KSEM2750FEGM KCPM45	H54
5981596	KSEM2850FEGM KCPM45	H54
5981597	KSEM2900FEGM KCPM45	H54
5981598	KSEM2950FEGM KCPM45	H54
5981599	KSEM3000FEGM KCPM45	H54
5981600	KSEM3100FEGM KCPM45	H54
5981601	KSEM3175FEGM KCPM45	H54
5981602	KSEM3200FEGM KCPM45	H54
5981603	KSEM3300FEGM KCPM45	H54
5981604	KSEM3400FEGM KCPM45	H54
5981605	KSEM3500FEGM KCPM45	H54
5981606	KSEM3600FEGM KCPM45	H55
5981607	KSEM3700FEGM KCPM45	H55
5981608	KSEM3800FEGM KCPM45	H55
5981609	KSEM3810FEGM KCPM45	H55
5981610	KSEM3900FEGM KCPM45	H55
5982089	VBMT160404MP KCP25B	B265
5984676	KSEM2670FEGM KCPM45	H54
5986819	KGIP0300N0189GD KCU45	H76
5987474	B286D03000HPS KN15	G88
5987475	B286D03100HPS KN15	G88
5987476	B286D03175HPS KN15	G88
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5988787	EG094I02P05GUP KCU25	C20
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5988812	EG375I10P3GUP KCU25	C20
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5988814	ER187I04P00GUP KCU25	C22
5988815	ER250I06P00GUP KCU25	C22
5988816	ER312I08P00GUP KCU25	C22
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5988961	EG250I06P1GUP K313	C20
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5988963	EG312I08P3GUP K313	C20
5988964	EG375I10P3GUP K313	C20
5988965	ER187I04P00GUP K313	C22
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5988967	ER312I08P00GUP K313	C22
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5989965	CNMG120408MG KCP10B	B57
5989966	CNMG120412MG KCP10B	B57
5989967	CNMG120416MG KCP10B	B57
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5990787	B285D03455HPS KN15	G88
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5990949	B285D08900HPS KN15	G89
5990950	B285D09100HPS KN15	G89
5990951	B285D09129HPS KN15	G89

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
5990952	B285D09400HPS KN15	G89
5990953	B285D09900HPS KN15	G89
5990954	B285D09921HPS KN15	G89
5990955	B285D10100HPS KN15	G89
5990956	B285D10200HPS KN15	G89
5990957	B285D10300HPS KN15	G89
5990958	B285D10320HPS KN15	G89
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5990960	B285D10716HPS KN15	G90
5990971	B285D10800HPS KN15	G90
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5991010	B285D20000HPS KN15	G90
5991410	KSEM2370HPGM KCPM45	H45
5996610	B978F12500 KC7315	G149
5999788	KM40TSKGMER50C	C61, C132
5999789	KM40TSKGMEL50C	C61, C132
5999790	KM40TSKGMSR50C	C60, C131
5999861	KM40TSKGMSL50C	C60, C131
5999862	KM50TSKGMER50C	C61, C132
5999863	KM50TSKGMEL50C	C61, C132
5999864	KM50TSKGMSR50C	C60, C131
5999865	KM50TSKGMSL50C	C60, C131
5999946	KM63TSKGMER50C	C61, C132
5999947	KM63TSKGMEL50C	C61, C132
5999948	KM63TSKGMSR50C	C60, C131
5999949	KM63TSKGMSL50C	C60, C131
5999950	KM63XMZKGMER50CY	C61, C132
5999971	KM63XMZKGMELF50CY	C61, C132
5999972	KM63XMZKGMSR50CY	C60, C131
5999973	KM63XMZKGMSLF50CY	C60, C131
6000012	KM80TSKGMER50C	C61, C132
6000013	KM80TSKGMEL50C	C61, C132
6000014	KM80TSKGMSR50C	C60, C131
6000015	KM80TSKGMSL50C	C60, C131
6000016	KM80ATCKGMER50C	C61, C132
6000017	KM80ATCKGMEL50C	C61, C132
6000018	KM80ATCKGMSR50C	C60, C131
6000019	KM80ATCKGMSL50C	C60, C131
6000026	PSC40KGMER50C	C65, C135
6000027	PSC40KGMEL50C	C65, C135
6000028	PSC40KGMSR50C	C64, C134
6000029	PSC40KGMSL50C	C64, C134
6000030	PSC50KGMER50C	C65, C135
6000151	PSC50KGMEL50C	C65, C135
6000152	PSC50KGMSR50C	C64, C134
6000153	PSC50KGMSL50C	C64, C134
6000159	PSC63KGMER50C	C65, C135
6000160	PSC63KGMEL50C	C65, C135
6000199	CNMU120612MN KCP05B	B51
6000211	PSC63KGMSR50C	C64, C134
6000213	PSC63KGMSL50C	C64, C134
6000214	PSC80KGMER50C	C65, C135
6000215	PSC80KGMEL50C	C65, C135
6000216	PSC80KGMSR50C	C64, C134
6000217	PSC80KGMSL50C	C64, C134
6000404	KM4X63KGMER50C	C63, C133
6000405	KM4X63KGMEL50C	C63, C133
6000407	KM4X63KGMSR50C	C62–63, C133
6000408	KM4X63KGMSL50C	C62–63, C133
6000410	KM50TSKGMER65C	C61, C132
6000421	KM50TSKGMEL65C	C61, C132
6000422	KM50TSKGMSR65C	C60, C131
6000424	KM50TSKGMSL65C	C60, C131
6000425	KM63TSKGMER65C	C61, C132
6000430	KM63TSKGMEL65C	C61, C132
6000431	KM63TSKGMSR65C	C60, C131
6000433	KM63TSKGMSL65C	C60, C131
6000434	KM63XMZKGMER65CY	C61, C132
6000436	KM63XMZKGMELF65CY	C61, C132
6000462	PSC63KGMER65C	C65, C135
6000463	PSC63KGMEL65C	C65, C135
6000464	PSC63KGMSR65C	C64, C134
6000465	PSC63KGMSL65C	C64, C134
6000466	PSC80KGMER65C	C65, C135
6000467	PSC80KGMEL65C	C65, C135
6000468	PSC80KGMSR65C	C64, C134
6000469	PSC80KGMSL65C	C64, C134
6001036	ONGX080620SNHB KCK15	S36
6001106	ONGX080620ENLE KC514M	S35
6001107	ONGX080620SNGP KC514M	S35
6001108	ONGX080620SNGP KCK15	S35
6001231	LNGU15T604ERGEJ KC422M	T18
6001232	LNGU15T608ERGEJ KC422M	T18
6001233	LNPU15T620SRGE KC725M	T19
6001234	LNPU15T620SRGE KCPK30	T19
6001235	LNPU15T620SRGE KCK15	T19
6001236	LNPU15T620SRGE KCPM40	T19
6001237	LNPU15T620SRGE KC522M	T19
6001244	ONGX080620SNHB KC514M	S36
6001245	ONGX080620SNHB KCPK30	S36
6001247	ONGX080620SNHB KCK20	S36
6001258	ONGX080630SNHB KC514M	S36
6001259	ONGX080630SNHB KCK15	S36
6001260	ONGX080630SNHB KCK20	S36
6001316	ONGX0806ANSNGP KC514M	S35
6001317	ONGX0806ANSNGP KCK15	S35
6001321	ONPX080608SNGP KCK15	S36
6001322	ONPX080620SNHB KCK15	S36
6001323	ONGX080608SNHB KC514M	S36
6001324	ONGX080608SNHB KCK15	S36
6001972	MILL16D050Z050N08W	S32
6001973	MILL16D063Z060N08W	S32
6001974	MILL16D080Z100N08W	S32
6001975	MILL16D100Z140N08W	S32
6001976	MILL16D125Z180N08W	S32
6001977	MILL16D160Z220N08W	S32
6001978	MILL16D200Z280N08W	S32
6002128	KCRA40Z04S22RN12	V147
6003372	B269A14600HP KCPK15	G70
6003373	B269A15200HP KCPK15	G70
6003401	B269A17600HP KCPK15	G70
6003402	B269A18600HP KCPK15	G70
6010729	XDPT090408ERD41 X500	V15
6010730	XDPT090408ERD41 SP6519	V15
6010771	XDPT090408ERD41 SC6525	V15
6010772	XDPT120508ERD41 X500	V23
6010773	XDPT120508ERD41 SP6519	V23
6010774	XDPT120508ERD41 SC6525	V23
6012527	EG0212M02U02GUN KCU10	C22
6012528	EG0251M02U02GUN KCU10	C22
6012529	EG0312M03U02GUN KCU10	C22
6012530	EG0312M03U04GUN KCU10	C22
6012651	EG063I1FU05GUN KCU10	C23
6012652	EG130I03U05GUN KCU10	C23
6012653	EG130I03U1GUN KCU10	C23
6012654	ER0312M03U00GUN KCU10	C23
6012655	ER130I03U00GUN KCU10	C24
6012656	EG0412M04U04GUN KCP10B	C22
6012657	EG0412M04U08GUN KCP10B	C22
6012658	EG192I04U1GUN KCP10B	C23
6012659	EG192I04U2GUN KCP10B	C23
6012660	EG255I06U1GUN KCP10B	C23
6012671	EG255I06U2GUN KCP10B	C23
6012672	EG0812M08U08GUN KCP10B	C22
6012673	EG0812M08U12GUN KCP10B	C22
6012674	EG0612M06U04GUN KCP10B	C22
6012675	EG317I08U3GUN KCP10B	C23
6012676	EG0512M05U04GUN KCP10B	C22
6012677	EG0512M05U08GUN KCP10B	C22
6012678	EG380I10U3GUN KCP10B	C23
6012679	EG1012M10U12GUN KCP10B	C22
6012680	ER0412M04U00GUN KCP10B	C23
6012681	ER192I04U00GUN KCP10B	C24
6012682	ER0512M05U00GUN KCP10B	C23
6012683	ER0612M06U00GUN KCP10B	C23
6012684	ER255I06U00GUN KCP10B	C24
6012685	ER317I08U00GUN KCP10B	C24
6012686	ER0812M08U00GUN KCP10B	C23
6012687	EG0200M02P02GUP KCU10	C18
6012688	EG0300M03P02GUP KCU10	C18
6012689	EG0300M03P04GUP KCU10	C18
6012690	EG0400M04P04GUP KCU10	C18
6012701	EG0400M04P08GUP KCU10	C18
6012702	EG0500M05P04GUP KCU10	C18
6012703	EG0500M05P08GUP KCU10	C18
6012704	EG0600M06P04GUP KCU10	C18
6012705	EG0600M06P08GUP KCU10	C18
6012706	EG063I1FP05GUP KCU10	C20
6012707	EG0700M06P08GUP KCU10	C18
6012708	EG0800M08P08GUP KCU10	C18
6012709	EG0800M08P12GUP KCU10	C18
6012710	EG094I02P05GUP KCU10	C20
6012711	EG1000M10P12GUP KCU10	C18
6012712	EG125I03P05GUP KCU10	C20
6012713	EG125I03P1GUP KCU10	C20
6012714	EG187I04P1GUP KCU10	C20
6012715	EG187I04P2GUP KCU10	C20
6012716	EG250I06P1GUP KCU10	C20
6012717	EG250I06P2GUP KCU10	C20
6012718	EG312I08P3GUP KCU10	C20
6012719	EG375I10P3GUP KCU10	C20
6012720	ER0300M03P00GUP KCU10	C21
6012721	ER0400M04P00GUP KCU10	C21
6012722	ER0500M05P00GUP KCU10	C21
6012723	ER0600M06P00GUP KCU10	C21
6012724	ER0800M08P00GUP KCU10	C21
6012725	ER125I03P00GUP KCU10	C22
6012726	ER187I04P00GUP KCU10	C22
6012727	ER250I06P00GUP KCU10	C22
6012728	ER312I08P00GUP KCU10	C22
6012729	EG0412M04U04GUP KCP10B	C17
6012730	EG0412M04U08GUP KCP10B	C17
6012741	EG192I04U1GUP KCP10B	C19
6012742	EG192I04U2GUP KCP10B	C19
6012743	EG255I06U1GUP KCP10B	C19
6012744	EG255I06U2GUP KCP10B	C19
6012745	EG0812M08U08GUP KCP10B	C17
6012746	EG0812M08U12GUP KCP10B	C17
6012747	EG0612M06U04GUP KCP10B	C17
6012748	EG0612M06U08GUP KCP10B	C17
6012749	EG317I08U3GUP KCP10B	C19
6012750	EG0512M05U04GUP KCP10B	C17
6012751	EG0512M05U08GUP KCP10B	C17
6012752	EG0712M06U08GUP KCP10B	C17
6012753	EG380I10U3GUP KCP10B	C19
6012754	EG1012M10U12GUP KCP10B	C17
6012755	ER0412M04U00GUP KCP10B	C20
6012756	ER192I04U00GUP KCP10B	C21
6012757	ER0512M05U00GUP KCP10B	C20
6012758	ER0612M06U00GUP KCP10B	C20
6012759	ER255I06U00GUP KCP10B	C21
6012760	ER317I08U00GUP KCP10B	C21
6012761	ER0812M08U00GUP KCP10B	C20
6012762	EG0312M03U04GUP KCP25B	C17
6012763	EG130I03U05GUP KCP25B	C19
6012764	EG130I03U1GUP KCP25B	C19
6012765	EG0212M02U02GUP KCP25B	C17
6012766	EG0251M02U02GUP KCP25B	C17
6012767	ER0312M03U00GUP KCP25B	C20
6012768	ER130I03U00GUP KCP25B	C21
6012898	EG0412M04U04GUN KCU10	C22
6012899	EG0412M04U08GUN KCU10	C22
6012900	EG0512M05U04GUN KCU10	C22
6012901	EG0512M05U08GUN KCU10	C22
6012902	EG0612M06U04GUN KCU10	C22
6012903	EG0612M06U08GUN KCU10	C22
6012904	EG0812M08U08GUN KCU10	C22
6012905	EG0812M08U12GUN KCU10	C22
6012906	EG1012M10U12GUN KCU10	C22
6012907	EG192I04U1GUN KCU10	C23
6012908	EG192I04U2GUN KCU10	C23
6012909	EG255I06U1GUN KCU10	C23
6012910	EG255I06U2GUN KCU10	C23
6012911	EG317I08U3GUN KCU10	C23
6012913	EG380I10U3GUN KCU10	C23
6012914	ER0412M04U00GUN KCU10	C23
6012915	ER0512M05U00GUN KCU10	C23
6012916	ER0612M06U00GUN KCU10	C23
6012917	ER0812M08U00GUN KCU10	C23
6012918	ER192I04U00GUN KCU10	C24
6012919	ER255I06U00GUN KCU10	C24
6012920	ER317I08U00GUN KCU10	C24
6012944	EG0412M04U04GUP KCU10	C17
6012945	EG0412M04U08GUP KCU10	C17
6012946	EG0512M05U04GUP KCU10	C17
6012947	EG0512M05U08GUP KCU10	C17
6012948	EG0612M06U04GUP KCU10	C17
6012949	EG0612M06U08GUP KCU10	C17
6012950	EG0712M06U08GUP KCU10	C17
6012961	EG0812M08U08GUP KCU10	C17
6012962	EG0812M08U12GUP KCU10	C17
6012963	EG1012M10U12GUP KCU10	C17
6012964	EG192I04U1GUP KCU10	C19
6012965	EG192I04U2GUP KCU10	C19
6012966	EG255I06U1GUP KCU10	C19
6012967	EG255I06U2GUP KCU10	C19
6012968	EG317I08U3GUP KCU10	C19
6012969	EG380I10U3GUP KCU10	C19
6012970	ER0412M04U00GUP KCU10	C20
6012971	ER0512M05U00GUP KCU10	C20
6012972	ER0612M06U00GUP KCU10	C20
6012973	ER0812M08U00GUP KCU10	C20
6012974	ER192I04U00GUP KCU10	C21
6012975	ER255I06U00GUP KCU10	C21
6012976	ER317I08U00GUP KCU10	C21
6013031	EG0212M02U02GUP KCU10	C17
6013032	EG0251M02U02GUP KCU10	C17
6013033	EG0312M03U02GUP KCU10	C17
6013034	EG0312M03U04GUP KCU10	C17
6013035	EG130I03U05GUP KCU10	C19
6013036	EG130I03U1GUP KCU10	C19
6013037	ER0312M03U00GUP KCU10	C20
6013038	ER130I03U00GUP KCU10	C21
6013040	EG0312M03U02GUN KCP10B	C22
6013061	EG0312M03U04GUN KCP10B	C22
6013062	EG130I03U05GUN KCP10B	C23
6013063	EG130I03U1GUN KCP10B	C23
6013064	EG0212M02U02GUN KCP10B	C22
6013065	EG0251M02U02GUN KCP10B	C22
6013066	EG063I1FU05GUN KCP10B	C23
6013067	ER0312M03U00GUN KCP10B	C23
6013068	ER130I03U00GUN KCP10B	C24
6013069	EG0312M03U02GUP KCP10B	C17
6013070	EG0312M03U04GUP KCP10B	C17
6013091	EG130I03U05GUP KCP10B	C19
6013092	EG130I03U1GUP KCP10B	C19
6013093	EG0212M02U02GUP KCP10B	C17
6013095	EG0251M02U02GUP KCP10B	C17
6013096	ER0312M03U00GUP KCP10B	C20
6013097	ER130I03U00GUP KCP10B	C21
6013099	EG0312M03U02GUN KCP25B	C22
6013100	EG0312M03U04GUN KCP25B	C22
6013131	EG130I03U05GUN KCP25B	C23
6013132	EG130I03U1GUN KCP25B	C23
6013133	EG0212M02U02GUN KCP25B	C22
6013134	EG0251M02U02GUN KCP25B	C22
6013135	EG063I1FU05GUN KCP25B	C23
6013136	ER0312M03U00GUN KCP25B	C23
6013137	ER130I03U00GUN KCP25B	C24
6017353	EG0312M03U02GUN KCK20B	C22
6017354	EG0312M03U04GUN KCK20B	C22

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
6017356	EG130I03U05GUN KCK20B	C23
6017357	EG130I03U1GUN KCK20B	C23
6017358	EG0212M02U02GUN KCK20B	C22
6017359	EG0251M02U02GUN KCK20B	C22
6017360	EG063I1FU05GUN KCK20B	C23
6017391	ER0312M03U00GUN KCK20B	C23
6017392	ER130I03U00GUN KCK20B	C24
6017393	EG0412M04U04GUN KCK20B	C22
6017394	EG0412M04U08GUN KCK20B	C22
6017395	EG192I04U1GUN KCK20B	C23
6017396	EG192I04U2GUN KCK20B	C23
6017397	EG255I06U1GUN KCK20B	C23
6017398	EG255I06U2GUN KCK20B	C23
6017399	EG0812M08U08GUN KCK20B	C22
6017400	EG0812M08U12GUN KCK20B	C22
6017481	EG0612M06U04GUN KCK20B	C22
6017482	EG0612M06U08GUN KCK20B	C22
6017483	EG317I08U3GUN KCK20B	C23
6017484	EG0512M05U04GUN KCK20B	C22
6017485	EG0512M05U08GUN KCK20B	C22
6017486	EG380I10U3GUN KCK20B	C23
6017487	EG1012M10U12GUN KCK20B	C22
6017488	ER0412M04U00GUN KCK20B	C23
6017489	ER192I04U00GUN KCK20B	C24
6017490	ER0512M05U00GUN KCK20B	C23
6017491	ER0612M06U00GUN KCK20B	C23
6017492	ER255I06U00GUN KCK20B	C24
6017493	ER317I08U00GUN KCK20B	C24
6017494	ER0812M08U00GUN KCK20B	C23
6017497	EC030M03L06CF02 KCM35B	C24
6017498	EC030M03R06CF02 KCM35B	C24
6017499	EC014M1BN00CF01 KCM35B	C24
6017500	EC020M02N00CF02 KCM35B	C24
6017511	EC014M1BN00CL01 KCM35B	C25
6017512	EC020M02N00CL02 KCM35B	C25
6017513	EC020M02L06CF02 KCM35B	C24
6017514	EC020M02R06CF02 KCM35B	C24
6017515	EC014M1BL06CL01 KCM35B	C25
6017516	EC014M1BR06CL01 KCM35B	C25
6017517	EC020M02L06CL02 KCM35B	C25
6017518	EC020M02R06CL02 KCM35B	C25
6017519	EC030M03L06CL02 KCM35B	C25
6017520	EC030M03R06CL02 KCM35B	C25
6017521	EC014M1BL06CF01 KCM35B	C24
6017522	EC014M1BR06CF01 KCM35B	C24
6017525	EG0412M04U04GUP KCP25B	C17
6017526	EG0412M04U08GUP KCP25B	C17
6017527	EG192I04U1GUP KCP25B	C19
6017528	EG192I04U2GUP KCP25B	C19
6017529	EG255I06U1GUP KCP25B	C19
6017530	EG255I06U2GUP KCP25B	C19
6017541	EG0812M08U08GUP KCP25B	C17
6017542	EG0812M08U12GUP KCP25B	C17
6017543	EG0612M06U04GUP KCP25B	C17
6017544	EG0612M06U08GUP KCP25B	C17
6017545	EG317I08U3GUP KCP25B	C19
6017546	EG0512M05U04GUP KCP25B	C17
6017547	EG0512M05U08GUP KCP25B	C17
6017548	EG0712M06U08GUP KCP25B	C17
6017549	EG380I10U3GUP KCP25B	C19
6017550	EG1012M10U12GUP KCP25B	C17
6017551	ER0412M04U00GUP KCP25B	C20
6017552	ER192I04U00GUP KCP25B	C21
6017553	ER0512M05U00GUP KCP25B	C20
6017555	ER0612M06U00GUP KCP25B	C20
6017556	ER255I06U00GUP KCP25B	C21
6017557	ER317I08U00GUP KCP25B	C21
6017558	ER0812M08U00GUP KCP25B	C20
6017560	EG0412M04U04GUN KCP25B	C22
6017581	EG0412M04U08GUN KCP25B	C22
6017582	EG192I04U1GUN KCP25B	C23
6017583	EG192I04U2GUN KCP25B	C23
6017584	EG255I06U1GUN KCP25B	C23
6017585	EG255I06U2GUN KCP25B	C23
6017587	EG0812M08U08GUN KCP25B	C22
6017588	EG0812M08U12GUN KCP25B	C22
6017589	EG0612M06U08GUN KCP25B	C22
6017590	EG317I08U3GUN KCP25B	C23
6017601	EG0512M05U04GUN KCP25B	C22
6017603	EG0512M05U08GUN KCP25B	C22
6017604	EG380I10U3GUN KCP25B	C23
6017605	EG1012M10U12GUN KCP25B	C22
6017606	ER0412M04U00GUN KCP25B	C23
6017607	ER192I04U00GUN KCP25B	C24
6017608	ER0512M05U00GUN KCP25B	C23
6017609	ER0612M06U00GUN KCP25B	C23
6017610	ER255I06U00GUN KCP25B	C24
6017611	ER317I08U00GUN KCP25B	C24
6017612	ER0812M08U00GUN KCP25B	C23
6017625	MILL16D250Z340N08W	S32
6017693	KM80TSKGMER65C	C61, C132
6017694	KM80TSKGMEL65C	C61, C132
6017695	KM80TSKGMSR65C	C60, C131
6017696	KM80TSKGMSL65C	C60, C131
6017697	KM80ATCKGMER65C	C61, C132
6017698	KM80ATCKGMEL65C	C61, C132
6017868	WNMG060404FW KCP05B	B156
6017935	EC040M04N00CF02 KCM35B	C24
6017936	EC040M04L06CF02 KCM35B	C24
6017937	EC040M04R06CF02 KCM35B	C24
6017938	EC040M04N00CL02 KCM35B	C25
6017939	EC030M03N00CF02 KCM35B	C24
6017940	EC030M03N00CL02 KCM35B	C25
6018001	EC050M05N00CF03 KCM35B	C24
6019340	ONGX0806ANENLE KC514M	S35
6019506	LNPU15T616SRGE KCPM40	T19
6019507	LNGU15T620SRGEM KC520M	T19
6019508	LNGU15T620SRGEM KCK15	T19
6019509	LNGU15T620SRGEM KCPK30	T19
6019510	LNGU15T620SRGEM KCPM40	T19
6020741	SDET1204PDSRGB KCSM40	T105, T112, U51
6023085	B053A01000CPG KC7325	G18
6023086	B053A01016CPG KC7325	G18
6023087	B053A01067CPG KC7325	G18
6023088	B053A01100CPG KC7325	G18
6023089	B053A01181CPG KC7325	G18
6023090	B053A01191CPG KC7325	G18
6023121	B053A01200CPG KC7325	G18
6023122	B053A01300CPG KC7325	G18
6023123	B053A01321CPG KC7325	G18
6023124	B053A01397CPG KC7325	G18
6023125	B053A01400CPG KC7325	G18
6024320	7792VXP06SA035Z6R43	V4, V6
6024361	7792VXD09SA025Z3R35	V9, V13
6024362	7792VXD09SA032Z4R43	V9, V13
6024363	7792VXD09SA035Z4R43	V9, V13
6024365	7792VXD09SA042Z5R43	V9, V13
6024366	7792VXD09CA025Z3R50	V11, V13
6024367	7792VXD09CA032Z4R70	V11, V13
6024368	7792VXD09-A050Z7R	V12–13
6024369	7792VXD09-A052Z5R	V12–13
6024370	7792VXD09-A052Z6R	V12–13
6024371	7792VXD09-A052Z7R	V12–13
6024372	7792VXD09-A063Z5R	V12–13
6024373	7792VXD09-A063Z6R	V12–13
6024374	7792VXD09-A063Z9R	V12–13
6024375	7792VXD09-A066Z5R	V12–13
6024376	7792VXD09-A066Z6R	V12–13
6024377	7792VXD09-A066Z9R	V12–13
6025272	7792VXD12-A040Z4R	V20–22
6025273	7792VXD12-A050Z6R	V20–22
6025274	7792VXD12-A052Z6R	V20–22
6025275	7792VXD12-A063Z7R	V20–22
6025276	7792VXD12-A066Z7R	V20–22
6025277	7792VXD12-A080Z10R	V20–22
6025278	7792VXD12-A100Z11R	V20–22
6025279	7792VXD12-A125Z13R	V20–22
6025280	7792VXD12SA032Z3R43	V18, V22
6025561	7792VXD12SA035Z3R43	V18, V22
6025562	7792VXD12SA042Z4R43	V18, V22
6025563	7792VXD12CA032Z3R70	V19, V22
6025614	7792VXE16-A050Z3R	V28–29
6025615	7792VXE16-A050Z4R	V28–29
6025616	7792VXE16-A052Z4R	V28–29
6025617	7792VXE16-A063Z6R	V28–29
6025618	7792VXE16-A066Z6R	V28–29
6025619	7792VXE16-A080Z7R	V28–29
6025620	7792VXE16-A100Z9R	V28–29
6025661	7792VXE16-A125Z11R	V28–29
6025662	7792VXE16-160Z13R	V28–29
6025665	DFT070408DS KCU40	J88
6025666	SPPX120408LP KCU40	J90
6025669	DFT030304DS KCU40	J88
6025670	SPPX070304LP KCU40	J90
6025821	DFTX20204DS KCU40	J88
6025822	SPGX050204LP KCU40	J90
6025823	DFT05T308DS KCU40	J88
6025824	SPPX09T308LP KCU40	J90
6025825	DFT05T308D32DS KCU40	H88
6025826	DFT05T308D33DS KCU40	H88
6025827	DFT06T308D36DS KCU40	H88
6025828	DFT06T308D39DS KCU40	H88
6025829	DFT06T308D44DS KCU40	H88
6025830	DFT070408D45DS KCU40	H88
6025891	DFT070408D50DS KCU40	H88
6025892	DFT090508D56DS KCU40	H88
6025893	DFT090508D63DS KCU40	H88
6025894	DFT090508DS KCU40	J88
6025895	DFC040310D28DS KCU40	H90
6025896	DFC05T312D32DS KCU40	H90
6025897	DFC06T312D36DS KCU40	H90
6025898	DFC070416D45DS KCU40	H90
6025899	DFC090520D56DS KCU40	H90
6026363	DFT06T308DS KCU40	J88
6026364	SPGX060304LP KCU40	J90
6026365	TPGN220408 KCP25B	B171
6026366	SPGR120308K KCP25B	B169
6026367	TPGR160308K KCP25B	B171
6027457	TPMR160308 KCP25B	B171
6030969	EVM50R0212M	C50
6030970	EVM50L0212M	C51
6031031	EVM50R0512MC	C50
6031032	EVM50L0512MC	C51
6031033	EVM50R0516MC	C50
6031034	EVM50L0516MC	C51
6031035	EVM65R0616MC	C50
6031036	EVM65L0616MC	C51
6031037	EVM65R0632MC	C50
6031038	EVM65L0632MC	C51
6031039	EVM65R0816MC	C50
6031040	EVM65L0816MC	C51
6031041	EVM50R1F12M	C50
6031042	EVM50L1F12M	C51
6031130	KTIP0852FEGM KCPM45	H29
6033254	XDPW120515SRD KCPM40	V25
6033255	XDPW120515SRD KCPK30	V25
6033256	XDPW120515SRD KC522M	V25
6033257	XDPW120515SRD KCK15	V25
6033258	XDPW120515SRD KC510M	V25
6034358	LNUX191950RRF KCP10B	E48
6034359	LNUX191950RRF KCP25B	E48
6034360	LNUX191950RRP KCP10B	E48
6034411	LNUX191950RRP KCP25B	E48
6039659	HNGJ0604ANSNHD KCPM40	S7, S12, S16
6039660	HNGJ0604ANSNHD KCK15	S7, S12, S16
6039811	HNGJ0604ANSNHD KC522M	S7, S12, S16
6039812	HNGJ0604ANSNHD KCPK30	S7, S12, S16
6039814	SNHJ120608SNGD KCPM40	S63
6039815	SNHJ120608SNGD KCPK30	S63
6039816	SNHJ120608SNGD KCK15	S63
6039817	SNHJ120608SNGD KC520M	S63
6039818	SNHJ120608SNGD KC522M	S63
6041797	KSEMP7200FDS71B1M	H86, H95
6041798	KSEMP7400FDS71B1M	H86, H95
6041799	KSEMP7600FDS71B1M	H86, H95
6041800	KSEMP7800FDS71B1M	H86, H95
6041881	KSEMP8000FDS80B1M	H86, H96
6041882	KSEMP8200FDS80B1M	H86, H96
6041883	KSEMP8400FDS80B1M	H86, H96
6041884	KSEMP8600FDS80B1M	H86, H96
6041885	KSEMP8800FDS80B1M	H86, H96
6041886	KSEMP9000FDS90B1M	H86, H96
6041887	KSEMP9200FDS90B1M	H86, H96
6041888	KSEMP9400FDS90B1M	H86, H96
6041889	KSEMP9600FDS90B1M	H86, H96
6041890	KSEMP9800FDS90B1M	H86, H96
6041901	KSEMP10000FDS90B1M	H86, H96
6041904	KSEMP7100FDS71A1M	H82, H92, H99
6041906	KSEMP7300FDS71A1M	H82, H92, H99
6041907	KSEMP7500FDS71A1M	H82, H92, H99
6041908	KSEMP7700FDS71A1M	H82, H93, H99
6041909	KSEMP7900FDS71A1M	H82, H93, H99
6041910	KSEMP8100FDS80A1M	H82, H93, H99
6041921	KSEMP8300FDS80A1M	H82, H93, H99
6041922	KSEMP8500FDS80A1M	H82, H93, H99
6041923	KSEMP8700FDS80A1M	H82, H93, H99
6041924	KSEMP8900FDS80A1M	H82, H93, H99
6041925	KSEMP9100FDS90A1M	H82, H93, H99
6041926	KSEMP9300FDS90A1M	H82, H93, H99
6041927	KSEMP9500FDS90A1M	H82, H93, H99
6041928	KSEMP9700FDS90A1M	H82, H93, H99
6041929	KSEMP9900FDS90A1M	H82, H93, H99
6041930	KSEMP10000FDS90A1M	H82, H93, H99
6041931	KSEMP7303FDS71A1M	H82, H92, H99
6041932	KSEMP7938FDS80A1M	H82, H93, H99
6041933	KSEMP8573FDS80A1M	H82, H93, H99
6041934	KSEMP9208FDS90A1M	H82, H93, H99
6041935	KSEMP9843FDS90A1M	H82, H93, H99
6041937	KSEMP7100FDS71B1M	H86, H95
6041938	KSEMP7300FDS71B1M	H86, H95
6041939	KSEMP7500FDS71B1M	H86, H95
6041940	KSEMP7700FDS71B1M	H86, H95
6041991	KSEMP7900FDS71B1M	H86, H96
6041992	KSEMP8100FDS80B1M	H86, H96
6041993	KSEMP8300FDS80B1M	H86, H96
6041994	KSEMP8500FDS80B1M	H86, H96
6041995	KSEMP8700FDS80B1M	H86, H96
6041996	KSEMP8900FDS80B1M	H86, H96
6041997	KSEMP9100FDS90B1M	H86, H96
6041998	KSEMP9300FDS90B1M	H86, H96
6041999	KSEMP9500FDS90B1M	H86, H96
6042000	KSEMP9700FDS90B1M	H86, H96
6042001	KSEMP9900FDS90B1M	H86, H96
6042002	KSEMP7303FDS71B1M	H86, H95
6042003	KSEMP7938FDS80B1M	H86, H96
6042004	KSEMP8573FDS80B1M	H86, H96
6042005	KSEMP9208FDS90B1M	H86, H96
6042006	KSEMP9843FDS90B1M	H86, H96
6042982	KSDR100031E0W4S KD1400	S127
6042983	KSDR100031E0W4S KD1425	S127
6042984	KSDR100031E1W4S KD1400	S127
6042985	KSDR100031E1W4S KD1425	S127
6042986	KSDR100031E3W4S KD1400	S128
6042987	KSDR100031E3W4S KD1425	S128
6042988	KSDR100093E1W4S KD1400	S127
6042989	KSDR100093E1W4S KD1425	S127
6042990	KSDR102S KD1400	S128
6043031	KSDR102S KD1425	S128
6044682	KBDM063SD06	S126
6044683	KBDM080SD08	S126
6044684	KBDM100SD12	S126
6044685	KBDM125SD16	S126
6044686	KBDM160SD18	S126
6044687	KBDM200SD24	S126
6044824	LNGU15T608SRGEH KCSM40	T20
6048710	KSEM2554HPGM KC7315	H43
6049015	WLJNR32CA19S	E49
6049016	WLJNL32CA19S	E49
6049017	WLJNR32CA30S	E49
6049018	WLJNL32CA30S	E49
6054192	KSCMA90UNBF KD1400	S134
6054193	KSCMA90UNBF KD1420	S134

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
6054194	KSCMA90QFBF KD1400	S134
6054195	KSCMA90QFBF KD1420	S134
6055137	RMR14000H7SF KCU05	K15
6055138	RMR15000H7SF KCU05	K15
6055139	RMR16000H7SF KCU05	K15
6055140	RMR17000H7SF KCU05	K15
6055148	CNMM190616MR KCP25B	B54
6055261	RMR18000H7SF KCU05	K15
6055262	RMR19000H7SF KCU05	K15
6055263	RMR20000H7SF KCU05	K15
6055264	RMR14000H7HF KCU05	K16
6055265	RMR15000H7HF KCU05	K16
6055266	RMR16000H7HF KCU05	K16
6055267	RMR17000H7HF KCU05	K16
6055268	RMR18000H7HF KCU05	K16
6055270	RMR19000H7HF KCU05	K16
6055271	RMR20000H7HF KCU05	K16
6055272	RHR14000KST115H7SF KCU05	K27
6055273	RHR15000KST115H7SF KCU05	K27
6055274	RHR16000KST135H7SF KCU05	K27
6055275	RHR17000KST135H7SF KCU05	K27
6055276	RHR18000KST155H7SF KCU05	K27
6055277	RHR19000KST155H7SF KCU05	K27
6055278	RHR20000KST175H7SF KCU05	K27
6055279	RHR21000KST175H7SF KCU05	K27
6055280	RHR22000KST175H7SF KCU05	K27
6055281	RHR23000KST200H7SF KCU05	K27
6055282	RHR24000KST200H7SF KCU05	K27
6055283	RHR25000KST200H7SF KCU05	K27
6055284	RHR26000KST200H7SF KCU05	K27
6055285	RHR27000KST200H7SF KCU05	K27
6055287	RHR28000KST250H7SF KCU05	K27
6055288	RHR29000KST250H7SF KCU05	K27
6055289	RHR30000KST250H7SF KCU05	K27
6055290	RHR31000KST250H7SF KCU05	K27
6055291	RHR32000KST250H7SF KCU05	K27
6055292	RHR33000KST300H7SF KCU05	K27
6055293	RHR34000KST300H7SF KCU05	K27
6055294	RHR35000KST300H7SF KCU05	K27
6055295	RHR36000KST300H7SF KCU05	K27
6055296	RHR37000KST300H7SF KCU05	K27
6055297	RHR38000KST350H7SF KCU05	K27
6055298	RHR39000KST350H7SF KCU05	K27
6055299	RHR40000KST350H7SF KCU05	K27
6055300	RHR41000KST350H7SF KCU05	K27
6055301	RHR42000KST350H7SF KCU05	K27
6055302	RHR14000KST115H7HF KCU05	K28
6055303	RHR15000KST115H7HF KCU05	K28
6055304	RHR16000KST135H7HF KCU05	K28
6055305	RHR17000KST135H7HF KCU05	K28
6055306	RHR18000KST155H7HF KCU05	K28
6055307	RHR19000KST155H7HF KCU05	K28
6055308	RHR20000KST175H7HF KCU05	K28
6055309	RHR21000KST175H7HF KCU05	K28
6055310	RHR22000KST175H7HF KCU05	K28
6055311	RHR23000KST200H7HF KCU05	K28
6055312	RHR24000KST200H7HF KCU05	K28
6055313	RHR25000KST200H7HF KCU05	K28
6055314	RHR26000KST200H7HF KCU05	K28
6055315	RHR27000KST200H7HF KCU05	K28
6055316	RHR28000KST250H7HF KCU05	K28
6055317	RHR29000KST250H7HF KCU05	K28
6055318	RHR30000KST250H7HF KCU05	K28
6055319	RHR31000KST250H7HF KCU05	K28
6055320	RHR32000KST250H7HF KCU05	K28
6055321	RHR33000KST300H7HF KCU05	K28
6055322	RHR34000KST300H7HF KCU05	K28
6055323	RHR35000KST300H7HF KCU05	K28
6055324	RHR36000KST300H7HF KCU05	K28
6055325	RHR37000KST300H7HF KCU05	K28
6055326	RHR38000KST350H7HF KCU05	K28
6055327	RHR39000KST350H7HF KCU05	K28
6055328	RHR40000KST350H7HF KCU05	K28
6055329	RHR41000KST350H7HF KCU05	K28
6055330	RHR42000KST350H7HF KCU05	K28
6055505	SNMG120404MN KCP10B	B98
6056569	B256A11900YPC KCK10	G60
6056600	HDWM5EUS	S126
6059086	T877G01250-28R-D56 KSP39	M78
6059087	T877G01250-28R-D56 KSU31	M78
6059088	T877G02500-19R-D56 KSP39	M78
6059089	T877G02500-19R-D56 KSU31	M78
6059090	T877G03750-19R-D56 KSP39	M78
6059101	T877G03750-19R-D56 KSU31	M78
6059102	T877G05000-14R-D56 KSP39	M78
6059103	T877G05000-14R-D56 KSU31	M78
6059104	T877G06250-14R-D56 KSP39	M78
6059105	T877G06250-14R-D56 KSU31	M78
6059106	T877G07500-14R-D56 KSP39	M78
6059107	T877G07500-14R-D56 KSU31	M78
6059108	T877G08750-14R-D56 KSP39	M78
6059109	T877G08750-14R-D56 KSU31	M78
6059110	T877G10000-11R-D56 KSP39	M78
6059111	T877G10000-11R-D56 KSU31	M78
6059167	T857G01250-28R-D56 KSP39	M78
6059168	T857G01250-28R-D56 KSU31	M78
6059169	T857G02500-19R-D56 KSP39	M78
6059170	T857G02500-19R-D56 KSU31	M78
6059171	T857G03750-19R-D56 KSP39	M78
6059172	T857G03750-19R-D56 KSU31	M78
6059173	T857G05000-14R-D56 KSP39	M78
6059174	T857G05000-14R-D56 KSU31	M78
6059175	T857G06250-14R-D56 KSP39	M78
6059176	T857G06250-14R-D56 KSU31	M78
6059177	T857G07500-14R-D56 KSP39	M78
6059178	T857G07500-14R-D56 KSU31	M78
6059179	T857G08750-14R-D56 KSP39	M78
6059180	T857G08750-14R-D56 KSU31	M78
6059181	T857G10000-11R-D56 KSP39	M78
6059182	T857G10000-11R-D56 KSU31	M78
6059288	T848NPT00625-27R-D56 KSU30	M79
6059289	T848NPT01250-27R-D56 KSU30	M79
6059290	T848NPT02500-18R-D56 KSU30	M79
6059321	T848NPT03750-18R-D56 KSU30	M79
6059322	T848NPT05000-14R-D56 KSU30	M79
6059323	T848NPT07500-14R-D56 KSU30	M79
6059324	T848NPT10000-11,5R-D56 KSU30	M79
6059325	T848NPTF00625-27R-D56 KSU30	M79
6059328	T848NPTF01250-27R-D56 KSU30	M79
6059329	T848NPTF02500-18R-D56 KSU30	M79
6059341	T848NPTF03750-18R-D56 KSU30	M79
6059342	T848NPTF05000-14R-D56 KSU30	M79
6059343	T848NPTF07500-14R-D56 KSU30	M79
6059344	T848NPTF10000-11,5R-D56 KSU30	M79
6063443	UDDE1600A5ARP KC643M	P32
6063444	UDDE2000A5ARP KC643M	P32
6063445	UDDE2500A5ARP KC643M	P32
6063446	UJDE1600A6AQP KCSM15	P49
6063447	UJDE2000A6AQP KCSM15	P49
6063448	UJDE2500A6AQP KCSM15	P49
6063449	UGDE1600A5BRP KC643M	P37
6063450	UGDE2000A5BRP KC643M	P37
6063471	UGDE2500A5BRP KC643M	P37
6063599	FSDE1600EBDYL KC643M	P94
6063661	FSDE1600EBDYP KC643M	P94
6063663	FSDE2000EFDYP KC643M	P94
6063665	FSDE2500EJDYL KC643M	P94
6063667	FSDE2500EJDYP KC643M	P94
6064367	KTIP1080FEGM KCPM45	H29
6064575	F4AS1600AWX38R600 KCPM15	P18
6064576	F4AS2000AWX38R600 KCPM15	P18
6064577	F4AS2500AWX38R600 KCPM15	P18
6064578	F4AS1600BWX38R600 KCPM15	P18
6064579	F4AS2000BWX38R600 KCPM15	P18
6064580	F4AS2500BWX38R600 KCPM15	P18
6064691	UBDE1600E4AQP KCSM15	P18
6064692	UBDE2000E4AQP KCSM15	P18
6064693	UBDE2500E4AQP KCSM15	P18
6064694	UDDE1600B5ARP KC643M	P32
6064695	UDDE2000B5ARP KC643M	P32
6064696	UDDE2500B5ARP KC643M	P32
6064697	UDDE1600E5AQP KCSM15	P32
6064698	UDDE2000E5AQP KCSM15	P32
6064699	UDDE2500E5AQP KCSM15	P32
6064700	UGDE1600A5ARP KC643M	P36
6064701	UGDE2000A5ARP KC643M	P36
6064702	UGDE2500A5ARP KC643M	P36
6065059	RPPT1204M0SGDX4 KCM40	V97
6066131	ABDE1200A3ARL K600	P112
6066132	ABDE1600A3ARL K600	P113
6066133	F2AA1200AWL45R250 K600	P120
6066134	F2AA1600AWX45R250 K600	P120
6068043	HNGJ090543ANSNHD KCPM40	S19, S23
6068798	HNPJ060432ANSNHD KCPM40	S7, S13, S16
6069649	KTIP1490FEGM KCPM45	H29
6072110	UKDV1000X4CV KCPM15	08
6072161	UKDV1200X4CV KCPM15	08
6072162	UKDV1600X4CV KCPM15	08
6072163	UKDV2000X4CV KCPM15	08
6072164	UKDV2500X4CV KCPM15	08
6072165	UKDV3200X4CV KCPM15	08
6072166	ULDV1000X4CQE KCSM15	09
6072167	ULDV1000X4CQG KCSM15	09
6072168	ULDV1000X4CQJ KCSM15	09
6072169	ULDV1200X4CQE KCSM15	09
6072170	ULDV1200X4CQG KCSM15	09
6072181	ULDV1200X4CQJ KCSM15	09
6072182	ULDV1200X4CQL KCSM15	09
6072183	ULDV1600X4CQG KCSM15	09
6072184	ULDV1600X4CQJ KCSM15	09
6072185	ULDV1600X4CQK KCSM15	09
6072186	ULDV1600X4CQL KCSM15	09
6072187	ULDV1600X4CQM KCSM15	09
6072188	ULDV2000X4CQG KCSM15	09
6072189	ULDV2000X4CQK KCSM15	09
6072190	ULDV2000X4CQL KCSM15	09
6072191	ULDV2000X4CQM KCSM15	09
6072192	ULDV2000X4CQN KCSM15	09
6072193	ULDV2500X4CQL KCSM15	09
6072194	ULDV2500X4CQN KCSM15	09
6072195	ULDV3200X4CQL KCSM15	09
6072196	ULDV3200X4CQN KCSM15	09
6072386	UJBV1000X6CN KCSM15	019
6072387	UJBV1200X6CN KCSM15	019
6072388	UJBV1600X6CN KCSM15	019
6072389	UJBV2000X6CN KCSM15	019
6072390	UJBV2500X6CN KCSM15	019
6072411	UKBV1000X4CN KCPM15	018
6072412	UKBV1200X4CN KCPM15	018
6072413	UKBV1600X4CN KCPM15	018
6072414	UKBV2000X4CN KCPM15	018
6072415	UKBV2500X4CN KCPM15	018
6072442	UJDV1000X6CQE KCSM15	016
6072443	UJDV1000X6CQG KCSM15	016
6072444	UJDV1000X6CQJ KCSM15	016
6072445	UJDV1200X6CQE KCSM15	016
6072446	UJDV1200X6CQG KCSM15	016
6072447	UJDV1200X6CQJ KCSM15	016
6072448	UJDV1200X6CQL KCSM15	016
6072449	UJDV1600X6CQG KCSM15	016
6072450	UJDV1600X6CQJ KCSM15	016
6072481	UCDV1000X5CV KCPM15	012
6072482	UCDV1200X5CV KCPM15	012
6072483	UCDV1600X5CV KCPM15	012
6072484	UCDV2000X5CV KCPM15	012
6072485	UCDV2500X5CV KCPM15	012
6072486	UCDV3200X5CV KCPM15	012
6072487	UDDV1000X5CQE KC643M	013
6072488	UDDV1000X5CQG KC643M	013
6072489	UDDV1000X5CQJ KC643M	013
6072491	UDDV1200X5CQE KC643M	013
6072492	UDDV1200X5CQG KC643M	013
6072493	UDDV1200X5CQJ KC643M	013
6072494	UDDV1200X5CQL KC643M	013
6072495	UDDV1600X5CQG KC643M	013
6072496	UDDV1600X5CQJ KC643M	013
6072497	UDDV1600X5CQK KC643M	013
6072498	UDDV1600X5CQL KC643M	013
6072499	UDDV1600X5CQM KC643M	013
6072500	UDDV2000X5CQG KC643M	013
6072501	UDDV2000X5CQK KC643M	013
6072502	UDDV2000X5CQL KC643M	013
6072503	UDDV2000X5CQM KC643M	013
6072504	UDDV2000X5CQN KC643M	013
6072505	UDDV2500X5CQL KC643M	013
6072506	UDDV2500X5CQN KC643M	013
6072507	UDDV3200X5CQL KC643M	013
6072508	UDDV3200X5CQN KC643M	013
6072561	UJDV1600X6CQK KCSM15	016
6072562	UJDV1600X6CQL KCSM15	016
6072563	UJDV1600X6CQM KCSM15	016
6072564	UJDV2000X6CQG KCSM15	016
6072565	UJDV2000X6CQK KCSM15	016
6072566	UJDV2000X6CQL KCSM15	016
6072567	UJDV2000X6CQM KCSM15	016
6072568	UJDV2000X6CQN KCSM15	016
6072569	UJDV2500X6CQL KCSM15	016
6072570	UJDV2500X6CQN KCSM15	016
6072571	UJDV3200X6CQL KCSM15	016
6072572	UJDV3200X6CQN KCSM15	016
6074027	XDPT120515SRGP KCPM40	V24
6074028	XDPT120515SRGP KCPK30	V24
6074029	XDPT120515SRGP KC725M	V24
6074030	XDPT120515SRGP KC522M	V24
6075455	DFSP140R2WB20M	J30
6075456	DFSP145R2WB20M	J30
6075457	DFSP150R2WB20M	J30
6075458	DFSP155R2WB20M	J30
6075459	DFSP160R2WB20M	J30
6075460	DFSP165R2WB20M	J30
6075491	DFSP170R2WB20M	J30–31
6075492	DFSP175R2WB25M	J30
6075493	DFSP180R2WB25M	J30
6075494	DFSP185R2WB25M	J30
6075495	DFSP190R2WB25M	J30
6075496	DFSP195R2WB25M	J30
6075497	DFSP200R2WB25M	J30
6075498	DFSP205R2WB25M	J30
6075499	DFSP209R2WB25M	J30
6075500	DFSP210R2WB25M	J30
6075501	DFSP215R2WB25M	J30–31
6075502	DFSP220R2WB25M	J30
6075503	DFSP225R2WB25M	J30
6075504	DFSP230R2WB25M	J30
6075505	DFSP235R2WB25M	J30
6075506	DFSP239R2WB25M	J30
6075507	DFSP240R2WB25M	J30
6075508	DFSP245R2WB25M	J30
6075610	DFSP140R3WB20M	J32
6075631	DFSP145R3WB20M	J32
6075632	DFSP150R3WB20M	J32
6075633	DFSP155R3WB20M	J32
6075634	DFSP160R3WB20M	J32
6075635	DFSP165R3WB20M	J32
6075636	DFSP170R3WB20M	J32–33
6075637	DFSP175R3WB25M	J32
6075638	DFSP180R3WB25M	J32
6075639	DFSP185R3WB25M	J32
6075640	DFSP190R3WB25M	J32
6075651	DFSP195R3WB25M	J32
6075652	DFSP200R3WB25M	J32
6075653	DFSP205R3WB25M	J32
6075654	DFSP209R3WB25M	J32
6075655	DFSP210R3WB25M	J32
6075656	DFSP215R3WB25M	J32–33
6075657	DFSP220R3WB25M	J32
6075658	DFSP225R3WB25M	J32
6075659	DFSP230R3WB25M	J32
6075660	DFSP235R3WB25M	J32
6075671	DFSP239R3WB25M	J32
6075672	DFSP240R3WB25M	J32
6075673	DFSP245R3WB25M	J32
6075677	DFSP140R4WB20M	J34
6075678	DFSP145R4WB20M	J34
6075679	DFSP150R4WB20M	J34
6075680	DFSP155R4WB20M	J34
6075712	DFSP140R5WB20M	J36
6075713	DFSP145R5WB20M	J36
6075714	DFSP150R5WB20M	J36
6075715	DFSP155R5WB20M	J36
6075716	DFSP160R5WB20M	J36
6075718	DFSP165R5WB20M	J36
6075719	DFSP170R5WB20M	J36–37
6075720	DFSP175R5WB25M	J36
6075721	DFSP160R4WB20M	J34
6075722	DFSP165R4WB20M	J34
6075723	DFSP170R4WB20M	J34–35
6075724	DFSP175R4WB25M	J34

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
6075725	DFSP180R4WB25M	J34
6075726	DFSP185R4WB25M	J34
6075727	DFSP190R4WB25M	J34
6075728	DFSP195R4WB25M	J34
6075729	DFSP200R4WB25M	J34
6075741	DFSP205R4WB25M	J34
6075742	DFSP209R4WB25M	J34
6075743	DFSP210R4WB25M	J34
6075744	DFSP215R4WB25M	J34–35
6075745	DFSP220R4WB25M	J34
6075746	DFSP225R4WB25M	J34
6075747	DFSP230R4WB25M	J34
6075748	DFSP235R4WB25M	J34
6075749	DFSP239R4WB25M	J34
6075750	DFSP240R4WB25M	J34
6075751	DFSP245R4WB25M	J34
6075752	DFSP140R4WD20M	J26
6075753	DFSP145R4WD20M	J26
6075754	DFSP150R4WD20M	J26
6075755	DFSP155R4WD20M	J26
6075756	DFSP160R4WD20M	J26
6075757	DFSP165R4WD20M	J26
6075758	DFSP170R4WD20M	J26–27
6075761	DFSP180R5WB25M	J36
6075762	DFSP185R5WB25M	J36
6075763	DFSP190R5WB25M	J36
6075764	DFSP195R5WB25M	J36
6075765	DFSP200R5WB25M	J36
6075766	DFSP205R5WB25M	J36
6075767	DFSP209R5WB25M	J36
6075768	DFSP210R5WB25M	J36
6075769	DFSP215R5WB25M	J36–37
6075770	DFSP220R5WB25M	J36
6075781	DFSP225R5WB25M	J36
6075782	DFSP230R5WB25M	J36
6075783	DFSP235R5WB25M	J36
6075784	DFSP239R5WB25M	J36
6075787	DFSP240R5WB25M	J36
6075788	DFSP245R5WB25M	J36
6076012	SDET1204PDERGB KCSM40	T105, T112, U51
6079223	EVM65R0620A060075C	C53
6079224	EVM65R0620A075100C	C53
6079225	EVM65R0620A100180C	C53
6079226	EVM65R0620A180250C	C53
6079227	EVM65R0620A250350C	C53
6079228	EVM65R0620A350999C	C53
6079229	EVM65R0820A080180C	C53
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6079234	EVM65L0620A060075C	C54
6079235	EVM65L0620A075100C	C54
6079236	EVM65L0620A100180C	C54
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6079238	EVM65L0620A250350C	C54
6079239	EVM65L0620A350999C	C54
6079240	EVM65L0820A080180C	C54
6079241	EVM65L0820A180999C	C54
6079246	EVM65R0620B060075C	C56
6079247	EVM65R0620B075100C	C56
6079248	EVM65R0620B100180C	C56
6079249	EVM65R0620B180250C	C56
6079250	EVM65R0620B250350C	C56
6079261	EVM65R0620B350999C	C56
6079262	EVM65R0820B080180C	C56
6079263	EVM65R0820B180999C	C56
6079266	EVM65L0620B060075C	C57
6079267	EVM65L0620B075100C	C57
6079268	EVM65L0620B100180C	C57
6079269	EVM65L0620B180250C	C57
6079270	EVM65L0620B250350C	C57
6079271	EVM65L0620B350999C	C57
6079272	EVM65L0820B080180C	C57
6079273	EVM65L0820B180999C	C57
6079340	EVM50R0312B035040C	C55
6079411	EVM50R0312B040050C	C55
6079412	EVM50R0312B050060C	C55
6079413	EVM50R0312B060075C	C55
6079414	EVM50R0320B075100C	C55
6079415	EVM50R0320B100180C	C55
6079416	EVM50R0320B180250C	C55
6079417	EVM50R0320B250350C	C55
6079418	EVM50R0320B350999C	C55
6079420	EVM50L0312B035040C	C56
6079421	EVM50L0312B040050C	C56
6079422	EVM50L0312B050060C	C56
6079423	EVM50L0312B060075C	C56
6079424	EVM50L0320B075100C	C56
6079425	EVM50L0320B100180C	C56
6079426	EVM50L0320B180250C	C56
6079427	EVM50L0320B250350C	C56
6079428	EVM50L0320B350999C	C56
6079429	EVM50R0416B040050C	C55
6079430	EVM50R0416B050060C	C55
6079451	EVM50R0416B060075C	C55
6079452	EVM50R0416B075100C	C55
6079453	EVM50R0426B100180C	C55
6079454	EVM50R0426B180250C	C56
6079455	EVM50R0426B250350C	C56
6079456	EVM50R0426B350999C	C56
6079457	EVM50R0520B050060C	C56
6079458	EVM50R0520B060075C	C56
6079459	EVM50R0520B075100C	C56
6079460	EVM50R0520B100180C	C56
6079461	EVM50R0520B180250C	C56
6079462	EVM50R0520B250350C	C56
6079463	EVM50R0520B350999C	C56
6079464	EVM50L0416B040050C	C56
6079465	EVM50L0416B050060C	C56
6079466	EVM50L0416B060075C	C56
6079467	EVM50L0416B075100C	C56
6079468	EVM50L0426B100180C	C56
6079469	EVM50L0426B180250C	C56
6079470	EVM50L0426B250350C	C56
6079471	EVM50L0426B350999C	C57
6079472	EVM50L0520B050060C	C57
6079473	EVM50L0520B060075C	C57
6079474	EVM50L0520B075100C	C57
6079475	EVM50L0520B100180C	C57
6079476	EVM50L0520B180250C	C57
6079477	EVM50L0520B250350C	C57
6079478	EVM50L0520B350999C	C57
6079480	EVM50R0416A040050C	C52
6079481	EVM50R0416A050060C	C52
6079482	EVM50R0416A060075C	C52
6079483	EVM50R0416A075100C	C52
6079484	EVM50R0426A100180C	C52
6079485	EVM50R0426A180250C	C53
6079486	EVM50R0426A250350C	C53
6079487	EVM50R0426A350999C	C53
6079488	EVM50R0520A050060C	C53
6079489	EVM50R0520A060075C	C53
6079490	EVM50R0520A075100C	C53
6079491	EVM50R0520A100180C	C53
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6079493	EVM50R0520A250350C	C53
6079494	EVM50R0520A350999C	C53
6079495	EVM50L0416A040050C	C53
6079496	EVM50L0416A050060C	C53
6079497	EVM50L0416A060075C	C53
6079498	EVM50L0416A075100C	C53
6079499	EVM50L0426A100180C	C53
6079500	EVM50L0426A180250C	C53
6079501	EVM50L0426A250350C	C53
6079502	EVM50L0426A350999C	C54
6079503	EVM50L0520A050060C	C54
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6079507	EVM50L0520A180250C	C54
6079508	EVM50L0520A250350C	C54
6079509	EVM50L0520A350999C	C54
6079778	DFR125R2WB20M	J13
6079779	DFR127R2WB20M	J13
6079780	DFR130R2WB20M	J13
6079879	DFSP250R4WB25M	J34
6079880	DFSP255R4WB25M	J34–35
6079881	DFR135R2WB20M	J13
6079882	DFR140R2WB20M	J13
6079883	DFR145R2WB20M	J13
6079884	DFR150R2WB20M	J13
6079885	DFR155R2WB20M	J13
6079886	DFR160R2WB20M	J13
6079887	DFR165R2WB20M	J13
6079888	DFR170R2WB20M	J13
6079889	DFR125R3WB20M	J14
6079890	DFR127R3WB20M	J14
6079891	DFR130R3WB20M	J14
6079892	DFR135R3WB20M	J14
6079893	DFR140R3WB20M	J14
6079894	DFR145R3WB20M	J14
6079895	DFR150R3WB20M	J14
6079896	DFR155R3WB20M	J14
6079897	DFR160R3WB20M	J14
6079898	DFR165R3WB20M	J14
6079899	DFR170R3WB20M	J14
6079900	DFR125R4WB20M	J15
6079901	DFR127R4WB20M	J15
6079902	DFR130R4WB20M	J15
6079903	DFR135R4WB20M	J15
6079904	DFR140R4WB20M	J15
6079905	DFR145R4WB20M	J15
6079906	DFR150R4WB20M	J15
6079907	DFR155R4WB20M	J15
6079908	DFR160R4WB20M	J15
6079909	DFR165R4WB20M	J15
6079910	DFR170R4WB20M	J15
6079913	DFSP250R2WB25M	J30
6079914	DFSP255R2WB25M	J30–31
6079915	DFSP260R2WB32M	J30
6079916	DFSP264R2WB32M	J30
6079917	DFSP265R2WB32M	J30
6079918	DFSP270R2WB32M	J30
6079919	DFSP280R2WB32M	J30
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6079931	DFSP294R2WB32M	J30
6079932	DFSP300R2WB32M	J30
6079933	DFSP310R2WB40M	J30
6079934	DFSP320R2WB40M	J30–31
6079935	DFSP330R2WB40M	J31
6079936	DFSP340R2WB40M	J31
6079937	DFSP350R2WB40M	J31
6079938	DFSP360R2WB40M	J31
6079940	DFSP370R2WB40M	J31
6079941	DFSP380R2WB40M	J31
6079942	DFSP390R2WB40M	J31
6079943	DFSP400R2WB40M	J31
6079944	DFSP250R3WB25M	J32
6079945	DFSP255R3WB25M	J32–33
6079946	DFSP260R3WB32M	J32
6079947	DFSP264R3WB32M	J32
6079948	DFSP265R3WB32M	J32
6079949	DFSP270R3WB32M	J32
6079950	DFSP280R3WB32M	J32
6079961	DFSP290R3WB32M	J32
6079962	DFSP294R3WB32M	J33
6079963	DFSP300R3WB32M	J33
6079964	DFSP310R3WB40M	J33
6079965	DFSP320R3WB40M	J33
6079966	DFSP330R3WB40M	J33
6079967	DFSP340R3WB40M	J33
6079968	DFSP350R3WB40M	J33
6079969	DFSP360R3WB40M	J33
6079970	DFSP370R3WB40M	J33
6079971	DFSP380R3WB40M	J33
6079972	DFSP390R3WB40M	J33
6079973	DFSP400R3WB40M	J33
6079991	DFSP260R4WB32M	J34
6079992	DFSP264R4WB32M	J34
6079993	DFSP265R4WB32M	J34
6079994	DFSP270R4WB32M	J34
6079995	DFSP280R4WB32M	J34
6079996	DFSP290R4WB32M	J34
6079997	DFSP294R4WB32M	J35
6079998	DFSP300R4WB32M	J35
6079999	DFSP310R4WB40M	J35
6080000	DFSP320R4WB40M	J35
6080001	DFSP330R4WB40M	J35
6080002	DFSP340R4WB40M	J35
6080003	DFSP350R4WB40M	J35
6080004	DFSP360R4WB40M	J35
6080005	DFSP370R4WB40M	J35
6080006	DFSP380R4WB40M	J35
6080007	DFSP390R4WB40M	J35
6080008	DFSP400R4WB40M	J35
6080031	EVSBR2020K0312035040C	C43
6080033	EVSBR2020K0416040050C	C43
6080035	EVSBR2525M05160500060C	C43
6080037	EVSBL2020K0312035040C	C44
6080038	EVSBL2020K0416040050C	C44
6080039	EVSBL2525M05160500060C	C45
6080040	EVSBR2020K0416050060C	C43
6080051	EVSBL2020K0416050060C	C44
6080053	EVSBR2525M0320060075C	C43
6080054	EVSBL2525M0320060075C	C44
6080055	EVSBR2525M0320075100C	C43
6080056	EVSBL2525M0320075100C	C44
6080057	EVSBR2525M0320100180C	C43
6080059	EVSBL2525M0320100180C	C44
6080060	EVSBR2525M0320180250C	C43
6080061	EVSBL2525M0320180250C	C44
6080067	EVSBR2525M0312100180C	C43
6080068	EVSBL2525M0312100180C	C44
6080069	EVSBR2525M0312180250C	C43
6080070	EVSBL2525M0312180250C	C44
6080194	DFSP250R5WB25M	J36
6080195	DFSP255R5WB25M	J36–37
6080196	DFSP260R5WB32M	J36
6080197	DFSP264R5WB32M	J36
6080198	DFSP265R5WB32M	J36
6080199	DFSP270R5WB32M	J36
6080200	DFSP280R5WB32M	J36
6080391	DFSP290R5WB32M	J36
6080392	DFSP294R5WB32M	J37
6080393	DFSP300R5WB32M	J37
6080394	DFSP310R5WB40M	J37
6080395	DFSP320R5WB40M	J37
6080396	DFSP330R5WB40M	J37
6080397	DFSP340R5WB40M	J37
6080398	DFSP350R5WB40M	J37
6080399	DFSP360R5WB40M	J37
6080400	DFSP370R5WB40M	J37
6080411	DFSP380R5WB40M	J37
6080412	DFSP390R5WB40M	J37
6080413	DFSP400R5WB40M	J37
6082135	CNGN090408T02020 KBK45	B284
6082136	CNGN090412S02020 KBK45	B284
6082137	CNGN120408T02020 KBK45	B284
6082138	CNGN120412S02020 KBK45	B284
6082139	CNGN120416S02020 KBK45	B284
6082140	CNGX120408T02020 KBK45	B287
6082231	CNGX120412S02020 KBK45	B287
6082232	CNGX120416S02020 KBK45	B287
6082233	RNGN090400S02020 KBK45	B284
6082234	RNGN120400S02020 KBK45	B284
6082235	RNGX120400S02020 KBK45	B287
6082236	RCGN090400T01015 KBK45	B288
6082237	DNGN120408S02020 KBK45	B284
6082238	DNGN120412S02020 KBK45	B284
6082239	SNGN090408S01015WCB KBK45	B285
6082240	SNGN090408S01015WCC KBK45	B285
6082241	SCGN090408S01015WCB KBK45	B288
6082242	SCGN090408S01015WCC KBK45	B288
6082243	SNGN120408T02020 KBK45	B285
6082244	SNGN120412S02020 KBK45	B285
6082245	SNGN120416S02020 KBK45	B285
6082246	SNGX120408T02020 KBK45	B287
6082247	SNGX120412S02020 KBK45	B287
6082248	SNGX120416S02020 KBK45	B287
6082249	TNGN110416S02020 KBK45	B286
6082250	TNGN160416S02020 KBK45	B286
6082261	TNGX160416S02020 KBK45	B288
6083010	B269A02400KMG KCPK15	G68
6083071	B269A02500KMG KCPK15	G68
6083072	B269A02600KMG KCPK15	G68
6083073	B269A02800KMG KCPK15	G68
6083074	B269A02900KMG KCPK15	G68
6083075	B269A03400HP KCPK15	G68
6083076	B269A04100HP KCPK15	G68
6083077	B269A06400HP KCPK15	G69
6083078	B707A04200FBS KN15	G114
6083079	B707A04900FBS KN15	G114
6083097	VCGR160408 KCP25B	E34
6087904	5720VZ16HA025Z2R75	T89
6088510	TPUN220412 KCK15B	B171

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
6088651	KCGR110308L08 KCM15B	E29
6088652	VCMR160404 KCM15B	E33
6088653	VCMR160408 KCM15B	E33
6091572	SALS063S	S126
6097181	EVM50R0312A035040C	C52
6097182	EVM50R0312A040050C	C52
6097183	EVM50R0312A050060C	C52
6097184	EVM50R0312A060075C	C52
6097185	EVM50R0320A075100C	C52
6097186	EVM50R0320A100180C	C52
6097187	EVM50R0320A180250C	C52
6097188	EVM50R0320A250350C	C52
6097189	EVM50R0320A350999C	C52
6097190	EVM50L0312A035040C	C53
6097191	EVM50L0312A040050C	C53
6097192	EVM50L0312A050060C	C53
6097193	EVM50L0312A060075C	C53
6097194	EVM50L0320A075100C	C53
6097195	EVM50L0320A100180C	C53
6097196	EVM50L0320A180250C	C53
6097197	EVM50L0320A250350C	C53
6097198	EVM50L0320A350999C	C53
6098863	B978F17500 KC7315	G149
6102279	LNPU221012PNSLHD2 KCPM40	S121, S123
6103457	TNMG160408MG KCP10B	B126
6104860	KSEM2835HPGM KCPM45	H46
6105048	TNMG160408CT KCPK05	B123
6105085	CPGH09T304 KCP25B	B188
6105089	CNMP160608 KCP25B	B56
6105091	CNMU120412RN KCP10B	B53
6105093	SPUN120312 KCP25B	B169
6105094	SPUN120308 KCP25B	B169
6105095	SPUN120304 KCP25B	B169
6105099	TPUN160304 KCP25B	B171
6105100	TPUN220408 KCP25B	B171
6105101	TPMR220408 KCP25B	B171
6105102	TPMR110308 KCP25B	B171
6105103	TPUN160308 KCP25B	B171
6105104	TPUN220412 KCP25B	B171
6108706	SNMG120416MG KCP25B	B99
6109122	SDCT120464ENLD2 KCSM40	T104, T111, U51
6109124	SDET120464SNGB KCSM40	T105, T112, U51
6109130	SDET120424ENGB KCSM40	T105, T112, U51
6109210	KTIP1595FEGM KCPM45	H29
6109265	SDET120424SNGB KCSM40	T105, T112, U51
6111468	OFKT06L5AFENGB KCPM40	S50
6111469	OFKT07L6AFENGB KCPM40	S55
6111470	OFKT07L6AFSNHB KCPM40	S55
6111671	SDET120412PDERGB KCPM40	T105, T112, U51
6111672	SDET120412PDERGB2 KCPM40	T104, T111, U52
6111673	SDET120420SNGB2 KCPM40	T104, T111, U52
6111674	SDET1204PDSRGB2 KCPM40	T104, T111, U52
6111676	SEKT1404AEENGP2 KCPM40	S42
6111677	SEKT1404AESNGP2 KCPM40	S42
6116297	A32SEVSAR0312M033042	C48
6116298	A32SEVSAL0312M033042	C48
6116299	A40TEVSAR0312M041050	C48
6116300	A40TEVSAL0312M041050	C48
6116521	A25REVSAR0212M026030	C48
6116522	A25REVSAR0312M030035	C48
6116527	A25REVSAL0212M026030	C48
6116528	A25REVSAL0312M030035	C48
6116561	EVSBR2020K0312040050C	C43
6116562	EVSBL2020K0312040050C	C44
6116563	EVSBR2020K0312050060C	C43
6116564	EVSBL2020K0312050060C	C44
6116567	EVSBR2020K0312060075C	C43
6116568	EVSBL2020K0312060075C	C44
6116569	EVSBR2020K0312075100C	C43
6116570	EVSBL2020K0312075100C	C44
6116571	EVSBR2020K0416060075C	C43
6116572	EVSBL2020K0416060075C	C44
6116573	EVSBR2020K0416075100C	C43
6116574	EVSBL2020K0416075100C	C44
6116575	EVSBR2525M0426060075C	C43
6116576	EVSBL2525M0426060075C	C44
6116577	EVSBR2525M0426075100C	C43
6116578	EVSBL2525M0426075100C	C44
6116579	EVSBR2525M0426100180C	C43
6116580	EVSBL2525M0426100180C	C45
6116581	EVSBR2525M0426180250C	C43
6116582	EVSBL2525M0426180250C	C45
6116587	EVSBR2525M0416100180C	C43
6116588	EVSBL2525M0416100180C	C44
6116589	EVSBR2525M0416180250C	C43
6116590	EVSBL2525M0416180250C	C44
6116789	EVM50R0312A075100C	C52
6116790	EVM50L0312A075100C	C53
6117023	KSEM3115HPGM KCPM45	H46
6117061	EVM50R0312B075100C	C55
6117062	EVM50L0312B075100C	C56
6117063	EVM50R0312A100180C	C52
6117064	EVM50L0312A100180C	C53
6117065	EVM50R0312B100180C	C55
6117066	EVM50L0312B100180C	C56
6117067	EVM50R0312A180250C	C52
6117068	EVM50L0312A180250C	C53
6117069	EVM50R0312B180250C	C55
6117070	EVM50L0312B180250C	C56
6117071	EVM50R0312A250350C	C52
6117072	EVM50L0312A250350C	C53
6117073	EVM50R0312B250350C	C55
6117074	EVM50L0312B250350C	C56
6117075	EVM50R0312A350999C	C52
6117076	EVM50L0312A350999C	C53
6117077	EVM50R0312B350999C	C55
6117078	EVM50L0312B350999C	C56
6117079	EVM50R0416A100180C	C52
6117080	EVM50L0416A100180C	C53
6117091	EVM50R0416B100180C	C55
6117092	EVM50L0416B100180C	C56
6117093	EVM50R0416A180250C	C52
6117094	EVM50L0416A180250C	C53
6117095	EVM50R0416B180250C	C55
6117096	EVM50L0416B180250C	C56
6117097	EVM50R0416A250350C	C52
6117098	EVM50L0416A250350C	C53
6117099	EVM50R0416B250350C	C55
6117100	EVM50L0416B250350C	C56
6117101	EVM50R0416A350999C	C52
6117102	EVM50L0416A350999C	C53
6117103	EVM50R0416B350999C	C55
6117104	EVM50L0416B350999C	C56
6117419	CNMU120616MN KCP25B	B51
6117573	DNMM150612RP KCP10B	B83
6123362	KSEM3450FEGM KCPM45	H54
6123525	KTIP080R12SS10M	H31
6123526	KTIP085R12SS10M	H31
6123527	KTIP090R12SS10M	H31
6123528	KTIP095R12SS10M	H31
6123529	KTIP100R12SS12M	H31
6123530	KTIP105R12SS12M	H31
6123570	WD32FDS28076M	H102
6123571	WD32FDS32082M	H102
6123572	WD32FDS36092M	H102
6123573	WD50FDS40100M	H102
6123575	WD50FDS45112M	H102
6123576	WD50FDS50122M	H102
6123577	WD50FDS56140M	H102
6123578	WD50FDS63154M	H102
6123579	WD50FDS71172M	H102
6123580	WD50FDS80192M	H102
6123581	WD50FDS90212M	H102
6123601	KTIP110R12SS12M	H31
6123602	KTIP115R12SS12M	H31
6123603	KTIP120R12SS14M	H31
6123604	KTIP125R12SS14M	H31
6123605	KTIP130R12SS14M	H31
6123607	KTIP135R12SS14M	H31
6123608	KTIP140R12SS16M	H31
6123609	KTIP145R12SS16M	H31
6123610	KTIP150R12SS16M	H31
6123611	KTIP160R12SS18M	H31
6123612	KTIP170R12SS18M	H31
6123613	KTIP180R12SS20M	H31
6123614	KTIP190R12SS20M	H31
6123615	KTIP200R12SS25M	H31
6123616	KTIP210R12SS25M	H31
6123617	KTIP220R12SS25M	H31
6123618	KTIP230R12SS25M	H31
6123619	KTIP240R12SS25M	H31
6123620	KTIP250R12SS32M	H31
6123621	KTIP260R12SS32M	H31
6123622	KTIP270R12SS32M	H31
6123704	KSEM321R3WD40M	H60
6123705	KSEM330R3WD40M	H60
6123706	KSEM340R3WD40M	H60
6123707	KSEM350R3WD40M	H60
6123708	KSEM360R3WD40M	H60
6123709	KSEM361R3WD40M	H60
6123710	KSEM370R3WD40M	H60
6123741	KSEM380R3WD40M	H60
6123742	KSEM390R3WD40M	H60
6123743	KSEM400R3WD40M	H60
6123744	KSEM321R5WD40M	H60
6123745	KSEM330R5WD40M	H60
6123746	KSEM340R5WD40M	H60
6123747	KSEM350R5WD40M	H60
6123748	KSEM360R5WD40M	H60
6123749	KSEM361R5WD40M	H60
6123750	KSEM370R5WD40M	H60
6123751	KSEM380R5WD40M	H60
6123752	KSEM390R5WD40M	H60
6123753	KSEM400R5WD40M	H60
6124198	EVSBR2525M0526050060C	C44
6124199	EVSBL2525M0526050060C	C45
6124200	EVSBR2525M0516060075C	C43
6124211	EVSBL2525M0516060075C	C45
6124212	EVSBR2525M0526060075C	C44
6124213	EVSBL2525M0526060075C	C45
6124214	EVSBR2525M0516075100C	C44
6124215	EVSBL2525M0516075100C	C45
6124216	EVSBR2525M0526075100C	C44
6124217	EVSBL2525M0526075100C	C45
6124218	EVSBR2525M0516100180C	C44
6124219	EVSBL2525M0516100180C	C45
6124222	EVSBR2525M0516180250C	C44
6124223	EVSBL2525M0516180250C	C45
6124226	EVSBR2525M0516250350C	C44
6124227	EVSBL2525M0516250350C	C45
6124230	EVSBR2525M0516350999C	C44
6124232	EVSBL2525M0516350999C	C45
6124235	EVSBR3232P0532100180C	C44
6124236	EVSBL3232P0532100180C	C45
6124237	EVSBR3232P0532180250C	C44
6124238	EVSBL3232P0532180250C	C45
6124239	EVSBR3232P0532250350C	C44
6124240	EVSBL3232P0532250350C	C45
6124241	EVSBR3232P0532350999C	C44
6124242	EVSBL3232P0532350999C	C45
6124605	EVSBR2525M0616060075C	C44
6124606	EVSBL2525M0616060075C	C45
6124607	EVSBR2525M0626060075C	C44
6124608	EVSBL2525M0626060075C	C45
6124609	EVSBR2525M0616075100C	C44
6124610	EVSBL2525M0616075100C	C45
6124671	EVSBR2525M0626075100C	C44
6124672	EVSBL2525M0626075100C	C45
6124673	EVSBR2525M0616100180C	C44
6124674	EVSBL2525M0616100180C	C45
6124677	EVSBR2525M0616180250C	C44
6124678	EVSBL2525M0616180250C	C45
6124681	EVSBR2525M0616250350C	C44
6124682	EVSBL2525M0616250350C	C45
6124685	EVSBR2525M0616350999C	C44
6124686	EVSBL2525M0616350999C	C45
6124689	EVSBR3232P0632100180C	C44
6124690	EVSBL3232P0632100180C	C45
6124691	EVSBR3232P0632180250C	C44
6124692	EVSBL3232P0632180250C	C45
6124693	EVSBR3232P0632250350C	C44
6124694	EVSBL3232P0632250350C	C45
6124695	EVSBR3232P0632350999C	C44
6124696	EVSBL3232P0632350999C	C45
6125373	B271Z15300HPG KCPK20	G75
6126887	RQBB1000X4CN KCPM15	O36
6126888	RQBB1200X4CN KCPM15	O36
6126889	RQBB1600X4CN KCPM15	O36
6126890	RQBB2000X4CN KCPM15	O36
6126911	RQBB2500X4CN KCPM15	O36
6126912	RKDF1000X4CQE KCSM15	O35
6126913	RKDF1200X4CQF KCSM15	O35
6126914	RKDF1600X6CQF KCSM15	O35
6126915	RKDF2000X6CQF KCSM15	O35
6126916	RKDF2500X6CQF KCSM15	O35
6127040	FSDE1000X9CQE KC643M	O43
6127071	FSDE1000X9CQG KC643M	O43
6127072	FSDE1000X9CQJ KC643M	O43
6127073	FSDE1200X9CQE KC643M	O43
6127074	FSDE1200X9CQG KC643M	O43
6127075	FSDE1200X9CQJ KC643M	O43
6127076	FSDE1200X9CQL KC643M	O43
6127077	FSDE1600XBCQG KC643M	O43
6127078	FSDE1600XBCQJ KC643M	O43
6127079	FSDE1600XBCQK KC643M	O43
6127080	FSDE1600XBCQL KC643M	O43
6127081	FSDE1600XBCQM KC643M	O43
6127082	FSDE2000XFCQG KC643M	O43
6127083	FSDE2000XFCQK KC643M	O43
6127084	FSDE2000XFCQL KC643M	O43
6127085	FSDE2000XFCQM KC643M	O43
6127086	FSDE2000XFCQN KC643M	O43
6127087	FSDE2500XJCQL KC643M	O43
6127088	FSDE2500XJCQN KC643M	O43
6127198	FMDF1000X6CQE KCPM15	O42
6127199	FMDF1200X6CQF KCPM15	O42
6127200	FMDF1600X6CQF KCPM15	O42
6127286	RQDB1000X4CV KCPM15	O34
6127287	RQDB1200X4CV KCPM15	O34
6127288	RQDB1600X4CV KCPM15	O34
6127289	RQDB2000X4CV KCPM15	O34
6127290	RQDB2500X5CV KCPM15	O34
6127311	FMDF2000X6CQF KCPM15	O42
6127312	FMDF2500X6CQF KCPM15	O42
6127382	XRDA1000X4CHJ KCPM15	O49
6127383	XRDA1000X4CRM KCPM15	O49
6127384	XRDA1200X5CRG KCPM15	O49
6127385	XRDA1200X5CRK KCPM15	O49
6127386	XRDA1200X5CRM KCPM15	O49
6127387	XRDA1600X6CRK KCPM15	O49
6127388	XRDA1600X6CRM KCPM15	O49
6127389	XRDA1600X6CRN KCPM15	O49
6127404	XADA1000X4CH45 KCPM15	O48
6127405	XADA1200X5CH45 KCPM15	O48
6127406	XADA1600X6CH45 KCPM15	O48
6127885	EDPT10T304PDSRGE KCPM40	T36
6127886	EDPT10T308PDSRGE KCPM40	T36
6127887	EDPT10T312PDERHD KCPM40	T36
6127888	EDPT10T316PDERHD KCPM40	T36
6127889	EDPT10T320PDERHD KCPM40	T36
6128132	EDPT140404PDERHD KCPM40	T53, T62
6128133	EDPT140408PDSRGD KCPM40	T54, T63
6128134	EDPT140416PDERHD KCPM40	T53, T62
6128135	EDPT140416PDSRGD KCPM40	T54, T63
6128136	EDPT140424PDERHD KCPM40	T53, T62
6128137	EDCT180504PDERGD KCPM40	T74
6128138	EDCT180508PDERGD KCPM40	T74
6128139	EDCT180512PDERGD KCPM40	T74
6128780	KTIP1770FEGM KCPM45	H29
6130644	SEPT1404AEENGB2 KCPM40	S43
6130645	SEPT1404AESNGB2 KCPM40	S43
6130740	UADE0400A4BV KCPM15	P17
6130871	UADE0400B4BV KCPM15	P17
6130874	UADE0500A4BV KCPM15	P17
6130875	UADE0500B4BV KCPM15	P17
6130878	UADE1400A4BV KCPM15	P17

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
6130879	UADE1400B4BV KCPM15	P17
6131423	LNGU110412SRGEM KCK15	T9
6131424	LNGU110412SRGEM KCPK30	T9
6131425	LNGU110412SRGEM KC520M	T9
6131426	LNGU110412SRGEM KCPM40	T9
6131428	LNPU110412SRGE KC522M	T9
6131429	LNPU110412SRGE KCPM40	T9
6131430	LNPU110412SRGE KC725M	T9
6131502	LNPU110408SRGE KC522M	T9
6131503	LNPU110408SRGE KCPM40	T9
6131504	LNPU110408SRGE KC725M	T9
6131505	LNPU110408SRGE KCPK30	T9
6131506	LNPU110408SRGE KC520M	T9
6131507	LNPU110408SRGE KCK15	T9
6131511	LNPU110412SRGE KCPK30	T9
6131512	LNPU110412SRGE KC520M	T9
6131513	LNPU110412SRGE KCK15	T9
6131514	LNGU110404ERGE KC725M	T8
6131515	LNGU110404ERGE KC522M	T8
6131516	LNGU110404ERGE KCPM40	T8
6131541	LNGU110408ERGE KC725M	T8
6131542	LNGU110408ERGE KC522M	T8
6131543	LNGU110408ERGE KCPM40	T8
6131544	LNGU110408ERGE KCSM30	T8
6131556	LNGU110408ERLEJ KC422M	T8
6131557	LNPU110416SRGE KC522M	T9
6131558	LNPU110416SRGE KCPM40	T9
6131559	LNPU110416SRGE KC725M	T9
6131560	LNPU110416SRGE KCPK30	T9
6131601	LNPU110416SRGE KC520M	T9
6131602	LNGU110408SRGEM KCK15	T9
6131603	LNGU110408SRGEM KCPK30	T9
6131604	LNGU110408SRGEM KC520M	T9
6131605	LNGU110408SRGEM KC522M	T9
6131606	LNGU110408SRGEM KCPM40	T9
6131627	M4D016Z02A16LN11L090	T6, T11
6131628	M4D016Z02B16LN11	T5
6131629	M4D020Z02A20LN11L150	T6
6131630	M4D020Z02B20LN11	T5, T11
6131681	M4D020Z03A20LN11L090	T6, T11
6131682	M4D020Z03M10LN11	T4
6131683	M4D025Z03A25LN11L170	T6
6131684	M4D025Z03B25LN11	T5, T11
6131685	M4D025Z04A25LN11L100	T6, T11
6131686	M4D025Z04M12LN11	T4
6132022	LNGU110408SRGE KC522M	T9
6132023	LNGU110408SRGE KCPM40	T9
6132024	LNGU110408SRGE KC725M	T9
6132025	LNGU110408SRGE KCPK30	T9
6132026	LNGU110408SRGE KCK15	T9
6132452	KSEM3750SPLM KCMS35	H53
6133107	B976F15400 KC7315	G145
6133656	KSEM2950SPLM KCMS35	H53
6134054	MILL16D080Z080N08W	S32
6134055	MILL16D100Z100N08W	S32
6134056	MILL16D125Z140N08W	S32
6134057	MILL16D160Z160N08W	S32
6134058	MILL16D200Z200N08W	S32
6134059	MILL16D250Z240N08W	S32
6134184	M4D032Z04A32LN11L200	T6
6134185	M4D032Z04B32LN11	T5, T11
6134186	M4D032Z05A32LN11L110	T6, T11
6134187	M4D032Z06M16LN11	T4
6134188	M4D040Z04S16LN11	T7, T11
6134189	M4D040Z06S16LN11	T7, T11
6134190	M4D050Z05S22LN11	T7, T11
6134231	M4D050Z07S22LN11	T7, T11
6134232	M4D063Z06S22LN11	T7
6134233	M4D063Z09S22LN11	T7, T11
6134234	M4D080Z08S27LN11	T7
6134889	SS10SLDL10055M	056
6134890	SS10DL10100M	057
6135041	SS12SLDL10065M	056
6135042	SS12DL10120M	057
6135043	SS12SLDL12065M	056
6135044	SS12DL12120M	057
6135045	SS16SLDL10090M	056
6135046	SS16DL10160M	057
6135047	SS16SLDL12080M	056
6135048	SS16DL12160M	057
6135049	SS16SLDL16070M	056
6135050	SS16DL16160M	057
6135051	SS20SLDL10115M	056
6135052	SS20DL10200M	057
6135053	SS20SLDL12105M	056
6135054	SS20DL12200M	057
6135055	SS20SLDL16080M	056
6135056	SS20DL16200M	057
6135057	SS20SLDL20080M	056
6135058	SS20DL20200M	057
6135059	SS25SLDL16115M	056
6135060	SS25DL16250M	057
6135061	SS25SLDL20095M	056
6135062	SS25DL20250M	057
6135063	SS25SLDL25090M	056
6135064	SS25DL25250M	057
6135065	SS32SLDL25105M	056
6135066	SS32DL25250M	057
6135067	SS32SLDL32105M	056
6135068	SS32DL32250M	057
6135069	SS40SLDL32140M	056
6135070	SS40DL32250M	057
6135081	SS50SLDL32200M	056
6135082	SS50DL32250M	057
6135413	TWDLTM	058
6135414	TWTMINSERTDL10	058
6135415	TWTMINSERTDL12	058
6135416	TWTMINSERTDL16	058
6135417	TWTMINSERTDL20	058
6135418	TWTMINSERTDL25	058
6135419	TWTMINSERTDL32	058
6135420	TWTMINSERTDL10W	058
6135421	TWTMINSERTDL12W	058
6135422	TWTMEXT	058
6135423	TWTMBC	058
6136737	M4D016Z02A16LN11L150	T6
6136738	M4D016Z02M08LN11	T4
6136739	M4D020Z03A20LN11L150	T6
6136740	M4D020Z03B20LN11	T5
6136780	TCMT16T312LF KCP10B	B244
6136791	M4D025Z04A25LN11L170	T6
6136792	M4D032Z05A32LN11L200	T6
6136793	M4D032Z05M16LN11	T4
6136794	M4D040Z05A32LN11L200	T6
6136795	M4D040Z05B32LN11	T5
6136796	M4D040Z07S16LN11	T7
6136797	M4D050Z09S22LN11	T7
6136798	M4D080Z10S27LN11	T7
6136949	HSK63ADL10048M	052
6136950	HSK63ADL12052M	052
6136951	HSK63ADL16057M	052
6136952	HSK63ADL20057M	052
6136953	HSK63ADL25061M	052
6136954	HSK63ADL32072M	052
6136955	PSC63DL10050M	052
6136956	PSC63DL12050M	052
6136957	PSC63DL16055M	052
6136958	PSC63DL20055M	052
6136959	PSC63DL25060M	052
6136960	PSC63DL32068M	052
6136971	CV40BDL10041M	053
6136972	CV40BDL12041M	053
6136973	CV40BDL16050M	053
6136974	CV40BDL20050M	053
6136975	CV40BDL25056M	053
6136976	CV40BDL32065M	053
6136977	BT40BDL10049M	053
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6136979	BT40BDL16058M	053
6136980	BT40BDL20058M	053
6136991	BT40BDL25060M	053
6136992	BT40BDL32068M	053
6136993	DV40BDL10041M	054
6136994	DV40BDL12041M	054
6136995	DV40BDL16050M	054
6136996	DV40BDL20050M	054
6136997	DV40BDL25056M	054
6136998	DV40BDL32065M	054
6137128	DNMG110408FP KCPK05	B77
6137163	DNMG110404FP KCPK05	B77
6140064	HNEC0905ANSN KY3500	S24
6143985	3CH0300MX019A KC633M	Q20
6143986	3CH0400MX019A KC633M	Q20
6143987	3CH0500MX020A KC633M	Q20
6143988	3CH0600MX028A KC633M	Q20
6143989	3CH0800MX028A KC633M	Q20
6143990	3CH1000MX032A KC633M	Q20
6144061	3CH1200MX045A KC633M	Q20
6144062	3CH1600MX056A KC633M	Q20
6144063	3CH2000MX064A KC633M	Q20
6144064	3CH0300MX019B KC633M	Q20
6144066	3CH0500MX020B KC633M	Q20
6144067	3CH0600MX028B KC633M	Q20
6144068	3CH0800MX028B KC633M	Q20
6144069	3CH1000MX032B KC633M	Q20
6144070	3CH1200MX045B KC633M	Q20
6144071	3CH1600MX056B KC633M	Q20
6144072	3CH2000MX064B KC633M	Q20
6145374	1-16NPTF-JIC	C75
6145375	1-8NPTF-JIC	C75
6145376	G18-JIC	C75
6145377	M10-JIC	C75
6145378	M8-JIC	C75
6145379	JICM-JICF-ELB	C75
6145380	COOL-HOSE-200	C75
6145381	COOL-HOSE-300	C75
6145382	M6-JIC	C75
6145383	JICM-JICM-STR	C75
6145386	G14-G18-RED	C75
6146871	3CH0250DK003A KC633M	Q18
6146872	3CH0300DK004A KC633M	Q18
6146874	3CH0350DK004A KC633M	Q18
6146875	3CH0400DK005A KC633M	Q18
6146876	3CH0450DK005A KC633M	Q18
6146877	3CH0500DK006A KC633M	Q18
6146878	3CH0550DK007A KC633M	Q18
6146879	3CH0600DK007A KC633M	Q18
6146880	3CH0700DK008A KC633M	Q18
6146881	3CH0800DK009A KC633M	Q18
6146882	3CH1000DK011A KC633M	Q18
6146883	3CH1200DK012A KC633M	Q18
6146884	3CH1400DK014A KC633M	Q19
6146885	3CH1600DK016A KC633M	Q19
6146886	3CH1800DK018A KC633M	Q19
6146888	3CH2000DK020A KC633M	Q19
6146890	3CH0250DK003B KC633M	Q18
6146891	3CH0300DK004B KC633M	Q18
6146892	3CH0350DK004B KC633M	Q18
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6146895	3CH0500DK006B KC633M	Q18
6146896	3CH0550DK007B KC633M	Q18
6146897	3CH0600DK007B KC633M	Q18
6146898	3CH0700DK008B KC633M	Q18
6146899	3CH0800DK009B KC633M	Q18
6146900	3CH1000DK011B KC633M	Q18
6146901	3CH1200DK012B KC633M	Q18
6146902	3CH1400DK014B KC633M	Q19
6146903	3CH1600DK016B KC633M	Q19
6146904	3CH1800DK018B KC633M	Q19
6146905	3CH2000DK020B KC633M	Q19
6146906	3CH0100MS004A KC633M	Q20
6146907	3CH0150MS004A KC633M	Q20
6146908	3CH0200MS006A KC633M	Q20
6146909	3CH0250MS006A KC633M	Q20
6146910	3CH0300MS009A KC633M	Q20
6146911	3CH0400MS012A KC633M	Q20
6146913	3CH0600MS016A KC633M	Q20
6146914	3CH0800MS019A KC633M	Q20
6146915	3CH1000MS022A KC633M	Q20
6146916	3CH1200MS025A KC633M	Q20
6146917	3CH1600MS032A KC633M	Q20
6146935	3CH0600MS016B KC633M	Q20
6146937	3CH1000MS022B KC633M	Q20
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6146939	3CH1600MS032B KC633M	Q20
6146940	3CH0200DL006A KC633M	Q18
6146941	3CH0250DL007A KC633M	Q18
6146942	3CH0300DL007A KC633M	Q18
6146943	3CH0350DL007A KC633M	Q18
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6146946	3CH0500DL010A KC633M	Q18
6146947	3CH0550DL010A KC633M	Q18
6146948	3CH0600DL010A KC633M	Q18
6146949	3CH0700DL013A KC633M	Q18
6146950	3CH0800DL016A KC633M	Q18
6146951	3CH1000DL019A KC633M	Q18
6146952	3CH1200DL022A KC633M	Q19
6146953	3CH1400DL022A KC633M	Q19
6146954	3CH1600DL026A KC633M	Q19
6146955	3CH1800DL026A KC633M	Q19
6146956	3CH2000DL032A KC633M	Q19
6146957	3CH0200DL006B KC633M	Q18
6146958	3CH0250DL007B KC633M	Q18
6146959	3CH0300DL007B KC633M	Q18
6146960	3CH0350DL007B KC633M	Q18
6146961	3CH0400DL008B KC633M	Q18
6146962	3CH0450DL008B KC633M	Q18
6146963	3CH0500DL010B KC633M	Q18
6146964	3CH0550DL010B KC633M	Q18
6146965	3CH0600DL010B KC633M	Q18
6146966	3CH0700DL013B KC633M	Q18
6146967	3CH0800DL016B KC633M	Q18
6146968	3CH1000DL019B KC633M	Q18
6146969	3CH1200DL022B KC633M	Q19
6146970	3CH1400DL022B KC633M	Q19
6146971	3CH1600DL026B KC633M	Q19
6146972	3CH1800DL026B KC633M	Q19
6146973	3CH2000DL032B KC633M	Q19
6151025	ABDE1000X3CQE K600	029
6151026	ABDE1000X3CQG K600	029
6151027	ABDE1000X3CQJ K600	029
6151028	ABDE1200X3CQE K600	029
6151029	ABDE1200X3CQG K600	029
6151030	ABDE1200X3CQJ K600	029
6151031	ABDE1200X3CQL K600	029
6151032	ABDE1600X3CQG K600	029
6151033	ABDE1600X3CQJ K600	029
6151034	ABDE1600X3CQK K600	029
6151035	ABDE1600X3CQL K600	029
6151036	ABDE1600X3CQM K600	029
6151037	ABDE2000X3CQG K600	029
6151038	ABDE2000X3CQK K600	029
6151039	ABDE2000X3CQL K600	029
6151040	ABDE2000X3CQM K600	029
6151042	ABDE2000X3CQN K600	029
6151043	ABDE2500X3CQL K600	029
6151044	ABDE2500X3CQN K600	029
6151062	ABDF1000X2CU K600	028
6151063	ABDF1200X2CU K600	028
6151064	ABDF1600X2CU K600	028
6151066	ABDF2000X2CU K600	028
6151491	VDIB1M302040C	C67
6151492	VDIB1M402544C	C67
6151493	VDIB2M302040C	C67
6151494	VDIB2M402544C	C67
6151495	VDIB3M302040C	C68
6151497	VDIB3M402544C	C68
6151498	VDIB4M302040C	C68
6151499	VDIB4M402544C	C68
6151500	VDIB5M302040C	C69
6151511	VDIB5M402544C	C69
6151512	VDIB6M302040C	C69
6151513	VDIB6M402544C	C69
6151514	VDIC1M302070C	C70
6151515	VDIC1M402585C	C70
6151516	VDIC2M302070C	C70
6151517	VDIC2M402585C	C70
6151518	VDIC3M302070C	C71
6151519	VDIC3M402585C	C71
6151520	VDIC4M302070C	C71
6151521	VDIC4M402585C	C71
6151522	CNMG120402LF KCP25B	B50
6151523	CNMG120404LF KCP25B	B50
6151524	CNMG120408LF KCP25B	B50
6151525	CNMG160612MG KCP25B	B57
6151527	CNMG190612MG KCP25B	B57
6151528	CNMM120408MR KCP25B	B54
6151529	CNMM160612MR KCP25B	B54
6151530	CNMM160616MR KCP25B	B54
6151562	DNMP110408K KCP25B	B83
6151565	VNMG160408LF KCP25B	B144
6151567	RCMH190600K KCP10B	B223
6152227	MILL16D315Z440N08WSC	S33
6152228	MILL16D355Z480N08WSC	S33
6152229	MILL16D400Z560N08WSC	S33
6152230	MILL16D500Z700N08WSC	S33

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
6152251	D315CFA	S33
6152252	D355CFA	S33
6152253	D400CFA	S33
6152254	D500CFA	S33
6159024	MILL16D050Z040N08SC	S34
6159025	MILL16D063Z040N08SC	S34
6159026	MILL16D063Z050N08SC	S34
6159027	MILL16D080Z050N08SC	S34
6159028	MILL16D080Z070N08SC	S34
6159029	MILL16D100Z060N08SC	S34
6159030	MILL16D100Z080N08SC	S34
6159061	MILL16D125Z080N08SC	S34
6159062	MILL16D125Z100N08SC	S34
6159063	MILL16D160Z100N08SC	S34
6159064	MILL16D160Z120N08SC	S34
6159065	MILL16D200Z100N08SC	S34
6159066	MILL16D200Z140N08SC	S34
6159067	MILL16D250Z120N08SC	S34
6159068	MILL16D250Z160N08SC	S34
6160117	5720VZ16HA050Z4R75	T89
6162808	EDPT180516PDERHD KCPM40	T75
6162809	EDPT180532PDERHD KCPM40	T75
6162869	KSEM1830SPLM KCMS35	H52
6162870	KSEM2024SPLM KCMS35	H52
6163121	KSEM2250SPLM KCMS35	H52
6163122	KSEM2350SPLM KCMS35	H52
6163123	KSEM2450SPLM KCMS35	H52
6163124	KSEM2525SPLM KCMS35	H52
6163125	KSEM2530SPLM KCMS35	H52
6163126	KSEM2550SPLM KCMS35	H52
6163127	KSEM2630SPLM KCMS35	H52
6163128	KSEM2650SPLM KCMS35	H52
6163129	KSEM2659SPLM KCMS35	H52
6163130	KSEM2750SPLM KCMS35	H52
6163131	KSEM2800SPLM KCMS35	H52
6163132	KSEM2850SPLM KCMS35	H52
6163133	KSEM2900SPLM KCMS35	H53
6163134	KSEM3050SPLM KCMS35	H53
6163135	KSEM3100SPLM KCMS35	H53
6163136	KSEM3150SPLM KCMS35	H53
6163137	KSEM3250SPLM KCMS35	H53
6163138	KSEM3350SPLM KCMS35	H53
6163139	KSEM3400SPLM KCMS35	H53
6163141	KSEM3450SPLM KCMS35	H53
6163142	KSEM3500SPLM KCMS35	H53
6163143	KSEM3550SPLM KCMS35	H53
6163144	KSEM3600SPLM KCMS35	H53
6163145	KSEM3650SPLM KCMS35	H53
6163146	KSEM3700SPLM KCMS35	H53
6163147	KSEM3800SPLM KCMS35	H53
6163148	KSEM3850SPLM KCMS35	H53
6163149	KSEM3900SPLM KCMS35	H53
6163150	KSEM3950SPLM KCMS35	H53
6163300	KTIP0913FEGM KCPM45	H29
6163381	KTIP1010FEGM KCPM45	H29
6163382	KTIP1170FEGM KCPM45	H29
6163383	KSEM1984FEGM KCPM45	H54
6163384	KSEM2580FEGM KCPM45	H54
6163385	KSEM2581FEGM KCPM45	H54
6163386	KSEM2619FEGM KCPM45	H54
6163387	KSEM3050FEGM KCPM45	H54
6163388	KSEM3150FEGM KCPM45	H54
6163389	KSEM3250FEGM KCPM45	H54
6163390	KSEM3350FEGM KCPM45	H54
6163411	KSEM3550FEGM KCPM45	H54
6163412	KSEM3650FEGM KCPM45	H55
6163413	KSEM3750FEGM KCPM45	H55
6163414	KSEM3850FEGM KCPM45	H55
6163415	KSEM3950FEGM KCPM45	H55
6163504	KSEM2360HPGM KCPM45	H45
6163505	KSEM1965HPGM KCPM45	H45
6165212	B978F17000 KC7315	G149
6165214	B978F20000 KC7315	G149
6165350	RNGJ10T3M0ELDJ KCSM40	V50
6165392	RNGJ1204M0SGDJ KCSM40	V57
6165393	RNPJ1605M0SGD KCSM40	V61
6165397	LNGU110408SRGE KCSM40	T9
6165400	LNGU15T608SRGE KCSM40	T19
6165421	LNGU15T612SRGE KCSM40	T19
6165422	LNGU15T608ERGE KCSM40	T18
6165423	LNGU15T612ERGE KCSM40	T18
6165759	HNPJ0604ANSNGD KCSM40	S7, S13, S16
6165760	HNPJ0604ANSNHD KCSM40	S7, S13, S16
6165861	HNPJ060432ANSNHD KCSM40	S7, S13, S16
6165862	HNGJ0604ANENLD KCSM40	S6, S12, S15
6165863	XNGJ0604ANENLD3W KCSM40	S12
6165864	HNGJ0604ANSNHD KCSM40	S7, S12, S16
6167618	FSDE1000A9BCE KC643M	P92
6167619	FSDE1000A9BCG KC643M	P92
6167620	FSDE1200A9BCE KC643M	P92
6167621	FSDE1200A9BCG KC643M	P92
6167622	FSDE1200A9BCL KC643M	P92
6167623	FSDE1600ABBCG KC643M	P92
6167624	FSDE1600ABBCL KC643M	P92
6167625	FSDE1600ABBCM KC643M	P92
6167626	FSDE1600ABBCP KC643M	P92
6167627	FSDE2000AFBCG KC643M	P92
6167628	FSDE2000AFBCK KC643M	P92
6167629	FSDE2000AFBCL KC643M	P92
6167630	FSDE2000AFBCN KC643M	P92
6167631	FSDE2000AFBCP KC643M	P92
6167633	FSDE2500AJBCG KC643M	P92
6167634	FSDE2500AJBCL KC643M	P92
6167635	FSDE2500AJBCP KC643M	P92
6168013	SDCT1204PDERLD2 KCSM40	T104, T111, U51
6168014	SDCT120412PDERLD2 KCSM40	T104, T111, U51
6168015	SDET120412PDERGB KCSM40	T105, T112, U51
6168016	SDCT120416ENLD2 KCSM40	T104, T111, U51
6168017	SDCT120432ENLD2 KCSM40	T104, T111, U51
6168018	SDET1204PDERGB2 KCSM40	T104, T111, U52
6168019	SDET120464ENGB KCSM40	T105, T112, U51
6168020	SDET120448SNGB KCSM40	T105, T112, U51
6168101	SDET120448ENGB KCSM40	T105, T112, U51
6168102	SDET120432SNGB KCSM40	T105, T112, U51
6168103	SDET120432ENGB KCSM40	T105, T112, U51
6168104	SDET120416SNGB KCSM40	T105, T112, U51
6168105	SDET120416ENGB KCSM40	T105, T112, U51
6168106	SDET120412PDSRGB KCSM40	T105, T112, U51
6171518	EDCT140408PDERGD KCSM40	T52, T61
6171519	EDCT140412PDERGD KCSM40	T52, T61
6171520	EDCT140416PDERGD KCSM40	T52, T61
6171591	EDCT140431PDERGD KCSM40	T52, T61
6172122	EDPT140408PDERHD KCSM40	T53, T62
6172123	EDPT140412PDERHD KCSM40	T53, T62
6172124	EDPT140416PDERHD KCSM40	T53, T62
6172125	EDPT140420PDERHD KCSM40	T53, T62
6172126	EDPT140424PDERHD KCSM40	T53, T62
6172127	EDPT140431PDERHD KCSM40	T53, T62
6172128	EDPT140440PDERHD KCSM40	T53, T62
6172129	EDPT140408PDSRGD KCSM40	T54, T63
6172130	EDPT140412PDSRGD KCSM40	T54, T63
6172191	EDPT140416PDSRGD KCSM40	T54, T63
6172192	EDPT140408PDSRGE KCSM40	T53, T62
6172193	EDPT140412PDSRGE KCSM40	T53, T62
6172194	EDPT140416PDSRGE KCSM40	T53, T62
6172195	EDPT140431PDSRGE KCSM40	T53, T62
6172348	EDPT180508PDSRGD KCSM40	T75
6172349	EDPT180512PDSRGD KCSM40	T75
6172350	EDPT180516PDSRGD KCSM40	T75
6172391	EDPT180532PDSRGD KCSM40	T75
6172392	EDPT180548PDSRGD KCSM40	T75
6172393	EDPT180564PDSRGD KCSM40	T75
6172394	EDPT180508PDSRGE KCSM40	T75
6172395	EDPT180512PDSRGE KCSM40	T75
6172396	EDPT180516PDSRGE KCSM40	T75
6172397	EDPT180532PDSRGE KCSM40	T75
6172398	EDPT180508PDERGD KCSM40	T74
6172399	EDPT180516PDERGD KCSM40	T74
6172400	EDPT180532PDERGD KCSM40	T74
6172411	EDPT180548PDERGD KCSM40	T74
6172412	EDPT180564PDERGD KCSM40	T74
6172413	EDPT180508PDERHD KCSM40	T75
6172414	EDPT180512PDERHD KCSM40	T75
6172415	EDPT180516PDERHD KCSM40	T75
6172416	EDPT180532PDERHD KCSM40	T75
6172417	EDPT180540PDERHD KCSM40	T75
6172418	EDPT180548PDERHD KCSM40	T75
6172513	B967A03000 KC7315	G132
6172514	B967A03100 KC7315	G132
6172515	B967A03200 KC7315	G132
6172516	B967A03300 KC7315	G132
6172517	B967A03500 KC7315	G132
6172518	B967A03800 KC7315	G132
6172519	B967A04000 KC7315	G132
6172520	B967A04200 KC7315	G132
6172531	B967A04300 KC7315	G132
6172532	B967A04500 KC7315	G132
6172533	B967A04800 KC7315	G132
6172534	B967A05100 KC7315	G132
6172535	B967A05200 KC7315	G132
6172536	B967A05500 KC7315	G132
6172537	B967A05800 KC7315	G132
6172538	B967A06100 KC7315	G132
6172539	B967A06600 KC7315	G133
6172540	B967A06800 KC7315	G133
6172541	B967A07800 KC7315	G133
6172542	B967A08100 KC7315	G133
6172543	B967A08600 KC7315	G133
6172544	B967A08800 KC7315	G133
6172655	T839M030X050R6H-D1 KSP39	M45
6172656	T839M030X050R6H-D1 KSU31	M45
6172657	T839M040X070R6H-D1 KSP39	M45
6172658	T839M040X070R6H-D1 KSU31	M45
6172659	T839M050X080R6H-D1 KSP39	M45
6172660	T839M050X080R6H-D1 KSU31	M45
6172681	T839M060X100R6H-D1 KSP39	M45
6172682	T839M060X100R6H-D1 KSU31	M45
6172683	T839M080X125R6H-D1 KSP39	M45
6172684	T839M080X125R6H-D1 KSU31	M45
6172685	T839M100X150R6H-D1 KSP39	M45
6172686	T839M100X150R6H-D1 KSU31	M45
6172687	T839M120X175R6H-D6 KSP39	M45
6172688	T839M120X175R6H-D6 KSU31	M45
6172689	T839M140X200R6H-D6 KSP39	M45
6172690	T839M140X200R6H-D6 KSU31	M45
6172701	T839M160X200R6H-D6 KSP39	M45
6172702	T839M160X200R6H-D6 KSU31	M45
6172703	T839M180X250R6H-D6 KSP39	M45
6172704	T839M180X250R6H-D6 KSU31	M45
6172705	T839M200X250R6H-D6 KSP39	M45
6172706	T839M200X250R6H-D6 KSU31	M45
6172875	T838NC05625-12R2B-D6 KSP39	M47
6172876	T838NC05625-12R2B-D6 KSU31	M47
6172877	T838NF05625-18R2B-D4 KSP39	M47
6172878	T838NF05625-18R2B-D4 KSU31	M47
6172879	T838NC06250-11R2B-D6 KSP39	M47
6172880	T838NC06250-11R2B-D6 KSU31	M47
6172967	T838M020X040R6H-D1 KSP39	M43
6172968	T838M020X040R6H-D1 KSU31	M43
6172969	T838M030X050R6H-D1 KSP39	M43
6172970	T838M030X050R6H-D1 KSU31	M43
6173001	T838M040X070R6H-D1 KSP39	M43
6173002	T838M040X070R6H-D1 KSU31	M43
6173003	T838M050X080R6H-D1 KSP39	M43
6173004	T838M050X080R6H-D1 KSU31	M43
6173005	T838M050X080R6H-D6 KSP39	M43
6173006	T838M050X080R6H-D6 KSU31	M43
6173007	T838MF060X075R6H-D4 KSP39	M43
6173008	T838MF060X075R6H-D4 KSU31	M43
6173009	T838M060X100R6H-D1 KSP39	M43
6173010	T838M060X100R6H-D1 KSU31	M43
6173011	T838M060X100R6H-D6 KSP39	M43
6173012	T838M060X100R6H-D6 KSU31	M43
6173013	T838MF080X075R6H-D4 KSP39	M43
6173014	T838MF080X075R6H-D4 KSU31	M43
6173015	T838MF080X100R6H-D4 KSP39	M43
6173016	T838MF080X100R6H-D4 KSU31	M43
6173017	T838M080X125R6H-D1 KSP39	M43
6173018	T838M080X125R6H-D1 KSU31	M43
6173019	T838M080X125R6H-D6 KSP39	M43
6173020	T838M080X125R6H-D6 KSU31	M43
6173021	T838MF100X075R6H-D4 KSP39	M43
6173022	T838MF100X075R6H-D4 KSU31	M43
6173023	T838MF100X100R6H-D4 KSP39	M43
6173024	T838MF100X100R6H-D4 KSU31	M43
6173025	T838MF100X125R6H-D4 KSP39	M43
6173026	T838MF100X125R6H-D4 KSU31	M43
6173027	T838M100X150R6H-D1 KSP39	M43
6173028	T838M100X150R6H-D1 KSU31	M43
6173029	T838M100X150R6H-D6 KSP39	M43
6173030	T838M100X150R6H-D6 KSU31	M43
6173051	T838MF120X100R6H-D4 KSP39	M43
6173052	T838MF120X100R6H-D4 KSU31	M43
6173053	T838MF120X125R6H-D4 KSP39	M43
6173054	T838MF120X125R6H-D4 KSU31	M43
6173055	T838MF120X150R6H-D4 KSP39	M43
6173056	T838MF120X150R6H-D4 KSU31	M43
6173057	T838M120X175R6H-D6 KSP39	M43
6173058	T838M120X175R6H-D6 KSU31	M43
6173059	T838MF140X100R6H-D4 KSP39	M43
6173060	T838MF140X100R6H-D4 KSU31	M43
6173061	T838MF140X125R6H-D4 KSP39	M43
6173062	T838MF140X125R6H-D4 KSU31	M43
6173063	T838MF140X150R6H-D4 KSP39	M43
6173064	T838MF140X150R6H-D4 KSU31	M43
6173065	T838M140X200R6H-D6 KSP39	M43
6173066	T838M140X200R6H-D6 KSU31	M43
6173068	T838MF160X150R6H-D4 KSP39	M43
6173069	T838MF160X150R6H-D4 KSU31	M43
6173070	T838M160X200R6H-D6 KSP39	M43
6173071	T838NF06250-18R2B-D4 KSP39	M47
6173072	T838NF06250-18R2B-D4 KSU31	M47
6173073	T838NC07500-10R2B-D6 KSP39	M47
6173074	T838NC07500-10R2B-D6 KSU31	M47
6173075	T838NF07500-16R2B-D4 KSP39	M47
6173076	T838NF07500-16R2B-D4 KSU31	M47
6173077	T838NC08750-9R2B-D6 KSP39	M47
6173078	T838NC08750-9R2B-D6 KSU31	M47
6173079	T838NF08750-14R2B-D4 KSP39	M47
6173080	T838NF08750-14R2B-D4 KSU31	M47

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
6173081	T838NC10000-8R2B-D6 KSP39	M47
6173082	T838NC10000-8R2B-D6 KSU31	M47
6173083	T838NF10000-12R2B-D4 KSP39	M47
6173084	T838NF10000-12R2B-D4 KSU31	M47
6173085	T838NC11250-7R2B-D6 KSP39	M48
6173086	T838NC11250-7R2B-D6 KSU31	M48
6173087	T838NF11250-12R2B-D4 KSP39	M48
6173088	T838NF11250-12R2B-D4 KSU31	M48
6173089	T838NC12500-7R2B-D6 KSP39	M48
6173090	T838NC12500-7R2B-D6 KSU31	M48
6173091	T838NF12500-12R2B-D4 KSP39	M48
6173092	T838NF12500-12R2B-D4 KSU31	M48
6173093	T838NC13750-6R2B-D6 KSP39	M48
6173094	T838NC13750-6R2B-D6 KSU31	M48
6173095	T838NF13750-12R2B-D4 KSP39	M48
6173096	T838NF13750-12R2B-D4 KSU31	M48
6173097	T838NC15000-6R2B-D6 KSP39	M48
6173098	T838NC15000-6R2B-D6 KSU31	M48
6173099	T838NF15000-12R2B-D4 KSP39	M48
6173100	T838NF15000-12R2B-D4 KSU31	M48
6173101	T838NC17500-5R2B-D6 KSP39	M48
6173102	T838NC17500-5R2B-D6 KSU31	M48
6173103	T838NC20000-4,5R2B-D6 KSP39	M48
6173104	T838NC20000-4,5R2B-D6 KSU31	M48
6173111	T838M160X200R6H-D6 KSU31	M43
6173112	T838MF180X150R6H-D4 KSP39	M43
6173113	T838MF180X150R6H-D4 KSU31	M43
6173114	T838MF180X200R6H-D4 KSP39	M43
6173115	T838MF180X200R6H-D4 KSU31	M43
6173116	T838M180X250R6H-D6 KSP39	M43
6173117	T838M180X250R6H-D6 KSU31	M43
6173118	T838MF200X150R6H-D4 KSP39	M43
6173119	T838MF200X150R6H-D4 KSU31	M43
6173120	T838MF200X200R6H-D4 KSP39	M43
6173131	T838MF200X200R6H-D4 KSU31	M43
6173132	T838M200X250R6H-D6 KSP39	M44
6173133	T838M200X250R6H-D6 KSU31	M44
6173134	T838MF220X150R6H-D4 KSP39	M44
6173135	T838MF220X150R6H-D4 KSU31	M44
6173136	T838MF220X200R6H-D4 KSP39	M44
6173137	T838MF220X200R6H-D4 KSU31	M44
6173138	T838M220X250R6H-D6 KSP39	M44
6173139	T838M220X250R6H-D6 KSU31	M44
6173140	T838MF240X150R6H-D4 KSP39	M44
6173141	T838MF240X150R6H-D4 KSU31	M44
6173142	T838MF240X200R6H-D4 KSP39	M44
6173143	T838MF240X200R6H-D4 KSU31	M44
6173144	T838M240X300R6H-D6 KSP39	M44
6173145	T838M240X300R6H-D6 KSU31	M44
6173146	T838MF270X150R6H-D4 KSP39	M44
6173147	T838MF270X150R6H-D4 KSU31	M44
6173148	T838M270X300R6H-D6 KSP39	M44
6173149	T838M270X300R6H-D6 KSU31	M44
6173150	T838MF300X150R6H-D4 KSP39	M44
6173151	T838MF300X150R6H-D4 KSU31	M44
6173152	T838MF300X200R6H-D4 KSP39	M44
6173153	T838MF300X200R6H-D4 KSU31	M44
6173154	T838M300X350R6H-D6 KSP39	M44
6173155	T838M300X350R6H-D6 KSU31	M44
6173156	T838M330X350R6H-D6 KSP39	M44
6173157	T838M330X350R6H-D6 KSU31	M44
6173158	T838M360X400R6H-D6 KSP39	M44
6173159	T838M360X400R6H-D6 KSU31	M44
6173160	T838M390X400R6H-D6 KSP39	M44
6173171	T838M390X400R6H-D6 KSU31	M44
6173172	T838M420X450R6H-D6 KSP39	M44
6173173	T838M420X450R6H-D6 KSU31	M44
6173174	T838M450X450R6H-D6 KSP39	M44
6173175	T838M450X450R6H-D6 KSU31	M44
6173176	T838M480X500R6H-D6 KSP39	M44
6173177	T838M480X500R6H-D6 KSU31	M44
6173178	T838M520X500R6H-D6 KSP39	M44
6173179	T838M520X500R6H-D6 KSU31	M44
6173240	T838NC#06-32R2B-D1 KSP39	M47
6173261	T838NC#06-32R2B-D1 KSU31	M47
6173262	T838NF#06-40R2B-D1 KSP39	M47
6173263	T838NF#06-40R2B-D1 KSU31	M47
6173264	T838NC#08-32R2B-D1 KSP39	M47
6173265	T838NC#08-32R2B-D1 KSU31	M47
6173266	T838NF#08-36R2B-D1 KSP39	M47
6173267	T838NF#08-36R2B-D1 KSU31	M47
6173268	T838NC#10-24R2B-D1 KSP39	M47
6173269	T838NC#10-24R2B-D1 KSU31	M47
6173270	T838NF#10-32R2B-D1 KSP39	M47
6173271	T838NF#10-32R2B-D1 KSU31	M47
6173272	T838NC#12-24R2B-D1 KSP39	M47
6173273	T838NC#12-24R2B-D1 KSU31	M47
6173274	T838NF#12-28R2B-D1 KSP39	M47
6173275	T838NF#12-28R2B-D1 KSU31	M47
6173276	T838NC02500-20R2B-D1 KSP39	M47
6173277	T838NC02500-20R2B-D1 KSU31	M47
6173278	T838NC02500-20R2B-D6 KSP39	M47
6173279	T838NC02500-20R2B-D6 KSU31	M47
6173280	T838NF02500-28R2B-D1 KSP39	M47
6173281	T838NF02500-28R2B-D1 KSU31	M47
6173282	T838NF02500-28R2B-D4 KSP39	M47
6173283	T838NF02500-28R2B-D4 KSU31	M47
6173284	T838NC03125-18R2B-D1 KSP39	M47
6173285	T838NC03125-18R2B-D1 KSU31	M47
6173286	T838NC03125-18R2B-D6 KSP39	M47
6173287	T838NC03125-18R2B-D6 KSU31	M47
6173288	T838NF03125-24R2B-D4 KSP39	M47
6173289	T838NF03125-24R2B-D4 KSU31	M47
6173290	T838NC03750-16R2B-D1 KSP39	M47
6173301	T838NC03750-16R2B-D1 KSU31	M47
6173302	T838NC03750-16R2B-D6 KSP39	M47
6173303	T838NC03750-16R2B-D6 KSU31	M47
6173304	T838NF03750-24R2B-D4 KSP39	M47
6173305	T838NF03750-24R2B-D4 KSU31	M47
6173306	T838NC04375-14R2B-D6 KSP39	M47
6173307	T838NC04375-14R2B-D6 KSU31	M47
6173308	T838NF04375-20R2B-D4 KSP39	M47
6173309	T838NF04375-20R2B-D4 KSU31	M47
6173310	T838NC05000-13R2B-D6 KSP39	M47
6173311	T838NC05000-13R2B-D6 KSU31	M47
6173312	T838NF05000-20R2B-D4 KSP39	M47
6173313	T838NF05000-20R2B-D4 KSU31	M47
6173786	LNPU221012PNSRHD2 KCSM40	S121, S123
6174999	FSDE1200A9BCN KC643M	P92
6175000	FSDE1600ABBCN KC643M	P92
6175756	EDPT10T308PDERHD KCSM40	T36
6175757	EDPT10T312PDERHD KCSM40	T36
6175758	EDPT10T316PDERHD KCSM40	T36
6175759	EDPT10T320PDERHD KCSM40	T36
6175760	EDPT10T324PDERHD KCSM40	T36
6176091	EDPT10T331PDERHD KCSM40	T36
6176092	EDPT10T308PDSRGE KCSM40	T36
6176093	EDPT10T312PDSRGE KCSM40	T36
6176094	EDPT10T316PDSRGE KCSM40	T36
6176095	EDPT10T331PDSRGE KCSM40	T36
6176096	EDCT10T308PDERLD KCSM40	T35
6176097	EDCT10T312PDERLD KCSM40	T35
6176098	EDCT10T316PDERLD KCSM40	T35
6176099	EDCT10T324PDERLD KCSM40	T35
6176100	EDCT10T331PDERLD KCSM40	T35
6177823	SNHJ120608SNGD KCSM40	S63
6177924	OFKT06L5AFENLB KCSM40	S50
6177925	OFKT06L5AFENGB KCSM40	S50
6177926	OFKT06L5AFSNHB KCSM40	S50
6177927	OFPT06L5AFSNHB KCSM40	S51
6177928	OFKT07L6AFENLB KCSM40	S54
6177929	OFKT07L6AFENGB KCSM40	S55
6177930	OFKT07L6AFSNHB KCSM40	S55
6178011	OFPT07L6AFSNHB KCSM40	S55
6178103	HNGJ0905ANENLD KCSM40	S18, S22
6178104	HNGJ0905ANSNGD KCSM40	S18, S23
6178105	HNGJ0905ANSNHD KCSM40	S19, S23
6178106	HNGJ090543ANSNHD KCSM40	S19, S23
6178107	XNGJ0905ANSNGD3W KCSM40	S22
6178108	HNPJ0905ANSNHD KCSM40	S19, S24
6178109	HNPJ090543ANSNHD KCSM40	S19, S24
6178110	HNPJ1307ANSNHD KCSM40	S27
6178121	LNPU2410ANSRHD2 KCSM40	S117
6178232	DFT030304GD KC7140	J87
6178233	DFT05T308GD KC7140	J87
6178234	DFT06T308GD KC7140	J87
6178235	DFT070408GD KC7140	J87
6178236	DFT090508GD KC7140	J87
6178237	SDHT120412EN422 KCSM40	T119
6178238	SDHT120412EN423 KCSM40	T119
6178239	SDMT120412EN41 KCSM40	T120
6178240	SDMW120412TN KCSM40	T120
6178251	SDHT09T308EN422 KCSM40	T116
6178252	SDHT09T308EN423 KCSM40	T116
6178253	SDMT09T308EN41 KCSM40	T117
6178254	SDMW09T308TN KCSM40	T117
6179709	EVSCFL1010K1B10	C42
6179710	EVSCFL1010K1F10	C42
6179755	EVSCTR1212K0316C	C39
6179756	EVSCTL1212K0316C	C40
6179757	EVSCTR1212K1B16	C39
6179758	EVSCTR1212K1F16	C39
6179759	EVSCTR1212K0216	C39
6179760	EVSCTL1212K1B16	C40
6179761	EVSCTL1212K1F16	C40
6179762	EVSCTL1212K0216	C40
6179763	EVSCFR1010K1B10	C41
6179764	EVSCFR1010K1F10	C41
6179765	EVSCFR1010K0210	C41
6179766	EVSCFR1212K1B10	C41
6179767	EVSCFR1212K1B13	C41
6179768	EVSCFR1212K1F10	C41
6179769	EVSCFR1212K1F13	C41
6179770	EVSCFR1212K0210	C41
6179771	EVSCFR1212K0216	C41
6179772	EVSCFR1212K0310C	C41
6179773	EVSCFR1212K0316C	C41
6179774	EVSCFR1616K1B16	C41
6179775	EVSCFR1616K1F16	C41
6179776	EVSCFR1616K0216	C41
6179777	EVSCFR1616K0316C	C41
6179778	EVSCFR2020K1B16	C41
6179779	EVSCFR2020K1F16	C41
6179780	EVSCFR2020K0216	C41
6179781	EVSCFR2020K0316C	C41
6179921	EVSCFL1010K0210	C42
6179922	EVSCFL1212K1B10	C42
6179923	EVSCFL1212K1B13	C42
6179924	EVSCFL1212K1F10	C42
6179925	EVSCFL1212K1F13	C42
6179926	EVSCFL1212K0210	C42
6179927	EVSCFL1212K0216	C42
6179928	EVSCFL1212K0310C	C42
6179929	EVSCFL1212K0316C	C42
6179930	EVSCFL1616K1B16	C42
6179931	EVSCFL1616K1F16	C42
6179932	EVSCFL1616K0216	C42
6179933	EVSCFL1616K0316C	C42
6179934	EVSCFL2020K1B16	C42
6179935	EVSCFL2020K1F16	C42
6179936	EVSCFL2020K0216	C42
6179937	EVSCFL2020K0316C	C42
6180436	DNMG110412CT KCP10B	B76
6181213	LNUX191940S-WT5 KCP25B	E53
6181214	KNUX150405R20 KCP25B	E32
6181215	SNMX190640S-WT5 KCP25B	E53
6181216	KCUX110305R15 KCP25B	E32
6181217	KNUX150405R25 KCP25B	E31
6181311	CNMM190740RRP KCP10B	E53
6181316	RCMX2507M076 KCP25B	E53
6183779	RIQB6C4500S KBHK10	K56
6183780	RIQB7C4500S KBHK10	K56
6183831	RIQ07C4500S KBHK10	K56
6183832	RIQ08C4500S KBHK10	K56
6183833	RIQ09C4500S KBHK10	K56
6183834	RIQB6C4500S KBHK15	K56
6183836	RIQB7C4500S KBHK15	K56
6183837	RIQ07C4500S KBHK15	K56
6183838	RIQ08C4500S KBHK15	K56
6183839	RIQ09C4500S KBHK15	K56
6185769	XPPT060308ERD41 KCSM40	V7
6185770	XEPT160512ERD41 KCSM40	V31
6185921	XDPT090408ERD41 KCSM40	V15
6185922	XDPT090412ERD411 KCSM40	V15
6187383	SDPT1204PDERGB2 KCSM40	T105, T112, U52
6187384	SDPT1204PDSRGB2 KCSM40	T105, T112, U52
6187511	XPPW060310SRD KCPM40	V7
6187512	XPPW060310SRD KCPK30	V7
6187513	XPPW060310SRD KC522M	V7
6187514	XPPW060310SRD KC510M	V7
6187535	XDPW090412SRD KCPM40	V16
6187536	XDPW090412SRD KCPK30	V16
6187537	XDPW090412SRD KCK15	V16
6187538	XDPW090412SRD KC522M	V16
6187539	XDPW090412SRD KC510M	V16
6187714	XEPW160520SRD KCPM40	V31
6187715	XEPW160520SRD KCPK30	V31
6187716	XEPW160520SRD KCK15	V31
6187717	XEPW160520SRD KC522M	V31
6187806	XDPT120508ERD41 KCSM40	V23
6187808	XDPT120512ERD411 KCSM40	V24
6191237	KSDR100031E0W0S KD1400	S127
6191238	KSDR100031E0W0S KD1425	S127
6191356	RCGT2006M0ELF KCSM40	V83
6191357	RCGT2006M0SHF KCSM40	V83
6191557	XEPT160516ERD41 KCPM40	V31
6191558	XEPT160516ERD41 KCPK30	V31
6191559	XEPT160516ERD41 KC522M	V31
6191642	XDPT090412SRGP KCPM40	V16
6191643	XDPT090412SRGP KCPK30	V16
6191644	XDPT090412SRGP KC725M	V16
6191645	XDPT090412SRGP KC522M	V16
6197561	DTQ50140	S32–33
6200729	LNGU110416SRGEM KCK15	T9
6200730	LNGU110416SRGEM KCPK30	T9
6201021	LNGU110416SRGEM KC520M	T9
6201022	LNGU110416SRGEM KCPM40	T9
6201279	LNGU110404SRGE KC522M	T9
6201280	LNGU110404SRGE KCPM40	T9
6201291	LNGU110404SRGE KC510M	T9
6201292	LNGU110404ERLEJ KC422M	T8
6201351	LNGU110412ERGE KCSM40	T8
6201352	LNGU110412ERGE KC522M	T8
6201353	LNGU110412ERGE KCPM40	T8
6201354	LNGU110408ERGE KCSM40	T8
6202331	250C246RF60HN09C	S94
6202333	315Z328RF60HN09WSC	S94
6202340	ONPX080608SNGP KCK20	S36
6202371	ONPX080620SNHB KCK20	S36
6205876	BTQSW3L90	S32–33
6207836	KBDM250SD30	S126
6210796	HDHN070408SR KBK50	S112
6210797	SDHN1204ZZSN4W KBK50	S112
6210836	KCFMCA45SD12C	S111
6210837	KCFMCA45HD07	S111
6210838	HDHN070408ER KC514M	S112
6210839	SDHN1204ZZEN4W KC514M	S112
6210840	HDHN070408SR KY3500	S112
6213970	M4-11KITD16Z2A16SGEKCPM40	T11
6214071	M4-11KITD20Z2B20SGEKCPM40	T11
6214072	M4-11KITD20Z3A20SGEKCPM40	T11
6214073	M4-11KITD25Z3B25SGEKCPM40	T11
6214074	M4-11KITD25Z4A25SGEKCPM40	T11
6214075	M4-11KITD32Z4B32SGEKCPM40	T11
6214076	M4-11KITD32Z5A32SGEKCPM40	T11
6214077	M4-11KITD40Z4S16SGEKCPM40	T11
6214078	M4-11KITD40Z6S16SGEKCPM40	T11
6214079	M4-11KITD50Z5S22SGEKCPM40	T11
6214080	M4-11KITD50Z7S22SGEKCPM40	T11
6214081	M4-11KITD63Z9S22SGEKCPM40	T11
6214082	M4-11KITD16Z2A16EGEKC725M	T11
6214083	M4-11KITD20Z2B20EGEKC725M	T11
6214084	M4-11KITD20Z3A20EGEKC725M	T11
6214085	M4-11KITD25Z3B20EGEKC725M	T11
6214086	M4-11KITD25Z4A25EGEKC725M	T11
6214087	M4-11KITD32Z4B32EGEKC725M	T11
6214088	M4-11KITD32Z5A32EGEKC725M	T11
6214089	M4-11KITD40Z4S16EGEKC725M	T11
6214090	M4-11KITD40Z6S16EGEKC725M	T11
6214091	M4-11KITD50Z5S22EGEKC725M	T11
6214092	M4-11KITD50Z7S22EGEKC725M	T11
6214093	M4-11KITD63Z9S22EGEKC725M	T11
6224238	KCFM080R08HD07W2	S110
6224239	KCFM100R08HD07W2	S110
6224240	KCFM125R10HD07W2	S110

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
6224411	KCFM160R12HD07W4	S110
6224412	KCFM200R16HD07W4	S110
6224413	KCFM250R24HD07W6	S110
6226803	LNUX191940RRSM KCP25B	E52
6228171	NG2031L KCK20B	C155
6228172	NG2031R KCK20B	C154
6228173	NG2041L KCK20B	C155
6228174	NG2041R KCK20B	C154
6228175	NG2047R KCK20B	C154
6228176	NG2062L KCK20B	C155
6228177	NG2062R KCK20B	C154
6228178	NG2094L KCK20B	C155
6228179	NG2094R KCK20B	C154
6228180	NG2125L KCK20B	C155
6228181	NG3047L KCK20B	C155
6228182	NG3047R KCK20B	C154
6228183	NG3062L KCK20B	C155
6228184	NG3062R KCK20B	C154
6228185	NG3072R KCK20B	C154
6228186	NG3078R KCK20B	C154
6228187	NG3088R KCK20B	C154
6228188	NG3094L KCK20B	C155
6228189	NG3094R KCK20B	C154
6228190	NG3097R KCK20B	C154
6228191	NG3105R KCK20B	C154
6228192	NG3125L KCK20B	C155
6228193	NG3125R KCK20B	C154
6228194	NG3156R KCK20B	C154
6228195	NG3189L KCK20B	C155
6228196	NG3189R KCK20B	C154
6228197	NG4125R KCK20B	C154
6228198	NG4189L KCK20B	C155
6228199	NG4189R KCK20B	C154
6228200	NG4250L KCK20B	C155
6228201	NG4250R KCK20B	C154
6231915	ER094I02U00GUN KCU10	C24
6231916	ER125I03U00GUN KCU10	C24
6231917	ER187I04U00GUN KCU10	C24
6231918	ER250I06U00GUN KCU10	C24
6231919	ER312I08U00GUN KCU10	C24
6231920	ER094I02U00GUN KCU25	C24
6231921	ER125I03U00GUN KCU25	C24
6231922	ER187I04U00GUN KCU25	C24
6231923	ER250I06U00GUN KCU25	C24
6231924	ER312I08U00GUN KCU25	C24
6231925	ER094I02U00GUN KCP10B	C24
6231926	ER125I03U00GUN KCP10B	C24
6231927	ER187I04U00GUN KCP10B	C24
6231928	ER250I06U00GUN KCP10B	C24
6231929	ER312I08U00GUN KCP10B	C24
6231930	ER094I02U00GUN KCP25B	C24
6231931	ER125I03U00GUN KCP25B	C24
6231932	ER187I04U00GUN KCP25B	C24
6231933	ER250I06U00GUN KCP25B	C24
6231934	ER312I08U00GUN KCP25B	C24
6231935	ER094I02U00GUN KCK20B	C24
6231936	ER125I03U00GUN KCK20B	C24
6231937	ER187I04U00GUN KCK20B	C24
6231938	ER250I06U00GUN KCK20B	C24
6231939	ER312I08U00GUN KCK20B	C24
6274622	TCDE1000AC5RE KC643M	P42
6274623	TCDE1200AC5RF KC643M	P42
6283516	TCDE0800AC5RE KC643M	P42
6283517	TCDE1600A5CRG KC643M	P42
6283518	TCDE2000A5CRG KC643M	P42
6283519	TCDE2500A5CRG KC643M	P42
6295898	CNGA120404S01015MT KBH10	B310
6295899	CNGA120404S01015FWMT KBH10	B310
6295900	CNGA120408S01015MT KBH10	B310
6295921	CNGA120408S01015FWMT KBH10	B310
6295922	CNGA120412S01015MT KBH10	B310
6295923	CNGA120408S01225MT KBH10	B310
6295925	CNGA120408S01225FWMT KBH10	B310
6295926	CNGA120412S01225MT KBH10	B310
6295927	CNGA120412S01225FWMT KBH10	B310
6295928	CNGA120408S01735MT KBH10	B310
6295929	CNGA120412S01735MT KBH10	B310
6295930	DNGA150404S01015MT KBH10	B314
6295941	DNGA150408S01015MT KBH10	B314
6295942	DNGA150408S01015FWMT KBH10	B313
6295943	DNGA150412S01015MT KBH10	B314
6295944	DNGA150408S01225MT KBH10	B314
6295946	DNGA150408S01225FWMT KBH10	B313
6295947	DNGA150412S01225MT KBH10	B314
6295948	DNGA150412S01225FWMT KBH10	B313
6295949	DNGA150408S01735MT KBH10	B314
6295950	DNGA150412S01735MT KBH10	B314
6295951	DNGA150604S01015MT KBH10	B314
6295952	DNGA150608S01015MT KBH10	B314
6295953	DNGA150612S01015MT KBH10	B314
6295954	DNGA150608S01225MT KBH10	B314
6295955	DNGA150612S01225MT KBH10	B314
6295956	SNGA120408S01015MT KBH10	B318
6295957	SNGA120408S01225MT KBH10	B318
6295958	SNGA120412S01225MT KBH10	B318
6295959	TNGA160404S01015MT KBH10	B320
6295960	TNGA160408S01015MT KBH10	B320
6295971	TNGA160412S01015MT KBH10	B320
6295972	TNGA160408S01225MT KBH10	B320
6295973	TNGA160412S01225MT KBH10	B320
6295974	TNGA160408S01735MT KBH10	B320
6295975	TNGA160412S01735MT KBH10	B320
6295976	VNGA160404S01015MT KBH10	B323
6295977	VNGA160408S01015MT KBH10	B323
6295978	VNGA160404S01225MT KBH10	B323
6295979	VNGA160408S01225MT KBH10	B323
6295980	WNGA80408S01015MT KBH10	B324
6295991	WNGA80408S01225MT KBH10	B324
6295992	CCGW060202S01015MT KBH10	B308
6295993	CCGW060204S01015MT KBH10	B308
6295994	CCGW09T302S01015MT KBH10	B308
6295995	CCGW09T304S01015MT KBH10	B308
6295996	CCGW09T308S01015MT KBH10	B308
6295997	CCGW09T308S01015FWMT KBH10	B308
6295998	CCGW09T304S01225MT KBH10	B308
6296000	CCGW09T308S01225MT KBH10	B308
6296002	DCGW70202S01015MT KBH10	B312
6296004	DCGW70204S01015MT KBH10	B312
6296007	DCGW11T302S01015MT KBH10	B312
6296008	DCGW11T304S01015MT KBH10	B312
6296009	DCGW11T308S01015MT KBH10	B312
6296010	DCGW11T308S01015FWMT KBH10	B312
6296021	DCGW70204S01225MT KBH10	B312
6296022	DCGW11T304S01225MT KBH10	B312
6296023	DCGW11T308S01225MT KBH10	B312
6296024	DCGW11T308S01225FWMT KBH10	B312
6296025	TCGW110202S01015MT KBH10	B319
6296026	TCGW110204S01015MT KBH10	B319
6296027	TCGW110208S01015MT KBH10	B319
6296028	TCGW110204S01225MT KBH10	B319
6296029	TCGW110208S01225MT KBH10	B319
6296030	TPGW110304S01015MT KBH10	B321
6296031	TPGW160404S01015MT KBH10	B321
6296032	TPGW160408S01015MT KBH10	B321
6296033	TPGW110304S01225MT KBH10	B321
6296034	TPGW110308S01225MT KBH10	B321
6296035	TPGW160404S01225MT KBH10	B321
6296036	TPGW160408S01225MT KBH10	B321
6296037	VBGW110304S01015MT KBH10	B322
6296038	VBGW110308S01015MT KBH10	B322
6296039	VBGW160404S01015MT KBH10	B322
6296040	VBGW160408S01015MT KBH10	B322
6300607	KNUX160405L1 KCM15B	E31
6300608	KNUX160405L1 KCM25B	E31
6300609	KNUX160405L2 KU10	E31
6300610	KNUX160405R1 KCU25	E31
6300611	KNUX160405R1 KCM15B	E31
6300612	KNUX160405R1 KCM25B	E31
6300613	KNUX160405R2 KCM25B	E31
6300614	KNUX160410R1 KCM25B	E31
6300615	KNUX160410R2 KCM25B	E31
6320146	RCMH2507M0TUPG KCP10B	E60
6320147	RCMH2507M0TUPG KCP25B	E60
6320148	RCMX2507M0TUPG KCP10B	E61
6320149	RCMX2507M0TUPG KCP25B	E61
6320150	RCMH3209M0TUPG KCP10B	E60
6320351	RCMH3209M0TUPG KCP25B	E60
6320352	RCMX3209M0TUPG KCP10B	E61
6320353	RCMX3209M0TUPG KCP25B	E61
6320354	RCMT1606M0UPG KCPK05	E60
6320355	RCMT1606M0UPG KCP10B	E60
6320356	RCMT1606M0UPG KCP25B	E60
6320357	RCMT1606M0UPG KCK15B	E60
6320358	RCMT2006M0UPG KCPK05	E60
6320359	RCMT2006M0UPG KCP10B	E60
6320360	RCMT2006M0UPG KCP25B	E60
6320361	RCMT2006M0UPG KCK15B	E60
6342967	TWDL10TM	O58
6342968	TWDL12TM	O58
6342969	TWDL16TM	O58
6342970	TWDL20TM	O58
6343061	TWDL25TM	O58
6343062	TWDL32TM	O58
6348983	B273Z16000HPG KCPK15	G78
6348984	B274Z13500HPG KCPK15	G80
6348985	B274Z14000HPG KCPK15	G80
6348986	B274Z15000HPG KCPK15	G80
6348987	B275Z02500KMG KCPK20	G81
6348988	B275Z03000KMG KCPK20	G81
6348989	B275Z03175HPG KCPK20	G81
6348990	B275Z03500HPG KCPK20	G81
6349001	B275Z03571HPG KCPK20	G81
6349002	B275Z03970HPG KCPK20	G81
6349003	B275Z04000HPG KCPK20	G81
6349004	B275Z04200HPG KCPK20	G81
6349006	B275Z04763HPG KCPK20	G81
6349007	B275Z05000HPG KCPK20	G81
6349008	B275Z05500HPG KCPK20	G81
6349009	B275Z05558HPG KCPK20	G81
6349010	B275Z06000HPG KCPK20	G81
6349011	B275Z06350HPG KCPK20	G81
6349012	B275Z06500HPG KCPK20	G81
6349013	B275Z06800HPG KCPK20	G81
6349014	B275Z07000HPG KCPK20	G81
6349015	B275Z07145HPG KCPK20	G81
6349016	B275Z07500HPG KCPK20	G81
6349017	B275Z07938HPG KCPK20	G81
6349018	B275Z08000HPG KCPK20	G81
6349020	B275Z08733HPG KCPK20	G81
6349021	B275Z09000HPG KCPK20	G81
6349022	B275Z09525HPG KCPK20	G81
6349023	B275Z10000HPG KCPK20	G81
6349024	B275Z10200HPG KCPK15	G81
6349025	B275Z10320HPG KCPK15	G81
6349027	B273Z16000HPS KN25	G78
6349028	B274Z13500HPS KN25	G80
6349029	B274Z14000HPS KN25	G80
6349030	B274Z15000HPS KN25	G80
6349031	B275Z02500KMS KN25	G81
6349032	B275Z03000HPS KN25	G81
6349033	B275Z03175HPS KN25	G81
6349034	B275Z03500HPS KN25	G81
6349035	B275Z03571HPS KN25	G81
6349036	B275Z03970HPS KN25	G81
6349037	B275Z04000HPS KN25	G81
6349038	B275Z04200HPS KN25	G81
6349039	B275Z04500HPS KN25	G81
6349040	B275Z04763HPS KN25	G81
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6349042	B275Z05500HPS KN25	G81
6349043	B275Z05558HPS KN25	G81
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6349047	B275Z06800HPS KN25	G81
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6349049	B275Z07145HPS KN25	G81
6349050	B275Z07500HPS KN25	G81
6349051	B275Z07938HPS KN25	G81
6349052	B275Z08000HPS KN25	G81
6349053	B275Z08500HPS KN25	G81
6349054	B275Z08733HPS KN25	G81
6349055	B275Z09000HPS KN25	G81
6349056	B275Z09525HPS KN25	G81
6349057	B275Z10000HPS KN25	G81
6349058	B275Z10200HPS KN25	G81
6349059	B275Z10320HPS KN25	G81
6349060	B275Z11000HPS KN25	G81
6350374	B211A03000SGL KCMS15	G38
6350375	B211A03048SGL KCMS15	G38
6350376	B211A03100SGL KCMS15	G38
6350377	B211A03175SGL KCMS15	G38
6350378	B211A03200SGL KCMS15	G38
6350379	B211A03300SGL KCMS15	G38
6350380	B211A03400SGL KCMS15	G38
6350381	B211A03455SGL KCMS15	G38
6350382	B211A03500SGL KCMS15	G38
6350383	B211A03571SGL KCMS15	G38
6350384	B211A03600SGL KCMS15	G38
6350385	B211A03658SGL KCMS15	G38
6350386	B211A03700SGL KCMS15	G38
6350387	B211A03734SGL KCMS15	G38
6350388	B211A03800SGL KCMS15	G38
6350389	B211A03861SGL KCMS15	G38
6350390	B211A03900SGL KCMS15	G38
6350391	B211A04000SGL KCMS15	G38
6350392	B211A04039SGL KCMS15	G38
6350393	B211A04100SGL KCMS15	G38
6350394	B211A04200SGL KCMS15	G38
6350395	B211A04217SGL KCMS15	G38
6350396	B211A04300SGL KCMS15	G38
6350397	B211A04366SGL KCMS15	G38
6350398	B211A04400SGL KCMS15	G38
6350399	B211A04500SGL KCMS15	G38
6350400	B211A04600SGL KCMS15	G38
6350401	B211A04700SGL KCMS15	G38
6350402	B211A04763SGL KCMS15	G39
6350403	B211A04800SGL KCMS15	G39
6350404	B211A04852SGL KCMS15	G39
6350405	B211A04900SGL KCMS15	G39
6350406	B211A05000SGL KCMS15	G39
6350407	B211A05100SGL KCMS15	G39
6350408	B211A05106SGL KCMS15	G39
6350409	B211A05159SGL KCMS15	G39
6350410	B211A05200SGL KCMS15	G39
6350411	B211A05300SGL KCMS15	G39
6350412	B211A05400SGL KCMS15	G39
6350413	B211A05500SGL KCMS15	G39
6350414	B211A05558SGL KCMS15	G39
6350415	B211A05600SGL KCMS15	G39
6350416	B211A05700SGL KCMS15	G39
6350417	B211A05800SGL KCMS15	G39
6350418	B211A05900SGL KCMS15	G39
6350419	B211A05954SGL KCMS15	G39
6350420	B211A06000SGL KCMS15	G39
6350421	B211A06100SGL KCMS15	G39
6350422	B211A06200SGL KCMS15	G39
6350423	B211A06300SGL KCMS15	G39
6350424	B211A06350SGL KCMS15	G39
6350425	B211A06400SGL KCMS15	G39

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
6350426	B211A06500SGL KCMS15	G39
6350427	B211A06630SGL KCMS15	G39
6350428	B211A06700SGL KCMS15	G39
6350429	B211A06600SGL KCMS15	G39
6350430	B211A06800SGL KCMS15	G39
6350431	B211A06900SGL KCMS15	G39
6350432	B211A07000SGL KCMS15	G39
6350433	B211A07100SGL KCMS15	G39
6350434	B211A07200SGL KCMS15	G39
6350435	B211A07300SGL KCMS15	G39
6350436	B211A07400SGL KCMS15	G39
6350437	B211A07500SGL KCMS15	G39
6350438	B211A07600SGL KCMS15	G39
6350439	B211A07700SGL KCMS15	G39
6350440	B211A07800SGL KCMS15	G39
6350441	B211A07900SGL KCMS15	G39
6350442	B211A07938SGL KCMS15	G39
6350443	B211A08000SGL KCMS15	G39
6350444	B211A08100SGL KCMS15	G39
6350445	B211A08200SGL KCMS15	G39
6350446	B211A08400SGL KCMS15	G39
6350447	B211A08500SGL KCMS15	G39
6350448	B211A08600SGL KCMS15	G39
6350449	B211A08700SGL KCMS15	G40
6350450	B211A08800SGL KCMS15	G40
6350451	B211A08900SGL KCMS15	G40
6350452	B211A09000SGL KCMS15	G40
6350453	B211A09100SGL KCMS15	G40
6350454	B211A09200SGL KCMS15	G40
6350455	B211A09300SGL KCMS15	G40
6350456	B211A09400SGL KCMS15	G40
6350457	B211A09500SGL KCMS15	G40
6350458	B211A09525SGL KCMS15	G40
6350459	B211A09600SGL KCMS15	G40
6350460	B211A09700SGL KCMS15	G40
6350471	B211A09800SGL KCMS15	G40
6350472	B211A09900SGL KCMS15	G40
6350473	B211A10000SGL KCMS15	G40
6350474	B211A10100SGL KCMS15	G40
6350475	B211A10200SGL KCMS15	G40
6350476	B211A10300SGL KCMS15	G40
6350477	B211A10400SGL KCMS15	G40
6350478	B211A10500SGL KCMS15	G40
6350479	B211A10700SGL KCMS15	G40
6350480	B211A10800SGL KCMS15	G40
6350481	B211A11000SGL KCMS15	G40
6350482	B211A11100SGL KCMS15	G40
6350483	B211A11113SGL KCMS15	G40
6350484	B211A11200SGL KCMS15	G40
6350485	B211A11400SGL KCMS15	G40
6350486	B211A11500SGL KCMS15	G40
6350487	B211A11700SGL KCMS15	G40
6350488	B211A11800SGL KCMS15	G40
6350489	B211A12000SGL KCMS15	G40
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6350492	B211A12300SGL KCMS15	G40
6350493	B211A12500SGL KCMS15	G40
6350494	B211A12700SGL KCMS15	G40
6350495	B211A12800SGL KCMS15	G40
6350496	B211A12900SGL KCMS15	G40
6350497	B211A13000SGL KCMS15	G40
6350498	B211A13100SGL KCMS15	G40
6350499	B211A13200SGL KCMS15	G40
6350500	B211A13300SGL KCMS15	G40
6350501	B211A13500SGL KCMS15	G40
6350502	B211A13800SGL KCMS15	G40
6350503	B211A14000SGL KCMS15	G40
6350504	B211A14100SGL KCMS15	G40
6350505	B211A14300SGL KCMS15	G41
6350506	B211A14400SGL KCMS15	G41
6350507	B211A14500SGL KCMS15	G41
6350508	B211A14600SGL KCMS15	G41
6350509	B211A14800SGL KCMS15	G41
6350510	B211A15000SGL KCMS15	G41
6350511	B211A15100SGL KCMS15	G41
6350512	B211A15300SGL KCMS15	G41
6350513	B211A15500SGL KCMS15	G41
6350514	B211A15700SGL KCMS15	G41
6350515	B211A15875SGL KCMS15	G41
6350516	B211A16000SGL KCMS15	G41
6350517	B211A16100SGL KCMS15	G41
6350518	B211A16500SGL KCMS15	G41
6350519	B211A17000SGL KCMS15	G41
6350520	B211A17500SGL KCMS15	G41
6350521	B211A17700SGL KCMS15	G41
6350522	B211A18000SGL KCMS15	G41
6350523	B211A18500SGL KCMS15	G41
6350524	B211A19000SGL KCMS15	G41
6350525	B211A19159SGL KCMS15	G41
6350526	B211A19300SGL KCMS15	G41
6350527	B211A20500SGL KCMS15	G41
6350528	B212A03000SGL KCMS15	G38
6350529	B212A03175SGL KCMS15	G38
6350530	B212A03200SGL KCMS15	G38
6350551	B212A03264SGL KCMS15	G38
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6350553	B212A03455SGL KCMS15	G38
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6350555	B212A03571SGL KCMS15	G38
6350556	B212A03658SGL KCMS15	G38
6350557	B212A03700SGL KCMS15	G38
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6350559	B212A04000SGL KCMS15	G38
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6350561	B212A04100SGL KCMS15	G38
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6350564	B212A04300SGL KCMS15	G38
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6350566	B212A04500SGL KCMS15	G38
6350567	B212A04700SGL KCMS15	G38
6350568	B212A04800SGL KCMS15	G39
6350569	B212A04852SGL KCMS15	G39
6350570	B212A05000SGL KCMS15	G39
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6350572	B212A05200SGL KCMS15	G39
6350573	B212A05500SGL KCMS15	G39
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6350576	B212A06000SGL KCMS15	G39
6350577	B212A06350SGL KCMS15	G39
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6350579	B212A06630SGL KCMS15	G39
6350580	B212A06800SGL KCMS15	G39
6350591	B212A07000SGL KCMS15	G39
6350592	B212A07500SGL KCMS15	G39
6350593	B212A07800SGL KCMS15	G39
6350594	B212A08000SGL KCMS15	G39
6350595	B212A08400SGL KCMS15	G39
6350596	B212A08500SGL KCMS15	G39
6350597	B212A08800SGL KCMS15	G40
6350598	B212A09000SGL KCMS15	G40
6350599	B212A09500SGL KCMS15	G40
6350600	B212A10000SGL KCMS15	G40
6350601	B212A10200SGL KCMS15	G40
6350602	B212A10500SGL KCMS15	G40
6350603	B212A11000SGL KCMS15	G40
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6350605	B212A12000SGL KCMS15	G40
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6351168	B271Z03175SGL KCMS20	G74
6351170	B271Z03500SGL KCMS20	G74
6351172	B271Z03970SGL KCMS20	G74
6351174	B271Z04000SGL KCMS20	G74
6351176	B271Z04500SGL KCMS20	G74
6351178	B271Z04763SGL KCMS20	G74
6351179	B273Z02500SGL KCMS20	G78
6351191	B271Z04800SGL KCMS20	G74
6351192	B273Z03000SGL KCMS20	G78
6351194	B271Z05000SGL KCMS20	G74
6351195	B273Z03175SGL KCMS20	G78
6351197	B271Z05500SGL KCMS20	G74
6351198	B273Z03500SGL KCMS20	G78
6351200	B271Z05558SGL KCMS20	G74
6351201	B273Z04000SGL KCMS20	G78
6351203	B271Z06000SGL KCMS20	G74
6351204	B273Z04500SGL KCMS20	G78
6351206	B271Z06350SGL KCMS20	G74
6351207	B273Z05000SGL KCMS20	G78
6351209	B271Z06500SGL KCMS20	G75
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6351212	B271Z06746SGL KCMS20	G75
6351213	B273Z06000SGL KCMS20	G78
6351215	B271Z07000SGL KCMS20	G75
6351216	B273Z06500SGL KCMS20	G78
6351218	B271Z07145SGL KCMS20	G75
6351219	B273Z07000SGL KCMS20	G78
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6351222	B273Z08000SGL KCMS20	G78
6351224	B271Z07938SGL KCMS20	G75
6351225	B273Z08500SGL KCMS20	G78
6351227	B271Z08000SGL KCMS20	G75
6351228	B273Z09000SGL KCMS20	G78
6351230	B271Z08500SGL KCMS20	G75
6351231	B273Z10000SGL KCMS20	G78
6351233	B271Z08733SGL KCMS20	G75
6351234	B273Z11000SGL KCMS20	G78
6351236	B271Z09000SGL KCMS20	G75
6351237	B273Z12000SGL KCMS20	G78
6351239	B271Z09525SGL KCMS20	G75
6351240	B273Z13000SGL KCMS20	G78
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6358144	B210A04200SGL KCMS15	G38
6358145	B210A04300SGL KCMS15	G38
6358146	B210A04366SGL KCMS15	G38

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
6358147	B210A04500SGL KCMS15	G38
6358148	B210A04700SGL KCMS15	G38
6358149	B210A04800SGL KCMS15	G39
6358150	B210A04900SGL KCMS15	G39
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6370944	KTFST19253HPLM KCMS15	H15
6370945	KTFST13300HPCM KC7410	H12
6370946	KTFST13492HPCM KC7410	H12
6370947	KTFST19279HPLM KCMS15	H15
6370948	KTFST13500HPCM KC7410	H12
6370949	KTFST19355HPLM KCMS15	H15
6370950	KTFST13600HPCM KC7410	H12
6370951	KTFST19446HPLM KCMS15	H15
6370952	KTFST13800HPCM KC7410	H12
6370953	KTFST19460HPLM KCMS15	H15
6370954	KTFST13891HPCM KC7410	H12
6370955	KTFST19500HPLM KCMS15	H15
6370956	KTFST06000HPLM KCMS15	H14
6370957	KTFST19845HPLM KCMS15	H15
6370958	KTFST14000HPCM KC7410	H12
6370959	KTFST19850HPLM KCMS15	H15
6370960	KTFST14100HPCM KC7410	H12
6370971	KTFST06350HPLM KCMS15	H14
6370972	KTFST20000HPLM KCMS15	H15
6370973	KTFST14288HPCM KC7410	H12
6370974	KTFST06500HPLM KCMS15	H14
6370975	KTFST20500HPLM KCMS15	H15
6370976	KTFST14500HPCM KC7410	H12
6370977	KTFST06629HPLM KCMS15	H14
6370978	KTFST20638HPLM KCMS15	H15
6370979	KTFST14600HPCM KC7410	H12
6370980	KTFST06800HPLM KCMS15	H14
6370981	KTFST21000HPLM KCMS15	H15
6370982	KTFST21150HPLM KCMS15	H15
6370983	KTFST07000HPLM KCMS15	H14
6370984	KTFST14684HPCM KC7410	H12
6370985	KTFST21500HPLM KCMS15	H15
6370986	KTFST07500HPLM KCMS15	H14
6370987	KTFST07800HPLM KCMS15	H14
6370988	KTFST22000HPLM KCMS15	H15
6370989	KTFST14800HPCM KC7410	H12
6370990	KTFST07938HPLM KCMS15	H14
6370991	KTFST22225HPLM KCMS15	H15
6370992	KTFST08000HPLM KCMS15	H14

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
6370993	KTFST22500HPLM KCMS15	H15
6370994	KTFST08100HPLM KCMS15	H14
6370995	KTFST15000HPCM KC7410	H12
6370996	KTFST23000HPLM KCMS15	H15
6370997	KTFST08204HPLM KCMS15	H14
6370998	KTFST15083HPCM KC7410	H12
6370999	KTFST23500HPLM KCMS15	H15
6371000	KTFST08334HPLM KCMS15	H14
6371001	KTFST15100HPCM KC7410	H12
6371002	KTFST23813HPLM KCMS15	H15
6371003	KTFST08400HPLM KCMS15	H14
6371004	KTFST15200HPCM KC7410	H12
6371005	KTFST24000HPLM KCMS15	H15
6371006	KTFST08500HPLM KCMS15	H14
6371007	KTFST15300HPCM KC7410	H12
6371008	KTFST24500HPLM KCMS15	H15
6371009	KTFST08600HPLM KCMS15	H14
6371010	KTFST15500HPCM KC7410	H13
6371011	KTFST25000HPLM KCMS15	H15
6371012	KTFST08700HPLM KCMS15	H14
6371013	KTFST15600HPCM KC7410	H13
6371014	KTFST25400HPLM KCMS15	H15
6371015	KTFST08800HPLM KCMS15	H14
6371016	KTFST15800HPCM KC7410	H13
6371017	KTFST25500HPLM KCMS15	H15
6371018	KTFST08900HPLM KCMS15	H14
6371019	KTFST15875HPCM KC7410	H13
6371020	KTFST25600HPLM KCMS15	H15
6371031	KTFST09000HPLM KCMS15	H14
6371032	KTFST25650HPLM KCMS15	H15
6371033	KTFST09100HPLM KCMS15	H14
6371034	KTFST25679HPLM KCMS15	H15
6371035	KTFST09200HPLM KCMS15	H14
6371036	KTFST25806HPLM KCMS15	H15
6371037	KTFST09400HPLM KCMS15	H14
6371038	KTFST26000HPLM KCMS15	H15
6371039	KTFST09500HPLM KCMS15	H14
6371040	KTFST09558HPLM KCMS15	H14
6371041	KTFST09600HPLM KCMS15	H14
6371042	KTFST09700HPLM KCMS15	H14
6371043	KTFST09800HPLM KCMS15	H14
6371044	KTFST09900HPLM KCMS15	H14
6371045	KTFST10000HPLM KCMS15	H14
6371046	KTFST10100HPLM KCMS15	H14
6371047	KTFST10200HPLM KCMS15	H14
6371048	KTFST10300HPLM KCMS15	H14
6371049	KTFST10320HPLM KCMS15	H14
6371050	KTFST10400HPLM KCMS15	H14
6371051	KTFST10500HPLM KCMS15	H14
6371052	KTFST10600HPLM KCMS15	H14
6371053	KTFST10700HPLM KCMS15	H14
6371054	KTFST10800HPLM KCMS15	H14
6371055	KTFST10900HPLM KCMS15	H14
6371056	KTFST11000HPLM KCMS15	H14
6371057	KTFST11100HPLM KCMS15	H14
6371058	KTFST11113HPLM KCMS15	H14
6371059	KTFST11200HPLM KCMS15	H14
6371060	KTFST11400HPLM KCMS15	H14
6371061	KTFST11500HPLM KCMS15	H14
6371062	KTFST11600HPLM KCMS15	H14
6371063	KTFST11800HPLM KCMS15	H14
6371064	KTFST11908HPLM KCMS15	H14
6371065	KTFST12000HPLM KCMS15	H14
6371066	KTFST12200HPLM KCMS15	H14
6371067	KTFST12304HPLM KCMS15	H14
6371068	KTFST12500HPLM KCMS15	H14
6371069	KTFST12700HPLM KCMS15	H14
6371070	KTFST12800HPLM KCMS15	H14
6371071	KTFST12900HPLM KCMS15	H14
6371072	KTFST13000HPLM KCMS15	H14
6371073	KTFST13096HPLM KCMS15	H14
6371074	KTFST13200HPLM KCMS15	H14
6371075	KTFST13492HPLM KCMS15	H14
6371076	KTFST13500HPLM KCMS15	H14
6371077	KTFST13800HPLM KCMS15	H14
6371078	KTFST13891HPLM KCMS15	H14
6371079	KTFST13896HPLM KCMS15	H14
6371080	KTFST14000HPLM KCMS15	H14
6371081	KTFST14100HPLM KCMS15	H14
6371082	KTFST14200HPLM KCMS15	H14
6371083	KTFST14288HPLM KCMS15	H14
6371084	KTFST14300HPLM KCMS15	H14
6371085	KTFST14400HPLM KCMS15	H14
6371086	KTFST14500HPLM KCMS15	H14
6371087	KTFST14684HPLM KCMS15	H14
6371088	KTFST14800HPLM KCMS15	H15
6371089	KTFST15000HPLM KCMS15	H15
6371090	KTFST15100HPLM KCMS15	H15
6371111	KTFST15200HPLM KCMS15	H15
6371112	KTFST15500HPLM KCMS15	H15
6371113	KTFST15875HPLM KCMS15	H15
6371340	KTFS100R03SS12M	H16
6371961	KTFS105R03SS12M	H16
6371962	KTFS110R03SS12M	H16
6371963	KTFS115R03SS12M	H16
6371964	KTFS120R03SS14M	H16
6371965	KTFS125R03SS14M	H16
6371966	KTFS130R03SS14M	H16
6371967	KTFS135R03SS14M	H16
6371968	KTFS140R03SS16M	H16
6371969	KTFS145R03SS16M	H16
6371970	KTFS150R03SS16M	H16
6371971	KTFS160R03SS16M	H16
6371972	KTFS170R03SS20M	H16
6371973	KTFS100R05SS12M	H16
6371974	KTFS105R05SS12M	H16
6371975	KTFS110R05SS12M	H16
6371976	KTFS115R05SS12M	H16
6371977	KTFS120R05SS14M	H16
6371978	KTFS125R05SS14M	H16
6371979	KTFS130R05SS14M	H16
6371980	KTFS135R05SS14M	H16
6371981	KTFS140R05SS16M	H16
6371982	KTFS145R05SS16M	H16
6371983	KTFS150R05SS16M	H16
6371984	KTFS160R05SS16M	H16
6371985	KTFS170R05SS20M	H16
6371986	KTFS100R08SS12M	H16
6371987	KTFS105R08SS12M	H16
6371988	KTFS110R08SS12M	H16
6371989	KTFS115R08SS12M	H16
6371990	KTFS120R08SS14M	H16
6371991	KTFS125R08SS14M	H16
6371992	KTFS130R08SS14M	H16
6371993	KTFS135R08SS14M	H16
6371994	KTFS140R08SS16M	H16
6371995	KTFS145R08SS16M	H16
6371996	KTFS150R08SS16M	H16
6371997	KTFS160R08SS16M	H16
6371999	KTFS170R08SS20M	H16
6372514	KTFS100R03SCF16M	H17
6372515	KTFS105R03SCF16M	H17
6372516	KTFS110R03SCF16M	H17
6372517	KTFS115R03SCF16M	H17
6372518	KTFS120R03SCF16M	H17
6372519	KTFS125R03SCF16M	H17
6372520	KTFS130R03SCF16M	H17
6372591	KTFS135R03SCF16M	H17
6372592	KTFS140R03SCF16M	H17
6372593	KTFS145R03SCF16M	H17
6372594	KTFS150R03SCF20M	H17
6372595	KTFS160R03SCF20M	H17
6372596	KTFS170R03SCF20M	H17
6372597	KTFS100R05SCF16M	H17
6372598	KTFS105R05SCF16M	H17
6372599	KTFS110R05SCF16M	H17
6372600	KTFS115R05SCF16M	H17
6372601	KTFS120R05SCF16M	H17
6372602	KTFS125R05SCF16M	H17
6372603	KTFS130R05SCF16M	H17
6372604	KTFS135R05SCF16M	H17
6372605	KTFS140R05SCF16M	H17
6372606	KTFS145R05SCF16M	H17
6372607	KTFS150R05SCF20M	H17
6372608	KTFS160R05SCF20M	H17
6372609	KTFS170R05SCF20M	H17
6372610	KTFS100R08SCF16M	H17
6372611	KTFS105R08SCF16M	H17
6372612	KTFS110R08SCF16M	H17
6372613	KTFS115R08SCF16M	H17
6372614	KTFS120R08SCF16M	H17
6372615	KTFS125R08SCF16M	H17
6372616	KTFS130R08SCF16M	H17
6372617	KTFS135R08SCF16M	H17
6372618	KTFS140R08SCF16M	H17
6372619	KTFS145R08SCF16M	H17
6372620	KTFS150R08SCF20M	H17
6372621	KTFS160R08SCF20M	H17
6372622	KTFS170R08SCF20M	H17
6388420	KTFSS16000HPGM KCP15A	H9
6388531	KTFSS16027HPGM KCP15A	H9
6388532	KTFSS16080HPGM KCP15A	H9
6388533	KTFSS16104HPGM KCP15A	H9
6388534	KTFSS16100HPGM KCP15A	H9
6388535	KTFSS16200HPGM KCP15A	H9
6388536	KTFSS16271HPGM KCP15A	H9
6388537	KTFSS16300HPGM KCP15A	H9
6388538	KTFSS16400HPGM KCP15A	H9
6388539	KTFSS06000HPGM KCP15A	H8
6388540	KTFSS16500HPGM KCP15A	H9
6388541	KTFSS06100HPGM KCP15A	H8
6388542	KTFSS16600HPGM KCP15A	H9
6388543	KTFSS06200HPGM KCP15A	H8
6388544	KTFSS16670HPGM KCP15A	H9
6388545	KTFSS06300HPGM KCP15A	H8
6388546	KTFSS16700HPGM KCP15A	H9
6388547	KTFSS06350HPGM KCP15A	H8
6388548	KTFSS16800HPGM KCP15A	H9
6388549	KTFSS06400HPGM KCP15A	H8
6388550	KTFSS16900HPGM KCP15A	H9
6388551	KTFSS06500HPGM KCP15A	H8
6388552	KTFSS17000HPGM KCP15A	H9
6388553	KTFSS06530HPGM KCP15A	H8
6388554	KTFSS17066HPGM KCP15A	H9
6388555	KTFSS06600HPGM KCP15A	H8
6388556	KTFSS17100HPGM KCP15A	H9
6388557	KTFSS06629HPGM KCP15A	H8
6388558	KTFSS17200HPGM KCP15A	H9
6388559	KTFSS06700HPGM KCP15A	H8
6388560	KTFSS17300HPGM KCP15A	H9
6388561	KTFSS06746HPGM KCP15A	H8
6388562	KTFSS17400HPGM KCP15A	H9
6388563	KTFSS06800HPGM KCP15A	H8
6388564	KTFSS17463HPGM KCP15A	H9
6388565	KTFSS06900HPGM KCP15A	H8
6388566	KTFSS17480HPGM KCP15A	H9
6388567	KTFSS06909HPGM KCP15A	H8
6388568	KTFSS17500HPGM KCP15A	H9
6388569	KTFSS07000HPGM KCP15A	H8
6388570	KTFSS17600HPGM KCP15A	H9
6388571	KTFSS07100HPGM KCP15A	H8
6388572	KTFSS17700HPGM KCP15A	H9
6388573	KTFSS07145HPGM KCP15A	H8
6388574	KTFSS17800HPGM KCP15A	H9
6388575	KTFSS17859HPGM KCP15A	H9
6388576	KTFSS07200HPGM KCP15A	H8
6388577	KTFSS17900HPGM KCP15A	H9
6388578	KTFSS07366HPGM KCP15A	H8
6388579	KTFSS18000HPGM KCP15A	H9
6388580	KTFSS07400HPGM KCP15A	H8
6388581	KTFSS18100HPGM KCP15A	H9
6388582	KTFSS07500HPGM KCP15A	H8
6388583	KTFSS18200HPGM KCP15A	H9
6388584	KTFSS07541HPGM KCP15A	H8
6388585	KTFSS18258HPGM KCP15A	H9
6388586	KTFSS07600HPGM KCP15A	H8
6388587	KTFSS18300HPGM KCP15A	H9
6388588	KTFSS07700HPGM KCP15A	H8
6388589	KTFSS18400HPGM KCP15A	H9
6388590	KTFSS07800HPGM KCP15A	H8
6388591	KTFSS18500HPGM KCP15A	H9
6388592	KTFSS07900HPGM KCP15A	H8
6388593	KTFSS18600HPGM KCP15A	H9
6388594	KTFSS07938HPGM KCP15A	H8
6388595	KTFSS18654HPGM KCP15A	H9
6388596	KTFSS08000HPGM KCP15A	H8
6388597	KTFSS18700HPGM KCP15A	H9
6388598	KTFSS08100HPGM KCP15A	H8
6388599	KTFSS08164HPGM KCP15A	H8
6388600	KTFSS18800HPGM KCP15A	H9
6388601	KTFSS18900HPGM KCP15A	H9
6388602	KTFSS08204HPGM KCP15A	H8
6388603	KTFSS19000HPGM KCP15A	H9
6388604	KTFSS08300HPGM KCP15A	H8
6388605	KTFSS19050HPGM KCP15A	H9
6388606	KTFSS08334HPGM KCP15A	H8
6388607	KTFSS19100HPGM KCP15A	H9
6388608	KTFSS08400HPGM KCP15A	H8
6388609	KTFSS19200HPGM KCP15A	H9
6388610	KTFSS08433HPGM KCP15A	H8
6388611	KTFSS08500HPGM KCP15A	H8
6388612	KTFSS19228HPGM KCP15A	H9
6388613	KTFSS08600HPGM KCP15A	H8
6388614	KTFSS19253HPGM KCP15A	H9
6388615	KTFSS08611HPGM KCP15A	H8
6388616	KTFSS19279HPGM KCP15A	H9
6388617	KTFSS08700HPGM KCP15A	H8
6388618	KTFSS19300HPGM KCP15A	H9
6388619	KTFSS19355HPGM KCP15A	H9
6388620	KTFSS08733HPGM KCP15A	H8
6388621	KTFSS19400HPGM KCP15A	H10
6388622	KTFSS08800HPGM KCP15A	H8
6388623	KTFSS19446HPGM KCP15A	H10
6388624	KTFSS08839HPGM KCP15A	H8
6388625	KTFSS19460HPGM KCP15A	H10
6388626	KTFSS08900HPGM KCP15A	H8
6388627	KTFSS19500HPGM KCP15A	H10
6388628	KTFSS09000HPGM KCP15A	H8
6388629	KTFSS19600HPGM KCP15A	H10
6388630	KTFSS09093HPGM KCP15A	H8
6388641	KTFSS19700HPGM KCP15A	H10
6388642	KTFSS09100HPGM KCP15A	H8
6388643	KTFSS19800HPGM KCP15A	H10
6388644	KTFSS09129HPGM KCP15A	H8
6388645	KTFSS19845HPGM KCP15A	H10
6388646	KTFSS09200HPGM KCP15A	H8
6388647	KTFSS19900HPGM KCP15A	H10
6388648	KTFSS09300HPGM KCP15A	H8
6388649	KTFSS20000HPGM KCP15A	H10
6388650	KTFSS09347HPGM KCP15A	H8
6388651	KTFSS20100HPGM KCP15A	H10
6388652	KTFSS09400HPGM KCP15A	H8
6388653	KTFSS20200HPGM KCP15A	H10
6388654	KTFSS09500HPGM KCP15A	H8
6388655	KTFSS20241HPGM KCP15A	H10
6388656	KTFSS09525HPGM KCP15A	H8
6388657	KTFSS20300HPGM KCP15A	H10
6388658	KTFSS09558HPGM KCP15A	H8
6388659	KTFSS20500HPGM KCP15A	H10
6388660	KTFSS09600HPGM KCP15A	H8
6388661	KTFSS20600HPGM KCP15A	H10
6388662	KTFSS09700HPGM KCP15A	H8
6388663	KTFSS20638HPGM KCP15A	H10
6388664	KTFSS09800HPGM KCP15A	H8
6388665	KTFSS20700HPGM KCP15A	H10
6388666	KTFSS09900HPGM KCP15A	H8
6388667	KTFSS20800HPGM KCP15A	H10
6388668	KTFSS09921HPGM KCP15A	H8
6388669	KTFSS20900HPGM KCP15A	H10
6388670	KTFSS10000HPGM KCP15A	H8
6388671	KTFSS20990HPGM KCP15A	H10
6388672	KTFSS10023HPGM KCP15A	H8
6388673	KTFSS21000HPGM KCP15A	H10
6388674	KTFSS10084HPGM KCP15A	H8
6388675	KTFSS21100HPGM KCP15A	H10
6388676	KTFSS10100HPGM KCP15A	H8
6388677	KTFSS21200HPGM KCP15A	H10
6388678	KTFSS10200HPGM KCP15A	H8
6388679	KTFSS21300HPGM KCP15A	H10
6388680	KTFSS10262HPGM KCP15A	H8
6388681	KTFSS21400HPGM KCP15A	H10
6388682	KTFSS10300HPGM KCP15A	H8
6388683	KTFSS21433HPGM KCP15A	H10
6388684	KTFSS10320HPGM KCP15A	H8
6388685	KTFSS21500HPGM KCP15A	H10
6388686	KTFSS10400HPGM KCP15A	H8
6388687	KTFSS21700HPGM KCP15A	H10
6388688	KTFSS10490HPGM KCP15A	H8
6388689	KTFSS21800HPGM KCP15A	H10
6388690	KTFSS10500HPGM KCP15A	H8
6388691	KTFSS21829HPGM KCP15A	H10
6388692	KTFSS10600HPGM KCP15A	H8
6388693	KTFSS21900HPGM KCP15A	H10
6388694	KTFSS10700HPGM KCP15A	H8
6388695	KTFSS22000HPGM KCP15A	H10
6388696	KTFSS10716HPGM KCP15A	H8
6388697	KTFSS22100HPGM KCP15A	H10
6388698	KTFSS10800HPGM KCP15A	H8

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Order No.	Catalogue No.	Page(s)
6388699	KTFSS22200HPGM KCP15A	H10
6388700	KTFSS10900HPGM KCP15A	H8
6388701	KTFSS22225HPGM KCP15A	H10
6388702	KTFSS11000HPGM KCP15A	H8
6388703	KTFSS22400HPGM KCP15A	H10
6388704	KTFSS11100HPGM KCP15A	H8
6388705	KTFSS22500HPGM KCP15A	H10
6388706	KTFSS11113HPGM KCP15A	H8
6388707	KTFSS22600HPGM KCP15A	H10
6388708	KTFSS11200HPGM KCP15A	H8
6388709	KTFSS22700HPGM KCP15A	H10
6388710	KTFSS11300HPGM KCP15A	H9
6388711	KTFSS22800HPGM KCP15A	H10
6388712	KTFSS11400HPGM KCP15A	H9
6388713	KTFSS22900HPGM KCP15A	H10
6388714	KTFSS11500HPGM KCP15A	H9
6388715	KTFSS23000HPGM KCP15A	H10
6388716	KTFSS11509HPGM KCP15A	H9
6388717	KTFSS23100HPGM KCP15A	H10
6388718	KTFSS11600HPGM KCP15A	H9
6388719	KTFSS23200HPGM KCP15A	H10
6388720	KTFSS11700HPGM KCP15A	H9
6388721	KTFSS23300HPGM KCP15A	H10
6388722	KTFSS11800HPGM KCP15A	H9
6388723	KTFSS23400HPGM KCP15A	H10
6388724	KTFSS11900HPGM KCP15A	H9
6388725	KTFSS23416HPGM KCP15A	H10
6388726	KTFSS11908HPGM KCP15A	H9
6388727	KTFSS23500HPGM KCP15A	H10
6388728	KTFSS12000HPGM KCP15A	H9
6388729	KTFSS23600HPGM KCP15A	H10
6388730	KTFSS12100HPGM KCP15A	H9
6388731	KTFSS23700HPGM KCP15A	H10
6388732	KTFSS12200HPGM KCP15A	H9
6388733	KTFSS23800HPGM KCP15A	H10
6388734	KTFSS12304HPGM KCP15A	H9
6388735	KTFSS23813HPGM KCP15A	H10
6388736	KTFSS12400HPGM KCP15A	H9
6388737	KTFSS23900HPGM KCP15A	H10
6388738	KTFSS12474HPGM KCP15A	H9
6388739	KTFSS24000HPGM KCP15A	H10
6388740	KTFSS12500HPGM KCP15A	H9
6388741	KTFSS24100HPGM KCP15A	H10
6388742	KTFSS12600HPGM KCP15A	H9
6388743	KTFSS24200HPGM KCP15A	H10
6388744	KTFSS12700HPGM KCP15A	H9
6388745	KTFSS24300HPGM KCP15A	H10
6388746	KTFSS12800HPGM KCP15A	H9
6388747	KTFSS24400HPGM KCP15A	H10
6388749	KTFSS12900HPGM KCP15A	H9
6388750	KTFSS24500HPGM KCP15A	H10
6388751	KTFSS13000HPGM KCP15A	H9
6388752	KTFSS24600HPGM KCP15A	H10
6388753	KTFSS13096HPGM KCP15A	H9
6388754	KTFSS24608HPGM KCP15A	H10
6388755	KTFSS13200HPGM KCP15A	H9
6388756	KTFSS24700HPGM KCP15A	H10
6388757	KTFSS13280HPGM KCP15A	H9
6388758	KTFSS24800HPGM KCP15A	H10
6388759	KTFSS13300HPGM KCP15A	H9
6388760	KTFSS24900HPGM KCP15A	H10
6388761	KTFSS13380HPGM KCP15A	H9
6388762	KTFSS25000HPGM KCP15A	H10
6388763	KTFSS13400HPGM KCP15A	H9
6388764	KTFSS25100HPGM KCP15A	H10
6388765	KTFSS13492HPGM KCP15A	H9
6388766	KTFSS25200HPGM KCP15A	H10
6388767	KTFSS13500HPGM KCP15A	H9
6388768	KTFSS25250HPGM KCP15A	H10
6388769	KTFSS13600HPGM KCP15A	H9
6388770	KTFSS25300HPGM KCP15A	H10
6388771	KTFSS13700HPGM KCP15A	H9
6388772	KTFSS25400HPGM KCP15A	H10
6388773	KTFSS13800HPGM KCP15A	H9
6388774	KTFSS25500HPGM KCP15A	H10
6388775	KTFSS13891HPGM KCP15A	H9
6388776	KTFSS25540HPGM KCP15A	H10
6388777	KTFSS13896HPGM KCP15A	H9
6388778	KTFSS25600HPGM KCP15A	H10
6388779	KTFSS13940HPGM KCP15A	H9
6388780	KTFSS25679HPGM KCP15A	H10
6388781	KTFSS14000HPGM KCP15A	H9
6388782	KTFSS25700HPGM KCP15A	H10
6388783	KTFSS25800HPGM KCP15A	H10
6388784	KTFSS14100HPGM KCP15A	H9
6388785	KTFSS25806HPGM KCP15A	H10
6388786	KTFSS14200HPGM KCP15A	H9
6388787	KTFSS14288HPGM KCP15A	H9
6388788	KTFSS25900HPGM KCP15A	H10
6388789	KTFSS14300HPGM KCP15A	H9
6388790	KTFSS26000HPGM KCP15A	H10
6388791	KTFSS14400HPGM KCP15A	H9
6388792	KTFSS14500HPGM KCP15A	H9
6388793	KTFSS14600HPGM KCP15A	H9
6388794	KTFSS14666HPGM KCP15A	H9
6388795	KTFSS14684HPGM KCP15A	H9
6388796	KTFSS14700HPGM KCP15A	H9
6388798	KTFSS14800HPGM KCP15A	H9
6388799	KTFSS14900HPGM KCP15A	H9
6388800	KTFSS15000HPGM KCP15A	H9
6388821	KTFSS15083HPGM KCP15A	H9
6388822	KTFSS15100HPGM KCP15A	H9
6388823	KTFSS15200HPGM KCP15A	H9
6388824	KTFSS15300HPGM KCP15A	H9
6388825	KTFSS15380HPGM KCP15A	H9
6388826	KTFSS15400HPGM KCP15A	H9
6388828	KTFSS15479HPGM KCP15A	H9
6388829	KTFSS15500HPGM KCP15A	H9
6388830	KTFSS15600HPGM KCP15A	H9
6388831	KTFSS15700HPGM KCP15A	H9
6388832	KTFSS15800HPGM KCP15A	H9
6388833	KTFSS15875HPGM KCP15A	H9
6388834	KTFSS15900HPGM KCP15A	H9
6389147	KTFS180R03SS20M	H16
6389148	KTFS190R03SS20M	H16
6389149	KTFS180R05SS20M	H16
6389150	KTFS190R05SS20M	H16
6389271	KTFS180R08SS20M	H16
6389272	KTFS190R08SS20M	H16
6389279	KTFS180R03SCF25M	H17
6389280	KTFS190R03SCF25M	H17
6389281	KTFS200R03SCF25M	H17
6389282	KTFS210R03SCF25M	H17
6389283	KTFS220R03SCF25M	H17
6389284	KTFS230R03SCF25M	H17
6389285	KTFS240R03SCF25M	H17
6389286	KTFS250R03SCF25M	H17
6389287	KTFS180R05SCF25M	H17
6389288	KTFS190R05SCF25M	H17
6389289	KTFS200R05SCF25M	H17
6389290	KTFS210R05SCF25M	H17
6389311	KTFS220R05SCF25M	H17
6389312	KTFS230R05SCF25M	H17
6389313	KTFS240R05SCF25M	H17
6389314	KTFS250R05SCF25M	H17
6389315	KTFS180R08SCF25M	H17
6389316	KTFS190R08SCF25M	H17
6389317	KTFS200R08SCF25M	H17
6389318	KTFS210R08SCF25M	H17
6389319	KTFS220R08SCF25M	H17
6389320	KTFS230R08SCF25M	H17
6389331	KTFS240R08SCF25M	H17
6389332	KTFS250R08SCF25M	H17
6389361	KTFS060R03SS08M	H16
6389362	KTFS063R03SS08M	H16
6389363	KTFS066R03SS08M	H16
6389364	KTFS070R03SS08M	H16
6389365	KTFS075R03SS08M	H16
6389366	KTFS080R03SS10M	H16
6389367	KTFS085R03SS10M	H16
6389368	KTFS090R03SS10M	H16
6389369	KTFS095R03SS10M	H16
6389370	KTFS060R05SS08M	H16
6389381	KTFS063R05SS08M	H16
6389382	KTFS066R05SS08M	H16
6389383	KTFS070R05SS08M	H16
6389384	KTFS075R05SS08M	H16
6389385	KTFS080R05SS10M	H16
6389386	KTFS085R05SS10M	H16
6389387	KTFS090R05SS10M	H16
6389388	KTFS095R05SS10M	H16
6389389	KTFS060R08SS08M	H16
6389390	KTFS063R08SS08M	H16
6389391	KTFS066R08SS08M	H16
6389392	KTFS070R08SS08M	H16
6389393	KTFS075R08SS08M	H16
6389394	KTFS080R08SS10M	H16
6389395	KTFS085R08SS10M	H16
6389396	KTFS090R08SS10M	H16
6389397	KTFS095R08SS10M	H16
6389436	KTFS080R03SCF12M	H17
6389437	KTFS085R03SCF12M	H17
6389438	KTFS090R03SCF12M	H17
6389439	KTFS095R03SCF12M	H17
6389440	KTFS080R05SCF12M	H17
6389441	KTFS085R05SCF12M	H17
6389442	KTFS090R05SCF12M	H17
6389443	KTFS095R05SCF12M	H17
6389444	KTFS080R08SCF12M	H17
6389445	KTFS085R08SCF12M	H17
6389446	KTFS090R08SCF12M	H17
6389447	KTFS095R08SCF12M	H17
6389448	KTFS100R01SS12M	H16
6389449	KTFS105R01SS12M	H16
6389450	KTFS110R01SS12M	H16
6389471	KTFS115R01SS12M	H16
6389472	KTFS120R01SS14M	H16
6389473	KTFS125R01SS14M	H16
6389474	KTFS130R01SS14M	H16
6389475	KTFS135R01SS14M	H16
6389476	KTFS140R01SS16M	H16
6389477	KTFS145R01SS16M	H16
6389478	KTFS150R01SS16M	H16
6389479	KTFS160R01SS16M	H16
6389480	KTFS170R01SS20M	H16
6389481	KTFS100R12SF16M	H16
6389482	KTFS105R12SF16M	H16
6389483	KTFS110R12SF16M	H16
6389484	KTFS115R12SF16M	H16
6389485	KTFS120R12SF16M	H16
6389486	KTFS125R12SF16M	H16
6389487	KTFS130R12SF16M	H16
6389488	KTFS135R12SF16M	H16
6389489	KTFS140R12SF16M	H16
6389490	KTFS145R12SF16M	H16
6389501	KTFS150R12SF20M	H16
6389502	KTFS160R12SF20M	H16
6389503	KTFS170R12SF20M	H16
6389504	KTFS200R01SCF25M	H17
6389505	KTFS210R01SCF25M	H17
6389506	KTFS220R01SCF25M	H17
6389507	KTFS230R01SCF25M	H17
6389508	KTFS240R01SCF25M	H17
6389509	KTFS250R01SCF25M	H17
6389510	KTFS200R12SCF25M	H17
6389561	KTFS210R12SCF25M	H17
6389562	KTFS220R12SCF25M	H17
6389563	KTFS230R12SCF25M	H17
6389564	KTFS240R12SCF25M	H17
6389565	KTFS250R12SCF25M	H17
6389566	KTFS180R01SS20M	H16
6389567	KTFS190R01SS20M	H16
6389568	KTFS180R12SF25M	H16
6389569	KTFS190R12SF25M	H16
6389570	KTFS060R01SS08M	H16
6389571	KTFS063R01SS08M	H16
6389572	KTFS066R01SS08M	H16
6389573	KTFS070R01SS08M	H16
6389574	KTFS075R01SS08M	H16
6389575	KTFS080R01SS10M	H16
6389576	KTFS085R01SS10M	H16
6389577	KTFS090R01SS10M	H16
6389578	KTFS095R01SS10M	H16
6389579	KTFS060R12SF12M	H16
6389580	KTFS063R12SF12M	H16
6389581	KTFS066R12SF12M	H16
6389582	KTFS070R12SF12M	H16
6389583	KTFS075R12SF12M	H16
6389584	KTFS080R12SF12M	H16
6389585	KTFS085R12SF12M	H16
6389586	KTFS090R12SF12M	H16
6389587	KTFS095R12SF12M	H16
6397374	HNHX090516SNGE KCPK30	S91
6397378	SNXF1204ZNENLD KCPK30	S104
6397379	SNXF1204ZNSNHE KCPK30	S104
6397380	SNXF120412SNGP KCPK30	S104
6397611	SNXF120412SNHE KCPK30	S104
6397612	SNXF120412ENLD KCPK30	S104
6397613	SNXF1204ZNSNGP KCPK30	S104
6397614	SNXF1204ZNENLD KCK20	S104
6397615	SNXF1204ZNSNHE KCK20	S104
6397616	SNXF120412SNGP KCK20	S104
6397617	SNXF120412SNHE KCK20	S104
6397618	SNXF120412ENLD KCK20	S104
6397619	SNXF1204ZNSNGP KCK20	S104
6401814	A4M50L0314MC	C123
6401815	A4M50R0314MC	C123
6401816	A4M50L0414MC	C123
6401817	A4M50R0414MC	C123
6401818	A4M50L0519MC	C123
6401819	A4M50R0519MC	C123
6401820	A4M65L0522MC	C123
6401831	A4M65R0522MC	C123
6401832	A4M65L0620MC	C123
6401833	A4M65L0626MC	C123
6401834	A4M65R0620MC	C123
6401835	A4M65R0626MC	C123
6401836	A4M65L0820MC	C123
6401837	A4M65L0826MC	C123
6401838	A4M65R0820MC	C123
6401839	A4M65R0826MC	C123
6401840	A4M65L1020MC	C123
6401851	A4M65L1026MC	C123
6401852	A4M65R1020MC	C123
6401853	A4M65R1026MC	C123
6401854	EVSMR2020K0216C	C36
6401855	EVSMR2525M0216C	C36
6401856	EVSMR2525M0226C	C36
6401857	EVSMR2020K0222C	C36
6401881	EVSML2525M0216C	C37
6406706	ONGX080620ENLE KCK15	S35
6406707	ONGX080620ENLE KCK20	S35
6406708	ONGX0806ANENLE KCK15	S35
6406709	ONGX0806ANENLE KCK20	S35
6406710	ONGX080620SNGP KCK20	S35
6406851	ONGX080620SNGP KCPK30	S35
6406852	ONGX0806ANSNGP KCK20	S35
6406853	ONPX080608SNGP KCPK30	S36
6406854	ONPX080620SNHB KCPK30	S36
6408009	XADA1000X4CH60 KCPM15	O48
6408010	XADA1200X5CH60 KCPM15	O48
6408041	XADA1600X6CH60 KCPM15	O48
6432549	COOL-HOSE-200-FLEX	C75
6432550	COOL-HOSE-300-FLEX	C75

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
1-16NPTF-JIC	C75
1-8NPTF-JIC	C75
1.10820R310	E14
1.10825L310	E14
1.10825R310	E14
1.10825R700	E14
1.17125L330	E15
1.18016L110	E15
1.18016R110	E15
1.18020L110	E15
1.18020R110	E15
1.18020R310	E15
1.18025L310	E15
1.18025L315	E15
1.18025L330	E16
1.18025R110	E15
1.18025R310	E15
1.18025R315	E15
1.18032L315	E15
1.18032R315	E15
1.38020R021	E16
1.38025L021	E16
1.38025R021	E16
1.77120L100	E17
1.77120R100	E17
1.77125R300	E17
1.77132R400	E17
1.77225R301	E18
1.77725R301	E17
1.78012R103	E18
1.78016R100	E18
1.78020R100	E18
1.78025L100	E18
1.78025L300	E18
1.78025R100	E18
1.78025R300	E18
1.78032R400	E18
100A07RS90ED18D	T72
100A08RS90ED14D	T50
100A08RS90ED18D	T72
100A08RS90SD12PL-HF	V139
100A10RS90ED14D	T50
100B04RP90BG15CM	S143
100B05RS45SE14EG	S41
100B06RP90BG15C2WPM	S144
100B06RP90BG15C6WHPM	S146
100B06RS90RC20C	V82
100B06RS90RP16	V78
100B06RS90SD12DG	T102
100B07RS45SE14EG	S41
100B07RS90RP12	V72
100B07RS90SD12PL	V139
100B08RP00MD10CF	S68
100B08RP70SP12C2WFP	S72
100B08RP90BG15C2WPM	S144
100B08RP90SP12C2WFP	S76
100B08RP90SP15C2WFP	S82
100B08RS90ED10D	T33
100B08RS90RP16	V78
100B08RS90SD12DG	T102
100B09RP70SP15C2WFP	S79
100B09RS90RP12	V72
100B10RF84SN12B	S102
100B10RS90SP10DG	T98
100B12RP00MD10CF	S68
100B12RP70SP12C3WFP	S72
100B12RP90SP12C3WFP	S76
100B12RS90ED10D	T33
100B14RF45HN09C	S89
100B14RP70SP12CFP	S72
100B14RP90SP12CFP	S76
100B15RF84SN12B	S102
100B15RF84SN12B3W	S103
100B82RF60HN09C	S94
100G06LK90SP10N14K	U28
100G06NK90SP10N14K	U30
100G06RK90SP10N14K	U27
100G10NP90SP10N16K	U26
100G10NS90LN12N06	U17
100G10NS90LN12N08	U17
100G10RP90SP10	U25
100Y06LK90SP10N14K	U33
100Y06NK90SP10N14K	U34
100Y06RK90SP10N14K	U32
100Y10RS90LN12N06	U18
100Y10RS90LN12N08	U18
10X1R015B20STN11T	W42
112.244	E15
112.403	E14–15
112.404	E14–16
112.505	E15
114.111	E16
114.114	E16
114.305	E49, E55
118.204	E17–18
118.314	E17–18
11X1R012B12STN11N	W40
11X1R020B20STN11N	W40
121.610	S76
121.612	E14–15, E17, S72, S76, S79, S82
121.616	E14–16, E18, E49, E55, S79, S82
121.808	K44–46
121.812	E16, K44–46
121.816	E16–18
121.825	E18
12147629800	K111–113
12148006000	T24
12148044900	S32–33, S89, S94, S102–103, S110
12148068700	K111–113
125.025	S5, S10, S14, S17, S21, S48, S53, S68, S72, S76, S143–144, S146, T7, T17, V40
125.225	V40
125.616	U8
125.625	K44–46
125.820	J74–75
125.830	J74–75
125B05RP90BG15CM	S143
125B06RS45SE14EG	S41
125B06RS90RC20C	V82
125B07RS90SD12DG	T102
125B08RP90BG15C2WPM	S144
125B08RP90BG15C8WHPM	S146
125B08RS45SE14EG	S41
125B08RS90ED18D	T72
125B09RS90ED14D	T50
125B09RS90ED18D	T72
125B09RS90RP16	V78
125B09RS90SD12PL	V139
125B10RP00MD10CF	S68
125B10RP70SP12C2WFP	S72
125B10RP90BG15C2WPM	S144
125B10RP90SP12C2WFP	S76
125B10RP90SP15C2WFP	S82
125B10RS90SD12DG	T102
125B123RF60HN09C	S94
125B12RP70SP15C2WFP	S79
125B12RS90ED14D	T50
125B15RP90SP12C3WFP	S76
125B16RP00MD10CF	S68
125B18RF45HN09C	S89
125B18RF84SN12B	S102
125B18RF84SN12B3W	S103
125H08LK90SD12N18K	U41
125H08NK90SD12N18K	U42
125H08NK90SD12N20K	U43
125H08NK90SP10N14K	U30
125H08NK90SP10N16K	U31
125H08RK90SD12N18K	U40
125H08RK90SP10N14K	U27
125H11RP90SP10	U25
125H12NP90SP10N16K	U26
125H12NS90LN12N06	U17
125Y08LK90SD12N18K	U46
125Y08LK90SD12N20K	U47
125Y08LK90SP10N14K	U33
125Y08NK90SD12N18K	U48
125Y08NK90SD12N20K	U49
125Y08NK90SP10N14K	U34
125Y08NK90SP10N16K	U35
125Y08RK90SD12N18K	U44
125Y08RK90SD12N20K	U45
125Y08RK90SP10N14K	U32
125Y12RS90LN12N10	U18
12748308500	S94
12748358200	S89, S94, S102–103, S110
12748500200	S95
12748500400	S95
12748500500	S95
12748503400	S95
12748600900	S89, S94, S102–103
12748601000	S32–33
128.508	H64
128.510	H64
128.610	J67
129.025	S21, S41, S48, S76, T102
129.612	J74–75
129.616	J74–75
129.830	S143–144
12A01R020A16ED10	T31
12A02R018A12ED07	T24
12A02R020M08ED07	T24
12MHC030M	G85
12MHC040M	G85
12MHC050M	G85
12MHC060M	G85
12MHC070M	G85
12MHC080M	G85
12MHC090M	G85
12MHC100M	G85
132.151	E15
132.156	E15
15X1R020B16STN16C	W42
15X1R022B16STN16T	W42
160C06RP90BG15CM	S143
160C07RS45SE14EG	S41
160C07RS90RC20C	V82
160C07RS90RC20CHP	V82
160C08RS90RC20C	V82
160C08RS90RC20CHP	V82
160C08RS90SD12DG	T102
160C10RP70SP15C2WFP	S79
160C10RP90BG15C10WHPM	S146
160C10RP90BG15C2WPM	S144
160C10RP90SP15C2WFP	S82
160C10RS45SE14EG	S41
160C10RS90ED18D	T72
160C10RS90SD12PL	V139
160C11RS90ED14D	T50
160C12RP00MD10CF	S68
160C12RP70SP12C3WFP	S72
160C12RP90SP12C3WFP	S76
160C12RS90ED18D	T72
160C12RS90SD12DG	T102
160C164RF60HN09C	S94
160C16RP70SP15C4WFP	S79
160C18RP70SP12C3WFP	S72
160C18RP90SP12C3WFP	S76
160C20RP00MD10CF	S68
160C22RF45HN09C	S89
160C24RF84SN12B	S102
160C24RF84SN12B3W	S103
160H10LK90SD12N18K	U41
160H10LK90SP10N14K	U28
160H10NK90SD12N18K	U42
160H10NK90SD12N20K	U43
160H10NK90SP10N14K	U30
160H10NK90SP10N16K	U31
160H10RK90SD12N18K	U40
160H10RK90SP10N14K	U27
160H11LP90SP10	U25
160H11RP90SP10	U25
160H12LP90SD12	U38
160H12NP90SP10N16K	U26
160H12RP90SD12	U38
160H14NP90SD12N20K	U39
160H15NS90LN12N10	U17
160H15NS90LN12N12	U17
160H16NS90LN12N06	U17
160Y10LK90SD12N18K	U46
160Y10LK90SP10N14K	U33
160Y10NK90SD12N18K	U48
160Y10NK90SD12N20K	U49
160Y10NK90SP10N14K	U34
160Y10NK90SP10N16K	U35
160Y10RK90SP10N14K	U32
160Y15RS90LN12N10	U18
160Y16RS90LN12N06	U18
160Y16RS90LN12N08	U18
169.974	J47
16A02R025A16ED10	T31
16A02R025A16ED10-170	T32
16A02R025A16ED10R31-170	T32
16A02R025B16ED10	T30
16A02R025M08ED10	T29
16A03R020A16ED07	T24
16ERAG60 KC5025	D53
16ERG55 KC5025	D52
170.000	K72
170.002	K47
170.003	E14–18, E49, E55, I14, K47, S68, S72, S76, S79, S82, S143–147
170.004	E16–18, J79, K44–47
170.005	I14, J80, K44–46, U8
170.006	J79–80, K44–46
170.008	J79–81
170.023	J10–15, J23, J25, J27, J29, J31, J33, J35, J37, U13
170.024	I23–24, J23, J25, J27, J29, J31, J33, J35, J37, J45–46, J98
170.025	I14, I23–24, J23, J25, J27, J29, J31, J33, J35, J37, J45–46, J98, S4–5, S8–10, S14, S17, S20–21, U13, V46–49, V53–56, V64
170.026	J45, V60
170.027	J10–15
170.028	I14, J10–12, J23, J25, J27, J29, J31, J33, J35, J37, J98
170.135	K47
170.136	K47
170.270	H58, H63, H65
170.271	H65
170.272	H58, H63, H65
170.273	H65
170.274	H58, H63, H65
170.275	H65
170.276	H58, H63, H65
170.277	H65
170.281	H65
170.282	H65
170.283	H65
170.284	H65
170.285	H65
170.286	H65
170.287	H65
170.288	H65
170.289	H58, H65
170.290	H65
170.291	H65
170.294	H58, H65
170.295	H65
170.296	H65
170.306	H31–32
170.307	H31–32
170.308	H31–32
170.309	H31–32
170.314	H31–32
170.345	H98
170.346	H98
170.347	H98–99
170.348	H99
170.350	H98
170.352	H98
170.353	H98
170.355	H98–99
170.356	H98–99
170.365	H99
170.370	J23, J25, J31, J33, J35, J37
17X1R022B16STN16N	W40
18A02R028A16ED10-170	T32
190.076	I24
190.116	J67
190.195	I24
190.371	I24
190.458	J67
191.282	K72

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
191.375	J45
191.405	B70, B115–119, B199, B202, B220–221, B240–242, B260–263, B376–378
191.406	B70–73, B92, B115–121, B139–142, B183, B229, B235–237, B260–263, B375, B378
191.407	B70–73, B92–93, B115–117, B119, B139–141, B183, B235, B378
191.698	H98, J23, J25, J27, J29, J45–46, J74–75
191.725	I14, V153
191.726	H98–99, J45
191.727	J77–79
191.728	J77, J79–81
191.729	J80–81
191.848	J45–46, J74–75, V46–49
191.916	C41–42, H98–99, J23, J25, J27, J29, J31, J33, J35, J37, J75, J98
191.924	H98, J23, J25, J27, J29, J31, J33, J35, J37, J45–46, J74–75, J98, V153
192.057	I24
192.111	J74–75
192.112	J74–75
192.126	J81
192.156	J77–79
192.157	J77–80
192.158	J81
192.416	J10–15, J67
192.419	J77–79
192.420	J77–79
192.421	J77–80
192.422	J77–79
192.423	J77–80
192.424	J77, J79–81
192.425	J77, J79–81
192.426	J80–81
192.432	H98, I14, J10–12, J23, J25, J27, J29, J31, J33, J35, J37, J67, J74–75, J98
192.433	J23, J25, J27, J29
192.529	U13
192.530	U13
192.531	U13
192.532	U13
192.592	J67, J74
192.593	J74–75
192.636	B162
192.718	I14
192.720	I14
192.730	J81
192.731	J81
192.759	J81
192.888	I14
192.889	I14
192.902	J67, J74–75
192.903	J74–75
192.932	V60
193.113	I24
193.114	I24
193.115	I24
193.116	I24
193.281	J10–15, J23, J25, J31, J33, J35, J37
193.297	C118
193.337	S145–146
193.371	J77–78
193.372	J77–78
193.389	V112, V114, V129
193.390	V111–114, V129
193.391	V111–114, V128–130
193.392	V111–115, V128–130
193.393	V111–115, V128–130
193.394	V113–115, V130
193.395	V113–115
193.397	J67
193.409	S53, V153
193.433	S46–48
193.450	J75
193.451	J75
193.460	S132
193.461	S110, S131–132
193.462	S132
193.464	S131–132
193.465	S131–132
193.491	J23, J25, J27, J29, J31, J33, J35, J37
193.492	S4–5, S8–10, S14, S17, S20–21, S60, S62, V53–56, V64
193.523	H102–103
193.524	H102–103
193.525	H102–103
193.526	H102–103
193.531	S25
193.537	H102–103
193.545	H102–103
199.123	H64
19X1R023B20STN16T	W42
200C09RS90RC20C	V82
200C09RS90RC20CHP	V82
200C11RS90SD12DG	T102
200C12RP70SP15C2WFP	S79
200C12RP90BG15C12WHPM	S146
200C12RP90BG15C3WPM	S144
200C12RP90SP15C2WFP	S82
200C14RP00MD10CF	S68
200C14RS90SD12DG	T102
200C16RP70SP12C4WFP	S72
200C16RP90SP12C4WFP	S76
200C205RF60HN09C	S94
200C24RP00MD10CF	S68
200C24RP90SP12C4WFP	S76
200C30RF84SN12B	S102
200J13LP90SP10	U25
200J13RP90SP10	U25
200J14LK90SP10N16K	U29
200J14LP90SD12	U38
200J14NK90SD12N18K	U42
200J14NK90SD12N20K	U43
200J14NK90SP10N14K	U30
200J14NP90SP10N16K	U26
200J14RP90SD12	U38
200J18NP90SD12N20K	U39
200J18NS90LN12N08	U17
200Y14LK90SD12N20K	U47
200Y14LK90SP10N14K	U33
200Y14NK90SD12N20K	U49
200Y14NK90SP10N14K	U34
200Y14NK90SP10N16K	U35
20A02R028A20ED10	T31
20A02R028B20ED10	T30
20A02R028M10ED10	T29
20A02R032A20ED10-170	T32
20A02R032A20ED10R31-170	T32
20A02R035M10SED14	T47
20A02R039A20SED14	T49
20A02R039B20SED14	T48
20A02R050A20SED14-170	T49
20A03R028A20ED10	T31
20A03R028B20ED10	T30
20A03R028M10ED10	T29
20A03R032A20ED10-170	T32
20A03R032A20ED10R31-170	T32
20A05R020A20ED07	T24
20MHC030M	G85
20MHC040M	G85
20MHC050M	G85
20MHC060M	G85
20MHC070M	G85
20MHC080M	G85
20MHC090M	G85
20MHC100M	G85
20MHC110M	G85
20MHC120M	G85
20MHC130M	G85
20MHC140M	G85
20MHC150M	G85
20MHC160M	G85
20X1R043B20STN16N	W40
22A03R032A20ED10-170	T32
22X1R025B25STN16L	W41
250C16RP90BG15C4WPM	S144
250C18RP00MD10CF	S68
250C246RF60HN09C	S94
250C30RP00MD10CF	S68
250J16LP90SD12	U38
250J16NK90SD12N18K	U42
250J16RP90SD12	U38
250J18LK90SP10N16K	U29
250J18NK90SP10N16K	U31
250J22NP90SD12N20K	U39
250Y16NK90SD12N18K	U48
250Y16NK90SD12N20K	U49
250Y18NK90SP10N16K	U35
25A02R035M12SED14	T47
25A02R035M12SED18	T69
25A02R039B25SSP10G	T97
25A02R044A25SED14	T49
25A02R044A25SED18	T71
25A02R044A25SED18-150	T71
25A02R044B25SED14	T48
25A02R044B25SED18	T70
25A02R050A25SED14-170	T49
25A02R050A25SED18-170	T71
25A03R032A25ED10	T31
25A03R032B25ED10	T30
25A03R032M12ED10	T29
25A03R035M12SED14	T47
25A03R040A25ED10-200	T32
25A03R040A25ED10R31-200	T32
25A03R044A25SED14	T49
25A03R044B25SED14	T48
25A03R050A25SED14-170	T49
25A04R032A25ED10	T31
25A04R032B25ED10	T30
25A04R032M12ED10	T29
25A04R040A25ED10-200	T32
25A04R040A25ED10R31-200	T32
25MHC030M	G85
25MHC040M	G85
25MHC050M	G85
25MHC060M	G85
25MHC070M	G85
25MHC080M	G85
25MHC090M	G85
25MHC100M	G85
25MHC120M	G85
25MHC140M	G85
25MHC160M	G85
25X1R040B25STN27C	W42
26X2R043B25STN16D	W43
28A04R040A25ED10-200	T32
2BN0100MR004A KC633M	Q13
2BN0200DD007A KC633M	Q12
2BN0200DL006A KC633M	Q11
2BN0200MR006A KC633M	Q13
2BN0300DD007A KC633M	Q12
2BN0300DK004A KC633M	Q11
2BN0300DL007A KC633M	Q11
2BN0300MR009A KC633M	Q13
2BN0350MR012A KC633M	Q13
2BN0400DD008A KC633M	Q12
2BN0400DK005A KC633M	Q11
2BN0400DL008A KC633M	Q11
2BN0400MR012A KC633M	Q13
2BN0500DD010A KC633M	Q12
2BN0500DL010A KC633M	Q11
2BN0500MR014A KC633M	Q13
2BN0600DD010A KC633M	Q12
2BN0600DL010A KC633M	Q11
2BN0600MR038A KC633M	Q13
2BN0700DL013A KC633M	Q11
2BN0800DD016A KC633M	Q12
2BN0800DL016A KC633M	Q11
2BN0800MR040A KC633M	Q13
2BN1000DD019A KC633M	Q12
2BN1000DL019A KC633M	Q11
2BN1000MR045A KC633M	Q13
2BN1200DD022A KC633M	Q12
2BN1200DL022A KC633M	Q11
2BN1200ML045A KC633M	Q13
2BN1200MR025A KC633M	Q13
2BN1200MX075A KC633M	Q13
2BN1400DD022A KC633M	Q12
2BN1400DL022A KC633M	Q11
2BN1400MR032A KC633M	Q13
2BN1600DD026A KC633M	Q12
2BN1600DL026A KC633M	Q11
2BN1600MR032A KC633M	Q13
2BN2000DD032A KC633M	Q12
2BN2000DK020A KC633M	Q11
2BN2000DL032A KC633M	Q11
2BN2000ML075A KC633M	Q13
2BN2000MR038A KC633M	Q13
2CH0200DK003A KC633M	Q6
2CH0200MR006A KC633M	Q9
2CH0250MR006A KC633M	Q9
2CH0300DD007A KC633M	Q8
2CH0300DK004A KC633M	Q6
2CH0300DL007A KC633M	Q6
2CH0300ML019A KC633M	Q9
2CH0300MR009A KC633M	Q9
2CH0300MX025A KC633M	Q9
2CH0350DK004A KC633M	Q6
2CH0350MR012A KC633M	Q9
2CH0400DD008A KC633M	Q8
2CH0400DK005A KC633M	Q6
2CH0400DL008A KC633M	Q6
2CH0400ML019A KC633M	Q9
2CH0400MR012A KC633M	Q9
2CH0400MX031A KC633M	Q9
2CH0450DK005A KC633M	Q6
2CH0450DL008A KC633M	Q6
2CH0450MR014A KC633M	Q9
2CH0480MR014A KC633M	Q9
2CH0500DD010A KC633M	Q8
2CH0500DK006A KC633M	Q6
2CH0500DL010A KC633M	Q6
2CH0500ML020A KC633M	Q9
2CH0500MR014A KC633M	Q9
2CH0500MX031A KC633M	Q9
2CH0550MR014A KC633M	Q9
2CH0600DD010A KC633M	Q8
2CH0600DK007A KC633M	Q6
2CH0600DL010A KC633M	Q6
2CH0600ML028A KC633M	Q9
2CH0600MR016A KC633M	Q9
2CH0600MX038A KC633M	Q9
2CH0700DD013A KC633M	Q8
2CH0700DK008A KC633M	Q6
2CH0700DL013A KC633M	Q6
2CH0700MR020A KC633M	Q9
2CH0800DD016A KC633M	Q8
2CH0800DK009A KC633M	Q6
2CH0800DL016A KC633M	Q6
2CH0800ML028A KC633M	Q9
2CH0800MR020A KC633M	Q9
2CH0800MX041A KC633M	Q9
2CH0900DD016A KC633M	Q8
2CH0900DK010A KC633M	Q6
2CH0900DL016A KC633M	Q6
2CH0900MR020A KC633M	Q9
2CH1000DD019A KC633M	Q8
2CH1000DK011A KC633M	Q6
2CH1000DL019A KC633M	Q6
2CH1000ML032A KC633M	Q9
2CH1000MR022A KC633M	Q9
2CH1000MX045A KC633M	Q9
2CH1100MR025A KC633M	Q9
2CH1200DD022A KC633M	Q8
2CH1200DK012A KC633M	Q6
2CH1200DK012B KC633M	Q6
2CH1200DL022A KC633M	Q6
2CH1200DL022B KC633M	Q6
2CH1200ML045A KC633M	Q10
2CH1200ML045B KC633M	Q10
2CH1200MR025A KC633M	Q9
2CH1200MR025B KC633M	Q9
2CH1200MX075A KC633M	Q10
2CH1200MX075B KC633M	Q10
2CH1400DD022A KC633M	Q8
2CH1400DK014A KC633M	Q6
2CH1400DK014B KC633M	Q6
2CH1400DL022A KC633M	Q6
2CH1400DL022B KC633M	Q6
2CH1400ML050A KC633M	Q10
2CH1400ML050B KC633M	Q10
2CH1400MR032A KC633M	Q10
2CH1400MR032B KC633M	Q10
2CH1400MX075A KC633M	Q10
2CH1400MX075B KC633M	Q10

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
2CH1500DD026A KC633M	Q8
2CH1600DD026A KC633M	Q8
2CH1600DK016A KC633M	Q7
2CH1600DK016B KC633M	Q7
2CH1600DL026A KC633M	Q7
2CH1600DL026B KC633M	Q7
2CH1600ML056A KC633M	Q10
2CH1600ML056B KC633M	Q10
2CH1600MR032A KC633M	Q10
2CH1600MR032B KC633M	Q10
2CH1600MX075A KC633M	Q10
2CH1600MX075B KC633M	Q10
2CH1800DD026A KC633M	Q8
2CH1800DK018A KC633M	Q7
2CH1800DK018B KC633M	Q7
2CH1800DL026A KC633M	Q7
2CH1800MX075A KC633M	Q10
2CH2000DD032A KC633M	Q8
2CH2000DK020A KC633M	Q7
2CH2000DK020B KC633M	Q7
2CH2000DL032A KC633M	Q7
2CH2000DL032B KC633M	Q7
2CH2000ML056A KC633M	Q10
2CH2000ML056B KC633M	Q10
2CH2000MR038A KC633M	Q10
2CH2000MR038B KC633M	Q10
2CH2000MX075A KC633M	Q10
2CH2000MX075B KC633M	Q10
3.37042R320	I14
3.37042R820	I14
3.37051R320	I14
3.37051R820	I14
3.37052R320	I14
3.37052R820	I14
3.37060R720	I23
3.37061R320	I14
3.37061R820	I14
3.37062R320	I14
3.37062R820	I14
3.37071R320	I14
3.37071R820	I14
3.37080R720	I23
3.37081R320	I14
3.37081R820	I14
3.37091R320	I14
3.37091R820	I14
3.37092R320	I14
3.37092R820	I14
3.37100R720	I23
3.37101R332	I14
3.37101R832	I14
3.37111R332	I14
3.37111R832	I14
3.37120R732	I23
3.37121R332	I14
3.37121R832	I14
3.37131R332	I14
3.37131R832	I14
3.37140R732	I23
3.37141R332	I14
3.37141R832	I14
3.37151R332	I14
3.37151R832	I14
3.37160R732	I23
3.37161R332	I14
3.37161R832	I14
3.37171R332	I14
3.37171R832	I14
3.37180R732	I23
3.37181R332	I14
3.37181R832	I14
3.37526R006	I24
3.37528R008	I24
3.37530R010	I24
3.37532R012	I24
3.37534R014	I24
3.37538R016	I24
3.37540R018	I24
3.37542R020	I24
3.41020R900 KMF	I16
3.41020R900STF CS5	I16
3.41020R901 CS5	I15
3.41020R901 KC7315	I15
3.41020R902 CS5	I15
3.41020R902 KC7315	I15
3.41020R903 CS5	I15
3.41020R903 KC7315	I15
3.41020R904 KC7315	I16
3.41220R900 KMF	I16
3.41220R900SF KMF	I16
3.41220R900STF CS5	I16
3.41220R901 CS5	I15
3.41220R901 KC7315	I15
3.41220R902 CS5	I15
3.41220R902 KC7315	I15
3.41220R903 CS5	I15
3.41220R903 KC7315	I15
3.41220R904 KC7315	I16
3.42805R001 CS5	I27
3.42805R001 KC7215	I27
3.42805R001 KMF	I27
3.42805R021 KC7015	I27
3.42805R021 KC7315	I27
3.42805R081 KC7215	I27
3.42807R001 CS5	I27
3.42807R001 KC7215	I27
3.42807R001 KMF	I27
3.42807R021 KC7015	I27
3.42807R021 KC7315	I27
3.42807R081 KC7215	I27
3.76045R028V	J72–73
3.76050R028V	J72–73
3.76055R032V	J72–73
3.76058R032V	J72–73
3.76063R032V	J72–73
3.76063R040V	J72–73
3.76068R040V	J72–73
3.76073R040V	J72–73
3.76078R040V	J72–73
3.76078R048V	J72–73
3.76084R048V	J72–73
3.76090R048V	J72–73
3.76096R048V	J72–73
3.76096R058V	J72–73
3.76102R058V	J72–73
3.76108R058V	J72–73
3.76115R070V	J72–73
3.76122R070V	J72–73
3.76130R070V	J72–73
3.76140R080V	J72–73
3.76150R080V	J72–73
3.76158R080V	J72–73
3.76162R080V	J72–73
3.76180R110	J72–73
3.76195R110	J72–73
3.76213R125	J72–73
3.76230R160	J72–73
3.76260R160	J72–73
3.77000R023V	J74
3.77000R024V	J74
3.77000R025V	J74
3.77000R026V	J74
3.77000R027V	J74
3.77000R028V	J74
3.77000R029V	J74
3.77000R030V	J74
3.77000R031V	J74
3.77000R038V	J74
3.77000R039V	J74
3.77000R048V	J74
3.77000R049V	J74
3.77000R050V	J74
3.77000R051V	J74
3.77000R052V	J74
3.77000R053V	J74
3.77000R073V	J74
3.77000R074V	J74
3.77000R075V	J74
3.77000R076V	J74
3.77000R077V	J74
3.77000R078V	J74
3.77000R079V	J74
3.77000R080V	J74
3.77000R081V	J74
3.77000R082V	J74
3.77000R083V	J74
3.77000R084V	J74
3.77000R085V	J74
3.77000R086V	J74
3.77000R087V	J74
3.77000R088V	J74
3.77000R224V	J75
3.77000R227V	J75
3.77000R228V	J75
3.77000R229V	J75
3.77000R230V	J75
3.77000R231V	J75
3.77000R239V	J75
3.77000R248V	J75
3.77000R249V	J75
3.77000R250V	J75
3.77000R251V	J75
3.77000R252V	J75
3.77000R253V	J75
3.77000R274V	J75
3.77000R276V	J75
3.77000R278V	J75
3.77000R280V	J75
3.77000R282V	J75
3.77000R284V	J75
3.77000R286V	J75
3.77000R288V	J75
3.90016ECGD KMF	U9
3.90016SNGB KC735M	U9
3.90016SNGB KCPK30	U9
3.90016SNGD KC735M	U9
3.90016SNGD KCPK30	U9
3.90022ECGD KMF	U9
3.90022SNGB KC735M	U9
3.90022SNGB KCPK30	U9
3.90022SNGD KC735M	U9
3.90022SNGD KCPK30	U9
3.90030ECGD KMF	U9
3.90030SNGB KC735M	U9
3.90030SNGB KCPK30	U9
3.90030SNGD KC735M	U9
3.90030SNGD KCPK30	U9
3.90040ECGD KMF	U9
3.90040SNGB KC735M	U9
3.90040SNGB KCPK30	U9
3.90040SNGD KC735M	U9
3.90040SNGD KCPK30	U9
302.009	J79
302.010	J79
302.011	J79
302.014	J81
30X1R052B25STN27N	W40
30X1R092B25STN27L	W41
315K18LK90SD12N18K	U41
315K18NK90SD12N18K	U42
315K18NK90SD12N20K	U43
315K20NK90SP10N16K	U31
315Y18NK90SD12N18K	U48
315Y18NK90SD12N20K	U49
315Y20NK90SP10N16K	U35
315Z328RF60HN09WSC	S94
32A02R040M16SED18	T69
32A02R050A32SED18-200	T71
32A03R039B32SSP10G	T97
32A03R040A32RP12L190	V71
32A03R040B32RP12	V70
32A03R040M16SED14	T47
32A03R040M16SED18	T69
32A03R050A25SED14	T49
32A03R050A25SED18	T71
32A03R050A32SED14	T49
32A03R050A32SED14-200	T49
32A03R050A32SED18	T71
32A03R050A32SED18-200	T71
32A03R050B32SED14	T48
32A03R050B32SED18	T70
32A04R040A32ED10	T31
32A04R040B32ED10	T30
32A04R040M16ED10	T29
32A04R040M16SED14	T47
32A04R048A32ED10-200	T32
32A04R048A32ED10R31-200	T32
32A04R050A25SED14	T49
32A04R050A32SED14	T49
32A04R050A32SED14-200	T49
32A04R050B32SED14	T48
32A05R040A32ED10	T31
32A05R040B32ED10	T30
32A05R040M16ED10	T29
32A05R048A32ED10-200	T32
32A05R048A32ED10R31-200	T32
32E03R045M16RP12	V70
32M2R040A25SSD12PL	V138
32M2R050M16SSD12PL	V137
32MHC060M	G85
32MHC070M	G85
32MHC080M	G85
32MHC090M	G85
32MHC100M	G85
32MHC110M	G85
32MHC120M	G85
32MHC130M	G85
32MHC140M	G85
32MHC150M	G85
32MHC160M	G85
34A03R050A32SED18-250	T71
35E04R050A32RP12L200	V71
35X1R055B32STNB38N	W41
360.510	I23
360.511	I23
360.513	I23
360.550	I23–24
360.551	H64, I23–24
360.630	I23, I26
360.631	I23, I26
360.632	I23, I26
360.633	I23, I26
360.634	I23
360.635	I23, I26
360.636	I23, I26
360.637	I26
360.660	H64
360.661	H64
360.663	H64
360.664	H64
360.665	H64
360.666	H64
360.667	H64
360.668	H64
360.669	H64
360.670	H64
364.010	H58–59, H61, H63, H98
364.011	H58–61, H63, H98
364.012	H58, H60–63, H98–99
364.013	H58, H60, H62–63, H99
364.015	H58, H60, H63, H99
364.016	H58–59, H61, H63, H98
364.017	H58–59, H61, H63
37X1R058B32STN27N	W40
37X1R098B32STN27L	W41
3CH0100MS004A KC633M	Q20
3CH0150MS004A KC633M	Q20
3CH0200DL006A KC633M	Q18
3CH0200DL006B KC633M	Q18
3CH0200MS006A KC633M	Q20
3CH0250DK003A KC633M	Q18
3CH0250DK003B KC633M	Q18
3CH0250DL007A KC633M	Q18
3CH0250DL007B KC633M	Q18
3CH0250MS006A KC633M	Q20
3CH0300DK004A KC633M	Q18
3CH0300DK004B KC633M	Q18
3CH0300DL007A KC633M	Q18
3CH0300DL007B KC633M	Q18
3CH0300MS009A KC633M	Q20
3CH0300MX019A KC633M	Q20
3CH0300MX019B KC633M	Q20
3CH0350DK004A KC633M	Q18
3CH0350DK004B KC633M	Q18
3CH0350DL007A KC633M	Q18
3CH0350DL007B KC633M	Q18
3CH0400DK005A KC633M	Q18
3CH0400DK005B KC633M	Q18

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
3CH0400DL008A KC633M	Q18
3CH0400DL008B KC633M	Q18
3CH0400MS012A KC633M	Q20
3CH0400MX019A KC633M	Q20
3CH0450DK005A KC633M	Q18
3CH0450DK005B KC633M	Q18
3CH0450DL008A KC633M	Q18
3CH0450DL008B KC633M	Q18
3CH0500DK006A KC633M	Q18
3CH0500DK006B KC633M	Q18
3CH0500DL010A KC633M	Q18
3CH0500DL010B KC633M	Q18
3CH0500MX020A KC633M	Q20
3CH0500MX020B KC633M	Q20
3CH0550DK007A KC633M	Q18
3CH0550DK007B KC633M	Q18
3CH0550DL010A KC633M	Q18
3CH0550DL010B KC633M	Q18
3CH0600DK007A KC633M	Q18
3CH0600DK007B KC633M	Q18
3CH0600DL010A KC633M	Q18
3CH0600DL010B KC633M	Q18
3CH0600MS016A KC633M	Q20
3CH0600MS016B KC633M	Q20
3CH0600MX028A KC633M	Q20
3CH0600MX028B KC633M	Q20
3CH0700DK008A KC633M	Q18
3CH0700DK008B KC633M	Q18
3CH0700DL013A KC633M	Q18
3CH0700DL013B KC633M	Q18
3CH0800DK009A KC633M	Q18
3CH0800DK009B KC633M	Q18
3CH0800DL016A KC633M	Q18
3CH0800DL016B KC633M	Q18
3CH0800MS019A KC633M	Q20
3CH0800MX028A KC633M	Q20
3CH0800MX028B KC633M	Q20
3CH1000DK011A KC633M	Q18
3CH1000DK011B KC633M	Q18
3CH1000DL019A KC633M	Q18
3CH1000DL019B KC633M	Q18
3CH1000MS022A KC633M	Q20
3CH1000MS022B KC633M	Q20
3CH1000MX032A KC633M	Q20
3CH1000MX032B KC633M	Q20
3CH1200DK012A KC633M	Q18
3CH1200DK012B KC633M	Q18
3CH1200DL022A KC633M	Q19
3CH1200DL022B KC633M	Q19
3CH1200MS025A KC633M	Q20
3CH1200MS025B KC633M	Q20
3CH1200MX045A KC633M	Q20
3CH1200MX045B KC633M	Q20
3CH1400DK014A KC633M	Q19
3CH1400DK014B KC633M	Q19
3CH1400DL022A KC633M	Q19
3CH1400DL022B KC633M	Q19
3CH1600DK016A KC633M	Q19
3CH1600DK016B KC633M	Q19
3CH1600DL026A KC633M	Q19
3CH1600DL026B KC633M	Q19
3CH1600MS032A KC633M	Q20
3CH1600MS032B KC633M	Q20
3CH1600MX056A KC633M	Q20
3CH1600MX056B KC633M	Q20
3CH1800DK018A KC633M	Q19
3CH1800DK018B KC633M	Q19
3CH1800DL026A KC633M	Q19
3CH1800DL026B KC633M	Q19
3CH2000DK020A KC633M	Q19
3CH2000DK020B KC633M	Q19
3CH2000DL032A KC633M	Q19
3CH2000DL032B KC633M	Q19
3CH2000MX064A KC633M	Q20
3CH2000MX064B KC633M	Q20
4.81201R011 KCK15	S77
4.96082-204	U13
4.96102-204	U13
4.96102-205	U13
4.96102-206	U13
4.96124-204	U13
4.96124-205	U13
4.96124-210	U13
4.96124-212	U13
4.96164-204	U13
4.96164-205	U13
4.96164-210	U13
4.96205-208	U13
4.96255-206	U13
4.96255-208	U13
4.97060116	U7
4.97060130	U7
4.97060140	U7
4.97080116	U7
4.97080122	U7
4.97080130	U7
4.97080140	U7
4.97101116	U7
4.97101122	U7
4.97101130	U7
4.97101140	U7
4.97123116	U7
4.97123122	U7
4.97123130	U7
4.97123140	U7
4.97164122	U7
4.97164130	U7
4.97164140	U7
4.97204130	U7
4.97204140	U7
4.97254130	U7
40A02R110S63SKE25	T81
40A02R50A32SKE25	T79
40A02R80A32SKE25	T79
40A02RP90BG15CM	S143
40A02RP90BG15CPM	S144
40A03R040M16SED18	T69
40A03R050A32SED18-200	T71
40A03R050A32SED18-250	T71
40A03R050B32SED18	T70
40A03RS45SE14EG	S41
40A04R040M16SED14	T47
40A04R040M16SED18	T69
40A04R049B32SSP10G	T97
40A04R050A32SED14	T49
40A04R050A32SED14-200	T49
40A04R050A32SED18	T71
40A04R050A32SED18-200	T71
40A04R050A32SED18-250	T71
40A04R050B32SED14	T48
40A04R050B32SED18	T70
40A04RS90ED10D	T33
40A04RS90ED14D	T50
40A04RS90RP12	V72
40A05R040M16SED14	T47
40A05R050A32SED14	T49
40A05R050A32SED14-200	T49
40A05R050B32SED14	T48
40A05RS90ED14D	T50
40A06R040M16ED10	T29
40A06RS90ED10D	T33
40E02R040A32RP16L200	V77
40E03R045M16RP16	V77
40E04R045M16RP12	V70
40M3R040A32SSD12PL	V138
40M3R050M16SSD12PL	V137
410.081	E14, S72, S76
410.083	S143–147
410.084	E17–18, S79, S82
410.085	S68
410.091	E17–18
420.060	S68, S143–147
420.080	S143–144
420.100	S72, S76, S102–103, S143–144, S146
420.102	S72
420.104	S68
420.120	S68, S76, S79, S82, S102–103, S143–144, S146–147
420.160	S32, S34, S68, S72, S76, S79, S82, S143–144, S146
420.200	S10, S14, S17, S21, S25, S32, S34, S48, S53, S68, S72, S76, S79, S82, S102–103, S132, S143–144, S146, T17, T50, T72
42A04RS90RP12	V72
42A06R040M16ED10	T29
42X2R045B32STN27D	W43
460.716	J81
460.887	U8
460.888	U7–8
460.889	U7–8
460.890	U7–8
460.897	U7–8
460.898	U7–8
460.899	U7–8
46X1R100B40STNB38L	W41
470.232	S10, S14, S17, S21, S25, S32, S34, S48, S53, S68, S72, S76, S79, S82, S102–103, S143–144, S146, T50, T72
470.233	S17, S21, S25, S32, S34, S48, S53, S68, S72, S76, S79, S82, S102–103, S143–144, S146, T17, T50, T72
470.234	S21, S25, S34, S68, S72, S76, S79, S82, S102, S144, S146
470.235	S21, S25, S34, S68, S144
470.236	S21, S25
470.269	S132
470.270	S132
470.271	S132
470.272	S132
470.273	S132
479.100	S72, S76, S79, S82
4BN0300DL008A KC633M	Q29
4BN0300MR020A KC633M	Q31
4BN0400DD011A KC633M	Q30
4BN0400DL011A KC633M	Q29
4BN0400MR025A KC633M	Q31
4BN0500DD013A KC633M	Q30
4BN0500DL013A KC633M	Q29
4BN0500MR030A KC633M	Q31
4BN0600DD013A KC633M	Q30
4BN0600DL013A KC633M	Q29
4BN0600MR030A KC633M	Q31
4BN0800DD019A KC633M	Q30
4BN0800DL019A KC633M	Q29
4BN0800MR040A KC633M	Q31
4BN1000DD022A KC633M	Q30
4BN1000DL022A KC633M	Q29
4BN1000MR040A KC633M	Q31
4BN1200DD026A KC633M	Q30
4BN1200DL026A KC633M	Q29
4BN1200DL026B KC633M	Q29
4BN1200ML045A KC633M	Q31
4BN1200MR025A KC633M	Q31
4BN1400DD026A KC633M	Q30
4BN1400DL026A KC633M	Q29
4BN1600DD032A KC633M	Q30
4BN1600DL032A KC633M	Q29
4BN1600DL032B KC633M	Q29
4BN1600MR032A KC633M	Q31
4BN1800DD032A KC633M	Q30
4BN1800DL032A KC633M	Q29
4BN1800DL032B KC633M	Q29
4BN1800MR038A KC633M	Q31
4BN2000DD038A KC633M	Q30
4BN2000DL038A KC633M	Q29
4BN2000DL038B KC633M	Q29
4BN2000MR056A KC633M	Q31
4CH0200DK004A KC633M	Q24
4CH0200MR006A KC633M	Q27
4CH0250DL008A KC633M	Q24
4CH0300DK005A KC633M	Q24
4CH0300ML019A KC633M	Q27
4CH0300MR009A KC633M	Q27
4CH0300MX025A KC633M	Q27
4CH0350DL010A KC633M	Q24
4CH0400DD011A KC633M	Q26
4CH0400DK008A KC633M	Q24
4CH0400DL011A KC633M	Q24
4CH0400ML019A KC633M	Q27
4CH0400MR011A KC633M	Q27
4CH0400MX031A KC633M	Q27
4CH0450DL011A KC633M	Q24
4CH0500DD013A KC633M	Q26
4CH0500DK009A KC633M	Q24
4CH0500DL013A KC633M	Q24
4CH0500MR030A KC633M	Q27
4CH0550DL013A KC633M	Q24
4CH0600DD013A KC633M	Q26
4CH0600DK010A KC633M	Q24
4CH0600DL013A KC633M	Q24
4CH0600ML028A KC633M	Q27
4CH0600MR016A KC633M	Q27
4CH0600MX038A KC633M	Q27
4CH0650DL016A KC633M	Q24
4CH0700DK011A KC633M	Q24
4CH0700DL016A KC633M	Q24
4CH0800DD019A KC633M	Q26
4CH0800DK012A KC633M	Q24
4CH0800DL019A KC633M	Q24
4CH0800ML028A KC633M	Q27
4CH0800MR020A KC633M	Q27
4CH0800MX041A KC633M	Q27
4CH0900DK013A KC633M	Q24
4CH0900DL019A KC633M	Q24
4CH1000DD022A KC633M	Q26
4CH1000DK014A KC633M	Q24
4CH1000DL022A KC633M	Q24
4CH1000ML032A KC633M	Q27
4CH1000MR022A KC633M	Q27
4CH1000MX045A KC633M	Q27
4CH1200DD026A KC633M	Q26
4CH1200DK016A KC633M	Q24
4CH1200DK016B KC633M	Q24
4CH1200DL026A KC633M	Q24
4CH1200DL026B KC633M	Q24
4CH1200ML045A KC633M	Q27
4CH1200ML045B KC633M	Q27
4CH1200MR025A KC633M	Q27
4CH1200MR025B KC633M	Q27
4CH1200MX075A KC633M	Q27
4CH1200MX075B KC633M	Q27
4CH1400DD026A KC633M	Q26
4CH1400DK018A KC633M	Q24
4CH1400DK018B KC633M	Q24
4CH1400DL026A KC633M	Q25
4CH1400DL026B KC633M	Q25
4CH1400ML050A KC633M	Q27
4CH1400ML050B KC633M	Q27
4CH1400MR032A KC633M	Q27
4CH1400MR032B KC633M	Q27
4CH1400MX075A KC633M	Q27
4CH1400MX075B KC633M	Q27
4CH1600DD032A KC633M	Q26
4CH1600DK022A KC633M	Q25
4CH1600DK022B KC633M	Q25
4CH1600DL032A KC633M	Q25
4CH1600DL032B KC633M	Q25
4CH1600ML056A KC633M	Q28
4CH1600ML056B KC633M	Q28
4CH1600MR032A KC633M	Q27
4CH1600MR032B KC633M	Q27
4CH1600MX075A KC633M	Q28
4CH1600MX075B KC633M	Q28
4CH1800DD032A KC633M	Q26
4CH1800DK024A KC633M	Q25
4CH1800DK024B KC633M	Q25
4CH1800DL032A KC633M	Q25
4CH1800DL032B KC633M	Q25
4CH1800ML060A KC633M	Q28
4CH1800ML060B KC633M	Q28
4CH1800MR038A KC633M	Q28
4CH1800MR038B KC633M	Q28
4CH1800MX075A KC633M	Q28
4CH1800MX075B KC633M	Q28
4CH2000DD038A KC633M	Q26
4CH2000DK026A KC633M	Q25
4CH2000DK026B KC633M	Q25
4CH2000DL038A KC633M	Q25
4CH2000DL038B KC633M	Q25
4CH2000ML056A KC633M	Q28
4CH2000ML056B KC633M	Q28
4CH2000MR038A KC633M	Q28
4CH2000MR038B KC633M	Q28
4CH2000MX075A KC633M	Q28
4CH2000MX075B KC633M	Q28

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
5.34032-025115	J78
5.34032-025200	J78
5.34032-028115	J78
5.34032-028200	J78
5.34032-032125	J78
5.34050-025300	J78
5.34050-025450	J78
5.34050-028300	J78
5.34050-028450	J78
5.34050-032200	J78
5.34050-032350	J78
5.34050-032500	J78
5.34050-040148	J78
5.34050-040300	J78
5.34050-040450	J78
5.34050-040600	J78
5.34050-048168	J78
5.34050-048300	J78
5.34050-048450	J78
5.34050-048600	J78
5.34050-058186	J78
5.34050-058300	J78
5.34050-058450	J78
5.34050-058600	J78
5.34125R025150	J77
5.34128R028150	J77
5.34132R032100	J77
5.34132R032200	J77
5.34140R040200	J77
5.34148R048200	J77
5.34158R058300	J77
5.34170R070186	J77
5.34170R070300	J77
5.34170R070500	J77
5.34180R080204	J77
5.34180R080300	J77
5.34180R080500	J77
5.34240R032100	J77
5.34248R040100	J77
5.34258R048100	J77
5.34270R058100	J77
5.34280R028080	J77
5.34280R032080	J77
5.34280R040080	J77
5.34280R048080	J77
5.34280R058080	J77
5.34280R070150	J77
5.34350-090100	J81
5.36050-154040	J80
5.36050-154050	J80
50A02R100A32SKE25	T79
50A03R049A32PBG15S3WHPM	S145
50A03R060S63PBG15S3WHSM	S147
50A03R140S63SKE25	T81
50A03R80A32SKE25	T79
50A03RP90BG15CM	S143
50A03RP90BG15CPM	S144
50A03RS45SE14EG	S41
50A03RS90SD12DG	T102
50A04RP70SP12CFP	S72
50A04RP90SP12CFP	S76
50A04RS45SE14EG	S41
50A04RS90ED18D	T72
50A04RS90RP12	V72
50A04RS90RP16	V78
50A04RS90SD12DG	T102
50A04RS90SD12PL	V139
50A05RP70SP12CFP	S72
50A05RP90SP12CFP	S76
50A05RS90ED10D	T33
50A05RS90ED14D	T50
50A05RS90ED18D	T72
50A05RS90RP12	V72
50A05RS90SD12PL	V139
50A05RS90SD12PLHF	V139
50A05RS90SP10DG	T98
50A06RP70SP12CFP	S72
50A06RS90ED14D	T50
50A08RS90ED10D	T33
50A3RS90SD12L32	T109
50HC030M	G85
50HC040M	G85
50HC050M	G85
50HC060M	G85
50HC080M	G85
50HC100M	G85
511.011	B138
511.018	B111, B113, B135, B138, B163
511.022	B68, B73, B114, B120–121
511.023	B64–66, B68, B73, B111–114, B135, B138, B163, B165
511.024	B87–88, B91
511.025	B64–65, B68, B111–113
511.030	B142, B165
511.033	B64–66, B111–113
511.038	B111
511.060	B87–88
512.013	B135, B138
512.023	B135, B138
512.025	B111–113
512.053	B111, B113
512.060	B87–88
512.063	B111–114
512.083	B111–113
512.092	B111
512.112	B64–66, B68–69, B73
512.117	B64–65, B68
512.123	B64–66
512.125	B136
512.126	B136
512.131	B162
512.134	B163
512.135	B163, B165
512.153	B87–88, B91
513.018	B135, B138, B163
513.019	B111, B113
513.023	B64–66, B68–69, B73, B87–88, B91, B111–114, B135, B138, B163, B165
513.025	B64–65, B68, B111–113
513.033	B64–66, B111–113
513.038	B111
513.060	B87–88
513.125	B136
513.126	B136
513.132	B162
514.111	B138
514.112	B142, B165
514.118	B87–88, B111, B113, B135, B138, B163
514.122	B68, B73, B114, B120–121
514.123	B64–66, B68–69, B73, B111–113, B135, B138, B163, B165
514.124	B114
514.125	B64–65, B68, B111–113
514.128	B87–88, B91
514.133	B64–66, B111–113
514.138	B111
515.018	B64–66, B68–69, B87–88, B91, B111–114, B135, B138, B163, B165
515.022	B64–66, B68, B111–113
515.028	B111
5230VS09-A050Z4R51	T115
5230VS09-A050Z4R80	T115
5230VS12-A063Z4R57	T118
5230VS12-A063Z4R94	T118
5230VS12-A080Z5R110	T118
5230VS12-A080Z5R65	T118
5230VS12-A100Z6R133	T118
5230VS12-A100Z6R76	T118
52A02RS90KE25	T80
52A04RS90RP16	V78
52A05RS90RP12	V72
52A05RS90SD12PLHF	V139
536.091	J47
5505VX16CA20/016R30	V104
5505VX16SA016R25	V101
5505VX20CA25/020R40	V104
5505VX20SA020R35	V101
5505VX20WA020R34	V103
5505VX25CA025R55	V104
5505VX25CA32/025R55	V104
5505VX25SA025R40	V101
5505VX25WA025R60	V102
5505VX25WA025R69	V103
5505VX32CA032R65	V104
5505VX32SA032R50	V101
5505VX32WA032R100	V102
5505VX32WA032R75	V102
5505VX40WA040R100	V102
5505VX40WA040R150	V102
5505VX50WA050R100	V102
5505VX50WA050R150	V102
551.013	B356
551.125	B136
551.126	B136
551.131	B162
551.316	B358–361, B363–367, B369, B372–374
551.317	B358–361, B363–367, B372–373
551.332	B360
551.333	B362, B368
552.210	B369, B374
552.220	B358, B372
552.221	B356, B358–359, B372
552.225	B359–360
552.228	B360
552.229	B362
552.230	B362
552.231	B363–366
552.232	B363–367, B373
552.234	B364–365
552.235-H	B368
552.236	B368
552.240	B361
554.252	B356, B358–367, B369, B372–374
554.253	B364–365
554.254	B359–360, B368
557.111	B358–368, B372–373
557.125	B358, B361
570.850	J47
5720VZ16-A040Z3R	T88
5720VZ16-A050Z03R	T88
5720VZ16-A050Z04R	T88
5720VZ16-A063Z4R S	T88
5720VZ16-A063Z5R S	T88
5720VZ16-A080Z04R	T88
5720VZ16-A080Z5R	T88
5720VZ16CA025Z2R75	T87
5720VZ16CA032Z2R75 S	T87
5720VZ16CA032Z3R75 S	T87
5720VZ16HA025Z2R75	T89
5720VZ16HA032Z3R75	T89
5720VZ16HA040Z4R75	T89
5720VZ16HA050Z4R75	T89
5720VZ16SA025Z2R50	T86
5720VZ16SA032Z2R50	T86
5720VZ16SA032Z3R50	T86
63A02RS90KE25	T80
63A03RP90BG15CM	S143
63A03RS90KE25	T80
63A04RP00MD10CF	S68
63A04RP90BG15C1WPM	S144
63A04RP90BG15C4WHPM	S146
63A04RS45SE14EG	S41
63A04RS90RC20C	V82
63A04RS90RP16	V78
63A04RS90SD12DG	T102
63A05RS45SE14EG	S41
63A05RS90ED18D	T72
63A05RS90RP12	V72
63A05RS90SD12DG	T102
63A05RS90SD12PL	V139
63A06RF84SN12B	S102
63A06RP00MD10CF	S68
63A06RP90SP12CFP	S76
63A06RS90ED10D	T33
63A06RS90ED14D	T50
63A06RS90ED18D	T72
63A06RS90RP16	V78
63A06RS90SD12PL	V139
63A06RS90SD12PLHF	V139
63A06RS90SP10DG	T98
63A07RP90SP12CFP	S76
63A07RS90ED14D	T50
63A07RS90RP12	V72
63A08RP90SP12CFP	S76
63A09RF84SN12B	S102
63A09RF84SN12B1W	S103
63A09RS90ED10D	T33
63A3RS90SD12L50	T109
63B05RP70SP12CFP	S72
63B07RP70SP12CFP	S72
63B08RP70SP12CFP	S72
66A06RS90RP12	V72
66A06RS90SD12PLHF	V139
75HC030M	G85
75HC040M	G85
75HC050M	G85
75HC060M	G85
75HC080M	G85
75HC100M	G85
75HC120M	G85
75HC140M	G85
75HC160M	G85
7713VR10-A040Z05R	V89
7713VR10-A042Z06R	V89
7713VR10-A050Z06R	V89
7713VR10-A050Z07R	V89
7713VR10-A063Z08R	V89
7713VR10CA020Z2R40	V88–89
7713VR10CA025Z3R50	V88–89
7713VR10CA032Z3R70	V88–89
7713VR10CA032Z4R70	V88–89
7713VR10SA020Z2R25 S	V87, V89
7713VR10SA025Z2R35 S	V87, V89
7713VR10SA025Z3R35 S	V87, V89
7713VR10SA032Z3R35 S	V87, V89
7713VR10SA032Z4R35 S	V87, V89
7713VR10SA035Z5R35 S	V87, V89
7713VR12-A040Z04R	V94
7713VR12-A040Z05R	V94
7713VR12-A050Z05R	V94
7713VR12-A050Z06R	V94
7713VR12-A052Z05R	V94
7713VR12-A052Z06R	V94
7713VR12-A063Z06R	V94
7713VR12-A063Z07R	V94
7713VR12-A066Z06R	V94
7713VR12-A066Z07R	V94
7713VR12-A080Z08R	V94
7713VR12CA025Z2R50	V93–94
7713VR12CA032Z3R70	V93–94
7713VR12SA025Z2R35 S	V93–94
7713VR12SA032Z3R35 S	V93–94
7713VR12SA040Z4R43 S	V93–94
7713VR12SA040Z5R43 S	V93–94
7792VXD09-A040Z3R	V12–13
7792VXD09-A040Z4R	V12–13
7792VXD09-A040Z5R	V12–13
7792VXD09-A050Z5R	V12–13
7792VXD09-A050Z6R	V12–13
7792VXD09-A050Z7R	V12–13
7792VXD09-A052Z5R	V12–13
7792VXD09-A052Z6R	V12–13
7792VXD09-A052Z7R	V12–13
7792VXD09-A063Z5R	V12–13
7792VXD09-A063Z6R	V12–13
7792VXD09-A063Z9R	V12–13
7792VXD09-A066Z5R	V12–13
7792VXD09-A066Z6R	V12–13
7792VXD09-A066Z9R	V12–13
7792VXD09CA025Z2R50	V11, V13
7792VXD09CA025Z3R50	V11, V13
7792VXD09CA032Z3R70	V11, V13
7792VXD09CA032Z4R70	V11, V13
7792VXD09SA025Z2R35 S	V9, V13
7792VXD09SA025Z3R35	V9, V13
7792VXD09SA032Z3R43 S	V9, V13
7792VXD09SA032Z4R43	V9, V13
7792VXD09SA035Z3R43	V9
7792VXD09SA035Z4R43	V9, V13
7792VXD09SA042Z5R43	V9, V13
7792VXD09WA025Z2R	V10, V13
7792VXD09WA032Z3R	V10, V13
7792VXD12-160Z7R	V20–22
7792VXD12-A040Z4R	V20–22
7792VXD12-A050Z4R	V20–21
7792VXD12-A050Z6R	V20–22
7792VXD12-A052Z3R	V20–22

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
7792VXD12-A052Z4R	V20–22
7792VXD12-A052Z5R	V20–22
7792VXD12-A052Z6R	V20–22
7792VXD12-A063Z4R	V20–22
7792VXD12-A063Z5R	V20–22
7792VXD12-A063Z7R	V20–22
7792VXD12-A066Z4R	V20–22
7792VXD12-A066Z5R	V20–22
7792VXD12-A066Z7R	V20–22
7792VXD12-A080Z10R	V20–22
7792VXD12-A080Z5R	V20–22
7792VXD12-A080Z8R	V20–22
7792VXD12-A100Z11R	V20–22
7792VXD12-A100Z6R	V20–22
7792VXD12-A100Z9R	V20–22
7792VXD12-A125Z11R	V20–22
7792VXD12-A125Z13R	V20–22
7792VXD12-A125Z8R	V20–22
7792VXD12CA032Z2R70	V19, V22
7792VXD12CA032Z3R70	V19, V22
7792VXD12SA032Z2R43 S	V18, V22
7792VXD12SA032Z3R43	V18, V22
7792VXD12SA035Z3R43	V18, V22
7792VXD12SA042Z4R43	V18, V22
7792VXE16-160Z12R	V28–29
7792VXE16-160Z13R	V28–29
7792VXE16-A050Z3R	V28–29
7792VXE16-A050Z4R	V28–29
7792VXE16-A052Z4R	V28–29
7792VXE16-A063Z5R	V28–29
7792VXE16-A063Z6R	V28–29
7792VXE16-A066Z6R	V28–29
7792VXE16-A080Z6R	V28–29
7792VXE16-A080Z7R	V28–29
7792VXE16-A100Z8R	V28–29
7792VXE16-A100Z9R	V28–29
7792VXE16-A125Z10R	V28–29
7792VXE16-A125Z11R	V28–29
7792VXE16CA040Z2R102	V27, V29
7792VXE16CA050Z3R102	V27
7792VXP06CA016Z2R140	V5–6
7792VXP06CA020Z3R154	V5–6
7792VXP06CA025Z4R154	V5–6
7792VXP06CA032Z5R190 S	V5–6
7792VXP06SA016Z2R25 S	V4, V6
7792VXP06SA020Z2R35 S	V4, V6
7792VXP06SA020Z3R35 S	V4, V6
7792VXP06SA025Z3R35 S	V4, V6
7792VXP06SA025Z4R35 S	V4, V6
7792VXP06SA032Z5R43 S	V4, V6
7792VXP06SA035Z6R43	V4, V6
80A03RP90BG15CM	S143
80A05R090S63PBG15S5WHSM	S147
80A05RP90BG15C1WPM	S144
80A05RP90BG15C5WHPM	S146
80A05RP90SP15C1WFP	S82
80A05RS45SE14EG	S41
80A05RS90RC20C	V82
80A05RS90RP16	V78
80A05RS90SD12DG	T102
80A05RS90SD12PL	V139
80A06RP00MD10CF	S68
80A06RP90BG15C2WPM	S144
80A06RP90SP12C1WFP	S76
80A06RP90SP15C1WFP	S82
80A06RS45SE14EG	S41
80A06RS90ED18D	T72
80A06RS90RP12	V72
80A06RS90SD12DG	T102
80A06RS90SD12PL	V139
80A07RP70SP15C1WFP	S79
80A07RS90ED14D	T50
80A07RS90ED18D	T72
80A07RS90RP16	V78
80A07RS90SD12PL	V139
80A07RS90SD12PLHF	V139
80A08RF84SN12B	S102
80A08RP90SP12C2WFP	S76
80A08RS90ED10D	T33
80A08RS90RP12	V72
80A08RS90SP10DG	T98
80A09RP00MD10CF	S68
80A09RS90ED14D	T50
80A10RF45HN09C	S89
80A10RP90SP12CFP	S76
80A10RS90ED10D	T33
80A12RF84SN12B	S102
80A12RF84SN12B2W	S103
80A4RS90SD12L61	T109
80A62RF60HN09C	S94
80B06RP70SP12C1WFP	S72
80B08RP70SP12C2WFP	S72
80B10RP70SP12CFP	S72
80F08NS90LN12N06	U17
80F08NS90LN12N08	U17
80Y08RS90LN12N06	U18
80Y08RS90LN12N08	U18
840.142.200	K118–120
840.142.250	K118–120
840.142.320	K118–119
840.142.420	K118–119
840.142.550	K118–119
840.142.720	K118–119
840.142.940	K118–119
841.142.200	K118–120
841.142.250	K118–120
841.142.320	K118–119
841.142.420	K118–119
841.142.550	K118–119
841.142.720	K118–119
841.142.940	K118–119
841.342.200	K118–120
841.342.420	K118–119
843.006.000	K120–122, K136
843.009.000	K120–122, K136
843.012.000	K120–122
844.012.000	K120–122
844.016.000	K120–122
845.012.000	K120–122
845.016.000	K120–122
846.012.000	K120–122
846.016.000	K120–122
847.012.000	K120–122
847.016.000	K120–122
848.200.005	K121
848.200.407	K120–122
848.250.005	K121
848.250.409	K120–122
848.320.005	K121
848.320.413	K120–122
848.420.005	K121
848.420.614	K120–122
848.550.005	K121
848.550.620	K120–122
848.720.000	K120–122
848.720.005	K121
848.940.640	K120, K122
880.252.200	K133, K135
880.252.250	K133, K135
880.252.320	K133–134
880.252.420	K133–134
880.252.550	K133–134
881.252.200	K133, K135
881.252.250	K133, K135
881.252.320	K133–134
881.252.420	K133–134
881.252.550	K133–134
881.252.720	K133
881.252.940	K133
886038045	K132
9X1R012B12STN10M	W40
9X1R017B20STN10M	W40
A0410ESCLDRS412	B187
A0410ESCLDRS425	B187
A0412ESCLDRS412	B187
A0412ESCLDRS425	B187
A04XSCLDLS4	B186
A04XSCLDRS4	B186
A0510ESCFDRS412	B185
A0510ESCFDRS425	B185
A0510ESCLDRS412	B187
A0510ESCLDRS425	B187
A0510GSCLDRS4	B187
A05XSCLDLS4	B186
A05XSCLDRS4	B186
A0610HSCLDRS4	B187
A0612ESCFDRS431	B185
A0612ESCLDRS419	B187
A0612XSTLDR0731	B251
A0616HSTLDR0731	B251
A06HSTFDR07	B250
A06HSTLDR07	B250
A06HSWUPRS3	B273
A06MSWLCR2	B271
A06XSCLDLS4	B186
A06XSCLDRS4	B186
A08HSTFDR07	B250
A08HSTLDR07	B250
A08HSWUPRS3	B273
A08JSCFPL06	B194
A08JSCFPR06	B194
A08JSCLCL06	B182
A08JSCLCR06	B182
A08JSCLPL06	B196
A08JSCLPR06	B196
A08JSTFPL09	B257
A08JSTFPR09	B257
A08RSWLCR2	B271
A08XSCLDLS4	B186
A08XSCLDRS4	B186
A1010LSEL11	D81
A1010LSER11	D81
A1020LSEL11	D81
A1020LSER11	D81
A10KNNTOR1	C170, D37
A10KSCFPL06	B194
A10KSCFPR06	B194
A10KSCLCL06	B182
A10KSCLCR06	B182
A10KSCLPL06	B196
A10KSCLPR06	B196
A10KSCXPR06	B198
A10KSDUCL07	B213
A10KSDUCR07	B213
A10KSTFCL11	B248
A10KSTFCR11	B248
A10KSTFPL11	B257
A10KSTFPR11	B257
A10KSTWPL11	B259
A10KSTWPR11	B259
A10KSWLCR04	B271
A10SSWLCR3	B271
A12KEVEML0205M	C47
A12KEVEML1F05M	C47
A12KEVEMR0205M	C46
A12KEVEMR1F05M	C46
A12MNKLCL11	E40
A12MNKLCR11	E40
A12MNNTOL2	C169, D36
A12MNNTOR1	C170, D37
A12MNNTOR2	C169, D36
A12MSCFPL06	B194
A12MSCFPR06	B194
A12MSCLCL06	B182
A12MSCLCR06	B182
A12MSCLPL06	B196
A12MSCLPR06	B196
A12MSCXPR06	B198
A12MSDQCL07	B212
A12MSDQCR07	B212
A12MSDQPL07	B217
A12MSDQPR07	B217
A12MSDUCL07	B213
A12MSDUCR07	B213
A12MSDUPL07	B217
A12MSDUPR07	B217
A12MSDXPL07	B218
A12MSDXPR07	B218
A12MSTFCL11	B248
A12MSTFCR11	B248
A12MSTFDL11	B250
A12MSTFPL11	B257
A12MSTFPR11	B257
A12MSTWPR11	B259
A12MSWLCR04	B271
A12MSWUPR04	B273
A1320LSEL11	D81
A1320LSER11	D81
A1320LSER16	D81
A1616LSEL16	D81
A1616LSER16	D81
A1620LSEL16	D81
A1620LSER16	D81
A16MCTUPL11	B174, B371
A16MCTUPR11	B174, B371
A16MEVEML0207M	C47
A16MEVEML0307M	C47
A16MEVEML1F07M	C47
A16MEVEMR0207M	C46
A16MEVEMR0307M	C46
A16MEVEMR1F07M	C46
A16MNKLCL11	E40
A16MNKLCR11	E40
A16MNNTOL2	C169, D36
A16MNNTOR2	C169, D36
A16RA4SAL2S12M017021	C120
A16RA4SAR2S12M017021	C120
A16RCTFPR11	B174, B371
A16RPTFNR11	B138
A16RPWLNL06	B165
A16RPWLNR06	B165
A16RSCFPL09	B194
A16RSCFPR06	B194
A16RSCFPR09	B194
A16RSCLCL09	B182
A16RSCLCR09	B182
A16RSCLPL06	B196
A16RSCLPL09	B196
A16RSCLPR06	B196
A16RSCLPR09	B196
A16RSCXPR09	B198
A16RSDQCL07	B212
A16RSDQCR07	B212
A16RSDQPL07	B217
A16RSDQPR07	B217
A16RSDUCL07	B213
A16RSDUCL11	B213
A16RSDUCR07	B213
A16RSDUCR11	B213
A16RSDUPL07	B217
A16RSDUPR07	B217
A16RSDXPL07	B218
A16RSDXPR07	B218
A16RSSKCR09	B235
A16RSTFPL11	B257
A16RSTFPR11	B257
A16RSTWPR11	B259
A16RSVQBL11	B268
A16RSVQBR11	B268
A16RSWLCL06	B271
A16RSWLCR06	B271
A2020LSEL16	D81
A2020LSEL22	D81
A2020LSER16	D81
A2020LSER22	D81
A20QCTFPR11	B174, B371
A20QEVEML0207M	C47
A20QEVEML0307M	C47
A20QEVEML1F07M	C47
A20QEVEMR0207M	C46
A20QEVEMR0307M	C46
A20QEVEMR1F07M	C46
A20QNKLCL11	E40
A20QNKLCR11	E40
A20QNNTOL2	C169, D36
A20QNNTOR2	C169, D36
A20RA4EML0207M	C119
A20RA4EML0307M	C119
A20RA4EML0407M	C119
A20RA4EMR0207M	C119
A20RA4EMR0307M	C119
A20RA4EMR0407M	C119
A20RA4SAL2S12M021026	C120
A20RA4SAR2S12M021026	C120
A20RA4SAR3S14M021026	C120
A20SPTFNL11	B138
A20SPTFNR11	B138
A20SPWLNL06	B165

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
A20SPWLNR06	B165
A20SSCFPL09	B194
A20SSCFPR09	B194
A20SSCKPR09	B195
A20SSCLCL09	B182
A20SSCLCR09	B182
A20SSCLPL09	B196
A20SSCLPR06	B196
A20SSCLPR09	B196
A20SSDQCL11	B212
A20SSDQCR11	B212
A20SSDQPL11	B217
A20SSDQPR11	B217
A20SSDUCL11	B213
A20SSDUCR11	B213
A20SSDUPL11	B217
A20SSDUPR11	B217
A20SSDXPL11	B218
A20SSDXPR11	B218
A20SSTFPL16	B257
A20SSTFPR16	B257
A20SSVQBL11	B268
A20SSVQBR11	B268
A20SSVUBL11	B269
A20SSVUBR11	B269
A20SSWLCR06	B271
A2525LSEL16	D81
A2525LSEL22	D81
A2525LSER16	D81
A2525LSER22	D81
A2532LSEL16	D81
A2532LSER16	D81
A2532LSER22	D81
A25RA4EML0210M	C119
A25RA4EML0310M	C119
A25RA4EML0410M	C119
A25RA4EMR0210M	C119
A25RA4EMR0310M	C119
A25RA4EMR0410M	C119
A25RA4SAL2S12M026036	C120
A25RA4SAL3S14M026036	C120
A25RA4SAR2S12M026036	C120
A25RA4SAR3S14M026036	C120
A25RCTFPL16	B174, B371
A25RCTFPR16	B174, B371
A25RDCLNL12KC04	B66
A25RDCLNR12KC04	B66
A25RDDPNR11KC04	B89
A25RDDQNL11KC04	B89
A25RDDQNR11KC04	B89
A25RDDUNL11KC04	B90
A25RDDUNR11KC04	B90
A25RDTFNL16KC04	B137
A25RDTFNR16KC04	B137
A25RDWLNL06KC04	B163
A25RDWLNL08KC04	B163
A25RDWLNR06KC04	B163
A25RDWLNR08KC04	B163
A25REVEML0210M	C47
A25REVEML0310M	C47
A25REVEML0410M	C47
A25REVEMR0210M	C46
A25REVEMR0310M	C46
A25REVEMR0410M	C46
A25REVSAL0212M026030	C48
A25REVSAL0312M030035	C48
A25REVSAR0212M026030	C48
A25REVSAR0312M030035	C48
A25RMCLNL12	B67
A25RMCLNR09	B67
A25RMCLNR12	B67
A25RMDUNL11	B90
A25RMDUNL15	B90
A25RMDUNR11	B90
A25RMDUNR15	B90
A25RMTFNL16	B137
A25RMTFNR16	B137
A25RMVUNL16	B153
A25RMVUNR16	B153
A25RMWLNL08	B164
A25RMWLNR06	B164
A25RMWLNR08	B164
A25RNKLCL11	E40
A25RNKLCR11	E40
A25RNNTOL2	C169, D36
A25RNNTOL3	C169, D36
A25RNNTOR2	C169, D36
A25RNNTOR3	C169, D36
A25RPWLNL08	B165
A25RPWLNR08	B165
A25TNVQBR11	E42
A25TPCLNL12	B68
A25TPCLNR12	B68
A25TPSKNR12	B114
A25TPTFNL16	B138
A25TPTFNR16	B138
A25TSCFCL12	B182
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A25TSCLCR12	B182
A25TSDQCL11	B212
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A25TSDQPL11	B217
A25TSDQPR11	B217
A25TSDUCL11	B213
A25TSDUCR11	B213
A25TSDUPR11	B217
A25TSTFPL16	B257
A25TSTFPR16	B257
A25TSVQBL16	B268
A25TSVQBR16	B268
A25TSVUBL16	B269
A25TSVUBR16	B269
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A3232LSER22	D81
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A32SA4EML0412M	C119
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A32SA4EMR0412M	C119
A32SA4EMR0516M	C119
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A32SCTFPR16	B174, B371
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A32SDDPNR15KC06	B89
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A32SDDQNR15KC06	B89
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A32SDDUNR15KC06	B90
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A32SDVUNR16KC04	B152
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A32SDWLNR08KC04	B163
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A32SMDUNL15	B90
A32SMDUNR11	B90
A32SMDUNR15	B90
A32SMSKNL12	B114
A32SMTFNL16	B137
A32SMTFNR16	B137
A32SMVUNL16	B153
A32SMVUNR16	B153
A32SMWLNL06	B164
A32SMWLNL08	B164
A32SMWLNR06	B164
A32SMWLNR08	B164
A32SNKLCR11	E40
A32SNNTOL3	C169, D36
A32SNNTOR3	C169, D36
A32SNVOCL16	E42
A32SNVOCR16	E42
A32SNVQCR16	E43
A32SPWLNL08	B165
A32SPWLNR08	B165
A32TSCLCL12	B182
A32TSCLCR12	B182
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A40TDCLNL16KC06	B66
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A40TDDQNR15KC06	B89
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A40TDDUNR15KC06	B90
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A40TDVUNR16KC04	B152
A40TDWLNR08KC04	B163
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A40TEVSAR0312M041050	C48
A40TMCLNL12	B67
A40TMCLNL16	B67
A40TMCLNR12	B67
A40TMCLNR16	B67
A40TMDUNL15	B90
A40TMDUNR15	B90
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A40TMSKNR12	B114
A40TMTFNR16	B137
A40TMWLNL08	B164
A40TMWLNR08	B164
A40TNKLNR15	E41
A40TNNTOL3	C169, D36
A40TNNTOL4	C169, D36
A40TNNTOR3	C169, D36
A40TNNTOR4	C169, D36
A40TNVOCL16	E42
A40TPWLNL08	B165
A40TPWLNR08	B165
A40VCTFPR16	B174, B371
A40VPCLNL12	B68
A40VPCLNL16	B68
A40VPCLNR12	B68
A40VPCLNR16	B68
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A4BHCL26K0317R	C122
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A4BHCR32K0217R	C122
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A4ENN2020K0407	C118
A4ENN2020K0611	C118
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A4ENN2525M0509	C118
A4ENN2525M0611	C118
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A4G0300M03P02GUP KCU25	C93
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A4G0300M03P04GMP KC5010	C95
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A4G0300M03P04S02025ST KB5625	C101
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A4G0305M03U02B KCK20	C98
A4G0305M03U02B KCU25	C98
A4G0305M03U02GMN KC5010	C96

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
A4G0305M03U02GMN KC5025	C96
A4G0305M03U02GMN KCP10	C96
A4G0305M03U02GMN KCP25	C96
A4G0305M03U02GMN KCU10	C96
A4G0305M03U02GMN KCU25	C96
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A4G0405M04U04GMN KCP25	C96
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A4G0500M05P04GUP KCU25	C93
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A4G0500M05P08EST KB1630	C101
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A4G1000M10P08GUP KCU25	C93
A4G1000M10P12GUP KCU10	C93
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A4G1005M10U08GMN KC5025	C96
A4G1005M10U08GMN KCP10	C96
A4G1005M10U08GMN KCP25	C96
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A4G1005M10U08GMP KCU25	C95
A4G1005M10U08GUP KCP10	C92
A4G1005M10U08GUP KCU10	C92
A4G1005M10U08GUP KCU25	C92
A4G1005M10U12GMN KC5025	C96
A4G1005M10U12GMN KCP25	C96
A4G1005M10U12GUP KCP25	C92
A4G1005M10U12GUP KCU25	C92
A4G125I03P05GMN KC5010	C97
A4G125I03P05GMN KC5025	C97
A4G125I03P05GMN KCU10	C97
A4G125I03P05GMN KCU25	C97
A4G125I03P05GUP KCU25	C93
A4G125I03P1GMN KC5010	C97
A4G125I03P1GMN KC5025	C97
A4G125I03P1GMN KCU10	C97
A4G125I03P1GMN KCU25	C97
A4G125I03P1GUP KCU25	C93
A4G125I03P1T0425 KY3500	B300, C100
A4G187I04P1GMN KC5010	C97
A4G187I04P1GMN KCU10	C97
A4G187I04P1GMN KCU25	C97
A4G187I04P1GUP KCU25	C93
A4G187I04P2GMN KC5010	C97
A4G187I04P2GMN KC5025	C97
A4G187I04P2GMN KCU10	C97
A4G187I04P2GMN KCU25	C97
A4G250I06P1GMN KC5010	C97
A4G250I06P1GMN KCU10	C97
A4G250I06P1GMN KCU25	C97
A4G250I06P1GUP KCU25	C93
A4G250I06P2GMN KC5010	C97
A4G250I06P2GMN KCU10	C97
A4G250I06P2GMN KCU25	C97
A4G250I06P2GUP KCU25	C93
A4G250I06P2T0425 KY3500	B300, C100
A4G312I08P1GMN KC5010	C97
A4G312I08P1GMN KCU25	C97
A4G312I08P1GUP KCU25	C93
A4G375I10P1GMN KC5010	C97
A4G375I10P1GUP KCU25	C93
A4G375I10P2GMN KC5010	C97
A4G375I10P2GMN KCU10	C97
A4M50L0212A060084	C126
A4M50L0212A120254	C126
A4M50L0212A250999	C126
A4M50L0212B036046	C128
A4M50L0212B042054	C128
A4M50L0212B050064	C128
A4M50L0212B060084	C128
A4M50L0212B080124	C128
A4M50L0212B120254	C128
A4M50L0214M	C124
A4M50L0314A036048	C126
A4M50L0314A068100	C126
A4M50L0314A090160	C126
A4M50L0314A130300	C126
A4M50L0314A290999	C126
A4M50L0314B036048	C128
A4M50L0314B042058	C128
A4M50L0314B052074	C128
A4M50L0314B068100	C128
A4M50L0314B090160	C128
A4M50L0314B130300	C128
A4M50L0314B290999	C128
A4M50L0314M	C124
A4M50L0314MC	C123
A4M50L0414A064100	C126
A4M50L0414A092150	C126
A4M50L0414A132300	C126
A4M50L0414A290999	C126
A4M50L0414B048072	C128
A4M50L0414B064100	C128
A4M50L0414B092150	C128
A4M50L0414B132300	C128
A4M50L0414B290999	C128
A4M50L0414M	C124
A4M50L0414MC	C123
A4M50L0519A058094	C126
A4M50L0519A080136	C126
A4M50L0519A120300	C126
A4M50L0519A250999	C126
A4M50L0519B058094	C128
A4M50L0519B080136	C128

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
A4M50L0519B120300	C128
A4M50L0519B250999	C128
A4M50L0519M	C124
A4M50L0519MC	C123
A4M50L2B14M	C124
A4M50L2S12B016020	C128
A4M50L2S12B020025	C128
A4M50L2S12B025036	C128
A4M50L3S14B020025	C128
A4M50L3S14B025036	C128
A4M50L4S14B035048	C128
A4M50L5S17B028038	C128
A4M50R0212A036046	C125
A4M50R0212A042054	C125
A4M50R0212A050064	C125
A4M50R0212A060084	C125
A4M50R0212A080124	C125
A4M50R0212A120254	C125
A4M50R0212A250999	C125
A4M50R0212B036046	C127
A4M50R0212B042054	C127
A4M50R0212B050064	C127
A4M50R0212B060084	C127
A4M50R0212B080124	C127
A4M50R0212B120254	C127
A4M50R0212B250999	C127
A4M50R0214M	C124
A4M50R0314A036048	C125
A4M50R0314A042058	C125
A4M50R0314A052074	C125
A4M50R0314A068100	C125
A4M50R0314A090160	C125
A4M50R0314A130300	C125
A4M50R0314A290999	C125
A4M50R0314B036048	C127
A4M50R0314B042058	C127
A4M50R0314B052074	C127
A4M50R0314B068100	C127
A4M50R0314B090160	C127
A4M50R0314B130300	C127
A4M50R0314B290999	C127
A4M50R0314M	C124
A4M50R0314MC	C123
A4M50R0414A048072	C125
A4M50R0414A064100	C125
A4M50R0414A092150	C125
A4M50R0414A132300	C125
A4M50R0414A290999	C125
A4M50R0414B048072	C127
A4M50R0414B064100	C127
A4M50R0414B092150	C127
A4M50R0414B132300	C127
A4M50R0414B290999	C127
A4M50R0414M	C124
A4M50R0414MC	C123
A4M50R0519A058094	C125
A4M50R0519A080136	C125
A4M50R0519A120300	C125
A4M50R0519A250999	C125
A4M50R0519B058094	C127
A4M50R0519B080136	C127
A4M50R0519B120300	C127
A4M50R0519B250999	C127
A4M50R0519M	C124
A4M50R0519MC	C123
A4M50R2S12B016020	C127
A4M50R2S12B020025	C127
A4M50R2S12B025036	C127
A4M50R3S14B020025	C127
A4M50R3S14B025036	C127
A4M50R4S14B025035	C127
A4M50R5S17B028038	C127
A4M65L0522MC	C123
A4M65L0620M	C124
A4M65L0620MC	C123
A4M65L0624A070-112	C126
A4M65L0624A100-212	C126
A4M65L0624A200-999	C126
A4M65L0624B070-112	C128
A4M65L0624B100-212	C128
A4M65L0624B200-999	C128
A4M65L0626M	C124
A4M65L0626MC	C123
A4M65L0820M	C124
A4M65L0820MC	C123
A4M65L0824B090-200	C128
A4M65L0824B184-999	C128
A4M65L0826M	C124
A4M65L0826MC	C123
A4M65L1020M	C124
A4M65L1020MC	C123
A4M65L1024A200-999	C126
A4M65L1024B200-999	C128
A4M65L1026M	C124
A4M65L1026MC	C123
A4M65R0522MC	C123
A4M65R0620M	C124
A4M65R0620MC	C123
A4M65R0624A070-112	C125
A4M65R0624A100-212	C125
A4M65R0624A200-999	C125
A4M65R0624B070-112	C127
A4M65R0624B100-212	C127
A4M65R0624B200-999	C127
A4M65R0626M	C124
A4M65R0626MC	C123
A4M65R0820MC	C123
A4M65R0824A090-200	C125
A4M65R0824A184-999	C125
A4M65R0824B090-200	C127
A4M65R0824B184-999	C127
A4M65R0826M	C124
A4M65R0826MC	C123
A4M65R1020MC	C123
A4M65R1024A200-999	C125
A4M65R1024B100-220	C127
A4M65R1024B200-999	C127
A4M65R1026M	C124
A4M65R1026MC	C123
A4R0200M02P00GMP KC5010	C96
A4R0200M02P00GMP KC5025	C96
A4R0200M02P00GMP KCU10	C96
A4R0200M02P00GMP KCU25	C96
A4R0200M2SP00GMP KCU25	C99
A4R0205M02U00GMN KC5010	C97
A4R0205M02U00GMN KC5025	C97
A4R0205M02U00GMN KCP10	C97
A4R0205M02U00GMN KCU25	C97
A4R0300M03P00EST KB1630	B337, C102
A4R0300M03P00GMP K313	C96
A4R0300M03P00GMP KC5010	C96
A4R0300M03P00GMP KC5025	C96
A4R0300M03P00GMP KCU10	C96
A4R0300M03P00GMP KCU25	C96
A4R0300M03P00GUP KCU10	C94
A4R0300M03P00GUP KCU25	C94
A4R0300M03P00T01025 KY3500	B300, C100
A4R0300M3SP00GMP KCU25	C99
A4R0305M03U00GMN KC5010	C97
A4R0305M03U00GMN KC5025	C97
A4R0305M03U00GMN KCP10	C97
A4R0305M03U00GMN KCP25	C97
A4R0305M03U00GMN KCU10	C97
A4R0305M03U00GMN KCU25	C97
A4R0305M03U00GUP KCU10	C94
A4R0305M03U00GUP KCU25	C94
A4R0400M04P00EST KB1630	B337, C102
A4R0400M04P00GMP K313	C96
A4R0400M04P00GMP KC5010	C96
A4R0400M04P00GMP KC5025	C96
A4R0400M04P00GMP KCU10	C96
A4R0400M04P00GMP KCU25	C96
A4R0400M04P00GUP KCU25	C94
A4R0405M04U00GMN KC5010	C97
A4R0405M04U00GMN KC5025	C97
A4R0405M04U00GMN KCP10	C97
A4R0405M04U00GMN KCP25	C97
A4R0405M04U00GMN KCU10	C97
A4R0405M04U00GMN KCU25	C97
A4R0405M04U00GUP KCU25	C92
A4R0500M05P00E KD1405	B352, C101
A4R0500M05P00EST KB1630	B337, C102
A4R0500M05P00GMP K313	C96
A4R0500M05P00GMP KC5010	C96
A4R0500M05P00GMP KC5025	C96
A4R0500M05P00GMP KCU10	C96
A4R0500M05P00GMP KCU25	C96
A4R0500M05P00GUP KCU25	C94
A4R0500M05P00T01025 KY3500	B300, C100
A4R0500M5SP00GMP KCU25	C99
A4R0505M05U00GMN KC5010	C97
A4R0505M05U00GMN KC5025	C97
A4R0505M05U00GMN KCP10	C97
A4R0505M05U00GMN KCP25	C97
A4R0505M05U00GMN KCU10	C97
A4R0505M05U00GMN KCU25	C97
A4R0505M05U00GUP KCU10	C94
A4R0505M05U00GUP KCU25	C94
A4R0600M06P00EST KB1630	B337, C102
A4R0600M06P00GMP KC5010	C96
A4R0600M06P00GMP KC5025	C96
A4R0600M06P00GMP KCU10	C96
A4R0600M06P00GMP KCU25	C96
A4R0600M06P00GUP KCU10	C94
A4R0600M06P00GUP KCU25	C94
A4R0600M06P00T01025 KY3500	B300, C100
A4R0605M06U00GMN KC5010	C97
A4R0605M06U00GMN KC5025	C97
A4R0605M06U00GMN KCP10	C97
A4R0605M06U00GMN KCP25	C97
A4R0605M06U00GMN KCU10	C97
A4R0605M06U00GMN KCU25	C97
A4R0605M06U00GUP KCU25	C92
A4R0800M08P00GMP KC5010	C96
A4R0800M08P00GMP KCU10	C96
A4R0800M08P00GMP KCU25	C96
A4R0800M08P00GUP KCU25	C94
A4R0800M08P00T01025 KY3500	B300, C100
A4R0805M08U00GMN KC5010	C97
A4R0805M08U00GMN KC5025	C97
A4R0805M08U00GMN KCP10	C97
A4R0805M08U00GMN KCP25	C97
A4R0805M08U00GMN KCU10	C97
A4R0805M08U00GMN KCU25	C97
A4R0805M08U00GUP KCU25	C92
A4R1000M10P00GUP KCU10	C94
A4R1000M10P00GUP KCU25	C94
A4R1005M10U00GMN KCP25	C97
A4R1005M10U00GMN KCU10	C97
A4R1005M10U00GMN KCU25	C97
A4R1005M10U00GUP KCU10	C94
A4R1005M10U00GUP KCU25	C94
A4R125I03P00GMN KC5010	C97
A4R125I03P00GMN KC5025	C97
A4R125I03P00GMN KCU10	C97
A4R125I03P00GMN KCU25	C97
A4R125I03P00GUP KCU10	C94
A4R125I03P00GUP KCU25	C94
A4R187I04P00GMN KC5010	C97
A4R187I04P00GMN KC5025	C97
A4R187I04P00GMN KCU10	C97
A4R187I04P00GMN KCU25	C97
A4R187I04P00GUP KCU25	C94
A4R250I06P00GMN KC5010	C97
A4R250I06P00GMN KC5025	C97
A4R250I06P00GMN KCU10	C97
A4R250I06P00GMN KCU25	C97
A4R250I06P00GUP KCU10	C94
A4R250I06P00GUP KCU25	C94
A4R250I06P00T0425 KY3500	B300, C100
A4R312I08P00GMN KCU10	C97
A4R312I08P00GUP KCU10	C94
A4R375I10P00GMN KC5025	C97
A4SBL2020K2S12016020	C115
A4SBL2020K2S12025036	C115
A4SBL2020K3S14020025	C115
A4SBL2020K4S14025035	C115
A4SBL2525M5S19038058	C115
A4SBR2020K2S12016020	C115
A4SBR2020K2S12020025	C115
A4SBR2020K2S12025036	C115
A4SBR2020K3S14020025	C115
A4SBR2020K4S14035048	C115
A4SBR2525M5S19028038	C115
A4SBR2525M5S19038058	C115
A4SCL1212K0113	C114
A4SCL1212K0214	C114
A4SCL1616K0113	C114
A4SCL1616K0217	C114
A4SCL1616K0317	C114
A4SCL2020K0113	C114
A4SCR1010K0113	C114
A4SCR1212K0113	C114
A4SCR1212K0214	C114
A4SCR1212K0314	C114
A4SCR1616K0113	C114
A4SCR1616K0217	C114
A4SCR1616K0317	C114
A4SCR2020K0113	C114
A4SML1616K0214	C113
A4SML1616K0314	C113
A4SML2016K0317	C113
A4SML2020K0208	C114
A4SML2020K0214	C113
A4SML2020K0217	C113
A4SML2020K0308	C114
A4SML2020K0314	C113
A4SML2020K0317	C113
A4SML2020K0408	C114
A4SML2020K0414	C113
A4SML2020K0417	C113
A4SML2020K0519	C113
A4SML2020K0620	C113
A4SML2525M0214	C113
A4SML2525M0217	C113
A4SML2525M0317	C113
A4SML2525M0417	C113
A4SML2525M0510	C114
A4SML2525M0520	C113
A4SML2525M0610	C114
A4SML2525M0620	C113
A4SML2525M0820	C113
A4SML3225P0417	C113
A4SML3225P0522	C113
A4SML3225P0626	C113
A4SML3225P0826	C113
A4SML3225P1026	C113
A4SMR1616K0214	C112
A4SMR1616K0314	C112
A4SMR2016K0317	C112
A4SMR2016K0417	C112
A4SMR2020K0208	C114
A4SMR2020K0214	C112
A4SMR2020K0217	C112
A4SMR2020K0308	C114
A4SMR2020K0314	C112
A4SMR2020K0317	C112
A4SMR2020K0408	C114
A4SMR2020K0414	C112
A4SMR2020K0417	C112
A4SMR2020K0519	C112
A4SMR2020K0620	C112
A4SMR2525M0214	C112
A4SMR2525M0217	C112
A4SMR2525M0317	C112
A4SMR2525M0417	C112
A4SMR2525M0510	C114
A4SMR2525M0520	C112
A4SMR2525M0610	C114
A4SMR2525M0620	C112
A4SMR2525M0820	C112
A4SMR3225P0417	C112
A4SMR3225P0522	C112
A4SMR3225P0626	C112
A4SMR3225P0826	C112
A4SMR3225P1026	C112
A50UDDUNL15KC06	B90
A50UDDUNR15KC06	B90
A50UMCLNL12	B67
A50UMCLNL16	B67
A50UMCLNL19	B67
A50UMCLNR12	B67
A50UMCLNR16	B67
A50UMCLNR19	B67
A50UMDUNL15	B90
A50UMDUNR15	B90
A50UMSKNR19	B114

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
A50UNNTOR4	C169, D36
A50UNVOCR16	E42
ABDE0300A3AS K600	P111
ABDE0400A3AS K600	P111
ABDE0500A3AS K600	P111
ABDE0600A3ARA K600	P112
ABDE0600A3ARB K600	P112
ABDE0600A3ARC K600	P112
ABDE0600A3AS K600	P111
ABDE0800A3ARA K600	P112
ABDE0800A3ARB K600	P112
ABDE0800A3ARC K600	P112
ABDE0800A3AS K600	P111
ABDE1000A3ARA K600	P112
ABDE1000A3ARB K600	P112
ABDE1000A3ARC K600	P112
ABDE1000A3ARG K600	P112
ABDE1000A3ARK K600	P112
ABDE1000A3ARN K600	P112
ABDE1000A3AS K600	P111
ABDE1000X3CQE K600	029
ABDE1000X3CQG K600	029
ABDE1000X3CQJ K600	029
ABDE1200A3ARA K600	P112
ABDE1200A3ARB K600	P112
ABDE1200A3ARC K600	P112
ABDE1200A3ARG K600	P112
ABDE1200A3ARK K600	P112
ABDE1200A3ARL K600	P112
ABDE1200A3ARM K600	P112
ABDE1200A3ARN K600	P112
ABDE1200A3AS K600	P111
ABDE1200X3CQE K600	029
ABDE1200X3CQG K600	029
ABDE1200X3CQJ K600	029
ABDE1200X3CQL K600	029
ABDE1400A3AS K600	P111
ABDE1600A3ARA K600	P112
ABDE1600A3ARB K600	P112
ABDE1600A3ARC K600	P112
ABDE1600A3ARD K600	P112
ABDE1600A3ARL K600	P113
ABDE1600A3ARM K600	P113
ABDE1600A3ARN K600	P113
ABDE1600A3AS K600	P111
ABDE1600X3CQG K600	029
ABDE1600X3CQJ K600	029
ABDE1600X3CQK K600	029
ABDE1600X3CQL K600	029
ABDE1600X3CQM K600	029
ABDE1800A3AS K600	P111
ABDE2000A3ARA K600	P113
ABDE2000A3ARB K600	P113
ABDE2000A3ARC K600	P113
ABDE2000A3ARD K600	P113
ABDE2000A3ARG K600	P113
ABDE2000A3ARK K600	P113
ABDE2000A3ARM K600	P113
ABDE2000A3AS K600	P111
ABDE2000X3CQG K600	029
ABDE2000X3CQK K600	029
ABDE2000X3CQL K600	029
ABDE2000X3CQM K600	029
ABDE2000X3CQN K600	029
ABDE2500A3ARE K600	P113
ABDE2500A3ARG K600	P113
ABDE2500A3ARK K600	P113
ABDE2500A3ARM K600	P113
ABDE2500A3ARN K600	P113
ABDE2500X3CQL K600	029
ABDE2500X3CQN K600	029
ABDF0150A2AS K600	P110
ABDF0200A2AS K600	P110
ABDF0250A2AS K600	P110
ABDF0300A2AS K600	P110
ABDF0400A2AS K600	P110
ABDF0500A2AS K600	P110
ABDF0600A2AS K600	P110
ABDF0800A2AS K600	P110
ABDF1000A2AS K600	P110
ABDF1000X2CU K600	028
ABDF1200A2AS K600	P110
ABDF1200X2CU K600	028
ABDF1400A2AS K600	P110
ABDF1600A2AS K600	P110
ABDF1600X2CU K600	028
ABDF1800A2AS K600	P110
ABDF2000A2AS K600	P110
ABDF2000X2CU K600	028
AFB09075SCFCR06	K130
AFB13085SCFCR06	K130
AFB17100SCFCR06	K130
AFB21110SCFCR09	K130
AFB24115SCFCR09	K130
AFB27115SCFCR09	K130
AFB31115SCFCR09	K130
AFB34115SCFCR09	K130
AFB38115SCFPR09	K130
AFB42115SCFPR09	K130
AFB47115SCFPR09	K130
AFM29115	K131
AFM29SCFPR06	K132
AFM47115	K131
AFM47SCFPR09	K132
ASPM07001802	T57–59
B041A01000CPG KC7325	G8
B041A01016CPG KC7325	G8
B041A01041CPG KC7325	G8
B041A01067CPG KC7325	G8
B041A01092CPG KC7325	G8
B041A01100CPG KC7325	G8
B041A01181CPG KC7325	G8
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B041A16400CPG KC7325	G12

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
B041A16500CPG KC7325	G12
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B042A07700CPG KC7325	G10
B042A07800CPG KC7325	G10

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
B042A07900CPG KC7325	G10
B042A07938CPG KC7325	G10
B042A08000CPG KC7325	G10
B042A08100CPG KC7325	G10
B042A08200CPG KC7325	G10
B042A08300CPG KC7325	G10
B042A08334CPG KC7325	G10
B042A08400CPG KC7325	G10
B042A08433CPG KC7325	G10
B042A08500CPG KC7325	G10
B042A08600CPG KC7325	G10
B042A08700CPG KC7325	G10
B042A08733CPG KC7325	G10
B042A08800CPG KC7325	G10
B042A08900CPG KC7325	G10
B042A09000CPG KC7325	G10
B042A09100CPG KC7325	G10
B042A09129CPG KC7325	G10
B042A09200CPG KC7325	G10
B042A09300CPG KC7325	G10
B042A09347CPG KC7325	G10
B042A09400CPG KC7325	G11
B042A09500CPG KC7325	G11
B042A09525CPG KC7325	G11
B042A09600CPG KC7325	G11
B042A09700CPG KC7325	G11
B042A09800CPG KC7325	G11
B042A09900CPG KC7325	G11
B042A09921CPG KC7325	G11
B042A10000CPG KC7325	G11
B042A10100CPG KC7325	G11
B042A10200CPG KC7325	G11
B042A10300CPG KC7325	G11
B042A10320CPG KC7325	G11
B042A10400CPG KC7325	G11
B042A10500CPG KC7325	G11
B042A10600CPG KC7325	G11
B042A10700CPG KC7325	G11
B042A10716CPG KC7325	G11
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B042A10900CPG KC7325	G11
B042A11000CPG KC7325	G11
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B042A11113CPG KC7325	G11
B042A11200CPG KC7325	G11
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B042A11400CPG KC7325	G11
B042A11500CPG KC7325	G11
B042A11509CPG KC7325	G11
B042A11600CPG KC7325	G11
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B042A14200CPG KC7325	G12
B042A14288CPG KC7325	G12
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B042A15200CPG KC7325	G12
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B042A15400CPG KC7325	G12
B042A15479CPG KC7325	G12
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B042A15700CPG KC7325	G12
B042A15800CPG KC7325	G12
B042A15875CPG KC7325	G12
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B042A16000CPG KC7325	G12
B042A16100CPG KC7325	G12
B042A16200CPG KC7325	G12
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B042A17100CPG KC7325	G12
B042A17200CPG KC7325	G12
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B042F06200CPG KC7325	G14
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B042F06500CPG KC7325	G14
B042F06600CPG KC7325	G15
B042F06700CPG KC7325	G15
B042F06800CPG KC7325	G15
B042F06900CPG KC7325	G15
B042F07000CPG KC7325	G15
B042F07100CPG KC7325	G15
B042F07200CPG KC7325	G15
B042F07300CPG KC7325	G15
B042F07400CPG KC7325	G15
B042F07500CPG KC7325	G15
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B042F07800CPG KC7325	G15
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B042F08100CPG KC7325	G15
B042F08200CPG KC7325	G15
B042F08300CPG KC7325	G15
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B042F09200CPG KC7325	G15
B042F09300CPG KC7325	G15
B042F09400CPG KC7325	G15
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B042F09700CPG KC7325	G15
B042F09800CPG KC7325	G15
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B042F10100CPG KC7325	G15
B042F10200CPG KC7325	G15
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B042F10600CPG KC7325	G15
B042F10700CPG KC7325	G15
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B042F10900CPG KC7325	G15
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B042F11400CPG KC7325	G15
B042F11500CPG KC7325	G15
B042F11600CPG KC7325	G15
B042F11700CPG KC7325	G15
B042F11800CPG KC7325	G16
B042F11900CPG KC7325	G16
B042F12000CPG KC7325	G16
B042F12100CPG KC7325	G16
B042F12200CPG KC7325	G16
B042F12300CPG KC7325	G16
B042F12400CPG KC7325	G16
B042F12500CPG KC7325	G16
B042F12600CPG KC7325	G16
B042F12700CPG KC7325	G16
B042F12800CPG KC7325	G16
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B042F13000CPG KC7325	G16
B042F13100CPG KC7325	G16
B042F13200CPG KC7325	G16
B042F13300CPG KC7325	G16
B042F13400CPG KC7325	G16
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B042F13600CPG KC7325	G16
B042F13700CPG KC7325	G16
B042F13800CPG KC7325	G16
B042F13900CPG KC7325	G16
B042F14000CPG KC7325	G16
B042F14100CPG KC7325	G16
B042F14200CPG KC7325	G16
B042F14300CPG KC7325	G16
B042F14400CPG KC7325	G16
B042F14500CPG KC7325	G16
B042F14600CPG KC7325	G16
B042F14700CPG KC7325	G16
B042F14800CPG KC7325	G16
B042F14900CPG KC7325	G16
B042F15000CPG KC7325	G16
B042F15100CPG KC7325	G16
B042F15200CPG KC7325	G16
B042F15300CPG KC7325	G16
B042F15400CPG KC7325	G16
B042F15500CPG KC7325	G16
B042F15600CPG KC7325	G16
B042F15700CPG KC7325	G16
B042F15800CPG KC7325	G16
B042F15900CPG KC7325	G16
B042F16000CPG KC7325	G16
B042F16100CPG KC7325	G16
B042F16200CPG KC7325	G16
B042F16300CPG KC7325	G16
B042F16400CPG KC7325	G16
B042F16500CPG KC7325	G16
B042F16600CPG KC7325	G16
B042F16700CPG KC7325	G16
B042F16800CPG KC7325	G16
B042F16900CPG KC7325	G16
B042F17000CPG KC7325	G17
B042F17100CPG KC7325	G17
B042F17200CPG KC7325	G17
B042F17300CPG KC7325	G17
B042F17400CPG KC7325	G17
B042F17500CPG KC7325	G17
B042F17600CPG KC7325	G17
B042F17700CPG KC7325	G17
B042F17800CPG KC7325	G17
B042F17900CPG KC7325	G17
B042F18000CPG KC7325	G17
B042F18100CPG KC7325	G17
B042F18200CPG KC7325	G17
B042F18300CPG KC7325	G17
B042F18400CPG KC7325	G17
B042F18500CPG KC7325	G17
B042F18600CPG KC7325	G17
B042F18700CPG KC7325	G17
B042F18800CPG KC7325	G17
B042F18900CPG KC7325	G17
B042F19000CPG KC7325	G17
B042F19100CPG KC7325	G17
B042F19200CPG KC7325	G17
B042F19300CPG KC7325	G17
B042F19400CPG KC7325	G17
B042F19500CPG KC7325	G17
B042F19600CPG KC7325	G17
B042F19700CPG KC7325	G17
B042F19800CPG KC7325	G17
B042F19900CPG KC7325	G17
B042F20000CPG KC7325	G17
B051A01500CPG KC7325	G18
B051A01600CPG KC7325	G18
B051A01700CPG KC7325	G18
B051A01800CPG KC7325	G18
B051A01900CPG KC7325	G18
B051A01984CPG KC7325	G18
B051A02000CPG KC7325	G18

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
B051A02100CPG KC7325	G18
B051A02200CPG KC7325	G18
B051A02300CPG KC7325	G18
B051A02383CPG KC7325	G18
B051A02400CPG KC7325	G18
B051A02439CPG KC7325	G18
B051A02489CPG KC7325	G18
B051A02500CPG KC7325	G18
B051A02578CPG KC7325	G18
B051A02600CPG KC7325	G18
B051A02642CPG KC7325	G18
B051A02700CPG KC7325	G18
B051A02705CPG KC7325	G18
B051A02779CPG KC7325	G18
B051A02800CPG KC7325	G18
B051A02820CPG KC7325	G18
B051A02870CPG KC7325	G18
B051A02900CPG KC7325	G18
B051A02947CPG KC7325	G19
B051A03000CPG KC7325	G19
B051A03048CPG KC7325	G19
B051A03100CPG KC7325	G19
B051A03175CPG KC7325	G19
B051A03200CPG KC7325	G19
B051A03264CPG KC7325	G19
B051A03300CPG KC7325	G19
B051A03400CPG KC7325	G19
B051A03455CPG KC7325	G19
B051A03500CPG KC7325	G19
B051A03571CPG KC7325	G19
B051A03600CPG KC7325	G19
B051A03658CPG KC7325	G19
B051A03700CPG KC7325	G19
B051A03734CPG KC7325	G19
B051A03800CPG KC7325	G19
B051A03900CPG KC7325	G19
B051A03970CPG KC7325	G19
B051A04000CPG KC7325	G19
B051A04039CPG KC7325	G19
B051A04090CPG KC7325	G19
B051A04100CPG KC7325	G19
B051A04200CPG KC7325	G19
B051A04217CPG KC7325	G19
B051A04300CPG KC7325	G19
B051A04366CPG KC7325	G19
B051A04400CPG KC7325	G19
B051A04500CPG KC7325	G19
B051A04600CPG KC7325	G19
B051A04623CPG KC7325	G19
B051A04700CPG KC7325	G19
B051A04763CPG KC7325	G19
B051A04800CPG KC7325	G19
B051A04852CPG KC7325	G19
B051A04900CPG KC7325	G19
B051A05000CPG KC7325	G19
B051A05100CPG KC7325	G19
B051A05106CPG KC7325	G19
B051A05159CPG KC7325	G19
B051A05200CPG KC7325	G19
B051A05300CPG KC7325	G19
B051A05400CPG KC7325	G19
B051A05410CPG KC7325	G19
B051A05500CPG KC7325	G19
B051A05558CPG KC7325	G19
B051A05600CPG KC7325	G19
B051A05616CPG KC7325	G19
B051A05700CPG KC7325	G19
B051A05800CPG KC7325	G19
B051A05900CPG KC7325	G19
B051A05954CPG KC7325	G19
B051A06000CPG KC7325	G20
B051A06100CPG KC7325	G20
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B051A06300CPG KC7325	G20
B051A06350CPG KC7325	G20
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B051A06528CPG KC7325	G20
B051A06600CPG KC7325	G20
B051A06630CPG KC7325	G20
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B051A06800CPG KC7325	G20
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B051A07000CPG KC7325	G20
B051A07100CPG KC7325	G20
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B051A07200CPG KC7325	G20
B051A07300CPG KC7325	G20
B051A07400CPG KC7325	G20
B051A07500CPG KC7325	G20
B051A07541CPG KC7325	G20
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B051A07800CPG KC7325	G20
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B051A07938CPG KC7325	G20
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B051A08334CPG KC7325	G20
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B051A16000CPG KC7325	G22
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B051A16670CPG KC7325	G22
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B051A16900CPG KC7325	G22
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B051F10700CPG KC7325	G25
B051F10800CPG KC7325	G25
B051F10900CPG KC7325	G25
B051F11000CPG KC7325	G25
B051F11100CPG KC7325	G25
B051F11200CPG KC7325	G25

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
B051F11300CPG KC7325	G25
B051F11400CPG KC7325	G26
B051F11500CPG KC7325	G26
B051F11600CPG KC7325	G26
B051F11700CPG KC7325	G26
B051F11800CPG KC7325	G26
B051F11900CPG KC7325	G26
B051F12000CPG KC7325	G26
B051F12100CPG KC7325	G26
B051F12200CPG KC7325	G26
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B052A18600CPG KC7325	G23
B052A18654CPG KC7325	G23
B052A18700CPG KC7325	G23
B052A18800CPG KC7325	G23
B052A18900CPG KC7325	G23

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
B052A19000CPG KC7325	G23
B052A19050CPG KC7325	G23
B052A19100CPG KC7325	G23
B052A19200CPG KC7325	G23
B052A19300CPG KC7325	G23
B052A19400CPG KC7325	G23
B052A19500CPG KC7325	G23
B052A19600CPG KC7325	G23
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B052F03000CPG KC7325	G24
B052F03100CPG KC7325	G24
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B053A09921CPG KC7325	G21
B053A10000CPG KC7325	G21
B053A10100CPG KC7325	G21
B053A10200CPG KC7325	G21

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
B053A10300CPG KC7325	G21
B053A10320CPG KC7325	G21
B053A10400CPG KC7325	G21
B053A10500CPG KC7325	G21
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B211A03100SGL KCMS15	G38
B211A03175SGL KCMS15	G38
B211A03200SGL KCMS15	G38
B211A03300SGL KCMS15	G38
B211A03400SGL KCMS15	G38
B211A03455SGL KCMS15	G38

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
B211A03500SGL KCMS15	G38
B211A03571SGL KCMS15	G38
B211A03600SGL KCMS15	G38
B211A03658SGL KCMS15	G38
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B221A13000HP KCPK15	G49
B221A13100HP KCPK15	G49
B221A13200HP KCPK15	G49
B221A13300HP KCPK15	G49

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
B221A13500HP KCPK15	G49
B221A13600HP KCPK15	G49
B221A13700HP KCPK15	G49
B221A13800HP KCPK15	G49
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B225A08100HP KCPK15	G52
B225A08200HP KCPK15	G52
B225A08300HP KCPK15	G53
B225A08334HP KCPK15	G53

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
B225A08400HP KCPK15	G53
B225A08433HP KCPK15	G53
B225A08500HP KCPK15	G53
B225A08600HP KCPK15	G53
B225A08700HP KCPK15	G53
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B255A09100YPC KCK10	G59
B255A09129YPC KCK10	G59
B255A09200YPC KCK10	G59
B255A09300YPC KCK10	G59
B255A09400YPC KCK10	G59
B255A09500YPC KCK10	G60

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
B255A09525YPC KCK10	G60
B255A09600YPC KCK10	G60
B255A09700YPC KCK10	G60
B255A09800YPC KCK10	G60
B255A09921YPC KCK10	G60
B255A10000YPC KCK10	G60
B255A10200YPC KCK10	G60
B255A10262YPC KCK10	G60
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B256A05000 KC7315	G63
B256A05000YPC KCK10	G58
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B269A18500HP KCPK15	G70
B269A18600HP KCPK15	G70
B269A19000HP KCPK15	G70
B269A19050HP KCPK15	G70

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
B269A19500HP KCPK15	G70
B269A20000HP KCPK15	G70
B271Z02383KMG KCPK20	G74
B271Z02383KMS KN25	G74
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B271Z02500KMG KCPK20	G74
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B272Z11000HPS KN25	G77
B272Z11000SGL KCMS20	G77
B272Z11113SGL KCMS20	G77
B272Z11500HPG KCPK20	G77
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B272Z11500SGL KCMS20	G77
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B272Z12000HPG KCPK20	G77
B272Z12000HPS KN25	G77
B272Z12000SGL KCMS20	G77
B272Z12500HPG KCPK20	G77
B272Z12500HPS KN25	G77
B272Z12500SGL KCMS20	G77
B272Z12700HPG KCPK20	G77
B272Z12700HPS KN25	G77
B272Z12700SGL KCMS20	G77
B272Z13000HPG KCPK20	G77
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B272Z13500HPS KN25	G77
B272Z14000HPG KCPK20	G77
B272Z14000HPS KN25	G77
B272Z14000SGL KCMS20	G77
B272Z14500HPG KCPK20	G77
B272Z14500HPS KN25	G77
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B273Z02947KMS KN25	G78
B273Z03000HPG KCPK20	G78

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
B273Z03000HPS KN25	G78
B273Z03000SGL KCMS20	G78
B273Z03175HPG KCPK20	G78
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B284D05954HPS KN15	G89
B284D06000HPS KN15	G89
B284D06200HPS KN15	G89

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
B284D06300HPS KN15	G89
B284D06350HPS KN15	G89
B284D06400HPS KN15	G89
B284D06500HPS KN15	G89
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B286D13100HPS KN15	G90

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
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For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
B343S17000HPG KC7315	I10
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B505Z08000 K10	G152
B505Z10000 K10	G152
B505Z12000 K10	G152
B505Z16000 K10	G152
B505Z20000 K10	G152
B510S08000 A30	J76
B510S08000 AS3	J76
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B513S08000 A30	J68
B513S08000 AS3	J68
B513S10000 A30	J68
B513S10000 AS3	J68
B514S08000 KC7030	J68
B514S10000 KC7030	J68
B531A03200SPF KDF400	G105
B531A03300SPF KDF400	G105
B531A03600SPF KDF400	G105
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B531A04366SPF KDF400	G105
B531A04851SPF KDF400	G105
B531A04864SPF KDF400	G105
B531A05100SPF KDF400	G105
B531A05200SPF KDF400	G105
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B707A04800FBS KN15	G114
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B707A05000FBL KCMS15	G114
B707A05000FBS KN15	G114
B707A05200FBG KC7315	G114
B707A05560FBG KC7315	G114
B707A05560FBL KCMS15	G114
B707A05560FBS KN15	G114
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B707A05900FBG KC7315	G114
B707A05900FBL KCMS15	G114
B707A05900FBS KN15	G114
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B707A06000FBL KCMS15	G114
B707A06000FBS KN15	G114
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B707A06350FBL KCMS15	G114
B707A06350FBS KN15	G114
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B707A06500FBS KN15	G114
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B707A06800FBS KN15	G114
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B707A07000FBL KCMS15	G114
B707A07000FBS KN15	G114
B707A07145FBG KC7315	G114
B707A07400FBS KN15	G114
B707A07500FBG KC7315	G114
B707A07500FBL KCMS15	G114
B707A07500FBS KN15	G114
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B707A09000FBS KN15	G115
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B707A09500FBL KCMS15	G115
B707A09500FBS KN15	G115
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B707A10000FBS KN15	G115
B707A10200FBG KC7315	G115
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B707A10320FBS KN15	G115
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B707A10500FBL KCMS15	G115
B707A10500FBS KN15	G115
B707A10600FBG KC7315	G115
B707A10800FBG KC7315	G115
B707A11000FBG KC7315	G115
B707A11000FBL KCMS15	G115
B707A11000FBS KN15	G115
B707A11111FBG KC7315	G115
B707A11111FBL KCMS15	G115
B707A11111FBS KN15	G115
B707A11350FBG KC7315	G115
B707A11509FBG KC7315	G115
B707A11509FBL KCMS15	G115
B707A11509FBS KN15	G115
B707A11570FBG KC7315	G115
B707A11570FBL KCMS15	G115
B707A11570FBS KN15	G115
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B707A11700FBL KCMS15	G115
B707A11700FBS KN15	G115
B707A11800FBG KC7315	G115
B707A11800FBL KCMS15	G115
B707A11800FBS KN15	G115
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B707A14288FBS KN15	G115
B707A14500FBG KC7315	G115
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B707A14500FBS KN15	G115
B707A15000FBG KC7315	G115
B707A15000FBL KCMS15	G115
B707A15000FBS KN15	G115
B707A15250FBG KC7315	G115
B707A15250FBL KCMS15	G115
B707A15250FBS KN15	G115
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B707A15875FBL KCMS15	G115
B707A15875FBS KN15	G115
B707A16000FBG KC7315	G115
B707A16000FBL KCMS15	G115
B707A16000FBS KN15	G115
B707A16500FBG KC7315	G115
B707A16500FBL KCMS15	G115
B707A16500FBS KN15	G115
B707A17000FBG KC7315	G115
B707A17000FBL KCMS15	G115
B707A17000FBS KN15	G115

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
B707A17463FBG KC7315	G115
B707A17500FBG KC7315	G115
B707A17500FBL KCMS15	G115
B707A17500FBS KN15	G115
B707A17900FBL KCMS15	G115
B707A18000FBG KC7315	G115
B707A18000FBL KCMS15	G115
B707A18000FBS KN15	G115
B707A18500FBG KC7315	G115
B707A19000FBG KC7315	G115
B707A19000FBL KCMS15	G115
B707A19000FBS KN15	G115
B707A19050FBG KC7315	G115
B707A19050FBL KCMS15	G115
B707A19050FBS KN15	G115
B707A20000FBG KC7315	G115
B707A20000FBL KCMS15	G115
B707A20000FBS KN15	G115
B707A21000FBG KC7315	G115
B707A21000FBL KCMS15	G115
B707A21000FBS KN15	G115
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B731A04496HP KCPK15	G120
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B731A05106HP KCPK15	G120
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B731A06909HP KCPK15	G120
B731A07938HP KCPK15	G120
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B731A14000HP KCPK15	G120
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B941A03000 KC7315	G126
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B941A05200 KC7315	G126
B941A05500 KC7315	G126
B941A05600 KC7315	G126
B941A06000 KC7315	G126
B941A06900 KC7315	G126
B941A07000 KC7315	G126
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B941A09000 KC7315	G126
B941A10000 KC7315	G126
B941A10200 KC7315	G126
B941A10400 KC7315	G126
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B941A11100 KC7315	G126
B941A12000 KC7315	G126
B941A14000 KC7315	G126
B941Z02500 KC7315	G126
B951A03000 KC7315	G127
B951A03175 KC7315	G127
B951A03454 KC7315	G127
B951A03500 KC7315	G127
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B966A12100 KC7315	G134
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B966A13300 KC7315	G134
B966A13400 KC7315	G134
B966A13500 KC7315	G134
B966A13700 KC7315	G134
B966A14000 KC7315	G134
B966A14200 KC7315	G134
B966A14300 KC7315	G134
B966A14500 KC7315	G134
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B966A14800 KC7315	G134
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B966A15700 KC7315	G134
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B966A17000 KC7315	G134
B966A17500 KC7315	G134
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B966F04200 KC7315	G135
B966F05000 KC7315	G135
B966F05100 KC7315	G135
B966F05300 KC7315	G135
B966F05500 KC7315	G135
B966F05600 KC7315	G135
B966F06000 KC7315	G135
B966F06300 KC7315	G135
B966F06400 KC7315	G135
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B966F06800 KC7315	G135
B966F07000 KC7315	G135
B966F07100 KC7315	G135
B966F07300 KC7315	G135
B966F07400 KC7315	G135
B966F07600 KC7315	G135
B966F08000 KC7315	G135
B966F08200 KC7315	G135
B966F08400 KC7315	G135
B966F08500 KC7315	G135
B966F09000 KC7315	G135
B966F09100 KC7315	G135
B966F09500 KC7315	G135
B966F10000 KC7315	G135
B966F10200 KC7315	G135
B966F10400 KC7315	G135
B966F10500 KC7315	G135
B966F10600 KC7315	G135
B966F10700 KC7315	G135
B966F10800 KC7315	G136
B966F11000 KC7315	G136
B966F11800 KC7315	G136
B966F12000 KC7315	G136
B966F12100 KC7315	G136
B966F12200 KC7315	G136
B966F12500 KC7315	G136
B966F12700 KC7315	G136
B966F13000 KC7315	G136
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B967A04200 KC7315	G132

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
B967A04300 KC7315	G132
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B977A06350 KC7315	G139
B977A06400 KC7315	G139

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
B977A06500 KC7315	G139
B977A06528 KC7315	G139
B977A06600 KC7315	G139
B977A06700 KC7315	G139
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B978A03000 KC7315	G146
B978A03300 KC7315	G146
B978A03400 KC7315	G146
B978A03600 KC7315	G146
B978A03700 KC7315	G146
B978A03800 KC7315	G146
B978A03970 KC7315	G146
B978A04000 KC7315	G146
B978A04200 KC7315	G146
B978A04500 KC7315	G146
B978A04600 KC7315	G146
B978A04763 KC7315	G146
B978A04800 KC7315	G146
B978A05000 KC7315	G146
B978A05100 KC7315	G146
B978A05200 KC7315	G146
B978A05300 KC7315	G146
B978A05500 KC7315	G146
B978A05558 KC7315	G146
B978A05600 KC7315	G146
B978A05700 KC7315	G146
B978A05800 KC7315	G146
B978A05900 KC7315	G146
B978A06000 KC7315	G146
B978A06100 KC7315	G146
B978A06200 KC7315	G146
B978A06300 KC7315	G146
B978A06350 KC7315	G146
B978A06400 KC7315	G146
B978A06500 KC7315	G146
B978A06600 KC7315	G146
B978A06700 KC7315	G146
B978A06746 KC7315	G146
B978A06800 KC7315	G146
B978A07000 KC7315	G146
B978A07145 KC7315	G146
B978A07400 KC7315	G147
B978A07500 KC7315	G147
B978A07541 KC7315	G147
B978A07700 KC7315	G147
B978A07800 KC7315	G147
B978A07938 KC7315	G147
B978A08000 KC7315	G147
B978A08100 KC7315	G147
B978A08200 KC7315	G147
B978A08334 KC7315	G147
B978A08500 KC7315	G147
B978A08600 KC7315	G147
B978A08700 KC7315	G147
B978A08733 KC7315	G147
B978A08800 KC7315	G147
B978A09000 KC7315	G147
B978A09100 KC7315	G147
B978A09129 KC7315	G147
B978A09300 KC7315	G147
B978A09500 KC7315	G147
B978A09525 KC7315	G147
B978A09700 KC7315	G147
B978A09750 KC7315	G147
B978A09800 KC7315	G147
B978A09900 KC7315	G147
B978A09921 KC7315	G147
B978A10000 KC7315	G147
B978A10100 KC7315	G147
B978A10200 KC7315	G147
B978A10300 KC7315	G147
B978A10320 KC7315	G147
B978A10500 KC7315	G147
B978A10716 KC7315	G147
B978A10800 KC7315	G147
B978A11000 KC7315	G147
B978A11113 KC7315	G147
B978A11200 KC7315	G147
B978A11300 KC7315	G147
B978A11400 KC7315	G147
B978A11500 KC7315	G147
B978A11509 KC7315	G147
B978A11700 KC7315	G147
B978A11800 KC7315	G147
B978A11908 KC7315	G147
B978A12000 KC7315	G147
B978A12304 KC7315	G147
B978A12500 KC7315	G147
B978A12700 KC7315	G147
B978A12800 KC7315	G148
B978A13000 KC7315	G148
B978A13100 KC7315	G148
B978A13500 KC7315	G148

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
B978A14000 KC7315	G148
B978A14288 KC7315	G148
B978A14500 KC7315	G148
B978A15000 KC7315	G148
B978A15100 KC7315	G148
B978A15200 KC7315	G148
B978A15300 KC7315	G148
B978A15500 KC7315	G148
B978A15800 KC7315	G148
B978A15875 KC7315	G148
B978A16000 KC7315	G148
B978A16078 KC7315	G148
B978A16200 KC7315	G148
B978A16500 KC7315	G148
B978A17000 KC7315	G148
B978A17463 KC7315	G148
B978A17500 KC7315	G148
B978A18000 KC7315	G148
B978A18500 KC7315	G148
B978A19000 KC7315	G148
B978A19050 KC7315	G148
B978A19253 KC7315	G148
B978A19500 KC7315	G148
B978A19800 KC7315	G148
B978A19840 KC7315	G148
B978A20000 KC7315	G148
B978F03600 KC7315	G149
B978F04700 KC7315	G149
B978F05000 KC7315	G149
B978F06800 KC7315	G149
B978F07000 KC7315	G149
B978F07400 KC7315	G149
B978F07500 KC7315	G149
B978F08500 KC7315	G149
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B978F10200 KC7315	G149
B978F12000 KC7315	G149
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B978F16000 KC7315	G149
B978F17000 KC7315	G149
B978F17500 KC7315	G149
B978F18000 KC7315	G149
B978F20000 KC7315	G149
BGHX15L504ERGET KD1415	S149
BGHX15L504PCFRGG K110M	S149
BGHX15L508PCFRGG K110M	S149
BGHX15L508PCFRGG KC510M	S149
BGHX15L515PCFRGG K110M	S149
BGHX15L515PCFRGG KC510M	S149
BGHX15L5PCERGGT KD1410	S148
BGHX15L5PCERGGT KD1415	S148
BGHX15L5PCERGGT1W KD1415	S149
BGHX15L5PCERGGTM KD1410	S148
BGHX15L5PCFRGG K110M	S148
BGHX15L5PCFRGG KC510M	S148
BGHX15L5PCFRGG1W K110M	S149
BGHX15L5PCFRGG1W KC510M	S149
BGHX15L5PCSRLET KD1410	S148
BGHX15L5PCSRLET KD1415	S148
BGHX15L5PCTRGG K110M	S148
BGHX15L5PCTRGG KC510M	S148
BGHX15L5PCTRGG1W K110M	S149
BGHX15L5PCTRGG1W KC510M	S149
BGHX15L5PCTRHET KD1410	S148
BS32S	B386
BS40T	B386
BS50U	B386
BSD32U	B386
BSD40V	B386
BSD50W	B386
BT40BDL10049M	053
BT40BDL12049M	053
BT40BDL16058M	053
BT40BDL20058M	053
BT40BDL25060M	053
BT40BDL32068M	053
BT40BEWD20096M	J47
BT40BEWD32114M	J47
BT40BKR32030M	K86
BT40BKR50050M	K86
BT40BSIF80063M	K44
BT40FBHM1691	K129
BT40FBHMKIT164M	K123, K127
BT40RMEWD32114M	J47
BT50BEWD32127M	J47
BT50BHTS22075M	J80
BT50BHTS32080M	J80
BT50BHTS40080M	J80
BT50BHTS50080M	J80
BT50BKR32040M	K86
BT50BKR50040M	K86
BT50BKR63060M	K86
BT50BKR80060M	K86
BT50BSIF100068M	K45
BT50BSIF70063M	K45
BT50BT13088	K138
BTQSW3L90	S32–33
BTQT25	S116, S120, S122
C2FIX110404LMN KCU25	E8
C2FIX110404RMN KCU10	E8
C2FIX110405LMN KCP25	E8
C2FIX110405LMN KCP40	E8
C2FIX110405LMN KCU10	E8
C2FIX110405RMN KCP25	E8
C2FIX110405RMN KCP40	E8
C2FIX110408LMN KCP25	E8
C2FIX150504LMN KCP40	E8
C2FIX150504LMN KCU25	E8
C2FIX150505LMN KCP25	E8
C2FIX150505LMN KCP40	E8
C2FIX150505LMN KCU10	E8
C2FIX150505RMN KCP25	E8
C2FIX150508LMN KCP25	E8
C2FIX150508LMN KCU10	E8
C2FIX150508LMN KCU25	E8
C2FIX150510LMN KCP25	E8
C2FIX150510LMN KCP40	E8
C2FIX150510RMN KCP25	E8
C2FIX150512RMN KCU25	E8
C2FIX180610LMN KCP25	E8
C2FIX180610LMN KCP40	E8
C2FIX180610LMN KCU10	E8
C8FIX120503LMP KCP10	E12
C8FIX120503LMP KCP25	E12
C8FIX120503LMP KCU10	E12
C8FIX120503RMP KCP25	E12
C8FIX120503RMP KCU10	E12
C8FIX120503RMP KCU25	E12
C8FIX120503RRP KCP25	E12
C8FIX120503RRP KCP40	E12
C8FIX120504RRP KCP10	E12
C8FIX120504RRP KCP25	E12
C8FIX120505RRP KCP25	E12
C8FIX120505RRP KCU25	E12
C8FIX120508LRP KCP25	E12
C8FIX120508LRP KCP40	E12
C8FIX120508RRP KCP10	E12
C8FIX120508RRP KCP25	E12
C8FIX150603LMP KCP25	E12
C8FIX150603RMP KCP10	E12
C8FIX150603RMP KCP25	E12
C8FIX150603RMP KCP40	E12
C8FIX150603RMP KCU10	E12
C8FIX150603RMP KCU25	E12
C8FIX150605LRN KCP25	E11
C8FIX150605LRN KCP40	E11
C8FIX150605LRN KCU25	E11
C8FIX150605RRN KCP10	E11
C8FIX150605RRN KCP25	E11
C8FIX150605RRN KCP40	E11
C8FIX150605RRN KCU10	E11
C8FIX150605RRN KCU25	E11
C8FIX150608LRN KCP25	E11
C8FIX150608LRN KCU25	E11
C8FIX150608LRP KCU25	E12
C8FIX150608RRN KCP10	E11
C8FIX150608RRN KCP25	E11
C8FIX150608RRN KCP40	E11
C8FIX150608RRN KCU25	E11
C8FIX150612LRN KCP25	E11
C8FIX150612LRP KCP25	E12
C8FIX150612RRN KCP25	E11
C8FIX180805RMP KCP25	E12
C8FIX180808RRN KCP25	E11
C8FIX180808RRN KCP40	E11
C8FIX180812LRN KCP25	E11
C8FIX180812RRN KCP25	E11
C8FIX180812RRN KCP40	E11
C8FIX180812RRN KCU25	E11
CBDB0600AXAS KCN05	P132
CBDB0600AXBS KCN05	P132
CBDB1000AXAS KCN05	P132
CBDB1000AXBS KCN05	P132
CBDB1200AXAS KCN05	P132
CBDB1200AXBS KCN05	P132
CBTF150R2WD20N2M	J98
CBTF160R2WD20N2M	J98
CBTF170R2WD20N2M	J98
CBTF180R2WD20N2M	J98
CBTF180R2WD20N3M	J98
CBTF200R2WD20N2M	J98
CBTF200R2WD20N3M	J98
CBTF210R2WD20N2M	J98
CBTF210R2WD20N3M	J98
CBTF220R2WD20N2M	J98
CBTF220R2WD20N3M	J98
CBTF230R2WD20N2M	J98
CBTF230R2WD20N3M	J98
CBTF240R2WD20N2M	J98
CBTF240R2WD20N3M	J98
CBTF250R2WD20N2M	J98
CBTF250R2WD20N3M	J98
CBTF260R2WD20N2M	J98
CBTF270R2WD20N3M	J98
CBTF280R2WD20N3M	J98
CBTF300R2WD20N3M	J98
CBTF320R2WD20N3M	J98
CBTF330R2WD20N3M	J98
CBTF340R2WD32N3M	J98
CBTF350R2WD32N3M	J98
CBTF360R2WD32N3M	J98
CBTF380R2WD32N3M	J98
CBTF400R2WD32N3M	J98
CBTF420R2WD32N3M	J98
CBTF460R2WD32N3M	J98
CC09	B186–187
CC11	B185–187
CCGM09T304S01325MTCB1 KBH20	B308
CCGM09T308S01325MTCB1 KBH20	B308
CCGT060201LF KC5010	B175
CCGT060201LF KC5025	B175
CCGT060201LF KCU10	B175
CCGT060202HP K313	B175
CCGT060202HP KC5025	B175
CCGT060202HP KC5410	B175
CCGT060202HP KCU10	B175
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CCGT060202LF KC5025	B175
CCGT060202LF KCU10	B175
CCGT060204HP K313	B175
CCGT060204HP KC5010	B175
CCGT060204HP KC5025	B175
CCGT060204HP KC5410	B175
CCGT060204HP KCU10	B175
CCGT060204HP KCU25	B175
CCGT060204LF KC5010	B175
CCGT060204LF KC5025	B175
CCGT060204LF KCU10	B175
CCGT060208HP KC5010	B175
CCGT060208HP KC5410	B175
CCGT060208HP KCU25	B175
CCGT060208LF KC5010	B175
CCGT060208LF KCU10	B175
CCGT0602X0LF KC5025	B175
CCGT09T301LF KC5010	B175
CCGT09T301LF KC5025	B175
CCGT09T301LF KCU10	B175
CCGT09T302HP K313	B175
CCGT09T302HP KC5010	B175
CCGT09T302HP KC5025	B175
CCGT09T302HP KC5410	B175
CCGT09T302HP KCU10	B175
CCGT09T302HP KCU25	B175
CCGT09T302LF KC5010	B175
CCGT09T302LF KC5025	B175
CCGT09T302LF KCU10	B175
CCGT09T304HP K313	B175
CCGT09T304HP KC5010	B175
CCGT09T304HP KC5025	B175
CCGT09T304HP KC5410	B175
CCGT09T304HP KCU10	B175
CCGT09T304HP KCU25	B175
CCGT09T304LF KC5010	B175
CCGT09T304LF KC5025	B175
CCGT09T304LF KC5410	B175
CCGT09T304LF KCU10	B175
CCGT09T308HP KC5010	B175
CCGT09T308HP KC5025	B175
CCGT09T308HP KC5410	B175
CCGT09T308HP KCU10	B175
CCGT09T308HP KCU25	B175
CCGT09T308LF K313	B175
CCGT09T308LF KC5010	B175
CCGT09T308LF KC5025	B175
CCGT09T308LF KCU10	B175
CCGT09T3X0LF KC5025	B175
CCGT120402HP KC5010	B175
CCGT120402HP KCU10	B175
CCGT120402HP KCU25	B175
CCGT120404HP K313	B175
CCGT120404HP KC5010	B175
CCGT120404HP KC5025	B175
CCGT120404HP KC5410	B175
CCGT120404HP KCU10	B175
CCGT120408HP K313	B175
CCGT120408HP KC5010	B175
CCGT120408HP KC5410	B175
CCGT120408HP KCU10	B175
CCGT120408HP KCU25	B175
CCGW060202S01015C KB5630	B290, B308
CCGW060202S01015MT KBH10	B308
CCGW060202S01225MT KBH20	B308
CCGW060204FST KD1400	B344
CCGW060204FST KD1425	B344
CCGW060204S01015C KB5630	B290, B308
CCGW060204S01015MT KBH10	B308
CCGW060204S01225MT KBH20	B308
CCGW09T302S01015MT KBH10	B308
CCGW09T302S01225MT KBH20	B308
CCGW09T304FST KD1400	B344
CCGW09T304FST KD1425	B344
CCGW09T304S01015FWMT KBH20	B308
CCGW09T304S01015MT KB5630	B291, B308
CCGW09T304S01015MT KBH10	B308
CCGW09T304S01015MT KBH20	B308
CCGW09T304S01225MT KBH10	B308
CCGW09T304S01225MT KBH20	B308
CCGW09T308EC KB1345	B290
CCGW09T308FST KD1400	B344
CCGW09T308FST KD1425	B344
CCGW09T308S01015FWMT KBH10	B308
CCGW09T308S01015FWMT KBH20	B308
CCGW09T308S01015MT KB5630	B291, B308
CCGW09T308S01015MT KBH10	B308
CCGW09T308S01015MT KBH20	B308
CCGW09T308S01225MT KBH10	B308
CCGW09T308S01225MT KBH20	B308
CCGW120408S01015MT KBH20	B308
CCKNL2525M12MX7	B356
CCKNR2525M12MX7	B356
CCLNL2525M12-MF4	B358
CCLNL2525M12-MF7	B358
CCLNL2525M12-MN4	B358
CCLNL2525M12-MN7	B358
CCLNL2525M12-MX7	B358
CCLNL3225P12-MN7	B358
CCLNL3225P12-MX7	B358
CCLNR2525M12-MF4	B358
CCLNR2525M12-MF7	B358
CCLNR2525M12-MN4	B358
CCLNR2525M12-MN7	B358
CCLNR2525M12-MX7	B358

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
CCLNR3225P12-MN4	B358
CCLNR3225P12-MN7	B358
CCLNR3225P12-MX7	B358
CCMT060202FP KCM25	B176
CCMT060202FP KCM25B	B176
CCMT060202FP KCP10	B176
CCMT060202FP KCP25	B176
CCMT060202FP KCU10	B176
CCMT060202FP KCU25	B176
CCMT060202FW KC5010	B176
CCMT060202FW KT315	B176
CCMT060202LF KC5010	B177
CCMT060202LF KC5025	B177
CCMT060202LF KT315	B177
CCMT06020411 KT315	B176
CCMT060204FP KCM15	B176
CCMT060204FP KCM15B	B176
CCMT060204FP KCM25	B176
CCMT060204FP KCM25B	B176
CCMT060204FP KCP05	B176
CCMT060204FP KCP10	B176
CCMT060204FP KCP10B	B176
CCMT060204FP KCP25	B176
CCMT060204FP KCP25B	B176
CCMT060204FP KCU10	B176
CCMT060204FP KCU25	B176
CCMT060204FP KTP10	B176
CCMT060204FW KC5010	B176
CCMT060204FW KCK20B	B176
CCMT060204FW KCP25	B176
CCMT060204FW KCU10	B176
CCMT060204FW KT315	B176
CCMT060204LF K313	B177
CCMT060204LF KC5010	B177
CCMT060204LF KC5025	B177
CCMT060204LF KCK05	B177
CCMT060204LF KCK15	B177
CCMT060204LF KCK15B	B177
CCMT060204LF KCK20	B177
CCMT060204LF KCK20B	B177
CCMT060204LF KCM15	B177
CCMT060204LF KCM15B	B177
CCMT060204LF KCM25	B177
CCMT060204LF KCM25B	B177
CCMT060204LF KCM35	B177
CCMT060204LF KCP10	B177
CCMT060204LF KCP10B	B177
CCMT060204LF KCP25	B177
CCMT060204LF KCP25B	B177
CCMT060204LF KCP30	B177
CCMT060204LF KT315	B177
CCMT060204MF KCK15	B177
CCMT060204MF KCK20	B177
CCMT060204MF KCM15B	B177
CCMT060204MF KCM25	B177
CCMT060204MF KCM25B	B177
CCMT060204MF KCM35	B177
CCMT060204MF KCP10	B177
CCMT060204MF KCP10B	B177
CCMT060204MF KCP25	B177
CCMT060204MF KCP25B	B177
CCMT060204MF KCP30	B177
CCMT060204MP KCM15	B177
CCMT060204MP KCM15B	B177
CCMT060204MP KCM25	B177
CCMT060204MP KCM25B	B177
CCMT060204MP KCP10	B177
CCMT060204MP KCP25	B177
CCMT060204MP KCU10	B177
CCMT060204UF KC5010	B178
CCMT060204UF KCP05	B178
CCMT060204UF KCP10	B178
CCMT060204UF KCP25	B178
CCMT060204UF KCP25B	B178
CCMT060208FP KCM25	B176
CCMT060208FP KCM25B	B176
CCMT060208FP KCP25	B176
CCMT060208FP KCP25B	B176
CCMT060208FP KCU10	B176
CCMT060208FP KCU25	B176
CCMT060208FP KTP10	B176
CCMT060208FW KC5010	B176
CCMT060208FW KCK20	B176
CCMT060208FW KCP25	B176
CCMT060208FW KT315	B176
CCMT060208LF KC5010	B177
CCMT060208LF KC5025	B177
CCMT060208LF KCK05	B177
CCMT060208LF KCK05B	B177
CCMT060208LF KCK15	B177
CCMT060208LF KCK15B	B177
CCMT060208LF KCK20B	B177
CCMT060208LF KCM15B	B177
CCMT060208LF KCM25	B177
CCMT060208LF KCP05	B177
CCMT060208LF KCP10	B177
CCMT060208LF KCP25	B177
CCMT060208LF KCP25B	B177
CCMT060208LF KCP30	B177
CCMT060208LF KT315	B177
CCMT09T302FP KCM25	B176
CCMT09T302FP KCM25B	B176
CCMT09T302FP KCP25	B176
CCMT09T302FP KCP25B	B176
CCMT09T302FP KCU10	B176
CCMT09T302FP KCU25	B176
CCMT09T302FP KTP10	B176
CCMT09T302LF K313	B177
CCMT09T302LF KC5010	B177
CCMT09T302LF KC5025	B177
CCMT09T302LF KT315	B177
CCMT09T302UF KC5010	B178
CCMT09T302UF KCP05	B178
CCMT09T302UF KCP10	B178
CCMT09T30411 KT315	B176
CCMT09T304FP KCM15	B176
CCMT09T304FP KCM15B	B176
CCMT09T304FP KCM25	B176
CCMT09T304FP KCM25B	B176
CCMT09T304FP KCP05	B176
CCMT09T304FP KCP10B	B176
CCMT09T304FP KCP25	B176
CCMT09T304FP KCP25B	B176
CCMT09T304FP KCU10	B176
CCMT09T304FP KCU25	B176
CCMT09T304FP KTP10	B176
CCMT09T304FW KC5010	B176
CCMT09T304FW KCP25	B176
CCMT09T304FW KCU10	B176
CCMT09T304FW KT315	B176
CCMT09T304LF K313	B177
CCMT09T304LF KC5010	B177
CCMT09T304LF KC5025	B177
CCMT09T304LF KCK05	B177
CCMT09T304LF KCK15	B177
CCMT09T304LF KCK15B	B177
CCMT09T304LF KCK20	B177
CCMT09T304LF KCM15B	B177
CCMT09T304LF KCM25	B177
CCMT09T304LF KCM25B	B177
CCMT09T304LF KCM35	B177
CCMT09T304LF KCP10	B177
CCMT09T304LF KCP10B	B177
CCMT09T304LF KCP25	B177
CCMT09T304LF KCP25B	B177
CCMT09T304LF KCP30	B177
CCMT09T304LF KT315	B177
CCMT09T304MF KCK15	B177
CCMT09T304MF KCK15B	B177
CCMT09T304MF KCK20	B177
CCMT09T304MF KCK20B	B177
CCMT09T304MF KCM15B	B177
CCMT09T304MF KCM25	B177
CCMT09T304MF KCM25B	B177
CCMT09T304MF KCP10B	B177
CCMT09T304MF KCP25	B177
CCMT09T304MF KCP25B	B177
CCMT09T304MF KCP30	B177
CCMT09T304MP KCK20B	B177
CCMT09T304MP KCM15B	B177
CCMT09T304MP KCM25	B177
CCMT09T304MP KCM25B	B177
CCMT09T304MP KCP10	B177
CCMT09T304MP KCP25	B177
CCMT09T304MP KCU10	B177
CCMT09T304MW KC5010	B178
CCMT09T304MW KCM15B	B178
CCMT09T304MW KCU10	B178
CCMT09T304MW KT315	B178
CCMT09T304UF KC5010	B178
CCMT09T304UF KCP10	B178
CCMT09T304UF KCP25	B178
CCMT09T30811 KT315	B176
CCMT09T308FP KCM15B	B176
CCMT09T308FP KCM25	B176
CCMT09T308FP KCM25B	B176
CCMT09T308FP KCP10	B176
CCMT09T308FP KCP10B	B176
CCMT09T308FP KCP25	B176
CCMT09T308FP KCP25B	B176
CCMT09T308FP KCU10	B176
CCMT09T308FP KCU25	B176
CCMT09T308FP KTP10	B176
CCMT09T308FW KC5010	B176
CCMT09T308FW KCK20	B176
CCMT09T308FW KCM15B	B176
CCMT09T308FW KCP25	B176
CCMT09T308FW KCU10	B176
CCMT09T308FW KT315	B176
CCMT09T308LF K313	B177
CCMT09T308LF KC5010	B177
CCMT09T308LF KCK05	B177
CCMT09T308LF KCK15	B177
CCMT09T308LF KCK15B	B177
CCMT09T308LF KCK20	B177
CCMT09T308LF KCK20B	B177
CCMT09T308LF KCM15B	B177
CCMT09T308LF KCM25	B177
CCMT09T308LF KCM25B	B177
CCMT09T308LF KCM35	B177
CCMT09T308LF KCP05	B177
CCMT09T308LF KCP10	B177
CCMT09T308LF KCP10B	B177
CCMT09T308LF KCP25	B177
CCMT09T308LF KCP25B	B177
CCMT09T308LF KCP30	B177
CCMT09T308LF KT315	B177
CCMT09T308MF KC5025	B177
CCMT09T308MF KCK15	B177
CCMT09T308MF KCK15B	B177
CCMT09T308MF KCK20	B177
CCMT09T308MF KCK20B	B177
CCMT09T308MF KCM15B	B177
CCMT09T308MF KCM25	B177
CCMT09T308MF KCM25B	B177
CCMT09T308MF KCM35	B177
CCMT09T308MF KCP10B	B177
CCMT09T308MF KCP25	B177
CCMT09T308MF KCP25B	B177
CCMT09T308MF KCP30	B177
CCMT09T308MP KCK20	B177
CCMT09T308MP KCK20B	B177
CCMT09T308MP KCM15B	B177
CCMT09T308MP KCM25	B177
CCMT09T308MP KCM25B	B177
CCMT09T308MP KCP10	B177
CCMT09T308MP KCP25	B177
CCMT09T308MP KCU10	B177
CCMT09T308MW KC5010	B178
CCMT09T308MW KCK20	B178
CCMT09T308MW KCK20B	B178
CCMT09T308MW KCM15B	B178
CCMT09T308MW KCP25	B178
CCMT09T308MW KCU10	B178
CCMT09T308MW KT315	B178
CCMT09T308UF KC5010	B178
CCMT09T308UF KCP10B	B178
CCMT09T312MF KCK15	B177
CCMT09T312MF KCK20	B177
CCMT09T312MF KCK20B	B177
CCMT09T312MF KCM25B	B177
CCMT09T312MF KCP10	B177
CCMT09T312MF KCP25	B177
CCMT09T312MF KCP25B	B177
CCMT09T312MP KCM25	B177
CCMT09T312MP KCP25	B177
CCMT09T312MP KCU10	B177
CCMT120404FP KCM25B	B176
CCMT120404FP KCP10B	B176
CCMT120404FP KCP25B	B176
CCMT120404FP KCU10	B176
CCMT120404FP KCU25	B176
CCMT120404LF KC5010	B177
CCMT120404LF KC5025	B177
CCMT120404LF KCK15B	B177
CCMT120404LF KCK20	B177
CCMT120404LF KCP10	B177
CCMT120404LF KCP25	B177
CCMT120404LF KCP25B	B177
CCMT120404LF KCP30	B177
CCMT120404MW KC5010	B178
CCMT120404MW KCP25	B178
CCMT120408FP KCM25	B176
CCMT120408FP KCP25B	B176
CCMT120408FP KCU10	B176
CCMT120408LF KC5010	B177
CCMT120408LF KC5025	B177
CCMT120408LF KCK15	B177
CCMT120408LF KCK20	B177
CCMT120408LF KCK20B	B177
CCMT120408LF KCM25B	B177
CCMT120408LF KCM35	B177
CCMT120408LF KCP10	B177
CCMT120408LF KCP10B	B177
CCMT120408LF KCP25	B177
CCMT120408LF KCP25B	B177
CCMT120408MF KCK15	B177
CCMT120408MF KCK15B	B177
CCMT120408MF KCK20	B177
CCMT120408MF KCK20B	B177
CCMT120408MF KCM15B	B177
CCMT120408MF KCM25	B177
CCMT120408MF KCM25B	B177
CCMT120408MF KCM35	B177
CCMT120408MF KCP10	B177
CCMT120408MF KCP10B	B177
CCMT120408MF KCP25	B177
CCMT120408MF KCP25B	B177
CCMT120408MF KCP30	B177
CCMT120408MP KCK20	B177
CCMT120408MP KCK20B	B177
CCMT120408MP KCM25B	B177
CCMT120408MP KCP10	B177
CCMT120408MP KCP25	B177
CCMT120408MP KCU10	B177
CCMT120408MW KC5010	B178
CCMT120408MW KCK20B	B178
CCMT120408MW KCP25	B178
CCMT120412FP KCP10	B176
CCMT120412LF KCK20B	B177
CCMT120412LF KCM25	B177
CCMT120412LF KCP10	B177
CCMT120412LF KCP25B	B177
CCMT120412MF KC5025	B177
CCMT120412MF KCK15	B177
CCMT120412MF KCK20	B177
CCMT120412MF KCP25	B177
CCMT120412MF KCP25B	B177
CCMT120412MP KCK20	B177
CCMT120412MP KCM25	B177
CCMT120412MP KCM25B	B177
CCMT120412MP KCP25	B177
CCMW060204 KCK20B	B178
CCMW09T308 KCK20	B178
CCMW09T308 KCK20B	B178
CCMW120408 KCK20	B178
CCMW120408 KCK20B	B178
CCMW120412 KCK20	B178
CCMW120412 KCK20B	B178
CCNC0600A3AH KCN05	P130
CCNC0600A3BH KCN05	P130
CCNC1000A4AH KCN05	P130
CCNC1000A4BH KCN05	P130
CCNC1200A4AH KCN05	P130
CCNC1200A4BH KCN05	P130
CCRNL2525M12-MN7	B359
CCRNR3225P12-MN7	B359
CDDC0600A6AH KCN05	P131

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
CDDC0600A6BH KCN05	P131
CDDC1000A6AH KCN05	P131
CDDC1000A6BH KCN05	P131
CDDC1200A6AH KCN05	P131
CDDC1200A6BH KCN05	P131
CDHBS4T002 K313	B184
CDHBS4T002 KC5010	B184
CDHBS4T002 KC5025	B184
CDHBS4T002 KCU10	B184
CDHBS4T002 KCU25	B184
CDHBS4T002 KT315	B184
CDHBS4T002FST KD1400	B344
CDHBS4T002FST KD1425	B344
CDHBS4T004 KC5010	B184
CDHBS4T004 KC5025	B184
CDHBS4T004 KCU10	B184
CDHBS4T004 KCU25	B184
CDHBS4T004 KT315	B184
CDHBS4T0S0 KC5010	B184
CDHBS4T0S0 KC5025	B184
CDHBS4T0S0 KCU25	B184
CDHBS4T0X0 KCU10	B184
CDHBS4T0X0FST KD1400	B344
CDHHS4T002L KC5010	B184
CDHHS4T002L KC5025	B184
CDHHS4T002L KCU10	B184
CDHHS4T002L KCU25	B184
CDHHS4T002L KT315	B184
CDHHS4T002R KC5010	B184
CDHHS4T002R KC5025	B184
CDHHS4T002R KCU10	B184
CDHHS4T002R KT315	B184
CDHHS4T004L KC5010	B184
CDHHS4T004L KC5025	B184
CDHHS4T004L KCU10	B184
CDHHS4T004L KCU25	B184
CDHHS4T004R KC5010	B184
CDHHS4T004R KCU10	B184
CDHNR2525M12-MX7	B359
CDJNL2525M12-MX7	B360
CDJNL2525M15MN7	B360
CDJNL2525M15MX7	B360
CDJNL3225P15MN7	B360
CDJNR2525M15-MX7	B360
CDJNR2525M15MN7	B360
CDJNR3225P15MN7	B360
CELNL2525M13MN7	B361
CELNR2525M13-MX7	B361
CELNR2525M13MF7	B361
CELNR2525M13MN7	B361
CFB10082	K131
CFB12096	K131
CFB14110	K131
CFB16120	K131
CFB18140	K131
CFM0402R00RHP KCU40	H34
CFM0402R30RHP KCU40	H34
CFM0402R45RHP KCU40	H34
CKM10	B170, B173–174, B353–355, B371
CKM12	B61–63, B67–68, B91, B108–110, B114
CKM13	B172, B354
CKM19	B109, B172–174, B355, B371
CKM20	B68, B134, B164
CKM21	B61–63, B67–68, B95, B108–110, B114, B133–134, B137
CKM22	B86, B90–91, B153
CKM26	B151–152
CKM31	B151–153
CKM34	B70–72, B92–93, B115–119, B139–141, B375–378
CKM35	B72, B115, B139–141, B378
CKM36	B70, B92–93, B115–119
CKM37	B72, B115–117, B119
CKM41	B72, B92
CKM6	B62, B67, B151, B162, B164
CKM7	B86, B90, B162, B172, B354
CKM9	B133–134, B170, B173, B353–355
CM-72	D31–33, D39
CM105	E40–41
CM106	E40–41
CM109	C170, D37
CM113	E38–40, E42–43
CM114	E38–39, E42
CM120	D32
CM121	D32
CM146	C169, D36, D39–40
CM147	C169, D36, D39–40
CM158	E37–38
CM159	E37–38, E42
CM180	E36
CM182	C167, D27
CM183	C167, D27
CM184LP	C167, D27
CM185LP	C167, D27
CM209R ASSY	B58–60, B66, B105
CM210R ASSY	B59–60, B105
CM214	B168, B370
CM215R ASSY	B149–150, B152
CM216	B168, B370
CM217	B168, B370
CM219	B168, B370
CM234R ASSY	B58–60, B66, B85, B89–90, B105–107, B132, B137, B152, B161, B163
CM236R ASSY	B105–106
CM66	E37, E41
CM68	E36, E40
CM72LP	C166, C168–169, C171, D28–30, D36, D41–42
CM73	D31–33, D39
CM73LP	C166, C168–169, D28–30, D36
CM74	C166, C168–171, D28–31, D33, D36–37, D39, D41–42
CM75	C166, C168–171, D28–31, D33, D36–37, D39, D41–42
CM80	D32
CM81	D32
CNGA120404E KD1405	B344
CNGA120404FST KD1400	B344
CNGA120404FST KD1425	B344
CNGA120404S01015FWMT KBH10	B310
CNGA120404S01015FWMT KBH20	B310
CNGA120404S01015MT KBH10	B310
CNGA120404S01015MT KBH20	B310
CNGA120404S01025FWMT KB5630	B289, B310
CNGA120404S01025MT KB5630	B290, B310
CNGA120404S01225MT KBH20	B310
CNGA120404S01735MT KBH20	B310
CNGA120404T02020 KY1615	B309
CNGA120408E KD1405	B344
CNGA120408E KYS25	B332
CNGA120408E KYS30	B332
CNGA120408FST KD1400	B344
CNGA120408FST KD1425	B344
CNGA120408S01015FWMT KBH10	B310
CNGA120408S01015FWMT KBH20	B310
CNGA120408S01015MT KBH10	B310
CNGA120408S01015MT KBH20	B310
CNGA120408S01020MT KB1345	B290
CNGA120408S01025FWMT KB5630	B289, B310
CNGA120408S01025MT KB5630	B290, B310
CNGA120408S01225FWMT KBH10	B310
CNGA120408S01225MT KBH10	B310
CNGA120408S01225MT KBH20	B310
CNGA120408S01735MT KBH10	B310
CNGA120408S01735MT KBH20	B310
CNGA120408S02020MT KB1345	B290
CNGA120408T00520 KY1615	B309
CNGA120408T01020 KYS25	B332
CNGA120408T01020 KYS30	B332
CNGA120408T01020FW KY3500	B293
CNGA120408T01020FW KYK25	B293
CNGA120408T02020 KY1615	B309
CNGA120408T02020 KY3500	B292
CNGA120408T02020 KYK10	B292
CNGA120408T02020 KYK25	B292
CNGA120412S01015FWMT KBH20	B310
CNGA120412S01015MT KBH10	B310
CNGA120412S01015MT KBH20	B310
CNGA120412S01020MT KB5630	B290, B310
CNGA120412S01025MT KB5630	B290, B310
CNGA120412S01225FWMT KBH10	B310
CNGA120412S01225MT KBH10	B310
CNGA120412S01225MT KBH20	B310
CNGA120412S01735MT KBH10	B310
CNGA120412S01735MT KBH20	B310
CNGA120412T01020 KYS25	B332
CNGA120412T01020 KYS30	B332
CNGA120412T01020FW KY3500	B293
CNGA120412T01020FW KYK10	B293
CNGA120412T01020FW KYK25	B293
CNGA120412T02020 KY1615	B309
CNGA120412T02020 KY3500	B292
CNGA120412T02020 KYK10	B292
CNGA120412T02020 KYK25	B292
CNGA120412T02020FW KYK10	B293
CNGA120416T01020FW KY3500	B293
CNGA120416T02020 KY1615	B309
CNGA120416T02020 KY3500	B292
CNGA120416T02020 KYK10	B292
CNGA120416T02020 KYK25	B292
CNGA160612T02020 KY1615	B309
CNGA160612T02020 KY3500	B292
CNGA160612T02020 KYK25	B292
CNGA160616T02020 KY3500	B292
CNGA160616T02020 KYK25	B292
CNGA190612T02020 KY1615	B309
CNGA190612T02020 KY3500	B292
CNGA190616T02020 KY1615	B309
CNGA190616T02020 KY3500	B292
CNGA190616T02020 KYK25	B292
CNGF120408 KB1340	B286
CNGG120401FS KC5010	B46
CNGG120401FS KCU10	B46
CNGG120401LF KC5010	B46
CNGG120401LF KCU10	B46
CNGG120402FS KC5010	B46
CNGG120402FS KCU10	B46
CNGG120402FS KCU25	B46
CNGG120402LF KC5010	B46
CNGG120402LF KCU10	B46
CNGG120404FS KC5010	B46
CNGG120404FS KC5025	B46
CNGG120404FS KCU10	B46
CNGG120404FS KCU25	B46
CNGG120404LF KC5010	B46
CNGG120404LF KCU10	B46
CNGG120408FS KC5010	B46
CNGG120408FS KC5025	B46
CNGG120408FS KCU10	B46
CNGG120408FS KCU25	B46
CNGG120408LF KC5010	B46
CNGG120408LF KCU10	B46
CNGG120412LF KC5010	B46
CNGG120412LF KCU10	B46
CNGM120404S01325MTCB1 KBH20	B310
CNGM120408S01325MTCB1 KBH20	B310
CNGM120412S01325MTCB1 KBH20	B310
CNGN090408T02020 KBK45	B284
CNGN090412S02020 KBK45	B284
CNGN120404T02020 KY1615	B309
CNGN120408T02020 KBK45	B284
CNGN120408T02020 KY1615	B309
CNGN120408T02020 KY3500	B295
CNGN120412S02020 KBK45	B284
CNGN120412T02020 KY1615	B309
CNGN120412T02020 KY3500	B295
CNGN120416S02020 KBK45	B284
CNGN120416T01020 KYS25	B332
CNGN120416T02020 KY3500	B295
CNGN120708T02020 KY1615	B309
CNGN120712T01020 KYS25	B332
CNGN120712T01020 KYS30	B332
CNGN120712T02020 KY1615	B309
CNGN120712T02020 KY3500	B295
CNGN120716T01020 KYS30	B332
CNGN120716T02020 KY1615	B309
CNGN120716T02020 KYK10	B295
CNGN160716T02020 KY1615	B309
CNGN160716T05015 KY1615	B309
CNGP120401 KC5010	B46
CNGP120401 KC5410	B46
CNGP120401 KCU10	B46
CNGP120402 KC5010	B46
CNGP120402 KC5410	B46
CNGP120402 KCU10	B46
CNGP120404 K313	B46
CNGP120404 K68	B46
CNGP120404 KC5010	B46
CNGP120404 KC5410	B46
CNGP120404 KCU10	B46
CNGP120408 K313	B46
CNGP120408 K68	B46
CNGP120408 KC5010	B46
CNGP120408 KC5410	B46
CNGP120408 KCU10	B46
CNGP120408K KC5010	B47
CNGP120412 K313	B46
CNGP120412 KC5010	B46
CNGP120412 KC5410	B46
CNGP120412 KCU10	B46
CNGP120416 KC5010	B46
CNGP160612K K313	B47
CNGX120408T02020 KBK45	B287
CNGX120412S01015 KB1340	B287
CNGX120412S01015FW KB1340	B287
CNGX120412S02020 KBK45	B287
CNGX120416S02020 KB1340	B287
CNGX120416S02020 KBK45	B287
CNGX120708T01020 KYS25	B332
CNGX120708T01020 KYS30	B332
CNGX120708T01020FW KY3500	B295
CNGX120708T02020 KY1615	B311
CNGX120712T01020 KYS25	B332
CNGX120712T01020 KYS30	B332
CNGX120712T01020FW KY3500	B295
CNGX120712T02020 KY1615	B311
CNGX120716E KYS30	B332
CNGX120716T01020FW KY3500	B295
CNMA120404 KCK05B	B47
CNMA120404 KCK15	B47
CNMA120404 KCK15B	B47
CNMA120404 KCK20	B47
CNMA120404 KCK20B	B47
CNMA120408 K68	B47
CNMA120408 KCK05	B47
CNMA120408 KCK15	B47
CNMA120408 KCK15B	B47
CNMA120408 KCK20	B47
CNMA120408 KCK20B	B47
CNMA120408S02020 KB1340	B289
CNMA120412 KCK05	B47
CNMA120412 KCK15	B47
CNMA120412 KCK15B	B47
CNMA120412 KCK20	B47
CNMA120412 KCK20B	B47
CNMA120412S02020 KB1340	B289
CNMA120416 KCK05	B47
CNMA120416 KCK05B	B47
CNMA120416 KCK15	B47
CNMA120416 KCK15B	B47
CNMA120416 KCK20	B47
CNMA160608 KCK15	B47
CNMA160608 KCK20	B47
CNMA160612 KCK15	B47
CNMA160612 KCK15B	B47
CNMA160612 KCK20	B47
CNMA160612 KCK20B	B47
CNMA160616 KCK15	B47
CNMA160616 KCK20B	B47
CNMA190612 KCK05	B47
CNMA190612 KCK15	B47
CNMA190612 KCK15B	B47
CNMA190612 KCK20	B47
CNMA190616 KCK15B	B47
CNMA190616 KCK20	B47
CNMA190616 KCK20B	B47
CNMG090304FF KC5010	B48
CNMG090304FN KCP10	B49
CNMG090304FN KT315	B49
CNMG090304MN KCP10	B50
CNMG090304MN KCP25B	B50
CNMG090304MN KCP30	B50
CNMG090308FF KC5010	B48
CNMG090308FN KCK05	B49
CNMG090308FN KCP10	B49
CNMG090308FN KCP10B	B49

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
CNMG090308MN KCP10	B50
CNMG090308MN KCP10B	B50
CNMG090308MN KCP25	B50
CNMG090308MN KCP25B	B50
CNMG090308MN KCP30	B50
CNMG090308MP KC5010	B51
CNMG090308MP KCM15B	B51
CNMG090308MP KCM25	B51
CNMG090308MP KCU10	B51
CNMG090312MN KCP25	B50
CNMG120401MS KC5010	B52
CNMG120401MS KC5025	B52
CNMG120401MS KCU10	B52
CNMG120401MS KCU25	B52
CNMG120402FN KC5010	B49
CNMG120402FN KCU10	B49
CNMG120402FN KT315	B49
CNMG120402LF KCP25B	B50
CNMG120402MS KC5010	B52
CNMG120402MS KC5025	B52
CNMG120402MS KCU10	B52
CNMG120402MS KCU25	B52
CNMG120404B K68	B47
CNMG120404FF KC5010	B48
CNMG120404FF KCM15B	B48
CNMG120404FF KCP05	B48
CNMG120404FF KCP10	B48
CNMG120404FF KCP10B	B48
CNMG120404FF KCU10	B48
CNMG120404FF KT315	B48
CNMG120404FN KCK05	B49
CNMG120404FN KCK15B	B49
CNMG120404FN KCP05	B49
CNMG120404FN KCP10	B49
CNMG120404FN KCP10B	B49
CNMG120404FN KCP25	B49
CNMG120404FN KCP25B	B49
CNMG120404FN KT315	B49
CNMG120404FP KC5010	B49
CNMG120404FP KCM15	B49
CNMG120404FP KCP10	B49
CNMG120404FP KCP25B	B49
CNMG120404FP KCU10	B49
CNMG120404FP KT315	B49
CNMG120404FW KC5010	B49
CNMG120404FW KCP05	B49
CNMG120404FW KCP10	B49
CNMG120404FW KCP10B	B49
CNMG120404FW KCU10	B49
CNMG120404FW KT315	B49
CNMG120404LF KCP25B	B50
CNMG120404MN KCP10	B50
CNMG120404MN KCP10B	B50
CNMG120404MN KCP25	B50
CNMG120404MN KCP25B	B50
CNMG120404MN KCP30	B50
CNMG120404MN KCP40B	B50
CNMG120404MP KC5010	B51
CNMG120404MP KCM15	B51
CNMG120404MP KCM15B	B51
CNMG120404MP KCM25	B51
CNMG120404MP KCM25B	B51
CNMG120404MP KCM35	B51
CNMG120404MP KCM35B	B51
CNMG120404MP KCU10	B51
CNMG120404MR KCM15B	B51
CNMG120404MS K313	B52
CNMG120404MS KC5010	B52
CNMG120404MS KC5025	B52
CNMG120404MS KCU10	B52
CNMG120404MS KCU25	B52
CNMG120404P KC5010	B52
CNMG120404P KCU10	B52
CNMG120404RP KC5010	B53
CNMG120404RP KC5025	B53
CNMG120404RP KCM25	B53
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CNMG120412RP KCP10	B53
CNMG120412RP KCP10B	B53
CNMG120412RP KCP25	B53
CNMG120412RP KCP25B	B53
CNMG120412RP KCP30	B53
CNMG120412RP KCP30B	B53

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
CNMG120412RP KCP40	B53
CNMG120412RP KCP40B	B53
CNMG120412RP KCPK05	B53
CNMG120412RP KCU10	B53
CNMG120412RP KCU25	B53
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CNMG120412UN KCK05B	B54
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CNMM120416RP KCP25B	B56
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CNMM160612RP KCP10B	B56
CNMM160612RP KCP25	B56
CNMM160612RP KCP40	B56
CNMM160616MR KCP25B	B54
CNMM160616RM KCP10	B55
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CNMM160616RM KCP30	B55
CNMM160616RP KCM25	B56
CNMM160616RP KCP10	B56
CNMM160616RP KCP10B	B56
CNMM160616RP KCP25	B56
CNMM160616RP KCP25B	B56
CNMM160616RP KCPK05	B56
CNMM160624RM KCP10	B55
CNMM160624RM KCP25B	B55
CNMM160624RP KCP10B	B56
CNMM190612RH KCP25	B55
CNMM190612RH KCP40	B55
CNMM190612RM KCP10	B55

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
CNMM190612RM KCP25	B55
CNMM190612RM KCP25B	B55
CNMM190612RM KCP40	B55
CNMM190612RP KCM25B	B56
CNMM190612RP KCP25	B56
CNMM190612RP KCP25B	B56
CNMM190616MR KCP25B	B54
CNMM190616RH KCP10B	B55
CNMM190616RH KCP25B	B55
CNMM190616RH KCP30	B55
CNMM190616RH KCP40B	B55
CNMM190616RM KCP10	B55
CNMM190616RM KCP10B	B55
CNMM190616RM KCP25	B55
CNMM190616RM KCP25B	B55
CNMM190616RM KCP30	B55
CNMM190616RP KCM25B	B56
CNMM190616RP KCP10	B56
CNMM190616RP KCP10B	B56
CNMM190616RP KCP25	B56
CNMM190616RP KCP25B	B56
CNMM190624RH KCP10	B55
CNMM190624RH KCP10B	B55
CNMM190624RH KCP25	B55
CNMM190624RH KCP25B	B55
CNMM190624RH KCP30	B55
CNMM190624RH KCP40B	B55
CNMM190624RM KCP25	B55
CNMM190624RM KCP25B	B55
CNMM190624RM KCP30	B55
CNMM190624RP KCM25B	B56
CNMM190624RP KCP25	B56
CNMM190624RW KCP10B	B56
CNMM190624RW KCP25B	B56
CNMM190740RRP KCP10B	E53
CNMM250924RH KCP10	B55
CNMM250924RH KCP25	B55
CNMM250924RH KCP25B	B55
CNMM250924RH KCP30	B55
CNMM250924RH KCP30B	B55
CNMM250924RH KCP40	B55
CNMM250924RM KCP10	B55
CNMM250924RM KCP25	B55
CNMM250924RM KCP25B	B55
CNMM250924RM KCP40	B55
CNMM250924RP KCP25	B56
CNMM250924RW KCP25B	B56
CNMN120408S02020 KB1340	B284
CNMN120412S02020 KB1340	B284
CNMP120404 K313	B56
CNMP120404 K68	B56
CNMP120404 KC5410	B56
CNMP120404K KCP10B	B57
CNMP120404K KCP25	B57
CNMP120404K KCP25B	B57
CNMP120408 K313	B56
CNMP120408 K68	B56
CNMP120408 KC5410	B56
CNMP120408 KCP25B	B56
CNMP120408K KCP10	B57
CNMP120408K KCP10B	B57
CNMP120408K KCP25	B57
CNMP120408K KCP25B	B57
CNMP120412 K68	B56
CNMP160608 KCP25B	B56
CNMP190612 K313	B56
CNMS120404FST KD1400	B345
CNMS120408 K68	B57
CNMS120408 KC5410	B57
CNMS120408E KD1405	B345
CNMS120408FST KD1400	B345
CNMS120408FST KD1425	B345
CNMS160608 KC5410	B57
CNMS190608 K68	B57
CNMS190608 KC5410	B57
CNMS190612 K68	B57
CNMU120412RN KCP10B	B53
CNMU120612MN KCP05B	B51
CNMU120612MN KCP10	B51
CNMU120616MN KCP25B	B51
CNMX120708T02020 KY3500	B295
CNMX120712T02020 KY3500	B295
CNMX120716T02020 KY3500	B295
COOL-HOSE-200	C75
COOL-HOSE-200-FLEX	C75
COOL-HOSE-300	C75
COOL-HOSE-300-FLEX	C75
CP1416	U27–35
CP1820	U40–49
CPGH09T301 KC5010	B188
CPGH09T301 KC5025	B188
CPGH09T301 KCU10	B188
CPGH09T301 KT315	B188
CPGH09T302 K68	B188
CPGH09T302 KC5010	B188
CPGH09T302 KC5025	B188
CPGH09T302 KCU10	B188
CPGH09T302 KCU25	B188
CPGH09T304 K313	B188
CPGH09T304 K68	B188
CPGH09T304 KC5010	B188
CPGH09T304 KC5025	B188
CPGH09T304 KCM15B	B188
CPGH09T304 KCP10B	B188
CPGH09T304 KCP25B	B188
CPGH09T304 KCU10	B188
CPGH09T304 KCU25	B188
CPGH09T304 KT315	B188
CPGH09T308 K313	B188
CPGH09T308 K68	B188
CPGH09T308 KC5010	B188
CPGH09T308 KC5025	B188
CPGH09T308 KCP10B	B188
CPGH09T308 KCP25B	B188
CPGH09T308 KCU10	B188
CPGH09T308 KCU25	B188
CPGN120304 K313	B166
CPGN120304 K68	B166
CPGN120304F KD1425	B345
CPGN120308 K313	B166
CPGN120308 K68	B166
CPGN120308F KD1425	B345
CPGT060201LF KC5010	B189
CPGT060201LF KC5025	B189
CPGT060201LF KC5410	B189
CPGT060201LF KCU10	B189
CPGT060202HP KC5010	B188
CPGT060202HP KC5025	B188
CPGT060202HP KC5410	B188
CPGT060202HP KCU10	B188
CPGT060202HP KCU25	B188
CPGT060202K K68	B188
CPGT060202LF KC5010	B189
CPGT060202LF KC5025	B189
CPGT060202LF KCU10	B189
CPGT060204HP KC5010	B188
CPGT060204HP KC5025	B188
CPGT060204HP KC5410	B188
CPGT060204HP KCU10	B188
CPGT060204HP KCU25	B188
CPGT060204K K313	B188
CPGT060204K K68	B188
CPGT060204K KC5010	B188
CPGT060204LF KC5010	B189
CPGT060204LF KC5025	B189
CPGT060204LF KC5410	B189
CPGT060204LF KCU10	B189
CPGT060208HP KC5010	B188
CPGT060208HP KC5410	B188
CPGT060208HP KCU25	B188
CPGT060208LF KC5010	B189
CPGT060208LF KC5025	B189
CPGT060208LF KCU10	B189
CPGT09T302HP K313	B188
CPGT09T302HP KC5010	B188
CPGT09T302HP KC5025	B188
CPGT09T302HP KC5410	B188
CPGT09T302HP KCU10	B188
CPGT09T302LF KC5010	B189
CPGT09T302LF KC5025	B189
CPGT09T302LF KCU10	B189
CPGT09T304HP K313	B188
CPGT09T304HP KC5010	B188
CPGT09T304HP KC5025	B188
CPGT09T304HP KC5410	B188
CPGT09T304HP KCU10	B188
CPGT09T304HP KCU25	B188
CPGT09T304LF KC5010	B189
CPGT09T304LF KC5025	B189
CPGT09T304LF KC5410	B189
CPGT09T304LF KCU10	B189
CPGT09T308HP KC5010	B188
CPGT09T308HP KC5410	B188
CPGT09T308HP KCU10	B188
CPGT09T308HP KCU25	B188
CPGT09T308LF KC5010	B189
CPGT09T308LF KC5025	B189
CPGT09T308LF KCU10	B189
CPGW060202FST KD1400	B346
CPGW060202FST KD1425	B346
CPGW060204E KD1405	B345
CPGW060204FST KD1400	B346
CPGW060204FST KD1425	B346
CPGW060204FWST KD1400	B346
CPGW060204FWST KD1425	B346
CPGW060208FST KD1400	B346
CPGW060208FST KD1425	B346
CPGW09T304E KD1405	B345
CPGW09T304FST KD1400	B346
CPGW09T304FST KD1425	B346
CPGW09T304S01015MT KB5630	B311
CPGW09T308FST KD1400	B346
CPGW09T308FST KD1425	B346
CPGW09T308FWST KD1400	B346
CPGW09T308FWST KD1425	B346
CPGW09T308S01015MT KB5630	B311
CPGW120408FWST KD1400	B346
CPGW120408FWST KD1425	B346
CPMT050202FP KCU10	B189
CPMT050202FP KCU25	B189
CPMT050202LF KC5010	B190
CPMT050204FP KCP25	B189
CPMT050204FP KCU10	B189
CPMT050204FP KCU25	B189
CPMT050204LF KC5010	B190
CPMT050204LF KC5025	B190
CPMT050204LF KT315	B190
CPMT060202FP KCM25	B189
CPMT060202FP KCP10	B189
CPMT060202FP KCP25	B189
CPMT060202FP KCU10	B189
CPMT060202FP KCU25	B189
CPMT060202FP KTP10	B189
CPMT060202FW KC5010	B189
CPMT060202FW KT315	B189
CPMT060202LF KC5010	B190
CPMT060202LF KC5025	B190
CPMT060204FP KCK20	B189
CPMT060204FP KCM25	B189
CPMT060204FP KCP10	B189
CPMT060204FP KCP25	B189
CPMT060204FP KCP25B	B189
CPMT060204FP KCU10	B189
CPMT060204FP KCU25	B189
CPMT060204FP KTP10	B189
CPMT060204FW KC5010	B189
CPMT060204FW KCK20	B189
CPMT060204FW KCU10	B189
CPMT060204FW KT315	B189
CPMT060204LF K313	B190
CPMT060204LF K68	B190
CPMT060204LF KC5010	B190
CPMT060204LF KC5025	B190
CPMT060204LF KCK05	B190
CPMT060204LF KCK15	B190
CPMT060204LF KCK15B	B190
CPMT060204LF KCK20	B190
CPMT060204LF KCM15	B190
CPMT060204LF KCM25	B190
CPMT060204LF KCP10	B190
CPMT060204LF KCP10B	B190
CPMT060204LF KCP25	B190
CPMT060204LF KCP25B	B190
CPMT060204LF KT315	B190
CPMT060204UF KC5010	B191
CPMT060204UF KCP10B	B191
CPMT060204UF KCP25	B191
CPMT060204UF KCP25B	B191
CPMT060208FP KCP25	B189
CPMT060208FP KTP10	B189
CPMT060208FW KC5010	B189
CPMT060208FW KCK20	B189
CPMT060208FW KCP25	B189
CPMT060208FW KCU10	B189
CPMT060208FW KT315	B189
CPMT060208LF K313	B190
CPMT060208LF KC5010	B190
CPMT060208LF KC5025	B190
CPMT060208LF KCK05	B190
CPMT060208LF KCK15	B190
CPMT060208LF KCM25	B190
CPMT060208LF KCP10	B190
CPMT060208LF KCP25	B190
CPMT060208LF KCP25B	B190
CPMT060208LF KCP30	B190
CPMT060208LF KT315	B190
CPMT060208MF KCK15	B190
CPMT060208MF KCK20	B190
CPMT060208MF KCK20B	B190
CPMT060208MF KCM15B	B190
CPMT060208MF KCM25B	B190
CPMT060208MF KCP10B	B190
CPMT060208MF KCP25B	B190
CPMT060208MP KCP25B	B190
CPMT060208MP KCU10	B190
CPMT09T302FP KCM25	B189
CPMT09T302FP KCU10	B189
CPMT09T302LF KC5010	B190
CPMT09T302LF KT315	B190
CPMT09T304FP KCM15	B189
CPMT09T304FP KCM25	B189
CPMT09T304FP KCP10	B189
CPMT09T304FP KCP25B	B189
CPMT09T304FP KCU10	B189
CPMT09T304FP KCU25	B189
CPMT09T304FW KC5010	B189
CPMT09T304FW KCK20B	B189
CPMT09T304FW KCP25	B189
CPMT09T304FW KT315	B189
CPMT09T304LF KC5010	B190
CPMT09T304LF KC5025	B190
CPMT09T304LF KCK05	B190
CPMT09T304LF KCK15B	B190
CPMT09T304LF KCK20	B190
CPMT09T304LF KCK20B	B190
CPMT09T304LF KCM15	B190
CPMT09T304LF KCM15B	B190
CPMT09T304LF KCM25	B190
CPMT09T304LF KCM25B	B190
CPMT09T304LF KCP05	B190
CPMT09T304LF KCP10	B190
CPMT09T304LF KCP10B	B190
CPMT09T304LF KCP25	B190
CPMT09T304LF KCP25B	B190
CPMT09T304LF KCP30	B190
CPMT09T304LF KT315	B190
CPMT09T304MW KCU10	B191
CPMT09T304UF KC5010	B191
CPMT09T304UF KCP25	B191
CPMT09T304UF KCP25B	B191
CPMT09T308FP KCM25	B189
CPMT09T308FP KCP10	B189
CPMT09T308FP KCP25B	B189
CPMT09T308FP KCU10	B189
CPMT09T308FP KCU25	B189
CPMT09T308FP KTP10	B189
CPMT09T308FW KC5010	B189
CPMT09T308FW KCK20	B189
CPMT09T308FW KCP25	B189
CPMT09T308FW KCU10	B189
CPMT09T308FW KT315	B189
CPMT09T308LF K68	B190
CPMT09T308LF KC5010	B190
CPMT09T308LF KC5025	B190
CPMT09T308LF KCK05	B190
CPMT09T308LF KCK15	B190
CPMT09T308LF KCK15B	B190
CPMT09T308LF KCK20	B190

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
CPMT09T308LF KCK20B	B190
CPMT09T308LF KCM15	B190
CPMT09T308LF KCM25	B190
CPMT09T308LF KCP10	B190
CPMT09T308LF KCP10B	B190
CPMT09T308LF KCP25	B190
CPMT09T308LF KCP25B	B190
CPMT09T308LF KCP30	B190
CPMT09T308LF KT315	B190
CPMT09T308MF KCK15	B190
CPMT09T308MF KCK15B	B190
CPMT09T308MF KCK20	B190
CPMT09T308MF KCK20B	B190
CPMT09T308MF KCM15	B190
CPMT09T308MF KCM15B	B190
CPMT09T308MF KCM25	B190
CPMT09T308MF KCM25B	B190
CPMT09T308MF KCM35	B190
CPMT09T308MF KCP10	B190
CPMT09T308MF KCP10B	B190
CPMT09T308MF KCP25	B190
CPMT09T308MF KCP25B	B190
CPMT09T308MP KCK20	B190
CPMT09T308MP KCM25	B190
CPMT09T308MP KCM25B	B190
CPMT09T308MP KCP10	B190
CPMT09T308MP KCP25	B190
CPMT09T308MP KCP25B	B190
CPMT09T308MP KCU10	B190
CPMT09T308MW KC5010	B191
CPMT09T308MW KCK20	B191
CPMT09T308MW KCK20B	B191
CPMT09T308MW KCP25	B191
CPMT09T312MF KCM25B	B190
CPMT09T312MF KCP25	B190
CRDNN2525M12MN4	B362
CRDNN2525M12MN7	B362
CRDNN3225P12MN4	B362
CRDNN3225P12MN7	B362
CRDPN2525M06V	B168, B370
CRDPN2525M09V	B168, B370
CRDPN3232P09V	B168, B370
CRDPN3232P12V	B168, B370
CRDPN3232P15V	B168, B370
CRGPL2525M06V	B168, B370
CRGPL3232P09V	B168, B370
CRGPR2525M06V	B168, B370
CRGPR3232P09V	B168, B370
CRSNL2525M12-MN4	B362
CRSNL2525M12MN7	B362
CRSNL3225P12MN4	B362
CRSNL3225P12MN7	B362
CRSNR2525M12-MN4	B362
CRSNR2525M12MN7	B362
CRSNR3225P12MN4	B362
CRSNR3225P12MN7	B362
CS412	B168, B370
CSBPR2020K12	B170, B353
CSDNN2525M12MX7	B363
CSDPN2020K12	B170, B353
CSDPN2525M12	B170, B353
CSKNL2525M12-MN4	B363
CSKNL2525M12-MN7	B363
CSKNR2525M12-MN7	B363
CSKPR12CA12	B375
CSRNL2525M12-MN4	B364
CSRNL2525M12-MN7	B364
CSRNL3225P12-MN7	B364
CSRNL3225P15-MX7	B364
CSRNR2525M12-MN4	B364
CSRNR2525M12-MN7	B364
CSRPR10CA09	B376
CSSNL2525M12-MN7	B365
CSSNL2525M12-MX7	B365
CSSNL3225P12-MN4	B365
CSSNL3225P12-MN7	B365
CSSNR2525M12-MN7	B365
CSSNR2525M12-MX7	B365
CSSNR3225P12-MN4	B365
CSSNR3225P12-MN7	B365
CSSNR3225P15-MX7	B365
CSSPL10CA09	B377
CSSPL2525M12	B170, B354
CSSPR10CA09	B377
CSSPR2020K12	B170, B354
CSSPR2525M12	B170, B354
CSWM 035 040	B199, B202, B204–205
CSWM 040 050	B199–205, B229, B260–262
CSWM 060 050	B70–73, B92, B115–121, B139–142, B183, B199, B202, B220–221, B229, B235–237, B240–242, B260–263, B375–378, C171, D41–42
CSWM 080 050	B70–73, B92–93, B115–117, B119, B139–141, B183, B235, B378
CSWM 100 080	B72, B115, B119, C171, D41–42
CSXNL2525M12-MN4	B366
CSXNR2525M12-MN4	B366
CSXNR3225P12-MX7	B366
CSYNL2525M12-MN7	B367
CSYNL3225P12-MX7	B367
CSYNR2525M12-MN7	B367
CT11 WG	B273
CTCPN2510M11	B172, B354
CTCPN2514M16	B172, B354
CTCPN2518M22	B172, B354
CTCPN2520M22	B172, B354
CTDPR1212F11	B172, B355
CTFNL2525M16-MN4	B368
CTFNR2525M16-MN4	B368
CTFPL10CA11	B378
CTFPR10CA11	B378
CTFPR12CA16	B378
CTFPR20CA22	B378
CTGNL2525M16-MN4	B368
CTGNL2525M16-MN7	B368
CTGNR2525M16-MN4	B368
CTGNR2525M16-MN7	B368
CTGPL1212F11	B173, B355
CTGPL2020K16	B173, B355
CTGPL2525M16	B173, B355
CTGPR1212F11	B173, B355
CTGPR1616H11	B173, B355
CTGPR2020K11	B173, B355
CTGPR2020K16	B173, B355
CTGPR2525M16	B173, B355
CV40BDL10041M	053
CV40BDL12041M	053
CV40BDL16050M	053
CV40BDL20050M	053
CV40BDL25056M	053
CV40BDL32065M	053
CV40BKR32157	K86
CV40BKR50236	K86
CV40BSIF80248	K44
CV40FBHM1691	K130
CV40FBHMKIT645	K123, K127
CV50BHTS13M295	J79
CV50BHTS16M295	J79
CV50BHTS22M295	J79
CV50BHTS27M295	J79
CV50BHTS32M314	J79
CV50BHTS40M314	J79
CV50BHTS50M314	J79
CV50BKR32157	K86
CV50BKR50157	K86
CV50BKR63236	K86
CV50BKR80275	K86
CV50BSIF100236	K44
CV50BSIF70236	K44
CV50BT13069	K138
CV50RMHTS13M394	J79
CV50RMHTS16M394	J79
CV50RMHTS22M394	J79
CV50RMHTS27M394	J79
CV50RMHTS32M394	J79
CV50RMHTS40M413	J79
CV50RMHTS50M413	J79
CW16	S32–33
CWLNL2525M08-MX7	B369
CWLNR3225P08-MX7	B369
D100MTTB1330KM63	B387
D25MTTB400	B386
D2FIX110403LHP KCU10	E9
D2FIX110403RHP KCP25	E9
D2FIX110403RHP KCU10	E9
D2FIX110404RHP KCU25	E9
D2FIX110405LMN KCP25	E9
D2FIX110405LMN KCP40	E9
D2FIX110405RMN KCP25	E9
D2FIX110405RMN KCP40	E9
D2FIX150503LHP KCU10	E9
D2FIX150503LMS KCU10	E10
D2FIX150503RHP KCP25	E9
D2FIX150503RHP KCU10	E9
D2FIX150503RMN KCP25	E9
D2FIX150503RMS KCU10	E10
D2FIX150504RHP KCU10	E9
D2FIX150504RHP KCU25	E9
D2FIX150504RMN KCP25	E9
D2FIX150505LMN KCP25	E9
D2FIX150505LMS KCU10	E10
D2FIX150505LRN KCP25	E10
D2FIX150505RFN KCP25	E10
D2FIX150505RFN KCU10	E10
D2FIX150505RMN KCP10	E9
D2FIX150505RMN KCP25	E9
D2FIX150505RMN KCP40	E9
D2FIX150505RMS KCU10	E10
D2FIX150505RRN KCP10	E10
D2FIX150505RRN KCP40	E10
D2FIX150508LHP KCU10	E9
D2FIX150508LMN KCP25	E9
D2FIX150508RHP KCU10	E9
D2FIX150508RHP KCU25	E9
D2FIX150508RMN KCP25	E9
D315CFA	S33
D32MTTB447	B386
D355CFA	S33
D4007T S	V87–89
D4008T S	V87–89, V93–94
D400CFA	S33
D4010T S	V18–19, V21, V94, V101–104
D4012T S	V21
D40MTTB530	B386
D40MTTB560KM40	B387
D4FIX140603RMN KCP10	E11
D4FIX140603RMN KCP25	E11
D4FIX140604RMN KCP40	E11
D4FIX140604RMN KCU25	E11
D4FIX140605RMN KCP10	E11
D4FIX140605RMN KCP25	E11
D4FIX140608LMN KCP25	E11
D4FIX140608RMN KCP10	E11
D4FIX140608RMN KCP25	E11
D4FIX140608RMN KCU10	E11
D4FIX140608RMN KCU25	E11
D500CFA	S33
D5013T S	V101–102, V104
D50MTTB700	B386
D50MTTB737KM40	B387
D6014T S	V102
D60MTTB1000KM40	B387
D80MTTB1120KM63	B387
DCGM11T304S01325MTCB1 KBH20	B311
DCGR150404 KC5010	E28
DCGR150404 KCU10	E28
DCGR150404 KCU25	E28
DCGR150404FP KCP25	E28
DCGR150404FP KCU10	E28
DCGR150408 K68	E28
DCGR150408 KC5010	E28
DCGR150408 KCU10	E28
DCGR150408 KCU25	E28
DCGR150408 KD1425	E28
DCGR150408FP KCM25	E28
DCGR150408FP KCP10	E28
DCGR150412 KC5010	E28
DCGR150412 KCU25	E28
DCGT070201LF KC5010	B206
DCGT070201LF KC5025	B206
DCGT070201LF KCU10	B206
DCGT070202HP K313	B206
DCGT070202HP KC5010	B206
DCGT070202HP KC5025	B206
DCGT070202HP KC5410	B206
DCGT070202HP KCU10	B206
DCGT070202HP KCU25	B206
DCGT070204HP K313	B206
DCGT070204HP KC5010	B206
DCGT070204HP KC5025	B206
DCGT070204HP KC5410	B206
DCGT070204HP KCU10	B206
DCGT070204HP KCU25	B206
DCGT070208HP KC5010	B206
DCGT070208HP KC5025	B206
DCGT070208HP KC5410	B206
DCGT070208HP KCU10	B206
DCGT0702X0LF KC5025	B206
DCGT11T301LF KC5010	B206
DCGT11T301LF KC5025	B206
DCGT11T301LF KCU10	B206
DCGT11T302HP K313	B206
DCGT11T302HP KC5010	B206
DCGT11T302HP KC5025	B206
DCGT11T302HP KC5410	B206
DCGT11T302HP KCU10	B206
DCGT11T302HP KCU25	B206
DCGT11T304HP K313	B206
DCGT11T304HP KC5010	B206
DCGT11T304HP KC5025	B206
DCGT11T304HP KC5410	B206
DCGT11T304HP KCU10	B206
DCGT11T304HP KCU25	B206
DCGT11T308HP K313	B206
DCGT11T308HP KC5010	B206
DCGT11T308HP KC5025	B206
DCGT11T308HP KC5410	B206
DCGT11T308HP KCU10	B206
DCGT11T308HP KCU25	B206
DCGT11T3X0LF KC5025	B206
DCGT150408LF KC5010	B206
DCGT150408LF KCU10	B206
DCGW070202S01015C KB5630	B291, B312
DCGW070202S01225MT KBH20	B312
DCGW070204FST KD1400	B346
DCGW070204FST KD1425	B346
DCGW070204S01015C KB5630	B291, B312
DCGW070204S01015MT KBH20	B312
DCGW070204S01225MT KBH20	B312
DCGW11T302S01015MT KBH10	B312
DCGW11T302S01225MT KBH20	B312
DCGW11T304FST KD1400	B346
DCGW11T304FST KD1425	B346
DCGW11T304S01015MT KB1345	B291
DCGW11T304S01015MT KB5630	B291, B312
DCGW11T304S01015MT KBH10	B312
DCGW11T304S01015MT KBH20	B312
DCGW11T304S01225MT KBH10	B312
DCGW11T304S01225MT KBH20	B312
DCGW11T308S01015FWMT KBH10	B312
DCGW11T308S01015FWMT KBH20	B312
DCGW11T308S01015MT KB1345	B291
DCGW11T308S01015MT KB5630	B291, B312
DCGW11T308S01015MT KBH10	B312
DCGW11T308S01015MT KBH20	B312
DCGW11T308S01225FWMT KBH10	B312
DCGW11T308S01225MT KBH10	B312
DCGW11T308S01225MT KBH20	B312
DCGW70202S01015MT KBH10	B312
DCGW70204S01015MT KBH10	B312
DCGW70204S01225MT KBH10	B312
DCKNL2020K12KC04	B58
DCKNL2525M12KC04	B58
DCKNL3225P12KC04	B58
DCKNR2020K12KC04	B58
DCKNR2525M12KC04	B58
DCKNR3225P12KC04	B58
DCKNR3232P16KC06	B58
DCLNL2020K12KC04	B59
DCLNL2525M12KC04	B59
DCLNL2525M16KC06	B59
DCLNL3225P12KC04	B59
DCLNL3225P16KC06	B59
DCLNL3232P16KC06	B59
DCLNL3232P19KC06	B59

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
DCLNL4040S19KC06	B59
DCLNR1616H09KC03	B59
DCLNR2020K12KC04	B59
DCLNR2525M12KC04	B59
DCLNR2525M16KC06	B59
DCLNR3225P12KC04	B59
DCLNR3225P16KC06	B59
DCLNR3232P16KC06	B59
DCLNR3232P19KC06	B59
DCLNR4040S19KC06	B59
DCMT07020211 KT315	B206
DCMT070202FP KCM25	B207
DCMT070202FP KCP25B	B207
DCMT070202FP KCU10	B207
DCMT070202FP KTP10	B207
DCMT070202LF K313	B207
DCMT070202LF KC5010	B207
DCMT070202LF KC5025	B207
DCMT07020411 KT315	B206
DCMT070204FP KCM15	B207
DCMT070204FP KCM25	B207
DCMT070204FP KCM25B	B207
DCMT070204FP KCP10	B207
DCMT070204FP KCP25	B207
DCMT070204FP KCU10	B207
DCMT070204FP KCU25	B207
DCMT070204LF K313	B207
DCMT070204LF KC5010	B207
DCMT070204LF KC5025	B207
DCMT070204LF KCK15B	B207
DCMT070204LF KCK20	B207
DCMT070204LF KCM15	B207
DCMT070204LF KCM15B	B207
DCMT070204LF KCM25	B207
DCMT070204LF KCM25B	B207
DCMT070204LF KCM35	B207
DCMT070204LF KCP10	B207
DCMT070204LF KCP10B	B207
DCMT070204LF KCP25	B207
DCMT070204LF KCP25B	B207
DCMT070204LF KCP30	B207
DCMT070204LF KT315	B207
DCMT070204UF KC5010	B208
DCMT070204UF KCP25	B208
DCMT070208FP KCM25	B207
DCMT070208FP KCM25B	B207
DCMT070208FP KCP05	B207
DCMT070208FP KCP25	B207
DCMT070208FP KCP25B	B207
DCMT070208FP KCU10	B207
DCMT11T302FP KCM25	B207
DCMT11T302FP KCM25B	B207
DCMT11T302FP KCP10B	B207
DCMT11T302FP KCP25	B207
DCMT11T302FP KCP25B	B207
DCMT11T302FP KCU10	B207
DCMT11T302FP KCU25	B207
DCMT11T302FP KTP10	B207
DCMT11T302LF KC5010	B207
DCMT11T302LF KC5025	B207
DCMT11T302LF KT315	B207
DCMT11T302UF KC5010	B208
DCMT11T302UF KCP05	B208
DCMT11T30411 KT315	B206
DCMT11T304FP KCM15	B207
DCMT11T304FP KCM25	B207
DCMT11T304FP KCM25B	B207
DCMT11T304FP KCP05	B207
DCMT11T304FP KCP10	B207
DCMT11T304FP KCP10B	B207
DCMT11T304FP KCP25	B207
DCMT11T304FP KCP25B	B207
DCMT11T304FP KCU10	B207
DCMT11T304FP KCU25	B207
DCMT11T304FP KTP10	B207
DCMT11T304FW KC5010	B207
DCMT11T304FW KCK20	B207
DCMT11T304FW KCP25	B207
DCMT11T304FW KCU10	B207
DCMT11T304LF K313	B207
DCMT11T304LF KC5010	B207
DCMT11T304LF KC5025	B207
DCMT11T304LF KCK05	B207
DCMT11T304LF KCK15	B207
DCMT11T304LF KCK20	B207
DCMT11T304LF KCK20B	B207
DCMT11T304LF KCM15	B207
DCMT11T304LF KCM15B	B207
DCMT11T304LF KCM25	B207
DCMT11T304LF KCM25B	B207
DCMT11T304LF KCP05	B207
DCMT11T304LF KCP10	B207
DCMT11T304LF KCP10B	B207
DCMT11T304LF KCP25	B207
DCMT11T304LF KCP25B	B207
DCMT11T304LF KCP30	B207
DCMT11T304LF KT315	B207
DCMT11T304MF KCK15	B208
DCMT11T304MF KCK20	B208
DCMT11T304MF KCM15	B208
DCMT11T304MF KCM25	B208
DCMT11T304MF KCM25B	B208
DCMT11T304MF KCP10	B208
DCMT11T304MF KCP10B	B208
DCMT11T304MF KCP25	B208
DCMT11T304MF KCP25B	B208
DCMT11T304MF KCP30	B208
DCMT11T304MP KCP10	B208
DCMT11T304MP KCP25	B208
DCMT11T304MP KCU10	B208
DCMT11T304MW KCU10	B208
DCMT11T304UF KC5010	B208
DCMT11T304UF KCP05	B208
DCMT11T304UF KCP10B	B208
DCMT11T304UF KCP25B	B208
DCMT11T30811 KT315	B206
DCMT11T308FP KCK20B	B207
DCMT11T308FP KCM15	B207
DCMT11T308FP KCM25	B207
DCMT11T308FP KCM25B	B207
DCMT11T308FP KCP05	B207
DCMT11T308FP KCP10	B207
DCMT11T308FP KCP10B	B207
DCMT11T308FP KCP25	B207
DCMT11T308FP KCU10	B207
DCMT11T308FP KCU25	B207
DCMT11T308FP KTP10	B207
DCMT11T308FW KCP25	B207
DCMT11T308FW KCU10	B207
DCMT11T308FW KT315	B207
DCMT11T308LF K313	B207
DCMT11T308LF KC5010	B207
DCMT11T308LF KC5025	B207
DCMT11T308LF KCK05	B207
DCMT11T308LF KCK15	B207
DCMT11T308LF KCK15B	B207
DCMT11T308LF KCK20	B207
DCMT11T308LF KCK20B	B207
DCMT11T308LF KCM15	B207
DCMT11T308LF KCM15B	B207
DCMT11T308LF KCM25	B207
DCMT11T308LF KCM25B	B207
DCMT11T308LF KCP10	B207
DCMT11T308LF KCP10B	B207
DCMT11T308LF KCP25	B207
DCMT11T308LF KCP25B	B207
DCMT11T308LF KCU10	B207
DCMT11T308LF KT315	B207
DCMT11T308MF KCK15	B208
DCMT11T308MF KCK20	B208
DCMT11T308MF KCM15	B208
DCMT11T308MF KCM15B	B208
DCMT11T308MF KCM25	B208
DCMT11T308MF KCM35	B208
DCMT11T308MF KCP10	B208
DCMT11T308MF KCP10B	B208
DCMT11T308MF KCP25	B208
DCMT11T308MF KCP25B	B208
DCMT11T308MF KCP30	B208
DCMT11T308MP KCK20	B208
DCMT11T308MP KCK20B	B208
DCMT11T308MP KCM15	B208
DCMT11T308MP KCM25	B208
DCMT11T308MP KCM25B	B208
DCMT11T308MP KCP10	B208
DCMT11T308MP KCP25	B208
DCMT11T308MP KCU10	B208
DCMT11T308MW KCP25	B208
DCMT11T308MW KCU10	B208
DCMT11T308UF KC5010	B208
DCMT11T308UF KCP05	B208
DCMT11T308UF KCP10	B208
DCMT11T308UF KCP10B	B208
DCMT11T308UF KCP25	B208
DCMT11T312FP KCP10	B207
DCMT11T312LF KC5010	B207
DCMT11T312LF KCP10	B207
DCMT11T312LF KCP10B	B207
DCMT11T312LF KCP25	B207
DCMT11T312MF KCK15	B208
DCMT11T312MF KCK20	B208
DCMT11T312MF KCK20B	B208
DCMT11T312MF KCP10	B208
DCMT11T312MF KCP10B	B208
DCMT11T312MF KCP25B	B208
DCMT11T312MP KCP25	B208
DCMT11T312MP KCU10	B208
DCMT150404FP KCM25	B207
DCMT150404FP KCP10	B207
DCMT150404LF KC5010	B207
DCMT150404LF KC5025	B207
DCMT150404LF KCP10	B207
DCMT150404LF KCP25B	B207
DCMT150408FP KCM25	B207
DCMT150408FP KCP05	B207
DCMT150408FP KCP25	B207
DCMT150408FP KCU10	B207
DCMT150408LF KC5010	B207
DCMT150408LF KC5025	B207
DCMT150408LF KCK20	B207
DCMT150408LF KCP10	B207
DCMT150408LF KCP10B	B207
DCMT150408LF KCP25	B207
DCMT150408LF KCP25B	B207
DCRNL2525M12KC04	B60
DCRNL3232P16KC06	B60
DCRNR2020K12KC04	B60
DCRNR2525M12KC04	B60
DCRNR3225P12KC04	B60
DCRNR3232P19KC06	B60
DCSNL2525M12KC04	B60
DCSNR2020K12KC04	B60
DCSNR2525M12KC04	B60
DDJNL2020K11KC04	B85
DDJNL2020K15KC06	B85
DDJNL2525M11KC04	B85
DDJNL2525M15KC06	B85
DDJNL3225P15KC06	B85
DDJNL3232P15KC06	B85
DDJNR2020K11KC04	B85
DDJNR2020K15KC06	B85
DDJNR2525M11KC04	B85
DDJNR2525M15KC06	B85
DDJNR3225P15KC06	B85
DDJNR3232P15KC06	B85
DDNNR2020K15KC06	B85
DDNNR2525M15KC06	B85
DFC040310D28DS KCU40	H90
DFC040310D28HP KCU25	H90
DFC040310D28HP KCU40	H90
DFC040310D28MD KC7140	H90
DFC05T312D32DS KCU40	H90
DFC05T312D32HP KCU25	H90
DFC05T312D32HP KCU40	H90
DFC05T312D32MD KC7140	H90
DFC06T312D36DS KCU40	H90
DFC06T312D36HP KCU25	H90
DFC06T312D36HP KCU40	H90
DFC06T312D36MD KC7140	H90
DFC070416D45DS KCU40	H90
DFC070416D45HP KCU25	H90
DFC070416D45HP KCU40	H90
DFC070416D45MD KC7140	H90
DFC090520D56DS KCU40	H90
DFC090520D56HP KCU25	H90
DFC090520D56HP KCU40	H90
DFC090520D56MD KC7140	H90
DFR020204GD KC7140	J84
DFR020204GD KCPK10	J84
DFR020204GD KCU25	J84
DFR020204GD KCU40	J84
DFR020204LD KC7140	J84
DFR020204LD KCPK10	J84
DFR020204LD KCU25	J84
DFR020204LD KCU40	J84
DFR020204MD KC7140	J84
DFR020204MD KCU25	J84
DFR020204MD KCU40	J84
DFR030204GD KC7140	J84
DFR030204GD KCPK10	J84
DFR030204GD KCU25	J84
DFR030204GD KCU40	J84
DFR030204LD KC7140	J84
DFR030204LD KCPK10	J84
DFR030204LD KCU25	J84
DFR030204LD KCU40	J84
DFR030204MD KC7140	J84
DFR030204MD KCU25	J84
DFR030204MD KCU40	J84
DFR040304D28GD KCU25	H89
DFR040304D28GD KCU40	H89
DFR040304D28LD KC7225	H89
DFR040304D28MD KC7140	H89, J84
DFR040304GD KC7140	J84
DFR040304GD KCPK10	J84
DFR040304GD KCU25	J84
DFR040304GD KCU40	J84
DFR040304LD KC7140	J84
DFR040304LD KCPK10	J84
DFR040304LD KCU25	J84
DFR040304LD KCU40	J84
DFR040304MD KC7140	J84
DFR040304MD KCU25	J84
DFR040304MD KCU40	J84
DFR040304ST KD1425	J85
DFR125R2WB20M	J13
DFR125R2WD20M	J10
DFR125R3WB20M	J14
DFR125R3WD20M	J11
DFR125R4WB20M	J15
DFR125R4WD20M	J12
DFR127R2WB20M	J13
DFR127R2WD20M	J10
DFR127R3WB20M	J14
DFR127R3WD20M	J11
DFR127R4WB20M	J15
DFR127R4WD20M	J12
DFR130R2WB20M	J13
DFR130R2WD20M	J10
DFR130R3WB20M	J14
DFR130R3WD20M	J11
DFR130R4WB20M	J15
DFR130R4WD20M	J12
DFR135R2WB20M	J13
DFR135R2WD20M	J10
DFR135R3WB20M	J14
DFR135R3WD20M	J11
DFR135R4WB20M	J15
DFR135R4WD20M	J12
DFR140R2WB20M	J13
DFR140R2WD20M	J10
DFR140R3WB20M	J14
DFR140R3WD20M	J11
DFR140R4WB20M	J15
DFR140R4WD20M	J12
DFR145R2WB20M	J13
DFR145R2WD20M	J10
DFR145R3WB20M	J14
DFR145R3WD20M	J11
DFR145R4WB20M	J15
DFR145R4WD20M	J12
DFR150R2WB20M	J13
DFR150R2WD20M	J10
DFR150R3WB20M	J14
DFR150R3WD20M	J11
DFR150R4WB20M	J15
DFR150R4WD20M	J12
DFR155R2WB20M	J13

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
DFR155R2WD20M	J10
DFR155R3WB20M	J14
DFR155R3WD20M	J11
DFR155R4WB20M	J15
DFR155R4WD20M	J12
DFR160R2WB20M	J13
DFR160R2WD20M	J10
DFR160R3WB20M	J14
DFR160R3WD20M	J11
DFR160R4WB20M	J15
DFR160R4WD20M	J12
DFR165R2WB20M	J13
DFR165R2WD32M	J10
DFR165R3WB20M	J14
DFR165R3WD32M	J11
DFR165R4WB20M	J15
DFR165R4WD32M	J12
DFR170R2WB20M	J13
DFR170R2WD32M	J10
DFR170R3WB20M	J14
DFR170R3WD32M	J11
DFR170R4WB20M	J15
DFR170R4WD32M	J12
DFR175R2WD32M	J10
DFR175R3WD25M	J11
DFR175R3WD32M	J11
DFR175R4WD32M	J12
DFR180R2WD32M	J10
DFR180R3WD25M	J11
DFR180R3WD32M	J11
DFR180R4WD32M	J12
DFR185R2WD32M	J10
DFR185R3WD25M	J11
DFR185R3WD32M	J11
DFR185R4WD32M	J12
DFR190R2WD32M	J10
DFR190R3WD25M	J11
DFR190R3WD32M	J11
DFR190R4WD32M	J12
DFR195R2WD32M	J10
DFR195R3WD25M	J11
DFR195R3WD32M	J11
DFR195R4WD32M	J12
DFR200R2WD32M	J10
DFR200R3WD25M	J11
DFR200R3WD32M	J11
DFR200R4WD32M	J12
DFR205R2WD32M	J10
DFR205R3WD25M	J11
DFR205R3WD32M	J11
DFR205R4WD32M	J12
DFR210R2WD32M	J10
DFR210R3WD25M	J11
DFR210R3WD32M	J11
DFR210R4WD32M	J12
DFR220R2WD32M	J10
DFR220R3WD25M	J11
DFR220R3WD32M	J11
DFR220R4WD32M	J12
DFR230R2WD32M	J10
DFR230R3WD25M	J11
DFR230R3WD32M	J11
DFR230R4WD32M	J12
DFR240R2WD32M	J10
DFR240R3WD25M	J11
DFR240R3WD32M	J11
DFR240R4WD32M	J12
DFSP140R2WB20M	J30
DFSP140R2WD20M	J22
DFSP140R3WB20M	J32
DFSP140R3WD20M	J24
DFSP140R4WB20M	J34
DFSP140R4WD20M	J26
DFSP140R5WB20M	J36
DFSP145R2WB20M	J30
DFSP145R2WD20M	J22
DFSP145R3WB20M	J32
DFSP145R3WD20M	J24
DFSP145R4WB20M	J34
DFSP145R4WD20M	J26
DFSP145R5WB20M	J36
DFSP150R2WB20M	J30
DFSP150R2WD20M	J22
DFSP150R3WB20M	J32
DFSP150R3WD20M	J24
DFSP150R4WB20M	J34
DFSP150R4WD20M	J26
DFSP150R5WB20M	J36
DFSP155R2WB20M	J30
DFSP155R2WD20M	J22
DFSP155R3WB20M	J32
DFSP155R3WD20M	J24
DFSP155R4WB20M	J34
DFSP155R4WD20M	J26
DFSP155R5WB20M	J36
DFSP160R2WB20M	J30
DFSP160R2WD20M	J22
DFSP160R3WB20M	J32
DFSP160R3WD20M	J24
DFSP160R4WB20M	J34
DFSP160R4WD20M	J26
DFSP160R5WB20M	J36
DFSP165R2WB20M	J30
DFSP165R2WD32M	J22
DFSP165R3WB20M	J32
DFSP165R3WD32M	J24
DFSP165R4WB20M	J34
DFSP165R4WD20M	J26
DFSP165R5WB20M	J36
DFSP170R2WB20M	J30–31
DFSP170R2WD32M	J22–23
DFSP170R3WB20M	J32–33
DFSP170R3WD32M	J24–25
DFSP170R4WB20M	J34–35
DFSP170R4WD20M	J26–27
DFSP170R5WB20M	J36–37
DFSP175R2WB25M	J30
DFSP175R2WD32M	J22
DFSP175R3WB25M	J32
DFSP175R3WD32M	J24
DFSP175R4WB25M	J34
DFSP175R4WD32M	J26
DFSP175R5WB25M	J36
DFSP180R2WB25M	J30
DFSP180R2WD32M	J22
DFSP180R3WB25M	J32
DFSP180R3WD32M	J24
DFSP180R4WB25M	J34
DFSP180R4WD32M	J26
DFSP180R5WB25M	J36
DFSP185R2WB25M	J30
DFSP185R2WD32M	J22
DFSP185R3WB25M	J32
DFSP185R3WD32M	J24
DFSP185R4WB25M	J34
DFSP185R4WD32M	J26
DFSP185R5WB25M	J36
DFSP190R2WB25M	J30
DFSP190R2WD32M	J22
DFSP190R3WB25M	J32
DFSP190R3WD32M	J24
DFSP190R4WB25M	J34
DFSP190R4WD32M	J26
DFSP190R5WB25M	J36
DFSP195R2WB25M	J30
DFSP195R2WD32M	J22
DFSP195R3WB25M	J32
DFSP195R3WD32M	J24
DFSP195R4WB25M	J34
DFSP195R4WD32M	J26
DFSP195R5WB25M	J36
DFSP200R2WB25M	J30
DFSP200R2WD32M	J22
DFSP200R3WB25M	J32
DFSP200R3WD32M	J24
DFSP200R4WB25M	J34
DFSP200R4WD32M	J26
DFSP200R5WB25M	J36
DFSP200R5WD32M	J28
DFSP205R2WB25M	J30
DFSP205R3WB25M	J32
DFSP205R4WB25M	J34
DFSP205R5WB25M	J36
DFSP209R2WB25M	J30
DFSP209R3WB25M	J32
DFSP209R4WB25M	J34
DFSP209R5WB25M	J36
DFSP210R2WB25M	J30
DFSP210R2WD32M	J22–23
DFSP210R3WB25M	J32
DFSP210R3WD32M	J24–25
DFSP210R4WB25M	J34
DFSP210R4WD32M	J26–27
DFSP210R5WB25M	J36
DFSP210R5WD32M	J28–29
DFSP215R2WB25M	J30–31
DFSP215R3WB25M	J32–33
DFSP215R4WB25M	J34–35
DFSP215R5WB25M	J36–37
DFSP220R2WB25M	J30
DFSP220R2WD32M	J22
DFSP220R3WB25M	J32
DFSP220R3WD32M	J24
DFSP220R4WB25M	J34
DFSP220R4WD32M	J26
DFSP220R5WB25M	J36
DFSP220R5WD32M	J28
DFSP225R2WB25M	J30
DFSP225R3WB25M	J32
DFSP225R4WB25M	J34
DFSP225R5WB25M	J36
DFSP230R2WB25M	J30
DFSP230R2WD32M	J22
DFSP230R3WB25M	J32
DFSP230R3WD32M	J24
DFSP230R4WB25M	J34
DFSP230R4WD32M	J26
DFSP230R5WB25M	J36
DFSP230R5WD32M	J28
DFSP235R2WB25M	J30
DFSP235R3WB25M	J32
DFSP235R4WB25M	J34
DFSP235R5WB25M	J36
DFSP239R2WB25M	J30
DFSP239R3WB25M	J32
DFSP239R4WB25M	J34
DFSP239R5WB25M	J36
DFSP240R2WB25M	J30
DFSP240R2WD32M	J22
DFSP240R3WB25M	J32
DFSP240R3WD32M	J24
DFSP240R4WB25M	J34
DFSP240R4WD32M	J26
DFSP240R5WB25M	J36
DFSP240R5WD32M	J28
DFSP245R2WB25M	J30
DFSP245R3WB25M	J32
DFSP245R4WB25M	J34
DFSP245R5WB25M	J36
DFSP250R2WB25M	J30
DFSP250R2WD32M	J22–23
DFSP250R3WB25M	J32
DFSP250R3WD32M	J24–25
DFSP250R4WB25M	J34
DFSP250R4WD32M	J26–27
DFSP250R5WB25M	J36
DFSP250R5WD32M	J28–29
DFSP255R2WB25M	J30–31
DFSP255R3WB25M	J32–33
DFSP255R4WB25M	J34–35
DFSP255R5WB25M	J36–37
DFSP260R2WB32M	J30
DFSP260R2WD32M	J22
DFSP260R3WB32M	J32
DFSP260R3WD32M	J24
DFSP260R4WB32M	J34
DFSP260R4WD32M	J26
DFSP260R5WB32M	J36
DFSP260R5WD32M	J28
DFSP264R2WB32M	J30
DFSP264R3WB32M	J32
DFSP264R4WB32M	J34
DFSP264R5WB32M	J36
DFSP265R2WB32M	J30
DFSP265R2WD32M	J22
DFSP265R3WB32M	J32
DFSP265R3WD32M	J24
DFSP265R4WB32M	J34
DFSP265R4WD32M	J26
DFSP265R5WB32M	J36
DFSP265R5WD32M	J28
DFSP270R2WB32M	J30
DFSP270R2WD32M	J22
DFSP270R3WB32M	J32
DFSP270R3WD32M	J24
DFSP270R4WB32M	J34
DFSP270R4WD32M	J26
DFSP270R5WB32M	J36
DFSP270R5WD32M	J28
DFSP280R2WB32M	J30
DFSP280R2WD32M	J22
DFSP280R3WB32M	J32
DFSP280R3WD32M	J24
DFSP280R4WB32M	J34
DFSP280R4WD32M	J26
DFSP280R5WB32M	J36
DFSP280R5WD32M	J28
DFSP290R2WB32M	J30
DFSP290R2WD32M	J22
DFSP290R3WB32M	J32
DFSP290R3WD32M	J24
DFSP290R4WB32M	J34
DFSP290R4WD32M	J26
DFSP290R5WB32M	J36
DFSP290R5WD32M	J28
DFSP294R2WB32M	J30
DFSP294R3WB32M	J33
DFSP294R4WB32M	J35
DFSP294R5WB32M	J37
DFSP300R2WB32M	J30
DFSP300R2WD32M	J22
DFSP300R3WB32M	J33
DFSP300R3WD32M	J24
DFSP300R4WB32M	J35
DFSP300R4WD32M	J26
DFSP300R5WB32M	J37
DFSP300R5WD32M	J28
DFSP310R2WB40M	J30
DFSP310R2WD32M	J22
DFSP310R3WB40M	J33
DFSP310R3WD32M	J24
DFSP310R4WB40M	J35
DFSP310R4WD32M	J26
DFSP310R5WB40M	J37
DFSP310R5WD32M	J28
DFSP320R2WB40M	J30–31
DFSP320R2WD32M	J22–23
DFSP320R3WB40M	J33
DFSP320R3WD32M	J24–25
DFSP320R4WB40M	J35
DFSP320R4WD32M	J26–27
DFSP320R5WB40M	J37
DFSP320R5WD32M	J28–29
DFSP330R2WB40M	J31
DFSP330R2WD32M	J22
DFSP330R3WB40M	J33
DFSP330R3WD32M	J24
DFSP330R4WB40M	J35
DFSP330R4WD32M	J26
DFSP330R5WB40M	J37
DFSP330R5WD32M	J28
DFSP340R2WB40M	J31
DFSP340R2WD32M	J22
DFSP340R3WB40M	J33
DFSP340R3WD32M	J24
DFSP340R4WB40M	J35
DFSP340R4WD32M	J26
DFSP340R5WB40M	J37
DFSP340R5WD32M	J28
DFSP350R2WB40M	J31
DFSP350R2WD32M	J22
DFSP350R3WB40M	J33
DFSP350R3WD32M	J24
DFSP350R4WB40M	J35
DFSP350R4WD32M	J26
DFSP350R5WB40M	J37
DFSP350R5WD32M	J28
DFSP360R2WB40M	J31

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
DFSP360R2WD32M	J22
DFSP360R3WB40M	J33
DFSP360R3WD32M	J24
DFSP360R4WB40M	J35
DFSP360R4WD32M	J26
DFSP360R5WB40M	J37
DFSP360R5WD32M	J28
DFSP370R2WB40M	J31
DFSP370R2WD32M	J22
DFSP370R3WB40M	J33
DFSP370R3WD32M	J24
DFSP370R4WB40M	J35
DFSP370R4WD32M	J26
DFSP370R5WB40M	J37
DFSP370R5WD32M	J28
DFSP375R2WD32M	J22
DFSP375R3WD32M	J24
DFSP375R4WD32M	J26
DFSP375R5WD32M	J28
DFSP380R2WB40M	J31
DFSP380R2WD32M	J22
DFSP380R3WB40M	J33
DFSP380R3WD32M	J24
DFSP380R4WB40M	J35
DFSP380R4WD32M	J26
DFSP380R5WB40M	J37
DFSP380R5WD32M	J28
DFSP390R2WB40M	J31
DFSP390R2WD32M	J22
DFSP390R3WB40M	J33
DFSP390R3WD32M	J24
DFSP390R4WB40M	J35
DFSP390R4WD32M	J26
DFSP390R5WB40M	J37
DFSP390R5WD32M	J28
DFSP400R2WB40M	J31
DFSP400R2WD32M	J22–23
DFSP400R3WB40M	J33
DFSP400R3WD32M	J24–25
DFSP400R4WB40M	J35
DFSP400R4WD32M	J26–27
DFSP400R5WB40M	J37
DFSP400R5WD32M	J28–29
DFSP410R2WD32M	J22
DFSP410R3WD32M	J24
DFSP410R4WD32M	J26
DFSP410R5WD32M	J28
DFSP420R2WD32M	J23
DFSP420R3WD32M	J25
DFSP420R4WD32M	J27
DFSP420R5WD32M	J28
DFSP430R2WD32M	J23
DFSP430R3WD32M	J25
DFSP430R4WD32M	J27
DFSP430R5WD32M	J28–29
DFSP440R2WD32M	J23
DFSP440R3WD32M	J25
DFSP440R4WD32M	J27
DFSP440R5WD32M	J28
DFSP450R2WD40M	J23
DFSP450R3WD40M	J25
DFSP450R4WD40M	J27
DFSP450R5WD40M	J28
DFSP460R2WD40M	J23
DFSP460R3WD40M	J25
DFSP460R4WD40M	J27
DFSP460R5WD40M	J28
DFSP470R2WD40M	J23
DFSP470R3WD40M	J25
DFSP470R4WD40M	J27
DFSP470R5WD40M	J28
DFSP480R2WD40M	J23
DFSP480R3WD40M	J25
DFSP480R4WD40M	J27
DFSP480R5WD40M	J28–29
DFSP490R2WD40M	J23
DFSP490R3WD40M	J25
DFSP490R4WD40M	J27
DFSP490R5WD40M	J28
DFSP500R2WD40M	J23
DFSP500R3WD40M	J25
DFSP500R4WD40M	J27
DFSP500R5WD40M	J28
DFSP505R2WD40M	J23
DFSP505R3WD40M	J25
DFSP510R2WD40M	J23
DFSP510R3WD40M	J25
DFSP510R4WD40M	J27
DFSP510R5WD40M	J28
DFSP520R2WD40M	J23
DFSP520R3WD40M	J25
DFSP520R4WD40M	J27
DFSP520R5WD40M	J28
DFSP530R2WD40M	J23
DFSP530R3WD40M	J25
DFSP530R4WD40M	J27
DFSP530R5WD40M	J28
DFSP540R2WD40M	J23
DFSP540R3WD40M	J25
DFSP540R4WD40M	J27
DFSP540R5WD40M	J28
DFSP550R2WD50M	J23
DFSP550R3WD50M	J25
DFSP550R4WD50M	J27
DFSP550R5WD50M	J28–29
DFT030204GD KCPK10	J87
DFT030204GD KCU25	J87
DFT030204GD KCU40	J87
DFT030204HP KC7140	J87
DFT030204HP KCPK10	J87
DFT030204HP KCU25	J87
DFT030204HP KCU40	J87
DFT030204HP KMF	J87
DFT030204MD KC7140	J87
DFT030204MD KCU25	J87
DFT030204MD KCU40	J87
DFT030304DS KCU40	J88
DFT030304GD KC7140	J87
DFT030304GD KCPK10	J87
DFT030304GD KCU25	J87
DFT030304GD KCU40	J87
DFT030304HP KC7140	J87
DFT030304HP KCPK10	J87
DFT030304HP KCU25	J87
DFT030304HP KCU40	J87
DFT030304HP KMF	J87
DFT030304MD KC7140	J87
DFT030304MD KCU25	J87
DFT030304MD KCU40	J87
DFT05T308D32DS KCU40	H88
DFT05T308D32HP KCU25	H88
DFT05T308D32HP KCU40	H88
DFT05T308D32MD KC7140	H89
DFT05T308D33DS KCU40	H88
DFT05T308D33HP KCU25	H88
DFT05T308D33HP KCU40	H88
DFT05T308D33MD KC7140	H89
DFT05T308DS KCU40	J88
DFT05T308GD KC7140	J87
DFT05T308GD KCPK10	J87
DFT05T308GD KCU25	J87
DFT05T308GD KCU40	J87
DFT05T308HP KC7140	J87
DFT05T308HP KCPK10	J87
DFT05T308HP KCU25	J87
DFT05T308HP KCU40	J87
DFT05T308HP KMF	J87
DFT05T308MD KC7140	J87
DFT05T308MD KCU25	J87
DFT05T308MD KCU40	J87
DFT05T308ST KD1425	J85
DFT06T308D36DS KCU40	H88
DFT06T308D36HP KCU25	H88
DFT06T308D36HP KCU40	H88
DFT06T308D36MD KC7140	H89
DFT06T308D39DS KCU40	H88
DFT06T308D39HP KCU25	H88
DFT06T308D39HP KCU40	H88
DFT06T308D39MD KC7140	H89
DFT06T308D44DS KCU40	H88
DFT06T308D44HP KCU25	H88
DFT06T308D44HP KCU40	H88
DFT06T308D44MD KC7140	H89
DFT06T308DS KCU40	J88
DFT06T308GD KC7140	J87
DFT06T308GD KCPK10	J87
DFT06T308GD KCU25	J87
DFT06T308GD KCU40	J87
DFT06T308HP KC7140	J87
DFT06T308HP KCPK10	J87
DFT06T308HP KCU25	J87
DFT06T308HP KCU40	J87
DFT06T308HP KMF	J87
DFT06T308MD KC7140	J87
DFT06T308MD KCU25	J87
DFT06T308MD KCU40	J87
DFT06T308ST KD1425	J85
DFT070408D45DS KCU40	H88
DFT070408D45HP KCU25	H88
DFT070408D45HP KCU40	H88
DFT070408D45MD KC7140	H89
DFT070408D50DS KCU40	H88
DFT070408D50HP KCU25	H88
DFT070408D50HP KCU40	H88
DFT070408D50MD KC7140	H89
DFT070408DS KCU40	J88
DFT070408GD KC7140	J87
DFT070408GD KCPK10	J87
DFT070408GD KCU25	J87
DFT070408GD KCU40	J87
DFT070408HP KC7140	J87
DFT070408HP KCPK10	J87
DFT070408HP KCU25	J87
DFT070408HP KCU40	J87
DFT070408HP KMF	J87
DFT070408MD KC7140	J87
DFT070408MD KCU25	J87
DFT070408MD KCU40	J87
DFT070408ST KD1425	J85
DFT090508D56DS KCU40	H88
DFT090508D56HP KCU25	H88
DFT090508D56HP KCU40	H88
DFT090508D56MD KC7140	H89
DFT090508D63DS KCU40	H88
DFT090508D63HP KCU25	H88
DFT090508D63HP KCU40	H88
DFT090508D63MD KC7140	H89
DFT090508DS KCU40	J88
DFT090508GD KC7140	J87
DFT090508GD KCPK10	J87
DFT090508GD KCU25	J87
DFT090508GD KCU40	J87
DFT090508HP KC7140	J87
DFT090508HP KCPK10	J87
DFT090508HP KCU25	J87
DFT090508HP KCU40	J87
DFT090508HP KMF	J87
DFT090508MD KC7140	J87
DFT090508MD KCU25	J87
DFT090508MD KCU40	J87
DFT090508ST KD1425	J85
DFT110508MD KC7140	J87
DFT110508ST KD1425	J85
DFT250R2WD32M	J44
DFT250R2WD40M	J44
DFT250R4WD32M	J46
DFT250R4WD40M	J46
DFT260R2WD32M	J44
DFT260R2WD40M	J44
DFT260R4WD32M	J46
DFT260R4WD40M	J46
DFT270R2WD32M	J44
DFT270R2WD40M	J44
DFT270R4WD32M	J46
DFT270R4WD40M	J46
DFT280R2WD32M	J44
DFT280R2WD40M	J44
DFT280R4WD32M	J46
DFT280R4WD40M	J46
DFT290R2WD32M	J44
DFT290R2WD40M	J44
DFT290R4WD32M	J46
DFT290R4WD40M	J46
DFT300R2WD32M	J44
DFT300R2WD40M	J44
DFT300R4WD32M	J46
DFT300R4WD40M	J46
DFT310R2WD32M	J44
DFT310R2WD40M	J44
DFT310R4WD32M	J46
DFT310R4WD40M	J46
DFT320R2WD32M	J44
DFT320R2WD40M	J44
DFT320R4WD32M	J46
DFT320R4WD40M	J46
DFT330R2WD32M	J44
DFT330R2WD40M	J44
DFT330R4WD40M	J46
DFT340R2WD32M	J44
DFT340R2WD40M	J44
DFT340R4WD40M	J46
DFT350R2WD32M	J44
DFT350R2WD40M	J44
DFT350R4WD40M	J46
DFT360R2WD32M	J44
DFT360R2WD40M	J44
DFT360R4WD40M	J46
DFT370R2WD32M	J44
DFT370R2WD40M	J44
DFT370R4WD40M	J46
DFT380R2WD32M	J44
DFT380R2WD40M	J44
DFT380R4WD40M	J46
DFT390R2WD32M	J44
DFT390R2WD40M	J44
DFT390R4WD40M	J46
DFT400R2WD32M	J44
DFT400R2WD40M	J44
DFT400R4WD40M	J46
DFT410R2WD32M	J44
DFT410R2WD40M	J44
DFT410R4WD40M	J46
DFT420R2WD32M	J44
DFT420R2WD40M	J44
DFT420R4WD40M	J46
DFT430R2WD32M	J44
DFT430R2WD40M	J44
DFT430R4WD40M	J46
DFT440R2WD32M	J44
DFT440R2WD40M	J44
DFT440R4WD40M	J46
DFT450R2WD40M	J44
DFT450R2WD50M	J44
DFT450R4WD40M	J46
DFT460R2WD40M	J44
DFT460R2WD50M	J44
DFT460R4WD40M	J46
DFT470R2WD40M	J44
DFT470R2WD50M	J44
DFT470R4WD40M	J46
DFT480R2WD40M	J44
DFT480R2WD50M	J44
DFT480R4WD40M	J46
DFT490R2WD40M	J44
DFT490R2WD50M	J44
DFT500R2WD40M	J44
DFT500R2WD50M	J44
DFT510R2WD40M	J44
DFT510R2WD50M	J44
DFT520R2WD40M	J44
DFT520R2WD50M	J44
DFT530R2WD40M	J44
DFT530R2WD50M	J44
DFT540R2WD40M	J44
DFT540R2WD50M	J44
DFT550R2WD50M	J44
DFT560R2WD50M	J44
DFT570R2WD50M	J44
DFT580R2WD50M	J44
DFT590R2WD50M	J44
DFT600R2WD50M	J44
DFT610R2WD50M	J45
DFT620R2WD50M	J45
DFT630R2WD50M	J45
DFT640R2WD50M	J45
DFT650R2WD50M	J45
DFT660R2WD50M	J45
DFT670R2WD50M	J45

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
DFT680R2WD50M	J45
DFT690R2WD50M	J45
DFT700R2WD50M	J45
DFT710R2WD50M	J45
DFT720R2WD50M	J45
DFT730R2WD50M	J45
DFT740R2WD50M	J45
DFT750R2WD50M	J45
DFT760R2WD50M	J45
DFT770R2WD50M	J45
DFT780R2WD50M	J45
DFT790R2WD50M	J45
DFT800R2WD50M	J45
DFT810R2WD50M	J45
DFT820R2WD50M	J45
DFTX20204DS KCU40	J88
DFTX20204HP KC7140	J87
DFTX20204HP KCU25	J87
DFTX20204HP KCU40	J87
DFTX20204MD KC7140	J87
DFTX20204MD KCU25	J87
DFTX20204MD KCU40	J87
DH35M	S41, T102
DNGA150404E KD1405	B346
DNGA150404FST KD1400	B347
DNGA150404FST KD1425	B347
DNGA150404S01015MT KBH10	B314
DNGA150404S01015MT KBH20	B314
DNGA150404S01025MT KB5630	B290, B314
DNGA150404S01225MT KBH20	B314
DNGA150404S01735MT KBH20	B314
DNGA150404T02020 KY1615	B313
DNGA150408FST KD1400	B347
DNGA150408FST KD1425	B347
DNGA150408S01015FWMT KBH10	B313
DNGA150408S01015FWMT KBH20	B313
DNGA150408S01015MT KBH10	B314
DNGA150408S01015MT KBH20	B314
DNGA150408S01020MT KB1345	B290
DNGA150408S01025MT KB5630	B290, B314
DNGA150408S01225FWMT KBH10	B313
DNGA150408S01225MT KBH10	B314
DNGA150408S01225MT KBH20	B314
DNGA150408S01735MT KBH10	B314
DNGA150408S01735MT KBH20	B314
DNGA150408T01020 KYS30	B333
DNGA150408T02020 KY1615	B313
DNGA150408T02020 KY3500	B293
DNGA150412S01015FWMT KBH20	B313
DNGA150412S01015MT KBH10	B314
DNGA150412S01015MT KBH20	B314
DNGA150412S01225FWMT KBH10	B313
DNGA150412S01225MT KBH10	B314
DNGA150412S01225MT KBH20	B314
DNGA150412S01735MT KBH10	B314
DNGA150412S01735MT KBH20	B314
DNGA150412T01020 KYS30	B333
DNGA150412T02020 KY1615	B313
DNGA150412T02020 KY3500	B293
DNGA150416T02020 KY1615	B313
DNGA150416T02020 KY3500	B293
DNGA150416T02020 KYK10	B293
DNGA150416T02020 KYK25	B293
DNGA150604S01015MT KBH10	B314
DNGA150604S01015MT KBH20	B314
DNGA150604S01225MT KBH20	B314
DNGA150604S01735MT KBH20	B314
DNGA150604T02020 KY1615	B313
DNGA150608S01015MT KBH10	B314
DNGA150608S01015MT KBH20	B314
DNGA150608S01225MT KBH10	B314
DNGA150608S01225MT KBH20	B314
DNGA150608S01735MT KBH20	B314
DNGA150608T02020 KY1615	B313
DNGA150608T02020 KY3500	B293
DNGA150612S01015MT KBH10	B314
DNGA150612S01015MT KBH20	B314
DNGA150612S01225MT KBH10	B314
DNGA150612S01225MT KBH20	B314
DNGA150612S01735MT KBH20	B314
DNGA150612T02020 KY1615	B313
DNGA150612T02020 KY3500	B293
DNGG110402FS KC5010	B74
DNGG110402FS KCU10	B74
DNGG110404FS KCU10	B74
DNGG110408FS KCU10	B74
DNGG150401FS KCU10	B74
DNGG150402FS KC5010	B74
DNGG150402FS KCU10	B74
DNGG150402LF KC5010	B74
DNGG150402LF KCU10	B74
DNGG150404FS KC5010	B74
DNGG150404FS KC5025	B74
DNGG150404FS KCU10	B74
DNGG150404LF KC5010	B74
DNGG150404LF KCU10	B74
DNGG150408FS KC5010	B74
DNGG150408FS KCU10	B74
DNGG150408FS KCU25	B74
DNGG150408LF KC5010	B74
DNGG150408LF KCU10	B74
DNGG150412FS KC5010	B74
DNGG150604FS KCU10	B74
DNGG150608FS KCU10	B74
DNGM150408S01325MTCB1 KBH20	B314
DNGM150412S01325MTCB1 KBH20	B314
DNGM150608S01325MTCB1 KBH20	B314
DNGM150612S01325MTCB1 KBH20	B314
DNGN120408S02020 KBK45	B284
DNGN120412S02020 KBK45	B284
DNGN150704T02020 KY1615	B313
DNGN150708T02020 KY1615	B313
DNGN150712T02020 KY1615	B313
DNGN150716T02020 KY1615	B313
DNGP150401 KC5010	B74
DNGP150402 KC5010	B74
DNGP150402 KC5410	B74
DNGP150402 KCU10	B74
DNGP150404 K313	B74
DNGP150404 KC5010	B74
DNGP150404 KC5410	B74
DNGP150404 KCU10	B74
DNGP150408 K313	B74
DNGP150408 KC5010	B74
DNGP150408 KC5410	B74
DNGP150408 KCU10	B74
DNGP150604 K313	B74
DNGP150604 KC5410	B74
DNGP150604 KCU10	B74
DNGP150608 KC5010	B74
DNGP150608 KCU10	B74
DNGX120708T02020 KY3500	B296
DNGX120712T02020 KY3500	B296
DNGX120712T02020 KYK25	B296
DNGX120716T02020 KY3500	B296
DNGX150708T01020 KYS25	B333
DNGX150708T02020 KY1615	B315
DNGX150708T02020 KY3500	B296
DNGX150712T01020 KYS25	B333
DNGX150712T01020 KYS30	B333
DNGX150712T02020 KY3500	B296
DNGX150712T02020 KYK25	B296
DNGX150716T01020 KYS30	B333
DNGX150716T02020 KY3500	B296
DNMA110408 KCK05	B75
DNMA110408 KCK20B	B75
DNMA110408S02020 KB1340	B289
DNMA110412S02020 KB1340	B289
DNMA150408 KCK05	B75
DNMA150408 KCK15	B75
DNMA150408 KCK20	B75
DNMA150408 KCK20B	B75
DNMA150412 KCK05	B75
DNMA150412 KCK15	B75
DNMA150412 KCK20	B75
DNMA150416 KCK20B	B75
DNMA150608 KCK05	B75
DNMA150608 KCK15	B75
DNMA150608 KCK20	B75
DNMA150612 KCK20	B75
DNMA150612 KCK20B	B75
DNMG11040433 KT315	B75
DNMG110404FF KC5010	B76
DNMG110404FF KCP05	B76
DNMG110404FF KCP10	B76
DNMG110404FF KCU10	B76
DNMG110404FF KT315	B76
DNMG110404FN KCK05	B77
DNMG110404FN KCP05	B77
DNMG110404FN KCP10	B77
DNMG110404FN KCP10B	B77
DNMG110404FN KCP25B	B77
DNMG110404FN KT315	B77
DNMG110404FP KC5010	B77
DNMG110404FP KCM15	B77
DNMG110404FP KCM15B	B77
DNMG110404FP KCPK05	B77
DNMG110404FP KCU10	B77
DNMG110404FW KCP10	B78
DNMG110404FW KCU10	B78
DNMG110404FW KT315	B78
DNMG110404MN KCP05	B78
DNMG110404MN KCP10B	B78
DNMG110404MN KCP25	B78
DNMG110404MN KCP25B	B78
DNMG110404MN KCP30	B78
DNMG11040833 KT315	B75
DNMG11040CT KCP05	B76
DNMG11040CT KCP10	B76
DNMG11040CT KCP10B	B76
DNMG110408FF KCP05	B76
DNMG110408FF KCP05B	B76
DNMG110408FF KCP10	B76
DNMG110408FF KCP10B	B76
DNMG110408FF KCU10	B76
DNMG110408FF KT315	B76
DNMG110408FN KCK05	B77
DNMG110408FN KCP05	B77
DNMG110408FN KCP10	B77
DNMG110408FN KCP10B	B77
DNMG110408FN KCP25B	B77
DNMG110408FN KT315	B77
DNMG110408FP KC5010	B77
DNMG110408FP KCM15	B77
DNMG110408FP KCP05	B77
DNMG110408FP KCP10	B77
DNMG110408FP KCPK05	B77
DNMG110408FP KCU10	B77
DNMG110408FP KT315	B77
DNMG110408FW KCM15B	B78
DNMG110408FW KCP05	B78
DNMG110408FW KCP10	B78
DNMG110408FW KCP10B	B78
DNMG110408FW KT315	B78
DNMG110408MN KCP05	B78
DNMG110408MN KCP10	B78
DNMG110408MN KCP10B	B78
DNMG110408MN KCP25	B78
DNMG110408MN KCP25B	B78
DNMG110408MN KCP30	B78
DNMG110408MP KC5010	B79
DNMG110408MP KCM15	B79
DNMG110408MP KCM25	B79
DNMG110408MP KCM25B	B79
DNMG110408MP KCU10	B79
DNMG110408MR KCP10B	B80
DNMG110408MR KCP25B	B80
DNMG110408MS KC5010	B79
DNMG110408MS KC5025	B79
DNMG110408MS KCU10	B79
DNMG110408MS KCU25	B79
DNMG110408RP KC5010	B81
DNMG110408RP KCK20B	B81
DNMG110408RP KCM15	B81
DNMG110408RP KCP10	B81
DNMG110408RP KCP25B	B81
DNMG110408RP KCU10	B81
DNMG110408RP KCU25	B81
DNMG110408UN KCK15	B82
DNMG110408UN KCK15B	B82
DNMG110408UN KCK20	B82
DNMG110408UP KCM25	B82
DNMG110412CT KCP10B	B76
DNMG110412FN KCP05	B77
DNMG110412FN KCP10B	B77
DNMG110412MN KCP10	B78
DNMG110412MN KCP25	B78
DNMG110412MN KCP25B	B78
DNMG110412MP KCM15	B79
DNMG110412MP KCM25B	B79
DNMG110412RP KCP25B	B81
DNMG110412UN KCK15	B82
DNMG110412UN KCK15B	B82
DNMG110412UN KCK20	B82
DNMG150401MS KCU10	B79
DNMG150402MS KC5010	B79
DNMG150402MS KCU10	B79
DNMG150402MS KCU25	B79
DNMG150404CT KC5010	B76
DNMG150404CT KCP10	B76
DNMG150404CT KCP25	B76
DNMG150404CT KCP25B	B76
DNMG150404CT KCU10	B76
DNMG150404FF KC5010	B76
DNMG150404FF KCM15B	B76
DNMG150404FF KCP10	B76
DNMG150404FF KCU10	B76
DNMG150404FF KT315	B76
DNMG150404FN KCK05	B77
DNMG150404FN KCK15B	B77
DNMG150404FN KCP05	B77
DNMG150404FN KCP10	B77
DNMG150404FN KCP10B	B77
DNMG150404FN KCP25	B77
DNMG150404FN KCP25B	B77
DNMG150404FN KT315	B77
DNMG150404FP KC5010	B77
DNMG150404FP KCM15	B77
DNMG150404FP KCU10	B77
DNMG150404FP KT315	B77
DNMG150404FW KC5010	B78
DNMG150404FW KCP10	B78
DNMG150404FW KCU10	B78
DNMG150404FW KT315	B78
DNMG150404MN KCP10	B78
DNMG150404MN KCP10B	B78
DNMG150404MN KCP25	B78
DNMG150404MN KCP25B	B78
DNMG150404MN KCP30	B78
DNMG150404MP KC5010	B79
DNMG150404MP KCM15B	B79
DNMG150404MP KCM25	B79
DNMG150404MP KCM25B	B79
DNMG150404MP KCM35	B79
DNMG150404MP KCU10	B79
DNMG150404MS K313	B79
DNMG150404MS KC5010	B79
DNMG150404MS KC5025	B79
DNMG150404MS KCU10	B79
DNMG150404MS KCU25	B79
DNMG150404P KC5010	B81
DNMG150404P KCU10	B81
DNMG150404UP KCM15	B82
DNMG150404UP KCM25	B82
DNMG150404UP KCU10	B82
DNMG150408B K68	B75
DNMG150408CT KC5010	B76
DNMG150408CT KCP10	B76
DNMG150408CT KCP10B	B76
DNMG150408CT KCP25	B76
DNMG150408FF KC5010	B76
DNMG150408FF KCP05	B76
DNMG150408FF KCP10	B76
DNMG150408FF KCP10B	B76
DNMG150408FF KCU10	B76
DNMG150408FF KT315	B76
DNMG150408FN KCK05	B77
DNMG150408FN KCP05	B77
DNMG150408FN KCP10	B77
DNMG150408FN KCP10B	B77
DNMG150408FN KCP25	B77
DNMG150408FN KCP25B	B77
DNMG150408FN KCPK05	B77
DNMG150408FN KT315	B77
DNMG150408FP KC5010	B77
DNMG150408FP KCM15	B77
DNMG150408FP KCP10	B77
DNMG150408FP KCP25	B77
DNMG150408FP KCU10	B77

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
DNMG150408FP KT315	B77
DNMG150408FW KCK15B	B78
DNMG150408FW KCP05	B78
DNMG150408FW KCP10B	B78
DNMG150408FW KCU10	B78
DNMG150408FW KT315	B78
DNMG150408MN KCP05B	B78
DNMG150408MN KCP10	B78
DNMG150408MN KCP10B	B78
DNMG150408MN KCP25	B78
DNMG150408MN KCP25B	B78
DNMG150408MN KCP30	B78
DNMG150408MN KCP30B	B78
DNMG150408MN KCP40	B78
DNMG150408MN KCPK05	B78
DNMG150408MP KC5010	B79
DNMG150408MP KCM15B	B79
DNMG150408MP KCM25	B79
DNMG150408MP KCM25B	B79
DNMG150408MP KCM35	B79
DNMG150408MP KCP10	B79
DNMG150408MP KCP25	B79
DNMG150408MP KCU10	B79
DNMG150408MR KCM15	B80
DNMG150408MR KCM25B	B80
DNMG150408MR KCP10B	B80
DNMG150408MR KCP25B	B80
DNMG150408MR KCP30B	B80
DNMG150408MR KCPK05	B80
DNMG150408MR KCU10	B80
DNMG150408MS K313	B79
DNMG150408MS KC5010	B79
DNMG150408MS KC5025	B79
DNMG150408MS KCU10	B79
DNMG150408MS KCU25	B79
DNMG150408MW KCP05	B80
DNMG150408MW KCP10B	B80
DNMG150408MW KCP25	B80
DNMG150408P KC5010	B81
DNMG150408P KCU10	B81
DNMG150408RN KCP10	B81
DNMG150408RN KCP10B	B81
DNMG150408RN KCP25	B81
DNMG150408RN KCP25B	B81
DNMG150408RN KCP30B	B81
DNMG150408RN KCP40	B81
DNMG150408RP KC5010	B81
DNMG150408RP KC5025	B81
DNMG150408RP KCK05	B81
DNMG150408RP KCK20	B81
DNMG150408RP KCK20B	B81
DNMG150408RP KCM15	B81
DNMG150408RP KCM25	B81
DNMG150408RP KCM25B	B81
DNMG150408RP KCM35	B81
DNMG150408RP KCP10	B81
DNMG150408RP KCP10B	B81
DNMG150408RP KCP25	B81
DNMG150408RP KCP25B	B81
DNMG150408RP KCU10	B81
DNMG150408RP KCU25	B81
DNMG150408UN KCK05	B82
DNMG150408UN KCK15	B82
DNMG150408UN KCK15B	B82
DNMG150408UN KCK20	B82
DNMG150408UN KCK20B	B82
DNMG150408UP KC5010	B82
DNMG150408UP KCM15	B82
DNMG150408UP KCM25	B82
DNMG150408UP KCM25B	B82
DNMG150408UP KCM35	B82
DNMG150408UP KCU10	B82
DNMG150412CT KCP10B	B76
DNMG150412CT KCU10	B76
DNMG150412FN KCK05	B77
DNMG150412FN KCP05	B77
DNMG150412FN KCP10B	B77
DNMG150412FN KT315	B77
DNMG150412FP KCU10	B77
DNMG150412MN KCP05	B78
DNMG150412MN KCP10B	B78
DNMG150412MN KCP25	B78
DNMG150412MN KCP25B	B78
DNMG150412MN KCP30B	B78
DNMG150412MN KCP40B	B78
DNMG150412MP KC5010	B79
DNMG150412MP KCM25	B79
DNMG150412MP KCU10	B79
DNMG150412MR KCP10B	B80
DNMG150412MR KCPK05	B80
DNMG150412MS KC5010	B79
DNMG150412MS KCU10	B79
DNMG150412MS KCU25	B79
DNMG150412MW KCP05	B80
DNMG150412RN KCP10B	B81
DNMG150412RN KCP25	B81
DNMG150412RN KCP25B	B81
DNMG150412RN KCPK05	B81
DNMG150412RP KCM35	B81
DNMG150412RP KCP10B	B81
DNMG150412RP KCP25	B81
DNMG150412RP KCP25B	B81
DNMG150412RP KCP30	B81
DNMG150412RP KCU10	B81
DNMG150412RP KCU25	B81
DNMG150412UN KCK20B	B82
DNMG150416RN KCP25	B81
DNMG150416RN KCP40B	B81
DNMG150416RP KC5010	B81
DNMG150416RP KCU10	B81
DNMG150416UN KCK20	B82
DNMG150416UN KCK20B	B82
DNMG15060433 KT315	B75
DNMG150604CT KCP10	B76
DNMG150604FF KC5010	B76
DNMG150604FF KCP10B	B76
DNMG150604FF KT315	B76
DNMG150604FN KCK05	B77
DNMG150604FN KCK15B	B77
DNMG150604FN KCP05	B77
DNMG150604FN KCP10	B77
DNMG150604FN KCP10B	B77
DNMG150604FN KCP25	B77
DNMG150604FN KCP25B	B77
DNMG150604FN KT315	B77
DNMG150604FP KC5010	B77
DNMG150604FP KCM15	B77
DNMG150604FP KCU10	B77
DNMG150604FW KCP05	B78
DNMG150604FW KCP10B	B78
DNMG150604FW KCU10	B78
DNMG150604MN KCP10	B78
DNMG150604MN KCP10B	B78
DNMG150604MN KCP25	B78
DNMG150604MN KCP25B	B78
DNMG150604MN KCP30	B78
DNMG150604MP KC5010	B79
DNMG150604MP KCM15B	B79
DNMG150604MP KCM25	B79
DNMG150604MP KCM25B	B79
DNMG150604MP KCM35	B79
DNMG150604MP KCU10	B79
DNMG150604MS K313	B79
DNMG150604MS KC5010	B79
DNMG150604MS KC5025	B79
DNMG150604MS KCU10	B79
DNMG150604MS KCU25	B79
DNMG150604UP KCM25	B82
DNMG15060833 KT315	B75
DNMG150608CT KCP10	B76
DNMG150608CT KCP10B	B76
DNMG150608CT KCP25	B76
DNMG150608FF KC5010	B76
DNMG150608FF KCP10	B76
DNMG150608FF KCP10B	B76
DNMG150608FF KT315	B76
DNMG150608FN KCK05	B77
DNMG150608FN KCK15B	B77
DNMG150608FN KCP05	B77
DNMG150608FN KCP10	B77
DNMG150608FN KCP10B	B77
DNMG150608FN KCP25	B77
DNMG150608FN KCP25B	B77
DNMG150608FN KT315	B77
DNMG150608FP KC5010	B77
DNMG150608FP KCM15	B77
DNMG150608FP KCP10	B77
DNMG150608FP KCP10B	B77
DNMG150608FP KCP25	B77
DNMG150608FP KCP25B	B77
DNMG150608FP KCU10	B77
DNMG150608FW KCK15B	B78
DNMG150608FW KCP05	B78
DNMG150608FW KCP10	B78
DNMG150608FW KCP10B	B78
DNMG150608FW KCU10	B78
DNMG150608MN KCP05B	B78
DNMG150608MN KCP10	B78
DNMG150608MN KCP10B	B78
DNMG150608MN KCP25	B78
DNMG150608MN KCP25B	B78
DNMG150608MN KCP40	B78
DNMG150608MP KC5010	B79
DNMG150608MP KCM15	B79
DNMG150608MP KCM15B	B79
DNMG150608MP KCM25	B79
DNMG150608MP KCM25B	B79
DNMG150608MP KCM35	B79
DNMG150608MP KCP10	B79
DNMG150608MP KCP25	B79
DNMG150608MP KCU10	B79
DNMG150608MP KCU25	B79
DNMG150608MR KCK15B	B80
DNMG150608MR KCM15B	B80
DNMG150608MR KCM25	B80
DNMG150608MR KCM25B	B80
DNMG150608MR KCP10B	B80
DNMG150608MR KCP25B	B80
DNMG150608MR KCU10	B80
DNMG150608MS K313	B79
DNMG150608MS KC5010	B79
DNMG150608MS KC5025	B79
DNMG150608MS KCU10	B79
DNMG150608MS KCU25	B79
DNMG150608MW KCP05	B80
DNMG150608MW KCP10	B80
DNMG150608MW KCP10B	B80
DNMG150608MW KCP25	B80
DNMG150608MW KCPK05	B80
DNMG150608P KC5010	B81
DNMG150608RN KCP05	B81
DNMG150608RN KCP10	B81
DNMG150608RN KCP10B	B81
DNMG150608RN KCP25	B81
DNMG150608RN KCP25B	B81
DNMG150608RN KCP30	B81
DNMG150608RN KCP40B	B81
DNMG150608RP KC5010	B81
DNMG150608RP KC5025	B81
DNMG150608RP KCK15B	B81
DNMG150608RP KCK20	B81
DNMG150608RP KCM15	B81
DNMG150608RP KCM25	B81
DNMG150608RP KCM25B	B81
DNMG150608RP KCP05	B81
DNMG150608RP KCP10	B81
DNMG150608RP KCP10B	B81
DNMG150608RP KCP25	B81
DNMG150608RP KCP25B	B81
DNMG150608RP KCP30	B81
DNMG150608RP KCU10	B81
DNMG150608RP KCU25	B81
DNMG150608UN KCK15	B82
DNMG150608UN KCK15B	B82
DNMG150608UN KCK20	B82
DNMG150608UN KCK20B	B82
DNMG150608UP KC5010	B82
DNMG150608UP KCM15	B82
DNMG150608UP KCM25B	B82
DNMG150608UP KCU10	B82
DNMG150612CT KC5010	B76
DNMG150612CT KCP05	B76
DNMG150612CT KCP05B	B76
DNMG150612CT KCP10	B76
DNMG150612CT KCP10B	B76
DNMG150612CT KCP25	B76
DNMG150612CT KCP25B	B76
DNMG150612FN KCK05	B77
DNMG150612FN KCP05	B77
DNMG150612FN KCP10	B77
DNMG150612FN KCP10B	B77
DNMG150612FN KCP25	B77
DNMG150612FN KT315	B77
DNMG150612FP KCM15B	B77
DNMG150612FP KT315	B77
DNMG150612MG KCP10B	B80
DNMG150612MN KCP10	B78
DNMG150612MN KCP10B	B78
DNMG150612MN KCP25	B78
DNMG150612MN KCP25B	B78
DNMG150612MN KCP40B	B78
DNMG150612MP KC5010	B79
DNMG150612MP KCM15	B79
DNMG150612MP KCM25B	B79
DNMG150612MP KCP10	B79
DNMG150612MP KCU10	B79
DNMG150612MP KCU25	B79
DNMG150612MR KCP10B	B80
DNMG150612MR KCP25B	B80
DNMG150612MS KC5025	B79
DNMG150612MS KCU10	B79
DNMG150612MS KCU25	B79
DNMG150612MW KCP05	B80
DNMG150612MW KCP10B	B80
DNMG150612MW KCP25	B80
DNMG150612RN KCP05	B81
DNMG150612RN KCP10	B81
DNMG150612RN KCP10B	B81
DNMG150612RN KCP25	B81
DNMG150612RN KCP25B	B81
DNMG150612RN KCP30	B81
DNMG150612RN KCP40B	B81
DNMG150612RN KCPK05	B81
DNMG150612RP KCK05	B81
DNMG150612RP KCK15	B81
DNMG150612RP KCK20	B81
DNMG150612RP KCK20B	B81
DNMG150612RP KCM25	B81
DNMG150612RP KCM35B	B81
DNMG150612RP KCP10	B81
DNMG150612RP KCP10B	B81
DNMG150612RP KCP25	B81
DNMG150612RP KCP25B	B81
DNMG150612RP KCU10	B81
DNMG150612RP KCU25	B81
DNMG150612UN KCK15	B82
DNMG150612UN KCK15B	B82
DNMG150612UN KCK20	B82
DNMG150612UN KCK20B	B82
DNMG150616MG KCP10B	B80
DNMG150616MN KCP10	B78
DNMG150616MR KCP25B	B80
DNMG150616RN KCP10	B81
DNMG150616RN KCP25	B81
DNMG150616RN KCP25B	B81
DNMG150616RN KCP40B	B81
DNMG150616RP KCP10	B81
DNMG150616RP KCP10B	B81
DNMG150616RP KCP25	B81
DNMG150616RP KCP25B	B81
DNMG150616RP KCU25	B81
DNMG150616UN KCK15B	B82
DNMG150616UN KCK20	B82
DNMG190608RN KCP10B	B81
DNMG190608RN KCP25	B81
DNMG190608RN KCP30	B81
DNMG190612MN KCP30	B78
DNMG190612RN KCP10B	B81
DNMG190612RN KCP25	B81
DNMG190612RN KCP30	B81
DNMM150408RM KCP25	B82
DNMM150412RM KCP25B	B82
DNMM150608RM KCP10	B82
DNMM150608RM KCP25B	B82
DNMM150608RM KCP30	B82
DNMM150608RP KCP10	B83
DNMM150608RP KCP25	B83
DNMM150612RM KCP10	B82

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
DNMM150612RM KCP25	B82
DNMM150612RM KCP25B	B82
DNMM150612RM KCP40	B82
DNMM150612RP KCP10B	B83
DNMM150612RP KCP25	B83
DNMM150612RP KCP25B	B83
DNMM150616RM KCP25	B82
DNMM150616RP KCP10B	B83
DNMM150616RP KCP25	B83
DNMP110408K KCP25B	B83
DNMP150404 K68	B83
DNMP150404K KCP25	B83
DNMP150404K KCP25B	B83
DNMP150408 K68	B83
DNMP150408K KCP10B	B83
DNMP150408K KCP25	B83
DNMP150408K KCP25B	B83
DNMP150412 K68	B83
DNMP150412K KCP10B	B83
DNMP150412K KCP25	B83
DNMP150604K KCP25B	B83
DNMP150608K KCP10B	B83
DNMP150608K KCP25B	B83
DNMS150404FST KD1400	B347
DNMS150408 K68	B84
DNMS150408 KC5410	B84
DNMS150408FST KD1400	B347
DNMS150408FST KD1425	B347
DP5009A S	T86–89
DP5013T S	V27–28
DPA07T3D25 KCU40	H90
DPA09T4D32 KCU40	H90
DPA13T5D50 KCU40	H90
DPGT070201LF KC5010	B214
DPGT070202HP KC5010	B214
DPGT070202LF KC5010	B214
DPGT070202LF KCU10	B214
DPGT070204HP KC5010	B214
DPGT070204HP KC5410	B214
DPGT070204HP KCU10	B214
DPGT070204HP KCU25	B214
DPGT070204LF KC5010	B214
DPGT070204LF KC5025	B214
DPGT070204LF KCU10	B214
DPGT070208HP KCU25	B214
DPGT11T301LF KC5010	B214
DPGT11T302LF KC5010	B214
DPGT11T302LF KC5025	B214
DPGT11T302LF KCU10	B214
DPGT11T304HP K313	B214
DPGT11T304HP KC5010	B214
DPGT11T304HP KC5410	B214
DPGT11T304HP KCU10	B214
DPGT11T304HP KCU25	B214
DPGT11T304LF KC5010	B214
DPGT11T304LF KC5025	B214
DPGT11T304LF KCU10	B214
DPGT11T308HP KC5010	B214
DPGT11T308HP KCU10	B214
DPGT11T308HP KCU25	B214
DPGT11T308LF KC5010	B214
DPGT11T308LF KCU10	B214
DPGW070202FST KD1400	B348
DPGW070202FST KD1425	B348
DPGW070204FST KD1400	B348
DPGW070204FST KD1425	B348
DPGW11T304E KD1405	B347
DPGW11T304FST KD1400	B348
DPGW11T304FST KD1425	B348
DPGW11T304FWST KD1425	B348
DPMT070202FP KCU10	B214
DPMT070202LF KC5010	B215
DPMT070202LF KC5025	B215
DPMT070204FP KCM15	B214
DPMT070204FP KCP10	B214
DPMT070204FP KCP25	B214
DPMT070204FP KCU10	B214
DPMT070204FP KCU25	B214
DPMT070204FP KTP10	B214
DPMT070204FW KCP25	B215
DPMT070204LF KC5010	B215
DPMT070204LF KC5025	B215
DPMT070204LF KCK05	B215
DPMT070204LF KCK20	B215
DPMT070204LF KCM25	B215
DPMT070204LF KCP10	B215
DPMT070204LF KCP10B	B215
DPMT070204LF KCP25	B215
DPMT070204LF KCP25B	B215
DPMT070204LF KT315	B215
DPMT070204UF KC5010	B216
DPMT070204UF KCP25	B216
DPMT070208FP KCU10	B214
DPMT070208FP KCU25	B214
DPMT070208FW KCK20B	B215
DPMT070208FW KCU10	B215
DPMT11T302LF KC5010	B215
DPMT11T304FP KCP10	B214
DPMT11T304FP KCP25	B214
DPMT11T304FP KCU10	B214
DPMT11T304FP KCU25	B214
DPMT11T304LF KC5010	B215
DPMT11T304LF KC5025	B215
DPMT11T304LF KCK05	B215
DPMT11T304LF KCK20	B215
DPMT11T304LF KCM25B	B215
DPMT11T304LF KCP10	B215
DPMT11T304LF KCP10B	B215
DPMT11T304LF KCP25	B215
DPMT11T304LF KCP25B	B215
DPMT11T304LF KT315	B215
DPMT11T304UF KCP10	B216
DPMT11T308FP KCU10	B214
DPMT11T308FP KTP10	B214
DPMT11T308LF KC5010	B215
DPMT11T308LF KC5025	B215
DPMT11T308LF KCK20	B215
DPMT11T308LF KCM25	B215
DPMT11T308LF KCP10	B215
DPMT11T308LF KCP10B	B215
DPMT11T308LF KCP25	B215
DPMT11T308LF KCP25B	B215
DPMT11T308MF KCM25	B215
DPMT11T308MF KCP25	B215
DPMT11T308MP KCP25	B216
DPMT11T308MP KCU10	B216
DPMT11T308UF KCP10	B216
DSBNL2525M12KC04	B105
DSDNN2020K12KC04	B105
DSDNN2525M12KC04	B105
DSDNN2525M15KC06	B105
DSDNN3232P19KC06	B105
DSDNN4040S25KC09	B105
DSKNL2525M12KC04	B106
DSKNR2525M12KC04	B106
DSRNL4040S25KC09	B106
DSRNR2525M12KC04	B106
DSRNR4040S25KC09	B106
DSSNL2525M12KC04	B107
DSSNR2020K12KC04	B107
DSSNR2525M12KC04	B107
DSSNR3225P12KC04	B107
DT10	U3, W40–43
DT15	S60, S62, T79–81, U3, U17–18, V153–154
DT15IP	S41, T14–17, T69–72, T102, U38–39, V70–72, V77–78, V137–139
DT3IP	W34–35
DT7	W40
DT7IP	T30–33, T39–41
DT8	U3, W29–31, W40, W42
DT8IP	W4–5, W10–13, W17–19, W24–25
DT9	V153–154
DT9IP	T4–7, T47–50, T57–59, T97–98, U25–26, V38–40
DTFNL2525M22KC04	B132
DTFNR2020K16KC04	B132
DTGNL2525M22KC04	B132
DTGNR2020K16KC04	B132
DTGNR2525M16KC04	B132
DTGNR2525M22KC04	B132
DTQ3054	S116, S120, S122
DTQ50140	S32–33
DV40BDL10041M	O54
DV40BDL12041M	O54
DV40BDL16050M	O54
DV40BDL20050M	O54
DV40BDL25056M	O54
DV40BDL32065M	O54
DV40BEWD20090M	J47
DV40BEWD32108M	J47
DV40BKR32041M	K86
DV40BKR50060M	K86
DV40BSIF80061M	K45
DV40BT13069	K138
DV40FBHM1691	K129
DV40FBHMKIT164M	K123, K127
DV50BEWD32108M	J47
DV50BKR32040M	K86
DV50BKR32041M	K86
DV50BKR50040M	K86
DV50BKR63060M	K86
DV50BKR80070M	K86
DV50BSIF100060M	K45
DV50BSIF70060M	K45
DV50BT13069	K138
DV50RMEWD32108M	J47
DVJNL2020K16KC04	B149
DVJNL2525M16KC04	B149
DVJNL3225P16KC04	B149
DVJNR2020K16KC04	B149
DVJNR2525M16KC04	B149
DVJNR3225P16KC04	B149
DVONL2020K16KC04	B150
DVONL2525M16KC04	B150
DVONL3225P16KC04	B150
DVONR2020K16KC04	B150
DVONR2525M16KC04	B150
DVONR3225P16KC04	B150
DVWNN2020K16KC04	B150
DVWNN2525M16KC04	B150
DWLNL2020K06KC04	B161
DWLNL2020K08KC04	B161
DWLNL2525M06KC04	B161
DWLNL2525M08KC04	B161
DWLNL3232P08KC04	B161
DWLNR2020K06KC04	B161
DWLNR2020K08KC04	B161
DWLNR2525M06KC04	B161
DWLNR2525M08KC04	B161
DWLNR3232P08KC04	B161
E0412DSCLDRS422	B187
E0412XSCLDRS447	B187
E0416KSCLDRS447	B187
E04HSCLDLS4	B186
E04HSCLDRS4	B186
E04MSCLDLS4	B186
E04MSCLDRS4	B186
E0512XSCFDRS425	B185
E0512XSCFDRS450	B185
E0512XSCLDRS425	B187
E05HSCFDRS4	B185
E05HSCLDLS4	B186
E05HSCLDRS4	B186
E05MSCLDLS4	B186
E05MSCLDRS4	B186
E0612ESCLDRS431	B187
E0612HSCLDRS463	B187
E0616HSCLDRS431	B187
E0616XSCFDRS463	B185
E0616XSCLDRS463	B187
E06HSCFDRS4	B185
E06HSCLDLS4	B186
E06HSCLDRS4	B186
E06MSCLDLS4	B186
E06MSCLDRS4	B186
E06MSTLDL07	B251
E06MSTLDR07	B251
E06MSWUPLS3	B273
E06MSWUPRS3	B273
E0812XSTLDR0738	B252
E08KSCFPL06A	B195
E08KSCFPR06A	B195
E08KSCLPL06A	B197
E08KSCLPR06A	B197
E08KSTFPR09A	B258
E08MSCLDLS4	B186
E08MSCLDRS4	B186
E08MSTLDL07	B251
E08MSTLDR07	B251
E08MSWUPRS3	B273
E10MSCFPR06A	B195
E10MSCLPL06A	B197
E10MSCLPR06A	B197
E10MSTFPL11A	B258
E10MSTFPR11A	B258
E10SSWUPR04	B273
E12QNKLCL11 KWH	E41
E12QNKLCR11 KWH	E41
E12QSCFPR06	B195
E12QSCLPL06	B197
E12QSCLPR06 KWH	B197
E12QSDUPL07	B218
E12QSDUPR07	B218
E12QSTFPL11	B258
E12QSTFPR11	B258
E12SSWUPR04	B273
E16RLSER16 KWH	D82
E16RNKLCR11 KWH	E41
E16RNNTOL2 KWH	C170, D37
E16RNNTOR2 KWH	C170, D37
E16RSCLPL09 KWH	B197
E16RSCLPR09	B197
E16RSDUPL07	B218
E16RSDUPR07	B218
E16RSTFPL11	B258
E16RSTFPR11	B258
E20SLSER16 KWH	D82
E20SNNTOR2 KWH	C170, D37
E20SSCLPL09	B197
E20SSCLPR09	B197
E20SSDUPL11	B218
E20SSDUPR11	B218
E20SSTFPL16	B258
E20SSTFPR16	B258
E25TLSER16 KWH	D82
E2FIX100505LHP KCU10	E10
E2FIX100505RHP KCU10	E10
EADE0380A4AQE KYS40	P176
EADE0400A4AQE KYS40	P176
EADE0400A6ARE KYS40	P177
EADE0570A4AQF KYS40	P176
EADE0600A4AQF KYS40	P176
EADE0600A6ARF KYS40	P177
EADE0760A4AQG KYS40	P176
EADE0800A4AQG KYS40	P176
EADE0800A6ARG KYS40	P177
EADE0950A4AQH KYS40	P176
EADE1000A4AQH KYS40	P176
EADE1000A6ARH KYS40	P177
EADE1140A4AQJ KYS40	P176
EADE1200A4AQJ KYS40	P176
EADE1200A6ARJ KYS40	P177
EB10801281100	K140
EB13030150	K139
EB16301281650	K140
EB18030200	K139
EB23035250	K139
EB28035300	K139
EB33040350	K139
EB38040400	K139
EB43040450	K139
EB48040500	K139
EB53050550	K139
EB58050600	K139
EB630128650	K140
EBM1580160162	K132
EBM8015086	K132
EBSLD1105	K140
EBSLD2205	K140
EBUCW0074	K141
EBUFF0975	K141
EBURF1975PKG	K141
EC014M1BL06CF01 KCM35B	C24
EC014M1BL06CF01 KCU25	C24
EC014M1BL06CL01 KCM35B	C25
EC014M1BL06CL01 KCU25	C25
EC014M1BL06CM01 KCU25	C26

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
EC014M1BN00CF01 KCM35B	C24
EC014M1BN00CF01 KCU25	C24
EC014M1BN00CL01 KCM35B	C25
EC014M1BN00CL01 KCU25	C25
EC014M1BN00CM01 KCU25	C26
EC014M1BR06CF01 KCM35B	C24
EC014M1BR06CF01 KCU25	C24
EC014M1BR06CL01 KCM35B	C25
EC014M1BR06CL01 KCU25	C25
EC014M1BR06CM01 KCU25	C26
EC020M02L06CF02 KCM35B	C24
EC020M02L06CF02 KCU25	C24
EC020M02L06CL02 KCM35B	C25
EC020M02L06CL02 KCU25	C25
EC020M02L06CM02 KCU25	C26
EC020M02L06CR02 KCU25	C27
EC020M02N00CF02 KCM35B	C24
EC020M02N00CF02 KCU25	C24
EC020M02N00CL02 KCM35B	C25
EC020M02N00CL02 KCU25	C25
EC020M02N00CM02 KCU25	C26
EC020M02N00CR02 KCU25	C27
EC020M02R06CF02 KCM35B	C24
EC020M02R06CF02 KCU25	C24
EC020M02R06CL02 KCM35B	C25
EC020M02R06CL02 KCU25	C25
EC020M02R06CM02 KCU25	C26
EC020M02R06CR02 KCU25	C27
EC030M03L06CF02 KCM35B	C24
EC030M03L06CF02 KCU25	C24
EC030M03L06CL02 KCM35B	C25
EC030M03L06CL02 KCU25	C25
EC030M03L06CM02 KCU25	C26
EC030M03L06CR02 KCU25	C27
EC030M03N00CF02 KCM35B	C24
EC030M03N00CF02 KCU25	C24
EC030M03N00CL02 KCM35B	C25
EC030M03N00CL02 KCU25	C25
EC030M03N00CM02 KCU25	C26
EC030M03N00CR02 KCU25	C27
EC030M03R06CF02 KCM35B	C24
EC030M03R06CF02 KCU25	C24
EC030M03R06CL02 KCM35B	C25
EC030M03R06CL02 KCU25	C25
EC030M03R06CM02 KCU25	C26
EC030M03R06CR02 KCU25	C27
EC040M04L06CF02 KCM35B	C24
EC040M04L06CF02 KCU25	C24
EC040M04L06CL02 KCU25	C25
EC040M04L06CM02 KCU25	C26
EC040M04L06CR02 KCU25	C27
EC040M04N00CF02 KCM35B	C24
EC040M04N00CF02 KCU25	C24
EC040M04N00CL02 KCM35B	C25
EC040M04N00CL02 KCU25	C25
EC040M04N00CM02 KCU25	C26
EC040M04N00CR02 KCU25	C27
EC040M04R06CF02 KCM35B	C24
EC040M04R06CF02 KCU25	C24
EC040M04R06CL02 KCU25	C25
EC040M04R06CM02 KCU25	C26
EC040M04R06CR02 KCU25	C27
EC050M05N00CF03 KCM35B	C24
EC050M05N00CF03 KCU25	C24
EC050M05N00CM03 KCU25	C26
EC050M05N00CR03 KCU25	C27
EC060M06L06CR04 KCU25	C27
EC060M06N00CM03 KCU25	C26
EC060M06N00CR03 KCU25	C27
EC060M06R06CR04 KCU25	C27
EC070M06N00CM04 KCU25	C26
EC070M06N00CR04 KCU25	C27
EC080M08L06CR04 KCU25	C27
EC080M08N00CM04 KCU25	C26
EC080M08N00CR04 KCU25	C27
EC080M08R06CR04 KCU25	C27
EDCT10T302PDERLD KC725M	T35, T43
EDCT10T302PDERLD KCPK30	T35, T43
EDCT10T302PDFRLDJ KC410M	T35, T42
EDCT10T304PDERLD KC520M	T35, T43
EDCT10T304PDERLD KC522M	T35, T43
EDCT10T304PDERLD KC725M	T35, T43
EDCT10T304PDERLD KCPK30	T35, T43
EDCT10T304PDERLDJ KC422M	T35, T43
EDCT10T304PDFR-PCD KD1410	T34
EDCT10T304PDFRLDJ KC410M	T35, T42
EDCT10T308PDERLD KC510M	T35, T43
EDCT10T308PDERLD KC520M	T35, T43
EDCT10T308PDERLD KC522M	T35, T43
EDCT10T308PDERLD KC725M	T35, T43
EDCT10T308PDERLD KCK15	T35, T43
EDCT10T308PDERLD KCPK30	T35, T43
EDCT10T308PDERLD KCPM40	T35
EDCT10T308PDERLD KCSM40	T35
EDCT10T308PDERLDJ KC422M	T35, T43
EDCT10T308PDFR-PCD KD1410	T34
EDCT10T308PDFRLDJ KC410M	T35, T42
EDCT10T312PDERLD KC522M	T35, T43
EDCT10T312PDERLD KC725M	T35, T43
EDCT10T312PDERLD KCSM40	T35
EDCT10T312PDFRLDJ KC410M	T35, T42
EDCT10T316PDERLD KC522M	T35, T43
EDCT10T316PDERLD KC725M	T35, T43
EDCT10T316PDERLD KCPK30	T35, T43
EDCT10T316PDERLD KCSM40	T35
EDCT10T316PDERLDJ KC422M	T35, T43
EDCT10T316PDFRLDJ KC410M	T35, T42
EDCT10T320PDERLD KC725M	T35, T43
EDCT10T320PDERLD KCPK30	T35, T43
EDCT10T320PDERLDJ KC422M	T35, T43
EDCT10T320PDFRLDJ KC410M	T35, T42
EDCT10T324PDERLD KC522M	T35, T43
EDCT10T324PDERLD KC725M	T35, T43
EDCT10T324PDERLD KCSM40	T35
EDCT10T324PDERLDJ KC422M	T35, T43
EDCT10T331PDERLD KC725M	T35
EDCT10T331PDERLD KCPK30	T35, T43
EDCT10T331PDERLD KCSM40	T35
EDCT10T331PDFRLDJ KC410M	T35, T42
EDCT140402PDFRLDJ KC410M	T51, T60
EDCT140404PDERGD KC725M	T52, T61
EDCT140404PDERGD KCPM40	T52, T61
EDCT140404PDERLD KC522M	T52, T61
EDCT140404PDERLDJ KC422M	T52, T61
EDCT140404PDFRLDJ KC410M	T51, T60
EDCT140408PDERGD KC725M	T52, T61
EDCT140408PDERGD KCPM40	T52, T61
EDCT140408PDERGD KCSM40	T52, T61
EDCT140408PDERLD KC522M	T52, T61
EDCT140408PDERLDJ KC422M	T52, T61
EDCT140408PDFRLDJ KC410M	T51, T60
EDCT140412PDERGD KC725M	T52, T61
EDCT140412PDERGD KCSM40	T52, T61
EDCT140412PDERLD KC522M	T52, T61
EDCT140412PDFRLDJ KC410M	T51, T60
EDCT140416PDERGD KC725M	T52, T61
EDCT140416PDERGD KCSM40	T52, T61
EDCT140416PDERLD KC522M	T52, T61
EDCT140416PDFRLDJ KC410M	T51, T60
EDCT140424PDERLDJ KC422M	T52, T61
EDCT140431PDERGD KC725M	T52, T61
EDCT140431PDERGD KCSM40	T52, T61
EDCT140431PDERLD KC522M	T52, T61
EDCT140431PDFRLDJ KC410M	T51, T60
EDCT140440PDFRLDJ KC410M	T51, T60
EDCT180504PDERGD KC725M	T74
EDCT180504PDERGD KCPM40	T74
EDCT180504PDFRLDJ KC410M	T73
EDCT180508PDERGD KC725M	T74
EDCT180508PDERGD KCPM40	T74
EDCT180508PDERLD KC522M	T74
EDCT180508PDERLDJ KC422M	T73
EDCT180508PDFLLDJ KC410M	T73
EDCT180508PDFRLDJ KC410M	T73
EDCT180512PDERGD KC725M	T74
EDCT180512PDERGD KCPM40	T74
EDCT180512PDERLDJ KC422M	T73
EDCT180512PDFRLDJ KC410M	T73
EDCT180516PDERLD KC522M	T74
EDCT180516PDERLDJ KC422M	T73
EDCT180516PDFRLDJ KC410M	T73
EDCT180520PDFRLDJ KC410M	T73
EDCT180524PDERLDJ KC422M	T73
EDCT180524PDFRLDJ KC410M	T73
EDCT180532PDERLD KC522M	T74
EDCT180532PDERLDJ KC422M	T73
EDCT180532PDFRLDJ KC410M	T73
EDCT180540PDERLD KC522M	T74
EDCT180540PDFRLDJ KC410M	T73
EDCT180548PDERLD KC522M	T74
EDCT180548PDFRLDJ KC410M	T73
EDCT180550PDFRLDJ KC410M	T73
EDCT180564PDERLD KC522M	T74
EDCT180564PDERLDJ KC422M	T73
EDCT180564PDFRLDJ KC410M	T73
EDPT070308PDSRGE KC522M	T25
EDPT070308PDSRGE KC725M	T25
EDPT070308PDSRGE KCPK30	T25
EDPT070308PDSRGE KCPM40	T25
EDPT070308PDSRGE KCSM30	T25
EDPT10T304PDERHD KC520M	T36, T43
EDPT10T304PDERHD KC522M	T36, T43
EDPT10T304PDERHD KC725M	T36, T43
EDPT10T304PDERHD KCK15	T36, T43
EDPT10T304PDERHD KCPK30	T36, T43
EDPT10T304PDERHD KCPM40	T36
EDPT10T304PDSRGD KC725M	T36, T44
EDPT10T304PDSRGD KCK15	T36, T44
EDPT10T304PDSRGD KCPK30	T36, T44
EDPT10T304PDSRGE KC522M	T36, T44
EDPT10T304PDSRGE KC725M	T36, T44
EDPT10T304PDSRGE KCPK30	T36, T44
EDPT10T304PDSRGE KCPM40	T36
EDPT10T308PDERHD KC520M	T36, T43
EDPT10T308PDERHD KC522M	T36, T43
EDPT10T308PDERHD KC725M	T36, T43
EDPT10T308PDERHD KCK15	T36, T43
EDPT10T308PDERHD KCPK30	T36, T43
EDPT10T308PDERHD KCPM40	T36
EDPT10T308PDERHD KCSM40	T36
EDPT10T308PDSRGD KC520M	T36, T44
EDPT10T308PDSRGD KC725M	T36, T44
EDPT10T308PDSRGD KCK15	T36, T44
EDPT10T308PDSRGD KCPK30	T36, T44
EDPT10T308PDSRGD KCPM40	T36, T44
EDPT10T308PDSRGE KC522M	T36, T44
EDPT10T308PDSRGE KC725M	T36, T44
EDPT10T308PDSRGE KCPK30	T36, T44
EDPT10T308PDSRGE KCPM40	T36
EDPT10T308PDSRGE KCSM40	T36
EDPT10T310PDERHD KC522M	T36, T43
EDPT10T310PDERHD KC725M	T36, T43
EDPT10T310PDERHD KCK15	T36, T43
EDPT10T310PDERHD KCPK30	T36, T43
EDPT10T312PDERHD KC520M	T36, T43
EDPT10T312PDERHD KC522M	T36, T43
EDPT10T312PDERHD KC725M	T36, T43
EDPT10T312PDERHD KCPK30	T36, T43
EDPT10T312PDERHD KCPM40	T36
EDPT10T312PDERHD KCSM40	T36
EDPT10T312PDSRGD KC520M	T36, T44
EDPT10T312PDSRGD KC725M	T36, T44
EDPT10T312PDSRGD KCK15	T36, T44
EDPT10T312PDSRGD KCPK30	T36, T44
EDPT10T312PDSRGE KC522M	T36, T44
EDPT10T312PDSRGE KC725M	T36, T44
EDPT10T312PDSRGE KCPK30	T36, T44
EDPT10T312PDSRGE KCSM40	T36
EDPT10T316PDERHD KC522M	T36, T43
EDPT10T316PDERHD KC725M	T36, T43
EDPT10T316PDERHD KCPK30	T36, T43
EDPT10T316PDERHD KCPM40	T36
EDPT10T316PDERHD KCSM30	T36
EDPT10T316PDERHD KCSM40	T36
EDPT10T316PDSRGD KC725M	T36, T44
EDPT10T316PDSRGD KCPK30	T36, T44
EDPT10T316PDSRGD KCPM40	T36
EDPT10T316PDSRGD KCSM40	T36
EDPT10T316PDSRGE KC522M	T36, T44
EDPT10T316PDSRGE KC725M	T36, T44
EDPT10T316PDSRGE KCPK30	T36, T44
EDPT10T316PDSRGE KCSM40	T36
EDPT10T320PDERHD KC725M	T36, T43
EDPT10T320PDERHD KCPK30	T36, T43
EDPT10T320PDERHD KCPM40	T36
EDPT10T320PDERHD KCSM40	T36
EDPT10T324PDERHD KC725M	T36, T43
EDPT10T324PDERHD KCPK30	T36, T43
EDPT10T324PDERHD KCSM40	T36
EDPT10T331PDERHD KC522M	T36, T43
EDPT10T331PDERHD KC725M	T36, T43
EDPT10T331PDERHD KCPK30	T36, T43
EDPT10T331PDERHD KCSM40	T36
EDPT10T331PDSRGE KC522M	T36, T44
EDPT10T331PDSRGE KC725M	T36, T44
EDPT10T331PDSRGE KCPK30	T36, T44
EDPT10T331PDSRGE KCSM40	T36
EDPT140404PDERHD KC520M	T53, T62
EDPT140404PDERHD KC522M	T53, T62
EDPT140404PDERHD KC725M	T53, T62
EDPT140404PDERHD KCK15	T53, T62
EDPT140404PDERHD KCPK30	T53, T62
EDPT140404PDERHD KCPM40	T53, T62
EDPT140404PDSRGE KC522M	T53, T62
EDPT140404PDSRGE KC725M	T53, T62
EDPT140404PDSRGE KCPK30	T53, T62
EDPT140408PDERHD KC520M	T53, T62
EDPT140408PDERHD KC522M	T53, T62
EDPT140408PDERHD KC725M	T53, T62
EDPT140408PDERHD KCK15	T53, T62
EDPT140408PDERHD KCPK30	T53, T62
EDPT140408PDERHD KCPM40	T53, T62
EDPT140408PDERHD KCSM40	T53, T62
EDPT140408PDERHD2 KC522M	T53, T62
EDPT140408PDERHD2 KC725M	T53, T62
EDPT140408PDERHD2 KCK15	T53, T62
EDPT140408PDERHD2 KCPK30	T53, T62
EDPT140408PDERHD2 KCPM40	T53, T62
EDPT140408PDSRGD KC520M	T54, T63
EDPT140408PDSRGD KC725M	T54, T63
EDPT140408PDSRGD KCPK30	T54, T63
EDPT140408PDSRGD KCPM40	T54, T63
EDPT140408PDSRGD KCSM40	T54, T63
EDPT140408PDSRGD2 KC520M	T54, T63
EDPT140408PDSRGD2 KC725M	T54, T63
EDPT140408PDSRGD2 KCPK30	T54, T63
EDPT140408PDSRGD2 KCPM40	T54, T63
EDPT140408PDSRGE KC522M	T53, T62
EDPT140408PDSRGE KC725M	T53, T62
EDPT140408PDSRGE KCPK30	T53, T62
EDPT140408PDSRGE KCPM40	T53, T62
EDPT140408PDSRGE KCSM40	T53, T62
EDPT140412PDERHD KC520M	T53, T62
EDPT140412PDERHD KC522M	T53, T62
EDPT140412PDERHD KC725M	T53, T62
EDPT140412PDERHD KCK15	T53, T62
EDPT140412PDERHD KCPK30	T53, T62
EDPT140412PDERHD KCPM40	T53, T62
EDPT140412PDERHD KCSM40	T53, T62
EDPT140412PDSRGD KC520M	T54, T63
EDPT140412PDSRGD KC725M	T54, T63
EDPT140412PDSRGD KCPK30	T54, T63
EDPT140412PDSRGD KCPM40	T54, T63
EDPT140412PDSRGD KCSM40	T54, T63
EDPT140412PDSRGE KC522M	T53, T62
EDPT140412PDSRGE KC725M	T53, T62
EDPT140412PDSRGE KCPK30	T53, T62
EDPT140412PDSRGE KCSM40	T53, T62
EDPT140416PDERHD KC522M	T53, T62
EDPT140416PDERHD KC725M	T53, T62
EDPT140416PDERHD KCK15	T53, T62
EDPT140416PDERHD KCPK30	T53, T62
EDPT140416PDERHD KCPM40	T53, T62
EDPT140416PDERHD KCSM30	T53, T62
EDPT140416PDERHD KCSM40	T53, T62
EDPT140416PDSRGD KC520M	T54, T63
EDPT140416PDSRGD KC725M	T54, T63
EDPT140416PDSRGD KCPK30	T54, T63
EDPT140416PDSRGD KCPM40	T54, T63
EDPT140416PDSRGD KCSM40	T54, T63
EDPT140416PDSRGE KC522M	T53, T62
EDPT140416PDSRGE KC725M	T53, T62
EDPT140416PDSRGE KCPK30	T53, T62
EDPT140416PDSRGE KCSM40	T53, T62
EDPT140420PDERHD KC522M	T53, T62
EDPT140420PDERHD KC725M	T53, T62
EDPT140420PDERHD KCPK30	T53, T62
EDPT140420PDERHD KCSM40	T53, T62
EDPT140424PDERHD KC522M	T53, T62
EDPT140424PDERHD KC725M	T53, T62

Index

Catalogue No.	Page(s)
EDPT140424PDERHD KCPK30	T53, T62
EDPT140424PDERHD KCPM40	T53, T62
EDPT140424PDERHD KCSM40	T53, T62
EDPT140431PDERHD KC522M	T53, T62
EDPT140431PDERHD KC725M	T53, T62
EDPT140431PDERHD KCPK30	T53, T62
EDPT140431PDERHD KCSM30	T53, T62
EDPT140431PDERHD KCSM40	T53, T62
EDPT140431PDSRGE KC725M	T53, T62
EDPT140431PDSRGE KCPK30	T53, T62
EDPT140431PDSRGE KCSM40	T53, T62
EDPT140440PDERHD KC522M	T53, T62
EDPT140440PDERHD KC725M	T53, T62
EDPT140440PDERHD KCPK30	T53, T62
EDPT140440PDERHD KCSM30	T53, T62
EDPT140440PDERHD KCSM40	T53, T62
EDPT180508PDERGD KC520M	T74
EDPT180508PDERGD KC725M	T74
EDPT180508PDERGD KCPK30	T74
EDPT180508PDERGD KCPM40	T74
EDPT180508PDERGD KCSM40	T74
EDPT180508PDERHD KC725M	T75
EDPT180508PDERHD KCPK30	T75
EDPT180508PDERHD KCPM40	T75
EDPT180508PDERHD KCSM40	T75
EDPT180508PDSRGD KC725M	T75
EDPT180508PDSRGD KCK15	T75
EDPT180508PDSRGD KCPK30	T75
EDPT180508PDSRGD KCPM40	T75
EDPT180508PDSRGD KCSM40	T75
EDPT180508PDSRGE KC522M	T75
EDPT180508PDSRGE KC725M	T75
EDPT180508PDSRGE KCPK30	T75
EDPT180508PDSRGE KCSM40	T75
EDPT180512PDERGD KC725M	T74
EDPT180512PDERGD KCPM40	T74
EDPT180512PDERHD KC725M	T75
EDPT180512PDERHD KCPK30	T75
EDPT180512PDERHD KCSM40	T75
EDPT180512PDSRGD KC725M	T75
EDPT180512PDSRGD KCK15	T75
EDPT180512PDSRGD KCPK30	T75
EDPT180512PDSRGD KCPM40	T75
EDPT180512PDSRGD KCSM40	T75
EDPT180512PDSRGE KC522M	T75
EDPT180512PDSRGE KCPK30	T75
EDPT180512PDSRGE KCSM40	T75
EDPT180516PDERGD KC522M	T74
EDPT180516PDERGD KC725M	T74
EDPT180516PDERGD KCPK30	T74
EDPT180516PDERGD KCPM40	T74
EDPT180516PDERGD KCSM40	T74
EDPT180516PDERHD KC725M	T75
EDPT180516PDERHD KCPK30	T75
EDPT180516PDERHD KCPM40	T75
EDPT180516PDERHD KCSM40	T75
EDPT180516PDSRGD KC725M	T75
EDPT180516PDSRGD KCPK30	T75
EDPT180516PDSRGD KCPM40	T75
EDPT180516PDSRGD KCSM40	T75
EDPT180516PDSRGE KCSM40	T75
EDPT180524PDERGD KC725M	T74
EDPT180532PDERGD KC520M	T74
EDPT180532PDERGD KC522M	T74
EDPT180532PDERGD KC725M	T74
EDPT180532PDERGD KCPK30	T74
EDPT180532PDERGD KCSM40	T74
EDPT180532PDERHD KC725M	T75
EDPT180532PDERHD KCPK30	T75
EDPT180532PDERHD KCPM40	T75
EDPT180532PDERHD KCSM40	T75
EDPT180532PDSRGD KC725M	T75
EDPT180532PDSRGD KCPK30	T75
EDPT180532PDSRGD KCSM40	T75
EDPT180532PDSRGE KCPK30	T75
EDPT180532PDSRGE KCSM40	T75
EDPT180540PDERHD KC725M	T75
EDPT180540PDERHD KCSM40	T75
EDPT180548PDERGD KC725M	T74
EDPT180548PDERGD KCSM40	T74
EDPT180548PDERHD KC725M	T75
EDPT180548PDERHD KCPK30	T75
EDPT180548PDERHD KCSM40	T75
EDPT180548PDSRGD KCSM40	T75
EDPT180564PDERGD KC522M	T74
EDPT180564PDERGD KC725M	T74
EDPT180564PDERGD KCPK30	T74
EDPT180564PDERGD KCSM40	T74
EDPT180564PDERHD KC725M	T75
EDPT180564PDERHD KCPK30	T75
EDPT180564PDSRGD KC725M	T75
EDPT180564PDSRGD KCSM40	T75
EG0200M02P02GUP K313	C18
EG0200M02P02GUP KCU10	C18
EG0200M02P02GUP KCU25	C18
EG0212M02U02GUN KCK20B	C22
EG0212M02U02GUN KCP10B	C22
EG0212M02U02GUN KCP25B	C22
EG0212M02U02GUN KCU10	C22
EG0212M02U02GUN KCU25	C22
EG0212M02U02GUP KCP10B	C17
EG0212M02U02GUP KCP25B	C17
EG0212M02U02GUP KCU10	C17
EG0212M02U02GUP KCU25	C17
EG0251M02U02GUN KCK20B	C22
EG0251M02U02GUN KCP10B	C22
EG0251M02U02GUN KCP25B	C22
EG0251M02U02GUN KCU10	C22
EG0251M02U02GUN KCU25	C22
EG0251M02U02GUP KCP10B	C17
EG0251M02U02GUP KCP25B	C17
EG0251M02U02GUP KCU10	C17
EG0251M02U02GUP KCU25	C17
EG0300M03P02GUP K313	C18
EG0300M03P02GUP KCU10	C18
EG0300M03P02GUP KCU25	C18
EG0300M03P04GUP K313	C18
EG0300M03P04GUP KCU10	C18
EG0300M03P04GUP KCU25	C18
EG0312M03U02GUN KCK20B	C22
EG0312M03U02GUN KCP10B	C22
EG0312M03U02GUN KCP25B	C22
EG0312M03U02GUN KCU10	C22
EG0312M03U02GUN KCU25	C22
EG0312M03U02GUP KCP10B	C17
EG0312M03U02GUP KCU10	C17
EG0312M03U02GUP KCU25	C17
EG0312M03U04GUN KCK20B	C22
EG0312M03U04GUN KCP10B	C22
EG0312M03U04GUN KCP25B	C22
EG0312M03U04GUN KCU10	C22
EG0312M03U04GUN KCU25	C22
EG0312M03U04GUP KCP10B	C17
EG0312M03U04GUP KCP25B	C17
EG0312M03U04GUP KCU10	C17
EG0312M03U04GUP KCU25	C17
EG0400M04P04GUP K313	C18
EG0400M04P04GUP KCU10	C18
EG0400M04P04GUP KCU25	C18
EG0400M04P08GUP K313	C18
EG0400M04P08GUP KCU10	C18
EG0400M04P08GUP KCU25	C18
EG0412M04U04GUN KCK20B	C22
EG0412M04U04GUN KCP10B	C22
EG0412M04U04GUN KCP25B	C22
EG0412M04U04GUN KCU10	C22
EG0412M04U04GUN KCU25	C22
EG0412M04U04GUP KCP10B	C17
EG0412M04U04GUP KCP25B	C17
EG0412M04U04GUP KCU10	C17
EG0412M04U04GUP KCU25	C17
EG0412M04U08GUN KCK20B	C22
EG0412M04U08GUN KCP10B	C22
EG0412M04U08GUN KCP25B	C22
EG0412M04U08GUN KCU10	C22
EG0412M04U08GUN KCU25	C22
EG0412M04U08GUP KCP10B	C17
EG0412M04U08GUP KCP25B	C17
EG0412M04U08GUP KCU10	C17
EG0412M04U08GUP KCU25	C17
EG0500M05P04GUP K313	C18
EG0500M05P04GUP KCU10	C18
EG0500M05P04GUP KCU25	C18
EG0500M05P08GUP K313	C18
EG0500M05P08GUP KCU10	C18
EG0500M05P08GUP KCU25	C18
EG0512M05U04GUN KCK20B	C22
EG0512M05U04GUN KCP10B	C22
EG0512M05U04GUN KCP25B	C22
EG0512M05U04GUN KCU10	C22
EG0512M05U04GUN KCU25	C22
EG0512M05U04GUP KCP10B	C17
EG0512M05U04GUP KCP25B	C17
EG0512M05U04GUP KCU10	C17
EG0512M05U04GUP KCU25	C17
EG0512M05U08GUN KCK20B	C22
EG0512M05U08GUN KCP10B	C22
EG0512M05U08GUN KCP25B	C22
EG0512M05U08GUN KCU10	C22
EG0512M05U08GUN KCU25	C22
EG0512M05U08GUP KCP10B	C17
EG0512M05U08GUP KCP25B	C17
EG0512M05U08GUP KCU10	C17
EG0512M05U08GUP KCU25	C17
EG0600M06P04GUP K313	C18
EG0600M06P04GUP KCU10	C18
EG0600M06P04GUP KCU25	C18
EG0600M06P08GUP K313	C18
EG0600M06P08GUP KCU10	C18
EG0600M06P08GUP KCU25	C18
EG0612M06U04GUN KCK20B	C22
EG0612M06U04GUN KCP10B	C22
EG0612M06U04GUN KCU10	C22
EG0612M06U04GUN KCU25	C22
EG0612M06U04GUP KCP10B	C17
EG0612M06U04GUP KCP25B	C17
EG0612M06U04GUP KCU10	C17
EG0612M06U04GUP KCU25	C17
EG0612M06U08GUN KCK20B	C22
EG0612M06U08GUN KCP25B	C22
EG0612M06U08GUN KCU10	C22
EG0612M06U08GUN KCU25	C22
EG0612M06U08GUP KCP10B	C17
EG0612M06U08GUP KCP25B	C17
EG0612M06U08GUP KCU10	C17
EG0612M06U08GUP KCU25	C17
EG0631I1FP05GUP K313	C20
EG0631I1FP05GUP KCU10	C20
EG0631I1FP05GUP KCU25	C20
EG0631I1FU05GUN KCK20B	C23
EG0631I1FU05GUN KCP10B	C23
EG0631I1FU05GUN KCP25B	C23
EG0631I1FU05GUN KCU10	C23
EG0631I1FU05GUN KCU25	C23
EG0631I1FU05GUP KCP10B	C19
EG0631I1FU05GUP KCP25B	C19
EG0631I1FU05GUP KCU10	C19
EG0631I1FU05GUP KCU25	C19
EG0700M06P08GUP K313	C18
EG0700M06P08GUP KCU10	C18
EG0700M06P08GUP KCU25	C18
EG0712M06U08GUP KCP10B	C17
EG0712M06U08GUP KCP25B	C17
EG0712M06U08GUP KCU10	C17
EG0712M06U08GUP KCU25	C17
EG0800M08P08GUP K313	C18
EG0800M08P08GUP KCU10	C18
EG0800M08P08GUP KCU25	C18
EG0800M08P12GUP K313	C18
EG0800M08P12GUP KCU10	C18
EG0800M08P12GUP KCU25	C18
EG0812M08U08GUN KCK20B	C22
EG0812M08U08GUN KCP10B	C22
EG0812M08U08GUN KCP25B	C22
EG0812M08U08GUN KCU10	C22
EG0812M08U08GUN KCU25	C22
EG0812M08U08GUP KCP10B	C17
EG0812M08U08GUP KCP25B	C17
EG0812M08U08GUP KCU10	C17
EG0812M08U08GUP KCU25	C17
EG0812M08U12GUN KCK20B	C22
EG0812M08U12GUN KCP10B	C22
EG0812M08U12GUN KCP25B	C22
EG0812M08U12GUN KCU10	C22
EG0812M08U12GUN KCU25	C22
EG0812M08U12GUP KCP10B	C17
EG0812M08U12GUP KCP25B	C17
EG0812M08U12GUP KCU10	C17
EG0812M08U12GUP KCU25	C17
EG094I02P05GUP K313	C20
EG094I02P05GUP KCU10	C20
EG094I02P05GUP KCU25	C20
EG1000M10P12GUP K313	C18
EG1000M10P12GUP KCU10	C18
EG1000M10P12GUP KCU25	C18
EG1012M10U12GUN KCK20B	C22
EG1012M10U12GUN KCP10B	C22
EG1012M10U12GUN KCP25B	C22
EG1012M10U12GUN KCU10	C22
EG1012M10U12GUN KCU25	C22
EG1012M10U12GUP KCP10B	C17
EG1012M10U12GUP KCP25B	C17
EG1012M10U12GUP KCU10	C17
EG1012M10U12GUP KCU25	C17
EG125I03P05GUP K313	C20
EG125I03P05GUP KCU10	C20
EG125I03P05GUP KCU25	C20
EG125I03P1GUP K313	C20
EG125I03P1GUP KCU10	C20
EG125I03P1GUP KCU25	C20
EG130I03U05GUN KCK20B	C23
EG130I03U05GUN KCP10B	C23
EG130I03U05GUN KCP25B	C23
EG130I03U05GUN KCU10	C23
EG130I03U05GUN KCU25	C23
EG130I03U05GUP KCP10B	C19
EG130I03U05GUP KCP25B	C19
EG130I03U05GUP KCU10	C19
EG130I03U05GUP KCU25	C19
EG130I03U1GUN KCK20B	C23
EG130I03U1GUN KCP10B	C23
EG130I03U1GUN KCP25B	C23
EG130I03U1GUN KCU10	C23
EG130I03U1GUN KCU25	C23
EG130I03U1GUP KCP10B	C19
EG130I03U1GUP KCP25B	C19
EG130I03U1GUP KCU10	C19
EG130I03U1GUP KCU25	C19
EG187I04P1GUP K313	C20
EG187I04P1GUP KCU10	C20
EG187I04P1GUP KCU25	C20
EG187I04P2GUP K313	C20
EG187I04P2GUP KCU10	C20
EG187I04P2GUP KCU25	C20
EG192I04U1GUN KCK20B	C23
EG192I04U1GUN KCP10B	C23
EG192I04U1GUN KCP25B	C23
EG192I04U1GUN KCU10	C23
EG192I04U1GUN KCU25	C23
EG192I04U1GUP KCP10B	C19
EG192I04U1GUP KCP25B	C19
EG192I04U1GUP KCU10	C19
EG192I04U1GUP KCU25	C19
EG192I04U2GUN KCK20B	C23
EG192I04U2GUN KCP10B	C23
EG192I04U2GUN KCP25B	C23
EG192I04U2GUN KCU10	C23
EG192I04U2GUN KCU25	C23
EG192I04U2GUP KCP10B	C19
EG192I04U2GUP KCP25B	C19
EG192I04U2GUP KCU10	C19
EG192I04U2GUP KCU25	C19
EG250I06P1GUP K313	C20
EG250I06P1GUP KCU10	C20
EG250I06P1GUP KCU25	C20
EG250I06P2GUP K313	C20
EG250I06P2GUP KCU10	C20
EG250I06P2GUP KCU25	C20
EG255I06U1GUN KCK20B	C23
EG255I06U1GUN KCP10B	C23
EG255I06U1GUN KCP25B	C23
EG255I06U1GUN KCU10	C23
EG255I06U1GUN KCU25	C23
EG255I06U1GUP KCP10B	C19
EG255I06U1GUP KCP25B	C19
EG255I06U1GUP KCU10	C19
EG255I06U1GUP KCU25	C19
EG255I06U2GUN KCK20B	C23
EG255I06U2GUN KCP10B	C23
EG255I06U2GUN KCP25B	C23
EG255I06U2GUN KCU10	C23
EG255I06U2GUN KCU25	C23

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
EG255I06U2GUP KCP10B	C19
EG255I06U2GUP KCP25B	C19
EG255I06U2GUP KCU10	C19
EG255I06U2GUP KCU25	C19
EG312I08P3GUP K313	C20
EG312I08P3GUP KCU10	C20
EG312I08P3GUP KCU25	C20
EG317I08U3GUN KCK20B	C23
EG317I08U3GUN KCP10B	C23
EG317I08U3GUN KCP25B	C23
EG317I08U3GUN KCU10	C23
EG317I08U3GUN KCU25	C23
EG317I08U3GUP KCP10B	C19
EG317I08U3GUP KCP25B	C19
EG317I08U3GUP KCU10	C19
EG317I08U3GUP KCU25	C19
EG375I10P3GUP K313	C20
EG375I10P3GUP KCU10	C20
EG375I10P3GUP KCU25	C20
EG380I10U3GUN KCK20B	C23
EG380I10U3GUN KCP10B	C23
EG380I10U3GUN KCP25B	C23
EG380I10U3GUN KCU10	C23
EG380I10U3GUN KCU25	C23
EG380I10U3GUP KCP10B	C19
EG380I10U3GUP KCP25B	C19
EG380I10U3GUP KCU10	C19
EG380I10U3GUP KCU25	C19
ENGN130704T02020 KY1615	B315
ENGN130708T02020 KY1615	B315
ENGN130712T02020 KY1615	B315
ENGN130716T02020 KY1615	B315
ENGX130716T02020 KY3500	B296
ER0300M03P00GUP K313	C21
ER0300M03P00GUP KCU10	C21
ER0300M03P00GUP KCU25	C21
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ER40RBHT66	K119
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EVBSN26J1B15	C49
EVBSN26J1F17	C49
EVBSN26M0230	C49
EVBSN26M0340	C49
EVBSN32M0250	C49
EVBSN32M0350	C49
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EVM50R0422MC	C50
EVM50R0426A100180C	C52
EVM50R0426A180250C	C53
EVM50R0426A250350C	C53

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
EVM50R0426A350999C	C53
EVM50R0426B100180C	C55
EVM50R0426B180250C	C56
EVM50R0426B250350C	C56
EVM50R0426B350999C	C56
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EVSML2020K0222	C37
EVSML2020K0316C	C37
EVSML2020K0322C	C37
EVSML2020K0416C	C37
EVSML2020K0422C	C37
EVSML2020K0516C	C37
EVSML2020K0522C	C37
EVSML2020K0616C	C37
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EVSML2525M0316C	C37
EVSML2525M0326C	C37
EVSML2525M0416C	C37
EVSML2525M0426C	C37
EVSML2525M0516C	C37
EVSML2525M0526C	C37
EVSML2525M0616C	C37
EVSML2525M0626C	C37
EVSML2525M0826C	C38
EVSML3232P0426C	C37
EVSML3232P0432C	C37
EVSML3232P0526C	C37
EVSML3232P0532C	C37
EVSML3232P0626C	C38
EVSML3232P0632C	C38
EVSML3232P0826C	C38
EVSML3232P0832C	C38
EVSML3232P1032C	C38
EVSML4040R0640C	C38
EVSML4040R0840C	C38
EVSML4040R1040C	C38
EVSMR2020K0216	C36
EVSMR2020K0216C	C36
EVSMR2020K0222	C36
EVSMR2020K0222C	C36
EVSMR2020K0316C	C36
EVSMR2020K0322C	C36
EVSMR2020K0416C	C36
EVSMR2020K0422C	C36
EVSMR2020K0516C	C36
EVSMR2020K0522C	C36
EVSMR2020K0616C	C37
EVSMR2020K0622C	C37
EVSMR2525M0216	C36
EVSMR2525M0216C	C36
EVSMR2525M0226	C36
EVSMR2525M0226C	C36
EVSMR2525M0316C	C36
EVSMR2525M0326C	C36
EVSMR2525M0416C	C36
EVSMR2525M0426C	C36
EVSMR2525M0516C	C36
EVSMR2525M0526C	C36
EVSMR2525M0616C	C37
EVSMR2525M0626C	C37
EVSMR2525M0826C	C37
EVSMR3232P0426C	C36
EVSMR3232P0432C	C36
EVSMR3232P0526C	C36
EVSMR3232P0532C	C37
EVSMR3232P0626C	C37
EVSMR3232P0632C	C37
EVSMR3232P0826C	C37
EVSMR3232P0832C	C37
EVSMR3232P1032C	C37
EVSMR4040R0640C	C37
EVSMR4040R0840C	C37
EVSMR4040R1040C	C37
F10AJ1600ADK45E320 KCPM15	P104
F10AJ2000ADK45E400 KCPM15	P104
F1AA0200AWS30 K600	P118
F1AA0300AWS30 K600	P118
F1AA0400AWS30 K600	P118
F1AA0500AWS30 K600	P118
F1AA0600AWS30 K600	P118
F1AA0800AWM30 K600	P118
F1AA1000AWM30 K600	P118
F1AA1200AWM30 K600	P118
F2AA0400ADL45 K600	P119
F2AA0500ADL45 K600	P119
F2AA0600ADL45 K600	P119

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
F2AA0600AWM45R050 K600	P120
F2AA0600AWM45R100 K600	P120
F2AA0800ADL45 K600	P119
F2AA0800AWM45R050 K600	P120
F2AA0800AWM45R100 K600	P120
F2AA1000ADL45 K600	P119
F2AA1000AWL45R050 K600	P120
F2AA1000AWL45R100 K600	P120
F2AA1000AWL45R200 K600	P120
F2AA1000AWL45R300 K600	P120
F2AA1000AWL45R400 K600	P120
F2AA1200ADL45 K600	P119
F2AA1200AWL45R050 K600	P120
F2AA1200AWL45R100 K600	P120
F2AA1200AWL45R200 K600	P120
F2AA1200AWL45R250 K600	P120
F2AA1200AWL45R300 K600	P120
F2AA1200AWL45R400 K600	P120
F2AA1400ADL45 K600	P119
F2AA1600ADL45 K600	P119
F2AA1600AWX45R050 K600	P120
F2AA1600AWX45R100 K600	P120
F2AA1600AWX45R200 K600	P120
F2AA1600AWX45R250 K600	P120
F2AA1600AWX45R300 K600	P120
F2AA1600AWX45R400 K600	P120
F2AA1800ADL45 K600	P119
F2AA2000ADL45 K600	P119
F2AA2000AWX45R050 K600	P120
F2AA2000AWX45R100 K600	P120
F2AA2000AWX45R200 K600	P120
F2AA2000AWX45R300 K600	P120
F2AA2000AWX45R400 K600	P120
F2AA2500AWX45R050 K600	P120
F2AA2500AWX45R100 K600	P120
F2AA2500AWX45R200 K600	P120
F2AA2500AWX45R300 K600	P120
F2AA2500AWX45R400 K600	P120
F2AB0200AWM30 KC637M	P150
F2AB0300AWM30 KC637M	P150
F2AB0400AWL30 KC637M	P150
F2AB0500AWL30 KC637M	P150
F2AB0600AWL30 KC637M	P150
F2AB1000AWL30 KC637M	P150
F2AB1200AWX30 KC637M	P150
F2AH0030AWS30L040 KC637M	P162–163
F2AH0050AWS30L070 KC637M	P162–163
F2AH0080AWM30L120 KC637M	P162–163
F2AH0100AWM30L150 KC637M	P162–163
F2AH0100AWS30L150 KC637M	P162–163
F2AH0150AWM30L230 KC637M	P162–163
F2AH0150AWS30L230 KC637M	P162–163
F2AH0160AWM30L240 KC637M	P162–163
F2AH0160AWS30L240 KC637M	P162–163
F2AH0180AWM30L270 KC637M	P162–163
F2AH0180AWS30L270 KC637M	P162–163
F2AH0200AWM30L300 KC637M	P162–163
F2AH0200AWS30L300 KC637M	P162–163
F2AH0250AWM30L370 KC637M	P162–163
F2AH0250AWS30L370 KC637M	P162–163
F2AL0050AWS30 KC637M	P165
F2AL0050AWS30L050 KC637M	P166
F2AL0060AWS30L060 KC637M	P166
F2AL0080AWS30L080 KC637M	P166
F2AL0100AWL30 KC637M	P148
F2AL0100AWM30E060 KC637M	P167
F2AL0100AWM30E100 KC637M	P167
F2AL0100AWM30E160 KC637M	P167
F2AL0100AWS30 KC637M	P165
F2AL0100AWS30L100 KC637M	P166
F2AL0120AWS30L120 KC637M	P166
F2AL0150AWL30 KC637M	P148
F2AL0150AWM30E160 KC637M	P167
F2AL0150AWS30 KC637M	P165
F2AL0150AWS30L150 KC637M	P166
F2AL0160AWS30L160 KC637M	P166
F2AL0180AWS30L180 KC637M	P166
F2AL0200AWL30 KC637M	P148
F2AL0200AWM20 KC637M	P147
F2AL0200AWM30E0200 KC637M	P167
F2AL0200AWM30E100 KC637M	P167
F2AL0200AWM30E160 KC637M	P167
F2AL0200AWS30 KC637M	P165
F2AL0200AWS30L200 KC637M	P166
F2AL0250AWS30 KC637M	P165
F2AL0250AWS30L250 KC637M	P166
F2AL0300AWL30 KC637M	P148
F2AL0300AWM20 KC637M	P147
F2AL0300AWS30 KC637M	P165
F2AL0300AWS30L300 KC637M	P166
F2AL0400AWL20 KC637M	P147
F2AL0400AWL30 KC637M	P148
F2AL0400AWM30E060 KC637M	P167
F2AL0400AWM30E160 KC637M	P167
F2AL0400AWS30L400 KC637M	P166
F2AL0500AWL20 KC637M	P147
F2AL0500AWL30 KC637M	P148
F2AL0600AWL20 KC637M	P147
F2AL0600AWL30 KC637M	P148
F2AL0600AWM30 KC637M	P149
F2AL0600AWS30L600 KC637M	P166
F2AL0800AWL20 KC637M	P147
F2AL0800AWL30 KC637M	P148
F2AL0800AWM30 KC637M	P149
F2AL1000AWL20 KC637M	P147
F2AL1000AWL30 KC637M	P149
F2AL1000AWM30 KC637M	P148
F2AL1200AWM30 KC637M	P148
F2AL1200AWX20 KC637M	P147
F2AL1200AWX30 KC637M	P149
F2AL1600AWM30 KC637M	P148
F2AL1600AWX30 KC637M	P149
F2AT0200AWM20R003 KC637M	P142
F2AT0200AWM20R005 KC637M	P142
F2AT0300AWM20R005 KC637M	P142
F2AT0300AWM20R010 KC637M	P142
F2AT0400AWL20R005 KC637M	P142
F2AT0400AWL20R010 KC637M	P142
F2AT0500AWL20R005 KC637M	P142
F2AT0500AWL20R010 KC637M	P142
F2AT0600AWL20R005 KC637M	P142
F2AT0600AWL20R010 KC637M	P142
F2AT0800AWL20R010 KC637M	P142
F2AT0800AWL20R020 KC637M	P142
F2AT1000AWL20R010 KC637M	P142
F2AT1000AWL20R020 KC637M	P142
F2AT1000AWL20R030 KC637M	P142
F2AT1200AWX20R005 KC637M	P142
F2AT1200AWX20R010 KC637M	P142
F2AT1200AWX20R030 KC637M	P142
F2AU0180ADK38 KC643M	P186
F2AU0280ADK38 KC643M	P186
F2AU0380ADK38 KC643M	P186
F2AU0480ADK38 KC643M	P186
F2AU0575ADK38 KC643M	P186
F2AU0775ADK38 KC643M	P186
F2AU0970ADK38 KC643M	P186
F2AU1170ADK38 KC643M	P186
F2AU1370ADK38 KC643M	P186
F2AU1570ADK38 KC643M	P186
F2AU1770ADK38 KC643M	P186
F2AU1970ADK38 KC643M	P186
F3508T S	T115, V9–11
F3510T S	V9–12
F3AA0300AWS45 K600	P121
F3AA0400AWS45 K600	P121
F3AA0500AWS45 K600	P121
F3AA0600AWM45R050 K600	P122
F3AA0600AWM45R100 K600	P122
F3AA0600AWS45 K600	P121
F3AA0800AWM45 K600	P121
F3AA0800AWM45R050 K600	P122
F3AA0800AWM45R100 K600	P122
F3AA1000AWL45 K600	P121
F3AA1000AWL45R050 K600	P122
F3AA1000AWL45R100 K600	P122
F3AA1000AWL45R200 K600	P122
F3AA1000AWL45R300 K600	P122
F3AA1000AWL45R400 K600	P122
F3AA1200AWL45 K600	P121
F3AA1200AWL45R100 K600	P122
F3AA1200AWL45R200 K600	P122
F3AA1200AWL45R300 K600	P122
F3AA1200AWL45R400 K600	P122
F3AA1400AWL45 K600	P121
F3AA1600AWL45 K600	P121
F3AA1600AWX45R050 K600	P122
F3AA1600AWX45R100 K600	P122
F3AA1600AWX45R200 K600	P122
F3AA1600AWX45R300 K600	P122
F3AA1600AWX45R400 K600	P122
F3AA1800AWL45 K600	P121
F3AA2000AWX45 K600	P121
F3AA2000AWX45R050 K600	P122
F3AA2000AWX45R100 K600	P122
F3AA2000AWX45R200 K600	P122
F3AA2000AWX45R300 K600	P122
F3AA2000AWX45R400 K600	P122
F3AA2500AWX45R050 K600	P122
F3AA2500AWX45R100 K600	P122
F3AA2500AWX45R200 K600	P122
F3AA2500AWX45R300 K600	P122
F3AA2500AWX45R400 K600	P122
F3AH0050AWS30 KC635M	P164
F3AH0060AWS30 KC635M	P164
F3AH0080AWS30 KC635M	P164
F3AH0100AWS30 KC635M	P164
F3AH0120AWS30 KC635M	P164
F3AH0150AWS30 KC635M	P164
F3AH0200AWS30 KC635M	P164
F3AH0250AWS30 KC635M	P164
F3AH0300AWS30 KC635M	P164
F3AS0300BDK35 KCPM15	P102
F3AS0400BDK35 KCPM15	P102
F3AS0500BDK35 KCPM15	P102
F3AS0600BDK35 KCPM15	P102
F3AS0800BDK35 KCPM15	P102
F3AS1000BDK35 KCPM15	P102
F3AS1200BDK35 KCPM15	P102
F3AS1400BDK35 KCPM15	P102
F3AS1600BDK35 KCPM15	P102
F3AS2000BDK35 KCPM15	P102
F3AU0280ADK38 KC643M	P187
F3AU0380ADK38 KC643M	P187
F3AU0480ADK38 KC643M	P187
F3AU0575ADK38 KC643M	P187
F3AU0775ADK38 KC643M	P187
F3AU0970ADK38 KC643M	P187
F3AU1170ADK38 KC643M	P187
F3AU1370ADK38 KC643M	P187
F3AU1570ADK38 KC643M	P187
F3AU1770ADK38 KC643M	P187
F3AU1970ADK38 KC643M	P187
F3AW0600AWL35E120 KCPM15	P103
F3AW0800AWL35E160 KCPM15	P103
F3AW1000AWX35E200 KCPM15	P103
F3AW1200AWX35E240 KCPM15	P103
F3AW1600AWX35E320 KCPM15	P103
F3BA0600ADL40E180 K600	P125
F3BA0600BWS40 K600	P123
F3BA0800ADL40E240 K600	P125
F3BA0800BWM40 K600	P123
F3BA0800BWM40C160 K600	P124
F3BA1000ADL40E300 K600	P125
F3BA1000BWM40 K600	P123
F3BA1000BWM40C220 K600	P124
F3BA1200ADL40E360 K600	P125
F3BA1200BWL40 K600	P123
F3BA1200BWL40C260 K600	P124
F3BA1600ADL40E480 K600	P125
F3BA1600BWL40 K600	P123
F3BA1600BWL40C320 K600	P124
F3BA2000ADL40E600 K600	P125
F3BA2000BWX40 K600	P123
F3BA2000BWX40C380 K600	P124
F3BA2500BWX40 K600	P123
F3BA2500BWX40C450 K600	P124
F3BH0400BDL30 KCPM15	P81
F3BH0400BWS20L110 KCPM15	P78
F3BH0500BDL30 KCPM15	P81
F3BH0500BWS20L130 KCPM15	P78
F3BH0600BDL30 KCPM15	P81
F3BH0600BWS20L080 KCPM15	P78
F3BH0600BWS20L130 KCPM15	P78
F3BH0800BDL30 KCPM15	P81
F3BH0800BWM20C160 KCPM15	P79
F3BH0800BWM20L160 KCPM15	P78
F3BH0800BWS20C110 KCPM15	P79
F3BH0800BWS20L110 KCPM15	P78
F3BH1000BDL30 KCPM15	P81
F3BH1200BDL30 KCPM15	P81
F3BH1600BDL30 KCPM15	P81
F3BH2000BDL30 KCPM15	P81
F3BH2500BDL30 KCPM15	P81
F3BS0600BDK35 KCPM15	P82
F3BS0600BDL35 KCPM15	P82
F3BS0800BDK35 KCPM15	P82
F3BS0800BDL35 KCPM15	P82
F3BS1000BDK35 KCPM15	P82
F3BS1000BDL35 KCPM15	P82
F3BS1200BDK35 KCPM15	P82
F3BS1200BDL35 KCPM15	P82
F3BS1400BDL35 KCPM15	P82
F3BS1600BDK35 KCPM15	P82
F3BS1600BDL35 KCPM15	P82
F3BS2000BDK35 KCPM15	P82
F3BS2000BDL35 KCPM15	P82
F4011T S	T118
F4AJ0600AWS50L090 KC633M	P145
F4AJ0600AWS50R025 KC633M	P144
F4AJ0600AWS50R050 KC633M	P144
F4AJ0800AWM50L120 KC633M	P145
F4AJ0800AWM50R050 KC633M	P144
F4AJ0800AWM50R100 KC633M	P144
F4AJ1000AWL50R050 KC633M	P144
F4AJ1000AWL50R100 KC633M	P144
F4AJ1000AWM50L150 KC633M	P145
F4AJ1200AWL50R050 KC633M	P144
F4AJ1200AWL50R150 KC633M	P144
F4AJ1600AWL50L240 KC633M	P145
F4AJ1600AWL50R050 KC633M	P144
F4AJ1600AWL50R150 KC633M	P144
F4AJ2000AWL50L300 KC633M	P145
F4AJ2000AWX50R050 KC633M	P144
F4AJ2000AWX50R200 KC633M	P144
F4AL0300AWL30L040 KC637M	P151
F4AL0300AWM30L040 KC637M	P151
F4AL0400AWL30L050 KC637M	P151
F4AL0400AWM30L050 KC637M	P151
F4AL0500AWL30L060 KC637M	P151
F4AL0500AWM30L060 KC637M	P151
F4AL0600AWL30L080 KC637M	P151
F4AL0600AWM30L080 KC637M	P151
F4AL0800AWL30L120 KC637M	P151
F4AL0800AWX30L120 KC637M	P151
F4AL1000AWL30L150 KC637M	P151
F4AL1000AWX30L150 KC637M	P151
F4AS0400ADL38 KCPM15	P16
F4AS0400BDL38 KCPM15	P16
F4AS0500ADL38 KCPM15	P16
F4AS0500BDL38 KCPM15	P16
F4AS0600ADL38 KCPM15	P16
F4AS0600AWM38R050 KCPM15	P18
F4AS0600AWM38R100 KCPM15	P18
F4AS0600BDL38 KCPM15	P16
F4AS0600BWM38R050 KCPM15	P18
F4AS0600BWM38R100 KCPM15	P18
F4AS0800ADL38 KCPM15	P16
F4AS0800AWM38R050 KCPM15	P18
F4AS0800AWM38R100 KCPM15	P18
F4AS0800BDL38 KCPM15	P16
F4AS0800BWM38R050 KCPM15	P18
F4AS0800BWM38R100 KCPM15	P18
F4AS1000ADL38 KCPM15	P16
F4AS1000AWL38R050 KCPM15	P18
F4AS1000AWL38R100 KCPM15	P18
F4AS1000AWL38R200 KCPM15	P18
F4AS1000AWL38R300 KCPM15	P18
F4AS1000AWL38R400 KCPM15	P18
F4AS1000BDL38 KCPM15	P16
F4AS1000BWL38R050 KCPM15	P18
F4AS1000BWL38R100 KCPM15	P18
F4AS1000BWL38R200 KCPM15	P18
F4AS1000BWL38R300 KCPM15	P18
F4AS1000BWL38R400 KCPM15	P18
F4AS1200ADL38 KCPM15	P16
F4AS1200AWL38R050 KCPM15	P18

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
F4AS1200AWL38R100 KCPM15	P18
F4AS1200AWL38R200 KCPM15	P18
F4AS1200AWL38R300 KCPM15	P18
F4AS1200AWL38R400 KCPM15	P18
F4AS1200BDL38 KCPM15	P16
F4AS1200BWL38R050 KCPM15	P18
F4AS1200BWL38R100 KCPM15	P18
F4AS1200BWL38R200 KCPM15	P18
F4AS1200BWL38R300 KCPM15	P18
F4AS1200BWL38R400 KCPM15	P18
F4AS1400ADL38 KCPM15	P16
F4AS1400BDL38 KCPM15	P16
F4AS1600ADL38 KCPM15	P16
F4AS1600AWX38R050 KCPM15	P18
F4AS1600AWX38R100 KCPM15	P18
F4AS1600AWX38R200 KCPM15	P18
F4AS1600AWX38R300 KCPM15	P18
F4AS1600AWX38R400 KCPM15	P18
F4AS1600AWX38R600 KCPM15	P18
F4AS1600BDL38 KCPM15	P16
F4AS1600BWX38R050 KCPM15	P18
F4AS1600BWX38R100 KCPM15	P18
F4AS1600BWX38R200 KCPM15	P18
F4AS1600BWX38R300 KCPM15	P18
F4AS1600BWX38R400 KCPM15	P18
F4AS1600BWX38R600 KCPM15	P18
F4AS1800ADL38 KCPM15	P16
F4AS1800BDL38 KCPM15	P16
F4AS2000ADL38 KCPM15	P16
F4AS2000AWX38R050 KCPM15	P18
F4AS2000AWX38R100 KCPM15	P18
F4AS2000AWX38R200 KCPM15	P18
F4AS2000AWX38R300 KCPM15	P18
F4AS2000AWX38R400 KCPM15	P18
F4AS2000AWX38R600 KCPM15	P18
F4AS2000BDL38 KCPM15	P16
F4AS2000BWX38R050 KCPM15	P18
F4AS2000BWX38R100 KCPM15	P18
F4AS2000BWX38R200 KCPM15	P18
F4AS2000BWX38R300 KCPM15	P18
F4AS2000BWX38R400 KCPM15	P18
F4AS2000BWX38R600 KCPM15	P18
F4AS2500ADL38 KCPM15	P16
F4AS2500AWX38R050 KCPM15	P18
F4AS2500AWX38R100 KCPM15	P18
F4AS2500AWX38R200 KCPM15	P18
F4AS2500AWX38R400 KCPM15	P18
F4AS2500AWX38R600 KCPM15	P18
F4AS2500BDL38 KCPM15	P16
F4AS2500BWX38R050 KCPM15	P18
F4AS2500BWX38R200 KCPM15	P18
F4AS2500BWX38R300 KCPM15	P18
F4AS2500BWX38R400 KCPM15	P18
F4AS2500BWX38R600 KCPM15	P18
F4AT0400AWS20R005 KC637M	P143
F4AT0400AWS20R010 KC637M	P143
F4AT0500AWS20R005 KC637M	P143
F4AT0500AWS20R010 KC637M	P143
F4AT0600AWL20R005 KC637M	P143
F4AT0600AWL20R010 KC637M	P143
F4AT0600AWS20R005 KC637M	P143
F4AT0800AWL20R005 KC637M	P143
F4AT0800AWL20R010 KC637M	P143
F4AT0800AWL20R020 KC637M	P143
F4AT0800AWM20R010 KC637M	P143
F4AT0800AWM20R020 KC637M	P143
F4AT1000AWL20R005 KC637M	P143
F4AT1000AWL20R010 KC637M	P143
F4AT1000AWL20R020 KC637M	P143
F4AT1000AWL20R025 KC637M	P143
F4AT1000AWM20R005 KC637M	P143
F4AT1000AWM20R025 KC637M	P143
F4AT1200AWL20R015 KC637M	P143
F4AT1200AWL20R030 KC637M	P143
F4AT1200AWX20R010 KC637M	P143
F4AT1200AWX20R015 KC637M	P143
F4AT1200AWX20R030 KC637M	P143
F4AW0400AWL38W040 KC633M	P22
F4AW0400AWL38W060 KC633M	P22
F4AW0500AWL38W040 KC633M	P22
F4AW0500AWL38W060 KC633M	P22
F4AW0600AWL38E120 KCPM15	P21
F4AW0600AWL38W040 KC633M	P22
F4AW0600AWL38W060 KC633M	P22
F4AW0800AWL38E160 KCPM15	P21
F4AW0800AWL38W040 KC633M	P22
F4AW0800AWL38W060 KC633M	P22
F4AW1000AWX38E200 KCPM15	P21
F4AW1000AWX38W040 KC633M	P22
F4AW1000AWX38W060 KC633M	P22
F4AW1200AWX38E240 KCPM15	P21
F4AW1600AWX38E320 KCPM15	P21
F4BJ0600BDL30 KCPM15	P83
F4BJ0600BDL45 KCPM15	P84
F4BJ0800BDL30 KCPM15	P83
F4BJ0800BDL45 KCPM15	P84
F4BJ1000BDL30 KCPM15	P83
F4BJ1000BDL45 KCPM15	P84
F4BJ1000BWM20C130 KCPM15	P79
F4BJ1000BWM20C220 KCPM15	P79
F4BJ1000BWM20L130 KCPM15	P78
F4BJ1000BWM20L220 KCPM15	P78
F4BJ1200BDL30 KCPM15	P83
F4BJ1200BDL45 KCPM15	P84
F4BJ1200BWL20C260 KCPM15	P79
F4BJ1200BWL20L260 KCPM15	P78
F4BJ1200BWM20C160 KCPM15	P79
F4BJ1200BWM20L160 KCPM15	P78
F4BJ1400BDL30 KCPM15	P83
F4BJ1400BWL20L260 KCPM15	P78
F4BJ1600BDL30 KCPM15	P83
F4BJ1600BWL20C190 KCPM15	P79
F4BJ1600BWL20C320 KCPM15	P79
F4BJ1600BWL20L190 KCPM15	P78
F4BJ1600BWL20L320 KCPM15	P78
F4BJ1800BDL30 KCPM15	P83
F4BJ2000BDL30 KCPM15	P83
F4BJ2000BWL20C220 KCPM15	P79
F4BJ2000BWL20L220 KCPM15	P78
F4BJ2000BWX20C380 KCPM15	P79
F4BJ2000BWX20L380 KCPM15	P78
F4BS0600AWM38R050 KCPM15	P19
F4BS0600AWM38R100 KCPM15	P19
F4BS0600BWM38R050 KCPM15	P19
F4BS0600BWM38R100 KCPM15	P19
F4BS0800AWM38R050 KCPM15	P19
F4BS0800AWM38R100 KCPM15	P19
F4BS0800BWM38R050 KCPM15	P19
F4BS0800BWM38R100 KCPM15	P19
F4BS1000AWL38R050 KCPM15	P19
F4BS1000AWL38R100 KCPM15	P19
F4BS1000AWL38R200 KCPM15	P19
F4BS1000AWL38R300 KCPM15	P19
F4BS1000AWL38R400 KCPM15	P19
F4BS1000BWL38R050 KCPM15	P19
F4BS1000BWL38R100 KCPM15	P19
F4BS1000BWL38R200 KCPM15	P19
F4BS1000BWL38R300 KCPM15	P19
F4BS1000BWL38R400 KCPM15	P19
F4BS1200AWL38R050 KCPM15	P19
F4BS1200AWL38R100 KCPM15	P19
F4BS1200AWL38R200 KCPM15	P19
F4BS1200AWL38R300 KCPM15	P19
F4BS1200AWL38R400 KCPM15	P19
F4BS1200BWL38R050 KCPM15	P19
F4BS1200BWL38R100 KCPM15	P19
F4BS1200BWL38R200 KCPM15	P19
F4BS1200BWL38R300 KCPM15	P19
F4BS1200BWL38R400 KCPM15	P19
F4BS1600AWX38R050 KCPM15	P19
F4BS1600AWX38R100 KCPM15	P19
F4BS1600AWX38R200 KCPM15	P19
F4BS1600AWX38R300 KCPM15	P19
F4BS1600AWX38R400 KCPM15	P19
F4BS1600BWX38R050 KCPM15	P19
F4BS1600BWX38R100 KCPM15	P19
F4BS1600BWX38R200 KCPM15	P19
F4BS1600BWX38R300 KCPM15	P19
F4BS1600BWX38R400 KCPM15	P19
F4BS2000AWX38R050 KCPM15	P19
F4BS2000AWX38R100 KCPM15	P19
F4BS2000AWX38R200 KCPM15	P19
F4BS2000AWX38R300 KCPM15	P19
F4BS2000AWX38R400 KCPM15	P19
F4BS2000BWX38R050 KCPM15	P19
F4BS2000BWX38R100 KCPM15	P19
F4BS2000BWX38R200 KCPM15	P19
F4BS2000BWX38R300 KCPM15	P19
F4BS2000BWX38R400 KCPM15	P19
F4BS2500AWX38R050 KCPM15	P19
F4BS2500AWX38R100 KCPM15	P19
F4BS2500AWX38R200 KCPM15	P19
F4BS2500AWX38R300 KCPM15	P19
F4BS2500AWX38R400 KCPM15	P19
F4BS2500BWX38R050 KCPM15	P19
F4BS2500BWX38R100 KCPM15	P19
F4BS2500BWX38R200 KCPM15	P19
F4BS2500BWX38R300 KCPM15	P19
F4BS2500BWX38R400 KCPM15	P19
F5AJ2500AWX50L380 KC633M	P145
F5BJ2500BWX20L450 KCPM15	P78
F6AJ0600ADL45 KCPM15	P105
F6AJ0600AWM45 KCPM15	P105
F6AJ0800ADL45 KCPM15	P105
F6AJ0800AWM45 KCPM15	P105
F6AJ1000ADL45 KCPM15	P105
F6AJ1000AWL45 KCPM15	P105
F6AJ1200ADL45 KCPM15	P105
F6AJ1200AWL45 KCPM15	P105
F6AJ1400ADL45 KCPM15	P105
F6AJ1600ADL45 KCPM15	P105
F6AJ1600AWX45 KCPM15	P105
F6AV0600ADL45 KC637M	P146
F6AV0600AWM45 KC637M	P146
F6AV0800ADL45 KC637M	P146
F6AV0800AWM45 KC637M	P146
F6AV1000ADL45 KC637M	P146
F6AV1000AWL45 KC637M	P146
F6AV1200ADL45 KC637M	P146
F6AV1200AWL45 KC637M	P146
F6AV1600ADL45 KC637M	P146
F6AV1600AWX45 KC637M	P146
F6BJ1600BDL45 KCPM15	P84
F6BJ2000BDL45 KCPM15	P84
F6BJ2500BDL45 KCPM15	P84
F7IP	T29, T38
F8017S S	V102
F8AJ0800ADK45E160 KCPM15	P104
F8AJ1000ADK45E200 KCPM15	P104
F8AJ1200ADK45E240 KCPM15	P104
F8AJ2000AWX45 KCPM15	P105
F8AJ2500AWX45 KCPM15	P105
F8AV2000ADL45 KC637M	P146
F8AV2000AWX45 KC637M	P146
F8AV2500ADL45 KC637M	P146
F8AV2500AWX45 KC637M	P146
FAS100302GD KC7015	H33
FAS100302GD KC7215	H33
FBSCFCL09CA06F	K111
FBSCFCR09CA06F	K111
FBSCLCL09CA06F	K111
FBSCLCR09CA06F	K111
FBSCUCR09CA06F	K112
FBSTFCR09CA11F	K113
FC11	B250–251
FC14	B250–252
FMDF1000X6CQE KCPM15	042
FMDF1200X6CQF KCPM15	042
FMDF1600X6CQF KCPM15	042
FMDF2000X6CQF KCPM15	042
FMDF2500X6CQF KCPM15	042
FP2506T	V4–5
FP2507T	V4–5
FP3006T	V101, V104
FP3007T S	V101, V103–104
FSDE0600A7DYA KC643M	P94
FSDE0600A7DYE KC643M	P94
FSDE0800A7DYA KC643M	P94
FSDE0800A7DYE KC643M	P94
FSDE1000A9BCE KC643M	P92
FSDE1000A9BCG KC643M	P92
FSDE1000A9DYE KC643M	P94
FSDE1000A9DYG KC643M	P94
FSDE1000X9CQE KC643M	043
FSDE1000X9CQG KC643M	043
FSDE1000X9CQJ KC643M	043
FSDE1200A9BCE KC643M	P92
FSDE1200A9BCG KC643M	P92
FSDE1200A9BCL KC643M	P92
FSDE1200A9BCN KC643M	P92
FSDE1200E9DYE KC643M	P94
FSDE1200E9DYG KC643M	P94
FSDE1200E9DYL KC643M	P94
FSDE1200X9CQE KC643M	043
FSDE1200X9CQG KC643M	043
FSDE1200X9CQJ KC643M	043
FSDE1200X9CQL KC643M	043
FSDE1600ABBCG KC643M	P92
FSDE1600ABBCL KC643M	P92
FSDE1600ABBCM KC643M	P92
FSDE1600ABBCN KC643M	P92
FSDE1600ABBCP KC643M	P92
FSDE1600EBDYG KC643M	P94
FSDE1600EBDYL KC643M	P94
FSDE1600EBDYM KC643M	P94
FSDE1600EBDYP KC643M	P94
FSDE1600XBCQG KC643M	043
FSDE1600XBCQJ KC643M	043
FSDE1600XBCQK KC643M	043
FSDE1600XBCQL KC643M	043
FSDE1600XBCQM KC643M	043
FSDE2000AFBCG KC643M	P92
FSDE2000AFBCK KC643M	P92
FSDE2000AFBCL KC643M	P92
FSDE2000AFBCN KC643M	P92
FSDE2000AFBCP KC643M	P92
FSDE2000EFDYG KC643M	P94
FSDE2000EFDYK KC643M	P94
FSDE2000EFDYL KC643M	P94
FSDE2000EFDYP KC643M	P94
FSDE2000XFCQG KC643M	043
FSDE2000XFCQK KC643M	043
FSDE2000XFCQL KC643M	043
FSDE2000XFCQM KC643M	043
FSDE2000XFCQN KC643M	043
FSDE2500AJBCG KC643M	P92
FSDE2500AJBCL KC643M	P92
FSDE2500AJBCP KC643M	P92
FSDE2500EJDYG KC643M	P94
FSDE2500EJDYL KC643M	P94
FSDE2500EJDYP KC643M	P94
FSDE2500XJCQL KC643M	043
FSDE2500XJCQN KC643M	043
FT10	K38
FT15	K81, K120–121
FT20	K120–121
FT5	K74
FT6	K75, T24
FT7	K74–76, K81, K85, K120–121
FT8	K38, K81
FUWTCL	E57
FUWTCR	E57
G14-G18-RED	C75
G18-JIC	C75
G50MTTB1026KM40	B387
G80MTTB1564KM63	B387
GPCD050102 KC5025	B222
GPCD050102 KCU25	B222
GPCD050104 KCU25	B222
H16LSER3	D82
H20LSER3	D82
H24LSER3	D82
H24LSER4	D82
H25SDUCL11	B213
H25SDUCR11	B213
H32LSER3	D82
H32LSER4	D82
H32LSER5	D82
H32MCLNR12	B68
H32PCLNR12	B69
H32PDUNR15	B91
H32SCLCR09	B183
H32SDUCL11	B213
H32SDUCR11	B213
H40LSER22	D82
H40LSER5	D82
H40MDUNR15	B91
H40MVUNR16	B153

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
H40PCLNL12	B69
H40PCLNR12	B69
H40SCLCR12	B183
H40SDUCR11	B213
H50LSER16	D82
H50LSER22	D82
H50LSER27	D82
H50MCLNR12	B68
H50MCLNR19	B68
H50MDUNL19	B91
H50MVUNR16	B153
H50PCLNL12	B69
H50PCLNR12	B69
H50PDUNL15	B91
H50PDUNR15	B91
H50SDUCL11	B213
H50SDUCR11	B213
HDHN070408ER KC514M	S112
HDHN070408SR KBK50	S112
HDHN070408SR KY3500	S112
HDWM5EUS	S126
HFB1023SCFPR06	K126
HFB1223SCFPR06	K126
HFB14FBHS1440	K126
HFB1627SCFPR06	K126
HFB16FBHS1640	K126
HFB19FBHS1840	K126
HFB2127SCFPR06	K126
HFB2427SCFPR06	K126
HFB2727SCFPR06	K126
HFB3127SCFPR06	K126
HFB3427SCFPR06	K126
HNEC0905ANSN KY3500	S24
HNEN090508MSN KY3500	S92, S98
HNEN0905AMSN KY3500	S92, S98
HNEN0905ANSN KD200	S92, S98
HNEN0905XNSN KY3500	S92, S98
HNGF090504MF KC514M	S98
HNGF090504MF KCK15	S98
HNGF090504MF KCK20	S98
HNGJ060432ANENLD KC725M	S6, S12, S15
HNGJ060432ANENLD KCPK30	S6, S12, S15
HNGJ0604ANENLD KC510M	S6, S12, S15
HNGJ0604ANENLD KC520M	S6, S12, S15
HNGJ0604ANENLD KC522M	S6, S12, S15
HNGJ0604ANENLD KC725M	S6, S12, S15
HNGJ0604ANENLD KCK15	S6, S12, S15
HNGJ0604ANENLD KCPK30	S6, S12, S15
HNGJ0604ANENLD KCPM40	S6, S12, S15
HNGJ0604ANENLD KCSM40	S6, S12, S15
HNGJ0604ANFNLDJ K313	S6, S11, S15
HNGJ0604ANFNLDJ KC410M	S6, S11, S15
HNGJ0604ANSNHD KC522M	S7, S12, S16
HNGJ0604ANSNHD KCK15	S7, S12, S16
HNGJ0604ANSNHD KCPK30	S7, S12, S16
HNGJ0604ANSNHD KCPM40	S7, S12, S16
HNGJ0604ANSNHD KCSM40	S7, S12, S16
HNGJ090543ANSNHD KC520M	S19, S23
HNGJ090543ANSNHD KC725M	S19, S23
HNGJ090543ANSNHD KCK15	S19, S23
HNGJ090543ANSNHD KCPK30	S19, S23
HNGJ090543ANSNHD KCPM40	S19, S23
HNGJ090543ANSNHD KCSM40	S19, S23
HNGJ0905ANENLD KC520M	S18, S22
HNGJ0905ANENLD KC522M	S18, S22
HNGJ0905ANENLD KC725M	S18, S22
HNGJ0905ANENLD KCK15	S18, S22
HNGJ0905ANENLD KCPK30	S18, S22
HNGJ0905ANENLD KCSM40	S18, S22
HNGJ0905ANFNLDJ KC410M	S18, S22
HNGJ0905ANSNGD KC725M	S18, S23
HNGJ0905ANSNGD KCK15	S18, S23
HNGJ0905ANSNGD KCPK30	S18, S23
HNGJ0905ANSNGD KCPM40	S18, S23
HNGJ0905ANSNGD KCSM40	S18, S23
HNGJ0905ANSNHD KC520M	S19, S23
HNGJ0905ANSNHD KC725M	S19, S23
HNGJ0905ANSNHD KCK15	S19, S23
HNGJ0905ANSNHD KCPK30	S19, S23
HNGJ0905ANSNHD KCPM40	S19, S23
HNGJ0905ANSNHD KCSM40	S19, S23
HNGJ1307ANENGD KC725M	S26
HNGJ1307ANENGD KCPK30	S26
HNGJ1307ANENGD KCPM40	S26
HNGX090530MCI KCK15	S91, S97
HNHX090516ENLE KC514M	S90, S96
HNHX090516ENLE KCK15	S90, S96
HNHX090516SNGE KC514M	S91, S97
HNHX090516SNGE KCK15	S91, S97
HNHX090516SNGE KCPK30	S91
HNHX090520ENLE KC514M	S90, S96
HNHX090520ENLE KCK15	S90, S96
HNHX090520SNGE KC514M	S91, S97
HNHX090520SNGE KCK15	S91, S97
HNHX090530SNGE KCK15	S91, S97
HNHX0905ANSNGE KC514M	S90, S96
HNHX0905ANSNGE KCK15	S90, S96
HNPJ060432ANSNHD KC522M	S7, S13, S16
HNPJ060432ANSNHD KC725M	S7, S13, S16
HNPJ060432ANSNHD KCK15	S7, S13, S16
HNPJ060432ANSNHD KCPK30	S7, S13, S16
HNPJ060432ANSNHD KCPM40	S7, S13, S16
HNPJ060432ANSNHD KCSM40	S7, S13, S16
HNPJ0604ANSNGD KC520M	S7, S13, S16
HNPJ0604ANSNGD KC522M	S7, S13, S16
HNPJ0604ANSNGD KC725M	S7, S13, S16
HNPJ0604ANSNGD KCK15	S7, S13, S16
HNPJ0604ANSNGD KCPK30	S7, S13, S16
HNPJ0604ANSNGD KCPM40	S7, S13, S16
HNPJ0604ANSNGD KCSM40	S7, S13, S16
HNPJ0604ANSNHD KC520M	S7, S13, S16
HNPJ0604ANSNHD KC522M	S7, S13, S16
HNPJ0604ANSNHD KC725M	S7, S13, S16
HNPJ0604ANSNHD KCK15	S7, S13, S16
HNPJ0604ANSNHD KCPK30	S7, S13, S16
HNPJ0604ANSNHD KCPM40	S7, S13, S16
HNPJ0604ANSNHD KCSM40	S7, S13, S16
HNPJ090543ANSNHD KC522M	S19, S24
HNPJ090543ANSNHD KC725M	S19, S24
HNPJ090543ANSNHD KCK15	S19, S24
HNPJ090543ANSNHD KCPK30	S19, S24
HNPJ090543ANSNHD KCPM40	S19, S24
HNPJ090543ANSNHD KCSM40	S19, S24
HNPJ0905ANSNGD KC520M	S19, S23
HNPJ0905ANSNGD KC522M	S19, S23
HNPJ0905ANSNGD KC725M	S19, S23
HNPJ0905ANSNGD KCK15	S19, S23
HNPJ0905ANSNGD KCPK30	S19, S23
HNPJ0905ANSNGD KCPM40	S19, S23
HNPJ0905ANSNHD KC520M	S19, S24
HNPJ0905ANSNHD KC522M	S19, S24
HNPJ0905ANSNHD KC725M	S19, S24
HNPJ0905ANSNHD KCK15	S19, S24
HNPJ0905ANSNHD KCPK30	S19, S24
HNPJ0905ANSNHD KCPM40	S19, S24
HNPJ0905ANSNHD KCSM40	S19, S24
HNPJ130720ANSNGD KC520M	S26
HNPJ130720ANSNGD KC725M	S26
HNPJ130720ANSNGD KCPK30	S26
HNPJ130720ANSNHD KC725M	S27
HNPJ130720ANSNHD KCPK30	S27
HNPJ130720ANSNHD KCPM40	S27
HNPJ130735ANSNHD KC520M	S27
HNPJ130735ANSNHD KCK15	S27
HNPJ130735ANSNHD KCPK30	S27
HNPJ1307ANSNHD KC725M	S27
HNPJ1307ANSNHD KCK15	S27
HNPJ1307ANSNHD KCPK30	S27
HNPJ1307ANSNHD KCPM40	S27
HNPJ1307ANSNHD KCSM40	S27
HNPX090516SNGE KCK15	S91, S97
HNPX090520SNGE KCK15	S91, S97
HNPX090530SNGE KCK15	S91, S97
HSK100AHTS40085M	J81
HSK100AHTS50090M	J81
HSK100AKR32075M	K87
HSK100AKR50085M	K87
HSK100AKR63100M	K87
HSK100AKR80090M	K87
HSK100ASIF100070M	K46
HSK100ASIF70050M	K46
HSK100ASVUBB2124MCLB	K74
HSK100BT13075	K139
HSK63AAVS00B126MCLB	K79
HSK63AAVS0B143MCLB	K79
HSK63AAVS1B127MCLB	K79
HSK63AAVS2B139MCLB	K79
HSK63AAVS3B139MCLB	K79
HSK63ADL10048M	O52
HSK63ADL12052M	O52
HSK63ADL16057M	O52
HSK63ADL20057M	O52
HSK63ADL25061M	O52
HSK63ADL32072M	O52
HSK63AKR32075M	K87
HSK63AKR50080M	K87
HSK63ASIF70066M	K46
HSK63ASIF80063M	K46
HSK63ASVS4B139M	K80
HSK63ASVS5B139M	K80
HSK63ASVUBB1095MCLB	K72
HSK63ASVUBB2116MCLB	K74
HSK63FBHM1696	K128
HSK63FBHMKIT164M	K123, K127
HSK63FBHO1695	K124
HSK63FBHS24	K133
HSK63FBHS31	K133
HSK63FBHS40	K133
HSK63FBHS51	K133
HSK63FBHS67	K133
HSK63FBHS87	K133
HSK63RBHT24	K118
HSK63RBHT30	K118
HSK63RBHT40	K118
HSK63RBHT50	K118
HSK63RBHT66	K118
HSK63RBHT87	K118
HSK80ASIF70066M	K46
HTSR040R025M	J67
HTSR043R025M	J67
HTSR046R028M	J67
HTSR049R028M	J67
HTSR052R028M	J67
HTSR10CE	J67
HTSR10CI	J67
HTSR11CE	J67
HTSR11CI	J67
HTSR12CE	J67
HTSR12CI	J67
HTSR13CE	J67
HTSR13CI	J67
HTSR14CE	J67
HTSR14CI	J67
HUWTCL	E57
HUWTCR	E57
ICSN332 K9	B59, B62
ICSN432 K9	B61–63, B67–68, B70–72
ICSN433 K9	B58–60, B66
ICSN443 K9	B58–60
ICSN533 K9	B61–63, B66–67, B72
ICSN543 K9	B58–60
ICSN633 K9	B61–63, B67–68, B72
ICSN643 K9	B59–60
IDSN322 K9	B85–86, B89–90
IDSN432 K9	B86, B90–93
IDSN433 K9	B85, B89–90
IDSN533 K9	B91
IRSN43 K9	B95
ISSN332 K9	B109
ISSN432 K9	B109–110, B114–117, B119
ISSN433 K9	B105, B107–108, B110
ISSN443 K9	B105–107
ISSN533 K9	B108–109
ISSN543 K9	B105
ISSN633 K9	B108–110, B114–115, B119
ISSN643 K9	B105
ISSN846 K9	B105–106
ITSN322 K9	B133–134, B137, B139–141
ITSN323 K9	B132, B137
ITSN433 K9	B133–134, B139–141
ITSN443 K9	B132
IVSN322 K9	B149–153
IVSN432 K9	B151–152
IWSN322 K9	B161–162, B164
IWSN433 K9	B161–164
JICM-JICF-ELB	C75
JICM-JICM-STR	C75
KBDM063SD06	S126
KBDM080SD08	S126
KBDM100SD12	S126
KBDM125SD16	S126
KBDM160SD18	S126
KBDM200SD24	S126
KBDM250SD30	S126
KCFM080R08HD07W2	S110
KCFM100R08HD07W2	S110
KCFM125R10HD07W2	S110
KCFM160R12HD07W4	S110
KCFM200R16HD07W4	S110
KCFM250R24HD07W6	S110
KCFMCA45HD07	S111
KCFMCA45SD12C	S111
KCGR110304L08 K68	E29
KCGR110304L08 KC5010	E29
KCGR110304L08 KC5025	E29
KCGR110304L08 KCU10	E29
KCGR110304L08 KCU25	E29
KCGR110304L08 KT315	E29
KCGR110304L08FP KCM25	E29
KCGR110304L08FP KCP10	E29
KCGR110304L08FP KCP25	E29
KCGR110304L08FP KCU25	E29
KCGR110304R08 K68	E29
KCGR110304R08 KC5010	E29
KCGR110304R08 KC5025	E29
KCGR110304R08 KCU10	E29
KCGR110304R08 KCU25	E29
KCGR110304R08 KD1425	E29
KCGR110304R08 KT315	E29
KCGR110304R08FP KCM25	E29
KCGR110304R08FP KCP10	E29
KCGR110304R08FP KCP25	E29
KCGR110308L08 KC5025	E29
KCGR110308L08 KCM15B	E29
KCGR110308L08 KCU10	E29
KCGR110308L08 KCU25	E29
KCGR110308L08 KD1425	E29
KCGR110308L08FP KCP10	E29
KCGR110308L08FP KCP25	E29
KCGR110308R08 KCU10	E29
KCGR110308R08 KCU25	E29
KCGR110308R08 KT315	E29
KCGR110308R08FP KCP10	E29
KCGR110308R08FP KCU10	E29
KCGX110301L15 K313	E31
KCGX110301L15 K68	E31
KCGX110301L15 KC5010	E31
KCGX110301L15 KCU25	E31
KCGX110301L15 KD1425	E31
KCGX110301R15 K313	E31
KCGX110301R15 K68	E31
KCGX110301R15 KC5010	E31
KCGX110301R15 KC5025	E31
KCGX110301R15 KCU10	E31
KCGX110301R15 KD1425	E31
KCGX110302L15 K313	E31
KCGX110302L15 KCU10	E31
KCGX110302L15 KCU25	E31
KCGX110302L15 KD1425	E31
KCGX110302R15 K313	E31
KCGX110302R15 KC5010	E31
KCGX110302R15 KCU10	E31
KCGX110302R15 KCU25	E31
KCGX110302R15 KD1425	E31
KCGX110302R15 KT315	E31
KCGX110304L15 K313	E31
KCGX110304L15 K68	E31
KCGX110304L15 KC5010	E31
KCGX110304L15 KC5025	E31
KCGX110304L15 KCU10	E31
KCGX110304L15 KCU25	E31
KCGX110304L15 KD1425	E31
KCGX110304R15 K313	E31
KCGX110304R15 K68	E31
KCGX110304R15 KC5010	E31
KCGX110304R15 KC5025	E31
KCGX110304R15 KC5410	E31
KCGX110304R15 KCU10	E31

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
KCGX110304R15 KCU25	E31
KCGX110304R15 KD1425	E31
KCGX110304R15 KT315	E31
KCGX110308L15 K313	E31
KCGX110308L15 K68	E31
KCGX110308L15 KC5010	E31
KCGX110308L15 KCU25	E31
KCGX110308R15 K68	E31
KCGX110308R15 KC5010	E31
KCGX110308R15 KC5025	E31
KCGX110308R15 KCU10	E31
KCGX110308R15 KT315	E31
KCI1	V153–154
KCI2	V153–154
KCI3M	V153–154
KCRA40Z03A32RN12	V146
KCRA40Z04S22RN12	V147
KCRA50Z04S22RN12	V147
KCRA50Z06S22RN12	V147
KCRA63Z06S22RN12	V147
KCRA63Z09S22RN12	V147
KCRA80Z08S27RN12	V147
KCUX110302L15 K68	E32
KCUX110302L15 KC5010	E32
KCUX110302L15 KCU10	E32
KCUX110302R15 K68	E32
KCUX110302R15 KC5010	E32
KCUX110305L15 K68	E32
KCUX110305L15 KC5010	E32
KCUX110305L15 KCU10	E32
KCUX110305R15 K68	E32
KCUX110305R15 KC5010	E32
KCUX110305R15 KCP25B	E32
KCUX110305R15 KCU10	E32
KDMB06M0ERGN KC505M	V118
KDMB06M0ERGP KC505M	V118
KDMB06M0ERGP KC515M	V118
KDMB06M0ERLD K115M	V118
KDMB06R100A06HN	V114
KDMB06R150A06HN	V114
KDMB06R200A06HN	V114
KDMB06R90A08HN	V115
KDMB08M0ERGN KC505M	V118
KDMB08M0ERGN KC515M	V118
KDMB08M0ERGN KC530M	V118
KDMB08M0ERGP KC505M	V118
KDMB08M0ERGP KC515M	V118
KDMB08M0ERLD K115M	V118
KDMB08R100A08HN	V114
KDMB08R100A10HN	V115
KDMB08R140A08ST	V113
KDMB08R150A08HN	V114
KDMB08R150A10HN	V115
KDMB10M0ERGN KC505M	V118
KDMB10M0ERGN KC515M	V118
KDMB10M0ERGN KC530M	V118
KDMB10M0ERGP KC505M	V118
KDMB10M0ERGP KC515M	V118
KDMB10M0ERLD K115M	V118
KDMB10R100A12HNC	V115
KDMB10R120A10HNC	V114
KDMB10R150A10HNC	V114
KDMB10R150A10ST	V113
KDMB10R150A12HNC	V115
KDMB12M0ERGN KC505M	V118
KDMB12M0ERGN KC515M	V118
KDMB12M0ERGN KC530M	V118
KDMB12M0ERGP KC505M	V118
KDMB12M0ERGP KC515M	V118
KDMB12M0ERHC KC530M	V118
KDMB12M0ERLD K115M	V118
KDMB12R026M08SN	V111
KDMB12R120A12HNC	V114
KDMB12R120A16HNC	V115
KDMB12R130A12SN	V112
KDMB12R150A12SN	V112
KDMB12R150A16HNC	V115
KDMB12R160A12HNC	V114
KDMB12R160A12ST	V113
KDMB16M0ERGN KC505M	V118
KDMB16M0ERGN KC515M	V118
KDMB16M0ERGN KC530M	V118
KDMB16M0ERGP KC505M	V118
KDMB16M0ERGP KC515M	V118
KDMB16M0ERHC KC530M	V118
KDMB16M0ERLD K115M	V118
KDMB16R026M08SN	V111
KDMB16R140A16HNC	V114
KDMB16R140A16SN	V112
KDMB16R140A20HNC	V115
KDMB16R160A16SN	V112
KDMB16R175A16HNC	V114
KDMB16R175A16ST	V113
KDMB16R175A20HNC	V115
KDMB20M0ERGN KC505M	V118
KDMB20M0ERGN KC515M	V118
KDMB20M0ERGN KC530M	V118
KDMB20M0ERGP KC505M	V118
KDMB20M0ERGP KC515M	V118
KDMB20M0ERHC KC530M	V118
KDMB20M0ERLD K115M	V118
KDMB20R030M10SN	V111
KDMB20R140A20HNC	V114
KDMB20R160A20SN	V112
KDMB20R175A20SN	V112
KDMB20R190A20HNC	V114
KDMB20R190A20ST	V113
KDMB25M0ERGN KC505M	V118
KDMB25M0ERGN KC515M	V118
KDMB25M0ERGN KC530M	V118
KDMB25M0ERGP KC505M	V118
KDMB25M0ERGP KC515M	V118
KDMB25M0ERHC KC530M	V118
KDMB25M0ERLD K115M	V118
KDMB25R040M12SN	V111
KDMB25R160A25HNC	V114
KDMB25R160A25SN	V112
KDMB25R190A25SN	V112
KDMB25R210A25HNC	V114
KDMB25R210A25ST	V113
KDMB32M0ERGN KC505M	V118
KDMB32M0ERGN KC515M	V118
KDMB32M0ERGN KC530M	V118
KDMB32M0ERGP KC505M	V118
KDMB32M0ERGP KC515M	V118
KDMB32M0ERHC KC530M	V118
KDMB32M0ERLD K115M	V118
KDMB32R175A32SN	V112
KDMB32R210A32SN	V112
KDMB32R240A32HNC	V114
KDMS0806ERGN KC515M	V131
KDMS1008ERGN KC515M	V131
KDMS1210ERGN KC515M	V131
KDMS1613ERGN KC515M	V131
KDMS2016ERGN KC515M	V131
KDMS3220ERGN KC515M	V131
KDMT0604SRHF KC515M	V133
KDMT0605ERGC KC515M	V132
KDMT0806ERGN KC515M	V132
KDMT0806SRHF KC515M	V133
KDMT0810ERGC KC515M	V132
KDMT1008ERGN KC515M	V132
KDMT1008SRHF K115M	V133
KDMT1008SRHF KC515M	V133
KDMT1010ERGC KC515M	V132
KDMT1010ERHC KC505M	V133
KDMT10R120A10HNC	V130
KDMT10R150A10HNC	V130
KDMT1210ERGC KC515M	V132
KDMT1210ERGN KC515M	V132
KDMT1210ERHC KC505M	V133
KDMT1210SRHF K115M	V133
KDMT1210SRHF KC515M	V133
KDMT1220ERGN KC515M	V132
KDMT12R028M08SN	V128
KDMT12R120A12HNC	V130
KDMT12R130A12SN	V129
KDMT12R150A12SN	V129
KDMT12R160A12HNC	V130
KDMT1610ERGC KC515M	V132
KDMT1610ERGN KC515M	V132
KDMT1610ERHC KC505M	V133
KDMT1615SRHF K115M	V133
KDMT1615SRHF KC515M	V133
KDMT1630ERGN KC515M	V132
KDMT16R028M08SN	V128
KDMT16R140A16HNC	V130
KDMT16R140A16SN	V129
KDMT16R160A16SN	V129
KDMT16R175A16HNC	V130
KDMT2010ERGC KC515M	V132
KDMT2010ERGN KC515M	V132
KDMT2010ERHC KC505M	V133
KDMT2020SRHF K115M	V133
KDMT2020SRHF KC515M	V133
KDMT2040ERGN KC515M	V132
KDMT20R032M10SN	V128
KDMT20R140A20HNC	V130
KDMT20R160A20SN	V129
KDMT20R175A20SN	V129
KDMT20R190A20HNC	V130
KDMT2510ERGC KC515M	V132
KDMT2510ERGN KC515M	V132
KDMT25R190A25SN	V129
KDMT32R210A32SN	V129
KDR100Z06S32RN16	V60
KDR100Z07S32RN12	V56
KDR100Z08S32RN16	V60
KDR100Z09S32RN12	V56
KDR125Z08S40RN16	V60
KDR125Z10S40RN16	V60
KDR160Z12S40RN16	V60
KDR25Z03A25RN10L150	V48
KDR25Z03A25RN10L200	V48
KDR25Z03A32RN10L250	V48
KDR25Z03B25RN10	V47
KDR25Z03M12RN10	V46
KDR32Z02A32RN12L250	V55
KDR32Z03A32RN10L250	V48
KDR32Z03A32RN12L200	V55
KDR32Z03B32RN12	V54
KDR32Z03M16RN12	V53
KDR32Z04A32RN10L200	V48
KDR32Z04M16RN10	V46
KDR35Z03M16RN12	V53
KDR35Z05M16RN10	V46
KDR40Z04S16RN10	V49
KDR40Z04S16RN12	V56
KDR40Z04S16RN12X	V64
KDR40Z05M16RN10	V46
KDR40Z06S16RN10	V49
KDR42Z04M16RN12	V53
KDR50Z04S22RN12	V56
KDR50Z04S22RN16	V60
KDR50Z05S22RN10	V49
KDR50Z05S22RN12	V56
KDR50Z05S22RN12X	V64
KDR50Z06S22RN10	V49
KDR52Z04S22RN16	V60
KDR52Z05S22RN12	V56
KDR52Z06S22RN10	V49
KDR63Z04S22RN16	V60
KDR63Z05S22RN12	V56
KDR63Z06S22RN12X	V64
KDR63Z06S22RN16	V60
KDR63Z07S22RN10	V49
KDR63Z07S22RN12	V56
KDR66Z05S27RN16	V60
KDR66Z07S27RN10	V49
KDR66Z07S27RN12	V56
KDR80Z05S27RN16	V60
KDR80Z06S27RN12	V56
KDR80Z07S27RN12X	V64
KDR80Z07S27RN16	V60
KDR80Z08S27RN10	V49
KDR80Z08S27RN12	V56
KEGT25L508PEERLDJ KC410M	T82
KEGT25L512PEERLDJ KC410M	T82
KEGT25L516PEERLDJ KC410M	T82
KEGT25L516PEERLDJ2 KC410M	T83
KEGT25L520PEERLDJ KC410M	T82
KEGT25L531PEERLDJ KC410M	T82
KEGT25L540PEERLDJ KC410M	T82
KEGT25L550PEERLDJ KC410M	T82
KEGT25L564PEERLDJ KC410M	T82
KF2X25Z02A25W009L140	V39
KF2X25Z02A25W009L200	V39
KF2X25Z02A25W009L300	V39
KF2X25Z02M12W009	V38
KF2X28Z02A25W009L200	V39
KF2X32Z03A32W009L150	V39
KF2X32Z03A32W009L200	V39
KF2X32Z03A32W009L300	V39
KF2X32Z03M16W009	V38
KF2X35Z03A32W009L200	V39
KF2X35Z03M16W009	V38
KF2X40Z04W009	V40
KF2X42Z04M16W009	V38
KF2X50Z05W009	V40
KF2X52Z05W009	V40
KF2X63Z05S22W009	V40
KF2X63Z05W009	V40
KF2X66Z06S22W009	V40
KF2X66Z06W009	V40
KF2X80Z07W009	V40
KGEM1588R1WN20M	H76
KGEM1905R1WN20M	H76
KGEM1905R3WN20M	H76
KGIP0125N0189GD KCU45	H76
KGIP0300N0189GD KCU45	H76
KGMEL2525M50	C130
KGMEL2525M50C	C59
KGMEL2525M65	C130
KGMEL2525M65C	C59
KGMEL3232P50	C130
KGMEL3232P50C	C59
KGMEL3232P65	C130
KGMEL3232P65C	C59
KGMER2525M50	C130
KGMER2525M50C	C59
KGMER2525M65	C130
KGMER2525M65C	C59
KGMER3232P50	C130
KGMER3232P50C	C59
KGMER3232P65	C130
KGMER3232P65C	C59
KGMSL2525M50	C129
KGMSL2525M50C	C58
KGMSL2525M65	C129
KGMSL2525M65C	C58
KGMSL3232P50	C129
KGMSL3232P50C	C58
KGMSL3232P65	C129
KGMSL3232P65C	C58
KGMSR2525M50	C129
KGMSR2525M50C	C58
KGMSR2525M65	C129
KGMSR2525M65C	C58
KGMSR3232P50	C129
KGMSR3232P50C	C58
KGMSR3232P65	C129
KGMSR3232P65C	C58
KHDA0600A6ANA KC639M	P136
KHDA0800A6ANA KC639M	P136
KHDA1000A6ANA KC639M	P136
KHDA1200A6ANA KC639M	P136
KHDA1600A6ANA KC639M	P136
KHDA2000A6ANA KC639M	P136
KIPR016RP06CF02	V154
KIPR020RP06CF03	V154
KIPR020RP06MF03	V153
KIPR020RP09CF02	V154
KIPR020RP09MF02	V153
KIPR025RP09CF03	V154
KIPR025RP09MF03	V153
KIPR032RP12CF03	V154
KIPR032RP12MF03	V153
KIPR040RP12CF04	V154
KLM33	B62, B67, B70, B115–119
KLM33L	B90, B92, B139–141, B164
KLM34L	B62, B86, B90, B109, B133–134, B137, B139–141, B151–153, B162, B164
KLM34L9IP	B59, B85, B132, B149–150, B161
KLM43	B67, B70–72, B115–119, B164
KLM46	B61–63, B67–68, B70, B72, B92–93, B95, B108–110, B114, B133–134, B139–141, B151–152, B162, B164

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
KLM4615IP	B58–60, B105, B107, B161
KLM46L	B86, B90–91
KLM46L15IP	B58–60, B85, B105–107, B132
KLM46S	B70–72, B92–93, B115–117, B119
KLM54	B115–117, B119
KLM58	B61–63, B67, B72, B91, B108–109
KLM58L15IP	B58–60, B105
KLM68	B61–63, B67–68, B72, B108–110, B114–115, B119
KLM68L25IP	B59–60, B105
KLM81025IP	B105–106
KLSSM22-39-CG	S14, S21, S32, S34, V21, V28, V40, V147
KM25LSEL1630	D83
KM25LSER1630	D83
KM25LSSL1630	D83
KM25LSSL2230	D83
KM25LSSR1630	D83
KM25LSSR2230	D83
KM25NEL330	D30
KM25NEL430	D30
KM25NER230	D30
KM25NER330	D30
KM25NER430	D30
KM25NSL230	D30
KM25NSL330	D30
KM25NSL430	D30
KM25NSR230	D30
KM25NSR330	D30
KM32FBHS24	K133
KM32FBHS31	K133
KM32RBHT24	K118
KM32RBHT30	K118
KM40FBHO1660	K124
KM40FBHS40	K133
KM40RBHT40	K118
KM40TSAVS00B111MCLB	K78
KM40TSAVS0B128MCLB	K78
KM40TSAVS1B112MCLB	K78
KM40TSAVS2B127MCLB	K78
KM40TSE16JNEL2 KWH	D40
KM40TSE16JNER2 KWH	D40
KM40TSKGMEL50C	C61, C132
KM40TSKGMER50C	C61, C132
KM40TSKGMSL50C	C60, C131
KM40TSKGMSR50C	C60, C131
KM40TSLSEL16N	D85
KM40TSLSER16N	D85
KM40TSLSER22N	D85
KM40TSLSER27N	D85
KM40TSLSSL16	D84
KM40TSLSSL22	D84
KM40TSLSSL27	D84
KM40TSLSSR16	D84
KM40TSLSSR22	D84
KM40TSLSSR27	D84
KM40TSNEL2	D31
KM40TSNEL3	D31
KM40TSNEL4	D31
KM40TSNER2	D31
KM40TSNER3	D31
KM40TSNER4	D31
KM40TSNRL3045M	D33
KM40TSNRR3045M	D33
KM40TSNSL2	D33
KM40TSNSL3	D33
KM40TSNSL4	D33
KM40TSNSR2	D33
KM40TSNSR3	D33
KM40TSNSR4	D33
KM40TSS10DLSEL11	D86
KM40TSS10DLSER11	D86
KM40TSS12ELSEL11	D86
KM40TSS12ELSER11	D86
KM40TSS12ENEL2	D38–39
KM40TSS12ENER2	D38–39
KM40TSS16FLSER16	D86
KM40TSS16FNEL2	D38–39
KM40TSS16FNER2	D38–39
KM40TSS20GLSEL16	D86
KM40TSS20GLSER16	D86
KM40TSS20GNEL2	D38–39
KM40TSS20GNER2	D38–39
KM40TSS25ENEL2	D38–39
KM40TSS25ENEL3	D38–39
KM40TSS25ENER2	D38–39
KM40TSS25ENER3	D38–39
KM40TSS25HLSEL16	D86
KM40TSS25HLSER16	D86
KM40TSS25HNEL3	D38–39
KM40TSS25HNER2	D38–39
KM40TSS25HNER3	D38–39
KM40TSS32GNEL3	D38–39
KM40TSS32GNER3	D38–39
KM40TSS32JLSEL16	D86
KM40TSS32JLSEL22	D86
KM40TSS32JLSER16	D86
KM40TSS32JLSER22	D86
KM40TSS32JNER3	D38–39
KM4X100NEL3	D32
KM4X100NEL4	D32
KM4X100NEL5	D32
KM4X100NEL6	D32
KM4X100NER3	D32
KM4X100NER4	D32
KM4X100NER5	D32
KM4X100NER6	D32
KM4X63KGMEL50C	C63, C133
KM4X63KGMEL65C	C63, C133
KM4X63KGMER50C	C63, C133
KM4X63KGMER65C	C63, C133
KM4X63KGMSL50C	C62–63, C133
KM4X63KGMSL65C	C62, C133
KM4X63KGMSR50C	C62–63, C133
KM4X63KGMSR65C	C62, C133
KM50FBHO1670	K124
KM50FBHS51	K133
KM50FBHS67	K133
KM50FBHS87	K133
KM50RBHT50	K118
KM50RBHT66	K118
KM50RBHT87	K118
KM50SVS4B125M	K80
KM50SVS5B125M	K80
KM50TSAVS00B117MCLB	K78
KM50TSAVS0B134MCLB	K78
KM50TSAVS1B118MCLB	K78
KM50TSAVS2B128MCLB	K78
KM50TSAVS3B128MCLB	K78
KM50TSFBHM1677	K128
KM50TSFBHMKIT164M	K123, K127
KM50TSKGMEL50C	C61, C132
KM50TSKGMEL65C	C61, C132
KM50TSKGMER50C	C61, C132
KM50TSKGMER65C	C61, C132
KM50TSKGMSL50C	C60, C131
KM50TSKGMSL65C	C60, C131
KM50TSKGMSR50C	C60, C131
KM50TSKGMSR65C	C60, C131
KM50TSSVUBB2100MCLB	K73
KM63BT13065	K137
KM63SVS4B110M	K80
KM63SVS5B110M	K80
KM63TSAVS3B130MCLB	K78
KM63TSKGMEL50C	C61, C132
KM63TSKGMEL65C	C61, C132
KM63TSKGMER50C	C61, C132
KM63TSKGMER65C	C61, C132
KM63TSKGMSL50C	C60, C131
KM63TSKGMSL65C	C60, C131
KM63TSKGMSR50C	C60, C131
KM63TSKGMSR65C	C60, C131
KM63UTFBHS116	K133
KM63UTFBHS87	K133
KM63UTRBHT115	K118
KM63UTRBHT87	K118
KM63XMZKGMELF50CY	C61, C132
KM63XMZKGMELF65CY	C61, C132
KM63XMZKGMER50CY	C61, C132
KM63XMZKGMER65CY	C61, C132
KM63XMZKGMSLF50CY	C60, C131
KM63XMZKGMSR50CY	C60, C131
KM63XMZKR5060Y	K87
KM80ATCKGMEL50C	C61, C132
KM80ATCKGMEL65C	C61, C132
KM80ATCKGMER50C	C61, C132
KM80ATCKGMER65C	C61, C132
KM80ATCKGMSL50C	C60, C131
KM80ATCKGMSR50C	C60, C131
KM80BT13070	K137
KM80SVS6B150M	K80
KM80TSKGMEL50C	C61, C132
KM80TSKGMEL65C	C61, C132
KM80TSKGMER50C	C61, C132
KM80TSKGMER65C	C61, C132
KM80TSKGMSL50C	C60, C131
KM80TSKGMSL65C	C60, C131
KM80TSKGMSR50C	C60, C131
KM80TSKGMSR65C	C60, C131
KMDA0600A6ANA KC639M	P137
KMDA0800A6ANA KC639M	P137
KMDA1000A6ANA KC639M	P137
KMDA1200A6ANA KC639M	P137
KMDA1600A6ANA KC639M	P137
KMDA2000A6ANA KC639M	P137
KMSP315IP	B59, B85, B89–90, B132, B137, B149–150, B152, B161
KMSP415IP	B58–60, B66, B85, B89–90, B105–107, B132, B161, B163
KMSP515IP	B58–60, B66, B105
KMSP625IP	B59–60, B105
KMSP825IP	B105–106
KNGX150401R15 K68	E30
KNGX150401R15 KCU10	E30
KNGX150402R15 KCU10	E30
KNGX150404L20 KC5010	E30
KNGX150404L20 KCU25	E30
KNGX150404R20 KC5010	E30
KNGX150404R20 KCU25	E30
KNGX150408L20 K68	E30
KNGX150408L20 KC5010	E30
KNGX150408L20 KCU25	E30
KNGX150408R20 KC5010	E30
KNGX150408R20 KCU10	E30
KNGX150408R20 KCU25	E30
KNGX220404R25 KCU25	E30
KNGX220408L20 KCU10	E30
KNGX220408R32 KCU10	E30
KNUX150405L25 K68	E31
KNUX150405L25 KCU10	E31
KNUX150405R20 KC5010	E31
KNUX150405R20 KCP25B	E32
KNUX150405R20 KCU10	E31
KNUX150405R25 K68	E31
KNUX150405R25 KCP25B	E31
KNUX150410L25 K68	E31
KNUX150410L25 KCU10	E31
KNUX150410R25 K68	E31
KNUX150410R25 KCU10	E31
KNUX160405L1 KCM15B	E31
KNUX160405L1 KCM25B	E31
KNUX160405L2 KU10	E31
KNUX160405R1 KCM15B	E31
KNUX160405R1 KCM25B	E31
KNUX160405R1 KCU25	E31
KNUX160405R2 KCM25B	E31
KNUX160410R1 KCM25B	E31
KNUX160410R2 KCM25B	E31
KR32AVS00B099MCLB	K78
KR32AVS0B116MCLB	K78
KR32AVS1B100MCLB	K78
KR32AVS2B115MCLB	K78
KR32AVS3B115MCLB	K78
KR32KR32038050M	K88
KR32KR32038100M	K88
KR32KR32047050M	K88
KR32KR32047100M	K88
KR32SVUBB1060MCLB	K72
KR32SVUBB2085MCLB	K73
KR50KR50065050M	K88
KR50KR50065100M	K88
KR50SVS4B094M	K79
KR50SVS5B094M	K79
KR50SVU65110MCLB	K84
KR50SVUBB2075MCLB	K73
KR63KR63085050M	K88
KR63KR63085100M	K88
KR63SVS6B126M	K79
KR80KR80095050M	K88
KR80KR80095100M	K88
KR80SVU92152MCLB	K84
KRBB10FABDRS204C	K74, K96
KRBB10SCFPR06085C	K74, K96
KRBB10SCFPR06110C	K74, K97
KRBB10SCFPR06135C	K74, K97
KRBB10SCLDR4060C	K74, K96
KRBB16SCFPR06085A	K75, K98
KRBB16SCFPR0611A	K75, K98
KRBB16SCFPR06135A	K75, K98
KRBB16SCFPR0616A	K75, K99
KRBB16SCFPR0619A	K75, K99
KRBB16SCFPR0622A	K75, K99
KRBB16SCLDRS406A	K75, K98
KRCSCFPR061A	K82
KRCSCFPR061B	K82
KRCSCFPR061C	K82
KRCSCFPR061D	K82
KRCSCFPR061E	K85, K104–105
KRCSCFPR061F	K85, K106–110
KRCSCFPR061L	K82
KRCSCFPR061W	K81
KRCSCFPR061X	K81
KRCSCFPR061Y	K81
KRCSCFPR062A	K82
KRCSCFPR062B	K82
KRCSCFPR062C	K82
KRCSCFPR062D	K82
KRCSCFPR062E	K85, K104–105
KRCSCFPR062F	K85, K106–110
KRCSCFPR062L	K82
KRCSCFPR062W	K81
KRCSCFPR062X	K81
KRCSCFPR062Y	K81
KRCSCFPR063A	K82
KRCSCFPR063B	K82
KRCSCFPR063C	K82
KRCSCFPR063D	K82
KRCSCFPR063E	K85, K104–105
KRCSCFPR063F	K85, K106–110
KRCSCFPR063L	K82
KRCSCFPR063W	K81
KRCSCFPR063X	K81
KRCSCFPR063Y	K81
KRCSTFPR113F	K85
KRCW032A	K76
KRDCKR32M	K86–88
KRDCKR50M	K86–88
KRDCKR63M	K86–88
KRDCKR80M	K86–88
KRDE025010M	K76
KRDE033010M	K76
KRDE043010M	K76
KRDE065012M	K76
KRDE070019M	K85, K104
KRDE083019M	K85, K104–105
KRDE096019M	K85, K105
KRDE101023M	K85, K106
KRDE120023M	K85, K106–107
KRDE139026M	K85, K107
KRDE156026M	K85, K108
KRDE175026M	K85, K109
KRDE193026M	K85, K110
KRDEA012AM	K75
KRDEA046AM	K75
KRDEA051AM	K75
KRM018030CLB004NE	K89
KSCM100R12CAB32	S132
KSCM125R16CAB40	S132
KSCM160R18CAB40	S132
KSCM200R24CAB60	S132
KSCM250R30CAB60	S132
KSCM63R08CAH63A090	S131
KSCM80R10CAB27	S132
KSCMA90QFBF KD1400	S134
KSCMA90QFBF KD1420	S134
KSCMA90UNBF KD1400	S134
KSCMA90UNBF KD1420	S134
KSCMCA75PT KD1420	S133

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
KSCMCA75QF KD1420	S133
KSCMCA75UN KD1420	S133
KSCMCA90QF KD1420	S134
KSCMCA90QFBF KD1420	S134
KSCMCA90UN KD1420	S134
KSCMCA90UNBF KD1420	S134
KSDR100031E0W0S KD1400	S127
KSDR100031E0W0S KD1425	S127
KSDR100031E0W4S KD1400	S127
KSDR100031E0W4S KD1425	S127
KSDR100031E1W4S KD1400	S127
KSDR100031E1W4S KD1425	S127
KSDR100031E3W4S KD1400	S128
KSDR100031E3W4S KD1425	S128
KSDR100093E1W4S KD1400	S127
KSDR100093E1W4S KD1425	S127
KSDR102S KD1400	S128
KSDR102S KD1425	S128
KSEM1250HPCCLM KC7410	H48
KSEM1250HPGM KC7315	H42
KSEM1250HPGM KCPM45	H45
KSEM1250HPLM KC7320	H50
KSEM1250HPM KC7315	H40
KSEM1250PCM KC7135	H56
KSEM1250SPLM KCMS35	H52
KSEM125R10WN16M	H61
KSEM125R1WN16F45M	H63
KSEM125R1WN16M	H58
KSEM125R3WN16M	H59
KSEM125R5WN16M	H59
KSEM125R7WN16M	H61
KSEM125SEFM	H64
KSEM1260HPGM KC7315	H42
KSEM1270HPCCLM KC7410	H48
KSEM1270HPGM KC7315	H42
KSEM1270HPGM KCPM45	H45
KSEM1270HPLM KC7320	H50
KSEM1270HPM KC7315	H40
KSEM1270SPLM KCMS35	H52
KSEM1280HPGM KC7315	H42
KSEM1280HPGM KCPM45	H45
KSEM1280HPLM KC7320	H50
KSEM1280HPM KC7315	H40
KSEM1280PCM KC7135	H56
KSEM1293HPCCLM KC7410	H48
KSEM1293HPGM KC7315	H42
KSEM1293HPGM KCPM45	H45
KSEM1293HPLM KC7320	H50
KSEM1300HPCCLM KC7410	H48, H87
KSEM1300HPGM KC7315	H42
KSEM1300HPGM KCPM45	H45
KSEM1300HPLM KC7320	H50
KSEM1300HPM KC7315	H40
KSEM1300PCM KC7135	H56, H87
KSEM1300SPLM KCMS35	H52
KSEM130R10WN16M	H61
KSEM130R3WN16M	H59
KSEM130R5WN16M	H59
KSEM130R7WN16M	H61
KSEM130SEFM	H64
KSEM1310HPCCLM KC7410	H48
KSEM1310HPGM KC7315	H42
KSEM1310HPM KC7315	H40
KSEM1311HPLM KC7320	H50
KSEM1320HPGM KC7315	H42
KSEM1320HPM KC7315	H40
KSEM1350HPCCLM KC7410	H48
KSEM1350HPGM KC7315	H42
KSEM1350HPGM KCPM45	H45
KSEM1350HPLM KC7320	H50
KSEM1350HPM KC7315	H40
KSEM1350PCM KC7135	H56
KSEM1350SPLM KCMS35	H52
KSEM135R10WN16M	H61
KSEM135R3WN16M	H59
KSEM135R5WN16M	H59
KSEM135R7WN16M	H61
KSEM135SEFM	H64
KSEM1360HPGM KC7315	H42
KSEM1360HPGM KCPM45	H45
KSEM1360HPLM KC7320	H50
KSEM136R10WN16M	H61
KSEM136R1WN16F45M	H63
KSEM136R1WN16M	H58
KSEM136R3WN16M	H59
KSEM136R5WN16M	H59
KSEM136R7WN16M	H61
KSEM1370HPGM KC7315	H42
KSEM1370HPM KC7315	H40
KSEM1380HPGM KC7315	H42
KSEM1380HPGM KCPM45	H45
KSEM1380HPLM KC7320	H50
KSEM1380HPM KC7315	H40
KSEM1380PCM KC7135	H56
KSEM1389HPCCLM KC7410	H48
KSEM1389HPGM KC7315	H42
KSEM1389HPGM KCPM45	H45
KSEM1389HPLM KC7320	H50
KSEM1389HPM KC7315	H40
KSEM1400HPCCLM KC7410	H48, H87
KSEM1400HPGM KC7315	H42
KSEM1400HPGM KCPM45	H45
KSEM1400HPLM KC7320	H50
KSEM1400HPM KC7315	H40
KSEM1400PCM KC7135	H56, H87
KSEM1400SPLM KCMS35	H52
KSEM140R10WN16M	H61
KSEM140R3WN16M	H59
KSEM140R5WN16M	H59
KSEM140R7WN16M	H61
KSEM140SEFM	H64
KSEM1410HPGM KC7315	H42
KSEM1410HPGM KCPM45	H45
KSEM1410HPLM KC7320	H50
KSEM1410HPM KC7315	H40
KSEM1410PCM KC7135	H56
KSEM1415HPLM KC7320	H50
KSEM1420HPGM KC7315	H42
KSEM1420HPLM KC7320	H50
KSEM1420HPM KC7315	H40
KSEM1429HPCCLM KC7410	H48
KSEM1429HPGM KC7315	H42
KSEM1429HPGM KCPM45	H45
KSEM1429HPLM KC7320	H50
KSEM1429HPM KC7315	H40
KSEM1429SPLM KCMS35	H52
KSEM1440HPGM KC7315	H42
KSEM1440HPM KC7315	H40
KSEM1450HPCCLM KC7410	H48
KSEM1450HPGM KC7315	H42
KSEM1450HPGM KCPM45	H45
KSEM1450HPLM KC7320	H50
KSEM1450HPM KC7315	H40
KSEM1450PCM KC7135	H56
KSEM1450SPLM KCMS35	H52
KSEM145R10WN20M	H61
KSEM145R3WN20M	H59
KSEM145R5WN20M	H59
KSEM145R7WN20M	H61
KSEM145SEFM	H64
KSEM1460HPGM KC7315	H42
KSEM1460HPLM KC7320	H50
KSEM1460PCM KC7135	H56
KSEM1468HPCCLM KC7410	H48
KSEM1468HPGM KC7315	H42
KSEM1468HPGM KCPM45	H45
KSEM1468HPLM KC7320	H50
KSEM1468HPM KC7315	H40
KSEM146R10WN20M	H61
KSEM146R1WN20F45M	H63
KSEM146R1WN20M	H58
KSEM146R3WN20M	H59
KSEM146R5WN20M	H59
KSEM146R7WN20M	H61
KSEM1480HPGM KC7315	H42
KSEM1480HPLM KC7320	H50
KSEM1480HPM KC7315	H40
KSEM1480PCM KC7135	H56
KSEM1500HPCCLM KC7410	H48, H87
KSEM1500HPGM KC7315	H42
KSEM1500HPGM KCPM45	H45
KSEM1500HPLM KC7320	H50
KSEM1500HPM KC7315	H40
KSEM1500PCM KC7135	H56, H87
KSEM1500SPLM KCMS35	H52
KSEM1508HPGM KC7315	H42
KSEM1508HPGM KCPM45	H45
KSEM1508HPLM KC7320	H50
KSEM1508HPM KC7315	H40
KSEM150R10WN20M	H61
KSEM150R3WN20M	H59
KSEM150R5WN20M	H59
KSEM150R7WN20M	H61
KSEM150SEFM	H64
KSEM1530HPGM KC7315	H42
KSEM1530HPM KC7315	H40
KSEM1548HPCCLM KC7410	H48
KSEM1548HPGM KC7315	H42
KSEM1548HPLM KC7320	H50
KSEM1550HPCCLM KC7410	H48
KSEM1550HPGM KC7315	H42
KSEM1550HPGM KCPM45	H45
KSEM1550HPLM KC7320	H50
KSEM1550HPM KC7315	H40
KSEM1550PCM KC7135	H56
KSEM1550SPLM KCMS35	H52
KSEM155R10WN20M	H61
KSEM155R3WN20M	H59
KSEM155R5WN20M	H59
KSEM155R7WN20M	H61
KSEM155SEFM	H64
KSEM1560HPGM KC7315	H42
KSEM1560HPLM KC7320	H50
KSEM1560HPM KC7315	H40
KSEM1560PCM KC7135	H56
KSEM1570HPGM KC7315	H42
KSEM1570HPM KC7315	H40
KSEM1580HPGM KC7315	H42
KSEM1580HPGM KCPM45	H45
KSEM1580HPM KC7315	H40
KSEM1580PCM KC7135	H56
KSEM1588HPCCLM KC7410	H48
KSEM1588HPGM KC7315	H42
KSEM1588HPGM KCPM45	H45
KSEM1588HPLM KC7320	H50
KSEM1588HPM KC7315	H40
KSEM1588SPLM KCMS35	H52
KSEM1600FEGM KCPM45	H54
KSEM1600HPCCLM KC7410	H48, H87
KSEM1600HPGM KC7315	H42
KSEM1600HPGM KCPM45	H45
KSEM1600HPLM KC7320	H50
KSEM1600HPM KC7315	H40
KSEM1600PCM KC7135	H56, H87
KSEM1600SPLM KCMS35	H52
KSEM1604HPGM KC7315	H42
KSEM1609HPCCLM KC7410	H48
KSEM1609HPGM KC7315	H42
KSEM1609HPGM KCPM45	H45
KSEM1609HPLM KC7320	H50
KSEM1609HPM KC7315	H40
KSEM1609SPLM KCMS35	H52
KSEM160R10WN20M	H61
KSEM160R1WN20F45M	H63
KSEM160R1WN20M	H58
KSEM160R3WN20M	H59
KSEM160R5WN20M	H59
KSEM160R7WN20M	H61
KSEM160SEFM	H64
KSEM1610HPLM KC7320	H50
KSEM1615HPLM KC7320	H50
KSEM1615SPLM KCMS35	H52
KSEM1619HPGM KC7315	H42
KSEM1620HPGM KC7315	H42
KSEM1620HPGM KCPM45	H45
KSEM1620HPLM KC7320	H50
KSEM1620HPM KC7315	H40
KSEM1620PCM KC7135	H56
KSEM1627HPCCLM KC7410	H48
KSEM1627HPGM KC7315	H42
KSEM1627HPGM KCPM45	H45
KSEM1627HPLM KC7320	H50
KSEM1627HPM KC7315	H40
KSEM1627SPLM KCMS35	H52
KSEM1650FEGM KCPM45	H54
KSEM1650HPCCLM KC7410	H48
KSEM1650HPGM KC7315	H42
KSEM1650HPGM KCPM45	H45
KSEM1650HPLM KC7320	H50
KSEM1650HPM KC7315	H40
KSEM1650PCM KC7135	H56
KSEM1650SPLM KCMS35	H52
KSEM165R10WN20M	H61
KSEM165R3WN20M	H59
KSEM165R5WN20M	H59
KSEM165R7WN20M	H61
KSEM165SEFM	H64
KSEM1660HPGM KC7315	H42
KSEM1667HPCCLM KC7410	H48
KSEM1667HPGM KC7315	H42
KSEM1667HPGM KCPM45	H45
KSEM1667HPLM KC7320	H50
KSEM1667HPM KC7315	H40
KSEM1667SPLM KCMS35	H52
KSEM1700FEGM KCPM45	H54
KSEM1700HPCCLM KC7410	H48, H87
KSEM1700HPGM KC7315	H42
KSEM1700HPGM KCPM45	H45
KSEM1700HPLM KC7320	H50
KSEM1700HPM KC7315	H40
KSEM1700PCM KC7135	H56, H87
KSEM1700SPLM KCMS35	H52
KSEM1707HPCCLM KC7410	H48
KSEM1707HPGM KC7315	H42
KSEM1707HPGM KCPM45	H45
KSEM1707HPLM KC7320	H50
KSEM1707HPM KC7315	H40
KSEM170R10WN20M	H61
KSEM170R3WN20M	H59
KSEM170R5WN20M	H59
KSEM170R7WN20M	H61
KSEM170SEFM	H64
KSEM1735HPGM KC7315	H42
KSEM1746HPCCLM KC7410	H48
KSEM1746HPGM KC7315	H42
KSEM1746HPGM KCPM45	H45
KSEM1746HPLM KC7320	H50
KSEM1746HPM KC7315	H40
KSEM1746SPLM KCMS35	H52
KSEM1750FEGM KCPM45	H54
KSEM1750HPCCLM KC7410	H48
KSEM1750HPGM KC7315	H42
KSEM1750HPGM KCPM45	H45
KSEM1750HPLM KC7320	H50
KSEM1750HPM KC7315	H40
KSEM1750PCM KC7135	H56
KSEM1750SPLM KCMS35	H52
KSEM175R10WN20M	H61
KSEM175R3WN20M	H59
KSEM175R5WN20M	H59
KSEM175R7WN20M	H61
KSEM175SEFM	H64
KSEM1760HPCCLM KC7410	H48
KSEM1760HPGM KC7315	H42
KSEM1770HPGM KC7315	H42
KSEM1775HPLM KC7320	H50
KSEM1780HPLM KC7320	H50
KSEM1786HPGM KC7315	H42
KSEM1786HPGM KCPM45	H45
KSEM1786HPLM KC7320	H50
KSEM1786HPM KC7315	H40
KSEM1790HPLM KC7320	H50
KSEM1800FEGM KCPM45	H54
KSEM1800HPCCLM KC7410	H48, H87
KSEM1800HPGM KC7315	H42
KSEM1800HPGM KCPM45	H45
KSEM1800HPLM KC7320	H50
KSEM1800HPM KC7315	H40
KSEM1800PCM KC7135	H56, H87
KSEM1800SPLM KCMS35	H52
KSEM180R10WN20M	H61
KSEM180R3WN20M	H59
KSEM180R5WN20M	H59
KSEM180R7WN20M	H61
KSEM180SEFM	H64
KSEM181R10WN25M	H61
KSEM181R1WN25F45M	H63
KSEM181R1WN25M	H58

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
KSEM181R5WN25M	H59
KSEM1826HPCCLM KC7410	H48
KSEM1826HPGM KC7315	H42
KSEM1826HPGM KCPM45	H45
KSEM1826HPLM KC7320	H50
KSEM1826HPM KC7315	H40
KSEM1830SPLM KCMS35	H52
KSEM1850FEGM KCPM45	H54
KSEM1850HPCCLM KC7410	H48
KSEM1850HPGM KC7315	H42
KSEM1850HPGM KCPM45	H45
KSEM1850HPLM KC7320	H50
KSEM1850HPM KC7315	H40
KSEM1850PCM KC7135	H56
KSEM1850SPLM KCMS35	H52
KSEM185R10WN25M	H61
KSEM185R3WN25M	H59
KSEM185R5WN25M	H59
KSEM185R7WN25M	H61
KSEM185SEFM	H64
KSEM1860HPGM KC7315	H42
KSEM1860HPLM KC7320	H50
KSEM1865HPGM KC7315	H42
KSEM1865HPGM KCPM45	H45
KSEM1865HPLM KC7320	H50
KSEM1865HPM KC7315	H40
KSEM1880HPGM KC7315	H42
KSEM1890HPLM KC7320	H50
KSEM1900FEGM KCPM45	H54
KSEM1900HPCCLM KC7410	H48, H87
KSEM1900HPGM KC7315	H42
KSEM1900HPGM KCPM45	H45
KSEM1900HPLM KC7320	H50
KSEM1900HPM KC7315	H40
KSEM1900PCM KC7135	H56, H87
KSEM1900SPLM KCMS35	H52
KSEM1905FEGM KCPM45	H54
KSEM1905HPCCLM KC7410	H48
KSEM1905HPGM KC7315	H42
KSEM1905HPGM KCPM45	H45
KSEM1905HPLM KC7320	H50
KSEM1905HPM KC7315	H40
KSEM1905SPLM KCMS35	H52
KSEM190R10WN25M	H61
KSEM190R3WN25M	H59
KSEM190R5WN25M	H59
KSEM190R7WN25M	H61
KSEM190SEFM	H64
KSEM1920HPGM KCPM45	H45
KSEM1920HPLM KC7320	H50
KSEM1920SPLM KCMS35	H52
KSEM1923HPGM KCPM45	H45
KSEM1923HPLM KC7320	H50
KSEM1923HPM KC7315	H40
KSEM1923SPLM KCMS35	H52
KSEM1925HPGM KC7315	H42
KSEM1925HPGM KCPM45	H45
KSEM1925HPLM KC7320	H50
KSEM1925SPLM KCMS35	H52
KSEM1927HPCCLM KC7410	H48
KSEM1927HPGM KC7315	H42
KSEM1927HPGM KCPM45	H45
KSEM1927HPLM KC7320	H50
KSEM1927HPM KC7315	H40
KSEM1927SPLM KCMS35	H52
KSEM1932HPGM KC7315	H42
KSEM1935HPGM KC7315	H42
KSEM1935HPLM KC7320	H50
KSEM1935SPLM KCMS35	H52
KSEM1936HPLM KC7320	H50
KSEM1938HPLM KC7320	H50
KSEM1945HPCCLM KC7410	H48
KSEM1945HPGM KC7315	H42
KSEM1945HPGM KCPM45	H45
KSEM1945HPLM KC7320	H50
KSEM1945HPM KC7315	H40
KSEM1945SPLM KCMS35	H52
KSEM1950FEGM KCPM45	H54
KSEM1950HPCCLM KC7410	H48
KSEM1950HPGM KC7315	H42
KSEM1950HPGM KCPM45	H45
KSEM1950HPLM KC7320	H50
KSEM1950HPM KC7315	H40
KSEM1950PCM KC7135	H56
KSEM1950SPLM KCMS35	H52
KSEM195R10WN25M	H61
KSEM195R3WN25M	H59
KSEM195R5WN25M	H59
KSEM195R7WN25M	H61
KSEM195SEFM	H64
KSEM1965HPGM KCPM45	H45
KSEM1970HPGM KC7315	H42
KSEM1984FEGM KCPM45	H54
KSEM1984HPCCLM KC7410	H48
KSEM1984HPGM KC7315	H42
KSEM1984HPGM KCPM45	H45
KSEM1984HPLM KC7320	H50
KSEM1984HPM KC7315	H40
KSEM1984SPLM KCMS35	H52
KSEM2000FEGM KCPM45	H54
KSEM2000HPCCLM KC7410	H48, H87
KSEM2000HPGM KC7315	H42
KSEM2000HPGM KCPM45	H45
KSEM2000HPLM KC7320	H50
KSEM2000HPM KC7315	H40
KSEM2000PCM KC7135	H56, H87
KSEM2000SPLM KCMS35	H52
KSEM200R10WN25M	H61
KSEM200R1WN25F45M	H63
KSEM200R1WN25M	H58
KSEM200R3WN25M	H59
KSEM200R5WN25M	H59
KSEM200R7WN25M	H61
KSEM200SEFM	H64
KSEM2010HPLM KC7320	H50
KSEM2024HPCCLM KC7410	H48
KSEM2024HPGM KC7315	H42
KSEM2024HPGM KCPM45	H45
KSEM2024HPLM KC7320	H50
KSEM2024HPM KC7315	H40
KSEM2024SPLM KCMS35	H52
KSEM2035HPLM KC7320	H50
KSEM2050FEGM KCPM45	H54
KSEM2050HPCCLM KC7410	H48
KSEM2050HPGM KC7315	H42
KSEM2050HPGM KCPM45	H45
KSEM2050HPLM KC7320	H50
KSEM2050HPM KC7315	H40
KSEM2050PCM KC7135	H56
KSEM2050SPLM KCMS35	H52
KSEM205R10WN25M	H61
KSEM205R3WN25M	H59
KSEM205R5WN25M	H59
KSEM205R7WN25M	H61
KSEM205SEFM	H64
KSEM2064HPCCLM KC7410	H48
KSEM2064HPGM KC7315	H42
KSEM2064HPGM KCPM45	H45
KSEM2064HPLM KC7320	H50
KSEM2064HPM KC7315	H40
KSEM2064SPLM KCMS35	H52
KSEM2070HPGM KC7315	H42
KSEM2100FEGM KCPM45	H54
KSEM2100HPCCLM KC7410	H48, H87
KSEM2100HPGM KC7315	H42
KSEM2100HPGM KCPM45	H45
KSEM2100HPLM KC7320	H50
KSEM2100HPM KC7315	H40
KSEM2100PCM KC7135	H56, H87
KSEM2100SPLM KCMS35	H52
KSEM210R10WN25M	H61
KSEM210R3WN25M	H59
KSEM210R5WN25M	H59
KSEM210R7WN25M	H61
KSEM210SEFM	H64
KSEM2110HPGM KC7315	H42
KSEM2115HPLM KC7320	H50
KSEM2120HPGM KC7315	H42
KSEM2133HPGM KC7315	H43
KSEM2133HPLM KC7320	H50
KSEM2143HPCCLM KC7410	H48
KSEM2143HPGM KC7315	H43
KSEM2143HPGM KCPM45	H45
KSEM2143HPLM KC7320	H50
KSEM2143HPM KC7315	H40
KSEM2150FEGM KCPM45	H54
KSEM2150HPCCLM KC7410	H48
KSEM2150HPGM KC7315	H43
KSEM2150HPGM KCPM45	H45
KSEM2150HPLM KC7320	H50
KSEM2150HPM KC7315	H40
KSEM2150PCM KC7135	H56
KSEM2150SPLM KCMS35	H52
KSEM215R10WN25M	H61
KSEM215R3WN25M	H59
KSEM215R5WN25M	H59
KSEM215R7WN25M	H61
KSEM215SEFM	H64
KSEM2170HPGM KC7315	H43
KSEM2183HPGM KC7315	H43
KSEM2183HPGM KCPM45	H45
KSEM2183HPLM KC7320	H50
KSEM2183HPM KC7315	H40
KSEM2200FEGM KCPM45	H54
KSEM2200HPCCLM KC7410	H48, H87
KSEM2200HPGM KC7315	H43
KSEM2200HPGM KCPM45	H45
KSEM2200HPLM KC7320	H50
KSEM2200HPM KC7315	H40
KSEM2200PCM KC7135	H56, H87
KSEM2200SPLM KCMS35	H52
KSEM220R10WN25M	H61
KSEM220R3WN25M	H59
KSEM220R5WN25M	H59
KSEM220R7WN25M	H61
KSEM220SEFM	H64
KSEM2210HPCCLM KC7410	H48
KSEM2210HPGM KC7315	H43
KSEM2215HPGM KC7315	H43
KSEM221R10WN25M	H61
KSEM221R1WN25F45M	H63
KSEM221R1WN25M	H58
KSEM221R5WN25M	H59
KSEM2223HPCCLM KC7410	H48
KSEM2223HPGM KC7315	H43
KSEM2223HPGM KCPM45	H45
KSEM2223HPLM KC7320	H50
KSEM2223HPM KC7315	H40
KSEM2223SPLM KCMS35	H52
KSEM2244HPCCLM KC7410	H48
KSEM2244HPGM KC7315	H43
KSEM2244HPGM KCPM45	H45
KSEM2244HPLM KC7320	H50
KSEM2244HPM KC7315	H40
KSEM2250FEGM KCPM45	H54
KSEM2250HPCCLM KC7410	H48
KSEM2250HPGM KC7315	H43
KSEM2250HPGM KCPM45	H45
KSEM2250HPLM KC7320	H50
KSEM2250HPM KC7315	H40
KSEM2250PCM KC7135	H56
KSEM2250SPLM KCMS35	H52
KSEM225R10WN25M	H61
KSEM225R3WN25M	H60
KSEM225R5WN25M	H60
KSEM225R7WN25M	H61
KSEM225SEFM	H64
KSEM2262HPGM KC7315	H43
KSEM2277HPLM KC7320	H50
KSEM2300FEGM KCPM45	H54
KSEM2300HPCCLM KC7410	H48, H87
KSEM2300HPGM KC7315	H43
KSEM2300HPGM KCPM45	H45
KSEM2300HPLM KC7320	H50
KSEM2300HPM KC7315	H40
KSEM2300PCM KC7135	H56, H87
KSEM2300SPLM KCMS35	H52
KSEM2305HPGM KC7315	H43
KSEM230R10WN25M	H61
KSEM230R3WN25M	H60
KSEM230R5WN25M	H60
KSEM230R7WN25M	H61
KSEM230SEFM	H64
KSEM2310HPGM KC7315	H43
KSEM2325HPGM KC7315	H43
KSEM2330HPGM KC7315	H43
KSEM2342HPCCLM KC7410	H48
KSEM2342HPGM KC7315	H43
KSEM2342HPGM KCPM45	H45
KSEM2342HPLM KC7320	H50
KSEM2342HPM KC7315	H40
KSEM2350FEGM KCPM45	H54
KSEM2350HPCCLM KC7410	H48
KSEM2350HPGM KC7315	H43
KSEM2350HPGM KCPM45	H45
KSEM2350HPLM KC7320	H50
KSEM2350HPM KC7315	H40
KSEM2350PCM KC7135	H56
KSEM2350SPLM KCMS35	H52
KSEM235R10WN25M	H61
KSEM235R3WN25M	H60
KSEM235R5WN25M	H60
KSEM235R7WN25M	H61
KSEM235SEFM	H64
KSEM2360HPGM KCPM45	H45
KSEM2370HPGM KCPM45	H45
KSEM2381HPCCLM KC7410	H48
KSEM2381HPGM KC7315	H43
KSEM2381HPGM KCPM45	H45
KSEM2381HPLM KC7320	H50
KSEM2381HPM KC7315	H40
KSEM2381SPLM KCMS35	H52
KSEM2400FEGM KCPM45	H54
KSEM2400HPCCLM KC7410	H48, H87
KSEM2400HPGM KC7315	H43
KSEM2400HPGM KCPM45	H45
KSEM2400HPLM KC7320	H50
KSEM2400HPM KC7315	H40
KSEM2400PCM KC7135	H56, H87
KSEM2400SPLM KCMS35	H52
KSEM240R10WN25M	H61
KSEM240R3WN25M	H60
KSEM240R5WN25M	H60
KSEM240R7WN25M	H61
KSEM240SEFM	H64
KSEM241R10WN32M	H61
KSEM241R1WN32F45M	H63
KSEM241R1WN32M	H58
KSEM241R5WN32M	H60
KSEM2430HPGM KC7315	H43
KSEM2450FEGM KCPM45	H54
KSEM2450HPCCLM KC7410	H48
KSEM2450HPGM KC7315	H43
KSEM2450HPGM KCPM45	H45
KSEM2450HPLM KC7320	H50
KSEM2450HPM KC7315	H40
KSEM2450PCM KC7135	H56
KSEM2450SPLM KCMS35	H52
KSEM245R10WN32M	H61
KSEM245R3WN32M	H60
KSEM245R5WN32M	H60
KSEM245R7WN32M	H61
KSEM245SEFM	H64
KSEM2461HPCCLM KC7410	H48
KSEM2461HPGM KC7315	H43
KSEM2461HPGM KCPM45	H46
KSEM2461HPLM KC7320	H50
KSEM2461HPM KC7315	H40
KSEM2470HPGM KC7315	H43
KSEM2500FEGM KCPM45	H54
KSEM2500HPCCLM KC7410	H48, H87
KSEM2500HPGM KC7315	H43
KSEM2500HPGM KCPM45	H46
KSEM2500HPLM KC7320	H50
KSEM2500HPM KC7315	H40
KSEM2500PCM KC7135	H56, H87
KSEM2500SPLM KCMS35	H52
KSEM2507HPLM KC7320	H50
KSEM250R10WN32M	H61
KSEM250R3WN32M	H60
KSEM250R5WN32M	H60
KSEM250R7WN32M	H61
KSEM250SEFM	H64
KSEM2525SPLM KCMS35	H52
KSEM2530SPLM KCMS35	H52
KSEM2540FEGM KCPM45	H54
KSEM2540HPCCLM KC7410	H48
KSEM2540HPGM KC7315	H43

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
KSEM2540HPGM KCPM45	H46
KSEM2540HPLM KC7320	H50
KSEM2540HPM KC7315	H40
KSEM2540SPLM KCMS35	H52
KSEM2550FEGM KCPM45	H54
KSEM2550HPCCLM KC7410	H48
KSEM2550HPGM KC7315	H43
KSEM2550HPGM KCPM45	H46
KSEM2550HPLM KC7320	H50
KSEM2550HPM KC7315	H40
KSEM2550PCM KC7135	H56
KSEM2550SPLM KCMS35	H52
KSEM2554HPGM KC7315	H43
KSEM255R10WN32M	H61
KSEM255R3WN32M	H60
KSEM255R5WN32M	H60
KSEM255R7WN32M	H61
KSEM255SEFM	H64
KSEM2560HPGM KC7315	H43
KSEM2560HPGM KCPM45	H46
KSEM2560HPLM KC7320	H50
KSEM2560HPM KC7315	H40
KSEM2560SPLM KCMS35	H52
KSEM2565HPGM KC7315	H43
KSEM2565HPGM KCPM45	H46
KSEM2565HPLM KC7320	H51
KSEM2565SPLM KCMS35	H52
KSEM2567HPCCLM KC7410	H48
KSEM2567HPGM KC7315	H43
KSEM2567HPGM KCPM45	H46
KSEM2567HPLM KC7320	H51
KSEM2567HPM KC7315	H40
KSEM2567SPLM KCMS35	H52
KSEM2580FEGM KCPM45	H54
KSEM2581FEGM KCPM45	H54
KSEM2581HPGM KCPM45	H46
KSEM2581HPLM KC7320	H51
KSEM2581SPLM KCMS35	H52
KSEM2600FEGM KCPM45	H54
KSEM2600HPCCLM KC7410	H48, H87
KSEM2600HPGM KC7315	H43
KSEM2600HPGM KCPM45	H46
KSEM2600HPLM KC7320	H51
KSEM2600HPM KC7315	H41
KSEM2600PCM KC7135	H56, H87
KSEM2600SPLM KCMS35	H52
KSEM260R10WN32M	H62
KSEM260R3WN32M	H60
KSEM260R5WN32M	H60
KSEM260R7WN32M	H62
KSEM260SEFM	H64
KSEM2619FEGM KCPM45	H54
KSEM2619HPCCLM KC7410	H48
KSEM2619HPGM KC7315	H43
KSEM2619HPGM KCPM45	H46
KSEM2619HPLM KC7320	H51
KSEM2619HPM KC7315	H41
KSEM2619SPLM KCMS35	H52
KSEM261R10WN32M	H62
KSEM261R1WN32F45M	H63
KSEM261R1WN32M	H58
KSEM261R5WN32M	H60
KSEM2630SPLM KCMS35	H52
KSEM2650FEGM KCPM45	H54
KSEM2650HPCCLM KC7410	H48
KSEM2650HPGM KC7315	H43
KSEM2650HPGM KCPM45	H46
KSEM2650HPLM KC7320	H51
KSEM2650HPM KC7315	H41
KSEM2650PCM KC7135	H56
KSEM2650SPLM KCMS35	H52
KSEM2653HPGM KC7315	H43
KSEM2659HPCCLM KC7410	H48
KSEM2659HPGM KC7315	H43
KSEM2659HPGM KCPM45	H46
KSEM2659HPLM KC7320	H51
KSEM2659HPM KC7315	H41
KSEM2659SPLM KCMS35	H52
KSEM265R10WN32M	H62
KSEM265R3WN32M	H60
KSEM265R5WN32M	H60
KSEM265R7WN32M	H62
KSEM265SEFM	H64
KSEM2670FEGM KCPM45	H54
KSEM2670HPGM KC7315	H43
KSEM2670HPLM KC7320	H51
KSEM2700FEGM KCPM45	H54
KSEM2700HPCCLM KC7410	H48, H87
KSEM2700HPGM KC7315	H43
KSEM2700HPGM KCPM45	H46
KSEM2700HPLM KC7320	H51
KSEM2700HPM KC7315	H41
KSEM2700PCM KC7135	H56, H87
KSEM2700SPLM KCMS35	H52
KSEM270R10WN32M	H62
KSEM270R3WN32M	H60
KSEM270R5WN32M	H60
KSEM270R7WN32M	H62
KSEM270SEFM	H64
KSEM2750FEGM KCPM45	H54
KSEM2750HPCCLM KC7410	H48
KSEM2750HPGM KC7315	H43
KSEM2750HPGM KCPM45	H46
KSEM2750HPLM KC7320	H51
KSEM2750HPM KC7315	H41
KSEM2750SPLM KCMS35	H52
KSEM275R10WN32M	H62
KSEM275R3WN32M	H60
KSEM275R5WN32M	H60
KSEM275R7WN32M	H62
KSEM275SEFM	H64
KSEM2778HPCCLM KC7410	H48
KSEM2778HPGM KC7315	H43
KSEM2778HPGM KCPM45	H46
KSEM2778HPM KC7315	H41
KSEM2779HPLM KC7320	H51
KSEM2800FEGM KCPM45	H54
KSEM2800HPCCLM KC7410	H49, H87
KSEM2800HPGM KC7315	H43
KSEM2800HPGM KCPM45	H46
KSEM2800HPLM KC7320	H51
KSEM2800HPM KC7315	H41
KSEM2800PCM KC7135	H56, H87
KSEM2800SPLM KCMS35	H52
KSEM280R10WN32M	H62
KSEM280R3WN32M	H60
KSEM280R5WN32M	H60
KSEM280R7WN32M	H62
KSEM280SEFM	H64
KSEM2810HPLM KC7320	H51
KSEM2817HPLM KC7320	H51
KSEM2818HPCCLM KC7410	H49
KSEM2818HPGM KC7315	H43
KSEM2818HPGM KCPM45	H46
KSEM2818HPM KC7315	H41
KSEM281R10WN32M	H62
KSEM281R1WN32F45M	H63
KSEM281R1WN32M	H58
KSEM281R5WN32M	H60
KSEM2835HPGM KCPM45	H46
KSEM2850FEGM KCPM45	H54
KSEM2850HPCCLM KC7410	H49
KSEM2850HPGM KC7315	H43
KSEM2850HPGM KCPM45	H46
KSEM2850HPLM KC7320	H51
KSEM2850HPM KC7315	H41
KSEM2850PCM KC7135	H56
KSEM2850SPLM KCMS35	H52
KSEM2858HPCCLM KC7410	H49
KSEM2858HPGM KC7315	H43
KSEM2858HPGM KCPM45	H46
KSEM2858HPLM KC7320	H51
KSEM2858HPM KC7315	H41
KSEM2858SPLM KCMS35	H53
KSEM285R10WN32M	H62
KSEM285R3WN32M	H60
KSEM285R5WN32M	H60
KSEM285R7WN32M	H62
KSEM285SEFM	H64
KSEM2900FEGM KCPM45	H54
KSEM2900HPCCLM KC7410	H49, H87
KSEM2900HPGM KC7315	H43
KSEM2900HPGM KCPM45	H46
KSEM2900HPLM KC7320	H51
KSEM2900HPM KC7315	H41
KSEM2900PCM KC7135	H56, H87
KSEM2900SPLM KCMS35	H53
KSEM290R10WN32M	H62
KSEM290R3WN32M	H60
KSEM290R5WN32M	H60
KSEM290R7WN32M	H62
KSEM290SEFM	H64
KSEM2937HPCCLM KC7410	H49
KSEM2937HPGM KC7315	H43
KSEM2937HPGM KCPM45	H46
KSEM2937HPLM KC7320	H51
KSEM2937HPM KC7315	H41
KSEM2950FEGM KCPM45	H54
KSEM2950HPCCLM KC7410	H49
KSEM2950HPGM KC7315	H43
KSEM2950HPGM KCPM45	H46
KSEM2950HPLM KC7320	H51
KSEM2950HPM KC7315	H41
KSEM2950PCM KC7135	H56
KSEM2950SPLM KCMS35	H53
KSEM2955HPGM KC7315	H43
KSEM295R10WN32M	H62
KSEM295R3WN32M	H60
KSEM295R5WN32M	H60
KSEM295R7WN32M	H62
KSEM295SEFM	H64
KSEM2973HPGM KC7315	H43
KSEM2977HPCCLM KC7410	H49
KSEM2977HPGM KC7315	H43
KSEM2977HPGM KCPM45	H46
KSEM2977HPLM KC7320	H51
KSEM2977HPM KC7315	H41
KSEM3000FEGM KCPM45	H54
KSEM3000HPCCLM KC7410	H49, H87
KSEM3000HPGM KC7315	H43
KSEM3000HPGM KCPM45	H46
KSEM3000HPLM KC7320	H51
KSEM3000HPM KC7315	H41
KSEM3000PCM KC7135	H56, H87
KSEM3000SPLM KCMS35	H53
KSEM300R10WN32M	H62
KSEM300R3WN32M	H60
KSEM300R5WN32M	H60
KSEM300R7WN32M	H62
KSEM300SEFM	H64
KSEM3016HPCCLM KC7410	H49
KSEM3016HPGM KC7315	H43
KSEM3016HPGM KCPM45	H46
KSEM3016HPLM KC7320	H51
KSEM3016HPM KC7315	H41
KSEM301R10WN32M	H62
KSEM301R1WN32F45M	H63
KSEM301R1WN32M	H58
KSEM301R5WN32M	H60
KSEM3050FEGM KCPM45	H54
KSEM3050HPCCLM KC7410	H49
KSEM3050HPGM KC7315	H43
KSEM3050HPGM KCPM45	H46
KSEM3050HPLM KC7320	H51
KSEM3050HPM KC7315	H41
KSEM3050PCM KC7135	H56
KSEM3050SPLM KCMS35	H53
KSEM3056HPGM KC7315	H43
KSEM305R3WN32M	H60
KSEM305R5WN32M	H60
KSEM305R7WN32M	H62
KSEM305SEFM	H64
KSEM3096HPGM KC7315	H43
KSEM3096HPGM KCPM45	H46
KSEM3096HPM KC7315	H41
KSEM3100FEGM KCPM45	H54
KSEM3100HPCCLM KC7410	H49, H87
KSEM3100HPGM KC7315	H43
KSEM3100HPGM KCPM45	H46
KSEM3100HPLM KC7320	H51
KSEM3100HPM KC7315	H41
KSEM3100PCM KC7135	H56, H87
KSEM3100SPLM KCMS35	H53
KSEM310R10WN32M	H62
KSEM310R3WN32M	H60
KSEM310R5WN32M	H60
KSEM310R7WN32M	H62
KSEM310SEFM	H64
KSEM3115HPGM KCPM45	H46
KSEM3125HPGM KC7315	H43
KSEM3150FEGM KCPM45	H54
KSEM3150HPGM KC7315	H43
KSEM3150HPGM KCPM45	H46
KSEM3150HPLM KC7320	H51
KSEM3150HPM KC7315	H41
KSEM3150SPLM KCMS35	H53
KSEM315R3WN32M	H60
KSEM315R5WN32M	H60
KSEM315R7WN32M	H62
KSEM315SEFM	H64
KSEM3175FEGM KCPM45	H54
KSEM3175HPCCLM KC7410	H49
KSEM3175HPGM KC7315	H43
KSEM3175HPGM KCPM45	H46
KSEM3175HPLM KC7320	H51
KSEM3175HPM KC7315	H41
KSEM3175SPLM KCMS35	H53
KSEM3200FEGM KCPM45	H54
KSEM3200HPCCLM KC7410	H49, H87
KSEM3200HPGM KC7315	H43
KSEM3200HPGM KCPM45	H46
KSEM3200HPLM KC7320	H51
KSEM3200HPM KC7315	H41
KSEM3200PCM KC7135	H56, H87
KSEM3200SPLM KCMS35	H53
KSEM320R10WN32M	H62
KSEM320R3WN32M	H60
KSEM320R5WN32M	H60
KSEM320R7WN32M	H62
KSEM320SEFM	H64
KSEM321R1WD50F45M	H63
KSEM321R1WD50M	H58
KSEM321R3WD40M	H60
KSEM321R3WD50M	H60
KSEM321R5WD40M	H60
KSEM321R5WD50M	H60
KSEM3220HPGM KC7315	H43
KSEM3234HPGM KC7315	H43
KSEM3250FEGM KCPM45	H54
KSEM3250HPGM KC7315	H43
KSEM3250HPGM KCPM45	H46
KSEM3250HPM KC7315	H41
KSEM3250SPLM KCMS35	H53
KSEM3254HPGM KC7315	H43
KSEM3254HPGM KCPM45	H46
KSEM3254HPLM KC7320	H51
KSEM3294HPGM KC7315	H43
KSEM3300FEGM KCPM45	H54
KSEM3300HPCCLM KC7410	H49, H87
KSEM3300HPGM KC7315	H43
KSEM3300HPGM KCPM45	H46
KSEM3300HPLM KC7320	H51
KSEM3300HPM KC7315	H41
KSEM3300PCM KC7135	H56, H87
KSEM330R3WD40M	H60
KSEM330R3WD50M	H60
KSEM330R5WD40M	H60
KSEM330R5WD50M	H60
KSEM3334HPGM KC7315	H43
KSEM3334HPGM KCPM45	H46
KSEM3334HPM KC7315	H41
KSEM3335HPLM KC7320	H51
KSEM3350FEGM KCPM45	H54
KSEM3350HPGM KC7315	H43
KSEM3350HPGM KCPM45	H46
KSEM3350SPLM KCMS35	H53
KSEM3373HPGM KC7315	H43
KSEM3400FEGM KCPM45	H54
KSEM3400HPCCLM KC7410	H49, H87
KSEM3400HPGM KC7315	H43
KSEM3400HPGM KCPM45	H46
KSEM3400HPLM KC7320	H51
KSEM3400HPM KC7315	H41
KSEM3400PCM KC7135	H56, H87
KSEM3400SPLM KCMS35	H53
KSEM340R3WD40M	H60
KSEM340R3WD50M	H60
KSEM340R5WD40M	H60

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
KSEM340R5WD50M	H60
KSEM3413HPGM KC7315	H43
KSEM3413HPM KC7315	H41
KSEM3450FEGM KCPM45	H54
KSEM3450HPGM KC7315	H43
KSEM3450HPGM KCPM45	H46
KSEM3450SPLM KCMS35	H53
KSEM3493HPGM KC7315	H43
KSEM3493HPGM KCPM45	H46
KSEM3493HPLM KC7320	H51
KSEM3493HPM KC7315	H41
KSEM3500FEGM KCPM45	H54
KSEM3500HPCCLM KC7410	H49, H87
KSEM3500HPGM KC7315	H43
KSEM3500HPGM KCPM45	H46
KSEM3500HPLM KC7320	H51
KSEM3500HPM KC7315	H41
KSEM3500PCM KC7135	H56, H87
KSEM3500SPLM KCMS35	H53
KSEM350R3WD40M	H60
KSEM350R3WD50M	H60
KSEM350R5WD40M	H60
KSEM350R5WD50M	H60
KSEM3550FEGM KCPM45	H54
KSEM3550HPGM KC7315	H43
KSEM3550HPM KC7315	H41
KSEM3550SPLM KCMS35	H53
KSEM3571HPLM KC7320	H51
KSEM3572HPGM KC7315	H43
KSEM3600FEGM KCPM45	H55
KSEM3600HPCCLM KC7410	H49, H87
KSEM3600HPGM KC7315	H43
KSEM3600HPGM KCPM45	H46
KSEM3600HPLM KC7320	H51
KSEM3600HPM KC7315	H41
KSEM3600PCM KC7135	H56, H87
KSEM3600SPLM KCMS35	H53
KSEM360R3WD40M	H60
KSEM360R3WD50M	H60
KSEM360R5WD40M	H60
KSEM360R5WD50M	H60
KSEM3612HPGM KC7315	H43
KSEM361R1WD50F45M	H63
KSEM361R1WD50M	H58
KSEM361R3WD40M	H60
KSEM361R3WD50M	H60
KSEM361R5WD40M	H60
KSEM361R5WD50M	H60
KSEM3650FEGM KCPM45	H55
KSEM3650HPGM KC7315	H43
KSEM3650SPLM KCMS35	H53
KSEM3651HPGM KC7315	H43
KSEM3651HPGM KCPM45	H46
KSEM3700FEGM KCPM45	H55
KSEM3700HPCCLM KC7410	H49, H87
KSEM3700HPGM KC7315	H43
KSEM3700HPGM KCPM45	H46
KSEM3700HPLM KC7320	H51
KSEM3700PCM KC7135	H56, H87
KSEM3700SPLM KCMS35	H53
KSEM370R3WD40M	H60
KSEM370R3WD50M	H60
KSEM370R5WD40M	H60
KSEM370R5WD50M	H60
KSEM3731HPGM KC7315	H43
KSEM3731HPGM KCPM45	H46
KSEM3750FEGM KCPM45	H55
KSEM3750HPGM KC7315	H43
KSEM3750HPGM KCPM45	H46
KSEM3750HPLM KC7320	H51
KSEM3750HPM KC7315	H41
KSEM3750SPLM KCMS35	H53
KSEM3800FEGM KCPM45	H55
KSEM3800HPCCLM KC7410	H49, H87
KSEM3800HPGM KC7315	H43
KSEM3800HPGM KCPM45	H46
KSEM3800HPLM KC7320	H51
KSEM3800HPM KC7315	H41
KSEM3800PCM KC7135	H56, H87
KSEM3800SPLM KCMS35	H53
KSEM380R3WD40M	H60
KSEM380R3WD50M	H60
KSEM380R5WD40M	H60
KSEM380R5WD50M	H60
KSEM3810FEGM KCPM45	H55
KSEM3810HPGM KC7315	H43
KSEM3810HPGM KCPM45	H46
KSEM3810HPLM KC7320	H51
KSEM3810HPM KC7315	H41
KSEM3846HPGM KC7315	H43
KSEM3846HPGM KCPM45	H46
KSEM3846HPLM KC7320	H51
KSEM3846SPLM KCMS35	H53
KSEM3850FEGM KCPM45	H55
KSEM3850HPGM KC7315	H43
KSEM3850HPM KC7315	H41
KSEM3850SPLM KCMS35	H53
KSEM3900FEGM KCPM45	H55
KSEM3900HPCCLM KC7410	H49, H87
KSEM3900HPGM KC7315	H43
KSEM3900HPGM KCPM45	H46
KSEM3900HPLM KC7320	H51
KSEM3900HPM KC7315	H41
KSEM3900PCM KC7135	H56, H87
KSEM3900SPLM KCMS35	H53
KSEM390R3WD40M	H60
KSEM390R3WD50M	H60
KSEM390R5WD40M	H60
KSEM390R5WD50M	H60
KSEM3920HPCCLM KC7410	H49
KSEM3950FEGM KCPM45	H55
KSEM3950HPGM KC7315	H43
KSEM3950HPM KC7315	H41
KSEM3950SPLM KCMS35	H53
KSEM3975HPGM KC7315	H43
KSEM4000FEGM KCPM45	H55
KSEM4000HPCCLM KC7410	H49, H87
KSEM4000HPGM KC7315	H43
KSEM4000HPGM KCPM45	H46
KSEM4000HPLM KC7320	H51
KSEM4000HPM KC7315	H41
KSEM4000PCM KC7135	H56, H87
KSEM4000SPLM KCMS35	H53
KSEM400R3WD40M	H60
KSEM400R3WD50M	H60
KSEM400R5WD40M	H60
KSEM400R5WD50M	H60
KSEMP10000FDS90A1M	H82, H93, H99
KSEMP10000FDS90B1M	H86, H96
KSEMP10160FDS90A1M	H82, H93, H99
KSEMP10160FDS90B1M	H86, H96
KSEMP1300HPGM KC7315	H87
KSEMP1400HPGM KC7315	H87
KSEMP1500HPGM KC7315	H87
KSEMP1600HPGM KC7315	H87
KSEMP1700HPGM KC7315	H87
KSEMP1800HPGM KC7315	H87
KSEMP1900HPGM KC7315	H87
KSEMP2000HPGM KC7315	H87
KSEMP2100HPGM KC7315	H87
KSEMP2200HPGM KC7315	H87
KSEMP2300HPGM KC7315	H87
KSEMP2400HPGM KC7315	H87
KSEMP2500HPGM KC7315	H87
KSEMP2600HPGM KC7315	H87
KSEMP2700HPGM KC7315	H87
KSEMP2800FDS28A1M	H80, H91, H98
KSEMP2800FDS28B1M	H84, H94
KSEMP2800HPGM KC7315	H87
KSEMP2858FDS28A1M	H80, H91, H98
KSEMP2858FDS28B1M	H84, H94
KSEMP2900FDS28A1M	H80, H91, H98
KSEMP2900FDS28B1M	H84, H94
KSEMP2900HPGM KC7315	H87
KSEMP2937FDS28A1M	H80, H91, H98
KSEMP2937FDS28B1M	H84, H94
KSEMP3000FDS28A1M	H80, H91, H98
KSEMP3000FDS28B1M	H84, H94
KSEMP3000HPGM KC7315	H87
KSEMP3017FDS28A1M	H80, H91, H98
KSEMP3017FDS28B1M	H84, H94
KSEMP3096FDS28A1M	H80, H91, H98
KSEMP3096FDS28B1M	H84, H94
KSEMP3100FDS28A1M	H80, H91, H98
KSEMP3100FDS28B1M	H84, H94
KSEMP3100HPGM KC7315	H87
KSEMP3175FDS32A1M	H80, H91, H98
KSEMP3175FDS32B1M	H84, H94
KSEMP3200FDS32A1M	H80, H91, H98
KSEMP3200FDS32B1M	H84, H94
KSEMP3200HPGM KC7315	H87
KSEMP3300FDS32A1M	H80, H91, H98
KSEMP3300FDS32B1M	H84, H94
KSEMP3300HPGM KC7315	H87
KSEMP3320FDS32A1M	H80, H91, H98
KSEMP3320FDS32B1M	H84, H94
KSEMP3334FDS32A1M	H80, H91, H98
KSEMP3334FDS32B1M	H84, H94
KSEMP3400FDS32A1M	H80, H91, H98
KSEMP3400FDS32B1M	H84, H94
KSEMP3400HPGM KC7315	H87
KSEMP3493FDS32A1M	H80, H91, H98
KSEMP3493FDS32B1M	H84, H94
KSEMP3500FDS32A1M	H80, H91, H98
KSEMP3500FDS32B1M	H84, H94
KSEMP3500HPGM KC7315	H87
KSEMP3600FDS36A1M	H80, H92, H98
KSEMP3600FDS36B1M	H84, H94
KSEMP3600HPGM KC7315	H87
KSEMP3651FDS36A1M	H80, H92, H98
KSEMP3651FDS36B1M	H84, H94
KSEMP3700FDS36A1M	H80, H92, H98
KSEMP3700FDS36B1M	H84, H94
KSEMP3700HPGM KC7315	H87
KSEMP3750FDS36A1M	H80, H92, H98
KSEMP3750FDS36B1M	H84, H94
KSEMP3800FDS36A1M	H80, H92, H98
KSEMP3800FDS36B1M	H84, H95
KSEMP3800HPGM KC7315	H87
KSEMP3810FDS36A1M	H80, H92, H98
KSEMP3810FDS36B1M	H84, H95
KSEMP3900FDS36A1M	H80, H92, H98
KSEMP3900FDS36B1M	H84, H95
KSEMP3900HPGM KC7315	H87
KSEMP3920FDS36A1M	H80, H92, H98
KSEMP3920FDS36B1M	H84, H95
KSEMP3970FDS36A1M	H80, H92, H98
KSEMP3970FDS36B1M	H84, H95
KSEMP4000FDS40A1M	H80, H92, H98
KSEMP4000FDS40B1M	H84, H95
KSEMP4000HPGM KC7315	H87
KSEMP4100FDS40A1M	H80, H92, H98
KSEMP4100FDS40B1M	H84, H95
KSEMP4128FDS40A1M	H80, H92, H98
KSEMP4128FDS40B1M	H84, H95
KSEMP4200FDS40A1M	H80, H92, H98
KSEMP4200FDS40B1M	H84, H95
KSEMP4300FDS40A1M	H80, H92, H98
KSEMP4300FDS40B1M	H84, H95
KSEMP4400FDS40A1M	H80, H92, H98
KSEMP4400FDS40B1M	H84, H95
KSEMP4445FDS40A1M	H80, H92, H98
KSEMP4445FDS40B1M	H84, H95
KSEMP4500FDS45A1M	H81, H92, H98
KSEMP4500FDS45B1M	H85, H95
KSEMP4600FDS45A1M	H81, H92, H98
KSEMP4600FDS45B1M	H85, H95
KSEMP4700FDS45A1M	H81, H92, H98
KSEMP4700FDS45B1M	H85, H95
KSEMP4763FDS45A1M	H81, H92, H98
KSEMP4763FDS45B1M	H85, H95
KSEMP4800FDS45A1M	H81, H92, H98
KSEMP4800FDS45B1M	H85, H95
KSEMP4900FDS45A1M	H81, H92, H98
KSEMP4900FDS45B1M	H85, H95
KSEMP5000FDS50A1M	H81, H92, H98
KSEMP5000FDS50B1M	H85, H95
KSEMP5080FDS50A1M	H81, H92, H98
KSEMP5080FDS50B1M	H85, H95
KSEMP5100FDS50A1M	H81, H92, H98
KSEMP5100FDS50B1M	H85, H95
KSEMP5200FDS50A1M	H81, H92, H98
KSEMP5200FDS50B1M	H85, H95
KSEMP5300FDS50A1M	H81, H92, H98
KSEMP5300FDS50B1M	H85, H95
KSEMP5398FDS50A1M	H81, H92, H98
KSEMP5398FDS50B1M	H85, H95
KSEMP5400FDS50A1M	H81, H92, H98
KSEMP5400FDS50B1M	H85, H95
KSEMP5500FDS50A1M	H81, H92, H98
KSEMP5500FDS50B1M	H85, H95
KSEMP5600FDS56A1M	H81, H92, H98
KSEMP5600FDS56B1M	H85, H95
KSEMP5700FDS56A1M	H81, H92, H98
KSEMP5700FDS56B1M	H85, H95
KSEMP5715FDS56A1M	H81, H92, H98
KSEMP5715FDS56B1M	H85, H95
KSEMP5800FDS56A1M	H81, H92, H98
KSEMP5800FDS56B1M	H85, H95
KSEMP5900FDS56A1M	H81, H92, H98
KSEMP5900FDS56B1M	H85, H95
KSEMP6000FDS56A1M	H81, H92, H98
KSEMP6000FDS56B1M	H85, H95
KSEMP6033FDS56A1M	H81, H92, H98
KSEMP6033FDS56B1M	H85, H95
KSEMP6100FDS56A1M	H81, H92, H98
KSEMP6100FDS56B1M	H85, H95
KSEMP6200FDS56A1M	H81, H92, H98
KSEMP6200FDS56B1M	H85, H95
KSEMP6300FDS63A1M	H81, H92, H98
KSEMP6300FDS63B1M	H85, H95
KSEMP6350FDS63A1M	H81, H92, H99
KSEMP6350FDS63B1M	H85, H95
KSEMP6400FDS63A1M	H81, H92, H99
KSEMP6400FDS63B1M	H85, H95
KSEMP6500FDS63A1M	H81, H92, H99
KSEMP6500FDS63B1M	H85, H95
KSEMP6600FDS63A1M	H81, H92, H99
KSEMP6600FDS63B1M	H85, H95
KSEMP6668FDS63A1M	H81, H92, H99
KSEMP6668FDS63B1M	H85, H95
KSEMP6700FDS63A1M	H81, H92, H99
KSEMP6700FDS63B1M	H85, H95
KSEMP6800FDS63A1M	H81, H92, H99
KSEMP6800FDS63B1M	H85, H95
KSEMP6900FDS63A1M	H81, H92, H99
KSEMP6900FDS63B1M	H85, H95
KSEMP6985FDS63A1M	H81, H92, H99
KSEMP6985FDS63B1M	H85, H95
KSEMP7000FDS63A1M	H81, H92, H99
KSEMP7000FDS63B1M	H85, H95
KSEMP7100FDS71A1M	H82, H92, H99
KSEMP7100FDS71B1M	H86, H95
KSEMP7200FDS71A1M	H82, H92, H99
KSEMP7200FDS71B1M	H86, H95
KSEMP7300FDS71A1M	H82, H92, H99
KSEMP7300FDS71B1M	H86, H95
KSEMP7303FDS71A1M	H82, H92, H99
KSEMP7303FDS71B1M	H86, H95
KSEMP7400FDS71A1M	H82, H92, H99
KSEMP7400FDS71B1M	H86, H95
KSEMP7500FDS71A1M	H82, H92, H99
KSEMP7500FDS71B1M	H86, H95
KSEMP7600FDS71A1M	H82, H93, H99
KSEMP7600FDS71B1M	H86, H95
KSEMP7620FDS71A1M	H82, H93, H99
KSEMP7620FDS71B1M	H86, H95
KSEMP7700FDS71A1M	H82, H93, H99
KSEMP7700FDS71B1M	H86, H95
KSEMP7800FDS71A1M	H82, H93, H99
KSEMP7800FDS71B1M	H86, H95
KSEMP7900FDS71A1M	H82, H93, H99
KSEMP7900FDS71B1M	H86, H96
KSEMP7938FDS80A1M	H82, H93, H99
KSEMP7938FDS80B1M	H86, H96
KSEMP8000FDS80A1M	H82, H93, H99
KSEMP8000FDS80B1M	H86, H96
KSEMP8100FDS80A1M	H82, H93, H99
KSEMP8100FDS80B1M	H86, H96
KSEMP8200FDS80A1M	H82, H93, H99
KSEMP8200FDS80B1M	H86, H96
KSEMP8255FDS80A1M	H82, H93, H99
KSEMP8255FDS80B1M	H86, H96
KSEMP8300FDS80A1M	H82, H93, H99
KSEMP8300FDS80B1M	H86, H96
KSEMP8400FDS80A1M	H82, H93, H99
KSEMP8400FDS80B1M	H86, H96
KSEMP8500FDS80A1M	H82, H93, H99

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
KSEMP8500FDS80B1M	H86, H96
KSEMP8573FDS80A1M	H82, H93, H99
KSEMP8573FDS80B1M	H86, H96
KSEMP8600FDS80A1M	H82, H93, H99
KSEMP8600FDS80B1M	H86, H96
KSEMP8700FDS80A1M	H82, H93, H99
KSEMP8700FDS80B1M	H86, H96
KSEMP8800FDS80A1M	H82, H93, H99
KSEMP8800FDS80B1M	H86, H96
KSEMP8890FDS80A1M	H82, H93, H99
KSEMP8890FDS80B1M	H86, H96
KSEMP8900FDS80A1M	H82, H93, H99
KSEMP8900FDS80B1M	H86, H96
KSEMP9000FDS90A1M	H82, H93, H99
KSEMP9000FDS90B1M	H86, H96
KSEMP9100FDS90A1M	H82, H93, H99
KSEMP9100FDS90B1M	H86, H96
KSEMP9200FDS90A1M	H82, H93, H99
KSEMP9200FDS90B1M	H86, H96
KSEMP9208FDS90A1M	H82, H93, H99
KSEMP9208FDS90B1M	H86, H96
KSEMP9300FDS90A1M	H82, H93, H99
KSEMP9300FDS90B1M	H86, H96
KSEMP9400FDS90A1M	H82, H93, H99
KSEMP9400FDS90B1M	H86, H96
KSEMP9500FDS90A1M	H82, H93, H99
KSEMP9500FDS90B1M	H86, H96
KSEMP9525FDS90A1M	H82, H93, H99
KSEMP9525FDS90B1M	H86, H96
KSEMP9600FDS90A1M	H82, H93, H99
KSEMP9600FDS90B1M	H86, H96
KSEMP9700FDS90A1M	H82, H93, H99
KSEMP9700FDS90B1M	H86, H96
KSEMP9800FDS90A1M	H82, H93, H99
KSEMP9800FDS90B1M	H86, H96
KSEMP9843FDS90A1M	H82, H93, H99
KSEMP9843FDS90B1M	H86, H96
KSEMP9900FDS90A1M	H82, H93, H99
KSEMP9900FDS90B1M	H86, H96
KSHR025D02A20HN06L120	S9
KSHR025D03A20HN06L120	S9
KSHR025D03A25HN06L200	S9
KSHR025D03B20HN06	S8
KSHR025D03M16HN06	S8
KSHR032D03A25HN06L130	S9
KSHR032D03B25HN06	S8
KSHR032D03M16HN06	S8
KSHR032D04A25HN06L130	S9
KSHR032D04B25HN06	S8
KSHR032D04M16HN06	S8
KSHR040A04RS45HN06	S10
KSHR040A04RS60HN06	S14
KSHR040A05RS45HN06	S10
KSHR040A05RS60HN06	S14
KSHR050A04RS45HN06	S10
KSHR050A04RS60HN06	S14
KSHR050A05RS45HN06	S10
KSHR050A05RS60HN06	S14
KSHR050A06RS45HN06	S10
KSHR063A04RS45HN06	S10
KSHR063A04RS60HN06	S14
KSHR063A06RS45HN06	S10
KSHR063A06RS60HN06	S14
KSHR063A08RS45HN06	S10
KSHR080A05RS45HN06	S10
KSHR080A05RS60HN06	S14
KSHR080A08RS45HN06	S10
KSHR080A08RS60HN06	S14
KSHR080A10RS45HN06	S10
KSHR100B05RS45HN13	S25
KSHR100B06RS45HN06	S10
KSHR100B06RS45HN09	S21
KSHR100B06RS60HN06	S14
KSHR100B08RS45HN09	S21
KSHR100B09RS45HN06	S10
KSHR100B09RS60HN06	S14
KSHR100B11RS45HN09	S21
KSHR100B12RS45HN06	S10
KSHR125B06RS45HN13	S25
KSHR125B08RS45HN06	S10
KSHR125B08RS45HN09	S21
KSHR125B08RS60HN06	S14
KSHR125B10RS45HN09	S21
KSHR125B12RS45HN06	S10
KSHR125B12RS60HN06	S14
KSHR125B14RS45HN09	S21
KSHR125B16RS45HN06	S10
KSHR160C09RS45HN13	S25
KSHR160C10RS45HN09	S21
KSHR160C12RS45HN09	S21
KSHR160C16RS45HN09	S21
KSHR200C10RS45HN13	S25
KSHR200C12RS45HN13	S25
KSHR200C16RS45HN09	S21
KSHR250C12RS45HN13	S25
KSHR250C14RS45HN13	S25
KSHR250C20RS45HN09	S21
KSHR315C14RS45HN13	S25
KSHR315C18RS45HN13	S25
KSHR315C24RS45HN09	S21
KSHR40A04RS45HN09	S21
KSHR40D03R50A25SHN09	S20
KSHR40D03R50B25SHN09	S20
KSHR40D04R50A25SHN09	S20
KSHR40D04R50B25SHN09	S20
KSHR50A04RS45HN09	S21
KSHR50A05RS45HN09	S21
KSHR63A05RS45HN09	S21
KSHR63A06RS45HN09	S21
KSHR63A07RS45HN09	S21
KSHR80A04RS45HN13	S25
KSHR80A05RS45HN09	S21
KSHR80A06RS45HN09	S21
KSHR80A09RS45HN09	S21
KSHRHF025D03A20HN06L120	S4
KSHRHF025D03M16HN06	S4
KSHRHF032D03A25HN06L130	S4
KSHRHF032D04M16HN06	S4
KSHRHF040A05RS15HN06	S5
KSHRHF050A05RS15HN06	S5
KSHRHF063A06RS15HN06	S5
KSHRHF080A08RS15HN06	S5
KSHRHF100B08RS15HN09	S17
KSHRHF125B09RS15HN09	S17
KSHRHF160C12RS15HN09	S17
KSHRHF50A04RS15HN09	S17
KSHRHF63A05RS15HN09	S17
KSHRHF80A06RS15HN09	S17
KSOM100R050F07	S53
KSOM100R070F06	S48
KSOM100R080F07	S53
KSOM100R100F06	S48
KSOM125R060F07	S53
KSOM125R080F06	S48
KSOM125R100F07	S53
KSOM125R120F06	S48
KSOM160R070F07	S53
KSOM160R100F06	S48
KSOM160R120F07	S53
KSOM160R160F06	S48
KSOM32R02B200F06	S47
KSOM32R03A200F06	S47
KSOM32R03B200F06	S47
KSOM32R03B250F06	S47
KSOM32Z03A320F06X	S47
KSOM32Z03M160F06X	S46
KSOM40R03B250F06	S47
KSOM40R04B250F06	S47
KSOM40R04B320F06	S47
KSOM40Z04M160F06X	S46
KSOM40Z040F06X	S48
KSOM50R040F06	S48
KSOM50Z060F06X	S48
KSOM63R040F07	S53
KSOM63R050F06	S48
KSOM63R050F07	S53
KSOM63Z070F06X	S48
KSOM80R040F07	S53
KSOM80R060F06	S48
KSOM80R060F07	S53
KSOM80Z090F06X	S48
KSSM87D050Z05SN12	S62
KSSM87D063Z05SN12	S62
KSSM87D063Z07SN12	S62
KSSM87D080Z07SN12	S62
KSSM87D080Z09SN12	S62
KSSM87D100Z08SN12	S62
KSSM87D100Z11SN12	S62
KSSM87D125Z09SN12	S62
KSSM87D125Z14SN12	S62
KSSM87D160Z12SN12	S62
KSSM88D050Z05SN10	S60
KSSM88D050Z06SN10	S60
KSSM88D063Z05SN10	S60
KSSM88D063Z07SN10	S60
KSSM88D080Z07SN10	S60
KSSM88D080Z09SN10	S60
KSSM88D100Z08SN10	S60
KSSM88D100Z11SN10	S60
KST115115AS	K38
KST135155AS	K38
KST175200AS	K38
KST175200RK	K39
KST175CS	K39
KST200CS	K39
KST250250AS	K38
KST250250RK	K39
KST250CS	K39
KST300350AS	K38
KST300350RK	K39
KST300CS	K39
KST350CS	K39
KT15	K72, K85, S144–147, V113–115, V130
KT20	V111–115, V128–130
KT27	K73–74, K84
KT30	V111–114, V129
KT6	V114–115
KT8	K72, V113–115
KT9	S72, S76, S79, S82
KTFS060R01SS08M	H16
KTFS060R03SS08M	H16
KTFS060R05SS08M	H16
KTFS060R08SS08M	H16
KTFS060R12SF12M	H16
KTFS063R01SS08M	H16
KTFS063R03SS08M	H16
KTFS063R05SS08M	H16
KTFS063R08SS08M	H16
KTFS063R12SF12M	H16
KTFS066R01SS08M	H16
KTFS066R03SS08M	H16
KTFS066R05SS08M	H16
KTFS066R08SS08M	H16
KTFS066R12SF12M	H16
KTFS070R01SS08M	H16
KTFS070R03SS08M	H16
KTFS070R05SS08M	H16
KTFS070R08SS08M	H16
KTFS070R12SF12M	H16
KTFS075R01SS08M	H16
KTFS075R03SS08M	H16
KTFS075R05SS08M	H16
KTFS075R08SS08M	H16
KTFS075R12SF12M	H16
KTFS080R01SS10M	H16
KTFS080R03SCF12M	H17
KTFS080R03SS10M	H16
KTFS080R05SCF12M	H17
KTFS080R05SS10M	H16
KTFS080R08SCF12M	H17
KTFS080R08SS10M	H16
KTFS080R12SF12M	H16
KTFS085R01SS10M	H16
KTFS085R03SCF12M	H17
KTFS085R03SS10M	H16
KTFS085R05SCF12M	H17
KTFS085R05SS10M	H16
KTFS085R08SCF12M	H17
KTFS085R08SS10M	H16
KTFS085R12SF12M	H16
KTFS090R01SS10M	H16
KTFS090R03SCF12M	H17
KTFS090R03SS10M	H16
KTFS090R05SCF12M	H17
KTFS090R05SS10M	H16
KTFS090R08SCF12M	H17
KTFS090R08SS10M	H16
KTFS090R12SF12M	H16
KTFS095R01SS10M	H16
KTFS095R03SCF12M	H17
KTFS095R03SS10M	H16
KTFS095R05SCF12M	H17
KTFS095R05SS10M	H16
KTFS095R08SCF12M	H17
KTFS095R08SS10M	H16
KTFS095R12SF12M	H16
KTFS100R01SS12M	H16
KTFS100R03SCF16M	H17
KTFS100R03SS12M	H16
KTFS100R05SCF16M	H17
KTFS100R05SS12M	H16
KTFS100R08SCF16M	H17
KTFS100R08SS12M	H16
KTFS100R12SF16M	H16
KTFS105R01SS12M	H16
KTFS105R03SCF16M	H17
KTFS105R03SS12M	H16
KTFS105R05SCF16M	H17
KTFS105R05SS12M	H16
KTFS105R08SCF16M	H17
KTFS105R08SS12M	H16
KTFS105R12SF16M	H16
KTFS110R01SS12M	H16
KTFS110R03SCF16M	H17
KTFS110R03SS12M	H16
KTFS110R05SCF16M	H17
KTFS110R05SS12M	H16
KTFS110R08SCF16M	H17
KTFS110R08SS12M	H16
KTFS110R12SF16M	H16
KTFS115R01SS12M	H16
KTFS115R03SCF16M	H17
KTFS115R03SS12M	H16
KTFS115R05SCF16M	H17
KTFS115R05SS12M	H16
KTFS115R08SCF16M	H17
KTFS115R08SS12M	H16
KTFS115R12SF16M	H16
KTFS120R01SS14M	H16
KTFS120R03SCF16M	H17
KTFS120R03SS14M	H16
KTFS120R05SCF16M	H17
KTFS120R05SS14M	H16
KTFS120R08SCF16M	H17
KTFS120R08SS14M	H16
KTFS120R12SF16M	H16
KTFS125R01SS14M	H16
KTFS125R03SCF16M	H17
KTFS125R03SS14M	H16
KTFS125R05SCF16M	H17
KTFS125R05SS14M	H16
KTFS125R08SCF16M	H17
KTFS125R08SS14M	H16
KTFS125R12SF16M	H16
KTFS130R01SS14M	H16
KTFS130R03SCF16M	H17
KTFS130R03SS14M	H16
KTFS130R05SCF16M	H17
KTFS130R05SS14M	H16
KTFS130R08SCF16M	H17
KTFS130R08SS14M	H16
KTFS130R12SF16M	H16
KTFS135R01SS14M	H16
KTFS135R03SCF16M	H17
KTFS135R03SS14M	H16
KTFS135R05SCF16M	H17
KTFS135R05SS14M	H16
KTFS135R08SCF16M	H17
KTFS135R08SS14M	H16
KTFS135R12SF16M	H16
KTFS140R01SS16M	H16
KTFS140R03SCF16M	H17
KTFS140R03SS16M	H16
KTFS140R05SCF16M	H17
KTFS140R05SS16M	H16
KTFS140R08SCF16M	H17
KTFS140R08SS16M	H16

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
KTFS140R12SF16M	H16
KTFS145R01SS16M	H16
KTFS145R03SCF16M	H17
KTFS145R03SS16M	H16
KTFS145R05SCF16M	H17
KTFS145R05SS16M	H16
KTFS145R08SCF16M	H17
KTFS145R08SS16M	H16
KTFS145R12SF16M	H16
KTFS150R01SS16M	H16
KTFS150R03SCF20M	H17
KTFS150R03SS16M	H16
KTFS150R05SCF20M	H17
KTFS150R05SS16M	H16
KTFS150R08SCF20M	H17
KTFS150R08SS16M	H16
KTFS150R12SF20M	H16
KTFS160R01SS16M	H16
KTFS160R03SCF20M	H17
KTFS160R03SS16M	H16
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KTFS180R08SCF25M	H17
KTFS180R08SS20M	H16
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KTFSS06000HPGM KCP15A	H8
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KTFSS23800HPGM KCP15A	H10
KTFSS23813HPGM KCP15A	H10
KTFSS23900HPGM KCP15A	H10
KTFSS24000HPGM KCP15A	H10
KTFSS24100HPGM KCP15A	H10
KTFSS24200HPGM KCP15A	H10

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
KTFSS24300HPGM KCP15A	H10
KTFSS24400HPGM KCP15A	H10
KTFSS24500HPGM KCP15A	H10
KTFSS24600HPGM KCP15A	H10
KTFSS24608HPGM KCP15A	H10
KTFSS24700HPGM KCP15A	H10
KTFSS24800HPGM KCP15A	H10
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KTFSS25679HPGM KCP15A	H10
KTFSS25700HPGM KCP15A	H10
KTFSS25800HPGM KCP15A	H10
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KTFSS25900HPGM KCP15A	H10
KTFSS26000HPGM KCP15A	H10
KTFST06000HPCM KC7410	H12
KTFST06000HPLM KCMS15	H14
KTFST06200HPCM KC7410	H12
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KTFST06350HPLM KCMS15	H14
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KTFST06700HPCM KC7410	H12
KTFST06746HPCM KC7410	H12
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KTFST06800HPLM KCMS15	H14
KTFST07000HPCM KC7410	H12
KTFST07000HPLM KCMS15	H14
KTFST07145HPCM KC7410	H12
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KTFST07500HPCM KC7410	H12
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KTFST08204HPLM KCMS15	H14
KTFST08334HPLM KCMS15	H14
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KTFST16100HPLM KCMS15	H15
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KTFST16104HPLM KCMS15	H15
KTFST16150HPLM KCMS15	H15
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KTFST16271HPCM KC7410	H13
KTFST16271HPLM KCMS15	H15
KTFST16300HPCM KC7410	H13
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KTFST16500HPLM KCMS15	H15
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KTFST16600HPCM KC7410	H13
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KTFST16670HPLM KCMS15	H15
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KTFST17000HPLM KCMS15	H15
KTFST17066HPCM KC7410	H13
KTFST17100HPCM KC7410	H13
KTFST17200HPCM KC7410	H13
KTFST17300HPCM KC7410	H13
KTFST17463HPCM KC7410	H13
KTFST17463HPLM KCMS15	H15
KTFST17480HPLM KCMS15	H15
KTFST17500HPCM KC7410	H13
KTFST17500HPLM KCMS15	H15
KTFST17550HPCM KC7410	H13
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KTFST17700HPLM KCMS15	H15
KTFST17800HPCM KC7410	H13
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KTFST18000HPLM KCMS15	H15
KTFST18100HPCM KC7410	H13
KTFST18258HPCM KC7410	H13
KTFST18258HPLM KCMS15	H15
KTFST18500HPCM KC7410	H13
KTFST18500HPLM KCMS15	H15
KTFST18600HPCM KC7410	H13
KTFST18654HPLM KCMS15	H15
KTFST18700HPCM KC7410	H13
KTFST19000HPCM KC7410	H13
KTFST19000HPLM KCMS15	H15
KTFST19050HPCM KC7410	H13
KTFST19050HPLM KCMS15	H15
KTFST19200HPLM KCMS15	H15
KTFST19228HPLM KCMS15	H15
KTFST19253HPLM KCMS15	H15
KTFST19279HPCM KC7410	H13
KTFST19279HPLM KCMS15	H15
KTFST19355HPLM KCMS15	H15
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KTFST19446HPLM KCMS15	H15
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KTFST19500HPLM KCMS15	H15
KTFST19800HPCM KC7410	H13
KTFST19845HPLM KCMS15	H15
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KTFST20000HPLM KCMS15	H15
KTFST20241HPCM KC7410	H13
KTFST20300HPCM KC7410	H13
KTFST20500HPCM KC7410	H13
KTFST20500HPLM KCMS15	H15
KTFST20638HPCM KC7410	H13
KTFST20638HPLM KCMS15	H15
KTFST21000HPCM KC7410	H13
KTFST21000HPLM KCMS15	H15
KTFST21150HPLM KCMS15	H15
KTFST21433HPCM KC7410	H13
KTFST21500HPCM KC7410	H13
KTFST21500HPLM KCMS15	H15
KTFST22000HPCM KC7410	H13
KTFST22000HPLM KCMS15	H15
KTFST22225HPCM KC7410	H13
KTFST22225HPLM KCMS15	H15
KTFST22440HPCM KC7410	H13
KTFST22500HPCM KC7410	H13
KTFST22500HPLM KCMS15	H15
KTFST23000HPCM KC7410	H13
KTFST23000HPLM KCMS15	H15
KTFST23416HPCM KC7410	H13
KTFST23500HPCM KC7410	H13
KTFST23500HPLM KCMS15	H15
KTFST23813HPCM KC7410	H13
KTFST23813HPLM KCMS15	H15
KTFST24000HPCM KC7410	H13
KTFST24000HPLM KCMS15	H15
KTFST24500HPCM KC7410	H13
KTFST24500HPLM KCMS15	H15
KTFST24608HPCM KC7410	H13
KTFST25000HPCM KC7410	H13
KTFST25000HPLM KCMS15	H15
KTFST25070HPCM KC7410	H13
KTFST25400HPCM KC7410	H13
KTFST25400HPLM KCMS15	H15
KTFST25500HPCM KC7410	H13
KTFST25500HPLM KCMS15	H15
KTFST25600HPLM KCMS15	H15
KTFST25650HPLM KCMS15	H15
KTFST25679HPCM KC7410	H13
KTFST25679HPLM KCMS15	H15
KTFST25806HPCM KC7410	H13
KTFST25806HPLM KCMS15	H15
KTFST26000HPCM KC7410	H13
KTFST26000HPLM KCMS15	H15
KTIP0794FEGM KCPM45	H29
KTIP0794HPM KCP15	H26
KTIP0800FEGM KCPM45	H29
KTIP0800HPM KCP15	H26
KTIP080R12SS10M	H31
KTIP080R1SCF12M	H32
KTIP080R1SS10M	H31
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KTIP080R3SS10M	H31
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KTIP080R5BF09M	I13
KTIP080R5SCF12M	H32
KTIP080R5SS10M	H31
KTIP080R8SCF12M	H32
KTIP080R8SS10M	H31
KTIP0810HPM KCP15	H26
KTIP0816HPM KCP15	H26
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KTIP0850HPM KCP15	H26
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KTIP085R4BF09M	I12
KTIP085R5BF09M	I13
KTIP085R5SCF12M	H32
KTIP085R5SS10M	H31
KTIP085R8SCF12M	H32
KTIP085R8SS10M	H31
KTIP0860HPM KCP15	H26
KTIP0861HPM KCP15	H26
KTIP0870HPM KCP15	H26

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
KTIP0873HPM KCP15	H26
KTIP0880HPM KCP15	H26
KTIP0884HPM KCP15	H26
KTIP0890HPM KCP15	H26
KTIP0900FEGM KCPM45	H29
KTIP0900HPM KCP15	H26
KTIP0909HPM KCP15	H26
KTIP090R12SS10M	H31
KTIP090R1SCF12M	H32
KTIP090R1SS10M	H31
KTIP090R3BF09M	I11
KTIP090R3BF10M	I11
KTIP090R3SCF12M	H32
KTIP090R3SS10M	H31
KTIP090R4BF10M	I12
KTIP090R5BF10M	I13
KTIP090R5SCF12M	H32
KTIP090R5SS10M	H31
KTIP090R8SCF12M	H32
KTIP090R8SS10M	H31
KTIP0910HPM KCP15	H26
KTIP0913FEGM KCPM45	H29
KTIP0913HPM KCP15	H26
KTIP0920HPM KCP15	H26
KTIP0930HPM KCP15	H26
KTIP0935HPM KCP15	H26
KTIP0940HPM KCP15	H26
KTIP0950FEGM KCPM45	H29
KTIP0950HPM KCP15	H26
KTIP0953HPM KCP15	H26
KTIP0956HPM KCP15	H26
KTIP0958HPM KCP15	H26
KTIP095R12SS10M	H31
KTIP095R1SCF12M	H32
KTIP095R1SS10M	H31
KTIP095R3BF10M	I11
KTIP095R3SCF12M	H32
KTIP095R3SS10M	H31
KTIP095R4BF10M	I12
KTIP095R5BF10M	I13
KTIP095R5SCF12M	H32
KTIP095R5SS10M	H31
KTIP095R8SCF12M	H32
KTIP095R8SS10M	H31
KTIP0960HPM KCP15	H26
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KTIP0992HPM KCP15	H26
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KTIP1000HPM KCP15	H26
KTIP1002HPM KCP15	H26
KTIP1008HPM KCP15	H26
KTIP100R12SS12M	H31
KTIP100R1SCF16M	H32
KTIP100R1SS12M	H31
KTIP100R3BF10M	I11
KTIP100R3BF11M	I11
KTIP100R3SCF16M	H32
KTIP100R3SS12M	H31
KTIP100R4BF11M	I12
KTIP100R5BF11M	I13
KTIP100R5SCF16M	H32
KTIP100R5SS12M	H31
KTIP100R8SCF16M	H32
KTIP100R8SS12M	H31
KTIP1010FEGM KCPM45	H29
KTIP1010HPM KCP15	H26
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KTIP1030HPM KCP15	H26
KTIP1032HPM KCP15	H26
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KTIP1050FEGM KCPM45	H29
KTIP1050HPM KCP15	H26
KTIP105R12SS12M	H31
KTIP105R1SCF16M	H32
KTIP105R1SS12M	H31
KTIP105R3BF11M	I11
KTIP105R3SCF16M	H32
KTIP105R3SS12M	H31
KTIP105R4BF11M	I12
KTIP105R5BF11M	I13
KTIP105R5SCF16M	H32
KTIP105R5SS12M	H31
KTIP105R8SCF16M	H32
KTIP105R8SS12M	H31
KTIP1060HPM KCP15	H26
KTIP1070HPM KCP15	H26
KTIP1072HPM KCP15	H26
KTIP1080FEGM KCPM45	H29
KTIP1080HPM KCP15	H26
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KTIP1100FEGM KCPM45	H29
KTIP1100HPM KCP15	H26
KTIP110R12SS12M	H31
KTIP110R1SCF16M	H32
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KTIP110R3BF11M	I11
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KTIP110R3SCF16M	H32
KTIP110R3SS12M	H31
KTIP110R4BF12M	I12
KTIP110R5BF12M	I13
KTIP110R5SCF16M	H32
KTIP110R5SS12M	H31
KTIP110R8SCF16M	H32
KTIP110R8SS12M	H31
KTIP1110HPM KCP15	H26
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KTIP1120HPM KCP15	H26
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KTIP1150FEGM KCPM45	H29
KTIP1150HPM KCP15	H26
KTIP1151HPM KCP15	H26
KTIP115R12SS12M	H31
KTIP115R1SCF16M	H32
KTIP115R1SS12M	H31
KTIP115R3BF12M	I11
KTIP115R3SCF16M	H32
KTIP115R3SS12M	H31
KTIP115R4BF12M	I12
KTIP115R5BF12M	I13
KTIP115R5SCF16M	H32
KTIP115R5SS12M	H31
KTIP115R8SCF16M	H32
KTIP115R8SS12M	H31
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KTIP1161HPM KCP15	H26
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KTIP1200HPM KCP15	H27
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KTIP120R8SCF16M	H32
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KTIP125R5SS14M	H31
KTIP125R8SCF16M	H32
KTIP125R8SS14M	H31
KTIP1260HPM KCP15	H27
KTIP1270FEGM KCPM45	H29
KTIP1270HPM KCP15	H27
KTIP1280HPM KCP15	H27
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KTIP1300FEGM KCPM45	H29
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KTIP130R3BF13M	I11
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KTIP130R3SS14M	H31
KTIP130R4BF14M	I12
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KTIP130R5SCF16M	H32
KTIP130R5SS14M	H31
KTIP130R8SCF16M	H32
KTIP130R8SS14M	H31
KTIP1310HPM KCP15	H27
KTIP1320HPM KCP15	H27
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KTIP1350HPM KCP15	H27
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KTIP135R1SCF16M	H32
KTIP135R1SS14M	H31
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KTIP135R3SCF16M	H32
KTIP135R3SS14M	H31
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KTIP135R5BF14M	I13
KTIP135R5SCF16M	H32
KTIP135R5SS14M	H31
KTIP135R8SCF16M	H32
KTIP135R8SS14M	H31
KTIP1360HPM KCP15	H27
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KTIP1400HPM KCP15	H27
KTIP140R12SS16M	H31
KTIP140R1SCF16M	H32
KTIP140R1SS16M	H31
KTIP140R3BF14M	I11
KTIP140R3BF15M	I11
KTIP140R3SCF16M	H32
KTIP140R3SS16M	H31
KTIP140R4BF15M	I12
KTIP140R5BF15M	I13
KTIP140R5SCF16M	H32
KTIP140R5SS16M	H31
KTIP140R8SCF16M	H32
KTIP140R8SS16M	H31
KTIP1410HPM KCP15	H27
KTIP1420HPM KCP15	H27
KTIP1429HPM KCP15	H27
KTIP1430HPM KCP15	H27
KTIP1440HPM KCP15	H27
KTIP1450FEGM KCPM45	H29
KTIP1450HPM KCP15	H27
KTIP145R12SS16M	H31
KTIP145R1SCF16M	H32
KTIP145R1SS16M	H31
KTIP145R3BF15M	I11
KTIP145R3SCF16M	H32
KTIP145R3SS16M	H31
KTIP145R4BF15M	I12
KTIP145R5BF15M	I13
KTIP145R5SCF16M	H32
KTIP145R5SS16M	H31
KTIP145R8SCF16M	H32
KTIP145R8SS16M	H31
KTIP1460HPM KCP15	H27
KTIP1467HPM KCP15	H27
KTIP1468HPM KCP15	H27
KTIP1470HPM KCP15	H27
KTIP1480HPM KCP15	H27
KTIP1490FEGM KCPM45	H29
KTIP1490HPM KCP15	H27
KTIP1500FEGM KCPM45	H29
KTIP1500HPM KCP15	H27
KTIP1508HPM KCP15	H27
KTIP150R12SS16M	H31
KTIP150R1SCF20M	H32
KTIP150R1SS16M	H31
KTIP150R3BF15M	I11
KTIP150R3BF16M	I11
KTIP150R3SCF20M	H32
KTIP150R3SS16M	H31
KTIP150R4BF16M	I12
KTIP150R5BF16M	I13
KTIP150R5SCF20M	H32
KTIP150R5SS16M	H31
KTIP150R8SCF20M	H32
KTIP150R8SS16M	H31
KTIP1510HPM KCP15	H27
KTIP1520HPM KCP15	H27
KTIP1530HPM KCP15	H27
KTIP1538HPM KCP15	H27
KTIP1540HPM KCP15	H27
KTIP1548HPM KCP15	H27
KTIP1550FEGM KCPM45	H29
KTIP1550HPM KCP15	H27
KTIP1560HPM KCP15	H27
KTIP1570HPM KCP15	H27
KTIP1580HPM KCP15	H27
KTIP1588HPM KCP15	H27
KTIP1595FEGM KCPM45	H29
KTIP1600FEGM KCPM45	H29
KTIP1600HPM KCP15	H27
KTIP1603HPM KCP15	H27
KTIP1608HPM KCP15	H27
KTIP160R12SS18M	H31
KTIP160R1SCF20M	H32
KTIP160R1SS18M	H31
KTIP160R3BF16M	I11
KTIP160R3BF17M	I11
KTIP160R3SCF20M	H32
KTIP160R3SS18M	H31
KTIP160R4BF17M	I12
KTIP160R5BF17M	I13
KTIP160R5SCF20M	H32
KTIP160R5SS18M	H31
KTIP160R8SCF20M	H32
KTIP160R8SS18M	H31
KTIP1610HPM KCP15	H27
KTIP1620HPM KCP15	H27
KTIP1627HPM KCP15	H27
KTIP1630HPM KCP15	H27
KTIP1640HPM KCP15	H27
KTIP1650FEGM KCPM45	H29
KTIP1650HPM KCP15	H27
KTIP1660HPM KCP15	H27
KTIP1667HPM KCP15	H27
KTIP1670HPM KCP15	H27
KTIP1680HPM KCP15	H27
KTIP1690HPM KCP15	H27
KTIP1700FEGM KCPM45	H29
KTIP1700HPM KCP15	H27
KTIP1707HPM KCP15	H27
KTIP170R12SS18M	H31
KTIP170R1SCF20M	H32
KTIP170R1SS18M	H31
KTIP170R3BF17M	I11
KTIP170R3BF18M	I11
KTIP170R3SCF20M	H32
KTIP170R3SS18M	H31
KTIP170R4BF18M	I12

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
KTIP170R5BF18M	I13
KTIP170R5SCF20M	H32
KTIP170R5SS18M	H31
KTIP170R8SCF20M	H32
KTIP170R8SS18M	H31
KTIP1710HPM KCP15	H27
KTIP1720HPM KCP15	H27
KTIP1730HPM KCP15	H27
KTIP1740HPM KCP15	H27
KTIP1748HPM KCP15	H27
KTIP1750FEGM KCPM45	H29
KTIP1750HPM KCP15	H27
KTIP1760HPM KCP15	H27
KTIP1770FEGM KCPM45	H29
KTIP1770HPM KCP15	H27
KTIP1780HPM KCP15	H27
KTIP1786HPM KCP15	H27
KTIP1790HPM KCP15	H27
KTIP1800FEGM KCPM45	H29
KTIP1800HPM KCP15	H27
KTIP180R12SS20M	H31
KTIP180R1SCF25M	H32
KTIP180R1SS20M	H31
KTIP180R3BF18M	I11
KTIP180R3SCF25M	H32
KTIP180R3SS20M	H31
KTIP180R4BF18M	I12
KTIP180R5BF18M	I13
KTIP180R5SCF25M	H32
KTIP180R5SS20M	H31
KTIP180R8SCF25M	H32
KTIP180R8SS20M	H31
KTIP1810HPM KCP15	H27
KTIP1820HPM KCP15	H27
KTIP1826HPM KCP15	H27
KTIP1830HPM KCP15	H27
KTIP1840HPM KCP15	H27
KTIP1850FEGM KCPM45	H29
KTIP1850HPM KCP15	H27
KTIP1860HPM KCP15	H27
KTIP1865HPM KCP15	H27
KTIP1870HPM KCP15	H27
KTIP1880HPM KCP15	H27
KTIP1890HPM KCP15	H27
KTIP1900FEGM KCPM45	H29
KTIP1900HPM KCP15	H27
KTIP1905FEGM KCPM45	H29
KTIP1905HPM KCP15	H27
KTIP190R12SS20M	H31
KTIP190R1SCF25M	H32
KTIP190R1SS20M	H31
KTIP190R3SCF25M	H32
KTIP190R3SS20M	H31
KTIP190R5SCF25M	H32
KTIP190R5SS20M	H31
KTIP190R8SCF25M	H32
KTIP190R8SS20M	H31
KTIP1910HPM KCP15	H27
KTIP1920HPM KCP15	H27
KTIP1923HPM KCP15	H27
KTIP1925HPM KCP15	H27
KTIP1930HPM KCP15	H27
KTIP1935HPM KCP15	H27
KTIP1940HPM KCP15	H27
KTIP1946HPM KCP15	H27
KTIP1950FEGM KCPM45	H29
KTIP1950HPM KCP15	H27
KTIP1960HPM KCP15	H27
KTIP1970HPM KCP15	H28
KTIP1980HPM KCP15	H28
KTIP1984HPM KCP15	H28
KTIP1990HPM KCP15	H28
KTIP2000FEGM KCPM45	H29
KTIP2000HPM KCP15	H28
KTIP200R12SS25M	H31
KTIP200R1SCF25M	H32
KTIP200R1SS25M	H31
KTIP200R3SCF25M	H32
KTIP200R3SS25M	H31
KTIP200R5SCF25M	H32
KTIP200R5SS25M	H31
KTIP200R8SCF25M	H32
KTIP200R8SS25M	H31
KTIP2010HPM KCP15	H28
KTIP2020HPM KCP15	H28
KTIP2024HPM KCP15	H28
KTIP2030HPM KCP15	H28
KTIP2050HPM KCP15	H28
KTIP2060HPM KCP15	H28
KTIP2064HPM KCP15	H28
KTIP2070HPM KCP15	H28
KTIP2080HPM KCP15	H28
KTIP2090HPM KCP15	H28
KTIP2099HPM KCP15	H28
KTIP2100HPM KCP15	H28
KTIP210R12SS25M	H31
KTIP210R1SCF25M	H32
KTIP210R1SS25M	H31
KTIP210R3SCF25M	H32
KTIP210R3SS25M	H31
KTIP210R5SCF25M	H32
KTIP210R5SS25M	H31
KTIP210R8SCF25M	H32
KTIP210R8SS25M	H31
KTIP2110HPM KCP15	H28
KTIP2143HPM KCP15	H28
KTIP2150HPM KCP15	H28
KTIP2200HPM KCP15	H28
KTIP220R12SS25M	H31
KTIP220R1SCF25M	H32
KTIP220R1SS25M	H31
KTIP220R3SCF25M	H32
KTIP220R3SS25M	H31
KTIP220R5SCF25M	H32
KTIP220R5SS25M	H31
KTIP220R8SCF25M	H32
KTIP220R8SS25M	H31
KTIP2223HPM KCP15	H28
KTIP2250HPM KCP15	H28
KTIP2280HPM KCP15	H28
KTIP2300HPM KCP15	H28
KTIP230R12SS25M	H31
KTIP230R1SCF25M	H32
KTIP230R1SS25M	H31
KTIP230R3SCF25M	H32
KTIP230R3SS25M	H31
KTIP230R5SCF25M	H32
KTIP230R5SS25M	H31
KTIP230R8SCF25M	H32
KTIP230R8SS25M	H31
KTIP2350HPM KCP15	H28
KTIP2381HPM KCP15	H28
KTIP2400HPM KCP15	H28
KTIP240R12SS25M	H31
KTIP240R1SCF25M	H32
KTIP240R1SS25M	H31
KTIP240R3SCF25M	H32
KTIP240R3SS25M	H31
KTIP240R5SCF25M	H32
KTIP240R5SS25M	H31
KTIP240R8SCF25M	H32
KTIP240R8SS25M	H31
KTIP2450HPM KCP15	H28
KTIP2461HPM KCP15	H28
KTIP2500HPM KCP15	H28
KTIP250R12SS32M	H31
KTIP250R1SCF25M	H32
KTIP250R1SS32M	H31
KTIP250R3SCF25M	H32
KTIP250R3SS32M	H31
KTIP250R5SCF25M	H32
KTIP250R5SS32M	H31
KTIP250R8SCF25M	H32
KTIP250R8SS32M	H31
KTIP2540HPM KCP15	H28
KTIP2550HPM KCP15	H28
KTIP2567HPM KCP15	H28
KTIP2581HPM KCP15	H28
KTIP2599HPM KCP15	H28
KTIP2600HPM KCP15	H28
KTIP260R12SS32M	H31
KTIP260R1SCF25M	H32
KTIP260R1SS32M	H31
KTIP260R3SCF25M	H32
KTIP260R3SS32M	H31
KTIP260R5SCF25M	H32
KTIP260R5SS32M	H31
KTIP260R8SCF25M	H32
KTIP260R8SS32M	H31
KTIP2619HPM KCP15	H28
KTIP2650HPM KCP15	H28
KTIP2659HPM KCP15	H28
KTIP2700HPM KCP15	H28
KTIP270R12SS32M	H31
KTIP270R1SCF25M	H32
KTIP270R1SS32M	H31
KTIP270R3SCF25M	H32
KTIP270R3SS32M	H31
KTIP270R5SCF25M	H32
KTIP270R5SS32M	H31
KTIP270R8SCF25M	H32
KTIP270R8SS32M	H31
KTIP2750HPM KCP15	H28
KTIP2778HPM KCP15	H28
KTIP2799HPM KCP15	H28
KTMDU11L0515N60 KC610M	W32
KTMDU11L0515N60 KC635M	W32
KTMDU11L1107N55 KC610M	W32
KTMDU11L1107N55 KC635M	W32
KTMDU11L1520N60 KC610M	W32
KTMDU11L1520N60 KC635M	W32
KTMDU11L1612N55 KC610M	W32
KTMDU11L1612N55 KC635M	W32
KTMDU11L2025N60 KC610M	W32
KTMDU11L2025N60 KC635M	W32
KTMDU11L2525N60 KC610M	W32
KTMDU11L2525N60 KC635M	W32
KTMDU11L2540N60 KC610M	W32
KTMDU11L2540N60 KC635M	W32
KTMDU11L4816N55 KC610M	W32
KTMDU11L4816N55 KC635M	W32
KTMDU16L0604N55 KC610M	W36
KTMDU16L0604N55 KC635M	W36
KTMDU16L1107N55 KC610M	W36
KTMDU16L1107N55 KC635M	W36
KTMDU16L1520N60 KC610M	W36
KTMDU16L1520N60 KC635M	W36
KTMDU16L1612N55 KC610M	W36
KTMDU16L2535N60 KC610M	W36
KTMDU16L2535N60 KC635M	W36
KTMDU16L4060N60 KC610M	W36
KTMDU16L4060N60 KC635M	W36
KTMDUCD15L060Z1	W30
KTMDUCD17L065Z2	W30
KTMDUCD20L080Z2	W30
KTMDUED23L086Z2	W31
KTMDUED26L105Z3	W31
KTMDUED31L115Z4	W31
KTMDUED36L144Z3	W34
KTMDUSCREW1	W29–31
KTMDUSD42L400Z4	W35
KTMDUSD48L400Z5	W35
KTMDUSD56L400Z6	W35
KTMDUWD15L040Z1	W29
KTMDUWD20L060Z2	W29
KTMDUWD23L070Z2	W29
KTMDUWD26L080Z3	W29
KTMDUWD31L095Z4	W29
KTMDUWD36L095Z3	W34
KTMDUWD42L120Z4	W34
KTMS21S25SD06H	U3
KTMS25S25SD06H	U3
KTMS32S32SD08H	U3
KTMS40S32SD12H	U3
KTMS50S32SD12H	U3
KUAM20	B199–205, B229, B260–262
KUAM22	B70–72, B92, B115–119, B139–141, B375, B378
KUAM23	B73, B183, B229, B235–237, B260–263, C171, D41–42
KUAM25	B70–72, B92–93, B115–117, B119, B139–141, B183, B235, B378
KUAM26	B72, C171, D41–42
KUAM27	B72, B115, B119, T81
KUAM28	B70, B73, B115–121, B142, B199, B202, B220–221, B240–242, B260–263, B376–378
KUAM30	B70, B115–119, B199, B202, B220–221, B240–242, B260–263, B376–378
KUAM31	B70–73, B92, B115–121, B139–142, B183, B229, B235–237, B260–263, B375, B378, C171, D41–42
KUAM32	B70–73, B92–93, B115–117, B119, B139–141, B183, B235, B378
KUAM33	B119, B141, C171, D41–42
KUAM34	B199–205, B229, B260–262
KUAM35	B199, B202, B204–205
KW1008	V146–147
L08KSCLPR06	B198
L08KSTFPL09	B259
L08KSTFPR09	B259
L10MSCLPR06	B198
L12QSCLPL06	B198
L12QSCLPR06	B198
L12QSDUPL07	B219
L12QSDUPR07	B219
L12QSTFPR11	B259
L16RSCLPL09	B198
L16RSCLPR09	B198
L20SSCLPL09	B198
L20SSCLPR09	B198
L20SSDUPR11	B219
LK90SD1218	U41
LK90SD1220	U47
LNEQ1235R03 4 KC725M	U20
LNEQ1235R03 4 KCK15	U20
LNEQ1240R03 4 KC725M	U20
LNEQ1240R03 4 KCPK30	U20
LNEQ1245R04 KC520M	U20
LNEQ1245R04 KC725M	U20
LNEQ1245R04 KCK15	U20
LNEQ1245R04 KCPK30	U20
LNEQ1250R04 KCK15	U20
LNEQ1255R04 KC725M	U20
LNEQ1255R04 KCK15	U20
LNEQ1260R04 KC725M	U20
LNEQ1260R04 KCK15	U20
LNEQ1260R04 KCPM40	U20
LNEU1235R03 4 KC520M	U19
LNEU1235R03 4 KC725M	U19
LNEU1235R03 4 KCPM40	U19
LNEU1235R03SGP 4 KC725M	U20
LNEU1240R03 4 KC520M	U19
LNEU1240R03 4 KC725M	U19
LNEU1240R03 4 KCPM40	U19
LNEU1240R03SGP 4 KC725M	U20
LNEU1240R08 4 KC520M	U19
LNEU1240R08 4 KC725M	U19
LNEU1240R08 4 KCPM40	U19
LNEU1240R16 4 KC725M	U19
LNEU1245R04 KC520M	U19
LNEU1245R04 KC725M	U19
LNEU1245R04 KCPK30	U19
LNEU1245R04 KCPM40	U19
LNEU1245R04SGP KC725M	U20
LNEU1245R08 KC520M	U19
LNEU1245R08 KC725M	U19
LNEU1245R08 KCPM40	U19
LNEU1245R08SGP KC725M	U20
LNEU1245R08SGP KCPM40	U20
LNEU1245R16 KC520M	U19
LNEU1245R16 KC725M	U19
LNEU1245R16SGP KC725M	U20
LNEU1245R32 KC520M	U19
LNEU1245R32 KC725M	U19
LNEU1250R04 KC725M	U19
LNEU1250R04 KCPM40	U19
LNEU1250R04SGP KC725M	U20
LNEU1250R08 KC725M	U19
LNEU1250R08 KCPM40	U19
LNEU1250R08SGP KC725M	U20
LNEU1255R04 KC725M	U19
LNEU1255R04 KCPM40	U19
LNEU1255R08 KC520M	U19
LNEU1255R08 KC725M	U19

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
LNEU1255R08 KCPM40	U19
LNEU1255R16 KC725M	U19
LNEU1255R32 KC725M	U19
LNEU1260R04 KC725M	U19
LNEU1260R04 KCPM40	U19
LNGU110404ERGE KC522M	T8
LNGU110404ERGE KC725M	T8
LNGU110404ERGE KCPM40	T8
LNGU110404ERLEJ KC422M	T8
LNGU110404SRGE KC522M	T9
LNGU110404SRGE KCPM40	T9
LNGU110404SRGE KCSM40	T9
LNGU110408ERGE KC522M	T8
LNGU110408ERGE KC725M	T8
LNGU110408ERGE KCPM40	T8
LNGU110408ERGE KCSM30	T8
LNGU110408ERGE KCSM40	T8
LNGU110408ERLEJ KC422M	T8
LNGU110408SRGE KC522M	T9
LNGU110408SRGE KC725M	T9
LNGU110408SRGE KCK15	T9
LNGU110408SRGE KCPK30	T9
LNGU110408SRGE KCPM40	T9
LNGU110408SRGE KCSM40	T9
LNGU110408SRGEM KC520M	T9
LNGU110408SRGEM KC522M	T9
LNGU110408SRGEM KCK15	T9
LNGU110408SRGEM KCPK30	T9
LNGU110408SRGEM KCPM40	T9
LNGU110412ERGE KC522M	T8
LNGU110412ERGE KCPM40	T8
LNGU110412ERGE KCSM40	T8
LNGU110412SRGEM KC520M	T9
LNGU110412SRGEM KCK15	T9
LNGU110412SRGEM KCPK30	T9
LNGU110412SRGEM KCPM40	T9
LNGU110416SRGEM KC520M	T9
LNGU110416SRGEM KCK15	T9
LNGU110416SRGEM KCPK30	T9
LNGU110416SRGEM KCPM40	T9
LNGU15T604ERGE KC522M	T18
LNGU15T604ERGE KC725M	T18
LNGU15T604ERGE KCPM40	T18
LNGU15T604ERGE KCSM30	T18
LNGU15T604ERGEJ KC422M	T18
LNGU15T604SRGE KC520M	T19
LNGU15T604SRGE KC522M	T19
LNGU15T604SRGE KC725M	T19
LNGU15T604SRGE KCK15	T19
LNGU15T604SRGE KCPK30	T19
LNGU15T608ERGE KC522M	T18
LNGU15T608ERGE KC725M	T18
LNGU15T608ERGE KCPM40	T18
LNGU15T608ERGE KCSM30	T18
LNGU15T608ERGE KCSM40	T18
LNGU15T608ERGEJ KC422M	T18
LNGU15T608SRGE KC520M	T19
LNGU15T608SRGE KC522M	T19
LNGU15T608SRGE KC725M	T19
LNGU15T608SRGE KCK15	T19
LNGU15T608SRGE KCPK30	T19
LNGU15T608SRGE KCSM40	T19
LNGU15T608SRGEH KCSM40	T20
LNGU15T608SRGEM KC520M	T19
LNGU15T608SRGEM KCK15	T19
LNGU15T608SRGEM KCPK30	T19
LNGU15T608SRGEM KCPM40	T19
LNGU15T612ERGE KC522M	T18
LNGU15T612ERGE KC725M	T18
LNGU15T612ERGE KCPM40	T18
LNGU15T612ERGE KCSM30	T18
LNGU15T612ERGE KCSM40	T18
LNGU15T612SRGE KC520M	T19
LNGU15T612SRGE KC522M	T19
LNGU15T612SRGE KC725M	T19
LNGU15T612SRGE KCK15	T19
LNGU15T612SRGE KCPK30	T19
LNGU15T612SRGE KCSM40	T19
LNGU15T612SRGEM KC520M	T19
LNGU15T612SRGEM KCK15	T19
LNGU15T612SRGEM KCPM40	T19
LNGU15T616ERGE KC725M	T18
LNGU15T616ERGE KCPM40	T18
LNGU15T616ERGE KCSM30	T18
LNGU15T616SRGE KC520M	T19
LNGU15T616SRGE KC522M	T19
LNGU15T616SRGE KC725M	T19
LNGU15T616SRGE KCK15	T19
LNGU15T616SRGE KCPK30	T19
LNGU15T616SRGEM KC520M	T19
LNGU15T616SRGEM KCK15	T19
LNGU15T616SRGEM KCPK30	T19
LNGU15T616SRGEM KCPM40	T19
LNGU15T620SRGEM KC520M	T19
LNGU15T620SRGEM KCK15	T19
LNGU15T620SRGEM KCPK30	T19
LNGU15T620SRGEM KCPM40	T19
LNPU110408SRGE KC520M	T9
LNPU110408SRGE KC522M	T9
LNPU110408SRGE KC725M	T9
LNPU110408SRGE KCK15	T9
LNPU110408SRGE KCPK30	T9
LNPU110408SRGE KCPM40	T9
LNPU110412SRGE KC520M	T9
LNPU110412SRGE KC522M	T9
LNPU110412SRGE KC725M	T9
LNPU110412SRGE KCK15	T9
LNPU110412SRGE KCPK30	T9
LNPU110412SRGE KCPM40	T9
LNPU110416SRGE KC520M	T9
LNPU110416SRGE KC522M	T9
LNPU110416SRGE KC725M	T9
LNPU110416SRGE KCPK30	T9
LNPU110416SRGE KCPM40	T9
LNPU15T604SRGE KC520M	T19
LNPU15T604SRGE KC522M	T19
LNPU15T604SRGE KC725M	T19
LNPU15T604SRGE KCK15	T19
LNPU15T604SRGE KCPK30	T19
LNPU15T608SRGE KC520M	T19
LNPU15T608SRGE KC522M	T19
LNPU15T608SRGE KC725M	T19
LNPU15T608SRGE KCK15	T19
LNPU15T608SRGE KCPK30	T19
LNPU15T608SRGE KCPM40	T19
LNPU15T612SRGE KC520M	T19
LNPU15T612SRGE KC522M	T19
LNPU15T612SRGE KC725M	T19
LNPU15T612SRGE KCPK30	T19
LNPU15T612SRGE KCPM40	T19
LNPU15T616SRGE KCPM40	T19
LNPU15T620SRGE KC522M	T19
LNPU15T620SRGE KC725M	T19
LNPU15T620SRGE KCK15	T19
LNPU15T620SRGE KCPK30	T19
LNPU15T620SRGE KCPM40	T19
LNPU221012PNSLHD2 KC520M	S121, S123
LNPU221012PNSLHD2 KCPK30	S121, S123
LNPU221012PNSLHD2 KCPM40	S121, S123
LNPU221012PNSRHD KC725M	S121, S123
LNPU221012PNSRHD KCK15	S121, S123
LNPU221012PNSRHD KCPK30	S121, S123
LNPU221012PNSRHD KCPM40	S121, S123
LNPU221012PNSRHD2 KCPK30	S121, S123
LNPU221012PNSRHD2 KCPM40	S121, S123
LNPU221012PNSRHD2 KCSM40	S121, S123
LNPU2410ANSLHD2 KCPK30	S117
LNPU2410ANSLHD2 KCPM40	S117
LNPU2410ANSRHD KC725M	S117
LNPU2410ANSRHD KCK15	S117
LNPU2410ANSRHD KCPK30	S117
LNPU2410ANSRHD2 KCPK30	S117
LNPU2410ANSRHD2 KCPM40	S117
LNPU2410ANSRHD2 KCSM40	S117
LNUX191940RRF KCP10	E51
LNUX191940RRF KCP25	E51
LNUX191940RRH KCP10	E51
LNUX191940RRH KCP25	E51
LNUX191940RRP KCP10	E52
LNUX191940RRP KCP25	E52
LNUX191940RRSM KCP25B	E52
LNUX191940S-WT5 KCP25B	E53
LNUX191950RRF KCP10B	E48
LNUX191950RRF KCP25B	E48
LNUX191950RRP KCP10B	E48
LNUX191950RRP KCP25B	E48
LNUX301940RRF KCP10	E51
LNUX301940RRH KCP10B	E51
LNUX301940RRH KCP25	E51
LNUX301940RRP KCP25	E52
LNUX301940RRSM KCP10B	E52
LNUX301960RRP KCP10B	E48
LNUX301960RRP KCP25B	E48
LS103	S126
LSASL1212N16	D78
LSASL1616H16	D78
LSASL2020K16	D78
LSASL2525M16	D78
LSASL2525M22	D78
LSASR1212N16	D78
LSASR1616H16	D78
LSASR2020K16	D78
LSASR2525M16	D78
LSASR2525M22	D78
LSASR3232P16	D78
LSASR3232P22	D78
LSSL2020K16Q	D79
LSSL2525M16Q	D79
LSSL2525M22Q	D79
LSSL3232P16Q	D79
LSSLDH2525M16	D79
LSSR2020K16Q	D79
LSSR2525M16Q	D79
LSSR2525M22Q	D79
LSSR3232P16Q	D79
LSSR3232P22Q	D79
LSSRDH2020K16Q	D79
LSSRDH2525M16	D79
LSSRDH2525M22Q	D79
LT11NL10ISO KC5025	D70
LT11NL15ISO KC5025	D70
LT11NL32UN KC5025	D74
LT11NLA60 KC5025	D66
LT11NR05ISO KC5025	D70
LT11NR075ISO KC5025	D70
LT11NR075ISOCB KC5025	D71
LT11NR10ISO KC5025	D70
LT11NR10ISOCB KC5025	D71
LT11NR125ISO KC5025	D70
LT11NR125ISOCB KC5025	D71
LT11NR14BSPT KC5025	D69
LT11NR14NPT KC5010	D72
LT11NR14NPT KC5025	D72
LT11NR14NPTF KC5025	D72
LT11NR14UNJ KC5025	D75
LT11NR14W KC5025	D76
LT11NR15ISO KC5010	D70
LT11NR15ISO KC5025	D70
LT11NR15ISOCB KC5025	D71
LT11NR16UN KC5010	D74
LT11NR16UN KC5025	D74
LT11NR16UNCB KC5025	D75
LT11NR16UNJ KC5025	D75
LT11NR175ISO KC5025	D70
LT11NR18NPT KC5025	D72
LT11NR18UN KC5025	D74
LT11NR18UNCB KC5025	D75
LT11NR18UNJ KC5025	D75
LT11NR19W KC5025	D76
LT11NR20ISO KC5025	D70
LT11NR20UN KC5025	D74
LT11NR20UNCB KC5025	D75
LT11NR24UN KC5025	D74
LT11NR24UNCB KC5025	D75
LT11NR28UN KC5025	D74
LT11NR32UN KC5025	D74
LT11NR32UNCB KC5025	D75
LT11NR40UN KC5025	D74
LT11NRA55 KC5025	D65
LT11NRA60 KC5010	D66
LT11NRA60 KC5025	D66
LT11NRA60CB KC5025	D67
LT16EL05ISO KC5025	D57
LT16EL075ISO KC5025	D57
LT16EL10ISO KC5025	D57
LT16EL11W KC5025	D64
LT16EL125ISO KC5025	D57
LT16EL12UN KC5025	D62
LT16EL14UN KC5025	D62
LT16EL14W KC5025	D64
LT16EL15ISO KC5010	D57
LT16EL15ISO KC5025	D57
LT16EL16UN KC5025	D62
LT16EL16UNJ KC5025	D63
LT16EL175ISO KC5025	D57
LT16EL18UN KC5025	D62
LT16EL20ISO KC5025	D57
LT16EL20UN KC5025	D62
LT16EL24UN KC5025	D62
LT16EL25ISO KC5025	D57
LT16EL28UN KC5025	D62
LT16EL30ISO KC5025	D57
LT16EL8APIRD KC5025	D55
LT16EL8UN KC5025	D62
LT16ELA60 KC5025	D53
LT16ELAG55 KC5025	D52
LT16ELAG60 KC5025	D53
LT16ELG60 KC5025	D53
LT16ER05ISO KC5025	D57
LT16ER05ISOCB KC5010	D58
LT16ER05ISOCB KC5025	D58
LT16ER075ISO KC5025	D57
LT16ER075ISOCB KC5010	D58
LT16ER075ISOCB KC5025	D58
LT16ER10ACME KC5025	D54
LT16ER10APIRD KC5025	D55
LT16ER10ISO KC5010	D57
LT16ER10ISO KC5025	D57
LT16ER10ISOCB KC5010	D58
LT16ER10ISOCB KC5025	D58
LT16ER10STACME KC5025	D61
LT16ER10UN KC5025	D62
LT16ER10UNCB KC5025	D63
LT16ER10W KC5025	D64
LT16ER115NPT KC5010	D59
LT16ER115NPT KC5025	D59
LT16ER115NPTF KC5025	D60
LT16ER115NPTFCB KC5025	D60
LT16ER11BSPT KC5025	D56
LT16ER11W KC5010	D64
LT16ER11W KC5025	D64
LT16ER11WCB KC5025	D65
LT16ER125ISO KC5010	D57
LT16ER125ISO KC5025	D57
LT16ER125ISOCB KC5010	D58
LT16ER125ISOCB KC5025	D58
LT16ER12ACME KC5025	D54
LT16ER12STACME KC5025	D61
LT16ER12UN KC5010	D62
LT16ER12UN KC5025	D62
LT16ER12UNCB KC5010	D63
LT16ER12UNCB KC5025	D63
LT16ER12UNJ KC5010	D63
LT16ER12UNJ KC5025	D63
LT16ER12W KC5025	D64
LT16ER14BSPT KC5025	D56
LT16ER14NPT KC5010	D59
LT16ER14NPT KC5025	D59
LT16ER14NPTCB KC5010	D59
LT16ER14NPTCB KC5025	D59
LT16ER14NPTF KC5025	D60
LT16ER14UN KC5010	D62
LT16ER14UN KC5025	D62
LT16ER14UNCB KC5010	D63
LT16ER14UNCB KC5025	D63
LT16ER14UNJ KC5010	D63
LT16ER14UNJ KC5025	D63
LT16ER14W KC5010	D64
LT16ER14W KC5025	D64
LT16ER14WCB KC5010	D65
LT16ER14WCB KC5025	D65
LT16ER15ISO KC5010	D57
LT16ER15ISO KC5025	D57
LT16ER15ISOCB KC5010	D58
LT16ER15ISOCB KC5025	D58
LT16ER16ACME KC5025	D54
LT16ER16STACME KC5025	D61
LT16ER16UN KC5010	D62

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
LT16ER16UN KC5025	D62
LT16ER16UNCB KC5010	D63
LT16ER16UNCB KC5025	D63
LT16ER16UNJ KC5010	D63
LT16ER16UNJ KC5025	D63
LT16ER16W KC5025	D64
LT16ER175ISO KC5010	D57
LT16ER175ISO KC5025	D57
LT16ER175ISOCB KC5010	D58
LT16ER175ISOCB KC5025	D58
LT16ER18NPT KC5010	D59
LT16ER18NPT KC5025	D59
LT16ER18UN KC5010	D62
LT16ER18UN KC5025	D62
LT16ER18UNCB KC5010	D63
LT16ER18UNCB KC5025	D63
LT16ER18UNJ KC5010	D63
LT16ER18UNJ KC5025	D63
LT16ER18W KC5025	D64
LT16ER19W KC5010	D64
LT16ER19W KC5025	D64
LT16ER20ISO KC5010	D57
LT16ER20ISO KC5025	D57
LT16ER20ISOCB KC5010	D58
LT16ER20ISOCB KC5025	D58
LT16ER20UN KC5010	D62
LT16ER20UN KC5025	D62
LT16ER20UNCB KC5010	D63
LT16ER20UNCB KC5025	D63
LT16ER20UNJ KC5010	D63
LT16ER20UNJ KC5025	D63
LT16ER20W KC5025	D64
LT16ER24UN KC5010	D62
LT16ER24UN KC5025	D62
LT16ER24UNCB KC5010	D63
LT16ER24UNCB KC5025	D63
LT16ER24UNJ KC5025	D63
LT16ER24W KC5025	D64
LT16ER25ISO KC5010	D57
LT16ER25ISO KC5025	D57
LT16ER25ISOCB KC5025	D58
LT16ER27NPT KC5025	D59
LT16ER28UN KC5010	D62
LT16ER28UN KC5025	D62
LT16ER28UNCB KC5010	D63
LT16ER28UNCB KC5025	D63
LT16ER28UNJ KC5025	D63
LT16ER28W KC5025	D64
LT16ER2TR KC5025	D61
LT16ER30ISO KC5010	D57
LT16ER30ISO KC5025	D57
LT16ER30ISOCB KC5010	D58
LT16ER30ISOCB KC5025	D58
LT16ER32UN KC5010	D62
LT16ER32UN KC5025	D62
LT16ER32UNCB KC5010	D63
LT16ER32UNCB KC5025	D63
LT16ER32UNJ KC5025	D63
LT16ER36UN KC5025	D62
LT16ER3TR KC5025	D61
LT16ER40UN KC5025	D62
LT16ER48UN KC5025	D62
LT16ER6STACME KC5025	D61
LT16ER8ACME KC5025	D54
LT16ER8APIRD KC5025	D55
LT16ER8NPT KC5025	D59
LT16ER8RD KC5025	D60
LT16ER8STACME KC5025	D61
LT16ER8UN KC5025	D62
LT16ER8UNCB KC5010	D63
LT16ER8UNCB KC5025	D63
LT16ER8W KC5025	D64
LT16ER9W KC5025	D64
LT16ERA55 KC5025	D52
LT16ERA60 KC5010	D53
LT16ERA60 KC5025	D53
LT16ERAG55 KC5010	D52
LT16ERAG55 KC5025	D52
LT16ERAG60 KC5010	D53
LT16ERAG60CB KC5010	D53
LT16ERAG60CB KC5025	D53
LT16ERAG60K KU25T	D54
LT16ERG60 KC5010	D53
LT16ERG60 KC5025	D53
LT16NL10ISO KC5025	D70
LT16NL10UN KC5025	D74
LT16NL11W KC5025	D76
LT16NL12UN KC5025	D74
LT16NL15ISO KC5025	D70
LT16NL16UN KC5025	D74
LT16NL20ISO KC5025	D70
LT16NL25ISO KC5025	D70
LT16NL30ISO KC5025	D70
LT16NLA60 KC5025	D66
LT16NLAG60 KC5025	D66
LT16NLG60 KC5025	D66
LT16NR05ISO KC5025	D70
LT16NR075ISO KC5025	D70
LT16NR10ACME KC5025	D68
LT16NR10APIRD KC5025	D69
LT16NR10ISO KC5010	D70
LT16NR10ISO KC5025	D70
LT16NR10ISOCB KC5025	D71
LT16NR10STACME KC5025	D73
LT16NR10UN KC5025	D74
LT16NR10UNCB KC5025	D75
LT16NR10W KC5025	D76
LT16NR115NPT KC5010	D72
LT16NR115NPT KC5025	D72
LT16NR115NPTCB KC5025	D72
LT16NR11BSPT KC5025	D69
LT16NR11W KC5010	D76
LT16NR11W KC5025	D76
LT16NR11WCB KC5025	D76
LT16NR125ISO KC5025	D70
LT16NR12ACME KC5025	D68
LT16NR12STACME KC5025	D73
LT16NR12UN KC5010	D74
LT16NR12UN KC5025	D74
LT16NR12UNCB KC5025	D75
LT16NR12UNJ KC5025	D75
LT16NR12W KC5025	D76
LT16NR14BSPT KC5025	D69
LT16NR14NPT KC5025	D72
LT16NR14NPTCB KC5025	D72
LT16NR14NPTF KC5025	D72
LT16NR14STACME KC5025	D73
LT16NR14UN KC5025	D74
LT16NR14UNCB KC5025	D75
LT16NR14W KC5025	D76
LT16NR14WCB KC5025	D76
LT16NR15ISO KC5010	D70
LT16NR15ISO KC5025	D70
LT16NR15ISOCB KC5025	D71
LT16NR16STACME KC5025	D73
LT16NR16UN KC5025	D74
LT16NR16UNCB KC5025	D75
LT16NR16UNJ KC5025	D75
LT16NR16W KC5025	D76
LT16NR175ISO KC5025	D70
LT16NR18UN KC5025	D74
LT16NR18UNCB KC5025	D75
LT16NR19W KC5025	D76
LT16NR20ISO KC5010	D70
LT16NR20ISO KC5025	D70
LT16NR20ISOCB KC5025	D71
LT16NR20UN KC5025	D74
LT16NR20UNCB KC5025	D75
LT16NR20W KC5025	D76
LT16NR24UN KC5025	D74
LT16NR25ISO KC5025	D70
LT16NR25ISOCB KC5025	D71
LT16NR28UN KC5025	D74
LT16NR2TR KC5025	D73
LT16NR30ISO KC5010	D70
LT16NR30ISO KC5025	D70
LT16NR32UN KC5025	D74
LT16NR3TR KC5025	D73
LT16NR6STACME KC5025	D73
LT16NR8ACME KC5025	D68
LT16NR8APIRD KC5025	D69
LT16NR8NPT KC5025	D72
LT16NR8RD KC5025	D73
LT16NR8STACME KC5025	D73
LT16NR8UN KC5025	D74
LT16NR8UNCB KC5025	D75
LT16NR8W KC5025	D76
LT16NRA55 KC5025	D65
LT16NRA60 KC5010	D66
LT16NRA60 KC5025	D66
LT16NRAG55 KC5025	D65
LT16NRAG60 KC5010	D66
LT16NRAG60 KC5025	D66
LT16NRAG60CB KC5025	D67
LT16NRAG60K KU25T	D67
LT16NRG55 KC5025	D65
LT16NRG60 KC5010	D66
LT16NRG60 KC5025	D66
LT16NRG60CB KC5025	D67
LT22EL35ISO KC5025	D57
LT22ELN60 KC5025	D53
LT22ER35ISO KC5025	D57
LT22ER40ISO KC5025	D57
LT22ER45ISO KC5025	D57
LT22ER4API382 KC5025	D55
LT22ER4API502 KC5010	D55
LT22ER4API502 KC5025	D55
LT22ER4API503 KC5010	D55
LT22ER4TR KC5025	D61
LT22ER50ISO KC5025	D57
LT22ER5ACME KC5025	D54
LT22ER5API403 KC5010	D55
LT22ER5BUT75 KC5025	D56
LT22ER5STACME KC5025	D61
LT22ER5TR KC5025	D61
LT22ER6ACME KC5025	D54
LT22ER6RD KC5025	D60
LT22ER6W KC5025	D64
LT22ER7W KC5025	D64
LT22ERN55 KC5025	D52
LT22ERN60 KC5025	D53
LT22NLN60 KC5025	D66
LT22NR35ISO KC5025	D70
LT22NR40ISO KC5025	D70
LT22NR45ISO KC5025	D70
LT22NR4API382 KC5025	D68
LT22NR4API502 KC5025	D68
LT22NR4TR KC5025	D73
LT22NR50ISO KC5025	D70
LT22NR5ACME KC5025	D68
LT22NR5API403 KC5025	D68
LT22NR5BUT1 KC5025	D69
LT22NR5BUT75 KC5025	D69
LT22NR5TR KC5025	D73
LT22NR6ACME KC5025	D68
LT22NR6RD KC5025	D73
LT22NR7W KC5025	D76
LT22NRN55 KC5025	D65
LT22NRN60 KC5025	D66
LT27ER4API382 KC5025	D55
LT27ER4API502 KC5025	D55
LT27NR4API382 KC5025	D68
LT27NR4API502 KC5025	D68
M-13-M8-CA16-090 S	V35
M-13-M8-CA16-110 S	V35
M-13-M8-CA16-130 S	V35
M-13-M8-CA16-170 S	V35
M-18-M10-CA20-110 S	V35
M-18-M10-CA20-130 S	V35
M-18-M10-CA20-170 S	V35
M-18-M10-CA20-190 S	V35
M-21-M12-CA25-131 S	V35
M-21-M12-CA25-156 S	V35
M-21-M12-CA25-181 S	V35
M-21-M12-CA25-206 S	V35
M-21-M12-CA25-231 S	V35
M-29-M16-CA32-160 S	V35
M-29-M16-CA32-210 S	V35
M-29-M16-CA32-260 S	V35
M-29-M16-CA32-310 S	V35
M10 1.5 X 25 SHCS S	T88, V12, V21, V28, V89, V94
M10-JIC	C75
M12 X 1.75 X 30 SHCS S	T88, T115, T118, V12, V21, V28, V94
M16 X 2 X 40 SHCS S	T118, V21
M16X2X40 LHSCS S	V28
M1H20J02R28A20ED10C4	T40
M1H20J02R28M10ED10C4	T38
M1H20J02R36A20ED10C6	T40
M1H20J02R36B20ED10C6	T39
M1H25J02R28A25ED10C4	T40
M1H25J02R32M12ED10C4	T38
M1H25J02R46A25ED10C8	T40
M1H25J02R46B25ED10C8	T39
M1H32J02R28A32ED10C4	T40
M1H32J02R54B32ED10C10	T39
M1H32J03R28A32ED10C6	T40
M1H32J03R40M16ED10C6	T38
M1H32J03R54A32ED10C15	T40
M1H32J03R54B32ED10C15	T39
M1H32J2R50B32S90ED14C4	T57
M1H40J3R50B32S90ED14C6	T57
M1H40J3R65B32S90ED14C9	T57
M1H40J3R80B32S90ED14C12	T57
M1H40J4R80B32S90ED14C12	T57
M1H40T03R50A16ED10C12	T41
M1H40T05R50A16ED10C20	T41
M1H50J3R80B40S90ED14C12	T57
M1H50T03R60A22ED10C15	T41
M1H50T05R60A22ED10C25	T41
M1H50T3R50A22S90ED14C6	T58
M1H50T3R65A22S90ED14C9	T58
M1H63T3R50A27S90ED14C6	T58
M1H63T3R65A27S90ED14C9	T58
M1H63T3R75A27S90ED14C12	T58
M1H63T4R65A27S90ED14C12	T58
M1H63T5R75A27S90ED14C20	T59
M1HR125E14W125Z2L200C4	T65
M1HR150E14W125Z3L200C6	T65
M1HR150E14W125Z3L250C9	T65
M1HR150E14W125Z3L300C12	T65
M1HR200E14S075Z3L200C6	T65
M1HR200E14S075Z3L250C9	T65
M1HR200E14W150Z3L300C12	T65
M1HR250E14S100Z3L250C9	T65
M1HR250E14S100Z3L300C12	T65
M1HR250E14S100Z4L250C12	T65
M20 X 2.5 X 50 SHCS	T118, V21, V28
M4-11KITD16Z2A16EGEKC725M	T11
M4-11KITD16Z2A16SGEKCPM40	T11
M4-11KITD20Z2B20EGEKC725M	T11
M4-11KITD20Z2B20SGEKCPM40	T11
M4-11KITD20Z3A20EGEKC725M	T11
M4-11KITD20Z3A20SGEKCPM40	T11
M4-11KITD25Z3B20EGEKC725M	T11
M4-11KITD25Z3B25SGEKCPM40	T11
M4-11KITD25Z4A25EGEKC725M	T11
M4-11KITD25Z4A25SGEKCPM40	T11
M4-11KITD32Z4B32EGEKC725M	T11
M4-11KITD32Z4B32SGEKCPM40	T11
M4-11KITD32Z5A32EGEKC725M	T11
M4-11KITD32Z5A32SGEKCPM40	T11
M4-11KITD40Z4S16EGEKC725M	T11
M4-11KITD40Z4S16SGEKCPM40	T11
M4-11KITD40Z6S16EGEKC725M	T11
M4-11KITD40Z6S16SGEKCPM40	T11
M4-11KITD50Z5S22EGEKC725M	T11
M4-11KITD50Z5S22SGEKCPM40	T11
M4-11KITD50Z7S22EGEKC725M	T11
M4-11KITD50Z7S22SGEKCPM40	T11
M4-11KITD63Z9S22EGEKC725M	T11
M4-11KITD63Z9S22SGEKCPM40	T11
M4D016Z02A16LN11L090	T6, T11
M4D016Z02A16LN11L150	T6
M4D016Z02B16LN11	T5
M4D016Z02M08LN11	T4
M4D020Z02A20LN11L150	T6
M4D020Z02B20LN11	T5, T11
M4D020Z03A20LN11L090	T6, T11
M4D020Z03A20LN11L150	T6
M4D020Z03B20LN11	T5
M4D020Z03M10LN11	T4
M4D025Z02A25LN15L100	T16
M4D025Z02A25LN15L170	T16
M4D025Z02B25LN15	T15
M4D025Z02M12LN15	T14
M4D025Z03A25LN11L170	T6

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
M4D025Z03B25LN11	T5, T11
M4D025Z04A25LN11L100	T6, T11
M4D025Z04A25LN11L170	T6
M4D025Z04M12LN11	T4
M4D032Z03A32LN15L110	T16
M4D032Z03A32LN15L200	T16
M4D032Z03B32LN15	T15
M4D032Z03M16LN15	T14
M4D032Z04A32LN11L200	T6
M4D032Z04A32LN15L110	T16
M4D032Z04A32LN15L200	T16
M4D032Z04B32LN11	T5, T11
M4D032Z04M16LN15	T14
M4D032Z05A32LN11L110	T6, T11
M4D032Z05A32LN11L200	T6
M4D032Z05M16LN11	T4
M4D032Z06M16LN11	T4
M4D035Z04M16LN15	T14
M4D040Z03A32LN15L200	T16
M4D040Z03B32LN15	T15
M4D040Z04A32LN15L200	T16
M4D040Z04B32LN15	T15
M4D040Z04S16LN11	T7, T11
M4D040Z04S16LN15	T17
M4D040Z05A32LN11L200	T6
M4D040Z05B32LN11	T5
M4D040Z05M16LN15	T14
M4D040Z05S16LN15	T17
M4D040Z06S16LN11	T7, T11
M4D040Z07S16LN11	T7
M4D050Z04S22LN15	T17
M4D050Z05S22LN11	T7, T11
M4D050Z05S22LN15	T17
M4D050Z06S22LN15	T17
M4D050Z07S22LN11	T7, T11
M4D050Z09S22LN11	T7
M4D063Z05S22LN15	T17
M4D063Z06S22LN11	T7
M4D063Z06S22LN15	T17
M4D063Z07S22LN15	T17
M4D063Z09S22LN11	T7, T11
M4D080Z05S27LN15	T17
M4D080Z07S27LN15	T17
M4D080Z08S27LN11	T7
M4D080Z09S27LN15	T17
M4D080Z10S27LN11	T7
M4D100Z06S32LN15	T17
M4D100Z08S32LN15	T17
M4D100Z11S32LN15	T17
M4D125Z07S40LN15	T17
M4D125Z09S40LN15	T17
M4D125Z12S40LN15	T17
M4D160Z08S40LN15	T17
M4D160Z12S40LN15	T17
M4D160Z16S40LN15	T17
M4KITD100Z08S32SGEKCPM40	T21
M4KITD100Z11S32SGEMKC520M	T21
M4KITD25Z02A25EGEKC725M	T21
M4KITD25Z02A25SGEKCPM40	T21
M4KITD25Z02A25SGEMKC520M	T21
M4KITD32Z03A32EGEKC725M	T21
M4KITD32Z03A32SGEKCPM40	T21
M4KITD32Z03A32SGEMKC520M	T21
M4KITD40Z04S16EGEKC725M	T21
M4KITD40Z04S16SGEKCPM40	T21
M4KITD40Z04S16SGEMKC520M	T21
M4KITD50Z05S22EGEKC725M	T21
M4KITD50Z05S22SGEKCPM40	T21
M4KITD50Z05S22SGEMKC520M	T21
M4KITD50Z06S22EGEKC725M	T21
M4KITD50Z06S22SGEKCPM40	T21
M4KITD50Z06S22SGEMKC520M	T21
M4KITD63Z06S22EGEKC725M	T21
M4KITD63Z06S22SGEKCPM40	T21
M4KITD63Z07S22SGEMKC520M	T21
M4KITD80Z07S27EGEKC725M	T21
M4KITD80Z07S27SGEKCPM40	T21
M4KITD80Z09S27SGEMKC520M	T21
M6-JIC	C75
M8 1.25 X 25 SHCS	T88, V12, V89, V94
M8-JIC	C75
MB115RBHT12F	K120
MB115RBHT16LF	K120
MB115RBHT16LK	K121
MB24RBHT06F	K120
MB24RBHT06K	K121
MB30RBHT06F	K120
MB30RBHT06K	K121
MB40RBHT09F	K120
MB40RBHT09K	K121
MB50RBHT09F	K120
MB50RBHT09K	K121
MB66RBHT12F	K120
MB66RBHT12K	K121
MB66RBHT12LF	K120
MB66RBHT12LK	K121
MB87RBHT12F	K120
MB87RBHT12K	K121
MB87RBHT16LF	K120
MB87RBHT16LK	K121
MCC080001	V82
MCC0800HP	V82
MCCM16001	S62, V60, V82, V139
MCCM160HP	V82
MCFNL10CA09	B70
MCFNL12CA12	B70
MCFNR10CA09	B70
MCFNR12CA12	B70
MCFNR16CA12	B70
MCFNR20CA12	B70
MCKNL12CA12	B71
MCKNL2525M12	B61
MCKNL3225P16	B61
MCKNL3232P19	B61
MCKNR12CA12	B71
MCKNR16CA12	B71
MCKNR2525M12	B61
MCKNR3225P12	B61
MCKNR3225P16	B61
MCLNL12CA12	B72
MCLNL1616H09	B62
MCLNL1616H12	B62
MCLNL16CA12	B72
MCLNL2020K12	B62
MCLNL20CA12	B72
MCLNL2525M12	B62
MCLNL2525M16	B62
MCLNL2525M19	B62
MCLNL25CA19	B72
MCLNL3225P12	B62
MCLNL3225P16	B62
MCLNL3225P19	B62
MCLNL3232P12	B62
MCLNL3232P16	B62
MCLNL3232P19	B62
MCLNL4040R19	B62
MCLNR12CA12	B72
MCLNR1616H09	B62
MCLNR1616H12	B62
MCLNR16CA12	B72
MCLNR2020K09	B62
MCLNR2020K12	B62
MCLNR20CA12	B72
MCLNR2525M09	B62
MCLNR2525M12	B62
MCLNR2525M16	B62
MCLNR2525M19	B62
MCLNR25CA12	B72
MCLNR25CA16	B72
MCLNR25CA19	B72
MCLNR3225P12	B62
MCLNR3225P16	B62
MCLNR3225P19	B62
MCLNR3232P12	B62
MCLNR3232P16	B62
MCLNR3232P19	B62
MCLNR4040R19	B62
MCMNN2020K12	B63
MCMNN2525M12	B63
MCMNN3225P16	B63
MCMNN4040R19	B63
MCRNL2525M12	B63
MCRNL3225P12	B63
MCRNL3232P16	B63
MCRNL3232P19	B63
MCRNR2020K12	B63
MCRNR2525M12	B63
MCRNR3225P12	B63
MCRNR3232P16	B63
MCRNR3232P19	B63
MDHX1004ZDERGD K110M	S69
MDHX1004ZDERGD KC520M	S69
MDHX1004ZDERGD KTPK20	S69
MDHX1004ZDERGD4W K110M	S69
MDHX1004ZDERGD4W KC520M	S69
MDHX1004ZDERGD4W KTPK20	S69
MDHX1004ZDFLGD4W K110M	S69
MDHX1004ZDFLGD4W KC520M	S69
MDHX1004ZDFRGD4W K110M	S69
MDHX1004ZDFRGD4W KC520M	S69
MDHX1004ZDFRGD4W KTPK20	S69
MDJNL12CA11	B92
MDJNL16CA15	B92
MDJNL2020K11	B86
MDJNL2525M11	B86
MDJNL2525M15	B86
MDJNL3225P15	B86
MDJNL3232P15	B86
MDJNR12CA11	B92
MDJNR1616H11	B86
MDJNR16CA15	B92
MDJNR2020K11	B86
MDJNR2020K15	B86
MDJNR20CA15	B92
MDJNR2525M11	B86
MDJNR2525M15	B86
MDJNR3225P15	B86
MDJNR3232P15	B86
MDNNL2525M15	B86
MDNNL3225P15	B86
MDNNR2525M15	B86
MDNNR3225P15	B86
MDQNL16CA15	B93
MDQNL20CA15	B93
MDQNR16CA15	B93
MDQNR20CA15	B93
MEGA45D125B06LN24	S116
MEGA45D160C07LN24	S116
MEGA45D200C07LN24	S116
MEGA45D250C09LN24	S116
MEGA45D250C11LN24	S116
MEGA45D315C10LN24	S116
MEGA45D315C13LN24	S116
MEGA60D125B06LN22	S120
MEGA60D160C07LN22	S120
MEGA60D200C07LN22	S120
MEGA60D200C09LN22	S120
MEGA60D250C09LN22	S120
MEGA60D250C11LN22	S120
MEGA60D315C10LN22	S120
MEGA60D315C13LN22	S120
MEGA90D125B06LN22	S122
MEGA90D160C07LN22	S122
MEGA90D200C07LN22	S122
MEGA90D200C09LN22	S122
MEGA90D250C09LN22	S122
MEGA90D250C11LN22	S122
MEGA90D315C10LN22	S122
MEGA90D315C13LN22	S122
MILL16D050Z040N08SC	S34
MILL16D050Z050N08W	S32
MILL16D063Z040N08SC	S34
MILL16D063Z050N08SC	S34
MILL16D063Z060N08W	S32
MILL16D080Z050N08SC	S34
MILL16D080Z070N08SC	S34
MILL16D080Z080N08W	S32
MILL16D080Z100N08W	S32
MILL16D100Z060N08SC	S34
MILL16D100Z080N08SC	S34
MILL16D100Z100N08W	S32
MILL16D100Z140N08W	S32
MILL16D125Z080N08SC	S34
MILL16D125Z100N08SC	S34
MILL16D125Z140N08W	S32
MILL16D125Z180N08W	S32
MILL16D160Z100N08SC	S34
MILL16D160Z120N08SC	S34
MILL16D160Z160N08W	S32
MILL16D160Z220N08W	S32
MILL16D200Z100N08SC	S34
MILL16D200Z140N08SC	S34
MILL16D200Z200N08W	S32
MILL16D200Z280N08W	S32
MILL16D250Z120N08SC	S34
MILL16D250Z160N08SC	S34
MILL16D250Z240N08W	S32
MILL16D250Z340N08W	S32
MILL16D315Z440N08WSC	S33
MILL16D355Z480N08WSC	S33
MILL16D400Z560N08WSC	S33
MILL16D500Z700N08WSC	S33
MRGNL2525M12	B95
MRGNR2525M12	B95
MS-1896	K81
MS-2071	T14–17, V77–78
MS1025	C171, D41–42
MS1034	C170, D37
MS110	B174, B371
MS111	B170, B172–173, B353–355, E37, E41
MS1130	B386
MS1152	B260–262, J23, J25, J27, J29, J31, J33, J35, J37
MS1153	B179–182, B192–205, B210–213, B217–221, B227–229, B247–248, B257–263, B266–269, B271, K74–76, K81, K85
MS1154	B227–228
MS1155	B179–183, B194–199, B202, B209–210, B212–213, B217–219, B229, B233–235, B240–242, B257–258, B260–263, B266–269, B271
MS1156	B179–181, B209–211, B213, B227–228, B233–234, B247–248, B257, B266–268, B271, C114
MS1157	B182–183, B235–237
MS1158	B180, B182–183, B209–211, B213, B233–234
MS1160	B227, C36–37, C39–42, C46–48, C112–114, C120
MS1162	C46–48, C58–65, C129–135, S116, S120, S122, V82
MS1163	C58–65, C129–135
MS1198	S110, T58
MS1200	C166–170, D27–30, D36–37
MS1233	T58
MS1234CG	S21, V64
MS1235	T58, T109
MS1235CG	T80
MS1238	T58, T109
MS1241	T109
MS1242	S32, V49, V56, V60, V72, V78, V147
MS1242CG	T80, V72, V78, V82, V139
MS125	B172, B354, B378
MS1273	C46–47, T109
MS1276	J80
MS1280	U17–18
MS1282	U17–18
MS1284	U17
MS1285	C46–47
MS1294	B168, B370, S48, T50, V49, V64, V72
MS1294CG	V64, V72
MS1321	B168, B370
MS1336	V56, V72
MS1374	T79–81
MS1375	K85
MS1433	T58–59
MS1454	B187, K75
MS1488	D31, D33, D39–40
MS1489	D31–33, D39
MS1490	C37–40, C44–45, C112–113, D32
MS1499	B386
MS1556	T98, U32–34, V147
MS1559	T50, T72, U32–35, U44–49
MS1571	C122
MS1595	C36–37, C39–40, C43–44, C46–47, C112–115, C118–119

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
MS1861	H76
MS1933	B199, B202, B204–205, B257–259
MS1939	B182, B195–198, B271
MS1944	C39–40, C112–114
MS1970	C36–40, C43–45, C112–115, C118–119
MS2002	C58–65, C129–135
MS2038	S41, S60, S62, T33, T50, T72, T102, V49, V56, V60, V64, V72, V78
MS2038CG	S21, V64, V72, V78, V139
MS2060	S34
MS2072CG	S21, V72, V139
MS2077	U40–49, V70–72, V139
MS2078	S41, T102, U38–39
MS2089	C119
MS2090	C118
MS2091	C36–37, C39–40, C112–114, C118
MS2111	C166–169, D27–30, D36
MS2126	T69–72
MS2148	T57–59, T97–98, U25–35
MS2166	T47–50
MS2167	T47–49
MS2173	B199, B202, B204–205
MS2175	B199–205, B229, B260–262
MS2187C	S62, T17, V60, V78, V82, V139
MS2188C	V82
MS2189C	S10, S14, S17, S21, S25, S48, S53, S60, S62, T17, V139
MS2190CG	V82
MS2191C00	T58–59, V72, V137–138, V140
MS2191C06	T58–59, V137–138, V140
MS2191C08	T58–59, V137–138, V140
MS2191C12	T58–59, V137–140
MS2191C14	T58–59, V137–138, V140
MS2191C16	T58–59, V137–138, V140
MS2191C18	T58–59, V137–138, V140
MS2191C20	T57–59, V137–140
MS2195C	V56, V60, V72, V78
MS2197	V137–139
MS2205	T29–33, T38–41
MS2206	U3
MS2207	U3
MS2208	U3
MS2219	V38–40
MS2236	V114–115
MS2260	V60
MS2263	T4–7
MS319	B386
MS325	B386
MS326	B386
MS330	B386
MS337	B386
MS364	B72, B115, B119
MS412	B386, C171, D41–42, E38–40, E42–43
MS5001	W12–13
MS5002	W12
MS5003	W18–19, W25
MS5004	W12
MS518	E37–38, E40–42
MS524	E36, E40
MS624	E41
MS625	E37
MS9000	W17–19, W24–25
MS959	E36–43
MS960	B172–173, B354–355
MS961	B174, B371
MSBNL2020K12	B108
MSBNL2525M12	B108
MSBNL2525M15	B108
MSBNL3225P12	B108
MSBNL3232P15	B108
MSBNL3232P19	B108
MSBNL4040R19	B108
MSBNR2020K12	B108
MSBNR2525M12	B108
MSBNR2525M15	B108
MSBNR3225P12	B108
MSBNR3232P15	B108
MSBNR3232P19	B108
MSBNR4040R19	B108
MSDNN1616H09	B109
MSDNN2020K12	B109
MSDNN2525M12	B109
MSDNN2525M15	B109
MSDNN3225P12	B109
MSDNN3232P19	B109
MSKNL12CA12	B115
MSKNL20CA15	B115
MSKNL2525M12	B109
MSKNL3225P12	B109
MSKNL3232P15	B109
MSKNL3232P19	B109
MSKNR10CA09	B115
MSKNR12CA12	B115
MSKNR16CA12	B115
MSKNR20CA15	B115
MSKNR2525M12	B109
MSKNR25CA19	B115
MSKNR3232P19	B109
MSRNL12CA12	B116
MSRNL16CA12	B116
MSRNL20CA15	B116
MSRNR10CA09	B116
MSRNR12CA12	B116
MSRNR16CA12	B116
MSSNL10CA09	B117
MSSNL12CA12	B117
MSSNL2020K12	B110
MSSNL2525M12	B110
MSSNL3232P19	B110
MSSNR10CA09	B117
MSSNR12CA12	B117
MSSNR16CA12	B117
MSSNR2020K12	B110
MSSNR20CA15	B117
MSSNR2525M12	B110
MSSNR3232P19	B110
MSTNR10CA09	B118
MSTNR12CA12	B118
MSYNL10CA09	B119
MSYNL12CA12	B119
MSYNL20CA15	B119
MSYNR10CA09	B119
MSYNR12CA12	B119
MSYNR16CA12	B119
MSYNR25CA19	B119
MSZNL2525M12	B110
MSZNR2525M12	B110
MTANLS2525M16	B133
MTANRS2020K16	B133
MTANRS2525M16	B133
MTENNS2020K16	B133
MTENNS2525M16	B133
MTENNS2525M22	B133
MTENNS3225P22	B133
MTFNL12CA16	B139
MTFNL16CA16	B139
MTFNL2020K16	B134
MTFNL20CA22	B139
MTFNL2525M16	B134
MTFNR12CA16	B139
MTFNR16CA16	B139
MTFNR20CA22	B139
MTFNR2525M16	B134
MTGNL12CA16	B140
MTGNL20CA22	B140
MTGNL2525M16	B134
MTGNL2525M22	B134
MTGNL3232P22	B134
MTGNR12CA16	B140
MTGNR1616H16	B134
MTGNR16CA16	B140
MTGNR2525M16	B134
MTGNR2525M22	B134
MTGNR3232P22	B134
MTJNL2020K16H4	B136
MTJNL2525M16H4	B136
MTJNL2525M22H4	B136
MTJNL3225P16H4	B136
MTJNR2020K16H4	B136
MTJNR2525M16H4	B136
MTJNR2525M22H4	B136
MTJNR3225P16H4	B136
MTJNR3225P22H4	B136
MTUNL12CA16	B141
MTUNL16CA16	B141
MTUNR20CA22	B141
MVJNL2020K16	B151
MVJNL2525M16	B151
MVJNL3225P16	B151
MVJNL3225P22	B151
MVJNL3232P16	B151
MVJNR2020K16	B151
MVJNR2525M16	B151
MVJNR3225P16	B151
MVJNR3225P22	B151
MVJNR3232P16	B151
MVONL2525M16	B151
MVONR2525M16	B151
MVVNN2020K16	B152
MVVNN2525M16	B152
MVVNN2525M22	B152
MVVNN3225P16	B152
MW25	U27–35, V146–147
MW3	U40–49
MWLNL2020K06	B162
MWLNL2020K08H4	B162
MWLNL2525M06	B162
MWLNL2525M08H4	B162
MWLNL3225P08H4	B162
MWLNL3232P08	B162
MWLNR2020K06	B162
MWLNR2020K08H4	B162
MWLNR2525M06	B162
MWLNR2525M08H4	B162
MWLNR3225P08H4	B162
MWLNR3232P08	B162
NA3L10 KC5025	D12
NA3L10 KCU25	D12
NA3L12 KC5010	D12
NA3L12 KC5025	D12
NA3L16 KCU10	D12
NA3L4 K68	D12
NA3L4 KC5010	D12
NA3L4 KC5025	D12
NA3L4 KCU10	D12
NA3L4 KCU25	D12
NA3L5 KC5010	D12
NA3L5 KC5025	D12
NA3L5 KCU25	D12
NA3L6 KC5010	D12
NA3L6 KC5025	D12
NA3L6 KCU25	D12
NA3L8 KC5010	D12
NA3L8 KC5025	D12
NA3L8 KCU10	D12
NA3L8 KCU25	D12
NA3R10 KC5010	D12
NA3R10 KC5025	D12
NA3R10 KCU10	D12
NA3R10 KCU25	D12
NA3R12 KC5025	D12
NA3R12 KCU10	D12
NA3R16 KCU10	D12
NA3R4 KC5010	D12
NA3R4 KC5025	D12
NA3R4 KCU25	D12
NA3R5 KC5010	D12
NA3R5 KC5025	D12
NA3R5 KCU10	D12
NA3R5 KCU25	D12
NA3R6 KC5010	D12
NA3R6 KC5025	D12
NA3R6 KCU10	D12
NA3R6 KCU25	D12
NA3R8 KC5010	D12
NA3R8 KC5025	D12
NA3R8 KCU10	D12
NA3R8 KCU25	D12
NA4L4 KC5025	D12
NA4L4 KCU10	D12
NA4L5 KC5025	D12
NA4L6 KC5025	D12
NA4L8 KCU25	D12
NA4R4 KC5010	D12
NA4R4 KC5025	D12
NA4R4 KCU25	D12
NA4R5 KC5025	D12
NA4R6 KC5025	D12
NA6L2 KC5010	D12
NA6L2 KC5025	D12
NA6L2 KCU25	D12
NA6L25 KCU25	D12
NA6L3 KC5025	D12
NA6L3 KCU25	D12
NA6R2 KC5010	D12
NA6R2 KC5025	D12
NA6R2 KCU10	D12
NA6R2 KCU25	D12
NA6R25 KC5025	D12
NA6R3 KC5025	D12
NA6R3 KCU25	D12
NAS3L10 KC5025	D13
NAS3L10 KCU10	D13
NAS3L12 KC5025	D13
NAS3L4 KC5025	D13
NAS3L4 KCU25	D13
NAS3L5 KC5025	D13
NAS3L5 KCU10	D13
NAS3L6 KC5010	D13
NAS3L6 KC5025	D13
NAS3L6 KCU10	D13
NAS3L6 KCU25	D13
NAS3L8 KC5010	D13
NAS3L8 KC5025	D13
NAS3L8 KCU10	D13
NAS3L8 KCU25	D13
NAS3R10 KC5010	D13
NAS3R10 KC5025	D13
NAS3R10 KCU10	D13
NAS3R12 KC5025	D13
NAS3R12 KCU25	D13
NAS3R16 KC5025	D13
NAS3R4 KC5025	D13
NAS3R4 KCU25	D13
NAS3R5 KC5025	D13
NAS3R5 KCU10	D13
NAS3R6 KC5010	D13
NAS3R6 KC5025	D13
NAS3R6 KCU10	D13
NAS3R8 KC5010	D13
NAS3R8 KC5025	D13
NAS3R8 KCU10	D13
NAS3R8 KCU25	D13
NASL1010M2Q	C167, D27
NASL1212M2Q	C167, D27
NASL1616K3Q	C167, D27
NASR1010M2Q	C167, D27
NASR1212M2Q	C167, D27
NASR1616K3Q	C167, D27
NB2L K313	C162
NB2R K313	C162
NB3L K313	C162
NB3R K313	C162
NB4L K313	C162
NB4R K313	C162
NBD2R K313	C163
NBD3L K313	C163
NBD3R K313	C163
ND3038L KC5025	D14
ND3038R KC5025	D14
ND3040L KCU25	D14
ND3040R KC5025	D14
ND4050R KCU25	D14
NDC3040L3 KC5010	D14
NDC3040R3 KC5025	D14
NDC310RDL75 KC5025	D15
NDC310RDR75 KC5025	D15
NDC3115VL75 KC5010	D16
NDC3115VL75 KCU10	D16
NDC3115VR75 KC5010	D16
NDC3115VR75 KCU10	D16
NDC314VR75 KCU10	D16
NDC327VR75 KCU10	D16
NDC38RDL75 KC5010	D15
NDC38RDL75 KC5025	D15
NDC38RDL75 KCU25	D15
NDC38RDR75 KC5010	D15
NDC38RDR75 KC5025	D15

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
NDC38RDR75 KCU25	D15
NDC38VL75 KC5010	D16
NDC38VR75 KC5010	D16
NDC4038L2 KC5025	D14
NDC4038R2 KC5025	D14
NDC4040R3 KC5025	D14
NDC4050L2 KC5025	D14
NDC4050R2 KC5025	D14
NDC4050R3 KC5025	D14
NDC68RDR75M KCU10	D15
NDC8115VR75M KCU10	D16
NDC88VL75M KC5010	D16
NDC88VR75M KC5010	D16
NDC88VR75M KCU10	D16
NEL12CA2	C171, D41–42
NEL1616H2	C168, D28
NEL2020K2	C168, D28
NEL2525M2	C168, D28
NEL2525M3	C168, D28
NEL2525M4	C168, D28
NEL25CA3	C171, D41–42
NEL3225P3	C168, D28
NEL3225P4	C168, D28
NEL3232P4	C168, D28
NER12CA2	C171, D41–42
NER1616H2	C168, D28
NER2020K2	C168, D28
NER2525M2	C168, D28
NER2525M3	C168, D28
NER2525M4	C168, D28
NER3225P3	C168, D28
NER3225P4	C168, D28
NER3232P4	C168, D28
NF3125L K313	C161
NF3125LK KC5025	C159
NF3125LK KCU25	C159
NF3125R K313	C161
NF3125RK KC5025	C159
NF3125RK KCU25	C159
NF3156LK KCU25	C159
NF3156RK KCU25	C159
NF3188L KCU25	C161
NF3188R KCU25	C161
NF3M200LK KC5025	C159
NF3M200RK KC5025	C159
NF3M300LK KC5025	C159
NF3M300RK KC5025	C159
NFD3125LK KC5025	C160
NFD3125LK KCU25	C160
NFD3125LKI KCU25	C160
NFD3125RK KC5025	C160
NFD3125RK KCU25	C160
NFD3125RKI KC5025	C160
NFD3125RKI KCU25	C160
NFD3189LKI KCU25	C160
NFD3189RKI KCU25	C160
NFD3M300LK KC5025	C160
NFD3M300RK KC5025	C160
NFD4189LK KC5025	C160
NFD4189LK KCU25	C160
NFD4189RK KCU25	C160
NFD4250LK KCU25	C160
NFD4250RK KCU25	C160
NG1031L KCU25	C155
NG1047L KC5025	C155
NG1047L KCU25	C155
NG1062L KC5025	C155
NG1062L KCU25	C155
NG1094L KC5025	C155
NG1094L KCU25	C155
NG2031L K313	C155
NG2031L KC5010	C155
NG2031L KCK20B	C155
NG2031L KCU10	C155
NG2031L KCU25	C155
NG2031LK KC5010	C147
NG2031LK KC5025	C147
NG2031LK KCP10B	C147
NG2031LK KCP25B	C147
NG2031LK KCU10	C147
NG2031LK KCU25	C147
NG2031R K313	C154
NG2031R KC5010	C154
NG2031R KC5025	C154
NG2031R KCK20B	C154
NG2031R KCU10	C154
NG2031R KCU25	C154
NG2031RK KC5010	C146
NG2031RK KC5025	C146
NG2031RK KCP10B	C146
NG2031RK KCP25B	C146
NG2031RK KCU10	C146
NG2031RK KCU25	C146
NG2031RK KT315	C146
NG2041L KC5010	C155
NG2041L KC5025	C155
NG2041L KCK20B	C155
NG2041L KCU25	C155
NG2041R K313	C154
NG2041R KC5010	C154
NG2041R KC5025	C154
NG2041R KCK20B	C154
NG2041R KCU10	C154
NG2041R KCU25	C154
NG2047L KC5010	C155
NG2047L KCU10	C155
NG2047L KCU25	C155
NG2047LK KC5010	C147
NG2047LK KC5025	C147
NG2047LK KCP10B	C147
NG2047LK KCP25B	C147
NG2047LK KCU10	C147
NG2047LK KCU25	C147
NG2047R KC5010	C154
NG2047R KCK20B	C154
NG2047R KCU10	C154
NG2047R KCU25	C154
NG2047RK KC5010	C146
NG2047RK KC5025	C146
NG2047RK KCP10B	C146
NG2047RK KCP25B	C146
NG2047RK KCU10	C146
NG2047RK KCU25	C146
NG2047RK KT315	C146
NG2058L KCU25	C155
NG2058R KC5025	C154
NG2058R KCU25	C154
NG2062L K313	C155
NG2062L KC5010	C155
NG2062L KC5025	C155
NG2062L KCK20B	C155
NG2062L KCU10	C155
NG2062L KCU25	C155
NG2062LK KC5010	C147
NG2062LK KC5025	C147
NG2062LK KCP10B	C147
NG2062LK KCP25B	C147
NG2062LK KCU10	C147
NG2062LK KCU25	C147
NG2062R K313	C154
NG2062R KC5010	C154
NG2062R KC5025	C154
NG2062R KCK20B	C154
NG2062R KCU10	C154
NG2062R KCU25	C154
NG2062RK KC5010	C146
NG2062RK KC5025	C146
NG2062RK KCP10B	C146
NG2062RK KCP25B	C146
NG2062RK KCU10	C146
NG2062RK KCU25	C146
NG2062RK KT315	C146
NG2094L K313	C155
NG2094L KC5010	C155
NG2094L KCK20B	C155
NG2094L KCU10	C155
NG2094L KCU25	C155
NG2094LK KC5010	C147
NG2094LK KC5025	C147
NG2094LK KCP10B	C147
NG2094LK KCP25B	C147
NG2094LK KCU10	C147
NG2094LK KCU25	C147
NG2094R K313	C154
NG2094R KC5010	C154
NG2094R KCK20B	C154
NG2094R KCU10	C154
NG2094R KCU25	C154
NG2094RK KC5010	C146
NG2094RK KC5025	C146
NG2094RK KCP10B	C146
NG2094RK KCP25B	C146
NG2094RK KCU10	C146
NG2094RK KCU25	C146
NG2094RK KT315	C146
NG2125L KC5010	C155
NG2125L KCK20B	C155
NG2125L KCU10	C155
NG2125L KCU25	C155
NG2125LK KC5010	C148
NG2125LK KC5025	C148
NG2125LK KCP10B	C148
NG2125LK KCP25B	C148
NG2125LK KCU10	C148
NG2125LK KCU25	C148
NG2125R KC5010	C154
NG2125R KCU10	C154
NG2125R KCU25	C154
NG2125RK KC5010	C146
NG2125RK KC5025	C146
NG2125RK KCP10B	C146
NG2125RK KCP25B	C146
NG2125RK KCU10	C146
NG2125RK KCU25	C146
NG2125RK KT315	C146
NG2M050LK KC5010	C147
NG2M050LK KCP25B	C147
NG2M050LK KCU10	C147
NG2M050LK KCU25	C147
NG2M050RK KC5010	C146
NG2M050RK KCP25B	C146
NG2M050RK KCU10	C146
NG2M050RK KCU25	C146
NG2M080LK KC5025	C147
NG2M080LK KCP10B	C147
NG2M080LK KCP25B	C147
NG2M080LK KCU10	C147
NG2M080LK KCU25	C147
NG2M080RK KC5025	C146
NG2M080RK KCP10B	C146
NG2M080RK KCP25B	C146
NG2M080RK KCU10	C146
NG2M080RK KCU25	C146
NG2M100LK KC5010	C147
NG2M100LK KC5025	C147
NG2M100LK KCP10B	C147
NG2M100LK KCP25B	C147
NG2M100LK KCU10	C147
NG2M100LK KCU25	C147
NG2M100RK KC5010	C146
NG2M100RK KC5025	C146
NG2M100RK KCP10B	C146
NG2M100RK KCP25B	C146
NG2M100RK KCU10	C146
NG2M100RK KCU25	C146
NG2M120LK KC5010	C147
NG2M120LK KC5025	C147
NG2M120LK KCP10B	C147
NG2M120LK KCP25B	C147
NG2M120LK KCU10	C147
NG2M120LK KCU25	C147
NG2M120RK KC5010	C146
NG2M120RK KC5025	C146
NG2M120RK KCP10B	C146
NG2M120RK KCP25B	C146
NG2M120RK KCU10	C146
NG2M120RK KCU25	C146
NG2M140LK KC5025	C147
NG2M140LK KCP10B	C147
NG2M140LK KCP25B	C147
NG2M140LK KCU10	C147
NG2M140LK KCU25	C147
NG2M140RK KC5010	C146
NG2M140RK KC5025	C146
NG2M140RK KCP10B	C146
NG2M140RK KCP25B	C146
NG2M140RK KCU10	C146
NG2M140RK KCU25	C146
NG2M150LK KC5025	C147
NG2M150LK KCP25B	C147
NG2M150LK KCU25	C147
NG2M150RK KC5025	C146
NG2M150RK KCP25B	C146
NG2M150RK KCU25	C146
NG2M170LK KC5010	C147
NG2M170LK KC5025	C147
NG2M170LK KCP10B	C147
NG2M170LK KCP25B	C147
NG2M170LK KCU25	C147
NG2M170RK KC5010	C146
NG2M170RK KC5025	C146
NG2M170RK KCP10B	C146
NG2M170RK KCP25B	C146
NG2M170RK KCU10	C146
NG2M170RK KCU25	C146
NG2M175LK KC5025	C147
NG2M175LK KCP25B	C147
NG2M175LK KCU25	C147
NG2M175RK KCP25B	C146
NG2M175RK KCU25	C146
NG2M195LK KC5010	C147
NG2M195LK KCP10B	C147
NG2M195LK KCP25B	C147
NG2M195LK KCU25	C147
NG2M195RK KC5010	C146
NG2M195RK KC5025	C146
NG2M195RK KCP10B	C146
NG2M195RK KCP25B	C146
NG2M195RK KCU10	C146
NG2M195RK KCU25	C146
NG2M200LK KC5010	C147
NG2M200LK KC5025	C147
NG2M200LK KCP10B	C147
NG2M200LK KCP25B	C147
NG2M200LK KCU10	C147
NG2M200LK KCU25	C147
NG2M200RK KC5010	C146
NG2M200RK KC5025	C146
NG2M200RK KCP10B	C146
NG2M200RK KCP25B	C146
NG2M200RK KCU10	C146
NG2M200RK KCU25	C146
NG2M200RK KT315	C146
NG2M220LK KCP25B	C147
NG2M220LK KCU25	C147
NG2M220RK KC5025	C146
NG2M220RK KCP25B	C146
NG2M220RK KCU25	C146
NG2M225LK KC5025	C147
NG2M225LK KCP10B	C147
NG2M225LK KCP25B	C147
NG2M225LK KCU10	C147
NG2M225LK KCU25	C147
NG2M225RK KC5025	C146
NG2M225RK KCP10B	C146
NG2M225RK KCP25B	C146
NG2M225RK KCU10	C146
NG2M225RK KCU25	C146
NG2M250LK KC5025	C147
NG2M250LK KCP25B	C147
NG2M250LK KCU25	C147
NG2M250RK KC5025	C146
NG2M250RK KCP25B	C146
NG2M250RK KCU25	C146
NG2M275LK KC5010	C147
NG2M275LK KCP25B	C147
NG2M275LK KCU10	C147
NG2M275LK KCU25	C147
NG2M275RK KC5025	C146
NG2M275RK KCP10B	C146
NG2M275RK KCP25B	C146
NG2M275RK KCU10	C146
NG2M275RK KCU25	C146
NG2M300LK KC5010	C148
NG2M300LK KC5025	C148
NG2M300LK KCP10B	C148
NG2M300LK KCP25B	C148
NG2M300LK KCU10	C148

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
NG2M300LK KCU25	C148
NG2M300RK KC5010	C146
NG2M300RK KC5025	C146
NG2M300RK KCP10B	C146
NG2M300RK KCP25B	C146
NG2M300RK KCU10	C146
NG2M300RK KCU25	C146
NG2M320RK KCP25B	C146
NG2M325LK KCP25B	C148
NG2M325LK KCU25	C148
NG2M325RK KC5025	C146
NG2M325RK KCP25B	C146
NG2M325RK KCU25	C146
NG3047L K313	C155
NG3047L KC5010	C155
NG3047L KCK20B	C155
NG3047L KCU10	C155
NG3047L KCU25	C155
NG3047LK KC5010	C148
NG3047LK KC5025	C148
NG3047LK KCP10B	C148
NG3047LK KCP25B	C148
NG3047LK KCU10	C148
NG3047LK KCU25	C148
NG3047R K313	C154
NG3047R KC5010	C154
NG3047R KC5025	C154
NG3047R KCK20B	C154
NG3047R KCU10	C154
NG3047R KCU25	C154
NG3047RK KC5010	C146
NG3047RK KC5025	C146
NG3047RK KCP10B	C146
NG3047RK KCP25B	C146
NG3047RK KCU10	C146
NG3047RK KCU25	C146
NG3062L K313	C155
NG3062L KC5010	C155
NG3062L KC5025	C155
NG3062L KCK20B	C155
NG3062L KCU10	C155
NG3062L KCU25	C155
NG3062LEST KB1630	C163
NG3062LEST KD1425	C163
NG3062LK KC5010	C148
NG3062LK KC5025	C148
NG3062LK KCU10	C148
NG3062LK KCU25	C148
NG3062R K313	C154
NG3062R KC5010	C154
NG3062R KC5025	C154
NG3062R KCK20B	C154
NG3062R KCU10	C154
NG3062R KCU25	C154
NG3062REST KB1630	C163
NG3062REST KD1425	C163
NG3062RK KC5010	C146
NG3062RK KC5025	C146
NG3062RK KCP10B	C146
NG3062RK KCP25B	C146
NG3062RK KCU10	C146
NG3062RK KCU25	C146
NG3062RK KT315	C146
NG3072L KC5010	C155
NG3072L KCU10	C155
NG3072LK KC5010	C148
NG3072LK KC5025	C148
NG3072LK KCP10B	C148
NG3072LK KCP25B	C148
NG3072LK KCU10	C148
NG3072LK KCU25	C148
NG3072R KC5010	C154
NG3072R KCK20B	C154
NG3072R KCU10	C154
NG3072RK KC5010	C146
NG3072RK KC5025	C146
NG3072RK KCP10B	C146
NG3072RK KCP25B	C146
NG3072RK KCU10	C146
NG3072RK KCU25	C146
NG3078L KCU10	C155
NG3078LK KC5010	C148
NG3078LK KC5025	C148
NG3078LK KCP10B	C148
NG3078LK KCP25B	C148
NG3078LK KCU10	C148
NG3078LK KCU25	C148
NG3078R KC5010	C154
NG3078R KCK20B	C154
NG3078R KCU10	C154
NG3078RK KC5010	C146
NG3078RK KC5025	C146
NG3078RK KCP10B	C146
NG3078RK KCP25B	C146
NG3078RK KCU10	C146
NG3078RK KCU25	C146
NG3088L KC5010	C155
NG3088L KCU10	C155
NG3088L KCU25	C155
NG3088R KC5010	C154
NG3088R KCK20B	C154
NG3088R KCU10	C154
NG3088R KCU25	C154
NG3094L K313	C155
NG3094L KC5010	C155
NG3094L KC5025	C155
NG3094L KCK20B	C155
NG3094L KCU10	C155
NG3094L KCU25	C155
NG3094LEST KB1630	C163
NG3094LEST KD1425	C163
NG3094LK KC5010	C148
NG3094LK KC5025	C148
NG3094LK KCP10B	C148
NG3094LK KCP25B	C148
NG3094LK KCU10	C148
NG3094LK KCU25	C148
NG3094LK KT315	C148
NG3094R K313	C154
NG3094R KC5010	C154
NG3094R KC5025	C154
NG3094R KCK20B	C154
NG3094R KCU10	C154
NG3094R KCU25	C154
NG3094REST KB1630	C163
NG3094REST KD1425	C163
NG3094RK KC5010	C146
NG3094RK KC5025	C146
NG3094RK KCP10B	C146
NG3094RK KCU10	C146
NG3094RK KCU25	C146
NG3094RK KT315	C146
NG3097L KCU10	C155
NG3097L KCU25	C155
NG3097R KC5010	C154
NG3097R KCK20B	C154
NG3097R KCU10	C154
NG3097R KCU25	C154
NG3105L KC5010	C155
NG3105L KCU10	C155
NG3105L KCU25	C155
NG3105R KC5010	C154
NG3105R KC5025	C154
NG3105R KCK20B	C154
NG3105R KCU10	C154
NG3105R KCU25	C154
NG3110L KC5025	C155
NG3110L KCU25	C155
NG3110R KC5025	C154
NG3110R KCU25	C154
NG3122L KCU25	C155
NG3122R KCU25	C154
NG3125L K313	C155
NG3125L KC5010	C155
NG3125L KC5025	C155
NG3125L KCK20B	C155
NG3125L KCU10	C155
NG3125L KCU25	C155
NG3125LEST KB1630	C163
NG3125LK KC5010	C148
NG3125LK KC5025	C148
NG3125LK KCP10B	C148
NG3125LK KCP25B	C148
NG3125LK KCU10	C148
NG3125LK KCU25	C148
NG3125LS0820ST KB1630	C163
NG3125R K313	C154
NG3125R KC5010	C154
NG3125R KC5025	C154
NG3125R KCK20B	C154
NG3125R KCU10	C154
NG3125R KCU25	C154
NG3125REST KB1630	C163
NG3125REST KD1425	C163
NG3125RK KC5010	C147
NG3125RK KC5025	C147
NG3125RK KCP10B	C147
NG3125RK KCP25B	C147
NG3125RK KCU10	C147
NG3125RK KCU25	C147
NG3125RK KT315	C147
NG3125RS0820ST KB1630	C163
NG3125RS0820ST KB5625	C163
NG3142L KCU10	C155
NG3142L KCU25	C155
NG3142R KC5010	C154
NG3142R KCU25	C154
NG3156L KC5025	C155
NG3156L KCU25	C155
NG3156LK KC5010	C148
NG3156LK KC5025	C148
NG3156LK KCP10B	C148
NG3156LK KCP25B	C148
NG3156LK KCU10	C148
NG3156LK KCU25	C148
NG3156R KC5010	C154
NG3156R KC5025	C154
NG3156R KCK20B	C154
NG3156R KCU10	C154
NG3156R KCU25	C154
NG3156RK KC5010	C147
NG3156RK KC5025	C147
NG3156RK KCP10B	C147
NG3156RK KCP25B	C147
NG3156RK KCU10	C147
NG3156RK KCU25	C147
NG3178L KCU25	C155
NG3178R KC5025	C154
NG3185L KC5025	C155
NG3185R KCU25	C154
NG3189L KC5010	C155
NG3189L KC5025	C155
NG3189L KCK20B	C155
NG3189L KCU10	C155
NG3189L KCU25	C155
NG3189LK KC5010	C148
NG3189LK KC5025	C148
NG3189LK KCP10B	C148
NG3189LK KCP25B	C148
NG3189LK KCU10	C148
NG3189LK KCU25	C148
NG3189R K313	C154
NG3189R KC5010	C154
NG3189R KC5025	C154
NG3189R KCK20B	C154
NG3189R KCU10	C154
NG3189R KCU25	C154
NG3189REST KD1425	C163
NG3189RK KC5010	C147
NG3189RK KC5025	C147
NG3189RK KCP10B	C147
NG3189RK KCP25B	C147
NG3189RK KCU10	C147
NG3189RK KCU25	C147
NG3M100LK KC5025	C148
NG3M100LK KCP25B	C148
NG3M100LK KCU25	C148
NG3M100RK KC5025	C146
NG3M100RK KCP25B	C146
NG3M100RK KCU25	C146
NG3M120LK KC5025	C148
NG3M120LK KCP10B	C148
NG3M120LK KCP25B	C148
NG3M120LK KCU10	C148
NG3M120LK KCU25	C148
NG3M120RK KC5025	C146
NG3M120RK KCP10B	C146
NG3M120RK KCP25B	C146
NG3M120RK KCU10	C146
NG3M120RK KCU25	C146
NG3M150LK KC5025	C148
NG3M150LK KCP25B	C148
NG3M150LK KCU25	C148
NG3M150RK KC5025	C146
NG3M150RK KCP25B	C146
NG3M150RK KCU25	C146
NG3M175LK KC5025	C148
NG3M175LK KCP25B	C148
NG3M175LK KCU25	C148
NG3M175RK KC5025	C146
NG3M175RK KCP25B	C146
NG3M175RK KCU25	C146
NG3M200LK KC5025	C148
NG3M200LK KCP25B	C148
NG3M200LK KCU25	C148
NG3M200LS02020ST KB5625	C163
NG3M200RK KC5025	C146
NG3M200RK KCP25B	C146
NG3M200RK KCU25	C146
NG3M200RK KT315	C146
NG3M200RS02020ST KB1630	C163
NG3M200RS02020ST KB5625	C163
NG3M220LK KC5025	C148
NG3M220LK KCP25B	C148
NG3M220LK KCU25	C148
NG3M220RK KC5025	C146
NG3M220RK KCP25B	C146
NG3M220RK KCU25	C146
NG3M225LK KCP10B	C148
NG3M225LK KCP25B	C148
NG3M225LK KCU10	C148
NG3M225LK KCU25	C148
NG3M225RK KC5010	C146
NG3M225RK KC5025	C146
NG3M225RK KCP10B	C146
NG3M225RK KCP25B	C146
NG3M225RK KCU10	C146
NG3M225RK KCU25	C146
NG3M250LK KC5025	C148
NG3M250LK KCP25B	C148
NG3M250LK KCU25	C148
NG3M250RK KC5025	C146
NG3M250RK KCP25B	C146
NG3M250RK KCU25	C146
NG3M275LK KC5025	C148
NG3M275LK KCP10B	C148
NG3M275LK KCP25B	C148
NG3M275LK KCU10	C148
NG3M275LK KCU25	C148
NG3M275RK KC5010	C147
NG3M275RK KC5025	C147
NG3M275RK KCP10B	C147
NG3M275RK KCP25B	C147
NG3M275RK KCU10	C147
NG3M275RK KCU25	C147
NG3M300LK KC5010	C148
NG3M300LK KC5025	C148
NG3M300LK KCP10B	C148
NG3M300LK KCP25B	C148
NG3M300LK KCU10	C148
NG3M300LK KCU25	C148
NG3M300RK KC5010	C147
NG3M300RK KC5025	C147
NG3M300RK KCP10B	C147
NG3M300RK KCP25B	C147
NG3M300RK KCU10	C147
NG3M300RK KCU25	C147
NG3M300RS02020ST KB1630	C163
NG3M300RS02020ST KB5625	C163
NG3M320LK KC5025	C148
NG3M320LK KCP25B	C148
NG3M320LK KCU25	C148
NG3M320RK KC5025	C147
NG3M320RK KCP25B	C147
NG3M320RK KCU25	C147
NG3M325LK KC5025	C148
NG3M325LK KCP25B	C148
NG3M325LK KCU25	C148

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
NG3M325RK KC5025	C147
NG3M325RK KCP25B	C147
NG3M325RK KCU25	C147
NG3M350LK KC5025	C148
NG3M350LK KCP25B	C148
NG3M350LK KCU25	C148
NG3M350RK KC5025	C147
NG3M350RK KCP25B	C147
NG3M350RK KCU25	C147
NG3M400LK KC5025	C148
NG3M400LK KCP10B	C148
NG3M400LK KCP25B	C148
NG3M400LK KCU10	C148
NG3M400LK KCU25	C148
NG3M400RK KC5010	C147
NG3M400RK KC5025	C147
NG3M400RK KCP10B	C147
NG3M400RK KCP25B	C147
NG3M400RK KCU10	C147
NG3M400RK KCU25	C147
NG3M400RS02020ST KB5625	C163
NG3M425LK KCP10B	C148
NG3M425LK KCP25B	C148
NG3M425LK KCU10	C148
NG3M425LK KCU25	C148
NG3M425RK KC5025	C147
NG3M425RK KCP10B	C147
NG3M425RK KCP25B	C147
NG3M425RK KCU10	C147
NG3M425RK KCU25	C147
NG3M450LK KCP25B	C148
NG3M450LK KCU25	C148
NG3M450RK KCP25B	C147
NG3M450RK KCU25	C147
NG4125L K313	C155
NG4125L KCU10	C155
NG4125L KCU25	C155
NG4125LK KCP10B	C148
NG4125LK KCP25B	C148
NG4125LK KCU10	C148
NG4125LK KCU25	C148
NG4125R K313	C154
NG4125R KCK20B	C154
NG4125R KCU10	C154
NG4125R KCU25	C154
NG4125RK KC5010	C147
NG4125RK KCP10B	C147
NG4125RK KCP25B	C147
NG4125RK KCU10	C147
NG4125RK KCU25	C147
NG4189L KC5010	C155
NG4189L KCK20B	C155
NG4189L KCU10	C155
NG4189L KCU25	C155
NG4189LEST KB1630	C155, C163
NG4189LK KC5010	C148
NG4189LK KC5025	C148
NG4189LK KCP10B	C148
NG4189LK KCP25B	C148
NG4189LK KCU10	C148
NG4189LK KCU25	C148
NG4189R K313	C154
NG4189R KC5010	C154
NG4189R KCK20B	C154
NG4189R KCU10	C154
NG4189R KCU25	C154
NG4189REST KB1630	C163
NG4189RK KC5010	C147
NG4189RK KC5025	C147
NG4189RK KCP10B	C147
NG4189RK KCP25B	C147
NG4189RK KCU10	C147
NG4189RK KCU25	C147
NG4213R KCU25	C154
NG4250L KC5010	C155
NG4250L KC5025	C155
NG4250L KCK20B	C155
NG4250L KCU10	C155
NG4250L KCU25	C155
NG4250LK KC5010	C148
NG4250LK KC5025	C148
NG4250LK KCP10B	C148
NG4250LK KCP25B	C148
NG4250LK KCU10	C148
NG4250LK KCU25	C148
NG4250R KC5010	C154
NG4250R KC5025	C154
NG4250R KCK20B	C154
NG4250R KCU10	C154
NG4250R KCU25	C154
NG4250RK KC5010	C147
NG4250RK KC5025	C147
NG4250RK KCP10B	C147
NG4250RK KCP25B	C147
NG4250RK KCU25	C147
NG4M300LK KCP25B	C148
NG4M300LK KCU25	C148
NG4M300RK KCP25B	C147
NG4M300RK KCU25	C147
NG4M320LK KCP25B	C148
NG4M350LK KCP25B	C148
NG4M350LK KCU25	C148
NG4M350RK KCP25B	C147
NG4M350RK KCU25	C147
NG4M400LK KCP10B	C148
NG4M400LK KCP25B	C148
NG4M400LK KCU10	C148
NG4M400LK KCU25	C148
NG4M400RK KC5010	C147
NG4M400RK KC5025	C147
NG4M400RK KCP10B	C147
NG4M400RK KCP25B	C147
NG4M400RK KCU25	C147
NG4M450LK KC5025	C148
NG4M450LK KCP25B	C148
NG4M450LK KCU25	C148
NG4M450RK KCP25B	C147
NG4M450RK KCU25	C147
NG4M500LK KC5010	C148
NG4M500LK KCP10B	C148
NG4M500LK KCP25B	C148
NG4M500LK KCU10	C148
NG4M500LK KCU25	C148
NG4M500RK KCP10B	C147
NG4M500RK KCP25B	C147
NG4M500RK KCU10	C147
NG4M500RK KCU25	C147
NG4M550LK KCP25B	C148
NG4M550RK KCP25B	C147
NG4M600LK KCP25B	C148
NG4M600LK KCU25	C148
NG4M600RK KCP25B	C147
NG4M600RK KCU25	C147
NG5312R KCU25	C154
NG6375R KCU25	C154
NGC2C130L055K KCU25	C152
NGC2C130R055K KCU25	C152
NGC2C185L125K KCU25	C152
NGC2C215L150K KCU25	C152
NGC2C215R150K KCU25	C152
NGD2M150LK KC5025	C149
NGD2M150LK KCU10	C149
NGD2M150LK KCU25	C149
NGD2M150RK KC5010	C149
NGD2M150RK KC5025	C149
NGD2M150RK KCU10	C149
NGD2M150RK KCU25	C149
NGD2M200LK KC5010	C149
NGD2M200LK KC5025	C149
NGD2M200LK KCU10	C149
NGD2M200LK KCU25	C149
NGD2M200RK KC5010	C149
NGD2M200RK KC5025	C149
NGD2M200RK KCU10	C149
NGD2M200RK KCU25	C149
NGD2M250LK KC5010	C149
NGD2M250LK KC5025	C149
NGD2M250LK KCU10	C149
NGD2M250LK KCU25	C149
NGD2M250RK KC5025	C149
NGD2M250RK KCU10	C149
NGD2M250RK KCU25	C149
NGD3062LK KC5010	C149
NGD3062LK KC5025	C149
NGD3062LK KCU10	C149
NGD3062LK KCU25	C149
NGD3062RK K313	C149
NGD3062RK KC5010	C149
NGD3062RK KC5025	C149
NGD3062RK KCU10	C149
NGD3062RK KCU25	C149
NGD3094LK K313	C149
NGD3094LK KC5010	C149
NGD3094LK KC5025	C149
NGD3094LK KCU10	C149
NGD3094LK KCU25	C149
NGD3094RK K313	C149
NGD3094RK KC5010	C149
NGD3094RK KC5025	C149
NGD3094RK KCU10	C149
NGD3094RK KCU25	C149
NGD3125LK K313	C149
NGD3125LK KC5010	C149
NGD3125LK KC5025	C149
NGD3125LK KCU10	C149
NGD3125LK KCU25	C149
NGD3125RK K313	C149
NGD3125RK KC5010	C149
NGD3125RK KC5025	C149
NGD3125RK KCU10	C149
NGD3125RK KCU25	C149
NGD3189L K313	C157
NGD3189L KC5010	C157
NGD3189L KCU10	C157
NGD3189LK KC5010	C149
NGD3189LK KC5025	C149
NGD3189LK KCU10	C149
NGD3189LK KCU25	C149
NGD3189R K313	C157
NGD3189R KCU10	C157
NGD3189RK KC5010	C149
NGD3189RK KC5025	C149
NGD3189RK KCU10	C149
NGD3189RK KCU25	C149
NGD3M200LK KC5025	C149
NGD3M200LK KCU25	C149
NGD3M200RK KC5010	C149
NGD3M200RK KC5025	C149
NGD3M200RK KCU10	C149
NGD3M200RK KCU25	C149
NGD3M250LK KC5025	C149
NGD3M250LK KCU25	C149
NGD3M250RK KC5010	C149
NGD3M250RK KC5025	C149
NGD3M250RK KCU25	C149
NGD3M300LK KC5010	C149
NGD3M300LK KC5025	C149
NGD3M300LK KCU10	C149
NGD3M300LK KCU25	C149
NGD3M300RK KC5010	C149
NGD3M300RK KC5025	C149
NGD3M300RK KCU10	C149
NGD3M300RK KCU25	C149
NGD3M350LK KC5025	C149
NGD3M350LK KCU25	C149
NGD3M400LK KC5025	C149
NGD3M400LK KCU10	C149
NGD3M400LK KCU25	C149
NGD3M400RK KC5010	C149
NGD3M400RK KC5025	C149
NGD3M400RK KCU10	C149
NGD3M400RK KCU25	C149
NGD4125LK KC5010	C149
NGD4125LK KC5025	C149
NGD4125LK KCU10	C149
NGD4125LK KCU25	C149
NGD4125RK KC5010	C149
NGD4125RK KC5025	C149
NGD4125RK KCU10	C149
NGD4125RK KCU25	C149
NGD4189LK KC5010	C149
NGD4189LK KC5025	C149
NGD4189LK KCU10	C149
NGD4189LK KCU25	C149
NGD4189RK KC5010	C149
NGD4189RK KC5025	C149
NGD4189RK KCU10	C149
NGD4189RK KCU25	C149
NGD4250L K313	C157
NGD4250L KC5010	C157
NGD4250L KCU10	C157
NGD4250LK KC5025	C149
NGD4250LK KCU10	C149
NGD4250LK KCU25	C149
NGD4250R K313	C157
NGD4250R KCU10	C157
NGD4250RK KC5010	C149
NGD4250RK KC5025	C149
NGD4250RK KCU10	C149
NGD4250RK KCU25	C149
NGD4M400LK KCU25	C149
NGD4M500LK KCU25	C149
NGD4M550RK KCU25	C149
NGP2031L KCU10	C152
NGP2031R KC5010	C152
NGP2031R KCU10	C152
NGP2062L KCU10	C152
NGP2062R KC5010	C152
NGP2062R KCU10	C152
NGP2125L KCU10	C152
NGP2125R KCU10	C152
NGP3088L KCU10	C152
NGP3088R KCU10	C152
NGP3088R KD1425	C152
NGP3125L KC5010	C152
NGP3125R KC5010	C152
NGP3125R KCU10	C152
NGP3125R KD1425	C152
NGP3156R KCU10	C152
NGP4189R KCU10	C152
NGP4250L KCU10	C152
NGP4250R KC5010	C152
NJ3010L16 KC5025	D17
NJ3010R16 K68	D17
NJ3010R16 KC5025	D17
NJ3010R16 KCU25	D17
NJ3014L12 KC5010	D17
NJ3014L12 KC5025	D17
NJ3014R12 KC5010	D17
NJ3014R12 KC5025	D17
NJ3014R12 KCU10	D17
NJ3014R12 KCU25	D17
NJ3020L8 KC5025	D17
NJ3020R8 KC5010	D17
NJ3020R8 KC5025	D17
NJF3005R32 KC5010	D17
NJF3005R32 KCU10	D17
NJF3006R28 KC5010	D17
NJF3006R28 KC5025	D17
NJF3007L24 KC5010	D17
NJF3007R24 KC5010	D17
NJF3007R24 KC5025	D17
NJF3008L20 KC5010	D17
NJF3008R20 KC5010	D17
NJF3008R20 KC5025	D17
NJF3009R18 K68	D17
NJF3009R18 KC5010	D17
NJF3009R18 KC5025	D17
NJF3009R18 KCU25	D17
NJF3010L16 KC5010	D17
NJF3010R16 KC5010	D17
NJF3010R16 KC5025	D17
NJF3012R14 KC5010	D17
NJF3012R14 KC5025	D17
NJF3012R14 KCU25	D17
NJK3005L32 KC5025	D18
NJK3005R32 KC5010	D18
NJK3005R32 KC5025	D18
NJK3006L28 KC5025	D18
NJK3006R28 KC5010	D18
NJK3006R28 KCU25	D18
NJK3007R24 KC5010	D18
NJK3007R24 KC5025	D18
NJK3007R24 KCU25	D18
NJK3008R20 KC5010	D18
NJK3008R20 KC5025	D18
NJK3008R20 KCU10	D18
NJK3008R20 KCU25	D18

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
NJK3009R18 KC5010	D18
NJK3009R18 KC5025	D18
NJK3010R16 KC5010	D18
NJK3010R16 KC5025	D18
NJK3010R16 KCU25	D18
NJK3012R14 KC5010	D18
NJK3012R14 KC5025	D18
NJP3010L16 KC5025	D18
NJP3010R16 KC5010	D18
NJP3010R16 KC5025	D18
NJP3010R16 KCU10	D18
NJP3014L12 KC5010	D18
NJP3014R12 K68	D18
NJP3014R12 KC5010	D18
NJP3014R12 KC5025	D18
NJP3014R12 KCU10	D18
NJP3014R12 KCU25	D18
NJP3020L8 KC5025	D18
NJP3020R8 KC5010	D18
NJP3020R8 KC5025	D18
NJP3020R8 KCU25	D18
NKLCL2020K11	E36
NKLCL2525M11	E36
NKLCR1616H11	E36
NKLCR2020K11	E36
NKLCR2525M11	E36
NKLCRF1212M11Q	E36
NKLNL2020K15	E37
NKLNL2525M15	E37
NKLNR2020K15	E37
NKLNR2525M15	E37
NLW-0.375 S	T115, T118
NLW-16SP S	T118
NLW12SP WASHER	T118
NP2002RK KC5010	C151
NP2002RK KC5025	C151
NP2002RK KCU10	C151
NP2002RK KCU25	C151
NP2012RK KCU25	C151
NP3002RK KC5010	C151
NP3002RK KCU10	C151
NP3002RK KCU25	C151
NP3012RK KC5025	C151
NP3012RK KCU25	C151
NPD2002RK KC5010	C151
NPD2002RK KCU25	C151
NPD3002RK KCU25	C151
NPD3012RK KC5010	C151
NPD3012RK KCU10	C151
NPD3012RK KCU25	C151
NR2031L KC5010	C158
NR2031L KC5025	C158
NR2031L KCU10	C158
NR2031L KCU25	C158
NR2031R KC5010	C158
NR2031R KC5025	C158
NR2031R KCU10	C158
NR2031R KCU25	C158
NR2047L KCU25	C158
NR2047R KCU25	C158
NR2062L KC5010	C158
NR2062L KCU10	C158
NR2062L KCU25	C158
NR2062R KC5010	C158
NR2062R KCU10	C158
NR2062R KCU25	C158
NR2M050L KC5010	C158
NR2M050L KCU10	C158
NR2M050L KCU25	C158
NR2M050R KC5010	C158
NR2M050R KC5025	C158
NR2M050R KCU10	C158
NR2M050R KCU25	C158
NR2M075R KC5010	C158
NR2M075R KCU10	C158
NR2M100L KC5025	C158
NR2M100R KC5010	C158
NR2M100R KC5025	C158
NR2M100R KCU10	C158
NR2M125R KC5025	C158
NR2M150L KC5025	C158
NR2M150R KC5025	C158
NR2M175R KC5025	C158
NR3031L K313	C158
NR3031L KC5010	C158
NR3031L KC5025	C158
NR3031L KCU10	C158
NR3031L KCU25	C158
NR3031LK KC5010	C150
NR3031LK KC5025	C150
NR3031LK KCU10	C150
NR3031LK KCU25	C150
NR3031R K313	C158
NR3031R KC5010	C158
NR3031R KC5025	C158
NR3031R KCU10	C158
NR3031R KCU25	C158
NR3031RK KC5010	C150
NR3031RK KC5025	C150
NR3031RK KCU10	C150
NR3031RK KCU25	C150
NR3047L K313	C158
NR3047L KC5010	C158
NR3047L KCU10	C158
NR3047L KCU25	C158
NR3047LK KC5010	C150
NR3047LK KC5025	C150
NR3047LK KCU10	C150
NR3047LK KCU25	C150
NR3047R K313	C158
NR3047R KC5010	C158
NR3047R KCU10	C158
NR3047R KCU25	C158
NR3047RK KC5010	C150
NR3047RK KC5025	C150
NR3047RK KCU10	C150
NR3047RK KCU25	C150
NR3062L K313	C158
NR3062L KC5010	C158
NR3062L KC5025	C158
NR3062L KCU10	C158
NR3062L KCU25	C158
NR3062LK KC5010	C150
NR3062LK KC5025	C150
NR3062LK KCU10	C150
NR3062LK KCU25	C150
NR3062R K313	C158
NR3062R KC5010	C158
NR3062R KC5025	C158
NR3062R KCU10	C158
NR3062R KCU25	C158
NR3062RK KC5010	C150
NR3062RK KC5025	C150
NR3062RK KCU10	C150
NR3062RK KCU25	C150
NR3078LK KC5010	C150
NR3078LK KC5025	C150
NR3078LK KCU25	C150
NR3078R K313	C158
NR3078RK KC5010	C150
NR3078RK KCU10	C150
NR3078RK KCU25	C150
NR3094L K313	C158
NR3094L KC5010	C158
NR3094L KC5025	C158
NR3094L KCU25	C158
NR3094R KC5010	C158
NR3094R KC5025	C158
NR3094R KCU10	C158
NR3094R KCU25	C158
NR3M100L KC5025	C158
NR3M100R KC5025	C158
NR3M150L KC5010	C158
NR3M150L KC5025	C158
NR3M150L KCU10	C158
NR3M150R KC5025	C158
NR3M200L KC5025	C158
NR3M200R KC5025	C158
NR4062LK KC5010	C150
NR4062LK KCU10	C150
NR4062LK KCU25	C150
NR4062RK KC5010	C150
NR4062RK KCU10	C150
NR4062RK KCU25	C150
NR4094LK KC5010	C150
NR4094LK KC5025	C150
NR4094LK KCU10	C150
NR4094LK KCU25	C150
NR4094R K313	C158
NR4094RK KC5010	C150
NR4094RK KCU10	C150
NR4094RK KCU25	C150
NR4125L KC5010	C158
NR4125L KCU25	C158
NR4125LK KC5010	C150
NR4125LK KCU10	C150
NR4125LK KCU25	C150
NR4125R KC5010	C158
NR4125R KCU10	C158
NR4125R KCU25	C158
NR4125RK KC5010	C150
NR4125RK KC5025	C150
NR4125RK KCU10	C150
NR4125RK KCU25	C150
NRD3031L KC5010	C159
NRD3031L KC5025	C159
NRD3031L KCU10	C159
NRD3031L KCU25	C159
NRD3031R KC5010	C159
NRD3031R KC5025	C159
NRD3031R KCU10	C159
NRD3031R KCU25	C159
NRD3062L KC5010	C159
NRD3062L KC5025	C159
NRD3062L KCU10	C159
NRD3062L KCU25	C159
NRD3062R KC5010	C159
NRD3062R KC5025	C159
NRD3062R KCU10	C159
NRD3062R KCU25	C159
NRD4062L KC5010	C159
NRD4062L KC5025	C159
NRD4062L KCU10	C159
NRD4062L KCU25	C159
NRD4062R KC5010	C159
NRD4062R KCU10	C159
NRD4062R KCU25	C159
NRD4094L KC5010	C159
NRD4094L KCU10	C159
NRD4094L KCU25	C159
NRD4094R KC5010	C159
NRD4094R KCU10	C159
NRD4125L KC5010	C159
NRD4125L KC5025	C159
NRD4125L KCU10	C159
NRD4125L KCU25	C159
NRD4125R KC5010	C159
NRD4125R KCU25	C159
NRL2020K3	C168
NRL2525M3	C168
NRL3225P3	C168
NRP3031L KC5010	C153
NRP3031L KCU10	C153
NRP3031R KC5010	C153
NRP3031R KCU10	C153
NRP3047L KC5010	C153
NRP3047L KCU10	C153
NRP3047R K313	C153
NRP3047R KC5010	C153
NRP3047R KCU10	C153
NRP3062L KC5010	C153
NRP3062R KC5010	C153
NRP3062R KCU10	C153
NRP3094L KC5010	C153
NRP3094L KCU10	C153
NRP3094R KC5010	C153
NRP3094R KCU10	C153
NRR2020K3	C168
NRR2525M3	C168
NRR3225P3	C168
NSL1010E2	C166, D29
NSL1212F2	C166, D29
NSL1616H2	C166, D29
NSL2020K2	C166, D29
NSL2020K3	C166, D29
NSL2525M2	C166, D29
NSL2525M3	C166, D29
NSL2525M4	C166, D29
NSL3225P3	C166, D29
NSL3225P4	C166, D29
NSL3232P3	C166, D29
NSL3232P4	C166, D29
NSR1010E2	C166, D29
NSR1212F2	C166, D29
NSR1616H2	C166, D29
NSR2020K2	C166, D29
NSR2020K3	C166, D29
NSR2525M2	C166, D29
NSR2525M3	C166, D29
NSR2525M4	C166, D29
NSR3225P3	C166, D29
NSR3225P4	C166, D29
NSR3232P3	C166, D29
NSR3232P4	C166, D29
NST1	B168, B370
NST2	B168, B370
NST3	B168, B370
NST4	B168, B370
NT1L K68	D25
NT1L KC5010	D25
NT1L KC5025	D25
NT1L KCU10	D25
NT1L KCU25	D25
NT2L K68	D19
NT2L KC5010	D19
NT2L KC5025	D19
NT2L KCU10	D19
NT2L KCU25	D19
NT2LK KC5010	D24
NT2LK KC5025	D24
NT2LK KCU10	D24
NT2LK KCU25	D24
NT2R K68	D19
NT2R KC5010	D19
NT2R KC5025	D19
NT2R KCU10	D19
NT2R KCU25	D19
NT2RK KC5010	D24
NT2RK KC5025	D24
NT2RK KCU10	D24
NT2RK KCU25	D24
NT3L K68	D19
NT3L KC5010	D19
NT3L KC5025	D19
NT3L KCU10	D19
NT3L KCU25	D19
NT3LCK KC5010	D21
NT3LCK KC5025	D21
NT3LCK KCU10	D21
NT3LCK KCU25	D21
NT3LK KC5010	D24
NT3LK KC5025	D24
NT3LK KCU10	D24
NT3LK KCU25	D24
NT3R K68	D19
NT3R KC5010	D19
NT3R KC5025	D19
NT3R KCU10	D19
NT3R KCU25	D19
NT3RCK KC5010	D21
NT3RCK KC5025	D21
NT3RCK KCU10	D21
NT3RCK KCU25	D21
NT3RK KC5010	D24
NT3RK KC5025	D24
NT3RK KCU10	D24
NT3RK KCU25	D24
NT4L K68	D19
NT4L KC5010	D19
NT4L KC5025	D19
NT4L KCU10	D19
NT4L KCU25	D19
NT4LCK KC5025	D21
NT4LCK KCU25	D21
NT4LK KC5010	D24
NT4LK KC5025	D24
NT4LK KCU10	D24
NT4LK KCU25	D24

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
NT4R K68	D19
NT4R KC5010	D19
NT4R KC5025	D19
NT4R KCU10	D19
NT4R KCU25	D19
NT4RCK KC5010	D21
NT4RCK KC5025	D21
NT4RCK KCU25	D21
NT4RK KC5010	D24
NT4RK KC5025	D24
NT4RK KCU10	D24
NT4RK KCU25	D24
NTB2LB KC5010	D20
NTB2LB KCU10	D20
NTB2RA K68	D19
NTB2RB KC5010	D20
NTB3L12B KC5010	D20
NTB3LA K68	D19
NTB3LA KC5010	D19
NTB3LA KC5025	D19
NTB3LB K68	D20
NTB3LB KC5010	D20
NTB3LB KC5025	D20
NTB3LB KCU10	D20
NTB3R12B KC5010	D20
NTB3RA KC5025	D19
NTB3RA KCU10	D19
NTB3RB K68	D20
NTB3RB KC5010	D20
NTB3RB KC5025	D20
NTB3RB KCU10	D20
NTB3RB KCU25	D20
NTB4LB KC5010	D20
NTB4LB KC5025	D20
NTB4RA KCU10	D19
NTB4RB KC5010	D20
NTB4RB KC5025	D20
NTB4RB KCU10	D20
NTC3L10E KCU10	D22
NTC3L10I KC5025	D20
NTC3L12E KCU10	D22
NTC3L12I KC5025	D20
NTC3L14I KC5025	D20
NTC3L16E KCU10	D22
NTC3L16I KC5025	D20
NTC3L8E KC5010	D22
NTC3L8I KC5025	D20
NTC3MR150E KC5010	D21
NTC3MR150E KC5025	D21
NTC3MR150E KCU10	D21
NTC3MR200E KC5010	D21
NTC3R10E KC5010	D22
NTC3R10E KC5025	D22
NTC3R11E KC5025	D22
NTC3R11E KCU10	D22
NTC3R12E KC5010	D22
NTC3R12E KC5025	D22
NTC3R12E KCU25	D22
NTC3R12I KC5025	D20
NTC3R13E KC5010	D22
NTC3R13E KC5025	D22
NTC3R14E KC5010	D22
NTC3R14E KC5025	D22
NTC3R16E KC5010	D22
NTC3R16E KC5025	D22
NTC3R18E KC5010	D22
NTC3R18E KC5025	D22
NTC3R18E KCU25	D22
NTC3R20E KC5010	D22
NTC3R20E KC5025	D22
NTC3R20E KCU10	D22
NTC3R24E KC5010	D22
NTC3R24E KC5025	D22
NTC3R28E KC5025	D22
NTC3R32E KC5025	D22
NTC3R32E KCU10	D22
NTC3R7E KC5025	D22
NTC3R8E KC5010	D22
NTC3R8E KC5025	D22
NTC3R8E KCU10	D22
NTC3R9E KCU10	D22
NTF2L K68	D23
NTF2L KC5010	D23
NTF2L KC5025	D23
NTF2L KCU10	D23
NTF2L KCU25	D23
NTF2R K68	D23
NTF2R KC5010	D23
NTF2R KC5025	D23
NTF2R KCU10	D23
NTF2R KCU25	D23
NTF3L K68	D23
NTF3L KC5010	D23
NTF3L KC5025	D23
NTF3L KCU10	D23
NTF3L KCU25	D23
NTF3R K68	D23
NTF3R KC5010	D23
NTF3R KC5025	D23
NTF3R KCU10	D23
NTF3R KCU25	D23
NTF4R KC5025	D23
NTK2L K68	D23
NTK2L KC5010	D23
NTK2L KC5025	D23
NTK2L KCU10	D23
NTK2L KCU25	D23
NTK2R K68	D23
NTK2R KC5010	D23
NTK2R KC5025	D23
NTK2R KCU10	D23
NTK2R KCU25	D23
NTK3L K68	D23
NTK3L KC5010	D23
NTK3L KC5025	D23
NTK3L KCU10	D23
NTK3L KCU25	D23
NTK3R K68	D23
NTK3R KC5010	D23
NTK3R KC5025	D23
NTK3R KCU10	D23
NTK3R KCU25	D23
NTP2L K68	D24
NTP2L KC5010	D24
NTP2L KC5025	D24
NTP2L KCU10	D24
NTP2L KCU25	D24
NTP2R K68	D24
NTP2R KC5010	D24
NTP2R KC5025	D24
NTP2R KCU10	D24
NTP2R KCU25	D24
NTP3L K68	D24
NTP3L KC5010	D24
NTP3L KC5025	D24
NTP3L KCU10	D24
NTP3L KCU25	D24
NTP3R K68	D24
NTP3R KC5010	D24
NTP3R KC5025	D24
NTP3R KC5410	D24
NTP3R KCU10	D24
NTP3R KCU25	D24
NTP4L KC5010	D24
NTP4L KC5025	D24
NTP4R KC5010	D24
NTP4R KC5025	D24
NTP4R KCU10	D24
NTP4R KCU25	D24
NTU4R KC5025	D24
NTU4R KCU25	D24
NU3094L KC5025	C161
NU3094L KCU25	C161
NU3094R KC5025	C161
NU3125L KC5025	C161
NU3125R KCU25	C161
NU3156L KC5025	C161
NUFRL	E58
NUFRR	E58
NUWTC	E59
NV3RJ KCU25	C162
NV4LL KCU25	C162
NV4RL KCU25	C162
NVHBL2020K11	E37
NVHBL2525M11	E37
NVHBR2020K11	E37
NVHBR2525M11	E37
NVLBL2020K11	E38
NVLBL2525M11	E38
NVLBR2020K11	E38
NVLBR2525M11	E38
NVLCL2020K16	E38
NVLCL2525M16	E38
NVLCL3225P16	E38
NVLCR1616H16	E38
NVLCR2020K16	E38
NVLCR2525M16	E38
NVLCR3225P16	E38
NVOCL2020K16	E39
NVOCL2525M16	E39
NVOCR2020K16	E39
NVOCR2525M16	E39
NVVCN2020K16	E40
NVVCN2525M16	E40
NWC3L11I KC5025	D25
NWC3R11E KC5010	D25
NWC3R11E KC5025	D25
NWC3R14E KC5010	D25
NWC3R14E KCU25	D25
OFKT06L5AFENGB KC520M	S50
OFKT06L5AFENGB KC522M	S50
OFKT06L5AFENGB KC725M	S50
OFKT06L5AFENGB KCK15	S50
OFKT06L5AFENGB KCPK30	S50
OFKT06L5AFENGB KCPM40	S50
OFKT06L5AFENGB KCSM40	S50
OFKT06L5AFENLB KC522M	S50
OFKT06L5AFENLB KC725M	S50
OFKT06L5AFENLB KCK15	S50
OFKT06L5AFENLB KCPK30	S50
OFKT06L5AFENLB KCSM40	S50
OFKT06L5AFENLBJ KC422M	S49
OFKT06L5AFFNLBJ KC410M	S49
OFKT06L5AFFNLNJ KC410M	S49
OFKT06L5AFSNHB KC522M	S50
OFKT06L5AFSNHB KC725M	S50
OFKT06L5AFSNHB KCPK30	S50
OFKT06L5AFSNHB KCSM40	S50
OFKT06L5AFSNLB KC520M	S50
OFKT06L5AFSNLB KC522M	S50
OFKT06L5AFSNLB KC725M	S50
OFKT06L5AFSNLB KCPK30	S50
OFKT07L6AFENGB KC520M	S55
OFKT07L6AFENGB KC522M	S55
OFKT07L6AFENGB KC725M	S55
OFKT07L6AFENGB KCPK30	S55
OFKT07L6AFENGB KCPM40	S55
OFKT07L6AFENGB KCSM30	S55
OFKT07L6AFENGB KCSM40	S55
OFKT07L6AFENLB KC522M	S54
OFKT07L6AFENLB KC725M	S54
OFKT07L6AFENLB KCPK30	S54
OFKT07L6AFENLB KCSM40	S54
OFKT07L6AFFNLNJ KC410M	S54
OFKT07L6AFSNHB KC520M	S55
OFKT07L6AFSNHB KC522M	S55
OFKT07L6AFSNHB KC725M	S55
OFKT07L6AFSNHB KCPK30	S55
OFKT07L6AFSNHB KCPM40	S55
OFKT07L6AFSNHB KCSM40	S55
OFKT07L6AFSNLB KC725M	S54
OFKT07L6AFSNLB KCPK30	S54
OFPT06L5AFENGB KC520M	S51
OFPT06L5AFENGB KC725M	S51
OFPT06L5AFENGB KCK15	S51
OFPT06L5AFENGB KCPK30	S51
OFPT06L5AFENGB KCPM40	S51
OFPT06L5AFSNHB KC520M	S51
OFPT06L5AFSNHB KC725M	S51
OFPT06L5AFSNHB KCK15	S51
OFPT06L5AFSNHB KCPK30	S51
OFPT06L5AFSNHB KCSM40	S51
OFPT07L6AFENGB KC520M	S55
OFPT07L6AFENGB KC522M	S55
OFPT07L6AFENGB KC725M	S55
OFPT07L6AFENGB KCK15	S55
OFPT07L6AFENGB KCPK30	S55
OFPT07L6AFENGB KCPM40	S55
OFPT07L6AFSNHB KC522M	S55
OFPT07L6AFSNHB KC725M	S55
OFPT07L6AFSNHB KCK15	S55
OFPT07L6AFSNHB KCPK30	S55
OFPT07L6AFSNHB KCPM40	S55
OFPT07L6AFSNHB KCSM40	S55
ONGX080608SNHB KC514M	S36
ONGX080608SNHB KCK15	S36
ONGX080620ENLE KC514M	S35
ONGX080620ENLE KCK15	S35
ONGX080620ENLE KCK20	S35
ONGX080620SNGP KC514M	S35
ONGX080620SNGP KCK15	S35
ONGX080620SNGP KCK20	S35
ONGX080620SNGP KCPK30	S35
ONGX080620SNHB KC514M	S36
ONGX080620SNHB KCK15	S36
ONGX080620SNHB KCK20	S36
ONGX080620SNHB KCPK30	S36
ONGX080630SNHB KC514M	S36
ONGX080630SNHB KCK15	S36
ONGX080630SNHB KCK20	S36
ONGX0806ANENLE KC514M	S35
ONGX0806ANENLE KCK15	S35
ONGX0806ANENLE KCK20	S35
ONGX0806ANSNGP KC514M	S35
ONGX0806ANSNGP KCK15	S35
ONGX0806ANSNGP KCK20	S35
ONPX080608SNGP KCK15	S36
ONPX080608SNGP KCK20	S36
ONPX080608SNGP KCPK30	S36
ONPX080620SNHB KCK15	S36
ONPX080620SNHB KCK20	S36
ONPX080620SNHB KCPK30	S36
PCBNL2020K12	B64
PCBNL2525M12	B64
PCBNL2525M16	B64
PCBNL3232P16	B64
PCBNL3232P19	B64
PCBNL4040S19	B64
PCBNR2525M12	B64
PCBNR2525M16	B64
PCBNR3225P12	B64
PCBNR3225P16	B64
PCBNR3232P16	B64
PCBNR3232P19	B64
PCBNR4040S19	B64
PCKNL2020K12	B64
PCKNL2525M12	B64
PCKNL3225P12	B64
PCKNL3225P16	B64
PCKNL3232P19	B64
PCKNR2020K12	B64
PCKNR2525M12	B64
PCKNR2525M16	B64
PCKNR3225P12	B64
PCKNR3225P16	B64
PCKNR3232P19	B64
PCLNL1616H12	B65
PCLNL16CA-12	B73
PCLNL2020K12	B65
PCLNL2525M12	B65
PCLNL2525M16	B65
PCLNL2525M19	B65
PCLNL3225P12	B65
PCLNL3225P16	B65
PCLNL3225P19	B65
PCLNL3232P16	B65
PCLNL3232P19	B65
PCLNL4040S19	B65
PCLNR12CA-12	B73
PCLNR1616H12	B65
PCLNR16CA-12	B73
PCLNR2020K12	B65
PCLNR2525M12	B65
PCLNR2525M16	B65
PCLNR2525M19	B65
PCLNR3225P12	B65
PCLNR3225P16	B65
PCLNR3225P19	B65
PCLNR3232P16	B65

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
PCLNR3232P19	B65
PCLNR4040S19	B65
PCSNL2020K12	B66
PCSNL2525M12	B66
PCSNL3225P12	B66
PCSNL3232P19	B66
PCSNR2020K12	B66
PCSNR2525M12	B66
PCSNR3225P12	B66
PCSNR3232P19	B66
PDC251A04763DA KD1415	G110
PDC251A06350DA KD1415	G110
PDC251A07938DA KD1415	G110
PDC251A09525DA KD1415	G110
PDC251A11113DA KD1415	G110
PDC251A12700DA KD1415	G110
PDJNL1616H11	B87
PDJNL2020K11	B87
PDJNL2020K15	B87
PDJNL2525M11	B87
PDJNL2525M15	B87
PDJNL3225P15	B87
PDJNL3232P15	B87
PDJNL4025R15	B87
PDJNR1616H11	B87
PDJNR2020K11	B87
PDJNR2020K15	B87
PDJNR2525M11	B87
PDJNR2525M15	B87
PDJNR3225P15	B87
PDJNR3232P15	B87
PDJNR4025R15	B87
PDNNL2020K11	B88
PDNNL2020K15	B88
PDNNL2525M11	B88
PDNNL2525M15	B88
PDNNL4025M15	B88
PDNNR2020K11	B88
PDNNR2020K15	B88
PDNNR2525M15	B88
PDNNR4025M15	B88
PKG-8001	K128–130
PKG0002	K141
PKG0011	K126
PKG1402	K126
PKG1565	K137–139
PKG156502	K139–140
PKG1602	K126
PKG1802	K126
PKG2025	K130, K132
PKG3242	K130, K132
PKG7001	K124
PKG7994	K141
PMT04525	C63, C133
PSBNL2020K12	B111
PSBNL2525M12	B111
PSBNL2525M15	B111
PSBNL3232P15	B111
PSBNL3232P19	B111
PSBNL4040S19	B111
PSBNL4040S25	B111
PSBNR2020K12	B111
PSBNR2525M12	B111
PSBNR2525M15	B111
PSBNR3225P12	B111
PSBNR3232P15	B111
PSBNR3232P19	B111
PSBNR4040S19	B111
PSBNR4040S25	B111
PSC40KGMEL50C	C65, C135
PSC40KGMER50C	C65, C135
PSC40KGMSL50C	C64, C134
PSC40KGMSR50C	C64, C134
PSC50KGMEL50C	C65, C135
PSC50KGMEL65C	C65, C135
PSC50KGMER50C	C65, C135
PSC50KGMER65C	C65, C135
PSC50KGMSL50C	C64, C134
PSC50KGMSL65C	C64, C134
PSC50KGMSR50C	C64, C134
PSC50KGMSR65C	C64, C134
PSC63DL10050M	052
PSC63DL12050M	052
PSC63DL16055M	052
PSC63DL20055M	052
PSC63DL25060M	052
PSC63DL32068M	052
PSC63KGMEL50C	C65, C135
PSC63KGMEL65C	C65, C135
PSC63KGMER50C	C65, C135
PSC63KGMER65C	C65, C135
PSC63KGMSL50C	C64, C134
PSC63KGMSL65C	C64, C134
PSC63KGMSR50C	C64, C134
PSC63KGMSR65C	C64, C134
PSC80KGMEL50C	C65, C135
PSC80KGMEL65C	C65, C135
PSC80KGMER50C	C65, C135
PSC80KGMER65C	C65, C135
PSC80KGMSL50C	C64, C134
PSC80KGMSL65C	C64, C134
PSC80KGMSR50C	C64, C134
PSC80KGMSR65C	C64, C134
PSDNN1616H09	B111
PSDNN2020K12	B111
PSDNN2525M12	B111
PSDNN3225P12	B111
PSDNN3225P19	B111
PSDNN3232P19	B111
PSDNN4040S25	B111
PSKNL2525M12	B112
PSKNL3232P19	B112
PSKNR12CA-12	B120
PSKNR2020K12	B112
PSKNR2525M12	B112
PSKNR3232P15	B112
PSKNR3232P19	B112
PSSNL12CA12	B121
PSSNL2020K12	B113
PSSNL2525M12	B113
PSSNL2525M15	B113
PSSNL3225P12	B113
PSSNL3232P19	B113
PSSNL4040S19	B113
PSSNR12CA-12	B121
PSSNR2020K09	B113
PSSNR2020K12	B113
PSSNR2525M12	B113
PSSNR2525M15	B113
PSSNR3225P12	B113
PSSNR3232P15	B113
PSSNR3232P19	B113
PSSNR4040S19	B113
PT00163	E54
PTFNL12CA-16	B142
PTFNL2020K16	B135
PTFNL2525M16	B135
PTFNR12CA-16	B142
PTFNR2020K16	B135
PTFNR2525M16	B135
PTGNL1616H16	B135
PTGNL2020K16	B135
PTGNL2525M16	B135
PTGNL2525M22	B135
PTGNR1616H16	B135
PTGNR2020K16	B135
PTGNR2525M16	B135
PTGNR2525M22	B135
PWLNL1616H06	B163
PWLNL2020K06	B163
PWLNL2020K08	B163
PWLNL2525M08	B163
PWLNL3225P08	B163
PWLNR1616H06	B163
PWLNR2020K06	B163
PWLNR2020K08	B163
PWLNR2525M08	B163
PWLNR3225P08	B163
QC26	B250
QTM20 WG	B273
R125FBHS09	K136
R24FBHS06	K136
R24FBHS06LF	K136
R30FBHS06	K136
R31FBHS06	K136
R31FBHS06LF	K136
R38FBHS06	K136
R40FBHS06	K136
R40FBHS06LF	K136
R48FBHS06	K136
R51FBHS06	K136
R51FBHS06LF	K136
R65FBHS06	K136
R67FBHS06	K136
R67FBHS09	K136
R67FBHS09LF	K136
R82154	K74
R85FBHS06	K136
R85FBHS09	K136
RCGH120400 KC5010	B222
RCGH120400 KCU10	B222
RCGH120400MP KCS10	B222
RCGK040300FS KCU10	E63
RCGK040300HP K313	E63
RCGK040300HP KC5010	E63
RCGK040300HP KCU10	E63
RCGK060400FS KC5010	E63
RCGK060400FS KCU10	E63
RCGK060400HP KC5010	E63
RCGK060400HP KC5410	E63
RCGK060400HP KCU10	E63
RCGK090700FS KC5010	E63
RCGK090700FS KC5025	E63
RCGK090700FS KCU10	E63
RCGK090700HP KC5410	E63
RCGK090700HP KCU10	E63
RCGK120800FS KCU10	E63
RCGK120800HP KC5410	E63
RCGK120800HP KCU10	E63
RCGN090400T01015 KBK45	B288
RCGT0602M0RP KCP25B	B223
RCGT0803M0HP K313	B222
RCGT0803M0HP K68	B222
RCGT0803M0HP KC5010	B222
RCGT0803M0HP KC5410	B222
RCGT0803M0HP KCU25	B222
RCGT0803M0MS KC5010	B223
RCGT0803M0MS KCU10	B223
RCGT0803M0RP KCP25B	B223
RCGT10T3M0HP K313	B222
RCGT10T3M0HP KC5010	B222
RCGT10T3M0HP KC5025	B222
RCGT10T3M0HP KC5410	B222
RCGT10T3M0HP KCU10	B222
RCGT10T3M0HP KCU25	B222
RCGT1204M0HP K313	B222
RCGT1204M0HP KC5010	B222
RCGT1204M0HP KC5025	B222
RCGT1204M0HP KCU10	B222
RCGT1204M0MS KC5010	B223
RCGT1204M0MS KCU10	B223
RCGT1204M0MS KCU25	B223
RCGT1204M0RP KCP25	B223
RCGT1606M0MS KCU10	B223
RCGT1606M0MS KCU25	B223
RCGT2006M0ELF KC725M	V83
RCGT2006M0ELF KCSM40	V83
RCGT2006M0SGF KC522M	V83
RCGT2006M0SGF KC725M	V83
RCGT2006M0SGFJ KCPM40	V83
RCGT2006M0SGFJ KCSM30	V83
RCGT2006M0SHF KC725M	V83
RCGT2006M0SHF KCPK30	V83
RCGT2006M0SHF KCSM40	V83
RCGT2006M0SHFJ KCPM40	V83
RCGV060400 KC5010	B166
RCGV060400 KCU10	B166
RCGV090700 KC5010	B166
RCGV120700 K313	B166
RCGV120700 KC5010	B166
RCGW1204M0T01020 KY1615	B316
RCGX060400E KYS25	B333
RCGX060400E KYS30	B333
RCGX060400MP KCS10	B166
RCGX0907-001 KY1615	B316
RCGX090700E KYS25	B333
RCGX090700E KYS30	B333
RCGX090700T00525 KYS30	B333
RCGX090700T01020 KY1615	B315
RCGX090700T01020 KYS25	B333
RCGX090700T01020 KYS30	B333
RCGX090700T02020 KY1615	B315
RCGX090700T10015 KY1615	B315
RCGX090700T20015 KY1615	B315
RCGX120700E KYS25	B333
RCGX120700E KYS30	B333
RCGX120700MP KCS10	B166
RCGX120700T01020 KYS25	B333
RCGX120700T01020 KYS30	B333
RCGX120700T01025 KYS25	B333
RCGX120700T01025 KYS30	B333
RCGX120700T02020 KY1615	B315
RCGX120700T10015 KY1615	B315
RCGX120700T20015 KY1615	B315
RCGX151000T20015 KY1615	B315
RCGX191000T20015 KY1615	B315
RCGX251200T20015 KY1615	B315
RCMH190600K KCP10B	B223
RCMH2507M0RU KCP25	E60
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RCMH2507M0TUPG KCP25B	E60
RCMH3209M0RU KCP25	E60
RCMH3209M0TUP KCP25B	E60
RCMH3209M0TUPG KCP10B	E60
RCMH3209M0TUPG KCP25B	E60
RCMK040300 K313	E63
RCMK040300 KC5010	E63
RCMK060400 K313	E63
RCMK060400 KC5010	E63
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RCMK060400MP KCS10	E64
RCMK090700 K313	E63
RCMK090700 KC5010	E63
RCMK090700MP KCS10	E64
RCMK120800 KC5010	E63
RCMK120800MP KCS10	E64
RCMT060200 KC5010	B224
RCMT060200 KCP25	B224
RCMT060200 KCU10	B224
RCMT0602M0 K313	B224
RCMT0602M0 K68	B224
RCMT0602M0 KC5010	B224
RCMT0602M0 KCM25	B224
RCMT0602M0 KCP25	B224
RCMT0602M0 KCP30	B224
RCMT0602M0 KCU10	B224
RCMT0803M0 K313	B224
RCMT0803M0 KC5010	B224
RCMT0803M0 KCK20B	B224
RCMT0803M0 KCM25	B224
RCMT0803M0 KCP25	B224
RCMT0803M0MP KCS10	B224
RCMT09T300 K313	B224
RCMT09T300 KC5010	B224
RCMT09T300 KCP25	B224
RCMT09T300 KCU10	B224
RCMT10T3M0 KC5010	B224
RCMT10T3M0 KCK20B	B224
RCMT10T3M0 KCM25	B224
RCMT10T3M0 KCP25	B224
RCMT10T3M0 KCP30	B224
RCMT10T3M0 KCU10	B224
RCMT10T3M0MP KCS10	B224
RCMT120400 KC5010	B224
RCMT120400 KCK20	B224
RCMT120400 KCM25	B224
RCMT120400 KCP10B	B224
RCMT120400MP KCS10	B224
RCMT1204M0 K313	B224
RCMT1204M0 KC5010	B224
RCMT1204M0 KCK15B	B224
RCMT1204M0 KCK20	B224
RCMT1204M0 KCK20B	B224
RCMT1204M0 KCM25	B224
RCMT1204M0 KCM25B	B224
RCMT1204M0 KCP30	B224
RCMT1204M0 KCU10	B224
RCMT1204M0MP KCS10	B224

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
RCMT1204M0RP KCK15	B226
RCMT1204M0RP KCK20	B226
RCMT1204M0RP KCP10	B226
RCMT1204M0RP KCP10B	B226
RCMT1204M0RP KCP25	B226
RCMT1204M0RP KCP25B	B226
RCMT1605M0 K313	B224
RCMT1605M0 KC5010	B224
RCMT1605M0 KCK20	B224
RCMT1605M0 KCM25	B224
RCMT1605M0 KCP25	B224
RCMT1605M0 KCU10	B224
RCMT1606M0MP KCS10	B224
RCMT1606M0RP KCK15	B226
RCMT1606M0RP KCP25	B226
RCMT1606M0RP KCP25B	B226
RCMT1606M0UP KCP10B	E60
RCMT1606M0UP KCP25B	E60
RCMT1606M0UPG KCK15B	E60
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RCMT1606M0UPG KCP25B	E60
RCMT1606M0UPG KCPK05	E60
RCMT2006M0 K313	B224
RCMT2006M0 KC5010	B224
RCMT2006M0 KCK20B	B224
RCMT2006M0 KCM25	B224
RCMT2006M0 KCP25	B224
RCMT2006M0 KCU10	B224
RCMT2006M0RH KCP10	B225
RCMT2006M0RH KCP25	B225
RCMT2006M0RM KCP25	B225
RCMT2006M0RP KCK20	B226
RCMT2006M0RP KCK20B	B226
RCMT2006M0RP KCP25	B226
RCMT2006M0UP KCP10B	E60
RCMT2006M0UP KCP25B	E60
RCMT2006M0UP KCPK05	E60
RCMT2006M0UPG KCK15B	E60
RCMT2006M0UPG KCP10B	E60
RCMT2006M0UPG KCP25B	E60
RCMT2006M0UPG KCPK05	E60
RCMX1003M0RP KCP10B	B226
RCMX1003M0RP KCP25B	B226
RCMX2507M076 KCP25B	E53
RCMX2507M0RH KCP10	B225
RCMX2507M0RH KCP25	B225
RCMX2507M0RP KCP25	B226
RCMX2507M0RP KCP30	B226
RCMX2507M0RU KCK20	E61
RCMX2507M0TUPG KCP10B	E61
RCMX2507M0TUPG KCP25B	E61
RCMX3209M0RH KCP25	B225
RCMX3209M0RU KCK20	E61
RCMX3209M0RU KCP10	E61
RCMX3209M0TUPG KCP10B	E61
RCMX3209M0TUPG KCP25B	E61
RHM14000KST115H7HF KT325	K31
RHM14000KST115H7HF KT6215	K31
RHM14000KST115H7SF KT325	K29
RHM14000KST115H7SF KT6215	K29
RHM14288KST115H7HF KT325	K31
RHM14288KST115H7HF KT6215	K31
RHM14288KST115H7SF KT325	K29
RHM14288KST115H7SF KT6215	K29
RHM15000KST115H7SF KT325	K29
RHM15875KST115H7HF KT325	K31
RHM15875KST115H7SF KT325	K29
RHM15875KST115H7SF KT6215	K29
RHM16000KST135H7HF KT325	K31
RHM16000KST135H7HF KT6215	K31
RHM16000KST135H7SF KT325	K29
RHM16000KST135H7SF KT6215	K29
RHM17000KST135H7HF KT325	K31
RHM17000KST135H7HF KT6215	K31
RHM17000KST135H7SF KT325	K29
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RHM19050KST155H7HF KT6215	K31
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RHM20000KST175H7HF KT325	K31
RHM20000KST175H7HF KT6215	K31
RHM20000KST175H7SF KT325	K29
RHM20000KST175H7SF KT6215	K29
RHM20640KST175H7HF KT325	K31
RHM20640KST175H7HF KT6215	K31
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RHM22230KST175H7SF KT6215	K29
RHM22500KST200H7HF KT325	K31
RHM22500KST200H7HF KT6215	K31
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RHM23810KST200H7SF KT6215	K29
RHM24000KST200H7HF KT325	K31
RHM24000KST200H7HF KT6215	K31
RHM24000KST200H7SF KT325	K29
RHM24000KST200H7SF KT6215	K29
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RHM25000KST200H7HF KT6215	K31
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RHM25400KST200H7HF KT325	K31
RHM25400KST200H7HF KT6215	K31
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RHM27500KST250H7SF KT6215	K30
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RHM28000KST250H7HF KT6215	K32
RHM28000KST250H7SF KT325	K30
RHM28000KST250H7SF KT6215	K30
RHM28580KST250H7HF KT325	K32
RHM28580KST250H7SF KT325	K30
RHM28580KST250H7SF KT6215	K30
RHM29000KST250H7HF KT325	K32
RHM29000KST250H7HF KT6215	K32
RHM29000KST250H7SF KT325	K30
RHM29000KST250H7SF KT6215	K30
RHM30000KST250H7HF KT325	K32
RHM30000KST250H7HF KT6215	K32
RHM30000KST250H7SF KT325	K30
RHM30000KST250H7SF KT6215	K30
RHM30160KST250H7HF KT325	K32
RHM30160KST250H7HF KT6215	K32
RHM30160KST250H7SF KT325	K30
RHM31000KST250H7HF KT325	K32
RHM31000KST250H7HF KT6215	K32
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RHM31750KST250H7SF KT325	K30
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RHM33000KST300H7SF KT6215	K30
RHM33340KST300H7HF KT325	K32
RHM33340KST300H7HF KT6215	K32
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RHM33340KST300H7SF KT6215	K30
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RHM34000KST300H7SF KT325	K30
RHM34930KST300H7HF KT325	K32
RHM34930KST300H7HF KT6215	K32
RHM34930KST300H7SF KT325	K30
RHM34930KST300H7SF KT6215	K30
RHM35000KST300H7HF KT325	K32
RHM35000KST300H7HF KT6215	K32
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RHM35000KST300H7SF KT6215	K30
RHM36000KST300H7HF KT325	K32
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RHM36000KST300H7SF KT6215	K30
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RHM36510KST300H7SF KT325	K30
RHM36510KST300H7SF KT6215	K30
RHM37000KST300H7HF KT325	K32
RHM37000KST300H7HF KT6215	K32
RHM37000KST300H7SF KT325	K30
RHM37500KST350H7HF KT325	K32
RHM37500KST350H7HF KT6215	K32
RHM37500KST350H7SF KT325	K30
RHM37500KST350H7SF KT6215	K30
RHM38000KST350H7SF KT325	K30
RHM38000KST350H7SF KT6215	K30
RHM38100KST350H7HF KT325	K32
RHM38100KST350H7SF KT325	K30
RHM38100KST350H7SF KT6215	K30
RHM39000KST350H7HF KT325	K32
RHM39000KST350H7HF KT6215	K32
RHM39000KST350H7SF KT325	K30
RHM39000KST350H7SF KT6215	K30
RHM39690KST350H7HF KT325	K32
RHM39690KST350H7HF KT6215	K32
RHM39690KST350H7SF KT325	K30
RHM39690KST350H7SF KT6215	K30
RHM40000KST350H7HF KT325	K32
RHM40000KST350H7HF KT6215	K32
RHM40000KST350H7SF KT6215	K30
RHM41000KST350H7HF KT325	K32
RHM41000KST350H7HF KT6215	K32
RHM41000KST350H7SF KT325	K30
RHM41000KST350H7SF KT6215	K30
RHM41280KST350H7HF KT325	K32
RHM41280KST350H7HF KT6215	K32
RHM41280KST350H7SF KT325	K30
RHM41280KST350H7SF KT6215	K30
RHM42000KST350H7HF KT325	K32
RHM42000KST350H7HF KT6215	K32
RHM42000KST350H7SF KT325	K30
RHM42000KST350H7SF KT6215	K30
RHME14000KST115H6HF KC6005	K34
RHME14000KST115H6HF KC6305	K34
RHME14000KST115H6SF KC6005	K33
RHME14000KST115H6SF KC6305	K33
RHME14288KST115H6HF KC6005	K34
RHME14288KST115H6HF KC6305	K34
RHME14288KST115H6SF KC6005	K33
RHME14288KST115H6SF KC6305	K33
RHME15000KST115H6HF KC6005	K34
RHME15000KST115H6HF KC6305	K34
RHME15000KST115H6SF KC6005	K33
RHME15000KST115H6SF KC6305	K33
RHME16000KST135H6HF KC6005	K34
RHME16000KST135H6HF KC6305	K34
RHME16000KST135H6SF KC6005	K33
RHME16000KST135H6SF KC6305	K33
RHME17000KST135H6HF KC6005	K34
RHME17000KST135H6HF KC6305	K34
RHME17000KST135H6SF KC6005	K33
RHME17000KST135H6SF KC6305	K33
RHME17463KST135H6HF KC6005	K34
RHME17463KST135H6HF KC6305	K34
RHME17463KST135H6SF KC6005	K33
RHME17463KST135H6SF KC6305	K33
RHME18000KST155H6HF KC6005	K34
RHME18000KST155H6HF KC6305	K34
RHME18000KST155H6SF KC6005	K33
RHME18000KST155H6SF KC6305	K33
RHME19000KST155H6HF KC6005	K34
RHME19000KST155H6HF KC6305	K34
RHME19000KST155H6SF KC6005	K33
RHME19000KST155H6SF KC6305	K33
RHME19050KST155H6HF KC6005	K34
RHME19050KST155H6HF KC6305	K34
RHME19050KST155H6SF KC6005	K33
RHME19050KST155H6SF KC6305	K33
RHME20000KST175H6HF KC6005	K34
RHME20000KST175H6HF KC6305	K34
RHME20000KST175H6SF KC6005	K33
RHME20000KST175H6SF KC6305	K33
RHME21000KST175H6HF KC6005	K34
RHME21000KST175H6HF KC6305	K34
RHME21000KST175H6SF KC6005	K33
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RHME22000KST175H6HF KC6005	K34
RHME22000KST175H6HF KC6305	K34
RHME22000KST175H6SF KC6005	K33
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RHME22225KST175H6HF KC6005	K34
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RHME22225KST175H6SF KC6305	K33
RHME23000KST200H6HF KC6005	K34
RHME23000KST200H6HF KC6305	K34
RHME23000KST200H6SF KC6005	K33
RHME23000KST200H6SF KC6305	K33
RHME23813KST200H6HF KC6005	K34
RHME23813KST200H6HF KC6305	K34
RHME23813KST200H6SF KC6005	K33
RHME23813KST200H6SF KC6305	K33
RHME24000KST200H6HF KC6005	K34
RHME24000KST200H6HF KC6305	K34
RHME24000KST200H6SF KC6005	K33
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RHME25000KST200H6SF KC6305	K33
RHME25400KST200H6HF KC6005	K34
RHME25400KST200H6HF KC6305	K34
RHME25400KST200H6SF KC6005	K33
RHME25400KST200H6SF KC6305	K33
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RHME26000KST200H6SF KC6005	K33
RHME26000KST200H6SF KC6305	K33
RHME27000KST200H6HF KC6005	K34
RHME27000KST200H6HF KC6305	K34
RHME27000KST200H6SF KC6005	K33
RHME27000KST200H6SF KC6305	K33
RHME28000KST250H6HF KC6005	K34
RHME28000KST250H6HF KC6305	K34
RHME28000KST250H6SF KC6005	K33
RHME28000KST250H6SF KC6305	K33
RHME30000KST250H6HF KC6005	K34
RHME30000KST250H6HF KC6305	K34
RHME30000KST250H6SF KC6005	K33
RHME30000KST250H6SF KC6305	K33
RHME31750KST250H6HF KC6005	K34

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
RHME31750KST250H6HF KC6305	K34
RHME31750KST250H6SF KC6005	K33
RHME31750KST250H6SF KC6305	K33
RHME32000KST250H6HF KC6005	K34
RHME32000KST250H6HF KC6305	K34
RHME32000KST250H6SF KC6005	K33
RHME32000KST250H6SF KC6305	K33
RHME34000KST300H6HF KC6005	K34
RHME34000KST300H6HF KC6305	K34
RHME34000KST300H6SF KC6005	K33
RHME34000KST300H6SF KC6305	K33
RHME36000KST300H6HF KC6005	K34
RHME36000KST300H6HF KC6305	K34
RHME36000KST300H6SF KC6005	K33
RHME36000KST300H6SF KC6305	K33
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RHME40000KST350H6HF KC6305	K34
RHME40000KST350H6SF KC6005	K33
RHME40000KST350H6SF KC6305	K33
RHME42000KST350H6HF KC6005	K34
RHME42000KST350H6HF KC6305	K34
RHME42000KST350H6SF KC6005	K33
RHME42000KST350H6SF KC6305	K33
RHR14000KST115H7HF KCU05	K28
RHR14000KST115H7SF KCU05	K27
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RHR23000KST200H7HF KCU05	K28
RHR23000KST200H7SF KCU05	K27
RHR24000KST200H7HF KCU05	K28
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RHR25000KST200H7HF KCU05	K28
RHR25000KST200H7SF KCU05	K27
RHR26000KST200H7HF KCU05	K28
RHR26000KST200H7SF KCU05	K27
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RHR27000KST200H7SF KCU05	K27
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RHR40000KST350H7SF KCU05	K27
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RHR42000KST350H7HF KCU05	K28
RHR42000KST350H7SF KCU05	K27
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RIQ06EDR00 KC6105	K56
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RIQ06EDR12 KC6005	K56
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RIQ06EGR06 KC6305	K56
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RIQ06EGR12 KC6005	K56
RIQ06EGR12 KC6105	K56
RIQ06EGR12 KC6305	K56
RIQ06R0200 KD1415	K54
RIQ06R0400FB KT6225	K55
RIQ06R0400S KB1610	K54
RIQ06R0500FT KT6315	K55
RIQ07C4500S KBHK10	K56
RIQ07C4500S KBHK15	K56
RIQ08C4500S KBHK10	K56
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RIQ09C4500S KBHK15	K56
RIQ09E1300 KC6005	K55
RIQ09E1300 KC6105	K55
RIQ09E1300 KC6305	K55
RIQ09E1306 KC6005	K55
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RIQ09E1306 KC6305	K55
RIQ09E1312 KC6005	K55
RIQ09E1312 KC6105	K55
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RIQ09EDR00 KC6005	K56
RIQ09EDR00 KC6105	K56
RIQ09EDR00 KC6305	K56
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RIQ09EDR06 KD1415	K56
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RIQ09EGR12 KC6305	K56
RIQ09R0400FB KT6225	K55
RIQ09R0400S KB1610	K54
RIQ09R0506FT KT6315	K55
RIQB6C4500S KBHK10	K56
RIQB6C4500S KBHK15	K56
RIQB7C4500S KBHK10	K56
RIQB7C4500S KBHK15	K56
RIR01E1306 KC6105	K53
RIR01E1312 KC6105	K53
RIR01EGU00 KC6105	K53
RIR02E1312 KC6105	K53
RIR02E1312 KC6305	K53
RIR03E1312 KC6305	K53
RIR04E1312 KC6005	K53
RIR04E1312 KC6105	K53
RIR04EDS06 KD1415	K53
RIR05EGU00 KC6105	K53
RIRT4C4512 KC6005	K54
RK90SD1218	U40, U42, U44, U48
RK90SD1220	U43, U45, U49
RK90SP1014	U27, U30, U32, U34
RK90SP1016	U31, U35
RKDF1000X4CQE KCSM15	O35
RKDF1200X4CQF KCSM15	O35
RKDF1600X6CQF KCSM15	O35
RKDF2000X6CQF KCSM15	O35
RKDF2500X6CQF KCSM15	O35
RMB14000H7HF KT6215	K18
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RMB17000H7SF KT6215	K17
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RMB20000H7HF KT6215	K18
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RMBE14000H6HF KC6005	K20
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RMBE15000H6HF KC6005	K20
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RMR15000H7HF KCU05	K16
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RMS14000H7SF KC6305	K8
RNGA090300T02020 KY1615	B316
RNGA120400T02020 KY1615	B316
RNGJ10T3M0ELDJ KC725M	V50
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RNGJ10T3M0SGDJ KC725M	V51
RNGJ10T3M0SGDJ KCSM30	V51
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RNGJ1204M0SNGDJX KC725M	V65
RNGJ1605M0ELDJ KC522M	V61
RNGJ1605M0ELDJ KC725M	V61
RNGN090300S02015C KB5630	B317
RNGN090300T02020 KY1615	B316
RNGN090400S02020 KBK45	B284
RNGN090400T02020 KY1615	B316
RNGN120300T02020 KY1615	B316
RNGN120400EGN KYS30	V148
RNGN120400EGN KYSP30	V148
RNGN120400S02020 KBK45	B284
RNGN120400T01020 KYS30	B334
RNGN120400T02020 KY1615	B316
RNGN120400T02020 KY3500	B296
RNGN120400T02020 KYK10	B296
RNGN120400TGN KYS30	V148
RNGN120400TGN KYSP30	V148
RNGN120700T00525 KYS30	B334
RNGN120700T01020 KYS30	B334
RNGN120700T01025 KYS25	B334
RNGN120700T01025 KYS30	B334
RNGN120700T02020 KY1615	B316
RNGN120700T02020 KY3500	B296
RNGN120700T10015 KY1615	B316
RNGN120700T20015 KY1615	B316
RNGN190700T01020 KYS30	B334

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
RNGN190700T02020 KY1615	B316
RNGN190700T02020 KY3500	B296
RNGX120400S02020 KBK45	B287
RNMA120400 K68	B94
RNMA150600 K68	B94
RNMG090300RN KCP25	B94
RNMG090300RN KCP25B	B94
RNMG120400RN KC5010	B94
RNMG120400RN KCP10	B94
RNMG120400RN KCP10B	B94
RNMG120400RN KCP25B	B94
RNMG120400RN KCP30	B94
RNMG120400RN KCU10	B94
RNMG120400UN KCK15B	B94
RNMG120400UN KCK20	B94
RNMG150600RN KCP25B	B94
RNMG150600RN KCP30	B94
RNMG190600 K313	B94
RNMG190600 KCP25	B94
RNMG190600 KCP40	B94
RNMG190600RN KC5010	B94
RNMG190600RN KCP25	B94
RNMG190600RN KCP25B	B94
RNMG190600RN KCP40B	B94
RNMG190600RN KCU10	B94
RNMG250900RN KCP10	B94
RNMG250900RN KCP25	B94
RNMN090300S02020 KB1340	B285
RNMN120300S02020 KB1340	B285
RNMN120400S02020 KB1340	B285
RNPJ10T3M0SGD KC522M	V51
RNPJ10T3M0SGD KCPK30	V51
RNPJ10T3M0SGD KCPM40	V51
RNPJ10T3M0SHD KC725M	V51
RNPJ10T3M0SHD KCK15	V51
RNPJ10T3M0SHD KCPK30	V51
RNPJ10T3M0SHD KCPM40	V51
RNPJ1204M0SGD KC522M	V58
RNPJ1204M0SGD KC725M	V58
RNPJ1204M0SGD KCPK30	V58
RNPJ1204M0SGD KCPM40	V58
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RNPJ1204M0SHD KCPM40	V58
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RNPJ1605M0SGD KC725M	V61
RNPJ1605M0SGD KCPK30	V61
RNPJ1605M0SGD KCPM40	V61
RNPJ1605M0SGD KCSM40	V61
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RNPJ1605M0SHD KCPK30	V61
RNPJ1605M0SHD KCPM40	V61
RPET1204M0ELE KC725M	V73
RPET1204M0ELE KCPK30	V73
RPET1204M0ELEJ KC422M	V73
RPET1204M0ELEJ KC522M	V73
RPET1204M0ELEJ KC725M	V73
RPET1204M0ELEJ KCSM30	V73
RPET1204M0SGE KCPK30	V74
RPET1204M0SGEJ KC522M	V73
RPET1204M0SGEJ KC725M	V73
RPET1204M0SGEJ KCSM30	V73
RPET1605M0ELE KCPK30	V79
RPET1605M0ELEJ KC725M	V79
RPET1605M0SGE KCPK30	V79
RPET1605M0SGEJ KC522M	V79
RPET1605M0SGEJ KC725M	V79
RPET1605M0SGEJ KCSM30	V79
RPEX10T3M0F701X4 GH1	V90
RPEX10T3M0F701X4 SP4019	V90
RPEX1204M0E701X4 X500	V95
RPEX1204M0F701X4 GH1	V95
RPGN060200E KYS30	B334, V155
RPGN060200E KYSP30	V155
RPGN090300E KYS30	B334, V155
RPGN090300E KYSP30	V155
RPGN090300T01020 KYS30	B334, V155
RPGN120300 K313	B166
RPGN120400E KYS30	B334, V155
RPGN120400E KYSP30	V155
RPGN120400T01020 KYS30	B334, V155
RPGT060400MP KCS10	B229
RPGV060400 KC5010	B167
RPGV090700 KC5010	B167
RPGV120700 KC5010	B167
RPGV120700MP KC5010	B167
RPGX060400MP KCS10	B167
RPGX090700E KYS25	B334
RPGX090700E KYS30	B334
RPGX090700MP KCS10	B167
RPGX090700T01020 KYS30	B334
RPGX120700E KYS25	B334
RPGX120700E KYS30	B334
RPGX120700MP KCS10	B167
RPGX120700T01020 KYS30	B334
RPHT10T3M0E421X4 X500	V90
RPHT10T3M0E421X4 X700	V90
RPHT10T3M0E422X4 SP6519	V91
RPHT10T3M0E422X4 X500	V91
RPHT10T3M0E422X4 X700	V91
RPHT10T3M0E422X8 SP6519	V91
RPHT10T3M0E422X8 X500	V91
RPHT10T3M0E422X8 X700	V91
RPHT10T3M0TX4 SP6519	V91
RPHT10T3M0TX4 X500	V91
RPHT1204M0E421X4 X500	V95
RPHT1204M0E442X4 SP6519	V95
RPHT1204M0E442X4 X500	V95
RPHT1204M0E442X4 X700	V95
RPHT1204M0E442X5 SC6525	V96
RPHT1204M0E442X5 SP6519	V96
RPHT1204M0E442X5 X500	V96
RPHT1204M0E442X5 X700	V96
RPHT1204M0E442X8 SC6525	V96
RPHT1204M0SGDX5 KCM40	V96
RPHT1204M0SGDX8 KCM40	V96
RPHT1204M0TX4 SP6519	V96
RPHT1204M0TX4 X500	V96
RPHT1204M0TX4 X700	V96
RPMT10T3M0E41X4 MP91M	V91
RPMT10T3M0E41X4 SP6519	V91
RPMT10T3M0E41X4 X500	V91
RPMT1204M0E41X4 MP91M	V96
RPMT1204M0E41X4 SP6519	V96
RPMT1204M0E41X4 X500	V96
RPMW10T3M0TX4 X500	V91
RPMW1204M0TX4 MP91M	V97
RPMW1204M0TX4 SP6519	V97
RPMW1204M0TX4 X500	V97
RPPT10T3M0E432X5 SC6525	V91
RPPT10T3M0E432X5 SP6519	V91
RPPT10T3M0E432X5 X500	V91
RPPT10T3M0E432X5 X700	V91
RPPT1204M0E432X4 SC6525	V97
RPPT1204M0E432X4 X500	V97
RPPT1204M0E432X4 X700	V97
RPPT1204M0E432X5 SC6525	V97
RPPT1204M0E432X5 SP6519	V97
RPPT1204M0E432X5 X500	V97
RPPT1204M0E432X5 X700	V97
RPPT1204M0E432X8 SP6519	V97
RPPT1204M0E432X8 X500	V97
RPPT1204M0E432X8 X700	V97
RPPT1204M0SGDX KC725M	V74
RPPT1204M0SGDX KCPM40	V74
RPPT1204M0SGDX4 KCM40	V97
RPPT1204M0SGDX5 KCM40	V97
RPPT1204M0SGDX8 KCM40	V97
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RPPT1204M0SGP KCPM40	V74
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RPPT1605M0SHP KCPK30	V80
RPPT1605M0SHP KCPM40	V80
RQBB1000X4CN KCPM15	036
RQBB1200X4CN KCPM15	036
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RQBB2000X4CN KCPM15	036
RQBB2500X4CN KCPM15	036
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RQDB1200X4CV KCPM15	034
RQDB1600X4CV KCPM15	034
RQDB2000X4CV KCPM15	034
RQDB2500X5CV KCPM15	034
RS1605	K125
RS1606	K125
RS1608	K125
RS1610	K125
RS1612	K125
RUDC0400B3BN KCPM15	P80
RUDC0500B3BN KCPM15	P80
RUDC0600B3BN KCPM15	P80
RUDC0800B3BN KCPM15	P80
RUDC1000B4BN KCPM15	P80
RUDC1200B4BN KCPM15	P80
RUDC1400B4BN KCPM15	P80
RUDC1600B4BN KCPM15	P80
RUDC1800B4BN KCPM15	P80
RUDC2000B4BN KCPM15	P80
RUDC2500B5BN KCPM15	P80
S1006PKG	E59
S2160	V82
S32SCCLNR12MX7	B372
S40T-CCLNL12-MN7	B372
S40T-CCLNL12-MX7	B372
S40T-CCLNR12-MN4	B372
S40T-CCLNR12-MN7	B372
S40T-CCLNR12-MX7	B372
S40T-CSSNL12-MX7	B373
S40T-CSSNR12-MX7	B373
S40T-CSYNR12-MN7	B373
S40T-CWLNL08-MX7	B374
SALS063S	S126
SALS080	S126
SALS100	S126
SALS125	S126
SALS160	S126
SB3230	T118
SB3232	T118
SB3413	T115
SB3621	T115
SCACR1010M06Q	B179
SCACR1212M06Q	B179
SCACR1616K09Q	B179
SCDPR1212H06	B192
SCEPR1010H06	B192
SCEPR1212H06	B192
SCFPL08CA06	B199
SCFPR06CA05	B199
SCFPR08CA06	B199
SCFPR10CA09	B199
SCGCL1212N09	B179
SCGCR1010M06	B179
SCGCR1212N09	B179
SCGN090408EFW KY3500	B299
SCGN090408S01015WCB KBK45	B288
SCGN090408S01015WCC KBK45	B288
SCGPR08CA06	B200
SCKCR2020K09	B180
SCKPL08CA06	B201
SCKPR08CA06	B201
SCLCL0808L06	B180
SCLCL1010M06	B180
SCLCL1212N09	B180
SCLCL12CA12	B183
SCLCL1616H09	B180
SCLCL2020K09	B180
SCLCL2020K12	B180
SCLCL2525M09	B180
SCLCL2525M12	B180
SCLCR0808L06	B180
SCLCR1010M06	B180
SCLCR1212N09	B180
SCLCR12CA12	B183
SCLCR1616H09	B180
SCLCR16CA12	B183
SCLCR2020K09	B180
SCLCR2020K12	B180
SCLCR2525M09	B180
SCLCR2525M12	B180
SCLCRF0808M06Q	B181
SCLCRF1010M06Q	B181
SCLCRF1212M06Q	B181
SCLCRF1616K09Q	B181
SCLPL08CA06	B202
SCLPL10CA09	B202
SCLPL1212M06	B193
SCLPR06CA05	B202
SCLPR08CA06	B202
SCLPR10CA09	B202
SCLPR1212M06	B193
SCMT09T30411 KT315	B230
SCMT09T304FP KCM25	B230
SCMT09T304FP KCP10	B230
SCMT09T304FP KCP25	B230
SCMT09T304FP KCU10	B230
SCMT09T304FP KCU25	B230
SCMT09T304LF KC5010	B230
SCMT09T304LF KC5025	B230
SCMT09T304LF KCK05	B230
SCMT09T304LF KCK15B	B230
SCMT09T304LF KCK20	B230
SCMT09T304LF KCM25	B230
SCMT09T304LF KCP10	B230
SCMT09T304LF KCP10B	B230
SCMT09T304LF KCP25	B230
SCMT09T304LF KCP25B	B230
SCMT09T304LF KCP30	B230
SCMT09T304LF KT315	B230
SCMT09T304MP KCK20	B231
SCMT09T304MP KCM15	B231
SCMT09T304MP KCM25	B231
SCMT09T304MP KCP25	B231
SCMT09T304MP KCU10	B231
SCMT09T30811 KT315	B230
SCMT09T308FP KCK20	B230
SCMT09T308FP KCM15	B230
SCMT09T308FP KCP10	B230
SCMT09T308FP KCP25	B230
SCMT09T308FP KCP25B	B230
SCMT09T308FP KCU10	B230
SCMT09T308FP KCU25	B230
SCMT09T308FP KTP10	B230
SCMT09T308LF KC5010	B230
SCMT09T308LF KC5025	B230
SCMT09T308LF KCK05	B230
SCMT09T308LF KCK05B	B230
SCMT09T308LF KCK15	B230
SCMT09T308LF KCK15B	B230
SCMT09T308LF KCK20	B230
SCMT09T308LF KCK20B	B230
SCMT09T308LF KCM25	B230
SCMT09T308LF KCP10	B230
SCMT09T308LF KCP10B	B230
SCMT09T308LF KCP25	B230
SCMT09T308LF KCP25B	B230
SCMT09T308LF KCP30	B230
SCMT09T308MF KCK15	B231
SCMT09T308MF KCK15B	B231
SCMT09T308MF KCK20	B231
SCMT09T308MF KCK20B	B231
SCMT09T308MF KCM25	B231
SCMT09T308MF KCM25B	B231
SCMT09T308MF KCP10	B231
SCMT09T308MF KCP10B	B231
SCMT09T308MF KCP25	B231
SCMT09T308MF KCP25B	B231
SCMT09T308MP KCK20B	B231
SCMT09T308MP KCM15	B231
SCMT09T308MP KCM25	B231
SCMT09T308MP KCM25B	B231
SCMT09T308MP KCP10	B231
SCMT09T308MP KCP25	B231
SCMT09T308MP KCP25B	B231
SCMT09T308MP KCU10	B231
SCMT09T308UF KC5010	B231
SCMT09T308UF KCP05	B231
SCMT09T308UF KCP10	B231
SCMT09T312MF KCP25B	B231
SCMT12040411 KT315	B230
SCMT120404FP KCP25	B230
SCMT120404FP KCU10	B230
SCMT120404LF KC5010	B230
SCMT120404LF KCM25B	B230
SCMT120404LF KCP10	B230
SCMT120404LF KCP25	B230

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
SCMT120404LF KCP30	B230
SCMT120404MP KCM25	B231
SCMT120404MP KCU10	B231
SCMT12040811 KT315	B230
SCMT120408FP KCM25	B230
SCMT120408FP KCP25B	B230
SCMT120408FP KCU10	B230
SCMT120408LF KC5010	B230
SCMT120408LF KC5025	B230
SCMT120408LF KCK05	B230
SCMT120408LF KCK15	B230
SCMT120408LF KCK15B	B230
SCMT120408LF KCK20	B230
SCMT120408LF KCK20B	B230
SCMT120408LF KCM15	B230
SCMT120408LF KCM25	B230
SCMT120408LF KCM25B	B230
SCMT120408LF KCP10B	B230
SCMT120408LF KCP25	B230
SCMT120408LF KCP25B	B230
SCMT120408LF KCP30	B230
SCMT120408MF KCK15	B231
SCMT120408MF KCK15B	B231
SCMT120408MF KCK20	B231
SCMT120408MF KCK20B	B231
SCMT120408MF KCM15	B231
SCMT120408MF KCM25	B231
SCMT120408MF KCM25B	B231
SCMT120408MF KCM35	B231
SCMT120408MF KCP10	B231
SCMT120408MF KCP25	B231
SCMT120408MF KCP25B	B231
SCMT120408MF KCP30	B231
SCMT120408MP KCK20	B231
SCMT120408MP KCK20B	B231
SCMT120408MP KCM25	B231
SCMT120408MP KCM25B	B231
SCMT120408MP KCP10	B231
SCMT120408MP KCP25	B231
SCMT120408MP KCU10	B231
SCMT120412FP KCP25	B230
SCMT120412FP KCU10	B230
SCMT120412LF KC5010	B230
SCMT120412LF KCK20	B230
SCMT120412LF KCP10B	B230
SCMT120412LF KCP25B	B230
SCMT120412MF KCK15	B231
SCMT120412MF KCK15B	B231
SCMT120412MF KCK20	B231
SCMT120412MF KCK20B	B231
SCMT120412MF KCP10	B231
SCMT120412MF KCP25	B231
SCMT120412MF KCP25B	B231
SCMT120412MP KCM25	B231
SCMT120412MP KCP25	B231
SCMW09T304 KCK20	B232
SCMW09T308 KCK20	B232
SCMW09T308 KCK20B	B232
SCMW120408 KCK20	B232
SCMW120408 KCK20B	B232
SCMW120412 KCK20	B232
SCMW120412 KCK20B	B232
SCRCR1212N09	B181
SCRCR1616H09	B181
SCRPR08CA06	B203
SCSPL06CA05	B204
SCSPL08CA06	B204
SCSPR06CA05	B204
SCSPR08CA06	B204
SCSPR1010H06	B193
SCTPL08CA06	B205
SCTPR06CA05	B205
SCTPR08CA06	B205
SCW5E	C49
SCW8E	C49
SDACL1212M11Q	B209
SDACR1212M11Q	B209
SDACR1616K11Q	B209
SDB115RBHT12F	K122
SDB115RBHT16LF	K122
SDB24RBHT06F	K122
SDB30RBHT06F	K122
SDB40RBHT09F	K122
SDB50RBHT09F	K122
SDB66RBHT12F	K122
SDB66RBHT12LF	K122
SDB87RBHT12F	K122
SDB87RBHT16LF	K122
SDCT120404PDELLD2 KC725M	T104, T111, U51
SDCT120404PDERLD2 KC725M	T104, T111, U51
SDCT120404PDFLLE KC410M	T103, T110, U50, V141
SDCT120404PDFRLE KC410M	T103, T110, U50, V141
SDCT120412PDELLD2 KC725M	T104, T111, U51
SDCT120412PDERLD2 KC725M	T104, T111, U51
SDCT120412PDERLD2 KCSM40	T104, T111, U51
SDCT120412PDFLLE KC410M	T103, T110, U50, V141
SDCT120412PDFRLE KC410M	T103, T110, U50, V141
SDCT120416ENLD2 KC725M	T104, T111, U51
SDCT120416ENLD2 KCSM40	T104, T111, U51
SDCT120416FNLE KC410M	T103, T110, U50, V141
SDCT120420ENLD2 KC725M	T104, T111, U51
SDCT120420FNLE KC410M	T103, T110, U50, V141
SDCT120424ENLD2 KC725M	T104, T111, U51
SDCT120424FNLE KC410M	T103, T110, U50, V141
SDCT120432ENLD2 KC522M	T104, T111, U51
SDCT120432ENLD2 KC725M	T104, T111, U51
SDCT120432ENLD2 KCSM30	T104, T111, U51
SDCT120432ENLD2 KCSM40	T104, T111, U51
SDCT120432FNLE KC410M	T103, T110, U50, V141
SDCT120464ENLD2 KC725M	T104, T111, U51
SDCT120464ENLD2 KCSM40	T104, T111, U51
SDCT1204PDELLD2 KC725M	T104, T111, U51
SDCT1204PDERLD2 KC520M	T104, T111, U51
SDCT1204PDERLD2 KC725M	T104, T111, U51
SDCT1204PDERLD2 KCPM40	T104, T111, U51
SDCT1204PDERLD2 KCSM40	T104, T111, U51
SDCT1204PDFLLE KC410M	T103, T110, U50, V141
SDCT1204PDFRLE KC410M	T103, T110, U50, V141
SDCW120412PDSRGN KY3500	T106, T113
SDCW1204PDSRGN KY3500	T106, T113
SDET120412PDELGB2 KC520M	T104, T111, U52
SDET120412PDELGB2 KC725M	T104, T111, U52
SDET120412PDELGB2 KCK15	T104, T111, U52
SDET120412PDENGDZ KC725M	V141
SDET120412PDENGDZ KCPK30	V141
SDET120412PDENGDZ KCPM40	V141
SDET120412PDERGB KC725M	T105, T112, U51
SDET120412PDERGB KCPM40	T105, T112, U51
SDET120412PDERGB KCSM40	T105, T112, U51
SDET120412PDERGB2 KC520M	T104, T111, U52
SDET120412PDERGB2 KC725M	T104, T111, U52
SDET120412PDERGB2 KCK15	T104, T111, U52
SDET120412PDERGB2 KCPK30	T104, T111, U52
SDET120412PDERGB2 KCPM40	T104, T111, U52
SDET120412PDSNGDZ KC522M	V141
SDET120412PDSNGDZ KC725M	V141
SDET120412PDSNGDZ KCPK30	V141
SDET120412PDSNGDZ KCPM40	V141
SDET120412PDSRGB KC725M	T105, T112, U51
SDET120412PDSRGB KCSM40	T105, T112, U51
SDET120416ENGB KCSM40	T105, T112, U51
SDET120416SNGB KC725M	T105, T112, U51
SDET120416SNGB KCSM40	T105, T112, U51
SDET120416SNGB2 KC520M	T104, T111, U52
SDET120416SNGB2 KC725M	T104, T111, U52
SDET120416SNGB2 KCK15	T104, T111, U52
SDET120416SNGB2 KCPK30	T104, T111, U52
SDET120420SNGB2 KC520M	T104, T111, U52
SDET120420SNGB2 KC725M	T104, T111, U52
SDET120420SNGB2 KCK15	T104, T111, U52
SDET120420SNGB2 KCPK30	T104, T111, U52
SDET120420SNGB2 KCPM40	T104, T111, U52
SDET120424ENGB KC725M	T105, T112, U51
SDET120424ENGB KCSM40	T105, T112, U51
SDET120424SNGB KC725M	T105, T112, U51
SDET120424SNGB KCSM40	T105, T112, U51
SDET120424SNGB2 KC725M	T104, T111, U52
SDET120424SNGB2 KCK15	T104, T111, U52
SDET120424SNGB2 KCPK30	T104, T111, U52
SDET120432ENGB KC725M	T105, T112, U51
SDET120432ENGB KCSM40	T105, T112, U51
SDET120432SNGB KCSM40	T105, T112, U51
SDET120432SNGB2 KC520M	T104, T111, U52
SDET120432SNGB2 KC725M	T104, T111, U52
SDET120432SNGB2 KCK15	T104, T111, U52
SDET120432SNGB2 KCPK30	T104, T111, U52
SDET120432XENGB2 KC725M	T104, T111, U52
SDET120448ENGB KC725M	T105, T112, U51
SDET120448ENGB KCSM40	T105, T112, U51
SDET120448SNGB KC725M	T105, T112, U51
SDET120448SNGB KCSM40	T105, T112, U51
SDET120464ENGB KC725M	T105, T112, U51
SDET120464ENGB KCSM40	T105, T112, U51
SDET120464SNGB KC725M	T105, T112, U51
SDET120464SNGB KCPK30	T105, T112, U51
SDET120464SNGB KCSM30	T105, T112, U51
SDET120464SNGB KCSM40	T105, T112, U51
SDET120464SNGB2 KCPK30	T104, T111, U52
SDET1204PDELGB2 KC520M	T104, T111, U52
SDET1204PDELGB2 KC725M	T104, T111, U52
SDET1204PDELGB2 KCK15	T104, T111, U52
SDET1204PDELGB2 KCPK30	T104, T111, U52
SDET1204PDERGB KC520M	T105, T112, U51
SDET1204PDERGB KCSM40	T105, T112, U51
SDET1204PDERGB2 KC520M	T104, T111, U52
SDET1204PDERGB2 KC725M	T104, T111, U52
SDET1204PDERGB2 KCK15	T104, T111, U52
SDET1204PDERGB2 KCPK30	T104, T111, U52
SDET1204PDERGB2 KCPM40	T104, T111, U52
SDET1204PDERGB2 KCSM40	T104, T111, U52
SDET1204PDSLGB2 KC725M	T104, T111, U52
SDET1204PDSLGB2 KCPK30	T104, T111, U52
SDET1204PDSRGB KC725M	T105, T112, U51
SDET1204PDSRGB KCPK30	T105, T112, U51
SDET1204PDSRGB KCPM40	T105, T112, U51
SDET1204PDSRGB KCSM30	T105, T112, U51
SDET1204PDSRGB KCSM40	T105, T112, U51
SDET1204PDSRGB2 KC520M	T104, T111, U52
SDET1204PDSRGB2 KC725M	T104, T111, U52
SDET1204PDSRGB2 KCK15	T104, T111, U52
SDET1204PDSRGB2 KCPK30	T104, T111, U52
SDET1204PDSRGB2 KCPM40	T104, T111, U52
SDHCL1616H11	B209
SDHCL2020K11	B209
SDHCL2525M11	B209
SDHCL2525M15	B209
SDHCR1616H11	B209
SDHCR2020K11	B209
SDHCR2525M11	B209
SDHCR2525M15	B209
SDHN1204ZZEN4W KC514M	S112
SDHN1204ZZSN4W KBK50	S112
SDHT09T308EN422 KCSM40	T116
SDHT09T308EN422 SP6519	T116
SDHT09T308EN422 X500	T116
SDHT09T308EN423 KCSM40	T116
SDHT09T308EN423 SP6519	T116
SDHT09T308EN423 X500	T116
SDHT09T3AEEN422 SP6519	T116
SDHT120412EN422 KCSM40	T119
SDHT120412EN422 SP6519	T119
SDHT120412EN422 X500	T119
SDHT120412EN423 KCSM40	T119
SDHT120412EN423 SP6519	T119
SDHT120412EN423 X500	T119
SDJCL0808L07	B210
SDJCL1010M07	B210
SDJCL1212N07	B210
SDJCL1212N11	B210
SDJCL1616H07	B210
SDJCL1616H11	B210
SDJCL2020K07	B210
SDJCL2020K11	B210
SDJCL2525M11	B210
SDJCL2525M15	B210
SDJCLF1616K11Q	B211
SDJCR0808L07	B210
SDJCR1010M07	B210
SDJCR1212N07	B210
SDJCR1212N11	B210
SDJCR1616H07	B210
SDJCR1616H11	B210
SDJCR2020K07	B210
SDJCR2020K11	B210
SDJCR2020K15	B210
SDJCR2525M11	B210
SDJCR2525M15	B210
SDJCRF0808M07Q	B211
SDJCRF1010M07Q	B211
SDJCRF1212M07Q	B211
SDJCRF1616K11Q	B211
SDJPL10CA07	B220
SDJPR10CA07	B220
SDMT060304EGG KC730M	U4
SDMT060304EGG KC735M	U4
SDMT080308EGG KC505M	U4
SDMT080308EGG KC730M	U4
SDMT080308EGG KC735M	U4
SDMT09T308EN41 KCSM40	T117
SDMT09T308EN41 MP91M	T117
SDMT09T308EN41 SP6519	T117
SDMT09T308EN41 X500	T117
SDMT120408EGG KC505M	U4
SDMT120408EGG KC730M	U4
SDMT120408EGG KC735M	U4
SDMT120412EN41 KCSM40	T120
SDMT120412EN41 MP91M	T120
SDMT120412EN41 SP6519	T120
SDMT120412EN41 X500	T120
SDMW09T308TN KCSM40	T117
SDMW120412TN KCSM40	T120
SDMW120412TN SP6519	T120
SDNCN0808L07	B211
SDNCN1010M07	B211
SDNCN1212N07	B211
SDNCN1616H11	B211
SDNCN2020K11	B211
SDNCN2020K15	B211
SDNCN2525M15	B211
SDPCN1212M11Q	B212
SDPT120412PDENHPZ KC725M	V141
SDPT120412PDENHPZ KCPK30	V141
SDPT120412PDENHPZ KCPM40	V141
SDPT120412PDSNHPZ KC725M	V141
SDPT120412PDSNHPZ KCPK30	V141
SDPT120412PDSNHPZ KCPM40	V141
SDPT1204PDERGB2 KC725M	T105, T112, U52
SDPT1204PDERGB2 KCK15	T105, T112, U52
SDPT1204PDERGB2 KCPK30	T105, T112, U52
SDPT1204PDERGB2 KCPM40	T105, T112, U52
SDPT1204PDERGB2 KCSM40	T105, T112, U52
SDPT1204PDSRGB2 KC725M	T105, T112, U52
SDPT1204PDSRGB2 KCK15	T105, T112, U52
SDPT1204PDSRGB2 KCPK30	T105, T112, U52
SDPT1204PDSRGB2 KCPM40	T105, T112, U52
SDPT1204PDSRGB2 KCSM40	T105, T112, U52
SDSW66	V82
SDUPR10CA07	B221
SECT1404AEENLD2 KC725M	S42
SECT1404AEFNLE KC410M	S42
SECW1404AEENGNW KC725M	S43
SECW1404AESNGN KY3500	S43
SEKT1404AEENGP2 KC520M	S42
SEKT1404AEENGP2 KC725M	S42
SEKT1404AEENGP2 KCK15	S42
SEKT1404AEENGP2 KCPK30	S42
SEKT1404AEENGP2 KCPM40	S42
SEKT1404AESNGP2 KC520M	S42
SEKT1404AESNGP2 KC725M	S42
SEKT1404AESNGP2 KCK15	S42
SEKT1404AESNGP2 KCPK30	S42
SEKT1404AESNGP2 KCPM40	S42
SEPT1404AEENGB2 KC725M	S43
SEPT1404AEENGB2 KCK15	S43
SEPT1404AEENGB2 KCPK30	S43
SEPT1404AEENGB2 KCPM40	S43
SEPT1404AESNGB2 KC725M	S43
SEPT1404AESNGB2 KCK15	S43

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
SEPT1404AESNGB2 KCPK30	S43
SEPT1404AESNGB2 KCPM40	S43
SF075RBHT24	K119
SF100FBHO1660	K125
SF100RBHT30	K119
SF100RBHT50	K119
SF125RBHT40	K119
SF125RBHT66	K119
SF150FBHO1660	K125
SF150RBHT87	K119
SF200RBHT115	K119
SF300M1LA1RA	K64
SF300M1RS	K64
SF750M1LA1RA	K64
SF750M1RS	K64
SFCPS	K66
SFCR20	K67
SFCR20S	K67
SFCRHSK3263	K67
SFCRHSK63100	K67
SFEBCH	K66
SFEBS	K66
SFMGS	K67
SFSB450	K66
SFSB900	K66
SFSLLA	K65
SFSLLS	K65
SFSLRA	K65
SFSLRS	K65
SFSLSS	K65
SFVB	K65
SHVBR0635M	S147
SIF100HC12090M	K47
SIF100HC20100M	K47
SIF100HC25100M	K47
SIF70HC12090M	K47
SIF70HC20100M	K47
SIF80HC12090M	K47
SIF80HC20100M	K47
SIF80HC25100M	K47
SKCP343 K9	B179–181
SKCP453 K9	B180, B182
SKDP343 K9	B209–211
SKDP453 K9	B209–211, B213
SKRN100300 K9	B227–228
SKRN1203M0 K9	B227–228
SKRN160400 K9	B227
SKSN566K K9	B115–117, B119
SKSP343 K9	B233–234
SKSP453 K9	B233–234
SKTP343 K9	B247–248, B257
SKVN343 K9	B266–268
SKWP343 K9	B271
SM-906 KC720	S116, S120, S122
SM-906LH KC720	S116, S120, S122
SM449 K9	T102
SM455 K9	S41
SM812 K9	E38–40, E42–43
SM813 K9	E37–38, E42
SM815 K9	B174, B371
SM819 K9	B172–173, B354–355
SM837 K9	B172, B354, B378
SM840 K9	B170, B353–354
SM841 K9	B172–174, B354–355, B371
SM871 K9	E37, E41
SM872 K9	E37
SM885 K9	E36, E40
SM886 K9	E36, E40–41
SMYE3 K9	D78–79, D81, D83–86
SMYE4 K9	D78–79, D81, D83–84, D86
SMYE5 K9	D84
SMYI3 K9	D78–79, D81–86
SMYI4 K9	D78–79, D81–86
SMYI5 K9	D82, D84–85
SN2TPKG	W40, W42
SN3TM	W40, W42
SN3TPKG	D82, D86, W40–43
SN5TM	W40–43
SN7T	W40
SNGA120408S01015MT KBH10	B318
SNGA120408S01225MT KBH10	B318
SNGA120408S01225MT KBH20	B318
SNGA120408T02020 KY1615	B317
SNGA120408T02020 KY3500	B293
SNGA120408T02020 KYK10	B293
SNGA120408T02020 KYK25	B293
SNGA120412S01225MT KBH10	B318
SNGA120412S01225MT KBH20	B318
SNGA120412T01020 KYS25	B335
SNGA120412T01020 KYS30	B335
SNGA120412T02020 KY1615	B317
SNGA120412T02020 KY3500	B293
SNGA120412T02020 KYK25	B293
SNGA120416T02020 KY3500	B293
SNGA150612T02020 KY3500	B293
SNGA150612T02020 KYK25	B293
SNGA150616T02020 KY3500	B293
SNGA190612T02020 KY3500	B293
SNGN090308T02020 KY1615	B317
SNGN090308T02020 KY3500	B297
SNGN090408S01015WCB KBK45	B285
SNGN090408S01015WCC KBK45	B285
SNGN120408T00520 KY1615	B317
SNGN120408T01020 KYS30	B335
SNGN120408T02020 KBK45	B285
SNGN120408T02020 KY1615	B317
SNGN120408T02020 KY3500	B297
SNGN120408T02020 KYK25	B297
SNGN120412S02020 KBK45	B285
SNGN120412T01020 KYS30	B335
SNGN120412T02020 KY1615	B317
SNGN120412T02020 KY3500	B297
SNGN120412T02020 KYK25	B297
SNGN120416S02020 KBK45	B285
SNGN120416T01020 KYS25	B335
SNGN120416T01020 KYS30	B335
SNGN120416T02020 KY1615	B317
SNGN120416T02020 KY3500	B297
SNGN120432T02020 KY3500	B297
SNGN120704T02020 KY1615	B317
SNGN120708T02020 KY1615	B317
SNGN120712T02020 KY1615	B317
SNGN120712T02020 KYK25	B297
SNGN120716T01020 KYS30	B335
SNGN120716T02020 KY1615	B317
SNGN120716T02020 KY3500	B297
SNGN120720T02020 KY1615	B317
SNGN120720T10015 KY1615	B317
SNGN120720T20015 KY1615	B317
SNGN150716T02020 KY1615	B317
SNGN190416T02020 KY3500	B297
SNGN190616E KYS25	B335
SNGN190616T01020 KYS30	B335
SNGN190724E KYS30	B335
SNGP120404 KC5010	B96
SNGP120408 KC5010	B96
SNGX120408T02020 KBK45	B287
SNGX120412S02020 KBK45	B287
SNGX120416S02020 KB1340	B287
SNGX120416S02020 KBK45	B287
SNGX120712T01020 KYS30	B335
SNGX120712T02020 KY1615	B318
SNGX120712T02020 KY3500	B297
SNGX120712T02020 KYK10	B297
SNGX120712T02020 KYK25	B297
SNGX120716T01020 KYS30	B335
SNGX120716T02020 KY3500	B297
SNGX120716T02020 KYK10	B297
SNGX120716T02020 KYK25	B297
SNGX150716T02020 KY3500	B297
SNGX150724T02020 KY3500	B297
SNHJ10T308ENLD KC520M	S61
SNHJ10T308ENLD KC725M	S61
SNHJ10T308ENLD KCK15	S61
SNHJ10T308ENLD KCPK30	S61
SNHJ10T312ENLD KC725M	S61
SNHJ10T312ENLD KCK15	S61
SNHJ120608ENLD KC520M	S63
SNHJ120608ENLD KC725M	S63
SNHJ120608ENLD KCK15	S63
SNHJ120608ENLD KCPK30	S63
SNHJ120608SNGD KC520M	S63
SNHJ120608SNGD KC522M	S63
SNHJ120608SNGD KCK15	S63
SNHJ120608SNGD KCPK30	S63
SNHJ120608SNGD KCPM40	S63
SNHJ120608SNGD KCSM40	S63
SNHJ120616ENLD KC520M	S63
SNHJ120616ENLD KC725M	S63
SNHJ120616ENLD KCK15	S63
SNHJ120616ENLD KCPK30	S63
SNHX1102PZTNGP K110M	U15
SNHX1102PZTNGP KC725M	U15
SNHX1102PZTNGP KCPK30	U15
SNHX1102PZTNGP KCPM40	U15
SNHX1102T KC725M	U14
SNHX1102T KCPM40	U14
SNHX1103T KC725M	U14
SNHX1103T KCPK30	U14
SNHX1103T KCPM40	U14
SNHX11T3PZFNGE KC510M	U14
SNHX11T3PZTNGP KC725M	U15
SNHX11T3PZTNGP KCPM40	U15
SNHX1203PZFNGE KC510M	U14
SNHX1203PZTNGP K110M	U15
SNHX1203PZTNGP KC725M	U15
SNHX1203PZTNGP KCPK30	U15
SNHX1203PZTNGP KCPM40	U15
SNHX1203T KC725M	U14
SNHX1203T KCPM40	U14
SNHX12045T KC725M	U14
SNHX1204T KC725M	U14
SNHX1205T KC725M	U14
SNHX12L4PZTNGP KCPK30	U15
SNHX12L5PZFNGE K110M	U14
SNHX12L5PZFNGE KC510M	U14
SNHX12L5PZTNGP K110M	U15
SNHX12L5PZTNGP KC725M	U15
SNHX12L5PZTNGP KCPK30	U15
SNMA120408 K68	B96
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SNMA120408 KCK20	B96
SNMA120408 KCK20B	B96
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SNMA120412 KCK15B	B96
SNMA120412 KCK20	B96
SNMA120412 KCK20B	B96
SNMA120412S02020 KB1340	B289
SNMA150612 KCK15B	B96
SNMA150612 KCK20	B96
SNMA190612 K68	B96
SNMA190612 KCK20	B96
SNMA190616 KCK20	B96
SNMG090304FF KC5010	B97
SNMG090304FF KCU10	B97
SNMG090308FF KC5010	B97
SNMG090308FF KCP10	B97
SNMG090308FF KCU10	B97
SNMG090308FF KT315	B97
SNMG090308FN KCK05	B97
SNMG090308FN KCK15B	B97
SNMG090308FN KCP10	B97
SNMG090308MN KCP10	B98
SNMG090308MN KCP10B	B98
SNMG090308MN KCP25	B98
SNMG090308MN KCP25B	B98
SNMG090308MN KCP30	B98
SNMG090312MN KCP10	B98
SNMG090312MN KCP25	B98
SNMG090412RN KCP10	B101
SNMG120404FN KCK05	B97
SNMG120404FN KCP05	B97
SNMG120404FN KCP10B	B97
SNMG120404FP KCM15	B97
SNMG120404FP KCU10	B97
SNMG120404MN KCP10B	B98
SNMG120404MN KCP25B	B98
SNMG120408 K313	B96
SNMG120408FF KC5010	B97
SNMG120408FN KCP10	B97
SNMG120408FN KCP10B	B97
SNMG120408FN KT315	B97
SNMG120408FP KCM15	B97
SNMG120408FP KCM25B	B97
SNMG120408FP KCU10	B97
SNMG120408FW KCP05	B98
SNMG120408FW KCP10	B98
SNMG120408MN KCP10	B98
SNMG120408MN KCP10B	B98
SNMG120408MN KCP25	B98
SNMG120408MN KCP25B	B98
SNMG120408MN KCP30	B98
SNMG120408MN KCP30B	B98
SNMG120408MN KCP40	B98
SNMG120408MN KCP40B	B98
SNMG120408MP KC5010	B98
SNMG120408MP KCM15	B98
SNMG120408MP KCM15B	B98
SNMG120408MP KCM25	B98
SNMG120408MP KCM25B	B98
SNMG120408MP KCM35B	B98
SNMG120408MP KCU10	B98
SNMG120408MR KCM25B	B99
SNMG120408MR KCP25B	B99
SNMG120408MR KCU10	B99
SNMG120408MS KC5010	B99
SNMG120408MS KC5025	B99
SNMG120408MS KCU10	B99
SNMG120408MS KCU25	B99
SNMG120408MW KCP25	B100
SNMG120408RN KCP10	B101
SNMG120408RN KCP25	B101
SNMG120408RN KCP25B	B101
SNMG120408RN KCP30B	B101
SNMG120408RN KCP40B	B101
SNMG120408RP KC5010	B101
SNMG120408RP KC5025	B101
SNMG120408RP KCK20	B101
SNMG120408RP KCK20B	B101
SNMG120408RP KCM25	B101
SNMG120408RP KCM35	B101
SNMG120408RP KCP05	B101
SNMG120408RP KCP10	B101
SNMG120408RP KCP25	B101
SNMG120408RP KCP25B	B101
SNMG120408RP KCU10	B101
SNMG120408RP KCU25	B101
SNMG120408UN KCK15	B102
SNMG120408UN KCK15B	B102
SNMG120408UN KCK20	B102
SNMG120408UN KCK20B	B102
SNMG120408UP KC5010	B102
SNMG120408UP KCM35	B102
SNMG120412 K68	B96
SNMG120412FN KCP10	B97
SNMG120412FN KCP25	B97
SNMG120412FW KCP10	B98
SNMG120412FW KT315	B98
SNMG120412MN KCP10	B98
SNMG120412MN KCP10B	B98
SNMG120412MN KCP25	B98
SNMG120412MN KCP25B	B98
SNMG120412MN KCP30	B98
SNMG120412MN KCP40	B98
SNMG120412MP KC5010	B98
SNMG120412MP KCM15	B98
SNMG120412MP KCM25	B98
SNMG120412MP KCM25B	B98
SNMG120412MP KCM35	B98
SNMG120412MP KCU10	B98
SNMG120412MP KCU25	B98
SNMG120412MR KCM25	B99
SNMG120412MR KCP10B	B99
SNMG120412MR KCP25B	B99
SNMG120412MR KCU10	B99
SNMG120412MS KC5010	B99
SNMG120412MS KCU10	B99
SNMG120412MS KCU25	B99
SNMG120412MW KCP10	B100
SNMG120412P KCU10	B100
SNMG120412RN KCP10	B101
SNMG120412RN KCP10B	B101
SNMG120412RN KCP25	B101
SNMG120412RN KCP25B	B101
SNMG120412RN KCP30B	B101
SNMG120412RN KCP40	B101
SNMG120412RN KCP40B	B101
SNMG120412RN KCPK05	B101

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
SNMG120412RP KC5010	B101
SNMG120412RP KC5025	B101
SNMG120412RP KCK05	B101
SNMG120412RP KCK15	B101
SNMG120412RP KCK15B	B101
SNMG120412RP KCK20	B101
SNMG120412RP KCM25	B101
SNMG120412RP KCM25B	B101
SNMG120412RP KCP05	B101
SNMG120412RP KCP10	B101
SNMG120412RP KCP10B	B101
SNMG120412RP KCP25	B101
SNMG120412RP KCP25B	B101
SNMG120412RP KCP30	B101
SNMG120412RP KCP40	B101
SNMG120412RP KCU10	B101
SNMG120412RP KCU25	B101
SNMG120412UN KCK05B	B102
SNMG120412UN KCK15B	B102
SNMG120412UN KCK20	B102
SNMG120412UN KCK20B	B102
SNMG120412UP KCM25	B102
SNMG120412UP KCM35	B102
SNMG120416FN KCP10	B97
SNMG120416MG KCP25B	B99
SNMG120416MN KCP25	B98
SNMG120416MN KCP25B	B98
SNMG120416MP KCM25B	B98
SNMG120416MP KCM35	B98
SNMG120416RN KCP10B	B101
SNMG120416RN KCP25	B101
SNMG120416RN KCP25B	B101
SNMG120416RN KCP40	B101
SNMG120416RN KCP40B	B101
SNMG120416RP KC5025	B101
SNMG120416RP KCP10	B101
SNMG120416RP KCU10	B101
SNMG120416UN KCK20	B102
SNMG120416UN KCK20B	B102
SNMG150608MP KCM25B	B98
SNMG150608MS KCU25	B99
SNMG150608RN KCP10	B101
SNMG150608RN KCP25	B101
SNMG150612MN KCP10B	B98
SNMG150612MN KCP25	B98
SNMG150612MN KCP25B	B98
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SNMG150612MP KCM15	B98
SNMG150612MP KCM25	B98
SNMG150612MP KCM25B	B98
SNMG150612MP KCU10	B98
SNMG150612MR KCM15B	B99
SNMG150612MR KCPK05	B99
SNMG150612MS KCU25	B99
SNMG150612RN KCP10B	B101
SNMG150612RN KCP25	B101
SNMG150612RN KCP25B	B101
SNMG150612RN KCP40	B101
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SNMG150612RN KCPK05	B101
SNMG150612RP KCM35	B101
SNMG150612RP KCP10B	B101
SNMG150612RP KCP25	B101
SNMG150612RP KCP25B	B101
SNMG150612RP KCP40	B101
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SNMG150612RP KCU25	B101
SNMG150612UN KCK15B	B102
SNMG150612UN KCK20	B102
SNMG150612UP KCM15	B102
SNMG150612UP KCM25	B102
SNMG150612UP KCU10	B102
SNMG150616MN KCP25B	B98
SNMG150616MP KCM25	B98
SNMG150616MP KCU10	B98
SNMG150616RN KCP25	B101
SNMG150616RN KCP25B	B101
SNMG150616RN KCP30B	B101
SNMG150616RN KCPK05	B101
SNMG150616RP KCM15B	B101
SNMG150616RP KCM25B	B101
SNMG150616RP KCP10B	B101
SNMG150616RP KCP25	B101
SNMG150616RP KCU25	B101
SNMG150616UN KCK15	B102
SNMG150616UN KCK20	B102
SNMG190608RN KCP25B	B101
SNMG190608RN KCP30	B101
SNMG190612 KCU10	B96
SNMG190612MN KCP10	B98
SNMG190612MN KCP25B	B98
SNMG190612MP KCM15	B98
SNMG190612MP KCM25	B98
SNMG190612MP KCM25B	B98
SNMG190612MP KCM35	B98
SNMG190612MS KC5025	B99
SNMG190612MS KCU25	B99
SNMG190612RN KCP10B	B101
SNMG190612RN KCP25	B101
SNMG190612RN KCP25B	B101
SNMG190612RN KCP30B	B101
SNMG190612RN KCP40	B101
SNMG190612RP KC5010	B101
SNMG190612RP KC5025	B101
SNMG190612RP KCM25B	B101
SNMG190612RP KCM35	B101
SNMG190612RP KCP10	B101
SNMG190612RP KCP25B	B101
SNMG190612RP KCP40B	B101
SNMG190612RP KCU10	B101
SNMG190612RP KCU25	B101
SNMG190612UN KCK15	B102
SNMG190612UN KCK20	B102
SNMG190616 KCP40	B96
SNMG190616MN KCP25	B98
SNMG190616MP KC5010	B98
SNMG190616RN KCP10	B101
SNMG190616RN KCP25	B101
SNMG190616RN KCP25B	B101
SNMG190616RN KCP30B	B101
SNMG190616RN KCP40B	B101
SNMG190616RN KCPK05	B101
SNMG190616RP KC5025	B101
SNMG190616RP KCK20	B101
SNMG190616RP KCM25	B101
SNMG190616RP KCM25B	B101
SNMG190616RP KCP10	B101
SNMG190616RP KCP40	B101
SNMG190616RP KCPK05	B101
SNMG190616RP KCU10	B101
SNMG190616RP KCU25	B101
SNMG190616UN KCK20	B102
SNMG190624RN KCP25	B101
SNMG190624RN KCP30	B101
SNMG250924 KCP25	B96
SNMG250924 KCP40	B96
SNMG250924 KCU10	B96
SNMG250924RM KC5010	B100
SNMG250924RM KCP25	B100
SNMG250924RM KCU10	B100
SNMG250924RN KCP40B	B101
SNMM120408RM KCP25	B103
SNMM120408RP KCM35	B103
SNMM120408RP KCP25	B103
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SNMM150612RM KCP25	B103
SNMM150612RM KCP25B	B103
SNMM150612RP KCP25	B103
SNMM150616RM KCP10	B103
SNMM150616RM KCP25	B103
SNMM150616RM KCP25B	B103
SNMM150616RP KCM25	B103
SNMM150616RP KCP10	B103
SNMM190612RM KCP25B	B102
SNMM190612RH KCP30	B102
SNMM190612RM KCP10	B103
SNMM190612RM KCP25	B103
SNMM190612RM KCP25B	B103
SNMM190612RM KCP40	B103
SNMM190612RP KCP25	B103
SNMM190612RP KCP40	B103
SNMM190616RH KCP10	B102
SNMM190616RH KCP25	B102
SNMM190616RH KCP25B	B102
SNMM190616RH KCP30	B102
SNMM190616RH KCP40	B102
SNMM190616RM KCP10	B103
SNMM190616RM KCP25	B103
SNMM190616RM KCP25B	B103
SNMM190616RM KCP40B	B103
SNMM190616RP KCM25	B103
SNMM190616RP KCM25B	B103
SNMM190616RP KCP40	B103
SNMM190624RH KCP10	B102
SNMM190624RH KCP25	B102
SNMM190624RH KCP25B	B102
SNMM190624RH KCP30	B102
SNMM190624RH KCP40B	B102
SNMM190624RM KCP25	B103
SNMM190624RM KCP25B	B103
SNMM190624RM KCP40B	B103
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SNMM190624RP KCP25B	B103
SNMM190624RW KCP25B	B103
SNMM250724RH KCP10	B102
SNMM250724RH KCP10B	B102
SNMM250724RH KCP25	B102
SNMM250724RH KCP25B	B102
SNMM250724RH KCP30	B102
SNMM250724RH KCP40	B102
SNMM250724RH KCP40B	B102
SNMM250724RM KCP10	B103
SNMM250724RM KCP25	B103
SNMM250724RP KCM25	B103
SNMM250724RP KCP25	B103
SNMM250724RP KCP40	B103
SNMM250724RW KCP25B	B103
SNMM250924RH KCP10	B102
SNMM250924RH KCP10B	B102
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SNMM250924RP KCM25B	B103
SNMM250924RP KCP25	B103
SNMN090308S02020 KB1340	B286
SNMN090316S02020 KB1340	B286
SNMN120316S02020 KB1340	B286
SNMN120416T02020 KB1340	B286
SNMP120408K KCP25	B104
SNMP190612 K313	B104
SNMP190612 K68	B104
SNMS120408 K68	B104
SNMS190612 K68	B104
SNMS190612 KC5410	B104
SNMX120712T02020 KY3500	B298
SNMX120716T02020 KY3500	B298
SNMX150716T02020 KY3500	B298
SNMX190640S-WT5 KCP25B	E53
SNPF120412SNGP KCK15	S105
SNPJ10T308SNGD KC520M	S61
SNPJ10T308SNGD KCK15	S61
SNPJ10T308SNGD KCPK30	S61
SNPJ10T308SNGD KCPM40	S61
SNPJ10T312SNGD KCK15	S61
SNPJ10T312SNGD KCPM40	S61
SNPJ120608SNGD KC520M	S64
SNPJ120608SNGD KCK15	S64
SNPJ120608SNGD KCPM40	S64
SNPJ120616SNGD KCK15	S64
SNPJ120616SNGD KCPM40	S64
SNXF120412AMSN KY3500	S105
SNXF120412ENLD KC514M	S104
SNXF120412ENLD KC524M	S104
SNXF120412ENLD KCK15	S104
SNXF120412ENLD KCK20	S104
SNXF120412ENLD KCPK30	S104
SNXF120412SNGP KC514M	S104
SNXF120412SNGP KC524M	S104
SNXF120412SNGP KCK15	S104
SNXF120412SNGP KCK20	S104
SNXF120412SNGP KCPK30	S104
SNXF120412SNHE KC524M	S104
SNXF120412SNHE KCK15	S104
SNXF120412SNHE KCK20	S104
SNXF120412SNHE KCPK30	S104
SNXF1204ZNAMSN KY3500	S105
SNXF1204ZNENLD KC514M	S104
SNXF1204ZNENLD KC524M	S104
SNXF1204ZNENLD KCK15	S104
SNXF1204ZNENLD KCK20	S104
SNXF1204ZNENLD KCPK30	S104
SNXF1204ZNSNGP KC514M	S104
SNXF1204ZNSNGP KC524M	S104
SNXF1204ZNSNGP KCK15	S104
SNXF1204ZNSNGP KCK20	S104
SNXF1204ZNSNGP KCPK30	S104
SNXF1204ZNSNHE KC514M	S104
SNXF1204ZNSNHE KCK15	S104
SNXF1204ZNSNHE KCK20	S104
SNXF1204ZNSNHE KCPK30	S104
SPCT10T304PPELLD2 KC725M	T100, U36
SPCT10T304PPERLD2 KC725M	T100, U36
SPCT10T304PPFLLE KC410M	T99, U36
SPCT10T304PPFRLE KC410M	T99, U36
SPCT10T312PPELLD2 KC725M	T100, U36
SPCT10T312PPERLD2 KC725M	T100, U36
SPCT10T312PPFRLE KC410M	T99, U36
SPCT10T316ENLD2 KC725M	T100, U36
SPCT10T316ENLD2 KCSM30	T100, U36
SPCT10T320ENLD2 KC725M	T100, U36
SPCT10T320FNLE KC410M	T99, U36
SPCT10T3PPELLD2 KC725M	T100, U36
SPCT10T3PPERLD2 KC520M	T100, U36
SPCT10T3PPERLD2 KC725M	T100, U36
SPCT10T3PPERLD2 KCPM40	T100, U36
SPCT10T3PPFLLE KC410M	T99, U36
SPCT10T3PPFRLE KC410M	T99, U36
SPET10T304PPELGB2 KC725M	T100, U37
SPET10T304PPELGB2 KCK15	T100, U37
SPET10T304PPELGB2 KCPK30	T100, U37
SPET10T304PPERGB2 KC725M	T100, U37
SPET10T304PPERGB2 KCK15	T100, U37
SPET10T304PPERGB2 KCPK30	T100, U37
SPET10T3PPELGB2 KC520M	T100, U37
SPET10T3PPELGB2 KC725M	T100, U37
SPET10T3PPELGB2 KCK15	T100, U37
SPET10T3PPELGB2 KCPK30	T100, U37
SPET10T3PPERGB2 KC520M	T100, U37
SPET10T3PPERGB2 KC725M	T100, U37
SPET10T3PPERGB2 KCK15	T100, U37
SPET10T3PPERGB2 KCPK30	T100, U37
SPET10T3PPERGB2 KCPM40	T100, U37
SPET10T3PPSLGB2 KC725M	T100, U37
SPET10T3PPSLGB2 KCPK30	T100, U37
SPET10T3PPSRGB2 KC520M	T100, U37
SPET10T3PPSRGB2 KC725M	T100, U37
SPET10T3PPSRGB2 KCK15	T100, U37
SPET10T3PPSRGB2 KCPK30	T100, U37
SPGN090304 K68	B169
SPGN090304 KC5010	B169
SPGN090308 K68	B169
SPGN090308 KC5010	B169
SPGN090308 KCK15	B169
SPGN090308T01020 KY1615	B318
SPGN120304 K68	B169
SPGN120304 KC5010	B169
SPGN120304 KCU10	B169
SPGN120308 K313	B169
SPGN120308 K68	B169
SPGN120308 KC5010	B169
SPGN120308 KCU10	B169
SPGN120308T01020 KY1615	B318
SPGN120312 K68	B169
SPGN120316 KC5010	B169
SPGN120412 KCU10	B169
SPGN190408 K68	B169
SPGN190412 K313	B169
SPGN190412 KCU10	B169

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
SPGR090308K KC5010	B169
SPGR090308K KCU10	B169
SPGR120308K KCP25B	B169
SPGT09T304LF KC5010	B238
SPGT09T304LF KC5025	B238
SPGT09T304LF KCU10	B238
SPGT09T308LF KC5010	B238
SPGT09T308LF KC5025	B238
SPGT09T308LF KC5410	B238
SPGT09T308LF KCU10	B238
SPGX050204HP KC7140	J89
SPGX050204HP KCU25	J89
SPGX050204HP KCU40	J89
SPGX050204LP KCU40	J90
SPGX050204MD KC7140	J89
SPGX050204MD KCU25	J89
SPGX050204MD KCU40	J89
SPGX060304FP KCPK10	J90
SPGX060304FP KCU25	J90
SPGX060304FP KCU40	J90
SPGX060304LP KCU40	J90
SPGX060304MD KC7140	J89
SPGX060304MD KCPK10	J89
SPGX060304MD KCU25	J89
SPGX060304MD KCU40	J89
SPGX060304RHP KC7140	J89
SPGX060304RHP KCU25	J89
SPGX060304RHP KCU40	J89
SPGX070304FP KCPK10	J90
SPGX070304FP KCU25	J90
SPGX070304FP KCU40	J90
SPGX070304MD KC7140	J89
SPGX070304MD KCPK10	J89
SPGX070304MD KCU25	J89
SPGX070304MD KCU40	J89
SPGX070304RHP KC7140	J89
SPGX070304RHP KCU25	J89
SPGX070304RHP KCU40	J89
SPGX070308FP KCPK10	J90
SPGX070308FP KCU25	J90
SPGX070308FP KCU40	J90
SPGX070308HP KCPK10	J89
SPGX070308HP KCU25	J89
SPGX070308HP KCU40	J89
SPGX070308MD KCPK10	J89
SPGX070308MD KCU25	J89
SPGX070308MD KCU40	J89
SPHX060202R20 KC7215	J99
SPHX060202R21 KC7215	J100
SPHX060204R-21 KM1	J100
SPHX060204R-22 KM1	J101
SPHX060204R20 KC7140	J99
SPHX060204R20 KCU25	J99
SPHX060204R20 KCU40	J99
SPHX060204R21 KCPK10	J100
SPHX060204R21 KCU25	J100
SPHX060204R21 KCU40	J100
SPHX060206R20 KC7215	J99
SPHX060206R21 KC7215	J100
SPHX060208R20 KC7215	J99
SPHX060208R21 KC7215	J100
SPHX070302R20 KC7215	J99
SPHX070304R-21 KM1	J100
SPHX070304R-22 KM1	J101
SPHX070304R20 KC7140	J99
SPHX070304R20 KCU25	J99
SPHX070304R20 KCU40	J99
SPHX070304R21 KCPK10	J100
SPHX070304R21 KCU25	J100
SPHX070304R21 KCU40	J100
SPHX070306R20 KC7215	J99
SPHX070306R21 KC7215	J100
SPHX070308R20 KC7215	J99
SPHX070308R21 KCPK10	J100
SPHX070308R21 KCU40	J100
SPHX070310R20 KC7215	J99
SPHX070310R21 KC7215	J100
SPHX070312R20 KC7215	J99
SPHX090304R-21 KM1	J100
SPHX090304R-22 KM1	J101
SPHX090304R20 KC7140	J99
SPHX090304R20 KC7215	J99
SPHX090304R20 KCU25	J99
SPHX090304R20 KCU40	J99
SPHX090304R21 KCPK10	J100
SPHX090304R21 KCU25	J100
SPHX090304R21 KCU40	J100
SPHX090308R20 KCU25	J99
SPHX090308R20 KCU40	J99
SPHX090308R21 KCPK10	J100
SPHX090308R21 KCU25	J100
SPHX090308R21 KCU40	J100
SPHX090310R20 KC7215	J99
SPHX090310R21 KC7215	J100
SPHX090312R20 KC7215	J99
SPHX090312R21 KC7215	J100
SPHX090316R20 KC7215	J99
SPHX090316R21 KC7215	J100
SPHX120404R-21 KM1	J100
SPHX120404R-22 KM1	J101
SPHX120404R20 KC7140	J99
SPHX120404R20 KCU25	J99
SPHX120404R20 KCU40	J99
SPHX120404R21 KCPK10	J100
SPHX120404R21 KCU25	J100
SPHX120404R21 KCU40	J100
SPHX120408R20 KCU25	J99
SPHX120408R20 KCU40	J99
SPHX120408R21 KC7215	J100
SPHX120410R20 KC7215	J99
SPHX120410R21 KC7215	J100
SPHX120412R20 KC7215	J99
SPHX120412R21 KC7215	J100
SPHX120416R20 KC7215	J99
SPHX120416R21 KC7215	J100
SPHX120420R20 KC7215	J99
SPHX120420R21 KC7215	J100
SPHX1205PCELGPB KCK15	S77
SPHX1205PCER-GP1WB KC520M	S78
SPHX1205PCER-GP1WB KCK15	S78
SPHX1205PCERGN1WB KCPK30	S78
SPHX1205PCERGNT1WB KB1340	S78, S84
SPHX1205PCERGP4SB KC520M	S77
SPHX1205PCERGP4SB KCK15	S77
SPHX1205PCERGPB KC520M	S77
SPHX1205PCERGPB KCK15	S77
SPHX1205PCERGPB KCPK30	S77
SPHX1205PCFLGN1WB KCK15	S78
SPHX1205PCFRGN1WB KC520M	S78
SPHX1205PCFRGN1WB KC725M	S78
SPHX1205PCFRGN1WB KCK15	S78
SPHX1205PCFRGN1WB KTPK20	S78
SPHX1205PCFRGN1WBK KY3500	S78
SPHX1205PCSRGPB KC725M	S77
SPHX1205PCSRGPB KCK15	S77
SPHX1205PCSRGPB KCPK30	S77
SPHX1205PCTLGPBK KY3500	S77
SPHX1205PCTR-GP1WBK KY3500	S78
SPHX1205PCTRGP4SBK KY3500	S77
SPHX1205PCTRGPB KTPK20	S77
SPHX1205PCTRGPBK KY3500	S77
SPHX1205ZCELGP KC520M	S73
SPHX1205ZCELGP KCK15	S73
SPHX1205ZCER-GP1W KC520M	S74
SPHX1205ZCER-GP1W KCK15	S74
SPHX1205ZCERGNT1W KB1340	S74
SPHX1205ZCERGP KC520M	S73
SPHX1205ZCERGP KCK15	S73
SPHX1205ZCERGP KCPK30	S73
SPHX1205ZCERGP4S KCK15	S73
SPHX1205ZCFRGN1W KC520M	S74
SPHX1205ZCFRGN1W KCK15	S74
SPHX1205ZCFRGN1WK KY3500	S74
SPHX1205ZCSRGP KCK15	S73
SPHX1205ZCSRGP KCPK30	S73
SPHX1205ZCTLGPK KY3500	S73
SPHX1205ZCTR-GP1WK KY3500	S74
SPHX1205ZCTRGP KTPK20	S73
SPHX1205ZCTRGP4SK KY3500	S73
SPHX1205ZCTRGPK KY3500	S73
SPHX150504R-21 KM1	J100
SPHX150504R-22 KM1	J101
SPHX150504R20 KCU25	J99
SPHX150504R20 KCU40	J99
SPHX150508R20 KCU25	J99
SPHX150508R20 KCU40	J99
SPHX150512R20 KC7215	J99
SPHX150516R20 KC7215	J99
SPHX150520R20 KC7215	J99
SPHX15T6PCERGP KCK15	S83
SPHX15T6PCERGP KCPK30	S83
SPHX15T6PCERGP4S KCK15	S83
SPHX15T6PCFRGN1W KCK15	S84
SPHX15T6PCFRGN1WK KY3500	S84
SPHX15T6PCSRGP KCPK30	S83
SPHX15T6PCTRGPK KY3500	S83
SPHX15T6ZCERGP KCK15	S80
SPHX15T6ZCERGP KCPK30	S80
SPHX15T6ZCERGP4S KCK15	S80
SPHX15T6ZCFRGN1W KCK15	S81
SPHX15T6ZCSRGP K110M	S80
SPHX15T6ZCSRGP KCPK30	S80
SPHX15T6ZCTRGP4SK KY3500	S80
SPHX15T6ZCTRGPK KY3500	S80
SPMT09T304FP KCP25	B238
SPMT09T304FP KCU10	B238
SPMT09T304FP KCU25	B238
SPMT09T304LF KC5010	B238
SPMT09T304LF KC5025	B238
SPMT09T304LF KCK15B	B238
SPMT09T304LF KCK20	B238
SPMT09T304LF KCP10	B238
SPMT09T304LF KCP25	B238
SPMT09T304LF KT315	B238
SPMT09T304UF KC5010	B239
SPMT09T304UF KCP10B	B239
SPMT09T308FP KCU10	B238
SPMT09T308LF K68	B238
SPMT09T308LF KC5010	B238
SPMT09T308LF KC5025	B238
SPMT09T308LF KCK15	B238
SPMT09T308LF KCK15B	B238
SPMT09T308LF KCK20	B238
SPMT09T308LF KCK20B	B238
SPMT09T308LF KCP10B	B238
SPMT09T308LF KCP25	B238
SPMT09T308LF KCP25B	B238
SPMT09T308MF KCK15	B239
SPMT09T308MF KCK15B	B239
SPMT09T308MF KCK20	B239
SPMT09T308MF KCM25B	B239
SPMT09T308MF KCP10	B239
SPMT09T308MF KCP25	B239
SPMT09T308MF KCP25B	B239
SPMT09T308MP KCK20	B239
SPMT09T308MP KCM15	B239
SPMT09T308MP KCU10	B239
SPMT120408MF KCK15	B239
SPMT120408MF KCK20	B239
SPMT120408MF KCM25	B239
SPMT120408MF KCP25	B239
SPMT120408MF KCP30	B239
SPMT120408MP KCP25	B239
SPMT120408MP KCU10	B239
SPPT10T3PPERGB2 KCK15	T101, U37
SPPT10T3PPERGB2 KCPK30	T101, U37
SPPT10T3PPSRGB2 KCK15	T101, U37
SPPT10T3PPSRGB2 KCPK30	T101, U37
SPPT10T3PPSRGB2 KTPK20	T101, U37
SPPX070304LP KCU40	J90
SPPX09T308FP KCPK10	J90
SPPX09T308FP KCU25	J90
SPPX09T308FP KCU40	J90
SPPX09T308LP KCU40	J90
SPPX09T308MD KC7140	J89
SPPX09T308MD KCU25	J89
SPPX09T308MD KCU40	J89
SPPX09T308RHP KC7140	J89
SPPX09T308RHP KCU25	J89
SPPX09T308RHP KCU40	J89
SPPX09T310FP KCPK10	J90
SPPX09T310FP KCU25	J90
SPPX09T310FP KCU40	J90
SPPX09T310HP KCPK10	J89
SPPX09T310HP KCU25	J89
SPPX09T310HP KCU40	J89
SPPX09T310MD KCPK10	J89
SPPX09T310MD KCU25	J89
SPPX09T310MD KCU40	J89
SPPX120408FP KCPK10	J90
SPPX120408FP KCU25	J90
SPPX120408FP KCU40	J90
SPPX120408LP KCU40	J90
SPPX120408MD KC7140	J89
SPPX120408MD KCU25	J89
SPPX120408MD KCU40	J89
SPPX120408RHP KC7140	J89
SPPX120408RHP KCU25	J89
SPPX120408RHP KCU40	J89
SPPX120412FP KCPK10	J90
SPPX120412FP KCU25	J90
SPPX120412FP KCU40	J90
SPPX120412HP KCPK10	J89
SPPX120412HP KCU25	J89
SPPX120412HP KCU40	J89
SPPX120412MD KCPK10	J89
SPPX120412MD KCU25	J89
SPPX120412MD KCU40	J89
SPPX15T508FP KCPK10	J90
SPPX15T508FP KCU25	J90
SPPX15T508FP KCU40	J90
SPPX15T508MD KC7140	J89
SPPX15T508MD KCU25	J89
SPPX15T508MD KCU40	J89
SPPX15T508RHP KC7140	J89
SPPX15T508RHP KCU25	J89
SPPX15T508RHP KCU40	J89
SPPX15T512FP KCPK10	J90
SPPX15T512FP KCU25	J90
SPPX15T512FP KCU40	J90
SPPX15T512HP KCPK10	J89
SPPX15T512HP KCU25	J89
SPPX15T512HP KCU40	J89
SPPX15T512MD KCPK10	J89
SPPX15T512MD KCU25	J89
SPPX15T512MD KCU40	J89
SPUN120304 K68	B169
SPUN120304 KCP25B	B169
SPUN120308 K68	B169
SPUN120308 KCP25B	B169
SPUN120308T00520 KY1615	B318
SPUN120312 KCP25B	B169
SRACR1212N08	B227
SRACR1616Q08	B227
SRDCN1212N06	B227
SRDCN1212N08	B227
SRDCN1616H06	B227
SRDCN1616H08	B227
SRDCN1616H10	B227
SRDCN1616Q08	B227
SRDCN2020K08	B227
SRDCN2020K10	B227
SRDCN2020K12	B227
SRDCN2525M08	B227
SRDCN2525M10	B227
SRDCN2525M12	B227
SRDCN2525M16	B227
SRGCL1616H06	B228
SRGCL1616H10	B228
SRGCL2020K08	B228
SRGCL2525M08	B228
SRGCL2525M10	B228
SRGCL2525M12	B228
SRGCR08CA06	B229
SRGCR12CA10	B229
SRGCR1616H06	B228
SRGCR1616H10	B228
SRGCR2020K08	B228
SRGCR2020K10	B228
SRGCR2525M08	B228
SRGCR2525M10	B228
SRGCR2525M12	B228
SRS3	B179–181, B209–211, B227–228, B233–234, B247–248, B257, B266–268, B271, S41, T102
SRS4	B180, B182, B209–211, B213, B233–234
SRS5	B227
SS10DL10100M	057

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
SS10SLDL10055M	056
SS12DL10120M	057
SS12DL12120M	057
SS12SLDL10065M	056
SS12SLDL12065M	056
SS16DL10160M	057
SS16DL12160M	057
SS16DL16160M	057
SS16KST115AR3M	K38
SS16KST115AR5M	K38
SS16SLDL10090M	056
SS16SLDL12080M	056
SS16SLDL16070M	056
SS20DL10200M	057
SS20DL12200M	057
SS20DL16200M	057
SS20DL20200M	057
SS20FBHS24	K135
SS20KST135AR3M	K38
SS20KST135AR5M	K38
SS20KST155AR3M	K38
SS20KST155AR5M	K38
SS20KST175AR3M	K38
SS20KST175AR5M	K38
SS20KST175RR3M	K39
SS20KST175RR5M	K39
SS20KST200AR3M	K38
SS20KST200AR5M	K38
SS20KST200RR3M	K39
SS20KST200RR5M	K39
SS20RBHT24	K120
SS20SLDL10115M	056
SS20SLDL12105M	056
SS20SLDL16080M	056
SS20SLDL20080M	056
SS25DL16250M	057
SS25DL20250M	057
SS25DL25250M	057
SS25FBHS31	K135
SS25KST250AR3M	K38
SS25KST250AR5M	K38
SS25KST250RR3M	K39
SS25KST250RR5M	K39
SS25RBHT30	K120
SS25SLDL16115M	056
SS25SLDL20095M	056
SS25SLDL25090M	056
SS32DL25250M	057
SS32DL32250M	057
SS32KST300AR3M	K38
SS32KST300AR5M	K38
SS32KST300RR3M	K39
SS32KST300RR5M	K39
SS32KST350AR3M	K38
SS32KST350AR5M	K38
SS32KST350RR3M	K39
SS32KST350RR5M	K39
SS32SLDL25105M	056
SS32SLDL32105M	056
SS40DL32250M	057
SS40SLDL32140M	056
SS50DL32250M	057
SS50SLDL32200M	056
SSA3T	D78–79, D81–86
SSA4T	D78–79, D81–86
SSA5T	D82, D84–85
SSBCL1616H09	B233
SSBCR1212N09	B233
SSBCR2525M12	B233
SSDCN1212N09	B233
SSDCN1616H09	B233
SSDCN2020K09	B233
SSKCL12CA12	B235
SSKCL2020K12	B234
SSKCR12CA12	B235
SSKCR1616H09	B234
SSKCR16CA12	B235
SSKPR10CA09	B240
SSN2T	D81, D86
SSP025016M	B58–60, B66, B85, B89–90, B105–107, B132, B137, B149–150, B152, B161, B163
SSP025018M	B66, B105–106
SSP8	S126
SSRCL12CA12	B236
SSRCR12CA12	B236
SSRPR10CA09	B241
SSSCL1212N09	B234
SSSCL12CA12	B237
SSSCL1616H09	B234
SSSCL1616H12	B234
SSSCL2020K12	B234
SSSCL2525M12	B234
SSSCR1212N09	B234
SSSCR12CA12	B237
SSSCR1616H09	B234
SSSCR1616H12	B234
SSSCR2020K12	B234
SSSCR2525M12	B234
SSSPL10CA09	B242
SSSPR10CA09	B242
SSY3T	D78–79, D81–86
SSY4T	D78–79, D81–86
SSY5T K9	D82, D84–85
STCM11	B67, B90, B134, B164, U27–35, U40–49
STCM20	B61–63, B67–68, B72, B86, B90–91, B95, B108–110, B114, B133–134, B137, B151–153, B164
STCM25	V146–147
STCM26	B153
STCM32	U27–28, U30
STCM37	B139–141
STCM38	B70–72, B92, B115–119, B139–141, B375–378
STCM4	B61–63, B67–68, B91, B108–110, B114, B133–134, B151–152, B170, B172–173, B353–355
STCM40	B72, B92, B115–117, B119
STCM5	B62, B67, B86, B90, B151, B162, B164, B172, B354
STCM8	B72, B115, B119, B170, B173–174, B353–355, B371, B378
STCM9	B70–72, B92–93, B109, B115–117, B119, B139–141, B172–174, B355, B371
STFCL2020K16	B247
STFCL2525M16	B247
STFCR1616H11	B247
STFCR1616H16	B247
STFCR2020K16	B247
STFCR2525M16	B247
STFPL08CA09	B260
STFPL10CA11	B260
STFPL12CA16	B260
STFPR08CA09	B260
STFPR10CA11	B260
STFPR12CA16	B260
STGCL1212N11	B247
STGCL1616H11	B247
STGCL1616H16	B247
STGCL2020K16	B247
STGCL2525M16	B247
STGCR1212N11	B247
STGCR1616H11	B247
STGCR1616H16	B247
STGCR2020K16	B247
STGCR2525M16	B247
STGPL08CA09	B261
STGPL10CA11	B261
STGPR10CA11	B261
STGPR12CA16	B261
STJCLF1212M11Q	B248
STJCRF1212M11Q	B248
STN10075ISOI KC635M	W45
STN10100ISOI KC620M	W45
STN10100ISOI KC635M	W45
STN10125ISOI KC635M	W45
STN10150ISOI KC635M	W45
STN1018UNI KC635M	W44
STN1020UNI KC635M	W44
STN11100ISOI KC635M	W45
STN1114UNI KC635M	W44
STN11150ISOI KC635M	W45
STN1116UNI KC635M	W44
STN1118NPT KC635M	W46
STN1118NPTF KC635M	W46
STN1118UNE KC635M	W44
STN1118UNI KC635M	W44
STN1119BSW KC635M	W46
STN1120UNI KC635M	W44
STN1124UNI KC635M	W44
STN16100ISOI KC635M	W45
STN16115NPS KC635M	W46
STN16115NPT KC635M	W46
STN16115NPTF KC635M	W46
STN1611BSW KC610M	W46
STN1611BSW KC635M	W46
STN1612BSW KC635M	W46
STN1612UNI KC635M	W44
STN1614BSW KC610M	W46
STN1614BSW KC635M	W46
STN1614NPS KC635M	W46
STN1614NPT KC635M	W46
STN1614NPTF KC635M	W46
STN1614UNE KC635M	W44
STN1614UNI KC635M	W44
STN16150ISOE KC610M	W45
STN16150ISOE KC620M	W45
STN16150ISOI KC635M	W45
STN1616UNE KC635M	W44
STN1616UNI KC610M	W44
STN16175ISOI KC635M	W45
STN16200ISOI KC635M	W45
STN1620UNE KC635M	W44
STN1624UNE KC635M	W44
STN1624UNI KC635M	W44
STN1627UNI KC635M	W44
STN1632UNI KC635M	W44
STN22300ISOIC KC610M	W45
STN2711BSW KC635M	W46
STN27200ISOE KC610M	W45
STN27350ISOIC KC610M	W45
STTPR08CA09	B262
STTPR10CA11	B262
STTPR12CA16	B262
STWPR10CA11	B263
STWPR12CA16	B263
SU3	E59
SUWTCL	E58
SUWTCR	E58
SVABL1212M11Q	B266
SVABL1616K16Q	B266
SVABR1010M11Q	B266
SVABR1212M11Q	B266
SVABR1616K16Q	B266
SVHBL1212N11	B266
SVHBL1616H11	B266
SVHBL2020K11	B266
SVHBL2020K16	B266
SVHBL2525M16	B266
SVHBR1212N11	B266
SVHBR1616H11	B266
SVHBR2020K11	B266
SVHBR2020K16	B266
SVHBR2525M16	B266
SVJBL1212N11	B267
SVJBL1616H11	B267
SVJBL1616H16	B267
SVJBL2020K11	B267
SVJBL2020K16	B267
SVJBL2525M16	B267
SVJBL3225P16	B267
SVJBLF1010M11Q	B267
SVJBLF1212M11Q	B267
SVJBLF1616K16Q	B267
SVJBR1212N11	B267
SVJBR1616H11	B267
SVJBR1616H16	B267
SVJBR2020K11	B267
SVJBR2020K16	B267
SVJBR2525M16	B267
SVJBR3225P16	B267
SVJBRF1010M11Q	B267
SVJBRF1212M11Q	B267
SVJBRF1616K16Q	B267
SVVBN1212N11	B268
SVVBN1616H11	B268
SVVBN1616H16	B268
SVVBN2020K11	B268
SVVBN2020K16	B268
SVVBN2525M16	B268
SVVBN3225P16	B268
SWLCR2020K06	B271
SWSM515	S126
SYB115RBHT16LF	K121
SYB24RBHT06F	K121
SYB30RBHT06F	K121
SYB40RBHT09F	K121
SYB50RBHT09F	K121
SYB66RBHT12F	K121
SYB66RBHT12LF	K121
SYB87RBHT12F	K121
SYB87RBHT16LF	K121
T15 S	T115, V9–12, V18–19, V21, V93–94, V101–104
T20 S	T118, V101–102, V104
T320M060X100R6HX KC7542	M4
T320M080X125R6HX KC7542	M4
T320M100X150R6HX KC7542	M4
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T331M080X125R6HX KC7542	M23
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T331NC4375-14R3BX KC7542	M22
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T331NF2500-28R3BX KC7542	M22
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T340M050X080R6HX KCK17	M55
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T351M070X100R6HX-D1 KCK17	M58
T351M080X125R6HX KCK17	M57
T351M080X125R6HX-D1 KCK17	M58
T351M090X125R6HX-D1 KCK17	M58

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
T351M100X150R6HX KCK17	M57
T351M100X150R6HX-D1 KCK17	M58
T351M120X175R6HX KCK17	M57
T351M120X175R6HX-D6 KCK17	M58
T351M140X2006RHX-D6 KCK17	M58
T351M140X200R6HX KCK17	M57
T351M160X200R6HX KCK17	M57
T351MF100X100R6HX KCK17	M57
T351MF100X100R6HX-D4 KCK17	M58
T351MF100X125R6HX-D4 KCK17	M58
T351MF120X125R6HX-D4 KCK17	M58
T351MF120X150R6HX KCK17	M57
T351MF120X150R6HX-D4 KCK17	M58
T351MF140X125R6HX-D4 KCK17	M58
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T351MF140X150R6HX-D4 KCK17	M58
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T351NC#8-32R3BX KCK17	M56
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T351NC03125-18R3BX KCK17	M56
T351NC03750-16R3BX KCK17	M56
T351NC04375-14R3BX KCK17	M56
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T351NC07500-10R3BX KCK17	M56
T351NF#10-32R3BX KCK17	M56
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T491M060X100R6HX-D74 KCN14	M73
T491M080X125R6HX KCN14	M72
T491M080X125R6HX-D74 KCN14	M73
T491M100X150R6HX KCN14	M72
T491M100X150R6HX-D74 KCN14	M73
T491M120X175R6HX KCN14	M72
T600M030X050R6HX-D1 KSP21	M13
T600M040X070R6HX-D1 KSP21	M13
T600M050X080R6HX-D1 KSP21	M13
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T604M140X200R6H-D6 KSH26	M39
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T604M200X250R6H-D6 KSH26	M39
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T604MF100X125R6H-D4 KSH26	M39
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T604MF160X150R6H-D4 KSH26	M39
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T620M200X250R6HX-D6 KM6515	M6
T620M200X250R6HX-D6 KP6525	M6
T620M240X300R6H-XL KP6525	M9
T620M240X300R6HX-D6 KP6525	M8
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T620M330X350R6HX-D6 KP6525	M8
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T620M360X400R6HX-D6 KP6525	M8
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T620M420X450R6HX-D6 KP6525	M8
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T621M100X150R6HX-D1 KM6515	M7
T621M100X150R6HX-D1 KP6525	M7
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T621M120X175R6HX-D6 KP6525	M7
T621M140X200R6HX-D6 KM6515	M7
T621M140X200R6HX-D6 KP6525	M7
T621M160X200R6HX-D6 KM6515	M7
T621M160X200R6HX-D6 KP6525	M7
T621M180X250R6HX-D6 KM6515	M7
T621M180X250R6HX-D6 KP6525	M7
T621MF080X100R6HX-D4 KM6515	M7
T621MF080X100R6HX-D4 KP6525	M7
T621MF100X100R6HX-D4 KM6515	M7
T621MF100X100R6HX-D4 KP6525	M7
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T623MF140X150R6HX-D74 KSN28	M75
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T623MF160X150R6HX-D74 KSP21	M75
T630M030X050R6HX-D1 KM6515	M24
T630M030X050R6HX-D1 KP6525	M24
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T630M330X350R6HX-D6 KP6525	M28
T630M330X350R6HX-XL KP6525	M30
T630M360X400R6HX-D6 KP6525	M28
T630M360X400R6HX-XL KP6525	M30
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T630M420X450R6HX-XL KP6525	M30
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T630NF03750-24R3BX-D1 KP6525	M36
T630NF04375-20R3BX-D6 KP6525	M36
T630NF05000-20R3BX-D6 KP6525	M36
T631M050X080R6HX-D1 KM6515	M25
T631M050X080R6HX-D1 KP6525	M25
T631M060X100R6HX-D1 KM6515	M25
T631M060X100R6HX-D1 KP6525	M25
T631M080X125R6HX-D1 KM6515	M25
T631M080X125R6HX-D1 KP6525	M25
T631M100X150R6HX-D1 KM6515	M25
T631M100X150R6HX-D1 KP6525	M25
T631M120X175R6HX-D6 KM6515	M25
T631M120X175R6HX-D6 KP6525	M25
T631M140X200R6HX-D6 KM6515	M25
T631M140X200R6HX-D6 KP6525	M25
T631M160X200R6HX-D6 KM6515	M25
T631M160X200R6HX-D6 KP6525	M25
T631M180X250R6HX-D6 KM6515	M25
T631M180X250R6HX-D6 KP6525	M25
T631M240X300R6HX-D6 KP6525	M29
T631M240X300R6HX-XL KP6525	M31
T631M300X350R6HX-D6 KP6525	M29

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
T631M300X350R6HX-XL KP6525	M31
T631M330X350R6HX-D6 KP6525	M29
T631M330X350R6HX-XL KP6525	M31
T631M360X400R6HX-D6 KP6525	M29
T631M360X400R6HX-XL KP6525	M31
T631M420X450R6HX-D6 KP6525	M29
T631M420X450R6HX-XL KP6525	M31
T631MF080X100R6HX-D4 KM6515	M25
T631MF080X100R6HX-D4 KP6525	M25
T631MF100X100R6HX-D4 KM6515	M25
T631MF100X100R6HX-D4 KP6525	M25
T631MF100X125R6HX-D4 KM6515	M25
T631MF100X125R6HX-D4 KP6525	M25
T631MF120X125R6HX-D4 KM6515	M25
T631MF120X125R6HX-D4 KP6525	M25
T631MF120X150R6HX-D4 KM6515	M25
T631MF120X150R6HX-D4 KP6525	M25
T631MF140X125R6HX-D4 KM6515	M25
T631MF140X125R6HX-D4 KP6525	M25
T631MF140X150R6HX-D4 KM6515	M25
T631MF140X150R6HX-D4 KP6525	M25
T631MF160X150R6HX-D4 KM6515	M25
T631MF160X150R6HX-D4 KP6525	M25
T631MF180X150R6HX-D4 KM6515	M25
T631MF180X150R6HX-D4 KP6525	M25
T631NC02500-20R3BX-D1 KP6525	M37
T631NC03125-18R3BX-D1 KP6525	M37
T631NC03750-16R3BX-D1 KP6525	M37
T631NC04375-14R3BX-D6 KP6525	M37
T631NC05000-13R3BX-D6 KP6525	M37
T631NF02500-28R3BX-D1 KP6525	M37
T631NF03125-24R3BX-D1 KP6525	M37
T631NF03750-24R3BX-D1 KP6525	M37
T631NF04375-20R3BX-D6 KP6525	M37
T631NF05000-20R3BX-D6 KP6525	M37
T632M050X080R6HX-D1 KP6525	M26
T632M060X100R6HX-D1 KP6525	M26
T632M080X125R6HX-D1 KP6525	M26
T632M100X150R6HX-D1 KP6525	M26
T632M120X175R6HX-D6 KP6525	M26
T632M140X200R6HX-D6 KP6525	M26
T632MF120X150R6HX-D4 KP6525	M26
T632MF140X150R6HX-D4 KP6525	M26
T632MF160X150R6HX-D4 KP6525	M26
T633M050X080R6HX-D1 KP6525	M27
T633M060X100R6HX-D1 KP6525	M27
T633M080X125R6HX-D1 KP6525	M27
T633M100X150R6HX-D1 KP6525	M27
T633M120X175R6HX-D6 KP6525	M27
T633M140X200R6HX-D6 KP6525	M27
T633MF120X150R6HX-D4 KP6525	M27
T633MF140X150R6HX-D4 KP6525	M27
T633MF160X150R6HX-D4 KP6525	M27
T640M040X070R6HX-D1 KP6525	M63
T640M050X080R6HX-D1 KP6525	M63
T640M060X100R6HX-D1 KP6525	M63
T640M080X125R6HX-D1 KP6525	M63
T640M100X150R6HX-D1 KP6525	M63
T640M120X175R6HX-D6 KP6525	M63
T640M140X200R6HX-D6 KP6525	M63
T640M160X200R6HX-D6 KP6525	M63
T640M180X250R6HX-D6 KP6525	M63
T640M200X250R6HX-D6 KP6525	M63
T640M220X250R6HX-D6 KP6525	M63
T640NC#06-32R2BX-D1 KP6525	M67
T640NC#08-32R2BX-D1 KP6525	M67
T640NC#10-24R2BX-D1 KP6525	M67
T640NC02500-20R3BX-D1 KP6525	M67
T640NC03125-18R3BX-D1 KP6525	M67
T640NC03750-16R3BX-D1 KP6525	M67
T640NC04375-14R3BX-D6 KP6525	M67
T640NC05000-13R3BX-D6 KP6525	M67
T640NF#06-40R2BX-D1 KP6525	M67
T640NF#10-32R2BX-D1 KP6525	M67
T640NF02500-28R3BX-D1 KP6525	M67
T640NF03125-24R3BX-D1 KP6525	M67
T640NF03750-24R3BX-D1 KP6525	M67
T640NF04375-20R3BX-D6 KP6525	M67
T640NF05000-20R3BX-D6 KP6525	M67
T641M050X080R6HX-D1 KP6525	M64
T641M060X100R6HX-D1 KP6525	M64
T641M080X125R6HX-D1 KP6525	M64
T641M100X150R6HX-D1 KP6525	M64
T641M120X175R6HX-D6 KP6525	M64
T641M140X200R6HX-D6 KP6525	M64
T641M160X200R6HX-D6 KP6525	M64
T641M180X250R6HX-D6 KP6525	M64
T641M200X250R6HX-D6 KP6525	M64
T641NC02500-20R3BX-D1 KP6525	M68
T641NC03125-18R3BX-D1 KP6525	M68
T641NC03750-16R3BX-D1 KP6525	M68
T641NC04375-14R3BX-D6 KP6525	M68
T641NC05000-13R3BX-D6 KP6525	M68
T641NF02500-28R3BX-D1 KP6525	M68
T641NF03125-24R3BX-D1 KP6525	M68
T641NF03750-24R3BX-D1 KP6525	M68
T641NF04375-20R3BX-D6 KP6525	M68
T641NF05000-20R3BX-D6 KP6525	M68
T642M050X080R6HX-D1 KP6525	M65
T642M060X100R6HX-D1 KP6525	M65
T642M080X125R6HX-D1 KP6525	M65
T642M100X150R6HX-D1 KP6525	M65
T642M120X175R6HX-D6 KP6525	M65
T642M140X200R6HX-D6 KP6525	M65
T642MF120X150R6HX-D4 KP6525	M65
T642MF140X150R6HX-D4 KP6525	M65
T642MF160X150R6HX-D4 KP6525	M65
T643M050X080R6HX-D1 KP6525	M66
T643M060X100R6HX-D1 KP6525	M66
T643M080X125R6HX-D1 KP6525	M66
T643M100X150R6HX-D1 KP6525	M66
T643M120X175R6HX-D6 KP6525	M66
T643M140X200R6HX-D6 KP6525	M66
T643MF120X150R6HX-D4 KP6525	M66
T643MF140X150R6HX-D4 KP6525	M66
T643MF160X150R6HX-D4 KP6525	M66
T650M240X300R6HX-D6 KP6525	M32
T650M240X300R6HX-XL KP6525	M34
T650M300X350R6HX-D6 KP6525	M32
T650M300X350R6HX-XL KP6525	M34
T650M330X350R6HX-D6 KP6525	M32
T650M330X350R6HX-XL KP6525	M34
T650M360X400R6HX-D6 KP6525	M32
T650M360X400R6HX-XL KP6525	M34
T650M420X450R6HX-D6 KP6525	M32
T650M420X450R6HX-XL KP6525	M34
T651M240X300R6HX-D6 KP6525	M33
T651M240X300R6HX-XL KP6525	M35
T651M300X350R6HX-D6 KP6525	M33
T651M300X350R6HX-XL KP6525	M35
T651M330X350R6HX-D6 KP6525	M33
T651M330X350R6HX-XL KP6525	M35
T651M360X400R6HX-D6 KP6525	M33
T651M360X400R6HX-XL KP6525	M35
T651M420X450R6HX-D6 KP6525	M33
T651M420X450R6HX-XL KP6525	M35
T670M030X050R6H-D1 KSN38	M12
T670M040X070R6H-D1 KSN38	M12
T670M050X080R6H-D1 KSN38	M12
T670M060X100R6H-D1 KSN38	M12
T670M080X125R6H-D1 KSN38	M12
T670M100X150R6H-D1 KSN38	M12
T670M120X175R6H-D6 KSN38	M12
T670M160X200R6H-D6 KSN38	M12
T680M030X050R6H-D1 KSN38	M38
T680M040X070R6H-D1 KSN38	M38
T680M050X080R6H-D1 KSN38	M38
T680M060X100R6H-D1 KSN38	M38
T680M080X125R6H-D1 KSN38	M38
T680M100X150R6H-D1 KSN38	M38
T680M120X175R6H-D6 KSN38	M38
T680M160X200R6H-D6 KSN38	M38
T680M200X250R6H-D6 KSN38	M38
T820M020X040R6G-D1 KSP39	M14
T820M020X040R6H-D1 KSP32	M14
T820M020X040R6H-D1 KSP39	M14
T820M025X045R6G-D1 KSP39	M14
T820M025X045R6H-D1 KSP39	M14
T820M030X050R6G-D1 KSP39	M14
T820M030X050R6H-D1 KSP32	M14
T820M030X050R6H-D1 KSP39	M14
T820M030X050R6H-J KSU30	M18
T820M030X050R6H-J KSU31	M18
T820M035X060R6H-D1 KSP39	M14
T820M040X070R6G-D1 KSP39	M14
T820M040X070R6H-D1 KSP32	M14
T820M040X070R6H-D1 KSP39	M14
T820M040X070R6H-J KSU30	M18
T820M040X070R6H-J KSU31	M18
T820M050X080R6G-D1 KSP39	M14
T820M050X080R6H-D1 KSP32	M14
T820M050X080R6H-D1 KSP39	M14
T820M050X080R6H-J KSU30	M18
T820M050X080R6H-J KSU31	M18
T820M060X100R6G-D1 KSP39	M14
T820M060X100R6H-D1 KSP32	M14
T820M060X100R6H-D1 KSP39	M14
T820M060X100R6H-D6 KSP39	M14
T820M060X100R6H-J KSU30	M18
T820M060X100R6H-J KSU31	M18
T820M070X100R6G-D1 KSP39	M14
T820M070X100R6H-D1 KSP32	M14
T820M070X100R6H-D1 KSP39	M14
T820M080X125R6G-D1 KSP39	M14
T820M080X125R6H-D1 KSP32	M14
T820M080X125R6H-D1 KSP39	M14
T820M080X125R6H-D6 KSP39	M14
T820M080X125R6H-J KSU30	M18
T820M080X125R6H-J KSU31	M18
T820M100X150R6G-D1 KSP39	M14
T820M100X150R6H-D1 KSP32	M14
T820M100X150R6H-D1 KSP39	M14
T820M100X150R6H-D6 KSP39	M14
T820M100X150R6H-J KSU30	M18
T820M100X150R6H-J KSU31	M18
T820M120X175R6G-D6 KSP39	M15
T820M120X175R6H-D6 KSP32	M15
T820M120X175R6H-D6 KSP39	M15
T820M120X175R6H-J KSU30	M18
T820M140X200R6G-D6 KSP39	M15
T820M140X200R6H-D6 KSP32	M15
T820M140X200R6H-D6 KSP39	M15
T820M140X200R6H-J KSU30	M18
T820M160X200R6G-D6 KSP39	M15
T820M160X200R6H-D6 KSP32	M15
T820M160X200R6H-D6 KSP39	M15
T820M160X200R6H-J KSU30	M18
T820M180X250R6H-D6 KSP32	M15
T820M180X250R6H-D6 KSP39	M15
T820M180X250R6H-J KSU30	M18
T820M200X250R6H-D6 KSP32	M15
T820M200X250R6H-D6 KSP39	M15
T820M200X250R6H-J KSU30	M18
T820M220X250R6H-D6 KSP39	M15
T820M240X300R6H-D6 KSP39	M15
T820M270X300R6H-D6 KSP39	M15
T820M300X350R6H-D6 KSP39	M15
T820M330X350R6H-D6 KSP39	M15
T820M360X400R6H-D6 KSP39	M15
T820MF040X050R6H-D4 KSP39	M14
T820MF050X050R6H-D4 KSP39	M14
T820MF060X050R6H-D4 KSP39	M14
T820MF060X075R6H-D4 KSP39	M14
T820MF080X100R6H-D4 KSP39	M14
T820MF100X100R6H-D4 KSP39	M14
T820MF100X125R6H-D4 KSP39	M14
T820MF120X100R6H-D4 KSP39	M14
T820MF120X125R6H-D4 KSP39	M14
T820MF120X125R6H-J KSU30	M18
T820MF120X150R6H-D4 KSP39	M14
T820MF120X150R6H-J KSU30	M18
T820MF140X100R6H-D4 KSP39	M15
T820MF140X125R6H-D4 KSP39	M15
T820MF140X150R6H-D4 KSP39	M15
T820MF140X150R6H-J KSU30	M18
T820MF160X100R6H-D4 KSP39	M15
T820MF160X150R6H-D4 KSP39	M15
T820MF160X150R6H-J KSU30	M18
T820MF180X150R6H-D4 KSP39	M15
T820MF180X200R6H-D4 KSP39	M15
T820MF200X150R6H-D4 KSP39	M15
T820MF200X200R6H-D4 KSP39	M15
T820MF220X150R6H-D4 KSP39	M15
T820MF220X200R6H-D4 KSP39	M15
T820MF240X150R6H-D4 KSP39	M15
T820NC#04-40R2B-D1 KSP39	M16
T820NC#04-40R3B-D1 KSP39	M17
T820NC#05-40R2B-D1 KSP39	M16
T820NC#06-32R2B-D1 KSP39	M16
T820NC#06-32R3B-D1 KSP39	M17
T820NC#08-32R2B-D1 KSP39	M16
T820NC#08-32R3B-D1 KSP39	M17
T820NC#10-24R2B-D1 KSP39	M16
T820NC02500-20R2B-D1 KSP39	M16
T820NC03125-18R2B-D1 KSP39	M16
T820NC03750-16R2B-D1 KSP39	M16
T820NC04375-14R2B-D6 KSP39	M16
T820NC05000-13R2B-D6 KSP39	M16
T820NC05625-12R2B-D6 KSP39	M16
T820NC06250-11R2B-D6 KSP39	M16
T820NC07500-10R2B-D6 KSP39	M16
T820NC08750-9R2B-D6 KSP39	M16
T820NC10000-8R2B-D6 KSP39	M16
T820NF#06-40R2B-D1 KSP39	M16
T820NF#10-32R2B-D1 KSP39	M16
T820NF#10-32R3B-D1 KSP39	M17
T820NF02500-28R2B-D1 KSP39	M16
T820NF02500-28R3B-D1 KSP39	M17
T820NF03125-24R2B-D1 KSP39	M16
T820NF03125-24R3B-D1 KSP39	M17
T820NF03750-24R2B-D1 KSP39	M16
T820NF03750-24R3B-D1 KSP39	M17
T820NF04375-20R2B-D6 KSP39	M16
T820NF04375-20R3B-D6 KSP39	M17
T820NF05000-20R2B-D6 KSP39	M16
T820NF05000-20R3B-D6 KSP39	M17
T820NF05625-18R2B-D6 KSP39	M16
T820NF06250-18R2B-D6 KSP39	M16
T820NF07500-16R2B-D6 KSP39	M16
T820NF08750-14R2B-D6 KSP39	M16
T820NF10000-12R2B-D6 KSP39	M16
T830M020X040R6G-D1 KSP39	M40
T830M020X040R6H-D1 KSP39	M40
T830M025X045R6G-D1 KSP39	M40
T830M025X045R6H-D1 KSP39	M40
T830M030X050R6G-D1 KSP39	M40
T830M030X050R6H-D1 KSP32	M40
T830M030X050R6H-D1 KSP39	M40
T830M030X050R6H-J KSU30	M50
T830M030X050R6H-J KSU31	M50
T830M035X060R6H-D1 KSP39	M40
T830M040X070R6G-D1 KSP39	M40
T830M040X070R6H-D1 KSP32	M40
T830M040X070R6H-D1 KSP39	M40
T830M040X070R6H-J KSU30	M50
T830M040X070R6H-J KSU31	M50
T830M050X080R6G-D1 KSP39	M40
T830M050X080R6H-D1 KSP32	M40
T830M050X080R6H-D1 KSP39	M40
T830M050X080R6H-J KSU30	M50
T830M050X080R6H-J KSU31	M50
T830M060X100R6G-D1 KSP39	M40
T830M060X100R6H-D1 KSP32	M40
T830M060X100R6H-D1 KSP39	M40
T830M060X100R6H-D6 KSP39	M40
T830M060X100R6H-J KSU30	M50
T830M060X100R6H-J KSU31	M50
T830M070X100R6H-D1 KSP39	M40
T830M080X125R6G-D1 KSP39	M40
T830M080X125R6H-D1 KSP32	M40
T830M080X125R6H-D1 KSP39	M40
T830M080X125R6H-D6 KSP39	M40
T830M080X125R6H-J KSU30	M50
T830M080X125R6H-J KSU31	M50
T830M100X150R6G-D1 KSP39	M40
T830M100X150R6H-D1 KSP32	M40
T830M100X150R6H-D1 KSP39	M40
T830M100X150R6H-D6 KSP39	M40
T830M100X150R6H-J KSU30	M50
T830M100X150R6H-J KSU31	M50
T830M120X175R6G-D6 KSP39	M40
T830M120X175R6H-D6 KSP32	M40
T830M120X175R6H-D6 KSP39	M40
T830M120X175R6H-J KSU30	M50
T830M140X200R6G-D6 KSP39	M41
T830M140X200R6H-D6 KSP32	M41
T830M140X200R6H-D6 KSP39	M41
T830M140X200R6H-J KSU30	M50

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
T830M160X200R6G-D6 KSP39	M41
T830M160X200R6H-D6 KSP39	M41
T830M160X200R6H-J KSU30	M50
T830M180X250R6H-D6 KSP39	M41
T830M180X250R6H-J KSU30	M50
T830M200X250R6H-D6 KSP39	M41
T830M200X250R6H-J KSU30	M50
T830M220X250R6H-D6 KSP39	M41
T830M240X300R6H-D6 KSP39	M41
T830M270X300R6H-D6 KSP39	M41
T830M300X350R6H-D6 KSP39	M41
T830M330X350R6H-D6 KSP39	M41
T830M360X400R6H-D6 KSP39	M41
T830MF080X100R6H-D4 KSP32	M40
T830MF080X100R6H-D4 KSP39	M40
T830MF100X125R6H-D4 KSP32	M40
T830MF100X125R6H-D4 KSP39	M40
T830MF120X125R6H-D4 KSP39	M40
T830MF120X125R6H-J KSU30	M50
T830MF120X150R6H-D4 KSP32	M40
T830MF120X150R6H-D4 KSP39	M40
T830MF120X150R6H-J KSU30	M50
T830MF140X150R6H-D4 KSP32	M41
T830MF140X150R6H-D4 KSP39	M41
T830MF140X150R6H-J KSU30	M50
T830MF160X150R6H-D4 KSP39	M41
T830MF160X150R6H-J KSU30	M50
T830MF180X150R6H-D4 KSP39	M41
T830NC#04-40R2B-D1 KSP39	M46
T830NC#04-40R3B-D1 KSP39	M49
T830NC#05-40R2B-D1 KSP39	M46
T830NC#06-32R2B-D1 KSP39	M46
T830NC#06-32R3B-D1 KSP39	M49
T830NC#08-32R2B-D1 KSP39	M46
T830NC#08-32R3B-D1 KSP39	M49
T830NC#10-24R2B-D1 KSP39	M46
T830NC02500-20R2B-D1 KSP39	M46
T830NC03125-18R2B-D1 KSP39	M46
T830NC03750-16R2B-D1 KSP39	M46
T830NC04375-14R2B-D6 KSP39	M46
T830NC05000-13R2B-D6 KSP39	M46
T830NC05625-12R2B-D6 KSP39	M46
T830NC06250-11R2B-D6 KSP39	M46
T830NC07500-10R2B-D6 KSP39	M46
T830NC10000-8R2B-D6 KSP39	M46
T830NF#06-40R2B-D1 KSP39	M46
T830NF#10-32R2B-D1 KSP39	M46
T830NF#10-32R3B-D1 KSP39	M49
T830NF02500-28R2B-D1 KSP39	M46
T830NF02500-28R3B-D1 KSP39	M49
T830NF03125-24R2B-D1 KSP39	M46
T830NF03125-24R3B-D1 KSP39	M49
T830NF03750-24R2B-D1 KSP39	M46
T830NF03750-24R3B-D1 KSP39	M49
T830NF04375-20R2B-D6 KSP39	M46
T830NF04375-20R3B-D6 KSP39	M49
T830NF05000-20R2B-D6 KSP39	M46
T830NF05000-20R3B-D6 KSP39	M49
T830NF05625-18R2B-D6 KSP39	M46
T830NF06250-18R2B-D6 KSP39	M46
T830NF07500-16R2B-D6 KSP39	M46
T830NF08750-14R2B-D6 KSP39	M46
T830NF08750-9R2B-D6 KSP39	M46
T830NF10000-12R2B-D6 KSP39	M46
T832M030X050R6H-D1 KSP32	M42
T832M030X050R6H-D1 KSP39	M42
T832M040X070R6H-D1 KSP32	M42
T832M040X070R6H-D1 KSP39	M42
T832M050X080R6H-D1 KSP32	M42
T832M050X080R6H-D1 KSP39	M42
T832M060X100R6H-D1 KSP32	M42
T832M060X100R6H-D1 KSP39	M42
T832M080X125R6H-D1 KSP32	M42
T832M080X125R6H-D1 KSP39	M42
T832M100X150R6H-D1 KSP32	M42
T832M100X150R6H-D1 KSP39	M42
T832M120X175R6H-D6 KSP32	M42
T832M120X175R6H-D6 KSP39	M42
T832M140X200R6H-D6 KSP32	M42
T832M140X200R6H-D6 KSP39	M42
T832M160X200R6H-D6 KSP39	M42
T832M180X250R6H-D6 KSP32	M42
T832M180X250R6H-D6 KSP39	M42
T832M200X250R6H-D6 KSP32	M42
T832M200X250R6H-D6 KSP39	M42
T832MF080X100R6H-D4 KSP32	M42
T832MF080X100R6H-D4 KSP39	M42
T832MF100X125R6H-D4 KSP32	M42
T832MF100X125R6H-D4 KSP39	M42
T832MF120X150R6H-D4 KSP32	M42
T832MF120X150R6H-D4 KSP39	M42
T832MF140X150R6H-D4 KSP32	M42
T832MF140X150R6H-D4 KSP39	M42
T838M020X040R6H-D1 KSP39	M43
T838M020X040R6H-D1 KSU31	M43
T838M030X050R6H-D1 KSP39	M43
T838M030X050R6H-D1 KSU31	M43
T838M040X070R6H-D1 KSP39	M43
T838M040X070R6H-D1 KSU31	M43
T838M050X080R6H-D1 KSP39	M43
T838M050X080R6H-D1 KSU31	M43
T838M050X080R6H-D6 KSP39	M43
T838M050X080R6H-D6 KSU31	M43
T838M060X100R6H-D1 KSP39	M43
T838M060X100R6H-D1 KSU31	M43
T838M060X100R6H-D6 KSP39	M43
T838M060X100R6H-D6 KSU31	M43
T838M080X125R6H-D1 KSP39	M43
T838M080X125R6H-D1 KSU31	M43
T838M080X125R6H-D6 KSP39	M43
T838M080X125R6H-D6 KSU31	M43
T838M100X150R6H-D1 KSP39	M43
T838M100X150R6H-D1 KSU31	M43
T838M100X150R6H-D6 KSP39	M43
T838M100X150R6H-D6 KSU31	M43
T838M120X175R6H-D6 KSP39	M43
T838M120X175R6H-D6 KSU31	M43
T838M140X200R6H-D6 KSP39	M43
T838M140X200R6H-D6 KSU31	M43
T838M160X200R6H-D6 KSP39	M43
T838M160X200R6H-D6 KSU31	M43
T838M180X250R6H-D6 KSP39	M43
T838M180X250R6H-D6 KSU31	M43
T838M200X250R6H-D6 KSP39	M44
T838M200X250R6H-D6 KSU31	M44
T838M220X250R6H-D6 KSP39	M44
T838M220X250R6H-D6 KSU31	M44
T838M240X300R6H-D6 KSP39	M44
T838M240X300R6H-D6 KSU31	M44
T838M270X300R6H-D6 KSP39	M44
T838M270X300R6H-D6 KSU31	M44
T838M300X350R6H-D6 KSP39	M44
T838M300X350R6H-D6 KSU31	M44
T838M330X350R6H-D6 KSP39	M44
T838M330X350R6H-D6 KSU31	M44
T838M360X400R6H-D6 KSP39	M44
T838M360X400R6H-D6 KSU31	M44
T838M390X400R6H-D6 KSP39	M44
T838M390X400R6H-D6 KSU31	M44
T838M420X450R6H-D6 KSP39	M44
T838M420X450R6H-D6 KSU31	M44
T838M450X450R6H-D6 KSP39	M44
T838M450X450R6H-D6 KSU31	M44
T838M480X500R6H-D6 KSP39	M44
T838M480X500R6H-D6 KSU31	M44
T838M520X500R6H-D6 KSP39	M44
T838M520X500R6H-D6 KSU31	M44
T838MF060X075R6H-D4 KSP39	M43
T838MF060X075R6H-D4 KSU31	M43
T838MF080X075R6H-D4 KSP39	M43
T838MF080X075R6H-D4 KSU31	M43
T838MF080X100R6H-D4 KSP39	M43
T838MF080X100R6H-D4 KSU31	M43
T838MF100X075R6H-D4 KSP39	M43
T838MF100X075R6H-D4 KSU31	M43
T838MF100X100R6H-D4 KSP39	M43
T838MF100X100R6H-D4 KSU31	M43
T838MF100X125R6H-D4 KSP39	M43
T838MF100X125R6H-D4 KSU31	M43
T838MF120X100R6H-D4 KSP39	M43
T838MF120X100R6H-D4 KSU31	M43
T838MF120X125R6H-D4 KSP39	M43
T838MF120X125R6H-D4 KSU31	M43
T838MF120X150R6H-D4 KSP39	M43
T838MF120X150R6H-D4 KSU31	M43
T838MF140X100R6H-D4 KSP39	M43
T838MF140X100R6H-D4 KSU31	M43
T838MF140X125R6H-D4 KSP39	M43
T838MF140X125R6H-D4 KSU31	M43
T838MF140X150R6H-D4 KSP39	M43
T838MF140X150R6H-D4 KSU31	M43
T838MF160X150R6H-D4 KSP39	M43
T838MF160X150R6H-D4 KSU31	M43
T838MF180X150R6H-D4 KSP39	M43
T838MF180X150R6H-D4 KSU31	M43
T838MF180X200R6H-D4 KSP39	M43
T838MF180X200R6H-D4 KSU31	M43
T838MF200X150R6H-D4 KSP39	M43
T838MF200X150R6H-D4 KSU31	M43
T838MF200X200R6H-D4 KSP39	M43
T838MF200X200R6H-D4 KSU31	M43
T838MF220X150R6H-D4 KSP39	M44
T838MF220X150R6H-D4 KSU31	M44
T838MF220X200R6H-D4 KSP39	M44
T838MF220X200R6H-D4 KSU31	M44
T838MF240X150R6H-D4 KSP39	M44
T838MF240X150R6H-D4 KSU31	M44
T838MF240X200R6H-D4 KSP39	M44
T838MF240X200R6H-D4 KSU31	M44
T838MF270X150R6H-D4 KSP39	M44
T838MF270X150R6H-D4 KSU31	M44
T838MF300X150R6H-D4 KSP39	M44
T838MF300X150R6H-D4 KSU31	M44
T838MF300X200R6H-D4 KSP39	M44
T838MF300X200R6H-D4 KSU31	M44
T838NC#06-32R2B-D1 KSP39	M47
T838NC#06-32R2B-D1 KSU31	M47
T838NC#08-32R2B-D1 KSP39	M47
T838NC#08-32R2B-D1 KSU31	M47
T838NC#10-24R2B-D1 KSP39	M47
T838NC#10-24R2B-D1 KSU31	M47
T838NC#12-24R2B-D1 KSP39	M47
T838NC#12-24R2B-D1 KSU31	M47
T838NC02500-20R2B-D1 KSP39	M47
T838NC02500-20R2B-D1 KSU31	M47
T838NC02500-20R2B-D6 KSP39	M47
T838NC02500-20R2B-D6 KSU31	M47
T838NC03125-18R2B-D1 KSP39	M47
T838NC03125-18R2B-D1 KSU31	M47
T838NC03125-18R2B-D6 KSP39	M47
T838NC03125-18R2B-D6 KSU31	M47
T838NC03750-16R2B-D1 KSP39	M47
T838NC03750-16R2B-D1 KSU31	M47
T838NC03750-16R2B-D6 KSP39	M47
T838NC03750-16R2B-D6 KSU31	M47
T838NC04375-14R2B-D6 KSP39	M47
T838NC04375-14R2B-D6 KSU31	M47
T838NC05000-13R2B-D6 KSP39	M47
T838NC05000-13R2B-D6 KSU31	M47
T838NC05625-12R2B-D6 KSP39	M47
T838NC05625-12R2B-D6 KSU31	M47
T838NC06250-11R2B-D6 KSP39	M47
T838NC06250-11R2B-D6 KSU31	M47
T838NC07500-10R2B-D6 KSP39	M47
T838NC07500-10R2B-D6 KSU31	M47
T838NC08750-9R2B-D6 KSP39	M47
T838NC08750-9R2B-D6 KSU31	M47
T838NC10000-8R2B-D6 KSP39	M47
T838NC10000-8R2B-D6 KSU31	M47
T838NC11250-7R2B-D6 KSP39	M48
T838NC11250-7R2B-D6 KSU31	M48
T838NC12500-7R2B-D6 KSP39	M48
T838NC12500-7R2B-D6 KSU31	M48
T838NC13750-6R2B-D6 KSP39	M48
T838NC13750-6R2B-D6 KSU31	M48
T838NC15000-6R2B-D6 KSP39	M48
T838NC15000-6R2B-D6 KSU31	M48
T838NC17500-5R2B-D6 KSP39	M48
T838NC17500-5R2B-D6 KSU31	M48
T838NC20000-4,5R2B-D6 KSP39	M48
T838NC20000-4,5R2B-D6 KSU31	M48
T838NF#06-40R2B-D1 KSP39	M47
T838NF#06-40R2B-D1 KSU31	M47
T838NF#08-36R2B-D1 KSP39	M47
T838NF#08-36R2B-D1 KSU31	M47
T838NF#10-32R2B-D1 KSP39	M47
T838NF#10-32R2B-D1 KSU31	M47
T838NF#12-28R2B-D1 KSP39	M47
T838NF#12-28R2B-D1 KSU31	M47
T838NF02500-28R2B-D1 KSP39	M47
T838NF02500-28R2B-D1 KSU31	M47
T838NF02500-28R2B-D4 KSP39	M47
T838NF02500-28R2B-D4 KSU31	M47
T838NF03125-24R2B-D4 KSP39	M47
T838NF03125-24R2B-D4 KSU31	M47
T838NF03750-24R2B-D4 KSP39	M47
T838NF03750-24R2B-D4 KSU31	M47
T838NF04375-20R2B-D4 KSP39	M47
T838NF04375-20R2B-D4 KSU31	M47
T838NF05000-20R2B-D4 KSP39	M47
T838NF05000-20R2B-D4 KSU31	M47
T838NF05625-18R2B-D4 KSP39	M47
T838NF05625-18R2B-D4 KSU31	M47
T838NF06250-18R2B-D4 KSP39	M47
T838NF06250-18R2B-D4 KSU31	M47
T838NF07500-16R2B-D4 KSP39	M47
T838NF07500-16R2B-D4 KSU31	M47
T838NF08750-14R2B-D4 KSP39	M47
T838NF08750-14R2B-D4 KSU31	M47
T838NF10000-12R2B-D4 KSP39	M47
T838NF10000-12R2B-D4 KSU31	M47
T838NF11250-12R2B-D4 KSP39	M48
T838NF11250-12R2B-D4 KSU31	M48
T838NF12500-12R2B-D4 KSP39	M48
T838NF12500-12R2B-D4 KSU31	M48
T838NF13750-12R2B-D4 KSP39	M48
T838NF13750-12R2B-D4 KSU31	M48
T838NF15000-12R2B-D4 KSP39	M48
T838NF15000-12R2B-D4 KSU31	M48
T839M030X050R6H-D1 KSP39	M45
T839M030X050R6H-D1 KSU31	M45
T839M040X070R6H-D1 KSP39	M45
T839M040X070R6H-D1 KSU31	M45
T839M050X080R6H-D1 KSP39	M45
T839M050X080R6H-D1 KSU31	M45
T839M060X100R6H-D1 KSP39	M45
T839M060X100R6H-D1 KSU31	M45
T839M080X125R6H-D1 KSP39	M45
T839M080X125R6H-D1 KSU31	M45
T839M100X150R6H-D1 KSP39	M45
T839M100X150R6H-D1 KSU31	M45
T839M120X175R6H-D6 KSP39	M45
T839M120X175R6H-D6 KSU31	M45
T839M140X200R6H-D6 KSP39	M45
T839M140X200R6H-D6 KSU31	M45
T839M160X200R6H-D6 KSP39	M45
T839M160X200R6H-D6 KSU31	M45
T839M180X250R6H-D6 KSP39	M45
T839M180X250R6H-D6 KSU31	M45
T839M200X250R6H-D6 KSP39	M45
T839M200X250R6H-D6 KSU31	M45
T848NPT00625-27R-D56 KSU30	M79
T848NPT01250-27R-D56 KSU30	M79
T848NPT02500-18R-D56 KSU30	M79
T848NPT03750-18R-D56 KSU30	M79
T848NPT05000-14R-D56 KSU30	M79
T848NPT07500-14R-D56 KSU30	M79
T848NPT10000-11,5R-D56 KSU30	M79
T848NPTF00625-27R-D56 KSU30	M79
T848NPTF01250-27R-D56 KSU30	M79
T848NPTF02500-18R-D56 KSU30	M79
T848NPTF03750-18R-D56 KSU30	M79
T848NPTF05000-14R-D56 KSU30	M79
T848NPTF07500-14R-D56 KSU30	M79
T848NPTF10000-11,5R-D56 KSU30	M79
T857G01250-28R-D56 KSP39	M78
T857G01250-28R-D56 KSU31	M78
T857G02500-19R-D56 KSP39	M78
T857G02500-19R-D56 KSU31	M78
T857G03750-19R-D56 KSP39	M78
T857G03750-19R-D56 KSU31	M78
T857G05000-14R-D56 KSP39	M78
T857G05000-14R-D56 KSU31	M78
T857G06250-14R-D56 KSP39	M78
T857G06250-14R-D56 KSU31	M78
T857G07500-14R-D56 KSP39	M78
T857G07500-14R-D56 KSU31	M78
T857G08750-14R-D56 KSP39	M78

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
T857G08750-14R-D56 KSU31	M78
T857G10000-11R-D56 KSP39	M78
T857G10000-11R-D56 KSU31	M78
T877G01250-28R-D56 KSP39	M78
T877G01250-28R-D56 KSU31	M78
T877G02500-19R-D56 KSP39	M78
T877G02500-19R-D56 KSU31	M78
T877G03750-19R-D56 KSP39	M78
T877G03750-19R-D56 KSU31	M78
T877G05000-14R-D56 KSP39	M78
T877G05000-14R-D56 KSU31	M78
T877G06250-14R-D56 KSP39	M78
T877G06250-14R-D56 KSU31	M78
T877G07500-14R-D56 KSP39	M78
T877G07500-14R-D56 KSU31	M78
T877G08750-14R-D56 KSP39	M78
T877G08750-14R-D56 KSU31	M78
T877G10000-11R-D56 KSP39	M78
T877G10000-11R-D56 KSU31	M78
T9 S	T115, T118
TB15	V9, V11–12, V21, V87–89
TB20	V28
TCDE0800AC5RE KC643M	P42
TCDE1000AC5RE KC643M	P42
TCDE1200AC5RF KC643M	P42
TCDE1600A5CRG KC643M	P42
TCDE2000A5CRG KC643M	P42
TCDE2500A5CRG KC643M	P42
TCGT110201LF KC5025	B243
TCGT110201LF KCU10	B243
TCGT110202HP KC5010	B243
TCGT110202HP KC5410	B243
TCGT110202HP KCU25	B243
TCGT110204HP K313	B243
TCGT110204HP KC5010	B243
TCGT110204HP KC5025	B243
TCGT110204HP KC5410	B243
TCGT110204HP KCU10	B243
TCGT110204HP KCU25	B243
TCGT110204LF KC5010	B243
TCGT110204LF KC5025	B243
TCGT110204LF KCU10	B243
TCGT110208HP KC5010	B243
TCGT16T301LF KCU10	B243
TCGT16T302HP KC5010	B243
TCGT16T302HP KCU25	B243
TCGT16T302LF KC5010	B243
TCGT16T304HP K313	B243
TCGT16T304HP KC5010	B243
TCGT16T304HP KC5025	B243
TCGT16T304HP KC5410	B243
TCGT16T304HP KCU10	B243
TCGT16T304LF KC5010	B243
TCGT16T304LF KCU10	B243
TCGT16T308HP K313	B243
TCGT16T308HP KC5010	B243
TCGT16T308HP KC5025	B243
TCGT16T308HP KC5410	B243
TCGT16T308HP KCU10	B243
TCGT16T308LF KC5010	B243
TCGT16T308LF KCU10	B243
TCGW090202S01015MT KBH20	B319
TCGW090204S01015 MT KBH20	B319
TCGW110202S01015MT KBH10	B319
TCGW110202S01015MT KBH20	B319
TCGW110204FST KD1400	B348
TCGW110204FST KD1425	B348
TCGW110204S01015MT KBH10	B319
TCGW110204S01015MT KBH20	B319
TCGW110204S01225MT KBH10	B319
TCGW110208S01015MT KBH10	B319
TCGW110208S01015MT KBH20	B319
TCGW110208S01225MT KBH10	B319
TCGW16T304FST KD1400	B348
TCMT090204FP KCP25B	B244
TCMT090204FP KCU10	B244
TCMT090204FP KCU25	B244
TCMT090208FP KCU10	B244
TCMT090208FP KCU25	B244
TCMT110202FP KCU25	B244
TCMT110202FP KTP10	B244
TCMT110202LF KC5010	B244
TCMT110202LF KC5025	B244
TCMT11020411 KT315	B243
TCMT110204FP KCK20B	B244
TCMT110204FP KCM25	B244
TCMT110204FP KCP10	B244
TCMT110204FP KCP25	B244
TCMT110204FP KCU10	B244
TCMT110204FP KCU25	B244
TCMT110204FP KTP10	B244
TCMT110204LF KC5010	B244
TCMT110204LF KC5025	B244
TCMT110204LF KCK05	B244
TCMT110204LF KCK15	B244
TCMT110204LF KCK15B	B244
TCMT110204LF KCK20	B244
TCMT110204LF KCK20B	B244
TCMT110204LF KCM15	B244
TCMT110204LF KCM15B	B244
TCMT110204LF KCM25B	B244
TCMT110204LF KCM35	B244
TCMT110204LF KCP10	B244
TCMT110204LF KCP10B	B244
TCMT110204LF KCP25	B244
TCMT110204LF KCP25B	B244
TCMT110204LF KCP30	B244
TCMT110204LF KT315	B244
TCMT110204UF KC5010	B245
TCMT110204UF KCP25	B245
TCMT110208FP KCM15	B244
TCMT110208FP KCP25	B244
TCMT110208FP KCU10	B244
TCMT110208FP KCU25	B244
TCMT110208LF KC5010	B244
TCMT110208LF KC5025	B244
TCMT110208LF KCK05	B244
TCMT110208LF KCK15	B244
TCMT110208LF KCK15B	B244
TCMT110208LF KCK20	B244
TCMT110208LF KCK20B	B244
TCMT110208LF KCM15	B244
TCMT110208LF KCM25B	B244
TCMT110208LF KCP10	B244
TCMT110208LF KCP25	B244
TCMT110208LF KCP25B	B244
TCMT110208LF KCP30	B244
TCMT110208LF KT315	B244
TCMT110208MF KCK15	B245
TCMT110208MF KCK20	B245
TCMT110208MF KCK20B	B245
TCMT110208MF KCM25B	B245
TCMT110208MF KCP25	B245
TCMT110208MF KCP25B	B245
TCMT110208MP KCK20B	B245
TCMT110208MP KCP25	B245
TCMT110208MP KCU10	B245
TCMT110208UF KC5010	B245
TCMT110304FP KCP10B	B244
TCMT110304FP KCU10	B244
TCMT110304FP KCU25	B244
TCMT110308FP KCP05	B244
TCMT110308FP KCU10	B244
TCMT110308FP KCU25	B244
TCMT110312FP KCP05	B244
TCMT110312FP KCU10	B244
TCMT16T302LF KC5010	B244
TCMT16T302LF KC5025	B244
TCMT16T30411 KT315	B243
TCMT16T304FP KCP10	B244
TCMT16T304FP KCP25	B244
TCMT16T304FP KCU10	B244
TCMT16T304FP KCU25	B244
TCMT16T304LF KC5010	B244
TCMT16T304LF KC5025	B244
TCMT16T304LF KCK05	B244
TCMT16T304LF KCK15	B244
TCMT16T304LF KCK20	B244
TCMT16T304LF KCK20B	B244
TCMT16T304LF KCM15	B244
TCMT16T304LF KCM25	B244
TCMT16T304LF KCM25B	B244
TCMT16T304LF KCM35	B244
TCMT16T304LF KCP10	B244
TCMT16T304LF KCP10B	B244
TCMT16T304LF KCP25	B244
TCMT16T304LF KCP25B	B244
TCMT16T304LF KT315	B244
TCMT16T304MP KCK20B	B245
TCMT16T304MP KCM25	B245
TCMT16T304MP KCM25B	B245
TCMT16T304MP KCP25	B245
TCMT16T304MP KCU10	B245
TCMT16T30811 KT315	B243
TCMT16T308FP KCM25	B244
TCMT16T308FP KCP10	B244
TCMT16T308FP KCP25	B244
TCMT16T308FP KCU10	B244
TCMT16T308FP KCU25	B244
TCMT16T308FP KTP10	B244
TCMT16T308LF KC5010	B244
TCMT16T308LF KC5025	B244
TCMT16T308LF KCK05B	B244
TCMT16T308LF KCK15	B244
TCMT16T308LF KCK15B	B244
TCMT16T308LF KCK20	B244
TCMT16T308LF KCK20B	B244
TCMT16T308LF KCM25	B244
TCMT16T308LF KCM25B	B244
TCMT16T308LF KCM35	B244
TCMT16T308LF KCP10	B244
TCMT16T308LF KCP10B	B244
TCMT16T308LF KCP25	B244
TCMT16T308LF KCP25B	B244
TCMT16T308LF KCP30	B244
TCMT16T308LF KT315	B244
TCMT16T308MF KCK15	B245
TCMT16T308MF KCK15B	B245
TCMT16T308MF KCK20	B245
TCMT16T308MF KCK20B	B245
TCMT16T308MF KCM25	B245
TCMT16T308MF KCM25B	B245
TCMT16T308MF KCM35	B245
TCMT16T308MF KCP10	B245
TCMT16T308MF KCP25	B245
TCMT16T308MF KCP25B	B245
TCMT16T308MF KCP30	B245
TCMT16T308MP KCK20B	B245
TCMT16T308MP KCM15	B245
TCMT16T308MP KCM25	B245
TCMT16T308MP KCM25B	B245
TCMT16T308MP KCP10	B245
TCMT16T308MP KCP25	B245
TCMT16T308MP KCU10	B245
TCMT16T308UF KC5010	B245
TCMT16T308UF KCP25	B245
TCMT16T312FP KCP10	B244
TCMT16T312FP KCU10	B244
TCMT16T312FP KCU25	B244
TCMT16T312LF KC5010	B244
TCMT16T312LF KCK15	B244
TCMT16T312LF KCK20	B244
TCMT16T312LF KCK20B	B244
TCMT16T312LF KCM25	B244
TCMT16T312LF KCP10B	B244
TCMT16T312LF KCP25	B244
TCMT16T312MF KCK20	B245
TCMT16T312MF KCK20B	B245
TCMT16T312MF KCM25B	B245
TCMT16T312MF KCP10	B245
TCMT16T312MF KCP25B	B245
TCMT16T312MP KCP25	B245
TCMT220408FP KCM25	B244
TCMT220408FP KCP05	B244
TCMT220408FP KCP25	B244
TCMT220408FP KCU10	B244
TCMT220408FP KCU25	B244
TCMT220408LF KC5010	B244
TCMT220408LF KC5025	B244
TCMT220408LF KCK15B	B244
TCMT220408LF KCK20B	B244
TCMT220408LF KCP10B	B244
TCMT220408LF KCP25	B244
TCMT220408LF KCP25B	B244
TCMW16T304 KCK20B	B246
TCMW16T308 KCK20B	B246
TD6P K68	B253
TDHB07T1202 KC5010	B249
TDHB07T1202 KC5025	B249
TDHB07T1202 KCU10	B249
TDHB07T1202 KCU25	B249
TDHB07T1204 KC5010	B249
TDHB07T1204 KC5025	B249
TDHB07T1204 KCU10	B249
TDHB07T1204 KCU25	B249
TDHB07T1204 KT315	B249
TDHB07T1208 KC5025	B249
TDHB07T12S0 KC5010	B249
TDHB07T12S0 KCU25	B249
TDHB07T12S0 KT315	B249
TDHH07T1202L KC5010	B249
TDHH07T1202L KCU10	B249
TDHH07T1202L KCU25	B249
TDHH07T1202R KCU10	B249
TDHH07T1204L KC5010	B249
TDHH07T1204L KCU10	B249
TDHH07T1204L KCU25	B249
TDHH07T1204R KCU10	B249
THW2M	T58–59, V72, V78, V137–139
THW3M	U27–35, U40–49
TK01338D	E54
TK01339D	E54
TM24D14L26Z1	W4
TM24D15L30Z1	W4
TM24D16L28Z2	W4
TM24D16L36Z1	W4
TM24EN14BSF KC610M	W6
TM24EN14BSF KC635M	W6
TM24EN18NPT KC610M	W6
TM24EN18NPT KC635M	W6
TM24EN18NPTF KC610M	W7
TM24EN18NPTF KC635M	W7
TM24EN19BSF KC610M	W6
TM24EN19BSF KC635M	W6
TM24EN19BSPT KC610M	W7
TM24EN19BSPT KC635M	W7
TM24ENBLANK	W7
TM24N050ISO KC610M	W6
TM24N050ISO KC635M	W6
TM24N075ISO KC610M	W6
TM24N075ISO KC635M	W6
TM24N100ISO KC610M	W6
TM24N100ISO KC635M	W6
TM24N10UN KC610M	W6
TM24N10UN KC635M	W6
TM24N125ISO KC610M	W6
TM24N125ISO KC635M	W6
TM24N12UN KC610M	W6
TM24N12UN KC635M	W6
TM24N14UN KC610M	W6
TM24N14UN KC635M	W6
TM24N150ISO KC610M	W6
TM24N150ISO KC635M	W6
TM24N16UN KC610M	W6
TM24N16UN KC635M	W6
TM24N175ISO KC610M	W6
TM24N175ISO KC635M	W6
TM24N18UN KC610M	W6
TM24N18UN KC635M	W6
TM24N200ISO KC610M	W6
TM24N200ISO KC635M	W6
TM24N20UN KC610M	W6
TM24N20UN KC635M	W6
TM24N24UN KC610M	W6
TM24N24UN KC635M	W6
TM24N250ISO KC610M	W6
TM24N250ISO KC635M	W6
TM24N28UN KC610M	W6
TM24N28UN KC635M	W6
TM24N32UN KC610M	W6
TM24N32UN KC635M	W6
TM25BLANK	W15
TM25D17L26Z2	W10
TM25D17L36Z2	W10
TM25D20L37Z3	W10
TM25D20L44Z3	W10
TM25D22L43Z3	W10

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
TM25D22L55Z3	W10
TM25D30L55Z5	W10
TM25EN115NPT KC610M	W15
TM25EN115NPT KC635M	W15
TM25EN11BSPT KC610M	W15
TM25EN11W KC610M	W15
TM25EN11W KC635M	W15
TM25EN12W KC610M	W15
TM25EN14BSPT KC610M	W15
TM25EN14NPT KC610M	W15
TM25EN14NPT KC635M	W15
TM25EN14W KC610M	W15
TM25EN14W KC635M	W15
TM25INSERTSCREW	W4–5, W10–13, W17–19, W24–25
TM25N100ISO KC610M	W14
TM25N100ISO KC635M	W14
TM25N10UN KC610M	W14
TM25N10UN KC635M	W14
TM25N12UN KC610M	W14
TM25N12UN KC635M	W14
TM25N14UN KC610M	W14
TM25N14UN KC635M	W14
TM25N150ISO KC610M	W14
TM25N150ISO KC635M	W14
TM25N16UN KC610M	W14
TM25N16UN KC635M	W14
TM25N18UN KC610M	W14
TM25N200ISO KC610M	W14
TM25N200ISO KC635M	W14
TM25N20UN KC610M	W14
TM25N20UN KC635M	W14
TM25N250ISO KC610M	W14
TM25N250ISO KC635M	W14
TM25N300ISO KC610M	W14
TM25N300ISO KC635M	W14
TM25N8UN KC610M	W14
TM25N8UN KC635M	W14
TM25N9UN KC610M	W14
TM25N9UN KC635M	W14
TM40D22L43Z3	W17
TM40D22L65Z3	W17
TM40D30L55Z4	W17
TM40D30L80Z3	W17
TM40EN008NPT KC610M	W20
TM40EN008NPT KC635M	W20
TM40EN008NPTF KC610M	W21
TM40EN008NPTF KC635M	W21
TM40EN011BSPT KC610M	W21
TM40EN011BSPT KC635M	W21
TM40EN115NPT KC610M	W20
TM40EN115NPTF KC610M	W21
TM40EN11BSF KC610M	W20
TM40EN11BSF KC635M	W20
TM40EN12BSF KC610M	W20
TM40EN14BSF KC610M	W20
TM40EN16BSF KC610M	W20
TM40ENBLANK	W21
TM40N100ISO KC610M	W20
TM40N100ISO KC635M	W20
TM40N10UN KC610M	W20
TM40N12UN KC610M	W20
TM40N12UN KC635M	W20
TM40N14UN KC610M	W20
TM40N150ISO KC610M	W20
TM40N150ISO KC635M	W20
TM40N16UN KC610M	W20
TM40N16UN KC635M	W20
TM40N18UN KC610M	W20
TM40N200ISO KC610M	W20
TM40N200ISO KC635M	W20
TM40N20UN KC610M	W20
TM40N20UN KC635M	W20
TM40N250ISO KC610M	W20
TM40N300ISO KC610M	W20
TM40N300ISO KC635M	W20
TM40N8UN KC610M	W20
TM40N8UN KC635M	W20
TM40N9UN KC610M	W20
TM41D21L45Z1	W24
TM41D25L43Z2	W24
TM41D30L43Z3	W24
TM41D30L65Z3	W24
TM41D36L43Z5	W24
TM41D36L65Z4	W24
TM41EN8NPT KC610M	W26
TM41EN8NPT KC635M	W26
TM41ENBLANK	W26
TM41N300ISO KC610M	W26
TM41N300ISO KC635M	W26
TM41N350ISO KC610M	W26
TM41N350ISO KC635M	W26
TM41N400ISO KC610M	W26
TM41N400ISO KC635M	W26
TM41N450ISO KC610M	W26
TM41N450ISO KC635M	W26
TM41N45UN KC610M	W26
TM41N45UN KC635M	W26
TM41N4UN KC610M	W26
TM41N4UN KC635M	W26
TM41N500ISO KC610M	W26
TM41N500ISO KC635M	W26
TM41N550ISO KC610M	W26
TM41N550ISO KC635M	W26
TM41N5UN KC610M	W26
TM41N5UN KC635M	W26
TM41N600ISO KC610M	W26
TM41N600ISO KC635M	W26
TM41N6UN KC610M	W26
TM41N6UN KC635M	W26
TM41N7UN KC610M	W26
TM41N7UN KC635M	W26
TM41N8UN KC610M	W26
TM41N8UN KC635M	W26
TM711M030X050R2DHA KCU33	M85
TM711M040X070R2DHA KCU33	M85
TM711M050X080R2DHA KCU33	M85
TM711M060X100R2DHA KCU33	M85
TM711M080X125R2DHA KCU33	M85
TM711M100X150R2DHA KCU33	M85
TM711M120X175R2DHA KCU33	M85
TM711M140X200R2DHA KCU33	M85
TM711M160X200R2DHA KCU33	M85
TM711M180X250R2DHA KCU33	M85
TM711M200X250R2DHA KCU33	M85
TM711MF040X050R2DHA KCU33	M85
TM711MF050X050R2DHA KCU33	M85
TM711MF060X075R2DHA KCU33	M85
TM711MF080X075R2DHA KCU33	M85
TM711MF080X100R2DHA KCU33	M85
TM711MF100X100R2DHA KCU33	M85
TM711MF120X100R2DHA KCU33	M85
TM711MF120X150R2DHA KCU33	M85
TM711MF140X150R2DHA KCU33	M85
TM711MF160X150R2DHA KCU33	M85
TM711MF180X150R2DHA KCU33	M85
TM711MF200X150R2DHA KCU33	M85
TM721M060X100R2DHA KCU32	M87
TM721M080X125R2DHA KCU32	M87
TM721M100X150R2DHA KCU32	M87
TM721M120X175R2DHA KCU32	M87
TM721M140X200R2DHA KCU32	M87
TM721M160X200R2DHA KCU32	M87
TM721MF080X100R2DHA KCU32	M87
TM721MF120X125R2DHA KCU32	M87
TM721MF140X150R2DHA KCU32	M87
TM721NC0500-13R2DHA KCU32	M86
TM721NC0625-11R2DHA KCU32	M86
TM721NC2500-20R2DHA KCU32	M86
TM721NC3125-18R2DHA KCU32	M86
TM721NC3750-16R2DHA KCU32	M86
TM721NC4375-14R2DHA KCU32	M86
TM721NC5625-12R2DHA KCU32	M86
TM731M040X070R2DHA KCU32	M88
TM731M050X080R2DHA KCU32	M88
TM731M060X100R2DHA KCU32	M88
TM731M080X125R2DHA KCU32	M88
TM731M100X150R2DHA KCU32	M88
TM731M120X175R2DHA KCU32	M88
TM731M160X200R2DHA KCU32	M88
TM731MF080X100R2DHA KCU32	M88
TM741M060X100R2DHA KCU36	M90
TM741M080X125R2DHA KCU36	M90
TM741M100X150R2DHA KCU36	M90
TM741M120X175R2DHA KCU36	M90
TM741M140X200R2DHA KCU36	M90
TM741M160X200R2DHA KCU36	M90
TM741M180X250R2DHA KCU36	M90
TM741M200X250R2DHA KCU36	M90
TM741MF080X100R2DHA KCU36	M90
TM741MF100X100R2DHA KCU36	M90
TM741MF100X125R2DHA KCU36	M90
TM741MF120X150R2DHA KCU36	M90
TM741NC0500-13R2DHA KCU36	M89
TM741NC0750-10R2DHA KCU36	M89
TM741NC0750-16R2DHA KCU36	M89
TM741NC2500-20R2DHA KCU36	M89
TM741NC3125-18R2DHA KCU36	M89
TM741NC3750-16R2DHA KCU36	M89
TM741NF0500-20R2DHA KCU36	M89
TM741NF0625-18R2DHA KCU36	M89
TM741NF2500-28R2DHA KCU36	M89
TM741NF3125-24R2DHA KCU36	M89
TM741NF3750-24R2DHA KCU36	M89
TMC25D30L80Z4	W10
TMS25D36L34Z5	W12
TMS25D44L38Z6	W12
TMS25D52L40Z8	W12
TMS40D44L48Z6	W18
TMS40D52L50Z8	W18
TMS41D48L50Z5	W25
TMS41D58L50Z6	W25
TMST25D36L34Z5	W13
TMST40D45L48Z6	W19
TMT24D14L26Z1	W5
TMT25D17L26Z2	W11
TMT25D22L43Z3	W11
TMT25D28L43Z4	W11
TNGA160404S01015MT KBH10	B320
TNGA160404S01015MT KBH20	B320
TNGA160404S01225MT KBH20	B320
TNGA160404S01735MT KBH20	B320
TNGA160408S01015MT KBH10	B320
TNGA160408S01015MT KBH20	B320
TNGA160408S01225MT KBH10	B320
TNGA160408S01225MT KBH20	B320
TNGA160408S01735MT KBH10	B320
TNGA160408S01735MT KBH20	B320
TNGA160408T02020 KY1615	B319
TNGA160408T02020 KY3500	B294
TNGA160408T02020 KYK10	B294
TNGA160412S01015MT KBH10	B320
TNGA160412S01015MT KBH20	B320
TNGA160412S01225MT KBH10	B320
TNGA160412S01225MT KBH20	B320
TNGA160412S01735MT KBH10	B320
TNGA160412S01735MT KBH20	B320
TNGA160412T02020 KY1615	B319
TNGA160412T02020 KY3500	B294
TNGA160416T02020 KY3500	B294
TNGA220408T02020 KY1615	B319
TNGA220412T02020 KY1615	B319
TNGG160402FS KC5025	B122
TNGG160402LF KC5010	B122
TNGG160402LF KCU10	B122
TNGG160404FS KC5010	B122
TNGG160404FS KC5025	B122
TNGG160404FS KCU10	B122
TNGG160404LF KC5010	B122
TNGG160408LF KC5010	B122
TNGG220408FS KCU10	B122
TNGM160408S01325MTCB1 KBH20	B320
TNGN110308T02020 KY1615	B319
TNGN110416S02020 KBK45	B286
TNGN160404T02020 KY1615	B319
TNGN160408T02020 KY1615	B319
TNGN160408T02020 KY3500	B298
TNGN160412T02020 KY1615	B319
TNGN160416S02020 KBK45	B286
TNGN160416T02020 KY1615	B319
TNGN160708T02020 KY1615	B319
TNGN160712T02020 KY1615	B319
TNGN220408T02020 KY1615	B319
TNGN220412T01020 KYS25	B336
TNGN220416T01020 KYS25	B336
TNGN220416T02020 KY3500	B298
TNGP160402 KC5010	B122
TNGP160402 KCU10	B122
TNGP160404 KC5010	B122
TNGP160404 KC5410	B122
TNGP160404 KCU10	B122
TNGP160408 KC5010	B122
TNGP160408 KC5410	B122
TNGP160408 KCU10	B122
TNGX160416S02020 KBK45	B288
TNMA160408 K68	B123
TNMA160408 KCK15	B123
TNMA160408 KCK15B	B123
TNMA160408 KCK20	B123
TNMA160408 KCK20B	B123
TNMA160412 KCK15	B123
TNMA160412 KCK20	B123
TNMA160416 KCK15	B123
TNMA160416 KCK20	B123
TNMA220408 K68	B123
TNMA220408 KCK05	B123
TNMA220408 KCK20B	B123
TNMA220412 KCK15B	B123
TNMA220412 KCK20B	B123
TNMA270616 KCK15	B123
TNMG110304FF KCU10	B124
TNMG110304FN KCP25	B124
TNMG110308FF KC5010	B124
TNMG110308FN KCP10	B124
TNMG110308FN KCP25	B124
TNMG160402MS KC5010	B126
TNMG160402MS KC5025	B126
TNMG160402MS KCU10	B126
TNMG160402MS KCU25	B126
TNMG160404FF KC5010	B124
TNMG160404FF KCM15B	B124
TNMG160404FF KCP10	B124
TNMG160404FF KCU10	B124
TNMG160404FF KT315	B124
TNMG160404FN KCK05	B124
TNMG160404FN KCK15B	B124
TNMG160404FN KCP05	B124
TNMG160404FN KCP10	B124
TNMG160404FN KCP10B	B124
TNMG160404FN KCP25	B124
TNMG160404FN KCP25B	B124
TNMG160404FN KT315	B124
TNMG160404FP KC5010	B124
TNMG160404FP KCM15	B124
TNMG160404FP KCU10	B124
TNMG160404FP KT315	B124
TNMG160404FW KC5010	B125
TNMG160404FW KCP05	B125
TNMG160404FW KCP10	B125
TNMG160404FW KCU10	B125
TNMG160404FW KT315	B125
TNMG160404MN KCP10	B125
TNMG160404MN KCP10B	B125
TNMG160404MN KCP25	B125
TNMG160404MN KCP25B	B125
TNMG160404MN KCP30	B125
TNMG160404MP KC5010	B125
TNMG160404MP KCM15	B125
TNMG160404MP KCM15B	B125
TNMG160404MP KCM25	B125
TNMG160404MP KCM25B	B125
TNMG160404MP KCM35B	B125
TNMG160404MP KCU10	B125
TNMG160404MS KC5010	B126
TNMG160404MS KC5025	B126
TNMG160404MS KCU10	B126
TNMG160404MS KCU25	B126
TNMG160404P KC5010	B127
TNMG160404P KCU10	B127
TNMG160404UP KCM25	B129
TNMG160408CT KCPK05	B123
TNMG160408FF KC5010	B124
TNMG160408FF KCP05	B124
TNMG160408FF KCP10B	B124
TNMG160408FF KCU10	B124
TNMG160408FF KT315	B124
TNMG160408FN KCK05	B124
TNMG160408FN KCK15B	B124

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
TNMG160408FN KCP05B	B124
TNMG160408FN KCP10	B124
TNMG160408FN KCP10B	B124
TNMG160408FN KCP25	B124
TNMG160408FN KCP25B	B124
TNMG160408FN KT315	B124
TNMG160408FP KC5010	B124
TNMG160408FP KCM15	B124
TNMG160408FP KCP10	B124
TNMG160408FP KCU10	B124
TNMG160408FP KT315	B124
TNMG160408FW KCP05	B125
TNMG160408FW KCP10B	B125
TNMG160408FW KT315	B125
TNMG160408MG KCP10B	B126
TNMG160408MN KCP05	B125
TNMG160408MN KCP10	B125
TNMG160408MN KCP10B	B125
TNMG160408MN KCP25	B125
TNMG160408MN KCP25B	B125
TNMG160408MN KCP30	B125
TNMG160408MN KCP30B	B125
TNMG160408MP KC5010	B125
TNMG160408MP KCM15	B125
TNMG160408MP KCM15B	B125
TNMG160408MP KCM25	B125
TNMG160408MP KCM25B	B125
TNMG160408MP KCM35	B125
TNMG160408MP KCM35B	B125
TNMG160408MP KCP25	B125
TNMG160408MP KCP25B	B125
TNMG160408MP KCU10	B125
TNMG160408MR KCM25	B126
TNMG160408MR KCM25B	B126
TNMG160408MR KCP10B	B126
TNMG160408MR KCP25B	B126
TNMG160408MS KC5010	B126
TNMG160408MS KC5025	B126
TNMG160408MS KCU10	B126
TNMG160408MS KCU25	B126
TNMG160408MW KCP05	B127
TNMG160408MW KCP10	B127
TNMG160408MW KCP25	B127
TNMG160408MW KCP25B	B127
TNMG160408P KCU10	B127
TNMG160408RN KCP10	B127
TNMG160408RN KCP10B	B127
TNMG160408RN KCP25	B127
TNMG160408RN KCP25B	B127
TNMG160408RN KCP30	B127
TNMG160408RP KC5010	B128
TNMG160408RP KC5025	B128
TNMG160408RP KCK05	B128
TNMG160408RP KCK20	B128
TNMG160408RP KCM15	B128
TNMG160408RP KCM25	B128
TNMG160408RP KCP05	B128
TNMG160408RP KCP10	B128
TNMG160408RP KCP10B	B128
TNMG160408RP KCP25	B128
TNMG160408RP KCP25B	B128
TNMG160408RP KCP30	B128
TNMG160408RP KCU10	B128
TNMG160408RP KCU25	B128
TNMG160408UN KCK05	B128
TNMG160408UN KCK15	B128
TNMG160408UN KCK15B	B128
TNMG160408UN KCK20	B128
TNMG160408UN KCK20B	B128
TNMG160408UP KCM15	B129
TNMG160408UP KCM25	B129
TNMG160412FN KCK05	B124
TNMG160412FN KCP05	B124
TNMG160412FN KCP10B	B124
TNMG160412FN KCP25	B124
TNMG160412FN KT315	B124
TNMG160412FP KC5010	B124
TNMG160412FP KCM15	B124
TNMG160412FP KCU10	B124
TNMG160412FW KCP05	B125
TNMG160412FW KCP10B	B125
TNMG160412FW KT315	B125
TNMG160412MN KCP10B	B125
TNMG160412MN KCP25	B125
TNMG160412MN KCP25B	B125
TNMG160412MN KCP40	B125
TNMG160412MP KC5010	B125
TNMG160412MP KCM15B	B125
TNMG160412MP KCM25	B125
TNMG160412MP KCM25B	B125
TNMG160412MR KCK15B	B126
TNMG160412MR KCP10B	B126
TNMG160412MR KCP25B	B126
TNMG160412MW KCP10	B127
TNMG160412MW KCP10B	B127
TNMG160412MW KCP25	B127
TNMG160412RN KCP10B	B127
TNMG160412RN KCP25	B127
TNMG160412RN KCP25B	B127
TNMG160412RN KCP30	B127
TNMG160412RP KC5025	B128
TNMG160412RP KCK20	B128
TNMG160412RP KCM25	B128
TNMG160412RP KCM35	B128
TNMG160412RP KCP05	B128
TNMG160412RP KCP10	B128
TNMG160412RP KCP10B	B128
TNMG160412RP KCP25	B128
TNMG160412RP KCP25B	B128
TNMG160412RP KCU25	B128
TNMG160412UN KCK05	B128
TNMG160412UN KCK05B	B128
TNMG160412UN KCK15B	B128
TNMG160412UN KCK20	B128
TNMG160412UN KCK20B	B128
TNMG160416RP KCP10	B128
TNMG160416UN KCK20	B128
TNMG220404FN KCP25	B124
TNMG220404FP KC5010	B124
TNMG220404FP KCM15	B124
TNMG220404FP KCM25B	B124
TNMG220404FP KCU10	B124
TNMG220404MN KCP10	B125
TNMG220404MN KCP25	B125
TNMG220404MN KCP25B	B125
TNMG220404MN KCP30	B125
TNMG220404MS KC5010	B126
TNMG220404MS KC5025	B126
TNMG220404MS KCU10	B126
TNMG220404MS KCU25	B126
TNMG220404P KCU10	B127
TNMG220408FN KCP10B	B124
TNMG220408FN KCP25	B124
TNMG220408FP KCM15	B124
TNMG220408FP KCU10	B124
TNMG220408MN KCP10	B125
TNMG220408MN KCP10B	B125
TNMG220408MN KCP25	B125
TNMG220408MN KCP25B	B125
TNMG220408MN KCP40	B125
TNMG220408MP KC5010	B125
TNMG220408MP KCM15B	B125
TNMG220408MP KCM25	B125
TNMG220408MP KCM25B	B125
TNMG220408MP KCP10B	B125
TNMG220408MP KCU10	B125
TNMG220408MR KCM25	B126
TNMG220408MR KCP25B	B126
TNMG220408MS K313	B126
TNMG220408MS KC5010	B126
TNMG220408MS KC5025	B126
TNMG220408MS KCU10	B126
TNMG220408MS KCU25	B126
TNMG220408P KCU10	B127
TNMG220408RN KCP10B	B127
TNMG220408RN KCP25	B127
TNMG220408RN KCP25B	B127
TNMG220408RN KCP30	B127
TNMG220408RN KCP30B	B127
TNMG220408RN KCP40	B127
TNMG220408RN KCP40B	B127
TNMG220408RP KC5010	B128
TNMG220408RP KC5025	B128
TNMG220408RP KCK20B	B128
TNMG220408RP KCM25	B128
TNMG220408RP KCM25B	B128
TNMG220408RP KCP10B	B128
TNMG220408RP KCP25	B128
TNMG220408RP KCP25B	B128
TNMG220408RP KCP40B	B128
TNMG220408RP KCU10	B128
TNMG220408RP KCU25	B128
TNMG220408UN KCK20	B128
TNMG220408UP KCM25	B129
TNMG220408UP KCM35	B129
TNMG220412 K68	B123
TNMG220412FN KCP10B	B124
TNMG220412FN KCP25	B124
TNMG220412MN KCP10B	B125
TNMG220412MN KCP25	B125
TNMG220412MN KCP25B	B125
TNMG220412MN KCP30	B125
TNMG220412MN KCP40B	B125
TNMG220412MP KC5010	B125
TNMG220412MP KCM25	B125
TNMG220412MP KCM25B	B125
TNMG220412MR KCM25B	B126
TNMG220412MS KCU10	B126
TNMG220412MS KCU25	B126
TNMG220412P KCU10	B127
TNMG220412RN KCP10	B127
TNMG220412RN KCP10B	B127
TNMG220412RN KCP25	B127
TNMG220412RN KCP25B	B127
TNMG220412RN KCP30B	B127
TNMG220412RN KCP40B	B127
TNMG220412RP KCM25	B128
TNMG220412RP KCM25B	B128
TNMG220412RP KCP10	B128
TNMG220412RP KCP25B	B128
TNMG220412RP KCP40	B128
TNMG220412RP KCU10	B128
TNMG220412RP KCU25	B128
TNMG220412UN KCK15	B128
TNMG220412UN KCK20	B128
TNMG220416MP KC5010	B125
TNMG220416RN KCP25	B127
TNMG220416RN KCP25B	B127
TNMG220416RP KCK15	B128
TNMG220416RP KCM25	B128
TNMG220416RP KCP10	B128
TNMG220416RP KCP25B	B128
TNMG220416RP KCU25	B128
TNMG220416UN KCK20	B128
TNMG220432RP KC5010	B128
TNMG220432RP KCK20	B128
TNMG220432RP KCP10B	B128
TNMG220432RP KCP25B	B128
TNMG220432RP KCP30	B128
TNMG270608MS KC5025	B126
TNMG270608MS KCU25	B126
TNMG270608RN KCP10	B127
TNMG270608RN KCP25	B127
TNMG270608RN KCP25B	B127
TNMG270608RN KCP30	B127
TNMG270612MR KCP25B	B126
TNMG270612RN KCP10	B127
TNMG270612RN KCP10B	B127
TNMG270612RN KCP25	B127
TNMG270612RN KCP30B	B127
TNMG270612RN KCP40	B127
TNMG270612RP KC5010	B128
TNMG270612RP KCM15	B128
TNMG270612RP KCM25B	B128
TNMG270612RP KCM35	B128
TNMG270612RP KCP10	B128
TNMG270612RP KCP25	B128
TNMG270612RP KCU10	B128
TNMG270612RP KCU25	B128
TNMG270616MS K313	B126
TNMG270616RN KCP10	B127
TNMG270616RN KCP25	B127
TNMG270616RN KCP25B	B127
TNMG270616RN KCP30B	B127
TNMG270616RN KCP40B	B127
TNMG270616RP KCM25	B128
TNMG270616RP KCP25B	B128
TNMG270616RP KCU10	B128
TNMG330924 KCP25	B123
TNMG330924 KCP40	B123
TNMG330924RN KCP10B	B127
TNMG330924RN KCP25	B127
TNMG330924RN KCP25B	B127
TNMG330924RN KCP30B	B127
TNMG330924RN KCP40B	B127
TNMG330924RP KCM25	B128
TNMG330924RP KCP25	B128
TNMG330924RP KCP40	B128
TNMG330924RP KCP40B	B128
TNMG330924RP KCU10	B128
TNMM160408RM KCP25	B129
TNMM160408RM KCP25B	B129
TNMM160408RM KCP30	B129
TNMM160412RM KCP25	B129
TNMM220408RM KCP25B	B129
TNMM220408RP KCP10	B130
TNMM220408RP KCP10B	B130
TNMM220412RM KCP25	B129
TNMM220412RM KCP25B	B129
TNMM220412RM KCP30	B129
TNMM220412RP KCM25B	B130
TNMM220412RP KCP25	B130
TNMM220416RM KCP25B	B129
TNMM220416RP KCP10	B130
TNMM270612RM KCP25	B129
TNMM270612RM KCP30	B129
TNMM270616RM KCP25	B129
TNMM330924MR KCP25B	B129
TNMP160404 K313	B130
TNMP160404K KCP25B	B130
TNMP160408 K313	B130
TNMP160408K KCP10	B130
TNMP160408K KCP25	B130
TNMP160408K KCP25B	B130
TNMP220408K KCP25	B130
TNMP220408K KCP25B	B130
TNMP220416 K68	B130
TNMS160404 K68	B131
TNMS160404FST KD1400	B348
TNMS160404FST KD1425	B348
TNMS160408 K68	B131
TNMS160408FST KD1400	B348
TNMS160408FST KD1425	B348
TNMS220408 K68	B131
TNMS220408 KC5410	B131
TP20	T86–89, V27–28
TP7	V4–5
TP8	V101, V103–104
TPCB110202 KC5010	B253
TPCB160302 KC5010	B253
TPCB160304 KC5010	B253
TPCB160308 KC5010	B253
TPCG110202L KC5010	B253
TPCG110204L KC5010	B253
TPCG110208L KC5010	B253
TPCH110202 KC5010	B253
TPCH110204 KC5010	B253
TPGH160304 KCU10	B253
TPGH160304 KCU25	B253
TPGH160308 KC5010	B253
TPGN110304 K313	B171
TPGN110304 K68	B171
TPGN110304 KC5010	B171
TPGN110304 KCU10	B171
TPGN110304F KD1425	B349
TPGN110304T01020 KY1615	B320
TPGN110308 K68	B171
TPGN110308 KC5010	B171
TPGN110308 KCU10	B171
TPGN110308T01020 KY1615	B320
TPGN110312T01020 KY1615	B320
TPGN160302 K313	B171
TPGN160302 K68	B171
TPGN160302 KC5010	B171
TPGN160304 K313	B171
TPGN160304 K68	B171
TPGN160304 KC5010	B171
TPGN160304 KCU10	B171

Index

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
TPGN160304F KD1425	B349
TPGN160304T00520 KY1615	B320
TPGN160304T01020 KY1615	B320
TPGN160308 K313	B171
TPGN160308 K68	B171
TPGN160308 KC5010	B171
TPGN160308 KCU10	B171
TPGN160308F KD1425	B349
TPGN160308T00520 KY1615	B320
TPGN160308T01020 KY1615	B320
TPGN160308T02020 KY3500	B299
TPGN160312 K313	B171
TPGN160312 KC5010	B171
TPGN160312T01020 KY1615	B320
TPGN160312T02020 KY3500	B299
TPGN160312T02020 KYK10	B299
TPGN160316 K68	B171
TPGN160316 KC5010	B171
TPGN220404 K313	B171
TPGN220404 K68	B171
TPGN220404 KC5010	B171
TPGN220404 KCU10	B171
TPGN220408 K313	B171
TPGN220408 K68	B171
TPGN220408 KC5010	B171
TPGN220408 KCP25B	B171
TPGN220408 KCU10	B171
TPGN220408F KD1425	B349
TPGN220408T02020 KY3500	B299
TPGN220412 K68	B171
TPGN220412 KC5010	B171
TPGN220412 KCU10	B171
TPGN220412T02020 KY3500	B299
TPGN220416 K68	B171
TPGN220416 KC5010	B171
TPGR110304K KC5010	B171
TPGR110308K KCU10	B171
TPGR160304K KC5010	B171
TPGR160304K KCU10	B171
TPGR160308K KC5010	B171
TPGR160308K KCP25B	B171
TPGR160308K KCU10	B171
TPGR220404K KCU10	B171
TPGR220408K KCU10	B171
TPGT090202LF KC5010	B254
TPGT090202LF KCU10	B254
TPGT090204LF KC5010	B254
TPGT090204LF KC5025	B254
TPGT090204LF KC5410	B254
TPGT090204LF KCU10	B254
TPGT110201LF KCU10	B254
TPGT110202HP KC5010	B254
TPGT110202HP KC5025	B254
TPGT110202HP KCU10	B254
TPGT110202LF KC5010	B254
TPGT110202LF KC5025	B254
TPGT110202LF KCU10	B254
TPGT110204HP KC5010	B254
TPGT110204HP KC5025	B254
TPGT110204HP KC5410	B254
TPGT110204HP KCU25	B254
TPGT110204LF KC5010	B254
TPGT110204LF KC5025	B254
TPGT110204LF KC5410	B254
TPGT110204LF KCU10	B254
TPGT110208HP KC5010	B254
TPGT110208HP KC5410	B254
TPGT110208LF KC5010	B254
TPGT110208LF KCU10	B254
TPGT16T302HP KC5010	B254
TPGT16T302HP KCU10	B254
TPGT16T304HP KC5010	B254
TPGT16T304HP KC5025	B254
TPGT16T304HP KC5410	B254
TPGT16T304HP KCU10	B254
TPGT16T304HP KCU25	B254
TPGT16T304LF KC5010	B254
TPGT16T304LF KC5025	B254
TPGT16T308HP KC5010	B254
TPGT16T308HP KC5410	B254
TPGT16T308HP KCU10	B254
TPGT16T308HP KCU25	B254
TPGT16T308LF KC5010	B254
TPGT16T308LF KC5410	B254
TPGT16T308LF KCU10	B254
TPGW110202S01015MT KBH20	B321
TPGW110204EC KB1345	B291
TPGW110204FST KD1400	B349
TPGW110204FST KD1425	B349
TPGW110204S01015MT KBH20	B321
TPGW110208FST KD1400	B349
TPGW110208S01015C KB5630	B291, B321
TPGW110208S01015MT KBH20	B321
TPGW110304S01015MT KBH10	B321
TPGW110304S01225MT KBH10	B321
TPGW110308S01225MT KBH10	B321
TPGW160404S01015MT KBH10	B321
TPGW160404S01225MT KBH10	B321
TPGW160408S01015MT KBH10	B321
TPGW160408S01225MT KBH10	B321
TPGW16T304FST KD1425	B349
TPGW16T304S01015MT KBH20	B321
TPGW16T308FST KD1400	B349
TPGW16T308FST KD1425	B349
TPGW16T308S01015MT KBH20	B321
TPGW16T308S01225MT KBH20	B321
TPGX0902ZPRGD KC7015	H63
TPGX0902ZPRGD KC7140	H63
TPGX0902ZPRGD KC7315	H63
TPGX1102ZPRGD KC7015	H63
TPGX1102ZPRGD KC7140	H63
TPGX1102ZPRGD KC7315	H63
TPGX1303ZPRGD KC7015	H63
TPGX1303ZPRGD KC7140	H63
TPGX1303ZPRGD KC7315	H63
TPGX1603ZPRGD KC7015	H63
TPGX1603ZPRGD KC7140	H63
TPGX1603ZPRGD KC7315	H63
TPMR110304 KCK15B	B171
TPMR110304 KCP25B	B171
TPMR110308 KCP25B	B171
TPMR160304 KCK15B	B171
TPMR160304 KCP25B	B171
TPMR160308 KCK15B	B171
TPMR160308 KCP25B	B171
TPMR220408 KCP25B	B171
TPMT090202LF KC5010	B255
TPMT090204FP KCU10	B254
TPMT090204LF KC5010	B255
TPMT090204LF KC5025	B255
TPMT090204LF KCK05	B255
TPMT090204LF KCK15	B255
TPMT090204LF KCM15B	B255
TPMT090204LF KCP10B	B255
TPMT090204LF KCP25	B255
TPMT090204LF KCP25B	B255
TPMT090204LF KT315	B255
TPMT090208FP KCP25	B254
TPMT090208FP KCU10	B254
TPMT090208FP KCU25	B254
TPMT110202FP KCU10	B254
TPMT110202LF KC5010	B255
TPMT110202UF KCP05	B256
TPMT110204FP KCP10	B254
TPMT110204FP KCP25	B254
TPMT110204FP KCU10	B254
TPMT110204FP KCU25	B254
TPMT110204LF K313	B255
TPMT110204LF KC5010	B255
TPMT110204LF KC5025	B255
TPMT110204LF KCK15B	B255
TPMT110204LF KCK20	B255
TPMT110204LF KCM15	B255
TPMT110204LF KCM25B	B255
TPMT110204LF KCP10	B255
TPMT110204LF KCP10B	B255
TPMT110204LF KCP25	B255
TPMT110204LF KCP25B	B255
TPMT110204LF KT315	B255
TPMT110204UF KC5010	B256
TPMT110204UF KCP05	B256
TPMT110208FP KCU10	B254
TPMT110208LF KC5010	B255
TPMT110208LF KC5025	B255
TPMT110208LF KCM25	B255
TPMT110208LF KCP10B	B255
TPMT110208LF KCP25	B255
TPMT110208LF KCP25B	B255
TPMT110208LF KT315	B255
TPMT110208MF KCK15	B255
TPMT110208MF KCK20	B255
TPMT110208MF KCM25	B255
TPMT110208MF KCP25	B255
TPMT110208MF KCP25B	B255
TPMT110208MP KCP25	B255
TPMT110304FP KCP10B	B254
TPMT110304FP KCU10	B254
TPMT110304FP KCU25	B254
TPMT110308FP KCU10	B254
TPMT16T304FP KCK20	B254
TPMT16T304FP KCM25	B254
TPMT16T304FP KCP10	B254
TPMT16T304FP KCP25	B254
TPMT16T304FP KCU10	B254
TPMT16T304FP KCU25	B254
TPMT16T304LF KC5010	B255
TPMT16T304LF KC5025	B255
TPMT16T304LF KCK05	B255
TPMT16T304LF KCK15	B255
TPMT16T304LF KCM15	B255
TPMT16T304LF KCM25B	B255
TPMT16T304LF KCP10	B255
TPMT16T304LF KCP10B	B255
TPMT16T304LF KCP25	B255
TPMT16T304LF KCP25B	B255
TPMT16T304LF KT315	B255
TPMT16T308FP KCP10	B254
TPMT16T308FP KCP25	B254
TPMT16T308FP KCU25	B254
TPMT16T308LF KC5010	B255
TPMT16T308LF KC5025	B255
TPMT16T308LF KCK05	B255
TPMT16T308LF KCK15	B255
TPMT16T308LF KCK15B	B255
TPMT16T308LF KCK20	B255
TPMT16T308LF KCK20B	B255
TPMT16T308LF KCM25	B255
TPMT16T308LF KCP10B	B255
TPMT16T308LF KCP25	B255
TPMT16T308LF KCP25B	B255
TPMT16T308LF KT315	B255
TPMT16T308MF KCK15	B255
TPMT16T308MF KCK20	B255
TPMT16T308MF KCM15	B255
TPMT16T308MF KCM25B	B255
TPMT16T308MF KCP10	B255
TPMT16T308MF KCP25	B255
TPMT16T308MF KCP30	B255
TPMT16T308MP KCK20B	B255
TPMT16T308MP KCP25	B255
TPMT16T308UF KCP10	B256
TPMT16T312MF KCK15	B255
TPMT16T312MF KCK20	B255
TPMT16T312MF KCK20B	B255
TPMT16T312MF KCP25	B255
TPMT16T312MP KCP25	B255
TPMT220408LF KC5010	B255
TPMT220408LF KC5025	B255
TPMT220408LF KCK20	B255
TPUN110304 K68	B171
TPUN110304 KCK15B	B171
TPUN110304T00520 KY1615	B321
TPUN110308 K68	B171
TPUN110308 KCK15B	B171
TPUN110308T00520 KY1615	B321
TPUN160304 K68	B171
TPUN160304 KCK15B	B171
TPUN160304 KCP25B	B171
TPUN160304T00520 KY1615	B321
TPUN160308 K68	B171
TPUN160308 KCK15B	B171
TPUN160308 KCP25B	B171
TPUN160308T00520 KY1615	B321
TPUN160312T00520 KY1615	B321
TPUN220408 K68	B171
TPUN220408 KCK15B	B171
TPUN220408 KCP25B	B171
TPUN220412 K68	B171
TPUN220412 KCK15B	B171
TPUN220412 KCP25B	B171
TRAOL2525M06	E65
TRAOR2525M04	E65
TRAOR2525M06	E65
TRAOR3225P06	E65
TRM50L0432M	E65
TRM50L0620M	E65
TRM50L0632M	E65
TRM50L0640M	E65
TRM50L0920M	E65
TRM50L0932M	E65
TRM50L0950M	E65
TRM50R0432M	E65
TRM50R0620M	E65
TRM50R0632M	E65
TRM50R0640M	E65
TRM50R0720M	E65
TRM50R0920M	E65
TRM50R0932M	E65
TRM50R0940M	E65
TRM50R0950M	E65
TT15	K38–39, T109
TT25	K38–39, V82, W40–43
TT30	K38–39, W41
TTP15	S46–48, U40–49
TTP20	S53, V153–154
TTP25	S25
TTP9	U27–35
TWDL10TM	058
TWDL12TM	058
TWDL16TM	058
TWDL20TM	058
TWDL25TM	058
TWDL32TM	058
TWDLTM	058
TWTMBC	058
TWTMEXT	058
TWTMINSERTDL10	058
TWTMINSERTDL10W	058
TWTMINSERTDL12	058
TWTMINSERTDL12W	058
TWTMINSERTDL16	058
TWTMINSERTDL20	058
TWTMINSERTDL25	058
TWTMINSERTDL32	058
UADE0400A4BV KCPM15	P17
UADE0400B4BV KCPM15	P17
UADE0500A4BV KCPM15	P17
UADE0500B4BV KCPM15	P17
UADE0600A4AL KCPM15	P20
UADE0600A4BV KCPM15	P17
UADE0600B4AL KCPM15	P20
UADE0600B4BV KCPM15	P17
UADE0800A4AL KCPM15	P20
UADE0800A4BV KCPM15	P17
UADE0800B4AL KCPM15	P20
UADE0800B4BV KCPM15	P17
UADE1000A4AL KCPM15	P20
UADE1000A4BV KCPM15	P17
UADE1000B4AL KCPM15	P20
UADE1000B4BV KCPM15	P17
UADE1200A4AL KCPM15	P20
UADE1200A4BV KCPM15	P17
UADE1200B4AL KCPM15	P20
UADE1200B4BV KCPM15	P17
UADE1400A4BV KCPM15	P17
UADE1400B4BV KCPM15	P17
UADE1600A4AL KCPM15	P20
UADE1600A4BV KCPM15	P17
UADE1600B4AL KCPM15	P20
UADE1600B4BV KCPM15	P17
UADE2000A4AL KCPM15	P20
UADE2000A4BV KCPM15	P17
UADE2000B4AL KCPM15	P20
UADE2000B4BV KCPM15	P17
UADE2500A4BV KCPM15	P17
UADE2500B4BV KCPM15	P17
UBDE1200E4AQE KCSM15	P18
UBDE1200E4AQG KCSM15	P18

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
UBDE1200E4AQK KCSM15	P18
UBDE1200E4AQM KCSM15	P18
UBDE1200E4AQN KCSM15	P18
UBDE1600E4AQE KCSM15	P18
UBDE1600E4AQG KCSM15	P18
UBDE1600E4AQK KCSM15	P18
UBDE1600E4AQM KCSM15	P18
UBDE1600E4AQN KCSM15	P18
UBDE1600E4AQP KCSM15	P18
UBDE2000E4AQE KCSM15	P18
UBDE2000E4AQG KCSM15	P18
UBDE2000E4AQK KCSM15	P18
UBDE2000E4AQM KCSM15	P18
UBDE2000E4AQN KCSM15	P18
UBDE2000E4AQP KCSM15	P18
UBDE2500E4AQE KCSM15	P18
UBDE2500E4AQG KCSM15	P18
UBDE2500E4AQK KCSM15	P18
UBDE2500E4AQM KCSM15	P18
UBDE2500E4AQN KCSM15	P18
UBDE2500E4AQP KCSM15	P18
UCDE0400A5ARA KC643M	P30
UCDE0400A5ARA KCPM15	P30
UCDE0400A5ASA KC643M	P30
UCDE0400A5ASA KCPM15	P30
UCDE0400B5ARA KC643M	P30
UCDE0400B5ARA KCPM15	P30
UCDE0500A5ARA KC643M	P30
UCDE0500A5ARA KCPM15	P30
UCDE0500A5ASA KC643M	P30
UCDE0500A5ASA KCPM15	P30
UCDE0500B5ARA KC643M	P30
UCDE0500B5ARA KCPM15	P30
UCDE0600A5ARA KC643M	P30
UCDE0600A5ARA KCPM15	P30
UCDE0600A5ASA KC643M	P30
UCDE0600A5ASA KCPM15	P30
UCDE0600B5ARA KC643M	P30
UCDE0600B5ARA KCPM15	P30
UCDE0700A5ARA KC643M	P30
UCDE0700A5ARA KCPM15	P30
UCDE0700A5ASA KC643M	P30
UCDE0700A5ASA KCPM15	P30
UCDE0700B5ARA KC643M	P30
UCDE0700B5ARA KCPM15	P30
UCDE0800A5ARA KC643M	P30
UCDE0800A5ARA KCPM15	P30
UCDE0800A5ASA KC643M	P30
UCDE0800A5ASA KCPM15	P30
UCDE0800B5ARA KC643M	P30
UCDE0800B5ARA KCPM15	P30
UCDE0900A5ARA KC643M	P30
UCDE0900A5ARA KCPM15	P30
UCDE0900A5ASA KC643M	P30
UCDE0900A5ASA KCPM15	P30
UCDE0900B5ARA KC643M	P30
UCDE0900B5ARA KCPM15	P30
UCDE1000A5ARA KC643M	P30
UCDE1000A5ARA KCPM15	P30
UCDE1000A5ASA KC643M	P30
UCDE1000A5ASA KCPM15	P30
UCDE1000B5ARA KC643M	P30
UCDE1000B5ARA KCPM15	P30
UCDE1200A5ARA KC643M	P30
UCDE1200A5ARA KCPM15	P30
UCDE1200A5ASA KC643M	P30
UCDE1200A5ASA KCPM15	P30
UCDE1200B5ARA KC643M	P30
UCDE1200B5ARA KCPM15	P30
UCDE1400A5ARA KC643M	P30
UCDE1400A5ARA KCPM15	P30
UCDE1400A5ASA KC643M	P30
UCDE1400A5ASA KCPM15	P30
UCDE1400B5ARA KC643M	P30
UCDE1400B5ARA KCPM15	P30
UCDE1600A5ARA KC643M	P30
UCDE1600A5ARA KCPM15	P30
UCDE1600A5ASA KC643M	P30
UCDE1600A5ASA KCPM15	P30
UCDE1600B5ARA KC643M	P30
UCDE1600B5ARA KCPM15	P30
UCDE1800A5ARA KC643M	P30

Catalogue No.	Page(s)
UCDE1800A5ARA KCPM15	P30
UCDE1800A5ASA KC643M	P30
UCDE1800A5ASA KCPM15	P30
UCDE1800B5ARA KC643M	P30
UCDE1800B5ARA KCPM15	P30
UCDE2000A5ARA KC643M	P30
UCDE2000A5ARA KCPM15	P30
UCDE2000A5ASA KC643M	P30
UCDE2000A5ASA KCPM15	P30
UCDE2000B5ARA KC643M	P30
UCDE2000B5ARA KCPM15	P30
UCDE2500A5ARA KC643M	P30
UCDE2500A5ARA KCPM15	P30
UCDE2500A5ASA KC643M	P30
UCDE2500A5ASA KCPM15	P30
UCDE2500B5ARA KC643M	P30
UCDE2500B5ARA KCPM15	P30
UCDV1000X5CV KCPM15	012
UCDV1200X5CV KCPM15	012
UCDV1600X5CV KCPM15	012
UCDV2000X5CV KCPM15	012
UCDV2500X5CV KCPM15	012
UCDV3200X5CV KCPM15	012
UDDE0600A5ARA KC643M	P31
UDDE0600A5ARB KC643M	P31
UDDE0600A5ARC KC643M	P31
UDDE0600A5ASA KC643M	P31
UDDE0600B5ARA KC643M	P31
UDDE0600B5ARB KC643M	P31
UDDE0600B5ARC KC643M	P31
UDDE0600B5ARD KC643M	P31
UDDE0800A5ARA KC643M	P31
UDDE0800A5ARB KC643M	P31
UDDE0800A5ARC KC643M	P31
UDDE0800A5ASA KC643M	P31
UDDE0800B5ARA KC643M	P31
UDDE0800B5ARB KC643M	P31
UDDE0800B5ARC KC643M	P31
UDDE0800B5ARD KC643M	P31
UDDE1000A5ARA KC643M	P31
UDDE1000A5ARB KC643M	P31
UDDE1000A5ARC KC643M	P31
UDDE1000A5ARD KC643M	P31
UDDE1000A5ASA KC643M	P31
UDDE1000B5ARA KC643M	P31
UDDE1000B5ARB KC643M	P31
UDDE1000B5ARC KC643M	P31
UDDE1000B5ARD KC643M	P31
UDDE1200A5ARA KC643M	P31
UDDE1200A5ARB KC643M	P31
UDDE1200A5ARC KC643M	P31
UDDE1200A5ARD KC643M	P31
UDDE1200A5ASA KC643M	P31
UDDE1200B5ARA KC643M	P31
UDDE1200B5ARB KC643M	P31
UDDE1200B5ARC KC643M	P31
UDDE1200B5ARD KC643M	P31
UDDE1200E5AQE KCSM15	P31
UDDE1200E5AQG KCSM15	P31
UDDE1200E5AQK KCSM15	P31
UDDE1200E5AQM KCSM15	P31
UDDE1400A5ARA KC643M	P31
UDDE1400A5ARC KC643M	P31
UDDE1400A5ARD KC643M	P31
UDDE1400A5ASA KC643M	P31
UDDE1400B5ARB KC643M	P31
UDDE1600A5ARA KC643M	P31
UDDE1600A5ARB KC643M	P31
UDDE1600A5ARC KC643M	P31
UDDE1600A5ARD KC643M	P32
UDDE1600A5ARE KC643M	P32
UDDE1600A5ARP KC643M	P32
UDDE1600A5ASA KC643M	P32
UDDE1600B5ARA KC643M	P31
UDDE1600B5ARB KC643M	P31
UDDE1600B5ARC KC643M	P31
UDDE1600B5ARD KC643M	P32
UDDE1600B5ARE KC643M	P32
UDDE1600B5ARP KC643M	P32
UDDE1600E5AQE KCSM15	P31
UDDE1600E5AQG KCSM15	P31
UDDE1600E5AQK KCSM15	P31

Catalogue No.	Page(s)
UDDE1600E5AQM KCSM15	P32
UDDE1600E5AQN KCSM15	P32
UDDE1600E5AQP KCSM15	P32
UDDE2000A5ARA KC643M	P32
UDDE2000A5ARB KC643M	P32
UDDE2000A5ARC KC643M	P32
UDDE2000A5ARD KC643M	P32
UDDE2000A5ARE KC643M	P32
UDDE2000A5ARP KC643M	P32
UDDE2000A5ASA KC643M	P32
UDDE2000B5ARA KC643M	P32
UDDE2000B5ARB KC643M	P32
UDDE2000B5ARC KC643M	P32
UDDE2000B5ARD KC643M	P32
UDDE2000B5ARE KC643M	P32
UDDE2000B5ARP KC643M	P32
UDDE2000E5AQE KCSM15	P32
UDDE2000E5AQG KCSM15	P32
UDDE2000E5AQK KCSM15	P32
UDDE2000E5AQM KCSM15	P32
UDDE2000E5AQN KCSM15	P32
UDDE2000E5AQP KCSM15	P32
UDDE2500A5ARA KC643M	P32
UDDE2500A5ARB KC643M	P32
UDDE2500A5ARC KC643M	P32
UDDE2500A5ARD KC643M	P32
UDDE2500A5ARE KC643M	P32
UDDE2500A5ARP KC643M	P32
UDDE2500A5ASA KC643M	P32
UDDE2500B5ARA KC643M	P32
UDDE2500B5ARB KC643M	P32
UDDE2500B5ARC KC643M	P32
UDDE2500B5ARD KC643M	P32
UDDE2500B5ARE KC643M	P32
UDDE2500B5ARP KC643M	P32
UDDE2500E5AQE KCSM15	P32
UDDE2500E5AQG KCSM15	P32
UDDE2500E5AQK KCSM15	P32
UDDE2500E5AQM KCSM15	P32
UDDE2500E5AQN KCSM15	P32
UDDE2500E5AQP KCSM15	P32
UDDV1000X5CQE KC643M	013
UDDV1000X5CQG KC643M	013
UDDV1000X5CQJ KC643M	013
UDDV1200X5CQE KC643M	013
UDDV1200X5CQG KC643M	013
UDDV1200X5CQJ KC643M	013
UDDV1200X5CQL KC643M	013
UDDV1600X5CQG KC643M	013
UDDV1600X5CQJ KC643M	013
UDDV1600X5CQK KC643M	013
UDDV1600X5CQL KC643M	013
UDDV1600X5CQM KC643M	013
UDDV2000X5CQG KC643M	013
UDDV2000X5CQK KC643M	013
UDDV2000X5CQL KC643M	013
UDDV2000X5CQM KC643M	013
UDDV2000X5CQN KC643M	013
UDDV2500X5CQL KC643M	013
UDDV2500X5CQN KC643M	013
UDDV3200X5CQL KC643M	013
UDDV3200X5CQN KC643M	013
UEBC0200A2A KC643M	P194
UEBC0300A2A KC643M	P194
UEBC0400A2A KC643M	P194
UEBC0500A2A KC643M	P194
UEBC0600A2A KC643M	P194
UEBC0800A2A KC643M	P194
UEBC1000A2A KC643M	P194
UEBC1200A2A KC643M	P194
UEBE0200A3A KC643M	P195
UEBE0300A3A KC643M	P195
UEBE0400A3A KC643M	P195
UEBE0500A3A KC643M	P195
UEBE0600A3A KC643M	P195
UEBE0800A3A KC643M	P195
UEBE1000A3A KC643M	P195
UEBE1200A3A KC643M	P195
UEDE0200A3AS KC643M	P192
UEDE0200B3AS KC643M	P192
UEDE0300A3AS KC643M	P192
UEDE0300B3AS KC643M	P192

Catalogue No.	Page(s)
UEDE0400A3AS KC643M	P192
UEDE0400A4AH KC643M	P193
UEDE0400B3AS KC643M	P192
UEDE0400B4AH KC643M	P193
UEDE0500A3AS KC643M	P192
UEDE0500B3AS KC643M	P192
UEDE0600A3AS KC643M	P192
UEDE0600A4AH KC643M	P193
UEDE0600B3AS KC643M	P192
UEDE0600B4AH KC643M	P193
UEDE0800A3AS KC643M	P192
UEDE0800A4AH KC643M	P193
UEDE0800B3AS KC643M	P192
UEDE0800B4AH KC643M	P193
UEDE1000A3AS KC643M	P192
UEDE1000A4AH KC643M	P193
UEDE1000B3AS KC643M	P192
UEDE1000B4AH KC643M	P193
UEDE1200A3AS KC643M	P192
UEDE1200A4AH KC643M	P193
UEDE1200B3AS KC643M	P192
UEDE1200B4AH KC643M	P193
UGDE0600A5ARA KC643M	P36
UGDE0600A5ARB KC643M	P36
UGDE0600A5ARC KC643M	P36
UGDE0600A5BRA KC643M	P37
UGDE0600A5BRB KC643M	P37
UGDE0600A5BRC KC643M	P37
UGDE0800A5ARA KC643M	P36
UGDE0800A5ARB KC643M	P36
UGDE0800A5ARC KC643M	P36
UGDE0800A5BRA KC643M	P37
UGDE0800A5BRB KC643M	P37
UGDE0800A5BRC KC643M	P37
UGDE1000A5ARA KC643M	P36
UGDE1000A5ARB KC643M	P36
UGDE1000A5ARC KC643M	P36
UGDE1000A5ARD KC643M	P36
UGDE1000A5BRA KC643M	P37
UGDE1000A5BRB KC643M	P37
UGDE1000A5BRC KC643M	P37
UGDE1000A5BRD KC643M	P37
UGDE1200A5ARA KC643M	P36
UGDE1200A5ARB KC643M	P36
UGDE1200A5ARC KC643M	P36
UGDE1200A5ARD KC643M	P36
UGDE1200A5BRA KC643M	P37
UGDE1200A5BRB KC643M	P37
UGDE1200A5BRC KC643M	P37
UGDE1200A5BRD KC643M	P37
UGDE1400A5ARD KC643M	P36
UGDE1400A5BRD KC643M	P37
UGDE1600A5ARA KC643M	P36
UGDE1600A5ARB KC643M	P36
UGDE1600A5ARC KC643M	P36
UGDE1600A5ARD KC643M	P36
UGDE1600A5ARE KC643M	P36
UGDE1600A5ARP KC643M	P36
UGDE1600A5BRA KC643M	P37
UGDE1600A5BRB KC643M	P37
UGDE1600A5BRC KC643M	P37
UGDE1600A5BRD KC643M	P37
UGDE1600A5BRE KC643M	P37
UGDE1600A5BRP KC643M	P37
UGDE2000A5ARA KC643M	P36
UGDE2000A5ARB KC643M	P36
UGDE2000A5ARC KC643M	P36
UGDE2000A5ARD KC643M	P36
UGDE2000A5ARE KC643M	P36
UGDE2000A5ARP KC643M	P36
UGDE2000A5BRA KC643M	P37
UGDE2000A5BRB KC643M	P37
UGDE2000A5BRC KC643M	P37
UGDE2000A5BRD KC643M	P37
UGDE2000A5BRE KC643M	P37
UGDE2000A5BRP KC643M	P37
UGDE2500A5ARA KC643M	P36
UGDE2500A5ARB KC643M	P36
UGDE2500A5ARC KC643M	P36
UGDE2500A5ARD KC643M	P36
UGDE2500A5ARE KC643M	P36
UGDE2500A5ARP KC643M	P36

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
UGDE2500A5BRA KC643M	P37
UGDE2500A5BRB KC643M	P37
UGDE2500A5BRC KC643M	P37
UGDE2500A5BRD KC643M	P37
UGDE2500A5BRE KC643M	P37
UGDE2500A5BRP KC643M	P37
UJBE0400A6BP KCSM15	P62
UJBE0400A6CP KCSM15	P62
UJBE0500A6BP KCSM15	P62
UJBE0500A6CP KCSM15	P62
UJBE0600A6BP KCSM15	P62
UJBE0600A6CP KCSM15	P62
UJBE0700A6BP KCSM15	P62
UJBE0700A6CP KCSM15	P62
UJBE0800A6BP KCSM15	P62
UJBE0800A6CP KCSM15	P62
UJBE1000A6AL KCSM15	P54
UJBE1000A6AN KCSM15	P54
UJBE1000A6BP KCSM15	P62
UJBE1000A6CP KCSM15	P62
UJBE1200A6AL KCSM15	P54
UJBE1200A6AN KCSM15	P54
UJBE1600A6AL KCSM15	P54
UJBE1600A6AN KCSM15	P54
UJBE2000A6AL KCSM15	P54
UJBE2000A6AN KCSM15	P54
UJBV1000X6CN KCSM15	019
UJBV1200X6CN KCSM15	019
UJBV1600X6CN KCSM15	019
UJBV2000X6CN KCSM15	019
UJBV2500X6CN KCSM15	019
UJDE1000A6ANS KCSM15	P49
UJDE1000A6AQE KCSM15	P49
UJDE1000A6AQG KCSM15	P49
UJDE1000A6AQK KCSM15	P49
UJDE1000A6AQM KCSM15	P49
UJDE1000A6ARE KCSM15	P48
UJDE1000A6AS KCSM15	P48
UJDE1200A6ANS KCSM15	P49
UJDE1200A6AQE KCSM15	P49
UJDE1200A6AQG KCSM15	P49
UJDE1200A6AQK KCSM15	P49
UJDE1200A6AQM KCSM15	P49
UJDE1200A6ARF KCSM15	P48
UJDE1200A6AS KCSM15	P48
UJDE1200E6AQE KCSM15	P49
UJDE1200E6AQG KCSM15	P49
UJDE1200E6AQK KCSM15	P49
UJDE1200E6AQM KCSM15	P49
UJDE1200E6ARF KCSM15	P48
UJDE1400A6ARF KCSM15	P48
UJDE1400A6AS KCSM15	P48
UJDE1400E6ARF KCSM15	P48
UJDE1600A6ANS KCSM15	P49
UJDE1600A6AQE KCSM15	P49
UJDE1600A6AQG KCSM15	P49
UJDE1600A6AQK KCSM15	P49
UJDE1600A6AQM KCSM15	P49
UJDE1600A6AQN KCSM15	P49
UJDE1600A6AQP KCSM15	P49
UJDE1600A6ARF KCSM15	P48
UJDE1600A6AS KCSM15	P48
UJDE1600E6AQE KCSM15	P49
UJDE1600E6AQG KCSM15	P49
UJDE1600E6AQK KCSM15	P49
UJDE1600E6AQM KCSM15	P49
UJDE1600E6AQN KCSM15	P49
UJDE1600E6ARF KCSM15	P48
UJDE2000A6ANS KCSM15	P49
UJDE2000A6AQE KCSM15	P49
UJDE2000A6AQG KCSM15	P49
UJDE2000A6AQK KCSM15	P49
UJDE2000A6AQM KCSM15	P49
UJDE2000A6AQN KCSM15	P49
UJDE2000A6AQP KCSM15	P49
UJDE2000A6ARF KCSM15	P48
UJDE2000A6AS KCSM15	P48
UJDE2000E6AQE KCSM15	P49
UJDE2000E6AQG KCSM15	P49
UJDE2000E6AQK KCSM15	P49
UJDE2000E6AQM KCSM15	P49
UJDE2000E6AQN KCSM15	P49
UJDE2000E6ARF KCSM15	P48
UJDE2500A6AQE KCSM15	P49
UJDE2500A6AQG KCSM15	P49
UJDE2500A6AQK KCSM15	P49
UJDE2500A6AQM KCSM15	P49
UJDE2500A6AQN KCSM15	P49
UJDE2500A6AQP KCSM15	P49
UJDE2500A6ARF KCSM15	P48
UJDE2500A6AS KCSM15	P48
UJDE2500E6AQE KCSM15	P49
UJDE2500E6AQG KCSM15	P49
UJDE2500E6AQK KCSM15	P49
UJDE2500E6AQM KCSM15	P49
UJDE2500E6AQN KCSM15	P49
UJDE2500E6ARF KCSM15	P48
UJDV1000X6CQE KCSM15	016
UJDV1000X6CQG KCSM15	016
UJDV1000X6CQJ KCSM15	016
UJDV1200X6CQE KCSM15	016
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ULDV2000X4CQM KCSM15	09
ULDV2000X4CQN KCSM15	09
ULDV2500X4CQL KCSM15	09
ULDV2500X4CQN KCSM15	09
ULDV3200X4CQL KCSM15	09
ULDV3200X4CQN KCSM15	09
VBGT110301LF KC5010	B264
VBGT110301LF KC5025	B264
VBGT110301LF KC5410	B264
VBGT110301LF KCU10	B264
VBGT110302HP KC5010	B264
VBGT110302HP KC5025	B264
VBGT110302HP KC5410	B264
VBGT110302HP KCU10	B264
VBGT110302LF K68	B264
VBGT110302LF KC5010	B264
VBGT110302LF KC5025	B264
VBGT110302LF KCU10	B264
VBGT110304HP KC5010	B264
VBGT110304HP KC5025	B264
VBGT110304HP KC5410	B264
VBGT110304HP KCU10	B264
VBGT110304HP KCU25	B264
VBGT110304LF K313	B264
VBGT110304LF KC5010	B264
VBGT110304LF KC5025	B264
VBGT110304LF KCU10	B264
VBGT1103X0LF KC5025	B264
VBGT160401LF KC5010	B264
VBGT160401LF KC5025	B264
VBGT160401LF KCU10	B264
VBGT160402LF K313	B264
VBGT160402LF KC5010	B264
VBGT160402LF KC5025	B264
VBGT160402LF KC5410	B264
VBGT160402LF KCU10	B264
VBGT160404HP K313	B264
VBGT160404HP K68	B264
VBGT160404HP KC5010	B264
VBGT160404HP KC5025	B264
VBGT160404HP KC5410	B264
VBGT160404HP KCU10	B264
VBGT160404HP KCU25	B264
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VBGT160404LF KC5410	B264
VBGT160404LF KCU10	B264
VBGT160408HP K313	B264
VBGT160408HP KC5010	B264
VBGT160408HP KC5025	B264
VBGT160408HP KC5410	B264
VBGT160408HP KCU10	B264
VBGT160408HP KCU25	B264
VBGT1604X0LF KC5025	B264
VBGW110304FST KD1400	B350
VBGW110304FST KD1425	B350
VBGW110304S01015MT KBH10	B322
VBGW110304S01015MT KBH20	B322
VBGW110304S01225MT KBH20	B322
VBGW110308S01015MT KBH10	B322
VBGW110308S01225MT KBH20	B322
VBGW160404FST KD1400	B350
VBGW160404FST KD1425	B350
VBGW160404S01015MT KB5630	B292, B322
VBGW160404S01015MT KBH10	B322
VBGW160408E KD1405	B349
VBGW160408S01015MT KB5630	B292, B322
VBGW160408S01015MT KBH10	B322
VBGW160408S01015MT KBH20	B322
VBGW160412S01015MT KBH20	B322
VBMR110302FP KCP25	E32
VBMR110304 KC5010	E32
VBMR110304 KC5025	E32
VBMR110304 KT315	E32
VBMR110304FP KCP10	E32
VBMR110304FP KCP25	E32
VBMR110304FP KCU25	E32
VBMR110308FP KCP10	E32
VBMR110308FP KCU10	E32
VBMT11030211 KT315	B264
VBMT110302FP KCP25	B265
VBMT110302FP KCU10	B265
VBMT110302LF KC5010	B265
VBMT110302LF KT315	B265
VBMT11030411 KT315	B264
VBMT110304FP KCM15	B265
VBMT110304FP KCM25	B265
VBMT110304FP KCP10	B265
VBMT110304FP KCP25	B265
VBMT110304FP KCU10	B265
VBMT110304FP KCU25	B265
VBMT110304FP KTP10	B265
VBMT110304LF K313	B265
VBMT110304LF KC5010	B265
VBMT110304LF KC5025	B265
VBMT110304LF KCK05	B265
VBMT110304LF KCM15	B265
VBMT110304LF KCM25B	B265
VBMT110304LF KCP05	B265
VBMT110304LF KCP10B	B265
VBMT110304LF KCP25	B265
VBMT110304LF KCP25B	B265
VBMT110304LF KCP30	B265
VBMT110304LF KT315	B265
VBMT110308FP KCM15	B265
VBMT110308FP KCP25	B265
VBMT110308FP KCU10	B265
VBMT110308FP KCU25	B265
VBMT110308LF KC5010	B265
VBMT110308LF KC5025	B265
VBMT110308LF KCK05	B265
VBMT110308LF KCK20B	B265
VBMT110308LF KCM25	B265
VBMT110308LF KCP05	B265
VBMT110308LF KCP10	B265
VBMT110308LF KCP25	B265
VBMT110308LF KCP25B	B265
VBMT160402FP KCM25	B265
VBMT160402FP KCP25	B265
VBMT160402FP KCU10	B265
VBMT160402FP KCU25	B265
VBMT160402FP KTP10	B265
VBMT160402LF K313	B265
VBMT160402LF KC5010	B265
VBMT160402LF KC5025	B265
VBMT160402LF KT315	B265
VBMT16040411 KT315	B264
VBMT160404FP KCK20B	B265
VBMT160404FP KCM15	B265
VBMT160404FP KCM25	B265
VBMT160404FP KCP05	B265
VBMT160404FP KCP10	B265
VBMT160404FP KCP10B	B265
VBMT160404FP KCP25	B265
VBMT160404FP KCP25B	B265
VBMT160404FP KCU10	B265
VBMT160404FP KCU25	B265
VBMT160404FP KTP10	B265
VBMT160404LF K313	B265
VBMT160404LF KC5010	B265
VBMT160404LF KC5025	B265
VBMT160404LF KCK15	B265
VBMT160404LF KCK15B	B265
VBMT160404LF KCK20B	B265
VBMT160404LF KCM15	B265
VBMT160404LF KCM15B	B265
VBMT160404LF KCM25	B265
VBMT160404LF KCM25B	B265
VBMT160404LF KCM35	B265
VBMT160404LF KCP10	B265
VBMT160404LF KCP10B	B265
VBMT160404LF KCP25	B265
VBMT160404LF KCP25B	B265
VBMT160404LF KCP30	B265
VBMT160404LF KT315	B265
VBMT160404MP KCM25	B265
VBMT160404MP KCM25B	B265
VBMT160404MP KCP25	B265
VBMT160404MP KCP25B	B265
VBMT16040811 KT315	B264
VBMT160408FP KCK20	B265
VBMT160408FP KCK20B	B265
VBMT160408FP KCM15	B265
VBMT160408FP KCM25	B265
VBMT160408FP KCP05	B265
VBMT160408FP KCP10	B265
VBMT160408FP KCP10B	B265
VBMT160408FP KCP25	B265
VBMT160408FP KCP25B	B265
VBMT160408FP KCU10	B265
VBMT160408FP KCU25	B265
VBMT160408FP KTP10	B265
VBMT160408LF K313	B265
VBMT160408LF KC5010	B265
VBMT160408LF KC5025	B265
VBMT160408LF KCK05	B265
VBMT160408LF KCK15	B265
VBMT160408LF KCK15B	B265
VBMT160408LF KCK20	B265
VBMT160408LF KCM15	B265
VBMT160408LF KCM15B	B265
VBMT160408LF KCM25	B265
VBMT160408LF KCM25B	B265
VBMT160408LF KCM35	B265

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
VBMT160408LF KCP05	B265
VBMT160408LF KCP10	B265
VBMT160408LF KCP10B	B265
VBMT160408LF KCP25	B265
VBMT160408LF KCP25B	B265
VBMT160408LF KCP30	B265
VBMT160408LF KT315	B265
VBMT160408MP KCK20	B265
VBMT160408MP KCK20B	B265
VBMT160408MP KCM25	B265
VBMT160408MP KCM25B	B265
VBMT160408MP KCP25	B265
VBMT160408MP KCP25B	B265
VBMT160412FP KCP10B	B265
VBMT160412FP KCP25	B265
VBMT160412FP KCP25B	B265
VBMT160412LF KCK05	B265
VBMT160412LF KCK20	B265
VBMT160412LF KCK20B	B265
VBMT160412LF KCP25	B265
VCGN160404 KD1425	B351, E34
VCGN160408 KD1425	B351, E34
VCGR160402 K68	E34
VCGR160402 KC5010	E34
VCGR160402 KC5025	E34
VCGR160402 KC5410	E34
VCGR160402 KCU10	E34
VCGR160402 KCU25	E34
VCGR160402FP KCP10	E35
VCGR160404 K313	E34
VCGR160404 K68	E34
VCGR160404 KC5010	E34
VCGR160404 KC5025	E34
VCGR160404 KC5410	E34
VCGR160404 KCP25	E34
VCGR160404 KCU10	E34
VCGR160404 KCU25	E34
VCGR160404 KD1425	B351, E34
VCGR160404 KT315	E34
VCGR160404FP KCM25	E35
VCGR160404FP KCP10	E35
VCGR160404FP KCP25	E35
VCGR160404FP KCU10	E35
VCGR160404HP K313	E35
VCGR160408 K313	E34
VCGR160408 K68	E34
VCGR160408 KC5010	E34
VCGR160408 KC5025	E34
VCGR160408 KC5410	E34
VCGR160408 KCP25B	E34
VCGR160408 KCU10	E34
VCGR160408 KCU25	E34
VCGR160408 KD1425	B351, E34
VCGR160408 KT315	E34
VCGR160408FP KCK05	E35
VCGR160408FP KCM25	E35
VCGR160408FP KCP10	E35
VCGR160408FP KCP25	E35
VCGR160412 K68	E34
VCGR160412 KC5010	E34
VCGR160412 KCU10	E34
VCGR160412 KCU25	E34
VCGR160412 KD1425	B351, E34
VCGR160412FP KCK05	E35
VCGR160412FP KCP10	E35
VCGR160412FP KCP25	E35
VCGR160416 KC5010	E34
VCGR160416 KCU10	E34
VCGR160416FP KCP25	E35
VCGW160404S01015MT KBH20	B322
VCGW160404S01225MT KBH20	B322
VCGW160408S01015MT KBH20	B322
VCGW160408S01225MT KBH20	B322
VCMR160404 KC5010	E33
VCMR160404 KC5025	E33
VCMR160404 KCM15B	E33
VCMR160404 KCU25	E33
VCMR160404 KT315	E33
VCMR160404FP KCM25	E33
VCMR160404FP KCP10	E33
VCMR160404FP KCP25	E33
VCMR160404FP KCU10	E33
VCMR160404FP KCU25	E33
VCMR160408 KC5010	E33
VCMR160408 KC5025	E33
VCMR160408 KCM15B	E33
VCMR160408 KCU10	E33
VCMR160408 KCU25	E33
VCMR160408 KT315	E33
VCMR160408FP KCK05	E33
VCMR160408FP KCM25	E33
VCMR160408FP KCP10	E33
VCMR160408FP KCP25	E33
VDIB1M302040C	C67
VDIB1M402544C	C67
VDIB2M302040C	C67
VDIB2M402544C	C67
VDIB3M302040C	C68
VDIB3M402544C	C68
VDIB4M302040C	C68
VDIB4M402544C	C68
VDIB5M302040C	C69
VDIB5M402544C	C69
VDIB6M302040C	C69
VDIB6M402544C	C69
VDIC1M302070C	C70
VDIC1M402585C	C70
VDIC2M302070C	C70
VDIC2M402585C	C70
VDIC3M302070C	C71
VDIC3M402585C	C71
VDIC4M302070C	C71
VDIC4M402585C	C71
VNGA160404 K68	B143
VNGA160404FST KD1400	B350
VNGA160404S01015MT KBH10	B323
VNGA160404S01015MT KBH20	B323
VNGA160404S01025MT KB5630	B292, B323
VNGA160404S01225MT KBH10	B323
VNGA160404S01225MT KBH20	B323
VNGA160404S01735MT KBH20	B323
VNGA160404T02020 KY1615	B322
VNGA160408 K68	B143
VNGA160408FST KD1400	B350
VNGA160408FST KD1425	B350
VNGA160408S01015MT KBH10	B323
VNGA160408S01015MT KBH20	B323
VNGA160408S01025MT KB5630	B292, B323
VNGA160408S01225MT KBH10	B323
VNGA160408S01225MT KBH20	B323
VNGA160408S01735MT KBH20	B323
VNGA160408T02020 KY1615	B322
VNGA160408T02020 KY3500	B294
VNGA160412S01225MT KBH20	B323
VNGA160412T02020 KY1615	B322
VNGA220408T02020 KY1615	B322
VNGA220408T02020 KYK25	B294
VNGG160401FS KCU10	B143
VNGG160402FS KC5010	B143
VNGG160402FS KCU10	B143
VNGG160402FS KCU25	B143
VNGG160402LF KC5010	B143
VNGG160402LF KCU10	B143
VNGG160404FS KC5010	B143
VNGG160404FS KC5025	B143
VNGG160404FS KCU10	B143
VNGG160404FS KCU25	B143
VNGG160404LF KC5010	B143
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VNGG160408FS KCU10	B143
VNGG160408FS KCU25	B143
VNGG160408LF K313	B143
VNGG160408LF KC5010	B143
VNGG160408LF KCU10	B143
VNGG220408LF KC5010	B143
VNGG220408LF KCU10	B143
VNGM160408S01325MTCB1 KBH20	B323
VNGM160412S01325MTCB1 KBH20	B323
VNGP160401 KC5010	B143
VNGP160401 KC5410	B143
VNGP160401 KCU10	B143
VNGP160402 KC5010	B143
VNGP160402 KC5410	B143
VNGP160402 KCU10	B143
VNGP160404K K313	B144
VNGP160404K KC5010	B144
VNGP160408K K313	B144
VNGP160408K KC5010	B144
VNGP220404 KC5010	B143
VNGP220404 KCU10	B143
VNGP220408 K313	B143
VNGP220408 KC5010	B143
VNGP220408 KCU10	B143
VNGX160712T02020 KY3500	B298
VNGX160716T02020 KY3500	B298
VNMA160408 KCK05	B144
VNMA160408 KCK15	B144
VNMA160408 KCK15B	B144
VNMA160408 KCK20	B144
VNMG160401MS KC5010	B146
VNMG160401MS KCU10	B146
VNMG160401MS KCU25	B146
VNMG160402MS K313	B146
VNMG160402MS KC5010	B146
VNMG160402MS KC5025	B146
VNMG160402MS KCU10	B146
VNMG160402MS KCU25	B146
VNMG160404FF KC5010	B145
VNMG160404FF KCM15B	B145
VNMG160404FF KCP05	B145
VNMG160404FF KCP10	B145
VNMG160404FF KCP10B	B145
VNMG160404FF KCU10	B145
VNMG160404FF KT315	B145
VNMG160404FN KCK05	B145
VNMG160404FN KCK15B	B145
VNMG160404FN KCP05	B145
VNMG160404FN KCP10	B145
VNMG160404FN KCP10B	B145
VNMG160404FN KCP25	B145
VNMG160404FN KCP25B	B145
VNMG160404FN KT315	B145
VNMG160404FP KC5010	B145
VNMG160404FP KCM15	B145
VNMG160404FP KCU10	B145
VNMG160404FP KT315	B145
VNMG160404MN KCP10	B145
VNMG160404MN KCP10B	B145
VNMG160404MN KCP25	B145
VNMG160404MN KCP25B	B145
VNMG160404MN KCP30	B145
VNMG160404MP KC5010	B146
VNMG160404MP KCM15	B146
VNMG160404MP KCM15B	B146
VNMG160404MP KCM25	B146
VNMG160404MP KCM25B	B146
VNMG160404MP KCM35	B146
VNMG160404MP KCU10	B146
VNMG160404MS K313	B146
VNMG160404MS KC5010	B146
VNMG160404MS KC5025	B146
VNMG160404MS KCU10	B146
VNMG160404MS KCU25	B146
VNMG160404P KC5010	B146
VNMG160404P KCU10	B146
VNMG160404UN KCK15	B147
VNMG160404UN KCK20	B147
VNMG160404UP KC5010	B147
VNMG160404UP KCM15	B147
VNMG160404UP KCM25	B147
VNMG160408 K68	B144
VNMG160408FF KC5010	B145
VNMG160408FF KCP05	B145
VNMG160408FF KCP10	B145
VNMG160408FF KCP10B	B145
VNMG160408FF KCP25B	B145
VNMG160408FF KCU10	B145
VNMG160408FF KT315	B145
VNMG160408FN KCK05	B145
VNMG160408FN KCK15B	B145
VNMG160408FN KCP05	B145
VNMG160408FN KCP10	B145
VNMG160408FN KCP10B	B145
VNMG160408FN KCP25	B145
VNMG160408FN KCP25B	B145
VNMG160408FN KT315	B145
VNMG160408FP KC5010	B145
VNMG160408FP KCM15	B145
VNMG160408FP KCP10	B145
VNMG160408FP KCP25B	B145
VNMG160408FP KCU10	B145
VNMG160408FP KT315	B145
VNMG160408LF KCP25B	B144
VNMG160408MN KCP05	B145
VNMG160408MN KCP05B	B145
VNMG160408MN KCP10	B145
VNMG160408MN KCP10B	B145
VNMG160408MN KCP25	B145
VNMG160408MN KCP25B	B145
VNMG160408MN KCP30	B145
VNMG160408MP KC5010	B146
VNMG160408MP KCM15	B146
VNMG160408MP KCM15B	B146
VNMG160408MP KCM25	B146
VNMG160408MP KCM25B	B146
VNMG160408MP KCM35	B146
VNMG160408MP KCU10	B146
VNMG160408MR KCM15B	B146
VNMG160408MS K313	B146
VNMG160408MS KC5010	B146
VNMG160408MS KC5025	B146
VNMG160408MS KCU10	B146
VNMG160408MS KCU25	B146
VNMG160408P K313	B146
VNMG160408P KC5010	B146
VNMG160408P KCU10	B146
VNMG160408RN KCP10	B147
VNMG160408RN KCP10B	B147
VNMG160408RN KCP25	B147
VNMG160408RN KCP25B	B147
VNMG160408RP KC5010	B147
VNMG160408RP KC5025	B147
VNMG160408RP KCK15	B147
VNMG160408RP KCK20B	B147
VNMG160408RP KCM15	B147
VNMG160408RP KCP10	B147
VNMG160408RP KCP25	B147
VNMG160408RP KCU10	B147
VNMG160408RP KCU25	B147
VNMG160408UN KCK05B	B147
VNMG160408UN KCK15	B147
VNMG160408UN KCK15B	B147
VNMG160408UN KCK20	B147
VNMG160408UP KC5010	B147
VNMG160408UP KCM15	B147
VNMG160408UP KCM25	B147
VNMG160408UP KCU10	B147
VNMG160412 K68	B144
VNMG160412MN KCP10	B145
VNMG160412MN KCP25	B145
VNMG160412MN KCP25B	B145
VNMG160412MN KCP30	B145
VNMG160412MP KC5010	B146
VNMG160412MP KCM15B	B146
VNMG160412MP KCU10	B146
VNMG160412MR KCM15	B146
VNMG160412RN KCP10	B147
VNMG160412RN KCP25	B147
VNMG160412RN KCP25B	B147
VNMG160412RP KCK15	B147
VNMG160412RP KCK15B	B147
VNMG160412RP KCK20	B147
VNMG160412RP KCM25	B147
VNMG160412RP KCP10	B147
VNMG160412RP KCP25	B147
VNMG160412RP KCU10	B147
VNMG160412RP KCU25	B147
VNMG160412UP KCM15	B147
VNMG220404LF KCP25B	B144
VNMG220404MS KC5010	B146
VNMG220404MS KCU10	B146
VNMG220404MS KCU25	B146
VNMG220408 K68	B144
VNMG220408LF KCP25B	B144
VNMG220408MS KC5010	B146
VNMG220408MS KC5025	B146

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
VNMG220408MS KCU10	B146
VNMG220408MS KCU25	B146
VNMG220408RN KCP10	B147
VNMG220408RN KCP10B	B147
VNMG220408RN KCP25	B147
VNMG220408RN KCP25B	B147
VNMG220408RN KCP30	B147
VNMG220408RN KCP40	B147
VNMG220412 K68	B144
VNMG220412RN KCP10	B147
VNMG220412RN KCP25	B147
VNMG220412RN KCP30	B147
VNMP160404 K313	B148
VNMP160404 K68	B148
VNMP160404K K68	B148
VNMP160404K KCP10B	B148
VNMP160404K KCP25	B148
VNMP160408 K313	B148
VNMP160408 K68	B148
VNMP160408K K68	B148
VNMP160408K KCP10	B148
VNMP160408K KCP10B	B148
VNMP160408K KCP25	B148
VNMS160404 K68	B148
VNMS160404 KC5410	B148
VNMS160404E KD1405	B350
VNMS160404FST KD1400	B350
VNMS160404FST KD1425	B350
VNMS160408 K68	B148
VNMS160408 KC5410	B148
VNMS160408E KD1405	B350
VNMS160408FST KD1400	B350
VNMS160408FST KD1425	B350
VPGP443K KC5410	B144
W14	U27–28, U30, U32–34
W16	U29, U31, U35
W18	U40–42, U44, U46, U48
W20	U43, U45, U47, U49
WCMT040204FP KCU10	B270
WCMT040204FP KCU25	B270
WCMT040204LF KC5010	B270
WCMT06T308FP KCP25	B270
WCMT06T308FP KCU10	B270
WCMT06T308LF KC5010	B270
WCMT06T308LF KC5025	B270
WD32FDS28076M	H102
WD32FDS28128M	H102
WD32FDS28190M	H103
WD32FDS28283M	H103
WD32FDS28345M	H103
WD32FDS32082M	H102
WD32FDS32146M	H102
WD32FDS32216M	H103
WD32FDS32321M	H103
WD32FDS32391M	H103
WD32FDS36092M	H102
WD32FDS36166M	H102
WD32FDS36244M	H103
WD32FDS36361M	H103
WD32FDS36439M	H103
WD50FDS40100M	H102
WD50FDS40183M	H102
WD50FDS40271M	H103
WD50FDS40403M	H103
WD50FDS40491M	H103
WD50FDS45112M	H102
WD50FDS45206M	H102
WD50FDS45304M	H103
WD50FDS45451M	H103
WD50FDS45549M	H103
WD50FDS50122M	H102
WD50FDS50228M	H102
WD50FDS50338M	H103
WD50FDS50503M	H103
WD50FDS50613M	H103
WD50FDS56140M	H102
WD50FDS56259M	H102
WD50FDS56383M	H103
WD50FDS56569M	H103
WD50FDS56693M	H103
WD50FDS63154M	H102
WD50FDS63289M	H102
WD50FDS63429M	H103
WD50FDS63639M	H103
WD50FDS63779M	H103
WD50FDS71172M	H102
WD50FDS71292M	H102
WD50FDS71452M	H103
WD50FDS80192M	H102
WD50FDS80327M	H102
WD50FDS80507M	H103
WD50FDS90212M	H102
WD50FDS90362M	H102
WD50FDS90562M	H103
WLFNL32CA19S	E55
WLFNR32CA19S	E55
WLJNL32CA19S	E49
WLJNL32CA30S	E49
WLJNR32CA19S	E49
WLJNR32CA30S	E49
WLLNL32CA19S	E55
WLLNL32CA30S	E55
WLLNR32CA19S	E55
WLLNR32CA30S	E55
WNGA080404S01015MT KBH20	B324
WNGA080408FST KD1425	B351
WNGA080408S01015FWHBMT KBH20	B324
WNGA080408S01015FWMT KBH20	B323
WNGA080408S01015MT KBH20	B324
WNGA080408S01225MT KBH20	B324
WNGA080408S01735MT KBH20	B324
WNGA080408T01020 KYS30	B336
WNGA080408T01020FW KY3500	B294
WNGA080408T02020 KY3500	B294
WNGA080408T02020 KYK25	B294
WNGA080412T02020 KY3500	B294
WNGA080412T02020 KYK25	B294
WNGA080416T01020 KYS30	B336
WNGA080416T02020 KY3500	B294
WNGA80408S01015MT KBH10	B324
WNGA80408S01225MT KBH10	B324
WNGG080401LF KC5010	B154
WNGG080402LF KC5010	B154
WNGG080402LF KCU10	B154
WNGG080404FS KCU10	B154
WNGG080404LF KC5010	B154
WNGG080404LF KCU10	B154
WNGG080408FS KCU10	B154
WNGG080408LF KC5010	B154
WNGP080408K KC5010	B154
WNGP080408K KC5410	B154
WNGX080712T02020 KY3500	B298
WNGX080712T02020 KYK10	B298
WNMA060408 KCK15	B155
WNMA060412 KCK20	B155
WNMA060412 KCK20B	B155
WNMA080408 KCK05	B155
WNMA080408 KCK15	B155
WNMA080408 KCK20	B155
WNMA080408 KCK20B	B155
WNMA080412 KCK15	B155
WNMA080412 KCK15B	B155
WNMA080412 KCK20	B155
WNMA080416 KCK20	B155
WNMG060404FF KCP10	B155
WNMG060404FF KCU10	B155
WNMG060404FN KCK05	B155
WNMG060404FN KCP10	B155
WNMG060404FN KT315	B155
WNMG060404FP KC5010	B156
WNMG060404FP KCM15	B156
WNMG060404FP KCU10	B156
WNMG060404FW KCP05	B156
WNMG060404FW KCP05B	B156
WNMG060404FW KCU10	B156
WNMG060404FW KT315	B156
WNMG060404MN KCP10	B157
WNMG060404MN KCP25	B157
WNMG060404MP KC5010	B157
WNMG060404MP KCM15	B157
WNMG060404MP KCM25B	B157
WNMG060404MP KCU10	B157
WNMG060408FF KC5010	B155
WNMG060408FF KCP10	B155
WNMG060408FF KT315	B155
WNMG060408FN KCK15B	B155
WNMG060408FN KCP10	B155
WNMG060408FN KCP25	B155
WNMG060408FN KT315	B155
WNMG060408FP KC5010	B156
WNMG060408FP KCM15	B156
WNMG060408FP KCP10	B156
WNMG060408FW KC5010	B156
WNMG060408FW KCP05	B156
WNMG060408FW KCP10	B156
WNMG060408FW KCU10	B156
WNMG060408FW KT315	B156
WNMG060408MN KCP10	B157
WNMG060408MN KCP10B	B157
WNMG060408MN KCP25	B157
WNMG060408MN KCP25B	B157
WNMG060408MN KCP30	B157
WNMG060408MP KC5010	B157
WNMG060408MP KCM15	B157
WNMG060408MP KCM25	B157
WNMG060408MP KCM25B	B157
WNMG060408MP KCM35B	B157
WNMG060408MP KCP25	B157
WNMG060408MP KCU10	B157
WNMG060408MR KCM15B	B157
WNMG060408MR KCP25B	B157
WNMG060408MS K313	B158
WNMG060408MS KC5010	B158
WNMG060408MS KC5025	B158
WNMG060408MS KCU10	B158
WNMG060408MS KCU25	B158
WNMG060408MW KCP10	B159
WNMG060408RN KCP10B	B159
WNMG060408RN KCP25	B159
WNMG060408RN KCP25B	B159
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WNMG060408RP KCM25	B159
WNMG060408RP KCP10	B159
WNMG060408RP KCP10B	B159
WNMG060408RP KCP25	B159
WNMG060408RP KCU10	B159
WNMG060408RP KCU25	B159
WNMG060408UN KCK15	B160
WNMG060408UN KCK20B	B160
WNMG060408UP KCM25B	B160
WNMG060412FW KCP10	B156
WNMG060412MN KCP10	B157
WNMG060412MN KCP25	B157
WNMG060412MN KCP30B	B157
WNMG060412MP KCM25	B157
WNMG060412RN KCP25	B159
WNMG060412RP KCP10	B159
WNMG060412RP KCP25	B159
WNMG080401MS KCU10	B158
WNMG080402MS KC5010	B158
WNMG080402MS KCU10	B158
WNMG080402MS KCU25	B158
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WNMG080404FF KCP10	B155
WNMG080404FF KCU10	B155
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WNMG080404FN KCK05B	B155
WNMG080404FN KCP05	B155
WNMG080404FN KCP10	B155
WNMG080404FN KCP10B	B155
WNMG080404FN KCP25B	B155
WNMG080404FN KT315	B155
WNMG080404FP KC5010	B156
WNMG080404FP KCM15	B156
WNMG080404FP KCP10	B156
WNMG080404FP KCP25	B156
WNMG080404FP KCU10	B156
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WNMG080404FW KCP05	B156
WNMG080404FW KCP10	B156
WNMG080404FW KCU10	B156
WNMG080404FW KT315	B156
WNMG080404MS K313	B158
WNMG080404MS KC5010	B158
WNMG080404MS KC5025	B158
WNMG080404MS KCU10	B158
WNMG080404MS KCU25	B158
WNMG080404P KC5010	B158
WNMG080404P KCM15B	B158
WNMG080404P KCU10	B158
WNMG080404UN KCK15	B160
WNMG080404UN KCK20	B160
WNMG080408FF KC5010	B155
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WNMG080408FN KCP10B	B155
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WNMG080408FN KCP25B	B155
WNMG080408FN KT315	B155
WNMG080408FP KC5010	B156
WNMG080408FP KCM15	B156
WNMG080408FP KCM15B	B156
WNMG080408FP KCP10	B156
WNMG080408FP KCP25	B156
WNMG080408FP KCU10	B156
WNMG080408FW KC5010	B156
WNMG080408FW KCP05	B156
WNMG080408FW KCP10	B156
WNMG080408FW KCP10B	B156
WNMG080408FW KCU10	B156
WNMG080408FW KT315	B156
WNMG080408MG KCP10B	B156
WNMG080408MG KCP25B	B156
WNMG080408MN KCP05	B157
WNMG080408MN KCP10	B157
WNMG080408MN KCP10B	B157
WNMG080408MN KCP25	B157
WNMG080408MN KCP25B	B157
WNMG080408MN KCP30	B157
WNMG080408MN KCP30B	B157
WNMG080408MN KCP40	B157
WNMG080408MP KC5010	B157
WNMG080408MP KCM15	B157
WNMG080408MP KCM15B	B157
WNMG080408MP KCM25	B157
WNMG080408MP KCM25B	B157
WNMG080408MP KCM35	B157
WNMG080408MP KCM35B	B157
WNMG080408MP KCP10	B157
WNMG080408MP KCP25	B157
WNMG080408MP KCP25B	B157
WNMG080408MP KCU10	B157
WNMG080408MR KCK15B	B157
WNMG080408MR KCM15B	B157
WNMG080408MR KCM25	B157
WNMG080408MR KCM25B	B157
WNMG080408MR KCM35	B157
WNMG080408MR KCP10B	B157
WNMG080408MR KCP25B	B157
WNMG080408MR KCPK05	B157
WNMG080408MR KCU10	B157
WNMG080408MS K313	B158
WNMG080408MS KC5010	B158
WNMG080408MS KC5025	B158
WNMG080408MS KCU10	B158
WNMG080408MS KCU25	B158
WNMG080408MW KCK15B	B158
WNMG080408MW KCP05	B158
WNMG080408MW KCP10	B158
WNMG080408MW KCP10B	B158
WNMG080408MW KCP25	B158
WNMG080408MW KCP25B	B158
WNMG080408MW KCPK05	B158
WNMG080408P KC5010	B158
WNMG080408P KCM15B	B158
WNMG080408P KCU10	B158
WNMG080408RN KCP10	B159
WNMG080408RN KCP10B	B159
WNMG080408RN KCP25	B159
WNMG080408RN KCP25B	B159
WNMG080408RN KCP30	B159
WNMG080408RN KCP30B	B159
WNMG080408RN KCP40	B159

For page references A–E, please see Volume I • Turning Tools Catalogue.

Catalogue No.	Page(s)
WNMG080408RP KC5010	B159
WNMG080408RP KC5025	B159
WNMG080408RP KCK05	B159
WNMG080408RP KCK05B	B159
WNMG080408RP KCK15	B159
WNMG080408RP KCK15B	B159
WNMG080408RP KCK20	B159
WNMG080408RP KCK20B	B159
WNMG080408RP KCM15	B159
WNMG080408RP KCM15B	B159
WNMG080408RP KCM25	B159
WNMG080408RP KCM25B	B159
WNMG080408RP KCM35	B159
WNMG080408RP KCM35B	B159
WNMG080408RP KCP05	B159
WNMG080408RP KCP10	B159
WNMG080408RP KCP10B	B159
WNMG080408RP KCP25	B159
WNMG080408RP KCP25B	B159
WNMG080408RP KCP30B	B159
WNMG080408RP KCP40B	B159
WNMG080408RP KCPK05	B159
WNMG080408RP KCU10	B159
WNMG080408RP KCU25	B159
WNMG080408UN KCK05B	B160
WNMG080408UN KCK15	B160
WNMG080408UN KCK15B	B160
WNMG080408UN KCK20	B160
WNMG080408UN KCK20B	B160
WNMG080408UP KC5010	B160
WNMG080408UP KCM15	B160
WNMG080408UP KCM25	B160
WNMG080408UP KCM25B	B160
WNMG080408UP KCU10	B160
WNMG080412FP KC5010	B156
WNMG080412FP KCM15	B156
WNMG080412FW KCP05	B156
WNMG080412FW KCP10	B156
WNMG080412FW KCP10B	B156
WNMG080412MN KCP10	B157
WNMG080412MN KCP10B	B157
WNMG080412MN KCP25	B157
WNMG080412MN KCP25B	B157
WNMG080412MN KCP40B	B157
WNMG080412MP KC5010	B157
WNMG080412MP KCM15	B157
WNMG080412MP KCM25	B157
WNMG080412MP KCM25B	B157
WNMG080412MP KCM35	B157
WNMG080412MP KCP10	B157
WNMG080412MP KCP25B	B157
WNMG080412MP KCU10	B157
WNMG080412MR KCM15B	B157
WNMG080412MR KCM25B	B157
WNMG080412MR KCM35	B157
WNMG080412MR KCP10B	B157
WNMG080412MR KCP25B	B157
WNMG080412MR KCPK05	B157
WNMG080412MW KCM15B	B158
WNMG080412MW KCP05	B158
WNMG080412MW KCP10	B158
WNMG080412MW KCP10B	B158
WNMG080412MW KCP25	B158
WNMG080412MW KCP25B	B158
WNMG080412RN KCP05	B159
WNMG080412RN KCP10	B159
WNMG080412RN KCP10B	B159
WNMG080412RN KCP25	B159
WNMG080412RN KCP25B	B159
WNMG080412RN KCP30	B159
WNMG080412RN KCP30B	B159
WNMG080412RN KCP40B	B159
WNMG080412RN KCPK05	B159
WNMG080412RP KC5010	B159
WNMG080412RP KCK05	B159
WNMG080412RP KCK15	B159
WNMG080412RP KCK15B	B159
WNMG080412RP KCK20	B159
WNMG080412RP KCK20B	B159
WNMG080412RP KCM15	B159
WNMG080412RP KCM25	B159
WNMG080412RP KCM25B	B159
WNMG080412RP KCM35	B159
WNMG080412RP KCM35B	B159
WNMG080412RP KCP05	B159
WNMG080412RP KCP10	B159
WNMG080412RP KCP10B	B159
WNMG080412RP KCP25	B159
WNMG080412RP KCP25B	B159
WNMG080412RP KCP30	B159
WNMG080412RP KCP30B	B159
WNMG080412RP KCP40B	B159
WNMG080412RP KCPK05	B159
WNMG080412RP KCPK30B	B159
WNMG080412RP KCU10	B159
WNMG080412RP KCU25	B159
WNMG080412UN KCK05	B160
WNMG080412UN KCK15	B160
WNMG080412UN KCK15B	B160
WNMG080412UN KCK20	B160
WNMG080412UN KCK20B	B160
WNMG080412UP KC5010	B160
WNMG080412UP KCM25	B160
WNMG080412UP KCM35	B160
WNMG080412UP KCU10	B160
WNMG080416MN KCP25	B157
WNMG080416MN KCP25B	B157
WNMG080416MR KCP10B	B157
WNMG080416MR KCP25B	B157
WNMG080416RN KCP10	B159
WNMG080416RN KCP10B	B159
WNMG080416RN KCP25	B159
WNMG080416RN KCP25B	B159
WNMG080416RP KCP10	B159
WNMG080416RP KCP25	B159
WNMG080416RP KCP25B	B159
WNMG080416RP KCU25	B159
WNMG080416UN KCK15B	B160
WNMG080416UN KCK20	B160
WOEJ090512SRGD KC522M	V41
WOEJ090512SRGD KC725M	V41
WOEJ090512SRGD KCPK30	V41
WOEJ090512SRGD KCPM40	V41
WOEJ090512SRGD KCSM30	V41
WOEJ090512SRHD KC522M	V41
WOEJ090512SRHD KC725M	V41
WOEJ090512SRHD KCPK30	V41
WOEJ090512SRHD KCPM40	V41
WPGT040202UF KCU10	B272
WPGTS30101UF KC5010	B272
WPGTS30101UF KCU10	B272
WPGTS30102UF KC5010	B272
WPGTS30102UF KCU10	B272
WPMT040204FP KCM25	B272
WPMT040204FP KCP25	B272
WPMT040204FP KCU10	B272
WPMT040204LF KC5010	B272
WPMT040204LF KC5025	B272
WPMT040204LF KCK20	B272
WPMT040204LF KCP10	B272
WPMT06T304FP KCU10	B272
WPMT06T304LF KC5010	B272
WPMT06T304LF KCM15B	B272
WPMT06T304LF KCP25	B272
WPMT06T308FP KCU10	B272
WPMT06T308LF KC5010	B272
WPMT06T308LF KCK05	B272
WPMT06T308LF KCM15	B272
WPMT06T308LF KCP25B	B272
WPMTS3T104FP KCP25	B272
WPMTS3T104FP KCU10	B272
WPMTS3T104LF KC5025	B272
WXXNL4455X-FL	E54
WXXNR4455X-FL	E54
XADA1000X4CH45 KCPM15	O48
XADA1000X4CH60 KCPM15	O48
XADA1200X5CH45 KCPM15	O48
XADA1200X5CH60 KCPM15	O48
XADA1600X6CH45 KCPM15	O48
XADA1600X6CH60 KCPM15	O48
XDLT090408ERD41 SC6525	V14
XDLT090408ERD41 SP6519	V14
XDLT090408ERD41 X500	V14
XDLT090408ERD721 GH2	V14
XDLT090412ERD411 SP6519	V15
XDLT090412ERD411 X500	V15
XDLT120508ERD41 SC6525	V23
XDLT120508ERD41 SP6519	V23
XDLT120508ERD41 X500	V23
XDLT120508ERD721 GH2	V23
XDLT120512ERD411 SP6519	V24
XDLT120512ERD411 X500	V24
XDLW090408SRD SC3025	V16
XDLW090408SRD SC6525	V16
XDLW090408SRD X400	V16
XDLW090408SRD X500	V16
XDLW120508SRD SC3025	V25
XDLW120508SRD X400	V25
XDLW120508SRD X500	V25
XDPT090408ERD41 KCSM40	V15
XDPT090408ERD41 SC6525	V15
XDPT090408ERD41 SP6519	V15
XDPT090408ERD41 X500	V15
XDPT090412ERD411 KCSM40	V15
XDPT090412SRGP KC522M	V16
XDPT090412SRGP KC725M	V16
XDPT090412SRGP KCPK30	V16
XDPT090412SRGP KCPM40	V16
XDPT120508ERD41 KCSM40	V23
XDPT120508ERD41 SC6525	V23
XDPT120508ERD41 SP6519	V23
XDPT120508ERD41 X500	V23
XDPT120512ERD411 KCSM40	V24
XDPT120515SRGP KC522M	V24
XDPT120515SRGP KC725M	V24
XDPT120515SRGP KCPK30	V24
XDPT120515SRGP KCPM40	V24
XDPW090412SRD KC510M	V16
XDPW090412SRD KC522M	V16
XDPW090412SRD KCK15	V16
XDPW090412SRD KCPK30	V16
XDPW090412SRD KCPM40	V16
XDPW120515SRD KC510M	V25
XDPW120515SRD KC522M	V25
XDPW120515SRD KCK15	V25
XDPW120515SRD KCPK30	V25
XDPW120515SRD KCPM40	V25
XE020MTN4-C SP4060	P72
XE025MTN4-C SP4060	P72
XE030MTN4-C SP4060	P72
XE040MTN4-C SP4060	P72
XE050MTN4-C SP4060	P72
XE060MN4-C SP4060	P72
XE080MN4-C SP4060	P72
XE100MN4-C SP4060	P72
XE160MN4-C SP4060	P72
XE200MN4-C SP4060	P72
XELT160512ERD41 SC6525	V30
XELT160512ERD41 SP6519	V30
XELT160512ERD41 X500	V30
XELW160512SRD SC3025	V31
XELW160512SRD X400	V31
XEPT160512ERD41 KCSM40	V31
XEPT160516ERD41 KC522M	V31
XEPT160516ERD41 KCPK30	V31
XEPT160516ERD41 KCPM40	V31
XEPW160520SRD KC522M	V31
XEPW160520SRD KCK15	V31
XEPW160520SRD KCPK30	V31
XEPW160520SRD KCPM40	V31
XER020NTN4-C SP4060	P73
XER030NTN4-C SP4060	P73
XER040NTN4-C SP4060	P73
XER040NTN4-E SP4060	P73
XER050NTN4-E SP4060	P73
XER060NN4-C SP4060	P73
XER060NN4-E SP4060	P73
XER060NN4-G SP4060	P73
XER080NN4-C SP4060	P73
XER080NN4-E SP4060	P73
XER080NN4-G SP4060	P73
XER100NN4-C SP4060	P73
XER100NN4-E SP4060	P73
XER100NN4-G SP4060	P73
XER120NN4-C SP4060	P73
XER120NN4-E SP4060	P73
XER120NN4-G SP4060	P73
XER120NN4-J SP4060	P73
XER120NN4-L SP4060	P73
XER160NN4-C SP4060	P73
XER160NN4-G SP4060	P73
XER160NN4-J SP4060	P73
XER160NN4-L SP4060	P73
XER160NN4-M SP4060	P73
XER160NN4-P SP4060	P73
XER200NN4-G SP4060	P73
XER200NN4-J SP4060	P73
XER200NN4-M SP4060	P73
XNGJ0604ANENLD3W KC510M	S12
XNGJ0604ANENLD3W KC522M	S12
XNGJ0604ANENLD3W KC725M	S12
XNGJ0604ANENLD3W KCPM40	S12
XNGJ0604ANENLD3W KCSM40	S12
XNGJ0604ANFNLDJ3W KC410M	S11
XNGJ0905ANFNLDJ3W KC410M	S22
XNGJ0905ANSNGD3W KC725M	S22
XNGJ0905ANSNGD3W KCK15	S22
XNGJ0905ANSNGD3W KCPK30	S22
XNGJ0905ANSNGD3W KCSM40	S22
XNXF1204ZNENLDW KCK15	S106
XNXF1204ZNENW KY3500	S106
XPLT060308ERD41 SC6525	V7
XPLT060308ERD41 SP6519	V7
XPLT060308ERD41 X400	V7
XPLT060308ERD41 X500	V7
XPNT16160308RF SP6519	V105
XPNT2020T306RF SP6519	V105
XPNT25250408RF SP6519	V105
XPNT32320612RF SP6519	V105
XPNT4040T716RF SP6519	V105
XPNT5050T716RF SP6519	V105
XPPT060308ERD41 KCSM40	V7
XPPW060310SRD KC510M	V7
XPPW060310SRD KC522M	V7
XPPW060310SRD KCPK30	V7
XPPW060310SRD KCPM40	V7
XRDA1000X4CHJ KCPM15	O49
XRDA1000X4CRM KCPM15	O49
XRDA1200X5CRG KCPM15	O49
XRDA1200X5CRK KCPM15	O49
XRDA1200X5CRM KCPM15	O49
XRDA1600X6CRK KCPM15	O49
XRDA1600X6CRM KCPM15	O49
XRDA1600X6CRN KCPM15	O49
ZDET16M504FR721 GH1	T90
ZDET16M508FR721 GH1	T90
ZDET16M512FR721 GH1	T90
ZDET16M516FR721 GH1	T90
ZDET16M520FR721 GH1	T90
ZDET16M525ER721 GH1	T90
ZDET16M525FR721 GH1	T90
ZDET16M530ER721 GH1	T90
ZDET16M530FR721 GH1	T90
ZDET16M532FR721 GH1	T90
ZDET16M540ER721 GH1	T90
ZDET16M540FR721 GH1	T90
ZDET16M550FR721 GH1	T90
ZDET16M560FR721 GH1	T90
ZDET16M5PDFR721 GH1	T90

For page references A–E, please see Volume I • Turning Tools Catalogue.

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*Visit **kennametal.com** for additional contact information for locations.*



Turning Icons

 Shank: KM-TS™ (ISO 26622)	 Shank: KM4X™	 Shank: VDI Shank	 DIN Number 69880	 Through Coolant
 Through Coolant: 100 bar	 Through Coolant: 1500 psi	 Through Coolant: 80 bar	 Through Coolant: 1200 psi	 ISO: 26622
 ISO: 10889	 Turning	 Profiling	 Facing	 Face Grooving
 Chamfering	 Back Boring	 Threading	 Grooving	 Cut-Off
 I.D. Turning	 I.D. Chamfering	 I.D. Facing	 I.D. Grooving	 I.D. Face Grooving
 Deep Grooving	 I.D. Internal Threading			

Holemaking Icons

 Countersinking/ Stroke Chamfering	 Taper Drilling	 Counterboring	 Drilling	 Drilling: Inclined Entry
 Drilling: Inclined Exit	 Drilling: Exit Offset	 Drilling: Flat Bottom	 Drilling: Stacked Plates	 Drilling: Convex
 Drilling: Blind Hole	 Drilling: Concave	 Drilling: Chain	Drilling: Cross Hole	Drilling: Half Cylinder
Drilling: Corner Drilling 45°	Reaming: Through Hole	Reaming: Blind Hole	Reaming: Through Cross	Reaming: Blind and Cross Holes
Reaming: Interrupted Cut	Drilling Depth: 1 x D	Drilling Depth: 3 x D	Drilling Depth: 5 x D	Drilling Depth: 8 x D
Drilling Depth: 10 x D	Drilling Depth: 12 x D	Drilling Depth: 7 x D	Drilling Depth: 4 x D	Drilling Depth: 1.5 x D

(continued)

(Holemaking Icons — continued)

Corner Style: Corner Chamfer	Corner Style: Square End	Shank: Cylindrical Plain	Shank: Cylindrical Plain ≤h6	Shank: Cylindrical Weldon®
Shank: Cylindrical Whistle Notch	Shank: Cylindrical Whistle Notch ≤h6	Shank: Cylindrical Whistle Notch 2°	Shank: Cylindrical with Flat	Flat Shank
SK Shank: Rübig	Shank: SK BT JIS B 6339	Shank: SK CAT(CV) ANSI B5.50	Shank: SK DV DIN 69871	Shank: Cylindrical Whistle Notch with Drive and Flange
Shank: Cylindrical with Flat and Flange	KM™ Shank	Shank: HSK DIN 69893	Shank: HSK DIN 69893 Form A	Shank: KM-TS™ (ISO 26622)
Shank: KM-XMZ	Shank: ER	Helix Angle: 0°	Helix Angle: 15°	Helix Angle: 30°
Tip Angle: 118°	Tip Angle: 130°	Balance (G 6.3/25,000)	Balance (G 6.3/10,000)	Balance (G 6.3/6,000)
Balance (G 16/20,000)	DIN Number 6537	DIN Number 6535	DIN Number 69893	DIN Number 69090-3
Drilling: No Coolant	Through Coolant: Radial: Drilling	Through Coolant: Radial: Reaming	Through Coolant: Radial: Indexable Drilling	Flood Coolant: Drilling
Through Coolant: MQL (Minimum Quantity Lubricant): Drilling	Through Coolant: Axial: Drilling	Through Coolant: Axial: Reaming	Through Coolant: Coolant Entry AD	Through Coolant: Coolant Entry AD/B
Tool Dimensions: 2 Flute/2 Margin/ Coolant	Tool Dimensions: 2 Flute/2 Margin/ No Coolant	Tool Dimensions: 2 Flute/3 Margin/ Coolant	Tool Dimensions: 2 Flute/4 Margin/ Coolant	Tool Dimensions: 2 Flute/4 Margin/ No Coolant
Tool Dimensions: 2 Flute/4 Margin/ X/Coolant	Tool Dimensions: 3 Flute/3 Margin/ Coolant	Tool Dimensions: 3 Flute/3 Margin/ No Coolant	Tool Dimensions: Flute Configuration: 2	Tool Dimensions: Flute Configuration: 3
Tool Dimensions: Flute Configuration: 4				

Tapping Icons

Countersinking/ Stroke Chamfering	Drilling: Flat Bottom	Drilling: Blind	Tapping: Through Hole	Tapping: Blind Hole
Threading: Through Hole	HSS-E: High-Speed Steel with Cobalt Alloy for Materials with Higher Hardnes	HSS-E-PM: High-Speed Steel with Cobalt Alloy for Materials with Higher Hardness (PM = Powder Metal Steel)	HM: (Carbide)	Drilling Depth: 2xD
Chamfer Form B (3.5–5.5)	Chamfer Form C (2–3)	Chamfer Form D (3.5–5)	Chamfer Form E (1.5–2)	Plug Chamfer Form B (3–5)
Tapping Helix Angle: 0º	Tapping Helix Angle: 10º	Tapping Helix Angle: L8º	Tapping Helix Angle: 15º	Tapping Helix Angle: L15º
Tapping Helix Angle: 25º	Tapping Helix Angle: 30º	Tapping Helix Angle: 42º	Tapping Helix Angle: 45º	Multipurpose Taps: Spiral Point
Tension/ Compression	DIN Number 371	DIN Number 374	DIN Number 376	DIN Number 5156
DIN Number 2174	Through Coolant: Radial: Tapping	Flood Coolant: Tapping	Through Coolant: Axial: Tapping	Manufacturer's Specs: ISO 2
Manufacturer's Specs: ISO 3	Manufacturer's Specs: JIS	Class of Fit: 2B	Class of Fit: 3B	Class of Fit: 6H
Class of Fit: 6HX	Class of Fit: 6G	Class of Fit: 2BX	Class of Fit: 3BX	Unified Fine Thread
Unified Course Thread	American Tapered Pipe Thread for Threads with Dryseal Material	American Tapered Pipe Thread for Threads without Dryseal Material	Whitworth Pipe Thread	Unified Course Thread: J Profile
Unified Fine Thread: J Profile	ISO Metric Coarse Thread	ISO Metric Fine Thread		

Solid End Milling Icons

Face Milling	Helical Milling	Plunge Milling	Plunge Milling: Ball Nose	Ramping: Blank
Ramping: Up to 3°	Slotting: Ball Nose	Slotting: Ball Nose with AP Dimension	Slotting: Square End	Slotting: Square End with AP Dimension
Trochoidal Milling	Trochoidal Milling: Ball Nose	Side Milling/Shoulder Milling: Ball Nose	Side Milling/ Shoulder Milling: Ball Nose with AE/AP Dimensions	Side Milling/ Shoulder Milling: Square End
Side Milling/ Shoulder Milling: Square End with AE/AP Dimensions	Side Milling/ Shoulder Milling: Eased Chamfer	Side Milling/ Shoulder Milling: Eased Chamfer with AE/AP Dimensions	Side Milling/ Shoulder Milling: Fine Finishing	Side Milling/ Shoulder Milling: Fine Finishing with AE/AP Dimensions
Side Milling/ Shoulder Milling: Finishing	Side Milling/ Shoulder Milling: Finishing with AE/AP Dimensions	Side Milling/ Shoulder Milling: Thin Wall Solid End Milling	Side Milling/ Shoulder Milling: Radius	Side Milling/ Shoulder Milling: Radius with AE/AP Dimensions
3D Profiling	3D Profiling with AE/AP Dimensions	3D Profiling with Square End Mill	Corner Style: Ball Nose	Corner Style: Corner Chamfer
Corner Style: Corner Radius	Corner Style: Square End	Corner Style: Torus	Shank: Cylindrical Plain	Shank: Cylindrical Weldon®
Shank: SK BT JIS B 6339	Shank: SK CAT(CV) ANSI B5.50	Shank: HSK: CAT: Drawbar Thread: 5/8–11 UNC	Shank: HSK A/ DIN69893	Shank: Safe-Lock™ ≤h6
Shank: Safe-Lock™	Shank: PSC Shank	Duo-Lock™ Connection	Helix Angle: 0°	Helix Angle: 15°
Helix Angle: 20°	Helix Angle: 25°	Helix Angle: 30°	Helix Angle: 35°	Helix Angle: 38°
Helix Angle: 40°	Helix Angle: 45°	Helix Angle: 50°	Helix Angle: 60°	Helix Angle: 43°
Helix Angle: 36°	Helix Angle: 35°/38°	Helix Angle: 37°/39°	Balance (G 2.5/25,000)	DIN Number 6527
DIN Number 6528	Drilling: Through Coolant	Through Coolant	Through Coolant: Axial: Solid End Mill	Tool Dimensions: Flute Configuration: X (Variable)

(continued)

(Solid End Milling Icons — continued)

Tool Dimensions: Flute Configuration: 2	Tool Dimensions: Flute Configuration: 3	Tool Dimensions: Flute Configuration: 4	Tool Dimensions: Flute Configuration: 5	Tool Dimensions: Flute Configuration: 6
Tool Dimensions: Flute Configuration: 1	Tool Dimensions: Flute Configuration: 12	ISO 26622		

Indexable Milling Icons

Counterboring	Spiral Circular	Face Milling	Helical Milling	Plunge Milling
Plunge Milling: Ball Nose	Ramping: Blank	Slotting: Ball Nose	Slotting: Side	Slotting: Side with AE/AP Dimensions
Slotting: Side Milling: Ball Nose	Slotting: Square End	Slotting: T	Slotting: T with AP Dimension	Side Milling/ Shoulder Milling: Ball Nose
Side Milling/ Shoulder Milling: Bottom Shouldering	Side Milling/ Shoulder Milling: Square End	Side Milling/ Shoulder Milling: Eased Chamfer	Slotting: Shoulder Profiling	Slotting: Shoulder
3D Profiling	3D Profiling with Square End Mill	PCD Tool	Pocketing	Shank: Cylindrical Plain
Shank: Cylindrical Weldon®	Shank: Cylindrical Weldon 2 Flat	Shank: Screw-On	Shank: HSK DIN 69893	Shell Mill Shank
Milling: Through Coolant	Through Coolant: Pressurised Air Coolant: Radial: Indexable Milling			

P	Steel
M	Stainless Steel
K	Cast Iron
N	Non-Ferrous
S	High-Temp Alloys
H	Hardened Materials
C	CFRP Materials

material group	description	content	tensile strength RM (MPa)*	hardness (HB)	hardness (HRC)	material number
P0	Low-Carbon Steels, Long Chipping	C <0,25%	<530	<125	–	–
P1	Low-Carbon Steels, Short Chipping, Free Machining	C <0,25%	<530	<125	–	C15, Ck22, ST37-2, S235JR, 9SMnPb28, GS38
P2	Medium- and High-Carbon Steels	C >0,25%	>530	<220	<25	ST52, S355JR, C35, GS60, Cf53
P3	Alloy Steels and Tool Steels	C >0,25%	600–850	<330	<35	16MnCr5, Ck45, 21CrMoV5-7, 38SMn28
P4	Alloy Steels and Tool Steels	C >0,25%	850–1400	340–450	35–48	100Cr6, 30CrNiMo8, 42CrMo4, C70W2, S6525, X120Mn12
P5	Ferritic, Martensitic, and PH Stainless Steels	–	600–900	<330	<35	100Cr6, 30CrNiMo8, 42CrMo4, C70W2, S6525, X120Mn12
P6	High-Strength Ferritic, Martensitic, and PH Stainless Steels	–	900–1350	350–450	35–48	X102CrMo17, G-X120Cr29
M1	Austenitic Stainless Steel	–	<600	130–200	–	X5CrNi 18 10, X2CrNiMo 17 13 2, G-X25CrNiSi18 9, X15CrNiSi 20 12
M2	High-Strength Austenitic Stainless and Cast Stainless Steels	–	600–800	150–230	<25	X2CrNiMo 13 4, X5NiCr 32 21, X5CrNiNb 18 10, G-X15CrNi 25-20
M3	Duplex Stainless Steel	–	<800	135–275	<30	X8CrNiMo27 5, X2CrNiMoN22 5 3, X20CrNiSi25 4, G-X40CrNiSi27 4
K1	Grey Cast Iron	–	125–500	120–290	<32	GG15, GG25, GG30, GG40, GTW40
K2	Low- and Medium-Strength Ductile Irons (Nodular Irons) and Compacted Graphite Irons (CGI)	–	<600	130–260	<28	GGG40, GTS35
K3	High-Strength Ductile Irons and Austempered Ductile Iron (ADI)	–	>600	180–350	<43	GGG60, GTW55, GTS65
N1	Wrought Aluminium	–	–	–	–	AlMg1, Al99.5, AlCuMg1, AlCuBiPb, AlMgSi1, ALMgSiPb
N2	Low-Silicon Aluminium Alloys and Magnesium Alloys	Si <12,2%	–	–	–	GAlSiCu4, GDAlSi10Mg
N3	High-Silicon Aluminium Alloys and Magnesium Alloys	Si >12,2%	–	–	–	G-ALSi12, G-AlSi17Cu4, G-AlSi21CuNiMg
N4	Copper-, Brass-, Zinc-Based on Machinability Index Range of 70–100	–	–	–	–	CuZn40, Ms60, G-CuSn5ZnPb, CuZn37, CuSi3Mn
N5	Nylon, Plastics, Rubbers, Phenolics, Resins, Fibreglass	–	–	–	–	Lexan®, Hostalen™, Polystyrol, Makrolon®
N6	Carbon, Graphite Composites, CFRP	–	–	–	–	CFK, GFK
N7	Metal Matrix Composites (MMC)	–	–	–	–	–
S1	Iron-Based, Heat-Resistant Alloys	–	500–1200	160–260	25–48	X1NiCrMoCu32 28 7, X12NiCrSi36 16, X5NiCrAlTi31 20, X40CoCrNi20 20
S2	Cobalt-Based, Heat-Resistant Alloys	–	1000–1450	250–450	25–48	Haynes® 188, Stellite 6,21,31
S3	Nickel-Based, Heat-Resistant Alloys	–	600–1700	160–450	<48	INCONEL® 690, INCONEL 625, Hastelloy®, NIMONIC® 75
S4	Titanium and Titanium Alloys	–	900–1600	300–400	33–48	Ti1, TiAl5Sn2, TiAl6V4, TiAl4Mo4Sn2
H1	Hardened Materials	–	–	–	44–48	GX260NiCr42, GX330NiCr42, GX300CrNiSi952, GX300CrMo153, Hardox® 400
H2	Hardened Materials	–	–	–	48–55	–
H3	Hardened Materials	–	–	–	56–60	–
H4	Hardened Materials	–	–	–	>60	–
C1	CFRP, CFRP/CFRP	–	–	–	–	–
C2	CFRP/Non-Ferrous	–	–	–	–	–
C3	CFRP/High Temp	–	–	–	–	–
C4	CFRP/Stainless Steel	–	–	–	–	–
C5	CFRP/Non-Ferrous/High-Temp	–	–	–	–	–

P0 Workpiece Materials Listing • Steel • P0

P0 Low-Carbon Steels, Long Chipping *Content: C <.25%* *Tensile Strength RM (MPa)*: <530* *Hardness (HB): <125*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
1013	USt 34-1	–	–	G10130	–	–	–	1233	–	–	1.0055	–
1010	C 10	045 M 10	S 10 C	G10100	C 10	XC 10	C 10	–	–	–	1.0301	–
1008	DD 11 (StW 22)	HR 3	SPHD	–	DD 11	1 C	–	–	–	–	1.0332	–
1020	C 22	050 A 20	S 22 C	G10200	1 C 22	C 20	C 20	1450	–	–	1.0402	–
1025	C 25	070 M 26	S 22 C	G10250	1 C 25	C 25	C 25	–	–	–	1.0406	–
1012	B 500 H	–	S 12 C	G10120	B 500 B	XC 12	B 500 B	1332	–	–	1.0439	–
1018	C16.8	080 A 17	–	G10180	–	–	–	–	–	–	1.0453	–
1108	10 S 20	210 M 15	–	G 11080	10 S 20	10 F 1	CF 10 S 20	–	–	–	1.0721	–
1010	Ck 10	040 A 10	S 10 C	G10100	2 C 10	XC 10	C 10	1265	–	–	1.1121	–
1022	20 Mn 5	120 M 19	SMn 420	G 10220	20 Mn 5	20 M 5	G 22 Mn 3	–	–	–	1.1133	–
1015	Ck 15	080 M 15	S 15 C	G 10150	2 C 15	XC 15	C 15	1370	–	–	1.1141	–
1021	22 B 2	–	SWRCHB 220	G10210	C 22 BE 69	21 B 3	–	–	–	–	1.5508	–
–	PS 275 TM	S 275 M	–	–	S 275 M	S 275 M	S 275 M	–	–	–	1.8818	–
–	DI-MC 355 B	–	–	–	S 355 M	E 355	S 355 M	–	–	–	1.8823	–
–	DI-MC 420 B	S 420 M	–	–	S 420 M	E 420	S 420 M	–	–	–	1.8825	–
–	S 460 M	S 460 M	–	–	S 460 M	E460; S460M	S460M	–	–	–	1.8827	–
–	BTStE 355 TM	S 355 ML	–	–	S 355 ML	E 355	S 355 ML	–	–	–	1.8834	–
–	BTStE 420 TM	S 420 MI	–	–	S 420 ML	E 420	S 420 ML	–	–	–	1.8836	–
–	St E 320-3Z	–	–	–	S 320 GD + ZA	–	–	–	–	–	1.0250	–

P1 Workpiece Materials Listing • Steel • P1

P1 Low-Carbon Steels, Short Chipping, Free Machining *Content: C <.25%* *Tensile Strength RM (MPa)*: <530* *Hardness (HB): <125*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
–	R St 34-2/ S 205 G2T	34/20CR	–	K02502	–	–	–	–	–	–	1.0034	–
–	St 33	HR 15	SS 330	K01400	–	A 33	Fe 320	–	–	–	1.0035	–
A 570 Gr. 33	USt 37-2	4360-40 B	SS 34	K 02502	S 235 JR G1	E 24-2	Fe 360 BFU	1311	–	–	1.0036	–
–	St 37-2	HS 37/23	STKR 400	K02702	S 235 JR	E 28-2	Fe 430 C	1412	–	–	1.0037	–
A 570 Gr. 36	R St 37-2/S235 JRG2	4260-40 C	SS 34	K 02502	S235 JR G 2	E 24-2 NE	Fe 360 BFN	1312	–	–	1.0038	–
–	S 235 JRH	S 235 JRH	–	–	S235JRH	E 24-2	S 235 JRH	–	–	–	1.0039	–
–	R St 42-1	–	–	K02507	–	–	–	–	–	–	1.0077	–
–	S235J2G3/Fe 360 D1	S 235 J 2 G 3	–	K01501	S 235 J2 G3	E 24-4	S 235 J2G3	1313	–	–	1.0161	–
–	C 10 Pb	–	–	–	C 10 GPb	–	–	–	–	–	1.0302	–
–	QSt 32-3	–	SWRCH6R	–	CB 4 FF KD	–	CB 4 F U	–	–	–	1.0303	–
–	St 35.8	–	STPT 38	K01201	–	–	–	–	–	–	1.0305	–
–	St 37-2	360	STKM 12 A	K02504	S 235 JR	E 24-2	Fe 360	1412	–	–	1.0308	–
–	C10D	–	SWRM 10	–	C 10 D	FM 10	C 10 D	–	–	–	1.0310	–
–	C12D	–	SWRM 12	–	C 12 D	–	C 12 D	–	–	–	1.0311	–
–	R St 15	FeP05	–	–	Fe P05	FeP05	FeP05	–	–	–	1.0312	–
–	D 6-2	0 1 5 A 03	SWRM 6	G10050	C 4 D	–	3 CD 5	–	–	–	1.0314	–
–	St 37.8	–	STB 35	–	–	–	Fe 37	–	–	–	1.0315	–
–	St 13	CR 3	SPCD	–	–	–	–	–	–	–	1.0333	–
–	D D 13 (StW 24)	H S 3	SPHE	–	D D 13	3C	–	–	–	–	1.0335	–
–	USt 4/DC 04 G	–	–	–	D C 04 G 1	–	–	–	–	–	1.0336	–
–	Ro St 4/DC 04 GT	–	–	–	DC 04 GT	–	–	–	–	–	1.0337	–
–	St 4	DC 04/FeP04	SPCE	–	Fe P04	Fe 14	DC04/FeP04	–	–	–	1.0338	–
–	DC01Cu	–	–	–	DC 01 Cu	–	–	–	–	–	1.0344	–
–	RR St 3	CR 3	SPCD	–	Fe P03	F 13	DC 03/FeP 03	–	–	–	1.0347	–
–	U H I/P 195GH	–	SGV 480	–	P 195 Gh	–	–	–	–	–	1.0348	–
–	St 14 Cu 3	–	–	–	DC 04 Cu	–	–	–	–	–	1.0354	–
–	–	3 CR	–	–	D D 12	D D 12	–	–	–	–	1.0398	–
1015	C 15	080 M 15	S 15 C	G10170	C 15	C 12	C 15	1350	–	–	1.0401	–
–	LSt 45.8	–	–	–	C 16	–	C 16	–	–	–	1.0407	–
–	C15D	–	SWRM 15	–	C 15 D	FM 15	C 15 D	–	–	–	1.0413	–
–	C20D	–	SWRM 20	–	C 20 D	FM 20	C 20 D	–	–	–	1.0414	–
–	C26D	–	SWRH 27	–	C 26 D	FM 26	C 26 D	–	–	–	1.0415	–
–	C18D	–	SWRM 17	–	C 18 D	FM 18	C 18 D	–	–	–	1.0416	–
–	RSt 44-2	440	–	G10160	–	–	–	–	–	–	1.0419	–
–	P265 NB	–	SG 295	–	P 265 NB	BS 2	–	–	–	–	1.0423	–
–	P 265 GH	151-400	SG 30	K02801	P 265 GH	A42CP	P 265 GH	1430	–	–	1.0425	–
–	C 22.3	–	–	–	C 22 G 1	–	–	–	–	–	1.0427	–
–	BSt 420 S	–	–	–	Fe B 400	–	–	–	–	–	1.0428	–
–	C 21	–	SFVC 1	K03504	P 305 GH	–	–	–	–	–	1.0432	–
–	GS-45	A1	SC 450	J03001	GE 230	E23-45M	–	1305	–	–	1.0446	–
–	TStE 275 (S 275 NL)	40EE	–	–	S 275 NL	S 275 NL	S 275 NL	–	–	–	1.0491	–
–	St 42.8	–	STPT 42	–	–	–	Fe 42	–	–	–	1.0498	–
–	S 335 N (StE 355)	50 E	–	–	S 355 N	E 355	S 355 N	2134	–	–	1.0545	–
–	S 355 NL (TStE 355)	50 E E	–	–	S 355 NL	E 355	S 355 N L	2135	–	–	1.0546	–
–	R 7 S 6/C 7 RG 2	–	–	–	C 7 RG 2	–	–	–	–	–	1.0709	–
B1112	9 S 20	220 M 07	SUM 21	G 11120	–	–	CF 9 S 22	–	–	–	1.0711	–
1213	9 SMn 28/11 SMn 30	230 M 07	SUM 22	G 12130	11 SMn 28	S 250	CF 9 SMn 28	1912	–	–	1.0715	–
12L13	9 SMnPb 28	–	SUM 22 L	G 12134	11 SMnPb 28	S 250 Pb	CF 9 SMnPb 28	1914	–	–	1.0718	–
–	15 S 22/15 S 20	En32M	SUM 32	–	15 S 22	–	–	1922	–	–	1.0723	–
–	15 SMn 13	15 SMn 13	–	–	15 SMn 13	15 SMn 13	–	–	–	–	1.0725	–
1215	9 SMn 36/11 S Mn 37	240 M 07	SUM 25	G 12150	11 SMn 37	S 300	CF 9 SMn 36	–	–	–	1.0736	–
12L14	9 SMnPb 36/11 SMnPb 37	–	–	G 12144	11 SMnPb 37	S 300 Pb	CF 9 SMnPb 36	1926	–	–	1.0737	–
–	11 SMnPbTe 37	11 SMn 37	–	–	11 SMn 37	–	–	–	–	–	1.0738	–
–	15 SPb 20/15 SPb 22	–	–	–	15 SPb 22	–	–	–	–	–	1.0753	–
–	36 SMn 14	36SMn14	–	–	36SMn14	36SMn14	–	–	–	–	1.0764	–
–	C10D2	–	–	–	C 10 D 2	FM 10	C 10 D 2	–	–	–	1.1114	–
–	Cq 10 (C 10 C)	–	SWRCH 10 K	–	C 10 KD	–	–	–	–	–	1.1122	–
–	C15D2	–	–	–	C 15 D 2	FM 15	C 15 D 2	–	–	–	1.1126	–
–	C 18D2	–	–	–	C 18 D 2	FM 18	C 18 D 2	–	–	–	1.1129	–

(continued)

P1 Workpiece Materials Listing • Steel • P1 *(continued)*

P1 Low-Carbon Steels, Short Chipping, Free Machining *Content: C <.25%* *Tensile Strength RM (MPa)*: <530* *Hardness (HB): <125*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
–	GS-16 Mn 5	–	–	–	G 17 Mn 5	G 17 Mn 5	G17Mn5	–	–	–	1.1131	–
–	C20D2	–	–	–	C 20 D 2	FM 20	C20D 2	–	–	–	1.1137	–
–	C26D2	–	–	–	C 26 D 2	FM 26	C26D 2	–	–	–	1.1139	–
–	GC 16 E/GS-Ck 16	–	–	–	GC 16 E	–	–	–	–	–	1.1142	–
–	C 16 E	C 16 E	–	–	C 16 E	XC 18	–	–	–	–	1.1148	–
–	Cm 22	070 M 20	C 22 R (3 C 22)	–	3 C 22	XC 18 u	C 22 R	–	–	–	1.1149	–
–	Ck 22	050 A 20	S 22 C	G10230	2 C 22	XC 25	C 20	–	–	–	1.1151	–
–	Cq 22	–	SWRCH20K	–	C 21 KD	–	CB 20 FF	–	–	–	1.1152	–
–	Ck 25	070 M 26	S 25 C	G10250	2 C 25	XC 25	C 25	–	–	–	1.1158	–
–	C2D1	–	–	–	C 2 D 1	–	C 2 D 1	–	–	–	1.1185	–
–	19 MnVS 6	–	–	–	19 MnVS 6	–	–	–	–	–	1.1301	–
–	PS 275 TM	S 275 M	–	–	S 275 M	S 275 M	S 275 M	–	–	–	1.8818	–
–	DI-MC 355 B	–	–	–	S 355 M	E 355	S 355 M	–	–	–	1.8823	–
–	DI-MC 420 B	S 420 M	–	–	S 420 M	E 420	S 420 M	–	–	–	1.8825	–
–	S 460 M	S 460 M	–	–	S 460 M	E460;S460M	S460M	–	–	–	1.8827	–
–	BTStE 355 TM	S 355 ML	–	–	S 355 ML	E 355	S 355 ML	–	–	–	1.8834	–
–	BTStE 420 TM	S 420 MI	–	–	S 420 ML	E 420	S 420 ML	–	–	–	1.8836	–
–	S 235 J 0 W (Allwesta 360)	S 235 J 0 W	SMA 400 BW	–	S 235 JO W	S 235 J 0 W	–	–	–	–	1.8958	–
–	S 355 J 0 W (Allwesta 510)	WR 50 B	SMA 490 BW	–	S 235 JO W	E24W-3	S 235 JO W	–	–	–	1.8959	–
–	WTSt 37-2/S235JRW	WR 50 B	SMA 41 A	K11538	S 235 JR W	E 24 W-2	–	–	–	–	1.8960	–
–	WTSt 37-3	WR 50 C	SMA 50 A	–	S 235 J2 W	S 235 J 2 W	Fe 360 D FF	–	–	–	1.8961	–
–	USt 42-2	–	SS 41	–	–	HS 18-0-2-10	–	–	–	–	1.0040	–
–	St 37-2	–	–	–	S 235 JRC	E 24-2	S 235 JRC	–	–	–	1.0120	–
–	S 235 JR G1F	–	–	–	S 235 JRG 1 F	–	–	–	–	–	1.0160	–
–	St 12	DC 01/Fe P01	SPCC	–	Fe P01	DC 01/fe P01	DC 01/FeP0 1	–	–	–	1.0330	–
–	GS-38	A1	–	–	GE 200	230-400M	–	1306	–	–	1.0420	–
–	GS-20 Mn 5	–	SMnC 420	H15220	–	–	–	–	–	–	1.1120	–
–	G 20 Mn 5	–	–	–	G 20 Mn 5	–	G 20 Mn 5	–	–	–	1.6220	–

P2 Workpiece Materials Listing • Steel • P2

P2 Medium- and High-Carbon Steels *Content: C >.25%* *Tensile Strength RM (MPa)*: >530* *Hardness (HB): <220 (HRC): <25*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
–	S 355 JR	En 50 B	SM 490 YA	–	S 1207	E36-2	Fe 510 BFN	–	–	–	1.0045	–
1035	C 35	060 A 35	S 35 C	G 10350	1 C 35	CC 35	C 35	1550	–	–	1.0501	–
1045	GS-C 45	080 M 46	S 45 C	G10450	1 C 45	CC 45	C 45	1650	–	–	1.0503	–
1040	C 40	080 M 40	S 40 C	G 10 400	1 C 40	C 40	C 40	–	–	–	1.0511	–
1046	S 355 K 2 G 4 Cu	–	–	G10460	S 355 K2 G4 Cu	–	–	–	–	–	1.0519	–
1030	C30	080 M 30	SUP 7	G 10 300	1 C 30	C C 32	C 30	–	–	–	1.0528	–
1055	C 55	070 M 55	S 55 C	J05000	1 C 55	C 55	C 55	1655	–	–	1.0535	–
1551	C 50 Pb	–	–	G15510	C 50 G Pb	–	–	–	–	–	1.0542	–
–	GS-60	A3	–	–	GE 300	320-560M	C 45	1606	–	–	1.0558	–
1037	36 Mn4	170 H 36	–	G10370	–	–	–	–	–	–	1.0561	–
–	PSt 52-3 (S 355 J2 G3 F)	–	–	–	S 355 J2 G3 F	–	FE 510 C	–	–	–	1.0572	–
–	S 355 J2H (RoSt 52-3)	50D	–	–	S355J2H	–	S355J2H	–	–	–	1.0576	–
1060	C 60	080 A 62	S 60 C-CSP	G 10600	1 C 60	AF 70 C 55	C 60	–	–	–	1.0601	–
1070	C 67	CS 70	S 70 C -CSP	G10700	1 CS 67	C 68	C 67	–	–	–	1.0603	–
1074	C 75	CS 80	–	G10740	1 CS 75	C 75	C 75	–	–	–	1.0605	–
1059	C58D	–	S 58 C	G10590	C 58 D	FM 58	C 58 D	–	–	–	1.0609	–
1075	C76D	–	–	G10750	C 76 D	FM 76	C 76 D	–	–	–	1.0614	–
1080	C86D	CS 80	–	G10860	C 86 D	FM 86	C 86 D	–	–	–	1.0616	–
1095	C92D	95 CS	–	G10950	C 92 D	–	C 92 D	–	–	–	1.0618	–
1110	U 10 S 10	–	SUM 12	G11100	–	–	–	–	–	–	1.0702	–
11L08	10 SPb 20	–	–	G 11084	10 SPb 20	10 Pb F 2	CF 10 SPb 20	–	–	–	1.0722	–
1140	35 S 20	212 M 36	–	G 11400	35 S 20	35 MF 4	–	1957	–	–	1.0726	–
1146	45 S 20	212 M 44	–	G 11460	45 S 20	45 MF 4	–	1973	–	–	1.0727	–
1151	60 S 20	–	–	G11510	60 S 20	60 MF 4	–	–	–	–	1.0728	–
1141	36 Mn 6	212 M 36	S Mn 443	G 11410	–	–	–	–	–	–	1.1127	–
1039	40 Mn 4	150 M 36	–	G10390	–	35 M 5	–	–	–	–	1.1157	–
1536	34 Mn 5	En15B	SS 55	G15360	–	–	–	–	–	–	1.1166	–
1030	Cq 35	–	F.1133 (C 35 DF)	G 10300	C 35 KD	–	CB 35	–	–	–	1.1172	–
1034	Ck 34	080 M 34	S 34 C	G 10340	2 C 34	–	C 34	–	–	–	1.1173	–
1038 H	Ck 38	–	–	G 10380	–	XF 38	–	–	–	–	1.1176	–
1030	Ck 30	080 M 30	S 30 C	G 10300	2 C 30	XC 32	C 30	–	–	–	1.1178	–
1034	Ck 35	080 M 36	S 35 C	G 10340	2 C 35	XC 38 H1	C 35	1572	–	–	1.1181	–
1035	Cf 35	060 A 35	S 35 C	G 10350	C 35 G	XC 38 TS	C 35	1572	–	–	1.1183	–
1040	Ck 40	080 A 40	S 40 C	G 10400	2 C 40	XC 42 H1	C 40	–	–	–	1.1186	–
1045	Cf 45	060 A 47	S 45 C	G10450	C 45 G	XC 42 TS	C 43	1672	–	–	1.1193	–
1055	Ck 55	070 M 55	S 55 C	G10550	2 C 55	XC 55 H1	C 55	1655	–	–	1.1203	–
1050	Ck 50	080 M 50	S 50 C	G10500	2 C 50	XC 48 H1	C 50	1674	–	–	1.1206	–
1055	Cm 55	070 M 55	–	G 10550	3 C 55	XC 55 H1	C 55 R	–	–	–	1.1209	–
1053	Ck 53	En43C	S 53 C	G 10530	–	–	–	–	–	–	1.1210	–
1050	Cf 53	060 A 57	S 50 C	G 10500	C 53 G	XC 48 TS	C 48	1674	–	–	1.1213	–
1060	Ck 60	060 A 62	S 58 C	G 10640	2 C 60	XC 60	C 60	1678	–	–	1.1221	–
1552	52 Mn 5	–	–	G15520	–	–	–	–	–	–	1.1226	–
1065	FD (Federstahldraht)	095 A 65	–	G10650	C 68 D	–	–	–	–	–	1.1230	–
1070	Ck 67	060 A 67	S 70 C-CSP	G 10700	C 67 S	XC 68	C 70	1770	–	–	1.1231	–
1069	Ck 68	–	–	G10690	C 70 D	–	–	–	–	–	1.1234	–
1080	Ck 75	060 A 78	C 75	G 10800	C 75 S	XC 75	C 75	1774	–	–	1.1248	–
–	Cf 70	–	–	–	C 70 G	XC 70	–	–	–	–	1.1249	–
1090	Ck 85	–	SK 5 -CSP	G 10900	C 85 S	XC 90	C 90	–	–	–	1.1269	–
1085	90 Mn 4	080 A 83	SUP4	G 10850	–	–	–	–	–	–	1.1273	–
1095	Ck 101	060 A 96	SUP_4	G 10950	C 100 S	XC 100	C 100	1870	–	–	1.1274	–
1050	C 50	080 M 50	S 50 C	G 10 500	1 C 50	C 50	C 50	1674	–	–	1.0540	–
–	St 52-3 G	4360-50 B	SM 50 YB	–	S 355 J 2 G 3	E 36-3	Fe 510 B	2132	–	–	1.0570	–
1078	C78D	–	SWRH 77 B	G10780	C 78 D	FM 78	C 78 D	–	–	–	1.0620	–
1035	Cm 35	080 M 36	–	G 10350	3 C 35	38 H1 k	C 35 R	1572-03	–	–	1.1180	–
1566	66 Mn 4	–	–	G15660	–	–	–	–	–	–	1.1260	–
1084	C 85 W	–	SK 5	G10840	C 90 U	Y3 90	–	–	–	–	1.1830	–

NOTE: For legend, see page Y217.

P3 Workpiece Materials Listing • Steel • P3

P3 Alloy Steels and Tool Steels *Content: C >.25%* *Tensile Strength RM (MPa)*: 600–850* *Hardness (HB): <330 (HRC): <35*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
1330	GS-30 Mn 5	120 M 36	SMn 433 H; SCMn 2	K13300	–	35 M 5	–	1330	–	–	1.1165	–
1330	28 Mn 6	150 M 28	SCMn 1	G 13300	28 Mn 6	35 M 5	C 28 Mn	–	–	–	1.1170	–
1335	36 Mn 5	150 M 36	SMn 438(H)	G13350	–	40 M 5	–	2120	–	–	1.1167	–
1345	StSch 90 C/GP 280 GH	–	–	G13450	GP 280 GH	GP 280 GH	GP 280 GH	–	–	–	1.0625	–
1513	P265	HR 40/30	–	G15130	–	12 M 5	–	–	–	–	1.0424	–
4142	43 CrMo 4	–	–	G41420	–	43 Cr Mo 4	–	–	–	–	1.3563	–
4147	48 CrMo 4	817 M 40	SNC 836	H41470	–	48 CrMo 4	–	–	–	–	1.3565	–
4419	GS-22 Mo 4	243-430	SCPH 11	G44190	G 20 Mo 5	G20Mo5	G 22 Mo 5	–	–	–	1.5419	–
4520	16 Mo 5	1503-245-420	SBC 690	K11522	–	–	16 Mo 5	–	–	–	1.5423	–
5015	15 Cr 3	523 M15	SCr 415 H	G50150	15 Cr 2	12 C 3	–	–	–	–	1.7015	–
5046	44 Cr 2	–	–	H50460	46 Cr 1 KD	44 Cr 2	–	–	–	–	1.3561	–
5115	16 MnCr 5	527 M 17	SCR 415	G 51150	16 MnCr 5 KD	16 MC 5	16 MnCr 5	2173	–	–	1.7131	–
5117	17 Cr 3	17 Cr 3	–	G51170	(15 Cr 2 KD)	18 C 3	–	–	–	–	1.7016	–
5130	28 Cr 4	530 A 30	–	G51300	28 Cr 4	30 CD 4	–	–	–	–	1.7030	–
5140	41 Cr 4	530 M 40	SCr 440 H	G51400	41 Cr 4	42 C 4	41 Cr 4	–	–	–	1.7035	–
5140	42 Cr 4	530 A 40	SCr 440	–	40 NiCrMo 3	42 C 4 TS	40 NiCrMo 3	2245	–	–	1.7045	–
9255	51 Si 7	250 A 53	–	G92550	–	51 S 7	48 Si 7	2090	–	–	1.0903	–
9255	55 Si 7	250 A 53	SKH 1; SKT 4	G92550	55 NiCrMoV 7	55 S 7	55 Si 8	2085	–	–	1.0904	–
9260	60 Si 7	251 A 60	–	G92600	60 Si 7	60 S 7	60 Si 7	–	–	–	1.5027	–
9262	60 SiCr 7	250 A 61	SUP 7	G92620	60 SiCr 8	60 SC 7	60 SiCr 8	–	–	–	1.0961	–
9262	60 SC 7	–	–	G92620	60 SiCr 8	61 SC 7	60 SiCr 8	–	–	–	1.5092	–
9262	60 SiCr 7	–	–	–	60 SiCr 8	–	–	–	–	–	1.7108	–
15B21 H	19 MnB 4	170 H 20	SWRCHB 420	H15211	19 MnB 4	20 MB 5	–	–	–	–	1.5523	–
15B21 H	20 MnB 5	–	SWRCHB 620	–	20 MnB 5	20 MnB 5	20 MnB 5	–	–	–	1.5530	–
50B40	37 CrB 1	120 M 36	SMnC 3 H	H50401	38 Cr 2	–	35 CB 1	–	–	–	1.7007	–
5130 H	34 Cr 4	530 A 32	SCr 430 H	G51300	34 Cr 4 KD	32 C 4	34 Cr 4 KB	–	–	–	1.7033	–
5132 H	37 Cr 4	530 A 36	SCr 435 H	G51320	37 Cr 4	38 C 4	36 CrMn 4	–	–	–	1.7034	–
A 204 Gr. A	15 Mo 3	1501-240	STFA 12	K11820	16 Mo 3	15 D3	16 Mo 3 KW	2912	–	–	1.5415	–
A 350-LF 5	10 Ni 14	503	SL 3 N 26	K31718	12 Ni 14	12Ni14	18 Ni 14 KT	–	–	–	1.5637	–
A 387 Gr. 12 Cl. 2	16 CrMo 4 4	–	–	K11564	–	–	A 18 CrMo 4 5 KW	–	–	–	1.7337	–
A 570 Gr. 36	St 37-3	4360-40 C	–	K01501	S 235 J2 G3	Fe 360 D1(2); E 24-3	Fe 360 D1(2)	1312	–	–	1.0116	–
A 570 Gr. 40	St 44-2	4360-43 B	SM 41 B	K 02502	S 275 JR	E 28-2	Fe 430 BFN	1412	–	–	1.0044	–
A 570 Gr. 50	St 50-2	4360-50 B	SS 50	–	E 295	A 50-2	Fe 490	2172	–	–	1.0050	–
A 573 Gr. 70	St 44-3	4360-43 C	SM 41 B	–	Fe 430 D1(2); S 275 J2 G3 (4)	Fe 430 D1(2); E 28-4	Fe 430 D FF	1414	–	–	1.0144	–
A 633 Gr. C	St E 355	P 355 N	SM 50 YB	K12000	P 355 N	E 355 R/FP	Fe E 355 KG	2132	–	–	1.0562	–
A 633 Gr. E	St E 420	S 420 N	SM 50 C	K02002	FeE 420 KGN	E 420-I	Fe E 420 KG	2143	–	–	1.8902	–
A 633 Gr. E	St E 460	P 460 N	SM 53 B	K02900	P 460 N	E 460-I	Fe E 460 KG	2143	–	–	1.8905	–
A-6	C 67 W	–	–	T30106	–	Y1 70	–	–	–	–	1.1744	–
E 52100	100 Cr 6	535 A 99	SUJ 2	G52986	100 Cr 6	100 C 6	100 Cr 6	2258	–	–	1.3505	–
O 2	90 MnCrV 8	BO 2	–	T31502	90 Mn V 8	90 MV 8	90 MnVCr 8 KU	–	–	–	1.2842	–
P21	90 Cr 3	–	–	T51621	–	–	–	–	–	–	1.2056	–
P3	10 NC 6	–	–	T51603	15 NiCr 6	10 NC 6	–	–	–	–	1.5713	–
P6	15 NiCr 14	–	SNC 22	T51606	–	10 NC 12	–	–	–	–	1.2735	–
T 8	C 80 W2	BW 1B	SKC 3	T12008	–	Y1 80	C 80 KU	–	–	–	1.1625	–
W 108	C 80 W1	–	–	T72301	C 80 U	Y1 90	C 80 KU	1880	–	–	1.1525	–
W 110	C 105 W1	B W 1 A	–	T72301	C 105 U	Y 105	C 100 KU	1880	–	–	1.1545	–
W 112	C 125 W	–	–	–	C 125 U	–	–	–	–	–	1.1563	–
W 112	C 125 W	–	SK 2	T72301	C 120 U	Y2 120	C 120 KU	–	–	–	1.1663	–
W 210	100 V 1	BW 2	SKS 43	T72302	100 V 2	Y1 105 V	102 V 2 KU	–	–	–	1.2833	–
–	St 50-1	–	–	–	–	–	–	–	–	–	1.0052	–
–	S 235 JO/ Fe 360 C	En 40C	–	–	S 235 JO	E24-3	Fe 360 CFN	–	–	–	1.0114	–
–	QSt 37-3	–	SWRCH 12R	–	–	–	–	–	–	–	1.0123	–
–	S 275 J0	En43C; S275J0	–	–	S 275 J0/ Fe 430 C	S 275 J0; E 28-3	S275J0; Fe430CFN	–	–	–	1.0143	–
–	S 275 J2 G4/ Fe 430 D 2	S 275 J2 G4	–	–	S 275 J2 G4	E28-4; S 275 J2 G4	S 275 J2 G4	1414	–	–	1.0145	–
–	Ro St 44-2	43C	–	–	S 275 J0 H	–	S 275 J0 H	–	–	–	1.0149	–
–	St 37.0	–	STPG 38	–	P 235 T1	–	–	–	–	–	1.0254	–
–	C9D	–	SWRM 8	–	C 9 D	FM 9	C 9 D	–	–	–	1.0304	–
–	C7D	C 7 D	SWRM 8	G10060	C 7 D	FM 8	C 7 D	–	–	–	1.0313	–
–	P235 GH	P 235 GH	SPV 50	K02503	P 235 GH	A 37 CP	Fe E 235	1330	–	–	1.0345	–
–	C 25 Pb	–	–	–	C 25 GPb	–	–	–	–	–	1.0411	–
–	L 245 MB	430	–	K03006	L 245 MB	L 245 MB	–	–	–	–	1.0418	–
–	P310 NB	224-410	SG 325	K02100	P280GH	BS 2	P 275 N	2103	–	–	1.0426	–
–	L 290 MB	–	–	–	L290MB	L 290 MB	–	–	–	–	1.0429	–
–	H III/P285NH	–	Sm 38	–	P 285 NH	–	–	–	–	–	1.0435	–
–	P310 NB	224-430	SG 325	K02100	P305GH	P 275 N	P 275 N	2103	–	–	1.0436	–
–	A St 41	P 275 N	STK 400	K02100	S 275 N	BS 3	P 275 N	2103	–	–	1.0437	–
–	B 500 A	–	SD 490	–	B 500 A	–	B 500 A	–	–	–	1.0438	–
–	H IV/P295NH	–	SG 37	K03102	–	–	Fe 460-2 KW	–	–	–	1.0445	–
–	StE 240.7	–	–	–	L 245 NB	L 245 NB	–	–	–	–	1.0457	–
–	TStE 255	–	–	K11535	–	–	–	–	–	–	1.0463	–
–	15 Mn 3 Al	–	–	–	C 14 GAl	–	–	–	–	–	1.0468	–
–	19 Mn 6/P 355 GH	P 355 GH	SGV 46	K03300	P355GH	A 52 CP	Fe E355-2	2101	–	–	1.0473	–
–	17 Mn 4/P 295 GH	224-460B	SG 37	K03501	P 295 GH	A 48 CP	Fe E 295	2102	–	–	1.0481	–
–	19 Mn 5	224-460	SG 37	K 03102	–	A 52 CP; AP; FP	Fe 460- 2 KW	–	–	–	1.0482	–
–	L 290 AG	–	–	–	L290GA	TS E 290	–	–	–	–	1.0483	–
–	L 290 NB	–	–	–	L290NB	L 290 NB	–	–	–	–	1.0484	–
–	21 Mn 6	–	–	K12320	–	–	–	–	–	–	1.0485	–
–	St E 285	P 275 N	SM 41 A	K 01802	P 275 N	P 275 N	Fe E 285 KG	–	–	–	1.0486	–
–	W St E 285	P 275 N	–	K 01802	P 275 NH	P 275 N	Fe E 285 KW	–	–	–	1.0487	–
–	T St E 285	P 275 NL 1	SLA 235 A	K 01803	P 275 NL 1	P 275 NL 1	Fe E 285 KT	–	–	–	1.0488	–
–	H 300/ZSt E 300	H280LA	–	–	H 280 LA	E 280 C	–	–	–	–	1.0489	–
–	S 275 NH	S 275 NH	–	–	S 275 NH	–	S 275 NH	–	–	–	1.0493	–
–	S 275 NLH	S275NLH	–	–	S 275 NLH	–	S275NLH	–	–	–	1.0497	–
–	C 35 Pb/C 35 GPb	–	–	–	C 35 Pb	–	–	–	–	–	1.0502	–
–	St E 315/P 315N	–	SM 50 A	K11506	P 315 N	–	Fe E 315 KG	–	–	–	1.0505	–
–	W St E 315	–	SNC 1	K02404	P 315 NH	–	Fe E 315 KW	2107	–	–	1.0506	–
–	St 55	–	STKM 16A	–	–	–	Fe 540	–	–	–	1.0507	–
–	T St E315	–	SLA 325 A	K02404	P 315 NL	–	–	2106	–	–	1.0508	–
–	C 40 Pb	–	–	–	C 40 G Pb	–	–	–	–	–	1.0512	–
–	C38D	–	SWRH 37	–	C 38 D	FM 38	C 38 D	–	–	–	1.0516	–
–	C48D	–	SWRH 48	–	C 48 D	FM 48	C 48 D	–	–	–	1.0517	–
–	C56D	–	–	–	C 56 D	FM 56	C 56 D	–	–	–	1.0518	–
–	S 355 NH	S 355 NH	–	–	S 355 NH	–	S 355 NH	–	–	–	1.0539	–
–	C42D	–	SWRH 42 B	–	C 42 D	FM 42	C 42 D	–	–	–	1.0541	–
–	S 355 JO H	50 C	–	–	S 355 JO H	–	S 355 JO H	–	–	–	1.0547	–
–	ZStE 340/ H 340	H 320 L A	–	–	H 320 LA	E 315 C	–	–	–	–	1.0548	–
–	S 335 NLH	50 EE	–	–	S 355 N LH	–	S 355 N L H	–	–	–	1.0549	–
–	S 355 JO	En 50 C; S 355 JO	SM 520 M	–	S 355 JO	S 355 JO; E 36-3	S 355 JO; Fe 510 C FN	–	–	–	1.0553	–
–	GS-70	50 C	–	–	S 355 JO C	E 36-3	Fe 510 C	–	–	–	1.0554	–

(continued)

P3 Workpiece Materials Listing • Steel • P3 *(continued)*

P3 Alloy Steels and Tool Steels *Content: C >.25%* *Tensile Strength RM (MPa)*: 600–850* *Hardness (HB): <330 (HRC): <35*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
–	ZStE 420/H 420	46/40HR, HS, CS	–	–	H 400 LA	H 400 LA	–	–	–	–	1.0556	–
–	P355 NB	–	SG 365	–	P 355 NB	BS 4	–	–	–	–	1.0557	–
–	W St E 355	P 355 NH	–	K01600	P 355 NH	P 355 NH	Fe E 355 KW	–	–	–	1.0565	–
–	T St E355	P 355 NL1	SLA 37	–	P 355 NL1	P 355 NL1	Fe E 355 KT	–	–	–	1.0566	–
–	P355 QH1	P 355 QH	–	–	P 355 QH	P 355 QH	–	–	–	–	1.0571	–
–	S 355 J 2 G 4	S 355 J 2 G 4	–	–	S 355 J 2 G 4	S 355 J 2 G 4	S 355 J 2 G 4	–	–	–	1.0577	–
–	L 360 MB	–	–	–	L 360 MB	L 360 MB	–	–	–	–	1.0578	–
–	St 52.4	–	STS 49	–	–	–	–	–	–	–	1.0581	–
–	L 360 NB/StE 360.7	–	–	–	L360NB	L 360 NB	–	–	–	–	1.0582	–
–	S 355 J 2 G 3 Cu/St 52-3 Cu3	–	–	–	S 355 J2 G3 Cu + CR	–	–	–	–	–	1.0585	–
–	C50D	–	–	–	C 50 D	FM 50	C 50 D	–	–	–	1.0586	–
–	QSt 52-3 Cu 3	–	–	–	S 355 J2 G3 Cu C	–	–	–	–	–	1.0587	–
–	D 53-2	–	SWRH 52 B	–	C 52 D	FM 52	C 52 D	–	–	–	1.0588	–
–	S 355 J 2 G 4 Cu	–	–	–	S 355 J2 G4 Cu	–	–	–	–	–	1.0592	–
–	S355k2G3/Fe 510 DD1 (MULTIST)	S 355 K 2 G 3	SM 520 C	K02505	S 355 K 2 G 3	E36-4	S 355 K 2 G 3	–	–	–	1.0595	–
–	S355K2G4/Fe 510 DD 2 (MULTIST)	S 355 K 2 G 4	–	–	S 355 K 2 G 4	S 355 K 2 G 4	S 355 K 2 G 4	–	–	–	1.0596	–
–	C62D	–	SWRH 62 B	–	C 62 D	FM 62	C 62 D	–	–	–	1.0611	–
–	C66D	–	–	–	C 66 D	FM 66	C 66 D	–	–	–	1.0612	–
–	C68D	–	SWRH 67 B	–	C 68 D	FM 68	C 68 D	–	–	–	1.0613	–
–	C70D	–	–	–	C 70 D	FM 70	C 70 D	–	–	–	1.0615	–
–	C72D	–	SWRH 72 B	–	C 72 D	FM 72	C 72 D	–	–	–	1.0617	–
–	GS-C 25	–	SCPH 1	–	GP 240 GH	GP 240 GH	GP 240 Gh	–	–	–	1.0619	–
–	C80D	–	–	–	C 80 D	FM 80	C 80 D	–	–	–	1.0622	–
–	C82D	–	SWRH 82 B	–	C 82 D	FM 82	C 82 D	–	–	–	1.0626	–
–	35 SPb 20	35 SPb 20	–	–	35 SPb 20	35 SPb 20	–	–	–	–	1.0756	–
–	45 SPb 20	–	–	–	46 SPb 20	–	–	–	–	–	1.0757	–
–	38 SMnPb 28	38 SMnPb 28	–	–	38 SMnPb 28	38 SMnPb 28	–	–	–	–	1.0761	–
–	44 SMn 28	44 SMn 28	–	–	44 SMn 28	44 SMn 28	–	–	–	–	1.0762	–
–	44 SMnPb 28	44 SMnPb 28	–	–	44 SMnPb 28	44 SMnPb 28	–	–	–	–	1.0763	–
–	36 SMnPb 14	36 SMnPb 14	–	–	36 SMnPb 14	36 SMnPb 14	–	–	–	–	1.0765	–
–	QSt E 690 TM (S 700 MC)	–	–	–	S 700 MC	S 690 MC	S 700 MC	–	–	–	1.0966	–
–	QSt E 260 N 7 S 260 NC	–	AE 275 NC	–	S 260 NC	–	S 260 NCX	–	–	–	1.0971	–
–	QSt E 300 TM/S 315 MC	43 F35 HR, HS, CS	–	–	S 315 MC	E 315 D	S 315 MC	–	–	–	1.0972	–
–	QSt E 300 N 7/ S 315 NC	–	AE 340 NC	–	S 315 NC	–	S 315 NC	–	–	–	1.0973	–
–	QSt E340 TM	HR 40/30	–	–	S 340 MC	E 335 D	–	–	–	–	1.0974	–
–	QSt E340 N	–	–	–	S 340 NC	–	Fe E 355 TD	–	–	–	1.0975	–
–	QSt E 360TM	–	–	–	S 355 MC	E 355 D	Fe E 355 TM	–	–	–	1.0976	–
–	QSt E360 N	–	–	–	S 355 NC	–	Fe E 355 TD	–	–	–	1.0977	–
–	QSt E380 TM	–	–	–	S 380 MC	E 390 D	–	–	–	–	1.0978	–
–	QSt E380 N	–	–	–	S 380 NC	–	Fe E 380 TD	–	–	–	1.0979	–
–	QSt E420 TM	HR 50 F 45	–	–	S 420 MC	E 430 D	Fe E 420 TM	–	–	–	1.0980	–
–	QSt E 420 N	–	–	–	S 420 NC	–	Fe E 420 TD	–	–	–	1.0981	–
–	QSt E 460 TM	50/45 HR	–	–	S 460 MC	E 445 D	–	–	–	–	1.0982	–
–	QSt E 460 N	–	–	–	S 460 NC	–	Fe E 460 TD	–	–	–	1.0983	–
–	QSt E500 TM	–	–	–	S 500 MC	E 490 D	Fe E 490 TM	2662	–	–	1.0984	–
–	QSt E500 N	–	–	–	S 500 NC	–	–	–	–	–	1.0985	–
–	QSt E550 TM	60/55 HS	–	–	S 550 MC	E 560 D	Fe E 560 TM	–	–	–	1.0986	–
–	QSt E550 N	–	–	–	S 550 NC	–	–	–	–	–	1.0987	–
–	EStE 285	P 275 NL 2	STK 400	–	P 275 NL 2	P 275 NL 2	P 275 NL 2	–	–	–	1.1104	–
–	EStE 315	–	–	–	S 315 NL 1	–	–	–	–	–	1.1105	–
–	EStE 355	P 355 NL 2	STK 500	–	P 355 NL 2	P 355 NL 2	P 355 NL 2	–	–	–	1.1106	–
–	C5D2	–	–	–	C 5 D 2	FM 6	C 5 D 2	–	–	–	1.1111	–
–	C8D2	–	–	–	C 8 D 2	FM 8	C 8 D 2	–	–	–	1.1113	–
–	C 10 E W/RSD 11	–	–	–	C 10 EW	–	–	–	–	–	1.1115	–
–	C32D2	–	–	–	C 32 D 2	FM 32	C 32 D 2	–	–	–	1.1143	–
–	C36D2	–	–	–	C 36 D 2	FM 36	C 36 D 2	–	–	–	1.1145	–
–	C40D2	–	–	–	C 40 D 2	FM 40	C 40 D 2	–	–	–	1.1153	–
–	C42D2	–	–	–	C 42 D 2	FM 42	C 42 D 2	–	–	–	1.1154	–
–	C46D2	–	–	–	C 46 D 2	FM 46	C46D 2	–	–	–	1.1162	–
–	C 25 R	C 25 R	–	–	C 25 R	C 25 R	C 25 R	–	–	–	1.1163	–
–	C48D2	–	–	–	C 48 D 2	FM 48	C48 D 2	–	–	–	1.1164	–
–	20 Mn 6	150 M 19	–	–	–	20 M 5	20 Mn 6	–	–	–	1.1169	–
–	C50D2	–	–	–	C 50 D 2	FM 50	C50D 2	–	–	–	1.1171	–
–	C 30 R	C 30 R	C 30 R (3 C 30)	–	C 30 R	C 30 R	C 30 R	–	–	–	1.1179	–
–	C3D1	–	–	–	C 3 D 1	–	C 3 D 1	–	–	–	1.1187	–
–	C40R/Cm 40	C 40 R	–	–	C 40 R	C 40 R	C 40	–	–	–	1.1189	–
–	Ck 45	080 M 46	S 45 C	–	2 C 45	XC 42	C 40	1672	–	–	1.1191	–
–	Cq 45	–	SWRCH45K	–	C 45 KD	–	–	–	–	–	1.1192	–
–	C 45 R	080 M 46	S 50 C	–	C 45 R	XC 48 H1u	C 45 R	1672	–	–	1.1201	–
–	C52D2	–	–	–	C 52 D 2	FM 52	C 52 D 2	–	–	–	1.1202	–
–	C 53 R/Cm 53	–	–	–	C 53 R	–	–	–	–	–	1.1205	–
–	C 10 R	C 10 R	–	–	C 10 R	C 10 R	–	–	–	–	1.1207	–
–	C 16 R	C 16 R	–	–	C 16 R	C 16 R	–	–	–	–	1.1208	–
–	C58D2	–	–	–	C 58 D 2	FM 58	C 58 D 2	–	–	–	1.1212	–
–	C62D2	–	–	–	C 62 D 2	FM 62	C 62 D 2	–	–	–	1.1222	–
–	Cm 60	C 60 R	–	–	3 C 60	C 60 R	C 60 R	–	–	–	1.1223	–
–	C60D2	–	–	–	C 60 D 2	FM 60	C 60 D 2	–	–	–	1.1228	–
–	C68D2	–	–	–	C 68 D 2	FM 68	C 68 D 2	–	–	–	1.1232	–
–	C66D2	–	–	–	C 66 D 2	FM 66	C 66 D 2	–	–	–	1.1236	–
–	C50R	C 50 R	–	–	C 50 R	FM 50	C 50 R	–	–	–	1.1241	–
–	C72D2	–	–	–	C 72 D 2	FM 72	C 72 D 2	–	–	–	1.1242	–
–	C70D2	–	–	–	C 70 D 2	FM 70	C 70 D 2	–	–	–	1.1251	–
–	C78D2	–	–	–	C 78 D 2	FM 78	C 78 D 2	–	–	–	1.1252	–
–	C76D2	–	–	–	C 76 D 2	FM 76	C 76 D 2	–	–	–	1.1253	–
–	C80D2	–	–	–	C 80 D 2	FM 80	C 80 D 2	–	–	–	1.1255	–

NOTE: For legend, see page Y217.

(continued)

P3 Workpiece Materials Listing • Steel • P3 *(continued)*

P3 Alloy Steels and Tool Steels *Content: C >.25%* *Tensile Strength RM (MPa)*: 600–850* *Hardness (HB): <330 (HRC): <35*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
–	C82D2	–	–	–	C 82 D 2	FM 82	C 82 D 2	–	–	–	1.1262	–
–	C86D2	–	–	–	C 86 D 2	FM 86	C 86 D 2	–	–	–	1.1265	–
–	C88D2	–	–	–	C 88 D 2	–	C 88 D 2	–	–	–	1.1272	–
–	C92D2	–	–	–	C 92 D 2	–	C 92 D 2	–	–	–	1.1282	–
–	C98D2	–	–	–	C 98 D 2	–	C 98 D 2	–	–	–	1.1283	–
–	46 MnVS 6	–	–	–	46 MnVS 6	–	–	–	–	–	1.1304	–
–	C 90 U	–	–	–	C90U	–	–	–	–	–	1.1535	–
–	85 Cr 1	–	–	–	–	Y1 100 C 2	–	–	–	–	1.2004	–
–	140 Cr 3	–	SKS 8	–	140 Cr 2	Y2 140 C	–	–	–	–	1.2008	–
–	21 MnCr 5	–	SCR 420 H	–	21 MnCr 5	20 NC 5	–	–	–	–	1.2162	–
–	40 CrMnNiMo 8 6 4	–	–	–	40 CrMnNiMo 8-6-4	–	–	–	–	–	1.2738	–
–	16 CrNiMo 6	820A16	–	–	–	16 NCD 6	16NiCrMo6	–	–	–	1.3531	–
–	100 CrMn 7 3	–	–	–	100 CrMnMo 7	100 CD 7	–	–	–	–	1.3536	–
–	100 CrMo 7	–	SUS 4	K19965	100 CrMo 7	100 CD 7	100CrMo7	–	–	–	1.3537	–
–	100 CrMnMo 8	–	–	–	–	100 CrMnMo 8	–	–	–	–	1.3539	–
–	46 Si 7	–	–	–	45 Si	46 S 7	–	–	–	–	1.5024	–
–	55 Si 7	250 A 53	–	G92550	56 Si 7	55 S 7	55 Si 8	2085	–	–	1.5026	–
–	37 MnSi 5	–	–	–	–	38 MS 5	–	F.130.A	–	–	1.5122	–
–	15 MnMoV 4 5	–	–	–	15 MnMoV 4-5	15 MDV 4.05	–	–	–	–	1.5402	–
–	11 MnMo 4 5	–	–	K11123	11 MnMo 45 KE	–	–	–	–	–	1.5425	–
–	13 MnMo 6 5	–	–	K11424	11 MnMo 65 KE	–	–	–	–	–	1.5426	–
–	35 B 2	–	SWRCHB 237	–	C 35 B	35 B 3	–	–	–	–	1.5511	–
–	24 Ni 8	–	SCPL 21	J22501	G 9 Ni 10	22 N 8	G9Ni10	–	–	–	1.5633	–
–	10 NiCr 5 4	10NiCr5-4	–	–	10 NiCr 5-4	10 NiCr 5-4	–	–	–	–	1.5805	–
–	18 MnMoNi 5 5	–	–	–	18 MnMoNi 5-5	–	–	–	–	–	1.6308	–
–	20 MnMoNi 4 5	–	SQV 2 B	K12539	20 MnMoNi 4-5	–	–	–	–	–	1.6311	–
–	15 MnCrMoNiV 5 3	–	–	–	15 MnCrMoNiV 5-3	–	–	–	–	–	1.6920	–
–	17 CrS 3	17 CrS3	–	–	17 CrS 3	17 CrS 3	–	–	–	–	1.7014	–
–	28 CrS 4	–	–	–	28CrS4	28CrS4	–	–	–	–	1.7036	–
–	34 CrS 4	34 CrS 4	–	–	34 CrS 4	34 CrS 4	34 CrS 4	–	–	–	1.7037	–
–	41 CrS 4	41 CrS 4	–	–	41 CrS 4	41 CrS 4	41 CrS 4	2245	–	–	1.7039	–
–	38 Cr 4	–	–	–	38 Cr 4	–	38 Cr 4	–	–	–	1.7043	–
–	16 CrMo 4	18 CrMo4	SCM 418 H	–	18 CrMo 4	15 CD 3.5	18 CrMo 4	–	–	–	1.7242	–
–	12 CrMo 11 10	–	–	–	–	–	–	–	–	–	1.7305	–
–	22 CrMoS 3 5	–	–	–	22 CrMoS 3-5	22 CrMoS 3-5	–	–	–	–	1.7333	–
–	12 CrMo 19 5	3606-625	SCMV 6	K41545	X 12 CrMo 5	Z 10 CD 5.05	16 CrMo 20 5	–	–	–	1.7362	–
–	X 7 CrMo 6 1	B 5	–	S50281	CM 5-IG	–	–	–	–	–	1.7373	–
–	51 CrMoV 4	–	–	–	51 CrMoV 4	51 CDV 4	51 CrMoV 4	–	–	–	1.7701	–
–	21 CrMoV 5 7	–	–	K14073	21 CrmoV 5-7	20 CDV 5.07	–	–	–	–	1.7709	–
–	20 CrMoVTiB 4 10	–	–	–	20 CrMoVTiB 4-10	20 CrMoVTiB 4-10	–	–	–	–	1.7729	–
–	PS 275 TMK	S 275 ML	–	–	S 275 ML	S 275 ML	S 275 ML	–	–	–	1.8819	–
–	S 500 M	–	–	–	S 500 m	–	–	–	–	–	1.8829	–
–	BTStE 460 TM	S 460 ML	–	–	S 460 ML	E 460	S 460 ML	–	–	–	1.8838	–
–	S 500 ML	–	–	–	S 500 ML	–	–	–	–	–	1.8839	–
–	S 275 MH	–	–	–	S 275 MH	–	S 275 MH	–	–	–	1.8843	–
–	S 275 MLH	–	–	–	S 275 MLH	–	S 275 MLH	–	–	–	1.8844	–
–	S 355 MH	–	–	–	S 355 MH	–	S 355 MH	–	–	–	1.8845	–
–	S 355 MLH	–	–	–	S 355 MLH	–	S 355 MLH	–	–	–	1.8846	–
–	S 420 MH	–	–	–	S 420 MH	–	S 420 MH	–	–	–	1.8847	–
–	S 420 MLH	–	–	–	S 420 MLH	–	S 420 MLH	–	–	–	1.8848	–
–	S 460 MH	–	–	–	S 460 MH	–	S 460 MH	–	–	–	1.8849	–
–	StE 460	S 460 N	–	–	S 460 N	E 460	S 460N	–	–	–	1.8901	–
–	TStE 460	S 460 L	–	–	S 460 NL	E460	S 460 NL	–	–	–	1.8903	–
–	S 550 Q	–	–	–	S 550 Q	E 550	S 550 Q	–	–	–	1.8904	–
–	S 460 Q	55 F	–	–	S 460 Q	E 460	S 460 Q	–	–	–	1.8908	–
–	S 420 NL/TStE 420	S 420 NL	STK 540	K02002	S 420 NL	E 420 T-I	Fe E 420 KT	–	–	–	1.8912	–
–	S 620 Q	–	–	–	S 620 Q	E 620	S 620 Q	–	–	–	1.8914	–
–	T St E 460/P460NL1	P 460 NL 1	–	K02900	P 460 NL1	E 460 T-I	Fe E 460 KT	–	–	–	1.8915	–
–	S 460 QL1	55 F	–	–	S 460 QL 1	–	–	–	–	–	1.8916	–
–	T St E 500	–	–	K02001	–	E 500 T-I	–	–	–	–	1.8917	–
–	EStE 460/P460NI2	P 460 NL 2	–	–	P 460 NL 2	P 460 NL 2	P 460 NL 2	–	–	–	1.8918	–
–	EStE 500/S500NL1	–	–	–	S 500 NL 1	–	–	–	–	–	1.8919	–
–	TStE 690 VA/S690G1QL	–	–	–	S 690 G 1 QL	–	–	–	–	–	1.8920	–
–	TStE 690 VB/S690G2QL	–	–	K11646	S 690 G 2 QL	–	–	–	–	–	1.8921	–
–	S 690 G 4 QL/TStE 690 VC	–	–	–	S 690 G 4 QL	–	–	–	–	–	1.8922	–
–	S 590 QL/TStE 590 V	–	–	–	S 590 QL	–	–	–	–	–	1.8923	–
–	S 500 Q (StE 500 V)	–	–	–	S 500 Q	E 500	S 500 Q	2614	–	–	1.8924	–
–	S 890 QL 1 (EStE 90 V)	–	–	–	S 890 QL 1	–	–	–	–	–	1.8925	–
–	S 690 QL (TStE 690 V)	–	SHY 685 NS	–	S 690 QL	–	–	–	–	–	1.8928	–
–	S 690 Q/StE 690 V	–	SHY 685 N	–	S 690 Q	E 690	S 690 Q	–	–	–	1.8931	–
–	WSt E 420/P420NH	S 420 NL	STK 540	K02002	S 420 NL	S 420 NL	Fe E 420 KW	–	–	–	1.8932	–
–	S 960 QL/TStE 960 V	–	–	–	S 960 QL	–	–	–	–	–	1.8933	–
–	WSt E 460/P460NH	P 460 NH	–	K02900	P 460 NH	P 460 NH	Fe E 460 KW	–	–	–	1.8935	–
–	S 960 Q	–	–	–	S 960 Q	E 960 T-II	S 960 Q	–	–	–	1.8941	–
–	S 355 J 0 WP	WR 50 A	–	–	S 355 J0 WP	E 36 W-A3	S 355 J0 WP	–	–	–	1.8945	–
–	S 355 J 2 WP	S 355 J 2 WP	–	–	S 355 J2 WP	E36W-A4	S 355 J2 WP	–	–	–	1.8946	–
–	L 415 QB	–	–	–	L 415 QB	L 415 QB	–	–	–	–	1.8947	–
–	L 360 QB	–	–	–	L 360 QB	L 360 QB	–	–	–	–	1.8948	–
–	L 450 QB	–	–	–	L 450 QB	L 450 QB	–	–	–	–	1.8952	–
–	S 460 NH (FGS 47)	–	–	–	S 460 NH	–	S 460 NH	–	–	–	1.8953	–
–	L 485 QB	–	–	–	L 485 QB	L 485 QB	–	–	–	–	1.8955	–
–	S 460 NLH/FG S 47	–	–	–	S 460 NLH	–	S460NLH	–	–	–	1.8956	–
–	L 555 QB	–	–	–	L 555 QB	L 555 QB	–	–	–	–	1.8957	–
–	9 CrNiCuP 3 2 4	WR 50 A	SPA-H	K11430	–	–	–	–	–	–	1.8962	–
–	WTSt 52-3	WR 50 C	SMA 58 W	K11430	S 355 J 2 G 1 W	E 36 W-A2	–	–	–	–	1.8963	–
–	S 355 J 2 G 2 W	S 355 J 2 G 2 W	–	–	S 355 J 2 G 2 W	S 355 J 2 G 2 W	S 355 J 2 G 2 W	–	–	–	1.8965	–

(continued)

P3 Workpiece Materials Listing • Steel • P3 *(continued)*

P3 Alloy Steels and Tool Steels *Content: C >.25%* *Tensile Strength RM (MPa)*: 600–850* *Hardness (HB): <330 (HRC): <35*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
–	S 355 K 2 G 1 W	S 355 K 2 G 1 W	SMA 490 CW	–	S 355 K2 G1 W	S 355 K2 G1 W	S 355 K 2 G 1 W	–	–	–	1.8966	–
–	S 355 K 2 G 2 W	S 355 K 2 G 2 W	–	–	S 355 K2G2W	S 355 K 2 G 2 W	S 355 K 2 G 2 W	–	–	–	1.8967	–
–	QStE 600 TM/S 600 MC	–	–	–	S 600 MC	E 620 D	S 600 MC	–	–	–	1.8969	–
–	StE 415..7/L 415 NB	–	–	–	L 415 NB	L 415 NB	–	–	–	–	1.8972	–
–	StE 415.7 TM/L 415 MB	–	–	–	L 415 MB	L 415 MB	–	–	–	–	1.8973	–
–	S 700 MC (QStE 690 TM)	–	–	–	S 700 MC	E 690 D	S 700 MC	–	–	–	1.8974	–
–	L 450 MB/StE 445.7 TM	–	–	–	L 450 MB	L 450 MB	–	–	–	–	1.8975	–
–	S 650 MC (QStE 650 TM)	–	–	–	S 650 MC	E 620 D	S 650 MC	–	–	–	1.8976	–
–	L 485 MB/StE 480.7 TM	–	–	–	L 485 MB	L 485 MB	–	–	–	–	1.8977	–
–	StE 550.7 TM/L 555 MB	–	–	–	L 555 MB	L 555 MB	–	–	–	–	1.8978	–
–	St 60-2	4360-55 E	SM 58	–	E 335	A 60-2	Fe 60-2	1650	–	–	1.0060	–
–	St 70-2	E 360	–	–	E 360	A 70-2	Fe 70-2	1655	–	–	1.0070	–
–	C4D	–	–	–	C 4 D	FM 5	C 4 D	–	–	–	1.0300	–
–	C 22 8	–	–	–	P 250 GH	–	–	–	–	–	1.0460	–
–	H 260/ZSt E 260	H 240 LA	–	–	H 240 LA	E 240 C	–	–	–	–	1.0480	–
–	C32D	–	SWRH 32	K02701	C 32 D	FM 32	C 32 D	–	–	–	1.0530	–
–	ZStE 380/H 380	H 360 L A	–	–	H 360 LA	E 355 C	–	–	–	–	1.0550	–
–	C60D	–	–	–	C 60 D	FM 60	C 60 D	–	–	–	1.0610	–
–	38 SMn 28	38 SMn 28	–	–	38 SMn 28	38 SMn 28	–	–	–	–	1.0760	–
–	QSt E 260 TM/5260 MC	–	–	–	S 260 MC	41 S 7	Fe E 275 TM	–	–	–	1.0970	–
–	C3D2	–	–	–	C 3 D 2	FM 5	C 3 D 2	–	–	–	1.1110	–
–	C38D2	–	–	–	C 38 D 2	FM 38	C 38 D 2	–	–	–	1.1150	–
–	C 42 E Al/Ck 42 Al	–	–	–	S 355 G15	–	–	–	–	–	1.1190	–
–	C56D2/D 55-2	–	–	–	C 56 D 2	FM 56	C 56 D 2	–	–	–	1.1220	–
–	C 70 W1	–	–	–	CT 70	C 70 E 2 U	C 70 K U	–	–	–	1.1520	–
–	C 45 W	–	–	–	C 45 U	Y3 42	–	–	–	–	1.1730	–
–	C 60 W	–	SK 7	–	–	Y3 55	–	–	–	–	1.1740	–
–	100 CrMn 6	–	–	K19195	100 CrMn 6	100 CM 6	–	–	–	–	1.3520	–
–	28 B 2	–	SWRCHB 26	–	C 30 B	20 B 3	–	–	–	–	1.5510	–
–	St E 380	–	SM 50 B	–	S 380 N	–	Fe E 390 KG	–	–	–	1.8900	–
–	TStE 380/S380NL	–	–	–	S 380 NL	–	Fe E 390 KT	2117	–	–	1.8910	–
–	S 890 Q	–	–	–	S 890 Q	S 890 Q	S 890 Q	–	–	–	1.8940	–
–	46 Si 7	–	–	–	45 Si	46 S 7	–	–	–	–	1.5024	–
–	55 Si 7	250 A 53	–	G92550	56 Si 7	55 S 7	55 Si 8	2085	–	–	1.5026	–
–	37 MnSi 5	–	–	–	–	38 MS 5	–	F.130.A	–	–	1.5122	–
–	15 MnMoV 4 5	–	–	–	15 MnMoV 4-5	15 MDV 4.05	–	–	–	–	1.5402	–
–	11 MnMo 4 5	–	–	K11123	11 MnMo 45 KE	–	–	–	–	–	1.5425	–
–	13 MnMo 6 5	–	–	K11424	11 MnMo 65 KE	–	–	–	–	–	1.5426	–
–	35 B 2	–	SWRCHB 237	–	C 35 B	35 B 3	–	–	–	–	1.5511	–
–	24 Ni 8	–	SCPL 21	J22501	G 9 Ni 10	22 N 8	G9Ni10	–	–	–	1.5633	–
–	10 NiCr 5 4	10NiCr5-4	–	–	10 NiCr 5-4	10 NiCr 5-4	–	–	–	–	1.5805	–
–	18 MnMoNi 5 5	–	–	–	18 MnMoNi 5-5	–	–	–	–	–	1.6308	–
–	20 MnMoNi 4 5	–	SQV 2 B	K12539	20 MnMoNi 4-5	–	–	–	–	–	1.6311	–
–	15 MnCrMoNiV 5 3	–	–	–	15 MnCrMoNiV 5-3	–	–	–	–	–	1.6920	–
–	17 CrS 3	17 CrS3	–	–	17 CrS 3	17 CrS 3	–	–	–	–	1.7014	–
–	28 CrS 4	–	–	–	28CrS4	28CrS4	–	–	–	–	1.7036	–
–	34 CrS 4	34 CrS 4	–	–	34 CrS 4	34 CrS 4	34 CrS 4	–	–	–	1.7037	–
–	41 CrS 4	41 CrS 4	–	–	41 CrS 4	41 CrS 4	41 CrS 4	2245	–	–	1.7039	–
–	38 Cr 4	–	–	–	38 Cr 4	–	38 Cr 4	–	–	–	1.7043	–
–	16 CrMo 4	18 CrMo4	SCM 418 H	–	18 CrMo 4	15 CD 3.5	18 CrMo 4	–	–	–	1.7242	–
–	12 CrMo 11 10	–	–	–	–	–	–	–	–	–	1.7305	–
–	22 CrMoS 3 5	–	–	–	22 CrMoS 3-5	22 CrMoS 3-5	–	–	–	–	1.7333	–
–	12 CrMo 19 5	3606-625	SCMV 6	K41545	X 12 CrMo 5	Z 10 CD 5.05	16 CrMo 20 5	–	–	–	1.7362	–
–	X 7 CrMo 6 1	B 5	–	S50281	CM 5-IG	–	–	–	–	–	1.7373	–
–	51 CrMoV 4	–	–	–	51 CrMoV 4	51 CDV 4	51 CrMoV 4	–	–	–	1.7701	–
–	21 CrMoV 5 7	–	–	K14073	21 CrmoV 5-7	20 CDV 5.07	–	–	–	–	1.7709	–
–	20 CrMoVTiB 4 10	–	–	–	20 CrMoVTiB 4-10	20 CrMoVTiB 4-10	–	–	–	–	1.7729	–
–	PS 275 TMK	S 275 ML	–	–	S 275 ML	S 275 ML	S 275 ML	–	–	–	1.8819	–
–	S 500 M	–	–	–	S 500 m	–	–	–	–	–	1.8829	–
–	BTStE 460 TM	S 460 ML	–	–	S 460 ML	E 460	S 460 ML	–	–	–	1.8838	–
–	S 500 ML	–	–	–	S 500 ML	–	–	–	–	–	1.8839	–
–	S 275 MH	–	–	–	S 275 MH	–	S 275 MH	–	–	–	1.8843	–
–	S 275 MLH	–	–	–	S 275 MLH	–	S 275 MLH	–	–	–	1.8844	–
–	S 355 MH	–	–	–	S 355 MH	–	S 355 MH	–	–	–	1.8845	–
–	S 355 MLH	–	–	–	S 355 MLH	–	S 355 MLH	–	–	–	1.8846	–
–	S 420 MH	–	–	–	S 420 MH	–	S 420 MH	–	–	–	1.8847	–
–	S 420 MLH	–	–	–	S 420 MLH	–	S 420 MLH	–	–	–	1.8848	–
–	S 460 MH	–	–	–	S 460 MH	–	S 460 MH	–	–	–	1.8849	–
–	StE 460	S 460 N	–	–	S 460 N	E 460	S 460N	–	–	–	1.8901	–
–	TStE 460	S 460 L	–	–	S 460 NL	E460	S 460 NL	–	–	–	1.8903	–
–	S 550 Q	–	–	–	S 550 Q	E 550	S 550 Q	–	–	–	1.8904	–
–	S 460 Q	55 F	–	–	S 460 Q	E 460	S 460 Q	–	–	–	1.8908	–
–	S 420 NL/TStE 420	S 420 NL	STK 540	K02002	S 420 NL	E 420 T-I	Fe E 420 KT	–	–	–	1.8912	–
–	S 620 Q	–	–	–	S 620 Q	E 620	S 620 Q	–	–	–	1.8914	–
–	T St E 460/P460NL1	P 460 NL 1	–	K02900	P 460 NL1	E 460 T-I	Fe E 460 KT	–	–	–	1.8915	–
–	S 460 QL1	55 F	–	–	S 460 QL 1	–	–	–	–	–	1.8916	–
–	T St E 500	–	–	K02001	–	E 500 T-I	–	–	–	–	1.8917	–
–	EStE 460/P460NI2	P 460 NL 2	–	–	P 460 NL 2	P 460 NL 2	P 460 NL 2	–	–	–	1.8918	–
–	EStE 500/S500NL1	–	–	–	S 500 NL 1	–	–	–	–	–	1.8919	–
–	TStE 690 VA/S690G1QL	–	–	–	S 690 G 1 QL	–	–	–	–	–	1.8920	–
–	TStE 690 VB/S690G2QL	–	–	K11646	S 690 G 2 QL	–	–	–	–	–	1.8921	–
–	S 690 G 4 QL/TStE 690 VC	–	–	–	S 690 G 4 QL	–	–	–	–	–	1.8922	–
–	S 590 QL/TStE 590 V	–	–	–	S 590 QL	–	–	–	–	–	1.8923	–
–	S 500 Q (StE 500 V)	–	–	–	S 500 Q	E 500	S 500 Q	2614	–	–	1.8924	–
–	S 890 QL 1 (EStE 90 V)	–	–	–	S 890 QL 1	–	–	–	–	–	1.8925	–
–	S 690 QL (TStE 690 V)	–	SHY 685 NS	–	S 690 QL	–	–	–	–	–	1.8928	–
–	S 690 Q/StE 690 V	–	SHY 685 N	–	S 690 Q	E 690	S 690 Q	–	–	–	1.8931	–

NOTE: For legend, see page Y217.

(continued)

P3 Workpiece Materials Listing • Steel • P3 *(continued)*

P3 Alloy Steels and Tool Steels *Content: C >.25%* *Tensile Strength RM (MPa)*: 600–850* *Hardness (HB): <330 (HRC): <35*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
–	WSt E 420/P420NH	S 420 NL	STK 540	K02002	S 420 NL	S 420 NL	Fe E 420 KW	–	–	–	1.8932	–
–	S 960 QL/TStE 960 V	–	–	–	S 960 QL	–	–	–	–	–	1.8933	–
–	WSt E 460/P460NH	P 460 NH	–	K02900	P 460 NH	P 460 NH	Fe E 460 KW	–	–	–	1.8935	–
–	S 960 Q	–	–	–	S 960 Q	E 960 T-II	S 960 Q	–	–	–	1.8941	–
–	S 355 J 0 WP	WR 50 A	–	–	S 355 J0 WP	E 36 W-A3	S 355 J0 WP	–	–	–	1.8945	–
–	S 355 J 2 WP	S 355 J 2 WP	–	–	S 355 J2 WP	E36W-A4	S 355 J2 WP	–	–	–	1.8946	–
–	L 415 QB	–	–	–	L 415 QB	L 415 QB	–	–	–	–	1.8947	–
–	L 360 QB	–	–	–	L 360 QB	L 360 QB	–	–	–	–	1.8948	–
–	L 450 QB	–	–	–	L 450 QB	L 450 QB	–	–	–	–	1.8952	–
–	S 460 NH (FGS 47)	–	–	–	S 460 NH	–	S 460 NH	–	–	–	1.8953	–
–	L 485 QB	–	–	–	L 485 QB	L 485 QB	–	–	–	–	1.8955	–
–	S 460 NLH/FG S 47	–	–	–	S 460 NLH	–	S460NLH	–	–	–	1.8956	–
–	L 555 QB	–	–	–	L 555 QB	L 555 QB	–	–	–	–	1.8957	–
–	9 CrNiCuP 3 2 4	WR 50 A	SPA-H	K11430	–	–	–	–	–	–	1.8962	–
–	WTSt 52-3	WR 50 C	SMA 58 W	K11430	S 355 J 2 G 1 W	E 36 W-A2	–	–	–	–	1.8963	–
–	S 355 J 2 G 2 W	S 355 J 2 G 2 W	–	–	S 355 J 2 G 2 W	S 355 J 2 G 2 W	S 355 J 2 G 2 W	–	–	–	1.8965	–
–	S 355 K 2 G 1 W	S 355 K 2 G 1 W	SMA 490 CW	–	S 355 K2 G1 W	S 355 K2 G1 W	S 355 K 2 G 1 W	–	–	–	1.8966	–
–	S 355 K 2 G 2 W	S 355 K 2 G 2 W	–	–	S 355 K2G2W	S 355 K 2 G 2 W	S 355 K 2 G 2 W	–	–	–	1.8967	–
–	QStE 600 TM/S 600 MC	–	–	–	S 600 MC	E 620 D	S 600 MC	–	–	–	1.8969	–
–	StE 415..7/L 415 NB	–	–	–	L 415 NB	L 415 NB	–	–	–	–	1.8972	–
–	StE 415.7 TM/L 415 MB	–	–	–	L 415 MB	L 415 MB	–	–	–	–	1.8973	–
–	S 700 MC (QStE 690 TM)	–	–	–	S 700 MC	E 690 D	S 700 MC	–	–	–	1.8974	–
–	L 450 MB/StE 445.7 TM	–	–	–	L 450 MB	L 450 MB	–	–	–	–	1.8975	–
–	S 650 MC (QStE 650 TM)	–	–	–	S 650 MC	E 620 D	S 650 MC	–	–	–	1.8976	–
–	L 485 MB/StE 480.7 TM	–	–	–	L 485 MB	L 485 MB	–	–	–	–	1.8977	–
–	StE 550.7 TM/L 555 MB	–	–	–	L 555 MB	L 555 MB	–	–	–	–	1.8978	–
–	St 60-2	4360-55 E	SM 58	–	E 335	A 60-2	Fe 60-2	1650	–	–	1.0060	–
–	St 70-2	E 360	–	–	E 360	A 70-2	Fe 70-2	1655	–	–	1.0070	–
–	C4D	–	–	–	C 4 D	FM 5	C 4 D	–	–	–	1.0300	–
–	C 22 8	–	–	–	P 250 GH	–	–	–	–	–	1.0460	–
–	H 260/ZSt E 260	H 240 LA	–	–	H 240 LA	E 240 C	–	–	–	–	1.0480	–
–	C32D	–	SWRH 32	K02701	C 32 D	FM 32	C 32 D	–	–	–	1.0530	–
–	ZStE 380/H 380	H 360 L A	–	–	H 360 LA	E 355 C	–	–	–	–	1.0550	–
–	C60D	–	–	–	C 60 D	FM 60	C 60 D	–	–	–	1.0610	–
–	38 SMn 28	38 SMn 28	–	–	38 SMn 28	38 SMn 28	–	–	–	–	1.0760	–
–	QSt E 260 TM/5260 MC	–	–	–	S 260 MC	41 S 7	Fe E 275 TM	–	–	–	1.0970	–
–	C3D2	–	–	–	C 3 D 2	FM 5	C 3 D 2	–	–	–	1.1110	–
–	C38D2	–	–	–	C 38 D 2	FM 38	C 38 D 2	–	–	–	1.1150	–
–	C 42 E Al/Ck 42 Al	–	–	–	S 355 G15	–	–	–	–	–	1.1190	–
–	C56D2/D 55-2	–	–	–	C 56 D 2	FM 56	C 56 D 2	–	–	–	1.1220	–
–	C 70 W1	–	–	–	CT 70	C 70 E 2 U	C 70 K U	–	–	–	1.1520	–
–	C 45 W	–	–	–	C 45 U	Y3 42	–	–	–	–	1.1730	–
–	C 60 W	–	SK 7	–	–	Y3 55	–	–	–	–	1.1740	–
–	100 CrMn 6	–	–	K19195	100 CrMn 6	100 CM 6	–	–	–	–	1.3520	–
–	28 B 2	–	SWRCHB 26	–	C 30 B	20 B 3	–	–	–	–	1.5510	–
–	St E 380	–	SM 50 B	–	S 380 N	–	Fe E 390 KG	–	–	–	1.8900	–
–	TStE 380/S380NL	–	–	–	S 380 NL	–	Fe E 390 KT	2117	–	–	1.8910	–
–	S 890 Q	–	–	–	S 890 Q	S 890 Q	S 890 Q	–	–	–	1.8940	–

P4 Workpiece Materials Listing • Steel • P4

P4 Alloy Steels and Tool Steels *Content: C>.25%* *Tensile Strength RM (MPa)*: 850–1400* *Hardness (HB): 350–450 (HRC): 35–48*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
A 570 Gr. 40	St 44-2	4360-43 B	SM 41 B	K 02502	S 275 JR	E 28-2	Fe 430 BFN	1412	–	–	1.0044	–
–	S 235 J0/Fe 360 C	En 40C	–	–	S 235 J0	E24-3	Fe 360 CFN	–	–	–	1.0114	–
A 570 Gr. 36	St 37-3	4360-40 C	–	K01501	S 235 J2 G3	Fe 360 D1(2); E 24-3	Fe 360 D1(2)	1312	–	–	1.0116	–
–	QSt 37-3	–	SWRCH 12R	–	–	–	–	–	–	–	1.0123	–
–	S 275 J0	En43C; S275J0	–	–	S 275 J0/Fe 430 C	S 275 J0; E 28-3	S275J0; Fe430CFN	–	–	–	1.0143	–
A 573 Gr. 70	St 44-3	4360-43 C	SM 41 B	–	Fe 430 D1(2); S 275 J2 G3 (4)	Fe 430 D1(2); E 28-4	Fe 430 D FF	1414	–	–	1.0144	–
–	S 275 J2 G4/Fe 430 D 2	S 275 J2 G4	–	–	S 275 J2 G4	E28-4; S 275 J2 G4	S 275 J2 G4	1414	–	–	1.0145	–
–	Ro St 44-2	43C	–	–	S 275 J0 H	–	S 275 J0 H	–	–	–	1.0149	–
–	St 37.0	–	STPG 38	–	P 235 T1	–	–	–	–	–	1.0254	–
–	C9D	–	SWRM 8	–	C 9 D	FM 9	C 9 D	–	–	–	1.0304	–
–	C7D	C 7 D	SWRM 8	G10060	C 7 D	FM 8	C 7 D	–	–	–	1.0313	–
–	L 210 GA	–	–	–	L 210 GA	TS E 220 class 2	–	–	–	–	1.0319	–
–	USD 7/C 8 G1 W	–	–	–	C 8 G 1 W	–	–	–	–	–	1.0323	–
–	RSD 7/C8G2W	–	–	–	C 8 G 2 W	–	–	–	–	–	1.0324	–
–	RSD 10 Si/C10WSi	–	–	–	C 10 W Si	–	–	–	–	–	1.0339	–
–	P235 GH	P 235 GH	SPV 50	K02503	P 235 GH	A 37 CP	Fe E 235	1330	–	–	1.0345	–
–	RRSD 10/C10 W	–	–	–	C 10 W	–	–	–	–	–	1.0351	–
–	St 45.8	–	STB 410	K02727	–	–	–	–	–	–	1.0405	–
–	C 25 Pb	–	–	–	C 25 GPb	–	–	–	–	–	1.0411	–
–	L 245 MB	430	–	K03006	L 245 MB	L 245 MB	–	–	–	–	1.0418	–
1513	P265	HR 40/30	–	G15130	–	12 M 5	–	–	–	–	1.0424	–
–	P310 NB	224-410	SG 325	K02100	P280GH	BS 2	P 275 N	2103	–	–	1.0426	–
–	L 290 MB	–	–	–	L290MB	L 290 MB	–	–	–	–	1.0429	–
–	H III/P285NH	–	Sm 38	–	P 285 NH	–	–	–	–	–	1.0435	–
–	P310 NB	224-430	SG 325	K02100	P305GH	P 275 N	P 275 N	2103	–	–	1.0436	–
–	A St 41	P 275 N	STK 400	K02100	S 275 N	BS 3	P 275 N	2103	–	–	1.0437	–
–	B 500 A	–	SD 490	–	B 500 A	–	B 500 A	–	–	–	1.0438	–
–	GS-45	–	SC 450	–	–	–	–	–	–	–	1.0443	–
–	H IV/P295NH	–	SG 37	K03102	–	–	Fe 460-2 KW	–	–	–	1.0445	–

(continued)

P4 Workpiece Materials Listing • Steel • P4 *(continued)*

P4 Alloy Steels and Tool Steels *Content: C>.25%* *Tensile Strength RM (MPa)*: 850–1400* *Hardness (HB): 350–450 (HRC): 35–48*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
–	StE 240.7	–	–	–	L 245 NB	L 245 NB	–	–	–	–	1.0457	–
–	HIII/L 235 GA	–	–	–	L 235 GA	–	–	–	–	–	1.0458	–
–	L 245 GA/RRStE 240.7	–	–	–	L 245 GA	TS E 250	–	–	–	–	1.0459	–
–	St E255	–	–	K01800	–	–	–	–	–	–	1.0461	–
–	TStE 255	–	–	K11535	–	–	–	–	–	–	1.0463	–
–	15 Mn 3 Al	–	–	–	C 14 GAl	–	–	–	–	–	1.0468	–
–	21 Mn 4	–	–	–	–	–	20 Mn 4	–	–	–	1.0469	–
–	19 Mn 6/P 355 GH	P 355 GH	SGV 46	K03300	P355GH	A 52 CP	Fe E355-2	2101	–	–	1.0473	–
–	17 Mn 4/P 295 GH	224-460B	SG 37	K03501	P 295 GH	A 48 CP	Fe E 295	2102	–	–	1.0481	–
–	19 Mn 5	224-460	SG 37	K 03102	–	A 52 CP; AP; FP	Fe 460- 2 KW	–	–	–	1.0482	–
–	L 290 AG	–	–	–	L290GA	TS E 290	–	–	–	–	1.0483	–
–	L 290 NB	–	–	–	L290NB	L 290 NB	–	–	–	–	1.0484	–
–	21 Mn 6	–	–	K12320	–	–	–	–	–	–	1.0485	–
–	St E 285	P 275 N	SM 41 A	K 01802	P 275 N	P 275 N	Fe E 285 KG	–	–	–	1.0486	–
–	W St E 285	P 275 N	–	K 01802	P 275 NH	P 275 N	Fe E 285 KW	–	–	–	1.0487	–
–	T St E 285	P 275 NL 1	SLA 235 A	K 01803	P 275 NL 1	P 275 NL 1	Fe E 285 KT	–	–	–	1.0488	–
–	H 300/ZSt E 300	H280LA	–	–	H 280 LA	E 280 C	–	–	–	–	1.0489	–
–	S 275 NH	S 275 NH	–	–	S 275 NH	–	S 275 NH	–	–	–	1.0493	–
–	S 275 NLH	S275NLH	–	–	S 275 NLH	–	S275NLH	–	–	–	1.0497	–
–	L 360 GA	–	–	–	L 360 GA	–	–	–	–	–	1.0499	–
–	C 35 Pb/C 35 GPb	–	–	–	C 35 Pb	–	–	–	–	–	1.0502	–
–	St E 315/P 315N	–	SM 50 A	K11506	P 315 N	–	Fe E 315 KG	–	–	–	1.0505	–
–	W St E 315	–	SNC 1	K02404	P 315 NH	–	Fe E 315 KW	2107	–	–	1.0506	–
–	St 55	–	STKM 16A	–	–	–	Fe 540	–	–	–	1.0507	–
–	T St E315	–	SLA 325 A	K02404	P 315 NL	–	–	2106	–	–	1.0508	–
–	C 40 Pb	–	–	–	C 40 G Pb	–	–	–	–	–	1.0512	–
–	C38D	–	SWRH 37	–	C 38 D	FM 38	C 38 D	–	–	–	1.0516	–
–	C48D	–	SWRH 48	–	C 48 D	FM 48	C 48 D	–	–	–	1.0517	–
–	C56D	–	–	–	C 56 D	FM 56	C 56 D	–	–	–	1.0518	–
–	StSch 700 (R 0 700)	–	–	–	R 0700	–	–	–	–	–	1.0521	–
–	StSch800 (R 0 800)	–	–	–	R 0800	–	–	–	–	–	1.0524	–
–	Cf 45 Pb	–	–	–	–	–	C 46	–	–	–	1.0526	–
–	C32D	–	SWRH 32	K02701	C 32 D	FM 32	C 32 D	–	–	–	1.0530	–
–	GL-A 40 (S 390 G 1 S)	–	–	–	S 390 G 1 S	–	–	–	–	–	1.0532	–
–	S 355 NH	S 355 NH	–	–	S 355 NH	–	S 355 NH	–	–	–	1.0539	–
–	C42D	–	SWRH 42 B	–	C 42 D	FM 42	C 42 D	–	–	–	1.0541	–
–	Schienen 60 F(R 0600/ St Sch 60)	–	–	–	R 0600	–	–	–	–	–	1.0544	–
–	S 355 J0 H	50 C	–	–	S 355 J0 H	–	S 355 J0 H	–	–	–	1.0547	–
–	ZStE 340/H 340	H 320 L A	–	–	H 320 LA	E 315 C	–	–	–	–	1.0548	–
–	S 335 NLH	50 EE	–	–	S 355 N LH	–	S 355 N L H	–	–	–	1.0549	–
–	GS-52	A2	–	–	GE 260	–	–	–	–	–	1.0552	–
–	S 355 J0	En 50 C;S 355 J0	SM 520 M	–	S 355 J0	S 355 J0; E 36-3	S 355 J0; Fe 510 C FN	–	–	–	1.0553	–
–	GS-70	50 C	–	–	S 355 J0 C	E 36-3	Fe 510 C	–	–	–	1.0554	–
–	GS-62	–	–	–	S 355 GO 1	–	–	–	–	–	1.0555	–
–	ZStE 420/H 420	46/40HR,HS,CS	–	–	H 400 LA	H 400 LA	–	–	–	–	1.0556	–
–	P355 NB	–	SG 365	–	P 355 NB	BS 4	–	–	–	–	1.0557	–
–	GS-62.3	–	–	–	S 355 GO 2	–	–	–	–	–	1.0559	–
A 633 Gr. C	St E 355	P 355 N	SM 50 YB	K12000	P 355 N	E 355 R/FP	Fe E 355 KG	2132	–	–	1.0562	–
–	N 80	–	–	–	–	–	–	–	–	–	1.0564	–
–	W St E 355	P 355 NH	–	K01600	P 355 NH	P 355 NH	Fe E 355 KW	–	–	–	1.0565	–
–	T St E355	P 355 NL1	SLA 37	–	P 355 NL1	P 355 NL1	Fe E 355 KT	–	–	–	1.0566	–
–	32 Mn 3	–	–	–	–	–	–	–	–	–	1.0567	–
–	P355 QH1	P 355 QH	–	–	P 355 QH	P 355 QH	–	–	–	–	1.0571	–
–	ZStE 460/H 460	–	–	–	–	–	–	–	–	–	1.0574	–
–	S 355 J 2 G 4	S 355 J 2 G 4	–	–	S 355 J 2 G 4	S 355 J 2 G 4	S 355 J 2 G 4	–	–	–	1.0577	–
–	L 360 MB	–	–	–	L 360 MB	L 360 MB	–	–	–	–	1.0578	–
–	St 52.4	–	STS 49	–	–	–	–	–	–	–	1.0581	–
–	L 360 NB/StE 360.7	–	–	–	L360NB	L 360 NB	–	–	–	–	1.0582	–
–	S 355 J 2 G 3 Cu/St 52-3 Cu3	–	–	–	S 355 J2 G3 Cu + CR	–	–	–	–	–	1.0585	–
–	C50D	–	–	–	C 50 D	FM 50	C 50 D	–	–	–	1.0586	–
–	QSt 52-3 Cu 3	–	–	–	S 355 J2 G3 Cu C	–	–	–	–	–	1.0587	–
–	D 53-2	–	SWRH 52 B	–	C 52 D	FM 52	C 52 D	–	–	–	1.0588	–
–	FStE 355 OS 3/S355G03	–	–	K12000	S 355 G03	–	–	–	–	–	1.0591	–
–	S 355 J 2 G 4 Cu	–	–	–	S 355 J2 G4 Cu	–	–	–	–	–	1.0592	–
–	S355k2G3/Fe 510 DD1 (MULTIST)	S 355 K 2 G 3	SM 520 C	K02505	S 355 K 2 G 3	E36-4	S 355 K 2 G 3	–	–	–	1.0595	–
–	S355K2G4/Fe 510 DD 2 (MULTIST)	S 355 K 2 G 4	–	–	S 355 K 2 G 4	S 355 K 2 G 4	S 355 K 2 G 4	–	–	–	1.0596	–
–	C 30 Pb	–	–	–	C 3 0 GPb	–	–	–	–	–	1.0598	–
–	C 60 Pb	–	–	–	C 60 GPb	–	–	–	–	–	1.0602	–
–	C 67 GPb/C 67 Pb	–	–	–	C 67 GPb	–	–	–	–	–	1.0606	–
–	C 75 GPb/C 75 Pb	–	–	–	C 75 GPb	–	–	–	–	–	1.0607	–

NOTE: For legend, see page Y217.

(continued)

P4 Workpiece Materials Listing • Steel • P4 *(continued)*

P4 Alloy Steels and Tool Steels *Content: C>.25%* *Tensile Strength RM (MPa)*: 850–1400* *Hardness (HB): 350–450 (HRC): 35–48*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
–	C62D	–	SWRH 62 B	–	C 62 D	FM 62	C 62 D	–	–	–	1.0611	–
–	C66D	–	–	–	C 66 D	FM 66	C 66 D	–	–	–	1.0612	–
–	C68D	–	SWRH 67 B	–	C 68 D	FM 68	C 68 D	–	–	–	1.0613	–
–	C70D	–	–	–	C 70 D	FM 70	C 70 D	–	–	–	1.0615	–
–	C72D	–	SWRH 72 B	–	C 72 D	FM 72	C 72 D	–	–	–	1.0617	–
–	GS-C 25	–	SCPH 1	–	GP 240 GH	GP 240 GH	GP 240 Gh	–	–	–	1.0619	–
–	GP 240 GR	–	–	–	GP 240 GR	GP 240 GR	GP 240 GR	–	–	–	1.0621	–
–	C80D	–	–	–	C 80 D	FM 80	C 80 D	–	–	–	1.0622	–
–	StSch 900 A (R 0900)	–	–	–	R 0900	–	–	–	–	–	1.0623	–
–	StSch 900 B (R 0900 Mn)	–	–	–	R 0900 Mn	–	–	–	–	–	1.0624	–
1345	StSch 90 C/GP 280 GH	–	–	G13450	GP 280 GH	GP 280 GH	GP 280 GH	–	–	–	1.0625	–
–	C82D	–	SWRH 82 B	–	C 82 D	FM 82	C 82 D	–	–	–	1.0626	–
–	C88D	–	–	–	C 88 D	–	C 88 D	–	–	–	1.0628	–
–	StSch 1200 (R 1200)	–	–	–	R 1200	–	–	–	–	–	1.0631	–
–	C 61/60 Mn 3	–	–	–	C 61	–	C 61	–	–	–	1.0642	–
–	C 85/85 Mn 3	–	–	–	C 85	–	C 85	–	–	–	1.0647	–
–	35 SPb 20	35 SPb 20	–	–	35 SPb 20	35 SPb 20	–	–	–	–	1.0756	–
–	45 SPb 20	–	–	–	46 SPb 20	–	–	–	–	–	1.0757	–
–	38 SMnPb 28	38 SMnPb 28	–	–	38 SMnPb 28	38 SMnPb 28	–	–	–	–	1.0761	–
–	44 SMn 28	44 SMn 28	–	–	44 SMn 28	44 SMn 28	–	–	–	–	1.0762	–
–	44 SMnPb 28	44 SMnPb 28	–	–	44 SMnPb 28	44 SMnPb 28	–	–	–	–	1.0763	–
–	36 SMnPb 14	36 SMnPb 14	–	–	36 SMnPb 14	36 SMnPb 14	–	–	–	–	1.0765	–
9255	51 Si 7	250 A 53	–	G92550	–	51 S 7	48 Si 7	2090	–	–	1.0903	–
9255	55 Si 7	250 A 53	SKH 1; SKT 4	G92550	55 NiCrMoV 7	55 S 7	55 Si 8	2085	–	–	1.0904	–
–	StSch 1100 (R 1100 Cr)	–	–	–	R 1100 Cr	–	–	–	–	–	1.0915	–
9262	60 SiCr 7	250 A 61	SUP 7	G92620	60 SiCr 8	60 SC 7	60 SiCr 8	–	–	–	1.0961	–
–	QSt E 690 TM (S 700 MC)	–	–	–	S 700 MC	S 690 MC	S 700 MC	–	–	–	1.0966	–
–	QSt E 260 N 7 S 260 NC	–	AE 275 NC	–	S 260 NC	–	S 260 NCX	–	–	–	1.0971	–
–	QSt E 300 TM/S 315 MC	43 F35 HR,HS,CS	–	–	S 315 MC	E 315 D	S 315 MC	–	–	–	1.0972	–
–	QSt E 300 N 7/S 315 NC	–	AE 340 NC	–	S 315 NC	–	S 315 NC	–	–	–	1.0973	–
–	QSt E340 TM	HR 40/30	–	–	S 340 MC	E 335 D	–	–	–	–	1.0974	–
–	QSt E340 N	–	–	–	S 340 NC	–	Fe E 355 TD	–	–	–	1.0975	–
–	QSt E 360TM	–	–	–	S 355 MC	E 355 D	Fe E 355 TM	–	–	–	1.0976	–
–	QSt E360 N	–	–	–	S 355 NC	–	Fe E 355 TD	–	–	–	1.0977	–
–	QSt E380 TM	–	–	–	S 380 MC	E 390 D	–	–	–	–	1.0978	–
–	QSt E380 N	–	–	–	S 380 NC	–	Fe E 380 TD	–	–	–	1.0979	–
–	QSt E420 TM	HR 50 F 45	–	–	S 420 MC	E 430 D	Fe E 420 TM	–	–	–	1.0980	–
–	QSt E 420 N	–	–	–	S 420 NC	–	Fe E 420 TD	–	–	–	1.0981	–
–	QSt E 460 TM	50/45 HR	–	–	S 460 MC	E 445 D	–	–	–	–	1.0982	–
–	QSt E 460 N	–	–	–	S 460 NC	–	Fe E 460 TD	–	–	–	1.0983	–
–	QSt E500 TM	–	–	–	S 500 MC	E 490 D	Fe E 490 TM	2662	–	–	1.0984	–
–	QSt E500 N	–	–	–	S 500 NC	–	–	–	–	–	1.0985	–
–	QSt E550 TM	60/55 HS	–	–	S 550 MC	E 560 D	Fe E 560 TM	–	–	–	1.0986	–
–	QSt E550 N	–	–	–	S 550 NC	–	–	–	–	–	1.0987	–
–	FStE 355 OS 3/S355G04	–	–	–	S 355 G04	–	–	–	–	–	1.1102	–
–	EStE 285	P 275 NL 2	STK 400	–	P 275 NL 2	P 275 NL 2	P 275 NL 2	–	–	–	1.1104	–
–	EStE 315	–	–	–	S 315 NL 1	–	–	–	–	–	1.1105	–
–	EStE 355	P 355 NL 2	STK 500	–	P 355 NL 2	P 355 NL 2	P 355 NL 2	–	–	–	1.1106	–
–	C5D2	–	–	–	C 5 D 2	FM 6	C 5 D 2	–	–	–	1.1111	–
–	USD 5/C 8 E1 W	–	–	–	C 8 E 1 W	–	–	–	–	–	1.1112	–
–	C8D2	–	–	–	C 8 D 2	FM 8	C 8 D 2	–	–	–	1.1113	–
–	C 10 E W/RSD 11	–	–	–	C 10 EW	–	–	–	–	–	1.1115	–
–	USD 6/C 8 E2 W	–	–	–	C 8 E 2 W	–	–	–	–	–	1.1116	–
–	G 24 Mn 4/GS 24 Mn 4	–	–	–	G 24 Mn 4	–	–	–	–	–	1.1136	–
–	C32D2	–	–	–	C 32 D 2	FM 32	C 32 D 2	–	–	–	1.1143	–
–	C36D2	–	–	–	C 36 D 2	FM 36	C 36 D 2	–	–	–	1.1145	–
–	C38D2	–	–	–	C 38 D 2	FM 38	C 38 D 2	–	–	–	1.1150	–
–	C 25 R	C 25 R	–	–	C 25 R	C 25 R	C 25 R	–	–	–	1.1163	–
–	C48D2	–	–	–	C 48 D 2	FM 48	C48 D 2	–	–	–	1.1164	–
1330	GS-30 Mn 5	120 M 36	SMn 433 H; SCMn 2	K13300	–	35 M 5	–	1330	–	–	1.1165	–
1335	36 Mn 5	150 M 36	SMn 438(H)	G13350	–	40 M 5	–	2120	–	–	1.1167	–
–	G 40 Mn 5/GS 40 Mn 5	–	–	–	G 40 Mn 5	–	–	–	–	–	1.1168	–
–	20 Mn 6	150 M 19	–	–	–	20 M 5	20 Mn 6	–	–	–	1.1169	–
–	C50D2	–	–	–	C 50 D 2	FM 50	C50D 2	–	–	–	1.1171	–
–	Ck 38 Pb	–	–	–	25 Mn 4	–	–	–	–	–	1.1177	–
–	C 30 R	C 30 R	C 30 R (3 C 30)	–	C 30 R	C 30 R	C 30 R	–	–	–	1.1179	–
–	Ck 35 Pb	–	–	–	S 355 G 13	–	–	–	–	–	1.1182	–
–	Ck 36	–	–	–	S 355 G 14	–	–	–	–	–	1.1184	–
–	C3D1	–	–	–	C 3 D 1	–	C 3 D 1	–	–	–	1.1187	–
–	C40R/Cm 40	C 40 R	–	–	C 40 R	C 40 R	C 40	–	–	–	1.1189	–
–	C52D2	–	–	–	C 52 D 2	FM 52	C 52 D 2	–	–	–	1.1202	–
–	C 53 R/Cm 53	–	–	–	C 53 R	–	–	–	–	–	1.1205	–
–	C 10 R	C 10 R	–	–	C 10 R	C 10 R	–	–	–	–	1.1207	–
–	C 16 R	C 16 R	–	–	C 16 R	C 16 R	–	–	–	–	1.1208	–
–	C58D2	–	–	–	C 58 D 2	FM 58	C 58 D 2	–	–	–	1.1212	–
–	Ck 53 Pb	–	–	–	C 90 S	–	–	–	–	–	1.1217	–
–	C62D2	–	–	–	C 62 D 2	FM 62	C 62 D 2	–	–	–	1.1222	–
–	Cm 60	C 60 R	–	–	3 C 60	C 60 R	C 60 R	–	–	–	1.1223	–
–	C60D2	–	–	–	C 60 D 2	FM 60	C 60 D 2	–	–	–	1.1228	–
–	C68D2	–	–	–	C 68 D 2	FM 68	C 68 D 2	–	–	–	1.1232	–
–	C66D2	–	–	–	C 66 D 2	FM 66	C 66 D 2	–	–	–	1.1236	–
–	C50R	C 50 R	–	–	C 50 R	FM 50	C 50 R	–	–	–	1.1241	–
–	C72D2	–	–	–	C 72 D 2	FM 72	C 72 D 2	–	–	–	1.1242	–
–	C70D2	–	–	–	C 70 D 2	FM 70	C 70 D 2	–	–	–	1.1251	–
–	C78D2	–	–	–	C 78 D 2	FM 78	C 78 D 2	–	–	–	1.1252	–
–	C76D2	–	–	–	C 76 D 2	FM 76	C 76 D 2	–	–	–	1.1253	–
–	C80D2	–	–	–	C 80 D 2	FM 80	C 80 D 2	–	–	–	1.1255	–
–	C82D2	–	–	–	C 82 D 2	FM 82	C 82 D 2	–	–	–	1.1262	–
–	C86D2	–	–	–	C 86 D 2	FM 86	C 86 D 2	–	–	–	1.1265	–
–	C88D2	–	–	–	C 88 D 2	–	C 88 D 2	–	–	–	1.1272	–
–	C92D2	–	–	–	C 92 D 2	–	C 92 D 2	–	–	–	1.1282	–
–	C98D2	–	–	–	C 98 D 2	–	C 98 D 2	–	–	–	1.1283	–
–	46 MnVS 6	–	–	–	46 MnVS 6	–	–	–	–	–	1.1304	–
–	C 90 U	–	–	–	C90U	–	–	–	–	–	1.1535	–
–	C 110 W	–	–	–	C 110 U	–	–	–	–	–	1.1554	–
–	C 120 U	–	–	–	C120U	–	–	–	–	–	1.1555	–
T 8	C 80 W2	BW 1B	SKC 3	T12008	–	Y1 80	C 80 KU	–	–	–	1.1625	–
–	C 105 W2	–	SK 3	–	–	–	–	–	–	–	1.1645	–
–	C 135 W	–	SK 1	–	–	Y2 140	C 140 KU	–	–	–	1.1673	–
A-6	C 67 W	–	–	T30106	–	Y1 70	–	–	–	–	1.1744	–

(continued)

P4 Workpiece Materials Listing • Steel • P4 *(continued)*

P4 Alloy Steels and Tool Steels *Content: C>.25%* *Tensile Strength RM (MPa)*: 850–1400* *Hardness (HB): 350–450 (HRC): 35–48*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
–	125 Cr 1	–	–	–	125 Cr 2	Y2 120 C	–	–	–	–	1.2002	–
–	85 Cr 1	–	–	–	–	Y1 100 C 2	–	–	–	–	1.2004	–
–	140 Cr 3	–	SKS 8	–	140 Cr 2	Y2 140 C	–	–	–	–	1.2008	–
–	105 Cr 4	–	SKC 11	–	–	–	–	–	–	–	1.2057	–
–	21 MnCr 5	–	SCR 420 H	–	21 MnCr 5	20 NC 5	–	–	–	–	1.2162	–
–	35 CrMo 7	–	–	–	35 CrMo 7	–	–	–	–	–	1.2302	–
–	48 CrMoV 67	–	–	–	–	45 CDV 6	–	–	–	–	1.2323	–
P6	15 NiCr 14	–	SNC 22	T51606	–	10 NC 12	–	–	–	–	1.2735	–
–	40 CrMnNiMo 8 6 4	–	–	–	40 CrMnNiMo 8-6-4	–	–	–	–	–	1.2738	–
–	57 NiCrMoV 7 7	–	–	–	55 NiCrMoV 7	–	–	–	–	–	1.2744	–
–	70 MnMoCr 8	–	–	–	70 MnMoCr 8	–	–	–	–	–	1.2824	–
–	95 MnWCr 5	–	–	–	95 MnWCr 5	–	–	–	–	–	1.2825	–
–	60 MnSi 4	–	–	–	–	60 MSC 4	–	–	–	–	1.2826	–
–	101 Cr 6	–	–	–	–	–	102 Cr 6 KU	–	–	–	1.3514	–
–	16 CrNiMo 6	820A16	–	–	–	16 NCD 6	16NiCrMo6	–	–	–	1.3531	–
–	100 CrMn 7 3	–	–	–	100 CrMnMo 7	100 CD 7	–	–	–	–	1.3536	–
–	100 CrMo 7	–	SUS 4	K19965	100 CrMo 7	100 CD 7	100CrMo7	–	–	–	1.3537	–
–	100 CrMnMo 8	–	–	–	–	100 CrMnMo 8	–	–	–	–	1.3539	–
5046	44 Cr 2	–	–	H50460	46 Cr 1 KD	44 Cr 2	–	–	–	–	1.3561	–
4142	43 CrMo 4	–	–	G41420	–	43 Cr Mo 4	–	–	–	–	1.3563	–
4147	48 CrMo 4	817 M 40	SNC 836	H41470	–	48 CrMo 4	–	–	–	–	1.3565	–
–	46 Si 7	–	–	–	45 Si	46 S 7	–	–	–	–	1.5024	–
9259H	51 Si 7	–	–	–	50 Si 7	–	48 Si 7	2090	–	–	1.5025	–
–	55 Si 7	250 A 53	–	G92550	56 Si 7	55 S 7	55 Si 8	2085	–	–	1.5026	–
9260	60 Si 7	251 A 60	–	G92600	60 Si 7	60 S 7	60 Si 7	–	–	–	1.5027	–
–	65 Si 7	–	SUP 7	–	–	–	–	–	–	–	1.5028	–
–	12 Mn 8	–	–	–	11 Mn 8 KE	–	–	–	–	–	1.5086	–
9262	60 SC 7	–	–	G92620	60 SiCr 8	61 SC 7	60 SiCr 8	–	–	–	1.5092	–
–	37 MnSi 5	–	–	–	–	38 MS 5	–	F.130.A	–	–	1.5122	–
–	50 MnSi 4	–	–	K04800	–	–	–	–	–	–	1.5131	–
–	15 MnMoV 4 5	–	–	–	15 MnMoV 4-5	15 MDV 4.05	–	–	–	–	1.5402	–
A 204 Gr. A	15 Mo 3	1501-240	STFA 12	K11820	16 Mo 3	15 D3	16 Mo 3 KW	2912	–	–	1.5415	–
4419	GS-22 Mo 4	243-430	SCPH 11	G44190	G 20 Mo 5	G20Mo5	G 22 Mo 5	–	–	–	1.5419	–
–	20 MnMo 3 5	–	–	K12121	–	–	–	–	–	–	1.5421	–
–	G 18 Mo 5	–	–	–	G18Mo5	–	G 18 Mo5	–	–	–	1.5422	–
4520	16 Mo 5	1503-245-420	SBC 690	K11522	–	–	16 Mo 5	–	–	–	1.5423	–
–	11 MnMo 4 5	–	–	K11123	11 MnMo 45 KE	–	–	–	–	–	1.5425	–
–	13 MnMo 6 5	–	–	K11424	11 MnMo 65 KE	–	–	–	–	–	1.5426	–
–	13 MnMo 8 5	–	–	K11423	11 MnMo 85 KE	–	–	–	–	–	1.5427	–
–	35 B 2	–	SWRCHB 237	–	C 35 B	35 B 3	–	–	–	–	1.5511	–
15B21 H	19 MnB 4	170 H 20	SWRCHB 420	H15211	19 MnB 4	20 MB 5	–	–	–	–	1.5523	–
15B21 H	20 MnB 5	–	SWRCHB 620	–	20 MnB 5	20 MnB 5	20 MnB 5	–	–	–	1.5530	–
–	24 Ni 8	–	SCPL 21	J22501	G 9 Ni 10	22 N 8	G9Ni10	–	–	–	1.5633	–
A 350-LF 5	10 Ni 14	503	SL 3 N 26	K31718	12 Ni 14	12Ni14	18 Ni 14 KT	–	–	–	1.5637	–
P3	10 NC 6	–	–	T51603	15 NiCr 6	10 NC 6	–	–	–	–	1.5713	–
–	10 NiCr 5 4	10NiCr5-4	–	–	10 NiCr 5-4	10 NiCr 5-4	–	–	–	–	1.5805	–
–	18 MnMoNi 5 5	–	–	–	18 MnMoNi 5-5	–	–	–	–	–	1.6308	–
–	20 MnMoNi 4 5	–	SQV 2 B	K12539	20 MnMoNi 4-5	–	–	–	–	–	1.6311	–
–	10 NiMnMo 6 5	–	–	K11160	–	–	–	–	–	–	1.6312	–
–	16 NiCrMO 12 6	–	–	–	–	16 NCD 13	–	–	–	–	1.6782	–
–	15 MnCrMoNiV 5 3	–	–	–	15 MnCrMoNiV 5-3	–	–	–	–	–	1.6920	–
50B40	37 CrB 1	120 M 36	SMnC 3 H	H50401	38 Cr 2	–	35 CB 1	–	–	–	1.7007	–
–	13 Cr 2	–	–	–	–	–	–	–	–	–	1.7012	–
–	17 CrS 3	17 CrS3	–	–	17 CrS 3	17 CrS 3	–	–	–	–	1.7014	–
5015	15 Cr 3	523 M15	SCr 415 H	G50150	15 Cr 2	12 C 3	–	–	–	–	1.7015	–
5117	17 Cr 3	17 Cr 3	–	G51170	(15 Cr 2 KD)	18 C 3	–	–	–	–	1.7016	–
5130 H	34 Cr 4	530 A 32	SCr 430 H	G51300	34 Cr 4 KD	32 C 4	34 Cr 4 KB	–	–	–	1.7033	–
5132 H	37 Cr 4	530 A 36	SCr 435 H	G51320	37 Cr 4	38 C 4	36 CrMn 4	–	–	–	1.7034	–
5140	41 Cr 4	530 M 40	SCr 440 H	G51400	41 Cr 4	42 C 4	41 Cr 4	–	–	–	1.7035	–
–	28 CrS 4	–	–	–	28CrS4	28CrS4	–	–	–	–	1.7036	–
–	34 CrS 4	34 CrS 4	–	–	34 CrS 4	34 CrS 4	34 CrS 4	–	–	–	1.7037	–
–	41 CrS 4	41 CrS 4	–	–	41 CrS 4	41 CrS 4	41 CrS 4	2245	–	–	1.7039	–
–	38 Cr 4	–	–	–	38 Cr 4	–	38 Cr 4	–	–	–	1.7043	–
5140	42 Cr 4	530 A 40	SCr 440	–	40 NiCrMo 3	42 C 4 TS	40 NiCrMo 3	2245	–	–	1.7045	–
–	54 SiCr 6	–	–	–	–	54 SC 6	–	–	–	–	1.7102	–
–	67 SiCr 5	–	–	–	67 SiCr 5	–	67 SiCr 5	–	–	–	1.7103	–
9262	60 SiCr 7	–	–	–	60 SiCr 8	–	–	–	–	–	1.7108	–
–	52 SiCrNi 5	–	–	–	–	52 SCN 5	–	–	–	–	1.7117	–
5115	16 MnCr 5	527 M 17	SCR 415	G 51150	16 MnCr 5 KD	16 MC 5	16 MnCr 5	2173	–	–	1.7131	–
–	49 CrMo 4	–	SCM 445	–	–	–	–	–	–	–	1.7238	–
–	16 CrMo 4	18 CrMo4	SCM 418 H	–	18 CrMo 4	15 CD 3.5	18 CrMo 4	–	–	–	1.7242	–
–	10 CrMo 11	–	–	–	–	12 CD 10	–	–	–	–	1.7276	–
–	16 CrMo 9 3	–	–	–	–	20 CD 8	–	–	–	–	1.7281	–
–	22 CrMoS 3 5	–	–	–	22 CrMoS 3-5	22 CrMoS 3-5	–	–	–	–	1.7333	–
A 387 Gr. 12 Cl. 2	16 CrMo 4 4	–	–	K11564	–	–	A 18 CrMo 4 5 KW	–	–	–	1.7337	–
–	12 CrMo 8 5	–	–	K21509	–	–	–	–	–	–	1.7358	–
–	12 CrMo 19 5	3606-625	SCMV 6	K41545	X 12 CrMo 5	Z 10 CD 5.05	16 CrMo 20 5	–	–	–	1.7362	–
–	X 7 CrMo 6 1	B 5	–	S50281	CM 5-IG	–	–	–	–	–	1.7373	–
–	12 CrMo 9 10	–	–	–	–	12 CrMo 9-10	–	–	–	–	1.7375	–
–	SG-CrMo 9	–	–	S50480	–	–	–	–	–	–	1.7388	–
–	51 CrMoV 4	–	–	–	51 CrMoV 4	51 CDV 4	51 CrMoV 4	–	–	–	1.7701	–
–	21 CrMoV 5 7	–	–	K14073	21 CrmoV 5-7	20 CDV 5.07	–	–	–	–	1.7709	–
–	20 CrMoVTiB 4 10	–	–	–	20 CrMoVTiB 4-10	20 CrMoVTiB 4-10	–	–	–	–	1.7729	–
6150	50 CrV 4	735 A 50	SUP 10	G61500	51 CrV 4	50 CV 4	50 CrV 4	2230	–	–	1.8159	–
–	PS 275 TMK	S 275 ML	–	–	S 275 ML	S 275 ML	S 275 ML	–	–	–	1.8819	–
–	S 355 G1 M	–	–	–	S 355 G 1 M	–	–	–	–	–	1.8822	–
–	BTStE 460 TM	S 460 ML	–	–	S 460 ML	E 460	S 460 ML	–	–	–	1.8838	–
–	S 500 ML	–	–	–	S 500 ML	–	–	–	–	–	1.8839	–

NOTE: For legend, see page Y217.

(continued)

P4 Workpiece Materials Listing • Steel • P4 *(continued)*

P4 Alloy Steels and Tool Steels *Content: C>.25%* *Tensile Strength RM (MPa)*: 850–1400* *Hardness (HB): 350–450 (HRC): 35–48*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
–	S 275 MH	–	–	–	S 275 MH	–	S 275 MH	–	–	–	1.8843	–
–	S 275 MLH	–	–	–	S 275 MLH	–	S 275 MLH	–	–	–	1.8844	–
–	S 355 MH	–	–	–	S 355 MH	–	S 355 MH	–	–	–	1.8845	–
–	S 355 MLH	–	–	–	S 355 MLH	–	S 355 MLH	–	–	–	1.8846	–
–	S 420 MH	–	–	–	S 420 MH	–	S 420 MH	–	–	–	1.8847	–
–	S 420 MLH	–	–	–	S 420 MLH	–	S 420 MLH	–	–	–	1.8848	–
–	S 460 MH	–	–	–	S 460 MH	–	S 460 MH	–	–	–	1.8849	–
–	S 460 MLH	–	–	–	S 460 MLH	–	S 460 MLH	–	–	–	1.8850	–
–	FStE 355 OS 4/ S420G5Q	–	–	–	S 420 G 2	–	–	–	–	–	1.8853	–
–	P 550 QL	–	–	–	P 550 QL	–	–	–	–	–	1.8878	–
–	StE 460	S 460 N	–	–	S 460 N	E 460	S 460N	–	–	–	1.8901	–
A 633 Gr. E	St E 420	S 420 N	SM 50 C	K02002	FeE 420 KGN	E 420-I	Fe E 420 KG	2143	–	–	1.8902	–
–	TStE 460	S 460 L	–	–	S 460 NL	E460	S 460 NL	–	–	–	1.8903	–
–	S 550 Q	–	–	–	S 550 Q	E 550	S 550 Q	–	–	–	1.8904	–
A 633 Gr. E	St E 460	P 460 N	SM 53 B	K02900	P 460 N	E 460-I	Fe E 460 KG	2143	–	–	1.8905	–
–	BGH 8906	55 F	–	–	S 460 QL	S 460 QL	S 460 QL	–	–	–	1.8906	–
–	St E 500	–	SM 58	K02001	–	–	–	–	–	–	1.8907	–
–	S 460 Q	55 F	–	–	S 460 Q	E 460	S 460 Q	–	–	–	1.8908	–
–	S 420 NL/TStE 420	S 420 NL	STK 540	K02002	S 420 NL	E 420 T-I	Fe E 420 KT	–	–	–	1.8912	–
–	EStE 420/ S420NL1	–	STK 540	–	–	–	–	–	–	–	1.8913	–
–	S 620 Q	–	–	–	S 620 Q	E 620	S 620 Q	–	–	–	1.8914	–
–	T St E 460/ P460NL1	P 460 NL 1	–	K02900	P 460 NL1	E 460 T-I	Fe E 460 KT	–	–	–	1.8915	–
–	S 460 QL1	55 F	–	–	S 460 QL 1	–	–	–	–	–	1.8916	–
–	T St E 500	–	–	K02001	–	E 500 T-I	–	–	–	–	1.8917	–
–	EStE 460/ P460Nl2	P 460 NL 2	–	–	P 460 NL 2	P 460 NL 2	P 460 NL 2	–	–	–	1.8918	–
–	EStE 500/ S500NL1	–	–	–	S 500 NL 1	–	–	–	–	–	1.8919	–
–	TStE 690 VB/ S690G2QL	–	–	K11646	S 690 G 2 QL	–	–	–	–	–	1.8921	–
–	S 690 G 4 QL/ TStE 690 VC	–	–	–	S 690 G 4 QL	–	–	–	–	–	1.8922	–
–	S 590 QL/TStE 590 V	–	–	–	S 590 QL	–	–	–	–	–	1.8923	–
–	S 500 Q (StE 500 V)	–	–	–	S 500 Q	E 500	S 500 Q	2614	–	–	1.8924	–
–	S 890 QL 1 (EStE 90 V)	–	–	–	S 890 QL 1	–	–	–	–	–	1.8925	–
–	S 690 QL (TStE 690 V)	–	SHY 685 NS	–	S 690 QL	–	–	–	–	–	1.8928	–
–	TStE 690 VD/ S690G3QL	–	–	–	S 690 G 3 QL	–	–	–	–	–	1.8929	–
–	S 690 Q/StE 690 V	–	SHY 685 N	–	S 690 Q	E 690	S 690 Q	–	–	–	1.8931	–
–	WSt E 420/ P420NH	S 420 NL	STK 540	K02002	S 420 NL	S 420 NL	Fe E 420 KW	–	–	–	1.8932	–
–	S 960 QL/TStE 960 V	–	–	–	S 960 QL	–	–	–	–	–	1.8933	–
–	WSt E 460/ P460NH	P 460 NH	–	K02900	P 460 NH	P 460 NH	Fe E 460 KW	–	–	–	1.8935	–
–	P420 QH	–	–	–	P 420 QH	–	–	–	–	–	1.8936	–
–	TStE 770 V/ S770QL	–	–	–	S 770 QL	–	–	–	–	–	1.8938	–
–	EStE 790 V/ S790QL1	–	–	–	S 790 QL 1	–	–	–	–	–	1.8939	–
–	S 960 Q	–	–	–	S 960 Q	E 960 T-II	S 960 Q	–	–	–	1.8941	–
–	S 550 G 1 QL 1/ EStE 550 VA	–	–	–	S 550 G 1 QL 1	–	–	–	–	–	1.8944	–
–	S 355 J 0 WP	WR 50 A	–	–	S 355 J0 WP	E 36 W-A3	S 355 J0 WP	–	–	–	1.8945	–
–	S 355 J 2 WP	S 355 J 2 WP	–	–	S 355 J2 WP	E36W-A4	S 355 J2 WP	–	–	–	1.8946	–
–	L 415 QB	–	–	–	L 415 QB	L 415 QB	–	–	–	–	1.8947	–
–	L 360 QB	–	–	–	L 360 QB	L 360 QB	–	–	–	–	1.8948	–
–	L 450 QB	–	–	–	L 450 QB	L 450 QB	–	–	–	–	1.8952	–
–	S 460 NH (FGS 47)	–	–	–	S 460 NH	–	S 460 NH	–	–	–	1.8953	–
–	EStE620VA/S 620 G 1 QL 1	–	–	–	S 620 G 1 QL 1	–	–	–	–	–	1.8954	–
–	L 485 QB	–	–	–	L 485 QB	L 485 QB	–	–	–	–	1.8955	–
–	S 460 NLH/FG S 47	–	–	–	S 460 NLH	–	S460NLH	–	–	–	1.8956	–
–	L 555 QB	–	–	–	L 555 QB	L 555 QB	–	–	–	–	1.8957	–
–	9 CrNiCuP 3 2 4	WR 50 A	SPA-H	K11430	–	–	–	–	–	–	1.8962	–
–	WTSt 52-3	WR 50 C	SMA 58 W	K11430	S 355 J 2 G 1 W	E 36 W-A2	–	–	–	–	1.8963	–
–	EStE 690 VA	–	–	–	S 690 G1 QL1	–	–	–	–	–	1.8964	–
–	S 355 J 2 G 2 W	S 355 J 2 G 2 W	–	–	S 355 J 2 G 2 W	S 355 J 2 G 2 W	S 355 J 2 G 2 W	–	–	–	1.8965	–
–	S 355 K 2 G 1 W	S 355 K 2 G 1 W	SMA 490 CW	–	S 355 K2 G1 W	S 355 K2 G1 W	S 355 K 2 G 1 W	–	–	–	1.8966	–
–	S 355 K 2 G 2 W	S 355 K 2 G 2 W	–	–	S 355 K2G2W	S 355 K 2 G 2 W	S 355 K 2 G 2 W	–	–	–	1.8967	–
–	QStE 600 TM/S 600 MC	–	–	–	S 600 MC	E 620 D	S 600 MC	–	–	–	1.8969	–
–	StE 415..7/L 415 NB	–	–	–	L 415 NB	L 415 NB	–	–	–	–	1.8972	–
–	StE 415.7 TM/L 415 MB	–	–	–	L 415 MB	L 415 MB	–	–	–	–	1.8973	–
–	S 700 MC (QStE 690 TM)	–	–	–	S 700 MC	E 690 D	S 700 MC	–	–	–	1.8974	–
–	L 450 MB/StE 445.7 TM	–	–	–	L 450 MB	L 450 MB	–	–	–	–	1.8975	–
–	S 650 MC (QStE 650 TM)	–	–	–	S 650 MC	E 620 D	S 650 MC	–	–	–	1.8976	–
–	L 485 MB/StE 480.7 TM	–	–	–	L 485 MB	L 485 MB	–	–	–	–	1.8977	–
–	StE 550.7 TM/L 555 MB	–	–	–	L 555 MB	L 555 MB	–	–	–	–	1.8978	–

(continued)

P4 Workpiece Materials Listing • Steel • P4 *(continued)*

P4 Alloy Steels and Tool Steels *Content: C>.25%* *Tensile Strength RM (MPa)*: 850–1400* *Hardness (HB): 350–450 (HRC): 35–48*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
A 570 Gr. 50	St 50-2	4360-50 B	SS 50	–	E 295	A 50-2	Fe 490	2172	–	–	1.0050	–
–	St 60-2	4360-55 E	SM 58	–	E 335	A 60-2	Fe 60-2	1650	–	–	1.0060	–
–	St 70-2	E 360	–	–	E 360	A 70-2	Fe 70-2	1655	–	–	1.0070	–
–	C4D	–	–	–	C 4 D	FM 5	C 4 D	–	–	–	1.0300	–
–	C 22 8	–	–	–	P 250 GH	–	–	–	–	–	1.0460	–
–	H 260/ZSt E 260	H 240 LA	–	–	H 240 LA	E 240 C	–	–	–	–	1.0480	–
–	ZStE 380/H 380	H 360 L A	–	–	H 360 LA	E 355 C	–	–	–	–	1.0550	–
–	GL-E - 40 (S 390 G 3 S)	–	–	–	S 390 G 3 S	–	–	–	–	–	1.0560	–
–	C60D	–	–	–	C 60 D	FM 60	C 60 D	–	–	–	1.0610	–
–	C 64/64 Mn 3	–	–	–	C 64	–	–	–	–	–	1.0640	–
–	38 SMn 28	38 SMn 28	–	–	38 SMn 28	38 SMn 28	–	–	–	–	1.0760	–
–	QSt E 260 TM/5260 MC	–	–	–	S 260 MC	41 S 7	Fe E 275 TM	–	–	–	1.0970	–
–	C3D2	–	–	–	C 3 D 2	FM 5	C 3 D 2	–	–	–	1.1110	–
1330	28 Mn 6	150 M 28	SCMn 1	G 13300	28 Mn 6	35 M 5	C 28 Mn	–	–	–	1.1170	–
–	C 42 E Al/Ck 42 Al	–	–	–	S 355 G15	–	–	–	–	–	1.1190	–
–	C56D2/D 55-2	–	–	–	C 56 D 2	FM 56	C 56 D 2	–	–	–	1.1220	–
–	C 70 W1	–	–	–	CT 70	C 70 E 2 U	C 70 K U	–	–	–	1.1520	–
–	C 70 W2	–	–	–	C 70 U	–	–	–	–	–	1.1620	–
–	C 45 W	–	–	–	C 45 U	Y3 42	–	–	–	–	1.1730	–
–	C 60 W	–	SK 7	–	–	Y3 55	–	–	–	–	1.1740	–
–	100 CrMn 6	–	–	K19195	100 CrMn 6	100 CM 6	–	–	–	–	1.3520	–
–	28 B 2	–	SWRCHB 26	–	C 30 B	20 B 3	–	–	–	–	1.5510	–
5130	28 Cr 4	530 A 30	–	G51300	28 Cr 4	30 CD 4	–	–	–	–	1.7030	–
–	S 420 G1 M	–	–	–	P 550 M	–	–	–	–	–	1.8830	–
–	St E 380	–	SM 50 B	–	S 380 N	–	Fe E 390 KG	–	–	–	1.8900	–
–	TStE 380/ S380NL	–	–	–	S 380 NL	–	Fe E 390 KT	2117	–	–	1.8910	–
–	TStE 690 VA/ S690G1QL	–	–	–	S 690 G 1 QL	–	–	–	–	–	1.8920	–
–	WSt E 380/ P380Nh	–	–	–	P 380 NH	–	Fe E 390 KW	2116	–	–	1.8930	–
–	S 890 Q	–	–	–	S 890 Q	S 890 Q	S 890 Q	–	–	–	1.8940	–

P5 Workpiece Materials Listing • Steel • P5

P5 Ferritic, Martensitic, and PH Stainless Steels *Tensile Strength RM (MPa)*: 600–900* *Hardness (HB): <330 (HRC): <35*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
410 S	X 7 Cr 14	–	–	–	–	–	–	–	–	–	1.4001	–
405	X 6 CrAl 13	405 S 17	SUS 405	S40500	X 6 CrAl 13	Z 6 CA 13	X 6 CrAl 13	2302	–	–	1.4002	–
–	X 2 CrNi 1 2	–	–	–	Hyfab3/12	CLC4003	F12N(Mn<1,50)	–	–	–	1.4003	–
416	X 12CrS 13	416 S 21	SUS416	S41600	X 12 CrS 13	Z 12 CF 13	X12CrS13	2380	–	–	1.4005	ATI 416™
410	X 12Cr 13	410 S 21	SUS410	S 41000	(X 12 Cr 13 KD)	Z 12 C 13	X12Cr13	2302	–	–	1.4006	ATI 410™
414	GX 8 CrNi 1 3	410 C 21	SCS 1	S41400	GX 7 CrNiMo 12-1	Z 12 CN 13 M	GX 12 Cr 13	–	–	–	1.4008	–
–	X 8 Cr 14	–	SUS Y 410	S41080	X 8 Cr 13 KE	–	–	–	–	–	1.4009	B13Fe
–	GX 12 Cr 1 2	–	–	–	GX12Cr12	GX12Cr12	–	–	–	–	1.4011	–
–	N 3 2 0 (LW)	–	–	–	3S62	–	–	–	–	–	1.4014	–
–	X 8 Cr 18	–	SUS Y 430	S43080	–	–	–	–	–	–	1.4015	B17Fe
430	X 8 Cr 17	430 S 15	SUS430	S 43000	X 8 Cr 17	Z8C17	X8Cr17	2320	–	–	1.4016	ATI 430™
–	X 6 CrNi 17 1	–	–	–	X6CrNi17-1	F17N	X6CrNi17-1	–	–	–	1.4017	–
420	X20Cr13	420 S 37	SUS 420J1	S42000	X 20 Cr 13	Z20C13	X20Cr13	2303	–	–	1.4021	ATI 420™
403	X 15 Cr 13	420 S 29	SUS 410 J1	J91201	X 15 Cr 13	Z 12 C 13 M	X 12 Cr 13	2301	–	A403M	1.4024	ATI 403™
–	GX 20 Cr 1 4	420 C 29	SCS 2	–	–	Z 20 C 13 M	–	–	–	A743-4	1.4027	–
420	X 40 Cr 13	–	SUS 420 J2	S42080	X 40 Cr 13	Z 40 C 14	X 40 Cr 14	2304	–	–	1.4031	–
–	GX 120 Cr 29	425 C 11	–	–	–	–	–	–	–	F30C	1.4086	–
430 F	X 12 CrMoS 17	441 S 29	SUS 430 F	S 43020	X 14 CrMoS 17	Z 10 CF 17	X 10 CrS 17	2383	–	–	1.4104	–
430	X 4 CrMoS 18	–	SUS 430F	–	X 6 CrMoS 17	Z 6 CDF 18 - 02	–	–	–	–	1.4105	–
–	X 2 CrMoSiS 18 2 1	–	–	J91151	–	–	–	–	–	CA15	1.4106	–
–	GX 8 CrNi 1 2	–	–	–	GX 8 CrNi 12	GX8CrNi 12	G X 8 CrNi 12	–	–	–	1.4107	–
434	X 6CrMo 17	434 S 17	SUS434	S43400	434S17	Z8CD17-01	X8CrMo17	2325	–	–	1.4113	AL 434
–	X 15 CrMo 13	–	–	–	–	–	–	–	–	–	1.4119	–
–	GX 70 CrMo 29 2	–	–	–	–	Z 60 CD 29.2 M	–	–	–	–	1.4136	–
–	X 2 CrNi 24 12	309 S 93	–	–	X 2 CrNi 24 13 KE	Z 2 CN 24-14	–	–	–	–	1.4332	CN23/12-IG
–	X 5 NiCr 32 21	–	–	S33200	–	–	–	–	–	B536	1.4333	H521
–	GX 5 CrNiMo 16 5	–	–	–	GX 4 CrNiMo 16-5-1	GX4CrNiMo 16-5-1	G X 4 CrNiMo 16-5-1	–	–	–	1.4405	–
–	ERO 4411 A	–	–	–	GX 4 CrNiMo 16-5-2	GX 4 CrNiMo 16-5-2	–	–	–	–	1.4411	–
–	X 38 CrMo 14	–	–	–	–	–	–	–	–	–	1.4419	–
–	X 8 CrTi 18	–	–	–	X 6 Cr 18 KE	–	–	–	–	–	1.4502	–
430 Nb	X 6 CrNb 17	–	SUS 430 LX	–	X 3 CrNb 17	Z 8 CNb 17	X 6 CrNb 17	–	–	–	1.4511	AXC525
409	X 6 CrTi 12	409 S 19	SUH 409	S40900	X 5 CrTi 12	Z 6 CT 12	X 6 CrTi 12	–	–	–	1.4512	–
–	X 6 CrNiTi 12	–	–	–	X 6 CrNiTi 12	X 6 CrNiTi 12	X 6 CrNiTi 12	–	–	–	1.4516	–
–	X 2 CrTi 17	–	SUS 430 LX	–	X 2 CrTi 17	F 20T	X 2 CrTi 17	–	–	–	1.4520	–
–	X 8 CrMoTi 17	–	–	–	X 2 CrMoTiS 18 2	X2CrMoTiS18-2	–	–	–	–	1.4523	1802
–	GX 5 CrNiCu 16 4	–	–	–	GX 5 CrNiCu 16-4	GX 5 CrNiCu 16-4	–	–	–	–	1.4525	–
–	X 6 CrMoNb 17 1	–	–	–	X 6 CrMoNb 17-1	X6CrMoNb 17-1	F 17 MNb	–	–	–	1.4526	–
904 L	X 1 NiCrMoCuN 25 20 5	904 S 13	–	N08904	X 1 NiCrMoCuN 25 20 5	Z 1 NCDU 25 20	–	2562	–	–	1.4539	ATI 904L™
348	X 5 CrNiNb 18 10	S 527	–	J92640	–	–	X 6 CrNiNb 18 11	–	–	–	1.4546	ATI 348™
–	X 5 CrNiNb 19 9	–	SUS Y 347	S34780	X 5 CrNiNb 20 10 KE	Z 6 CNNb 20-10	–	–	–	–	1.4551	–
–	GX 7 NiCrMoCuNb 42 20	–	–	–	GX 7 NiCrMoCuNb 4220	–	–	–	–	–	1.4559	–
–	X 5 CrNiMoNb 19 12	318 S 96	–	S31980	X 5 CrNiMoNb 19 12 03 KE	Z 4 CNDSNb 19-12-03	–	–	–	–	1.4576	–
–	X 2 CrAlTi 18 2	–	–	–	X 2 CrAlTi 18-2	DMV 59	X 2 CrAlTi 18-2	–	–	–	1.4605	–
–	X 10 CrAl 7	–	–	–	X 10 CrAl 7	–	–	–	–	–	1.4713	–

NOTE: For legend, see page Y217.

(continued)

P5 ■ Workpiece Materials Listing • Steel • P5 *(continued)*

P5 Ferritic, Martensitic, and PH Stainless Steels *Tensile Strength RM (MPa)*: 600–900* *Hardness (HB): <330 (HRC): <35*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
–	X 215 Cr 12	–	–	–	–	–	–	–	–	–	1.4721	–
H-12	X 10 CrAl 13	BH 12	SUS 405	T20812	X 10 CrAl 13	Z 10 C 13	X 10 CrAl 12	–	–	–	1.4724	–
430	X 10 CrAl 18	(430 S 15)	SUH 21	S43000	–	Z 10 CAS 18	(X 8 Cr 17)	–	–	–	1.4742	–
446	X 10 CrAl 25	–	SUH 442	S44600	X 10 CrAl 24	Z 10 CAS 24	X 16 Cr 26	2322	–	–	1.4762	–
–	GX 40 CrNiSi 27 4	–	–	J92605	–	–	–	–	–	–	1.4823	–
–	X 12 CrNi 22 12	311 S 94	SUS Y 309	S30980	X 15 CrNi 23 13	–	X 16 CrNi 23 14	–	–	309	1.4829	–
–	X 9 CrNiSiNCe 21 11 2	–	–	–	X 9 CrNiSiNCe 21-11-2	–	–	–	–	–	1.4835	–
314	X 15 CrNiSi 25 20	314 S 25	SUH 310	S31400	X 15 CrNiSi 25 20	Z 15 CNS 25.20	X 16 CrNiSi 25 20	–	–	–	1.4841	Cronifer® 2520
–	X 12 CrNi 25 20	310 S 94	–	S31080	X 12 CrNi 26 21 KE	Z 12 CN 26-21	–	–	–	–	1.4842	–
–	CrNi 25 20	–	SCS 18	S31400	–	–	–	–	–	–	1.4843	–
310 S	X 12 CrNi 25 21	310 S 24	SUS 310 S	S31008	X 8 CrNi 25 21	Z 12 CN 25.20	X 6 CrNi 25 20	2361	–	–	1.4845	ATI 310S™
HK	X 40 CrNiSi 25 20	310 C 40	SCH 21	J94204	–	–	GX 40 CrNi 26 20	–	–	–	1.4848	–
–	GX 40 NiCrSiNb 38-18	–	–	–	3072.76	–	–	–	–	–	1.4849	–
–	GX 10 NiCrNb 32 20	–	–	J95151	–	–	–	–	–	–	1.4859	–
330	X 12 NiCrSi 35 16	NA 17	SUH 330	N08330	X 12 NiCrSi 35 1 6	Z 12 NCS 37.18	–	–	–	–	1.4864	–
–	X40NiCrSi38-18	330 C 40	SCH15/SCH16	J94605	330C11/330C40/331C40	–	GX50NiCr39-19	–	–	–	1.4865	–
–	GX 50 CrNi 30-30	–	–	N08801	–	Z5NCT3220	–	–	–	–	1.4868	–
B163	X 10 NiCrAlTi 32 20	NA 15	NCF800(TP)	–	NA15(H)	Z10NC32.21	–	–	B163	–	1.4876	B163
–	X 6 NiCrNbCe 32 27	–	–	–	X 6 NiCrNbCe 32-27	–	–	–	–	–	1.4877	–
–	X 12 NiCrSi 35 19	–	–	N08830	X1 0 NiCrSi 35 19	–	–	–	–	–	1.4886	330
–	X 10 NiCrSiNb 35 22	–	–	–	X10NiCrSiNb35-22	–	–	–	–	–	1.4887	–
–	X 10 CrMoV 9 1	–	–	S59180	X 10 CrMoV 9-1	–	–	–	–	–	1.4903	–
–	X 20 CrMoV 12 1	–	–	–	X 20 CrMoV 11-1	–	X 20 CrMoV 12 01 KW	2317	–	–	1.4922	–
–	GX 22 CrMoV 12 1	–	–	–	G-X 22 CrMoV 12 1	GX23CrMoV12-1	G X 23 CrMoV 12-1	–	–	–	1.4931	–
422	X 20 CrMoWV 12 1	–	SUH 616	S42200	–	–	X 22 CrMoWV 12 1	–	–	–	1.4935	–
661	X 12 CrCoNi 21 20	–	SUH 661	R30155	–	–	–	–	–	–	1.4971	–
R30155	X 12 CrCoNiMoWNb 21 20 20	–	–	R30155	X 12 CrCoNiMoWNb 21 20 20	Z 12 CKNDWNb 21.20.20	N-155	–	–	–	1.4974	–
–	X 40 CoCrNi 20 20	–	–	–	–	Z 42 CNKDWNb	–	–	–	–	1.4977	–
403	X 6 Cr 13	403 S 17	SUS 403	S 40300	X 6 Cr 13	Z 6 C 13	X 6 Cr 13	2301	–	A240	1.4000	ATI 410S™
439	X 6 CrTi 17	–	SUS 430 LX	S 43035	X 8 CrTi 1 7	Z 8 CT 1 7	X 6 CrTi 17	–	–	–	1.4510	430 Ti
–	X 22 CrMoV 1 -1 = ST12T	–	–	–	–	–	–	–	–	A437-76 Grade B4B	–	ATI FV448™
409 Cb	–	–	–	–	–	–	–	–	–	–	–	ATI 409Cb™
436 S	–	–	–	–	–	–	–	–	–	–	–	ATI 436S™
439 HP	–	–	–	S43035	–	–	–	–	–	–	–	ATI 439 HP™
441 HP	–	–	–	–	–	–	–	–	–	–	–	ATI 441 HP™
–	–	–	–	S44735	–	–	–	–	–	A240	–	AL 29-4C®
–	–	–	–	–	–	–	–	–	–	B625	–	ATI E-BRITE®
403Cb	–	–	–	–	–	–	–	–	–	–	–	T656
420 modified	–	–	–	–	–	–	–	–	–	–	–	Stavax ESR
–	–	–	–	–	–	–	–	–	–	–	–	420HC
–	–	–	–	–	–	–	–	–	–	–	–	CPM 154
–	–	–	–	–	–	–	–	–	–	–	–	CPM® S30V®
–	–	–	–	–	–	–	–	–	–	–	–	CPM® S35VN®
420 V	–	–	–	–	–	–	–	–	–	–	–	CPM® S90V®
–	–	–	–	–	–	–	–	–	–	–	–	M390
422	–	–	–	S42200	–	–	–	–	–	–	–	616

P6

Workpiece Materials Listing • Steel • P6

P6 High-Strength Ferritic, Martensitic, and PH Stainless Steels *Tensile Strength RM (MPa)*: 900–1350*
Hardness (HB): 350–450 (HRC): 35–48

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
–	17-7 PH	301 S 81	SUS 631	S17700	X 7 CrNiAl 17-7	X7CrNiAl17-7; Z9CNA17-07	X 7 CrNiAl 17-7	2388	–	A693	1.4564	ATI 17-7™
–	GX 22 CrNi 17	ANC 2	–	J91803	–	Z 20 CN 17.2 M	–	–	–	CB30	1.4059	–
–	GX 30 CrSi 6	–	–	–	–	–	–	–	–	–	1.4710	–
–	GX 4 CrNi 13 4	–	–	–	GX 4 CrNi 13-4	GX 4 CrNi 13-4	GX 4 CrNi 13-4	–	–	–	1.4317	–
–	GX 40 CrSi 17	–	–	–	–	–	GX 35 Cr 17	–	–	–	1.4740	–
–	GX 40 CrSi 24	–	SCH 1	–	–	–	GX 35 Cr 13	–	–	–	1.4745	–
–	GX 40 CrSi 28	452 C 11	SCH 2	J92605	–	–	GX 35 Cr 28	–	–	CC50	1.4776	–
–	X 105 CrCoMo 18 2	–	–	–	–	–	–	–	–	–	1.4528	N690
440 C	X 105CrMo 17	–	SUS 440C	S44004	X 105 CrMo 17	Z 100 CD 17	X 105 CrMo 17	–	–	–	1.4125	ATI 440C™
–	X 110 CrMoV 15	–	SUS 430 LX	–	–	Z 4 CN b 17	X 6 CrNb 17	–	–	–	1.4111	–
5718.9	X 12 CrNiMo 12	S.151	–	S64152	–	Z12CNDV12	–	–	–	–	1.4939	ATI Jethete™ M152
–	X 12 CrNiMoV 12 3	–	–	–	X 12 CrNiMoV 12-3	X 12 CrNiMoV 12-3	–	–	–	–	1.4938	T522
–	X 15 TN	–	–	–	420S25	Z40CDV16-02	X40CrMoVN16-2	–	–	F899	1.4123	X 15 TN
15-5 PH	X 15 U 5 W	–	–	S15500	–	Z6CNU15.05	–	–	–	A564/ A693/A705	1.4545	ATI 15-5™
–	X 19 CrMoNbVN 11 1	–	–	–	–	Z 21 CDNbV 11	–	–	–	–	1.4913	Jethete X19
431	X 19 CrNi 17 2	431 S 29	SUS 431	S 43100	X 19 CrNi 17 2	Z 15 CN 16.02	X 16 CrNi 16	2321	–	–	1.4057	431 (HT)
–	X 20 CrMo 17 1	–	–	–	–	–	–	–	–	–	1.4115	B17MoFe
420F Mod	X 22 CrMoNiS 13 1	–	–	–	–	–	–	–	–	–	1.4121	Bioline 4C27A
–	X 22 CrMoV 12 1	762	–	–	X 22 CrMoV 12-1	Z 21 CDV 12	X 22 CrMoV 12 1	–	–	–	1.4923	Jethete X20
420	X 29 CrS 13	416 S 37	SUS 416	–	X 29 CrS 13	Z29CF13	X 29 CrS 13	–	–	–	1.4029	–
–	X 3 CrNiCuTi 12 9	–	–	S45500	–	–	X 6 CrNiNb 18 11	–	–	–	1.4543	ATI 455™
13-8 PH	X 3 CrNiMoAl 13 8 2	–	–	S13800	–	Z4 CNDAT 13 09	–	–	–	–	1.4534	ATI 13-8Mo™
420 F	X 30 Cr 13	420 S 45	SUS420J2	S42020	X 30 Cr 13	Z 30 C 13	X 30 Cr 13	2304	–	CA40	1.4028	–
–	X 30CrMoN 15 1	–	–	–	420S45	Z33C13	–	2304	–	–	1.4108	N360
–	X 35 CrMo 17	–	–	–	X 39 CrMo 17 1	X39CrMo17-1	X 35 CrMo 17	–	–	–	1.4122	–
–	X 4 CrNiCuNb 16 4	–	–	J92200	–	Z 4 CNUNb 16.4 M	–	–	–	–	1.4540	–
415 M	X 4 CrNiMo 16 5 1	–	–	–	X 4 CrNiMo 16 5 1	Z 6 CND 16.05.01	–	2387	–	–	1.4418	APX4
–	X 40 CrNi 25 21	310 S 98	SCH 13	–	–	–	–	–	–	–	1.4846	–
–	X 40 CrSiMo 10 2	–	SUH3	–	X 40 CrSiMo 10-2	Z40CSD10	–	–	–	–	1.4731	–
420	X 45 Cr 13	(420 S45)	–	–	X 45 Cr 13	Z 40 C 14	X 40 Cr 14	–	–	–	1.4034	–
–	X 45 CrMoV 15	–	–	–	X 50 CrMoV 15	Z 50 CD 15	X 50 CrMo V 15	–	–	–	1.4116	UGI 4116N
HNV3	X 45 CrSi 9 3	–	SUH1	–	401S45	Z45CS9	X45CrSi8	–	HNV3	–	1.4718	–
HNV 2	X 45 SiCr 4	–	–	S64006	–	–	–	–	–	–	1.4704	–
CA 6-NM	X 5 CrNi 134	425 C 11	SCS 5	J91540	X 3 CrNiMo 13 4	Z 4 CDN 13.4	X 6 CrNi 13 04	2385	–	–	1.4313	–
630	X 5 CrNiCuNb 16 4	–	SUS 630	–	X 5 CrNiCuNb 16-4	Z6CNU17.04	–	–	–	CB7Cu	1.4542	UGIMA® 4542
17-4 PH	X 5 CrNiCuNb 17 4 4	–	SUS 630	S17400	X 5 CrNiCuNb 16-4	X5CrNiCuNb16.4	–	–	–	A693	1.4548	–
–	X 5 CrNiMoCuNb 14 5	–	–	–	X 5 CrNiMoCuNb 14-5	X 5 CrNiMoCuNb 14-5	X 5 CrNiMoCuNb 14-5	–	–	–	1.4594	–
–	X 50 CoCrNi 20 20	–	–	–	–	–	–	–	–	–	1.4978	–
EV8	X 53 CrMnNiN 2 9	349 S 54	SUH35/SUH36	S63008	349S54	Z52CMN21.09	X53CrMnNiN21-9	–	EV8	–	1.4871	–
–	X 55 CrMo 14	–	–	–	–	Z 50 CD 13	–	–	–	–	1.4110	–
–	X 60 CrMnMoVNbN 21 10	–	–	–	–	Z 60 CMDVNb 21-10 Az	–	–	–	–	1.4785	–
440 A	X 65 CrMo 14	–	SUS 440A	S44002	X 70 CrMo 15	Z 70 CD 14	–	–	–	–	1.4109	ATI 440A™
–	X 7 CrNiAl 17 7	301 S 81	SUS 631	S17700	X 7 CrNiAl 17-7	X7CrNiAl17-7;Z9CNA17-07	X 7 CrNiAl 17-7	2388	–	A693	1.4568	–
632	X 7 CrNiMoAl 15 7	–	–	S15700	–	–	–	–	–	–	1.4574	PH 15-7 Mo®
–	X 8 CrCoNiMo 10 6	Z 9 CKD 11	–	–	S152	Z10CKD10	–	–	–	–	1.4911	ATI FV535™
15-7 PH	X 8 CrNiMoAl 15 7 2	–	–	S15700	X 8 CrNiMoAl 15-7-2	Z8CNDA15.07	X 8 CrNiMoAl 15-7-2	–	–	A693	1.4532	ATI 15-7™
HNV 6	X 80 CrNiSi 20	443 S 65	SUH 4	S65006	X 80 CrNiSi 20	Z 80 CSN 20.02	X 80 CrSiNi 20	–	–	–	1.4747	–
–	X 85 CrMoV 18 2	–	–	–	X 85 CrMoV 18 2	Z 85 CDMV 18.02	X 85 CrMoV 19 3	–	–	–	1.4748	–
440 B	X 90 CrMoV 18	409 S 1 9	SUS 440 B	S44003	X 90 CrMoV 18	Z 3 CT 1 2	X 6 Cr Ti 1 2	–	–	–	1.4112	–
–	X45CrNiW18-9	331 S 40	SUH31	–	X 45 CrNiW 18 9	Z35CNWS14.14	X45CrNiW18-9	–	–	–	1.4873	–

NOTE: For legend, see page Y217.

M1 Workpiece Materials Listing • Stainless Steel • M1

M1 Austenitic Stainless Steel *Tensile Strength RM (MPa)*: <600* *Hardness (HB): 130–200*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
CF-8	X 6 CrNi 18 9	304 C 15	SCS 13	–	X 2 CrNiN 18 7	Z 6 CN 18.10 M	G X 5 CrNi 19-10	2333	–	CF8	1.4308	CF-8
–	X 2 NiCr 18 16	–	–	–	–	Z 3 CDT 18-02	–	–	–	–	1.4321	–
–	X 1 CrNi 25 21	–	–	–	X 1 CrNi 25 21	X1CrNi25-21	X 1 CrNi 25-21	–	–	–	1.4335	Uranus 65
610	X1CrNiSi 18-15-4	–	–	S30600	X 1 CrNiSi 18-15-4	Z1 CNS 17.5	X 1 CrNiSi 18-15-4	–	–	A240-97A	1.4361	ATI 610™
CF-8M	X 6 CrNiMo 18 10	316 C 16	SCS 14	J92900	GX 5 CrNiMo 19-11-2	GX5CrNiMo 19-11-2	G X 5 CrNiMo 19-11-2	2343	–	–	1.4408	–
–	GX 2 CrNiMo 19 11 2	–	–	–	GX 2 CrNiMo 19-11-2	GX 2 CrNiMo 19-11-2	GX 2 CrNiMo 19-11-2	–	–	–	1.4409	–
–	ER0 4412 AHMo	–	–	J92900	GX 5 CrNiMo19-11-3	GX 5 CrNiMo 19-11-3	–	–	–	A743CF8M	1.4412	–
–	ER0 4416 AHCRMo	–	–	–	GX 2 NiCrMoN 25-20-5	GX2NiCrMoN 25-20-5	–	–	–	–	1.4416	–
–	GX 6 CrNiMo 18 12	317 C 12	–	–	–	–	–	–	–	–	1.4437	–
–	X 2 CrNiMo 18 16 5	–	–	S31780	–	–	–	–	–	–	1.4440	–
–	GX 2 CrNiMoN 17 1 3 4	–	–	–	GX 2 CrNiMoN 17 1 3 4	–	–	–	–	–	1.4446	–
–	GX 6 CrNiMo 17 13	317 C 16	–	J93000	–	–	–	–	–	CG8M	1.4448	–
–	GX 2 NiCrMo 28 20 2	–	–	–	GX 2 NiCrMo 28-20-2	GX 2 NiCrMo 28-20-2	GX 2 NiCrMo 28-20-2	–	–	–	1.4458	–
–	GX 4 NiCrCuMo 30 20 4	–	–	–	GX 4 NiCrCuMo 30-20-4	GX 4 NiCrCuMo 30-20-4	–	–	–	–	1.4527	–
–	GX 5 CrNiNb 18 9	347 C 17	SCS 21	J92710	GX 5 CrNiNb 19-11	Z 4 CNNb 19.10 M	G-X 5 CrNiNb 19-11	–	–	–	1.4552	–
–	GX 2 CrNiMoCuN 20 18 6	–	–	–	GX 2 CrNiMoCuN 20-18-6	GX 2 CrNiMoCuN 20-18-6	–	–	–	–	1.4557	–
–	X 3 CrNiCuMo 17 11 3 2	–	–	–	X 3 CrNiCuMo17 11 3 2	X3CrNiCuMo 17-11-3-2	X 3 CrNiCuMo 17-11-3-2	–	–	–	1.4578	–
–	GX 5 CrNiMoNb 18 10	318 C 17	SCS 22	–	GX 5 CrNiMoNb 19-11-2	Z 4 CNDNb 18.12 M	GX 6 CRNOMONB 20 11	–	–	–	1.4581	–
–	GX 2 NiCrMoCu 25 2 0 5	–	–	–	GX 2 NiCrMoCu 25-20-5	GX 2 NiCrMoCu 25-20-5	–	–	–	–	1.4584	–
–	GX 7 CrNiMoCuNb 18 18	–	–	J94651	–	–	–	–	–	–	1.4585	–
–	GX 2 NiCrMoCuN 29 25 5	–	–	–	GX 2 NiCrMoCuN 29-25-5	GX 2 NiCrMoCuN 29-25-5	–	–	–	–	1.4587	–
–	GX 2 NiCrMoCuN 25 20 6	–	–	–	GX 2 NiCrMoCuN 25-20-6	GX 2 NiCrMoCuN 25-20-6	–	–	–	–	1.4588	–
–	GX 25 CrNiSi 18 9	302 C 35	–	J92602	–	–	G X 16 CrNi 20 10	–	–	CF20	1.4825	–
–	GX 40 CrNiSi 22 9	–	SCH 12	J92603	–	–	–	–	–	–	1.4826	–
–	GX 50 CrNiNb 25 22	–	–	–	–	–	–	–	–	–	1.4836	–
–	GX 40 CrNiSi 25 12	309 C 30	SCS 17	J93503	–	–	GX 35 CrNi 25 12	–	–	CE30	1.4837	–
334	X 8 CrNiAlTi 20 20	–	–	S33400	–	–	–	–	–	–	1.4847	ATI 334™
–	GX 40 NiCrSiNb 38 18	–	–	N08004	–	–	–	–	–	–	1.4849	–
–	GX 40 NiCrSiNb 35 25	–	–	–	–	–	–	–	–	–	1.4852	–
–	GX 40 NiCrSi 35 25	–	–	J95705	–	–	GX 50 NiCr 35 25	–	–	–	1.4857	–
105 MA	BGH 4892	–	–	–	–	–	–	–	–	–	1.4892	–
–	X 3 CrNi 18 11	–	–	–	–	–	X 2 CrNiN 18 11	–	–	–	1.4949	–
–	X 2 CrNiMo 19 12	316 S 93	–	S31683	x 2 CrNiMo 19 13 03 KE	Z 2 CND 19-12-03	–	–	–	–	1.4430	–
–	GX 7 NiCrMoCuNb 25 20	–	SCS 23	J95150	10.204.3.1B	Z 3 NCDU 25.20 M	GX 5 NiCrCuMo 29 21	–	–	–	1.4500	–
–	X 3 CrNiCu 19 9 2	–	–	–	S 124 M	PHYHQ 4560	304 RH1	–	–	–	1.4560	ACX276
–	–	–	–	S63198	–	–	–	–	19-9 DL	–	–	19-9 DL
–	X 2 CrNiMoN 17 13 3	–	–	–	–	Z 2 CND 17.13	X 2 CrNiMoN 17 13 3	–	–	–	–	–
332	–	–	–	N08800	–	–	–	–	–	–	–	ATI 332™
–	–	–	–	N08367	–	–	–	–	–	–	–	AL-6XN®
611	–	–	–	S30601	–	–	–	–	–	A240-97A	–	ATI 611™

M2 Workpiece Materials Listing • Stainless Steel • M2

M2 High-Strength Austenitic Stainless and Cast Stainless Steels *Tensile Strength RM (MPa)*: 600–800*
Hardness (HB): 150–230 (HRC): <25

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
304 H	X 5 CrNi 18 10	304 S 15	SUS 304	S30409	X 6 CrNi 18 10 KD	Z 6 CN 18.09	X 5 CrNi 18 10	2332	–	–	1.4301	–
–	X 5 CrNi 19 9	308 S 96	–	S30888	X 6CrNi 20 10 KE	–	–	–	–	–	1.4302	–
305	X 4 CrNi 18 12	305 S 19	SUS 305	S30500	X 4 CrNi18 12 KD	Z 5 CN 18.12	X 4 CrNi 19 10	–	–	–	1.4303	–
303	X 10 CrNiS 18 9	303 S 21	SUS 303	S30300	X 10 CrNiS 18 9	Z 10 CNF 18.09	X 10 CrNiS 18 09	2346	–	–	1.4305	ATI 303™
304 L	X 2 CrNi 19 11	304 C 12	SUS 304L	S30403	X 3 CrNi18 10 KD	Z 2 CN 18.09	GX 2 CrNi 19 10	2352	–	CF3	1.4306	ATI 304L™
304 L	X 2 CrNi 18 9	304 S 11	SUS 304L	–	X 2 CrNi 18 9	CLC18.9.L	X 2 CrNi 18-9	–	–	–	1.4307	–
–	GX 2 CrNi 19 11	304 C 12	–	J92500	GX2CrNi19-11	GX2CrNi19-11	GX2CrNi19-11	2352	–	CF3	1.4309	–
304 LN	X 2 CrNiN 18 10	304 S 62	SUS 304 LN	S30453	X 2 CrNiN 18 10	Z 8 CN 18.12	X 8 CrNi 19 10	2371	–	–	1.4311	–
305	GX 10 CrNi 18 8	302 C 25	SCS 12	–	–	Z 10 CN 18.9 M	–	–	–	–	1.4312	ATI 305™
308 L	X 2 CrNi 19 9	308 S 92	SUS Y 308L	S30883	X 2 CrNi 20 10 KE	Z 2 CN 20.10	–	–	–	–	1.4316	–
–	X 2 CrNiN 18 7	–	–	–	X 2 CrNiN 18-7	18-7L	18-7L	–	–	–	1.4318	–
302	X 10 CrNi 18 9	302 S 26	SUS 302	S20200	302S31	Z10CN18-09	X 10 CrNi 18 09	2330	–	–	1.4319	ATI 302™
301	X 10 CrNi 18 9	302 S 26	–	J92501	X 10 CrNi 18 9	–	–	–	–	–	1.4324	–
–	X 10 CrNi 30 9	312 S 94	–	–	X 12 CrNi 30 09 KE	Z 10 CN 31-10	–	–	–	–	1.4337	–
–	X 3 CrNi 13 4	–	–	S41086	X 3 CrNi 14 04 KE	–	–	–	–	–	1.4351	410NiMo
202	X 3CrMnNiN 18 8 7	–	–	–	284S16	Z8CMN18-08-05	–	–	–	–	1.4371	–
201	X 12 CrMnNiN 17 7 5	284 S 16	SUS 201	–	X 12 CrMnNiN 17-7-5	X 12 CrMnNiN17-7-5	X 12 CrMnNiN 17-7-5	–	–	–	1.4372	ACX060
316	X 5 CrNiMo 17 12 2	316 S 16	SUS 316	S31600	X6 CrNiMo 17 12 2 KD	Z 6 CND 17.11	X 5 CrNiMo 17 12	2347	–	–	1.4401	ATI 316™
316L	X 2 CrNiMo 17 13 2	316 S 12	SUS 316 L	S31603	GX 3 CrNiMo 17 12 2 KD	Z 3 CND 19.10 M	GX 2 CrNiMo 19 11	2348	–	–	1.4404	ATI 316L™
316 LN	X 2 CrNiMoN 17 12 2	316 S 61	SUS 316 LN	S31653	X 3 CrNiMoN 17 12 2	Z 2 CND 17.12 Az	X 2 CrNiMoN 17 12	2353	–	–	1.4406	ATI 316LN™
–	X 5 CrNiMo 13 4	–	–	J91550	–	Z 6 CND 16.05.01	–	–	–	–	1.4407	–
–	X12CrNiMoS18-11	–	–	–	–	Z3CNDF17-13	–	–	–	–	1.4427	Chronifer® Special KL
316L	X 2 CrNiMo 17 12 3	316 S 13	SUS 316L	–	X 2 CrNiMo 17 12 2	Z 3 CND 17-13-30	X 2 CrNiMo 17-12-3	2348/2353/2354	–	–	1.4432	–
–	X 2 CrNiMoN 18 12 4	–	–	–	317 LN	CLC18.12.4.LN	X2CrNiMoN1812-4	–	–	–	1.4434	–
316 L	X 2 CrNiMo 18 14 3	316 S 11	SCS 16	S31603	X 2 CrNiMo 18 16	Z 2 CND 17.13	X 2 CrNiMo 17 13	2353	–	–	1.4435	–
316	X 5 CrNiMo 17 1 3 3	316 S 16	SUS 316	S31600	X6 CrNiMo 18 13 3 KD	Z 6 CND 17.12	X 5 CrNiMo 17 13	2343	–	–	1.4436	–
317 L	X 2 CrNiMo 18 16 4	317 S 12	SUS 317 L	S31703	X 3 CrNiMo 18 16 4	Z 2 CND 19.15	X 2 CrNiMo 18 15	2367	–	–	1.4438	ATI 317L™
–	X 2 CrNiMoN 17 13 5	–	–	–	X 3 CrNiMo 17 13 5	Z 3 CND 18.14-05 AZ	–	–	–	–	1.4439	–
–	X 2 CrNiMo 18 15 4	–	–	S31675	–	X 3 CrNiMoN 19-14	–	–	–	–	1.4442	–
317	X 5 CrNiMo 17 13	317 S 16	SUS 317	S31700	–	–	X 5 CrNiMo 18 15	–	–	–	1.4449	AL 317L+E55
–	X 5 CrNiCuNb 16 4	–	–	–	–	Z7CNU16.04	–	–	–	–	1.4452	–
–	–	–	–	S21904	–	–	–	–	–	A666	1.4454	ATI 219
–	X 2 CrNiMnMoN 20 16	–	–	–	X 2 CrNiMnMoN 20 15 08 KE	–	–	–	–	–	1.4455	–
–	X 1 CrNiMoN 25 2 5 2	–	–	S31050	–	–	–	–	–	–	1.4465	2RE69

(continued)

M2 Workpiece Materials Listing • Stainless Steel • M2 *(continued)*

M2 High-Strength Austenitic Stainless and Cast Stainless Steels *Tensile Strength RM (MPa)*: 600–800*
Hardness (HB): 150–230 (HRC): <25

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
–	X 1 CrNiMoN 25 22 2	–	–	–	725 LN	DMV 25.22.2	X 1 CrNiMoN 25-22-2	–	–	–	1.4466	–
–	X 1 NiCrMoCuN 25 20 6	–	–	–	–	–	–	–	–	–	1.4529	Uranus B26 6Mo
–	GX 2 NiCrMoCuN 25 20	–	–	J94650	GX 2 CrNiMoCuN 25-20-6	–	–	–	–	–	1.4536	–
–	X 1 CrNiMoCuN 25 25 5	–	–	–	X 1 CrNiMoCuN 25-25-5	X 1 CrNiMoCuN 25-25-5	X 1 CrNiMoCuN 25-25-5	–	–	–	1.4537	–
321	X 6 CrNiTi 18 10	321 S 12	SUS 321	S32100	X 6 CrNiTi 18 10	Z 6 CNT 18.10	X 6 CrNiTi 18 11	2337	–	–	1.4541	ATI 321™
321	A 700	304 S 31	–	J92630	–	Z 10 CNT 18 11	X 6 CrNiTi 18 11	–	–	–	1.4544	–
–	X 1 CrNiMoCuN 20 18 7	X 1 CrNiMoCuN 20 18 7	–	S31254	X 1 CrNiMoCuN 20-18-7	X 1 CrNiMoCuN 20-18-7	X 1 CrNiMoCuN 20-18-7	–	–	–	1.4547	Uranus B25 6Mo
–	X 2 NiCrAlTi 32 20	–	NCF 800 TB	–	–	–	–	–	–	–	1.4558	–
–	X 1 NiCrMoCuN 31 27 4	–	–	–	X 1 NiCrMoCu 31 27 4	X 1 NiCrMoCuN 31 -27-4	X 1 NiCrMoCuN 31 -27-4	2584	–	–	1.4563	–
–	X 3 CrNiCu 18 9 4	394 S 17	SUS XM7	–	X3CrNiCu18-9-4	304CU	304K	–	–	–	1.4567	–
316 Ti	X 6 CrNiMoTi 17 12 2	320 S 31	SUS 316Ti	–	X 6 CrNiMoTi 17 12 2	Z 6 CNDT 17.12	X 6 CrNiMoTi 17 12	2350	–	–	1.4571	ATI 316Ti™
–	GX 5 CrNiMoNb 23 9	–	–	–	–	–	–	–	–	–	1.4572	–
316 Ti	X 10 CrNiMoTi 18 12	320 S 33	SUS 316Ti	S31635	–	–	X 6 CrNiMoTi 17 13	–	–	–	1.4573	–
318	X 10 CrNiMoNb 18 12	–	–	–	–	–	X 6 CrNiMoNb 17 13	–	–	–	1.4583	–
–	X 2 CrNiCu 19 10	–	–	–	X 2 CrNiCu 19-10	TX 304L	–	–	–	–	1.4650	–
–	X1CrNiMoCuN24-22-8	–	–	S32654	–	–	–	–	–	–	1.4652	654 SMO®
–	153 MA	–	–	S30415	X 6 CrNiSiNCe 19 10	–	–	–	–	–	1.4818	153 MA™
–	X 20 CrNiSi 25 4	–	–	S44635	X 15 CrNiSi 25 4	Z 20 CNS 25.04	X 20 CrNiSi 25 4	–	–	–	1.4821	–
309	X 15 CrNiSi 20 12	309 S 24	SUH 309	S30900	X 15 CrNiSi 20 12	Z 15 CNS 20.12	X 16 CrNiSi 25,20	–	–	–	1.4828	ATI 309™
309 S	X 7 CrNi 23 14	309 S 24	SUS 309 S	J93400	X 12 CrNi 23 13	Z 15 CN 24.13	X 6 CrNi 23 14	–	–	–	1.4833	–
–	353 MA	–	–	S35315	X 6 NiCrSiNCe 35-25	–	–	–	–	–	1.4854	353 MA®
–	X 8 NiCrSi 38 18	NA 17	–	N08330	–	Z 12 NCS 37.18	–	–	–	–	1.4862	–
–	X 33 CrNiMnN 23 8	–	–	–	X 33 CrNiMnN 23-8	X 33 CrNiMnN 23-8	–	–	–	–	1.4866	–
EV 12	X 55 CrMnNiN 20 8	–	–	S63012	X 55 CrMnNiN 20-8	Z 55 CMN 20.08 Az	–	–	–	–	1.4875	–
321	X 12 CrNiTi 18 9	321 S 20	SUS 321	S32100	X 10 CrNiTi 18 10	Z 6 CNT 18.12	X 6 CrNiTi 18.11	2337	–	–	1.4878	ACX315
EV 11	X 70 CrMnNiN 21 6	–	–	S63011	–	–	X 70 CrMnNiN 21 6	–	–	–	1.4881	–
–	X 50 CrMnNiNbN 21 9	–	–	–	X 50 CrMnNiNbN 21-9	Z 50 CMNNb 21.09	–	–	–	–	1.4882	–
–	X 7 CrNiNb 18 10	–	SUS347H	S34709	X7CrNiNb18-10	X7CrNiNb18-10	–	–	–	–	1.4912	–
316 H	X 6 CrNiMo 17 13	316 S 51	–	S31609	X 6 CrNiMo 17 12 2	Z 6 CND 17-13 B	–	–	–	–	1.4919	–
321 H	X 8 CrNiTi 18 10	–	–	–	X 6 CrNiTiB 18-10	Z 6 CNT 18-10 B	X 6 CrNiTiB 11	–	–	–	1.4941	–
A660	X 4 NiCrTi 25 15	HR251	SUH 660	S66286	–	Z 6 NCTDV 25.15 B	–	–	–	–	1.4943	Discaloy
–	X 6 CrNiWNb 16 16	–	–	–	–	–	–	–	–	–	1.4945	–
–	X 6 CrNi 18 11	304 S 51	–	S30480	X 6 CrNi 18 10	Z 6 CN 18-09	X 5 CrNi 18 10 KW	2333	–	–	1.4948	–
–	X 6 CrNi 25 20	–	–	–	310 H	–	–	–	–	–	1.4951	–
–	X 8 CrNiNb 16 13	347 S 51	–	–	–	–	–	–	–	–	1.4961	–
–	Esshete12 50	–	–	S21500	X 10 CrNiMoMnNbVB 15-10-1	X 10 CrNiMoMnNbVB 15-10-1	–	–	–	A213	1.4982	Esshete 1250
–	X 8 CrNiMoBNb 16 16	–	–	–	X 7 CrNiMoBNb 16-16	–	–	–	–	–	1.4986	–
301	X 12 CrNi 17 7	301 S 21	SUS 301	S30100	X 12 CrNi 17 7	Z 12 CN 17.07	X 12 CrNi 17 07	2331	–	–	1.4310	ATI 301™
–	GX 40 CrNi 27 4	–	–	J92615	–	–	GX 35 CrNi 28 05	–	–	–	1.4340	–
304	X 5 CrNi 18 9	304 S 31	SUS 304	S30400	1	Z6CN18.09	X5CrNi1810	2332/2333	–	A276	1.4350	ATI 304™
–	X 15 CrNiMn 18 8	307 S 98	–	–	X 15 CrNiMn 18 08 KE	Z 8 CNM 19-09-07	–	–	–	–	1.4370	–
S32750	GX 10 CrNiMo 18 9	–	SCS 14 A	S32750	X 2 CrNiMoN 25-7-4	Z 5 CND 20.10 M	X 2 CrNiMoN 25-7-4	–	–	–	1.4410	–
–	X 5 CrNiMo 18 11	315 S 16	–	–	–	–	–	2340	–	–	1.4420	–
347	X 6 CrNiNb 18 10	347 S 17	SUS 347	S34700	X 6 CrNiNb 18 10	Z 6 CNNb 18.10	X 6 CrNiNb 18 11	2338	–	–	1.4550	ATI 347™
316 Cb	X 6 CrNiMoNb 17 12 2	318 S 17	–	–	X 6 CrNiMoNb 17 12 2	Z 6 CNDNb 17.12	X 6 CrNiMoNb 17 12	–	–	–	1.4580	–
–	X 3 CrNiMoN 17 13	–	–	–	X 3 CrNiMoN 17-13-3	–	X 2 CrNiMoN 17 12	–	–	–	1.4910	–
–	X 6 CrNi 23 13	–	–	–	309 H	–	–	–	–	–	1.4950	–
A286	X 6 NiCrTiMoVB 25-15-2	286 S 31	–	S66286	X 6 NiCrTiMoVB 21-15-2	–	–	–	–	–	1.4980	Incoloy A 286
XM-19	–	–	–	S20910	–	–	–	–	–	F1314	–	ATI XM-19™
303 plus X	–	–	–	S30310	–	–	–	–	–	XM-5	–	303 plus X
–	X 2 CrNi 18 13 3	–	–	–	–	–	–	–	–	–	–	Staybrite® 4435NCu
218	–	–	–	S21800	–	–	–	–	–	–	–	Nitronic 60
201LN	–	–	–	S20153	–	–	–	–	–	–	–	ATI 201LN™-MIL
–	X 2 CrNiMoN 17 13 3	–	–	–	–	Z 2 CND 17.13	X 2 CrNiMoN 17 13 3	–	–	–	–	AL 316LXN
–	–	–	–	S31675	–	–	–	–	–	F1586	–	ATI REX 734™
–	–	–	–	–	–	–	–	–	–	–	–	P558
–	X 1 NiCrMoCu 22 24 6	–	–	–	–	–	–	–	–	–	–	Uranus B66
–	–	–	–	–	–	–	–	–	–	–	–	ATI Datalloy 2®
–	–	–	–	–	–	–	–	–	–	–	–	ATI Staballoy® AG17®
–	–	–	–	–	–	–	–	–	–	–	–	P530
–	X 1 NiCrMoCu 31 27 4	–	–	N08028	–	–	–	–	–	–	–	Uranus B28
–	–	–	–	–	–	–	–	–	–	–	–	P750
–	–	–	–	–	–	–	–	–	–	–	–	P750-I
–	X 4 CrNiMoN 21 9 4	–	–	–	–	–	–	–	–	F1586	–	M30NW
–	–	–	–	–	–	–	–	–	–	–	–	P550
–	–	–	–	–	–	–	–	–	–	–	–	P580
–	–	–	–	–	–	–	–	–	–	–	–	P650
–	–	–	–	–	–	–	–	–	–	–	–	ATI Datalloy HP™

NOTE: For legend, see page Y217.

M3 ■ Workpiece Materials Listing • Stainless Steel • M3

M3 Duplex Stainless Steel *Tensile Strength RM (MPa)*: <800* *Hardness (HB): 135–275 (HRC): <30*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
–	GX 120 CrMo 29 2	–	–	–	–	–	–	–	–	F30M	1.4138	PK324
–	X 2 CrMnNiN 21 5 1	–	–	S32101	–	–	–	–	–	–	1.4162	LDX2101
–	GX 6 CrNiN 26 7	–	–	–	GX 6 CrNiN 26-7	–	–	–	–	–	1.4347	–
S32304	X 2 CrNiN 23 4	–	–	S32304	SAF 2304	35 N	X 2 CrNiN 23-4	2327	–	A240	1.4362	ATI 2304™
S31500	X 2 CrNiMoSi 19 5	–	–	S39215	GX 2 CrNiMoN 25-7-3	GX 2 CrNiMoN 25-7-3	–	2376	–	–	1.4417	–
S31803	X 2 CrNiMoN 22 5 3	318 S 13	SUS 329J 3L	S31803, S32205	X 2 CrNiMoN 22 5 3	Z 3 CND 22.05 AZ	X 2 CrNiMoN 22-5-3	2377	F51	2205	1.4462	ATI 2205™
–	GX 6 CrNiMo 24 8 2	–	–	–	–	–	–	–	–	–	1.4463	–
–	GX 2 CrNiMoN 25 6 3	–	–	–	GX 2 CrNiMoN 25-6-3	GX 2 CrNiMoN 25-6-3	–	–	–	–	1.4468	–
–	GX 2 CrNiMoN 26 7 4	–	–	J93404	GX 2 CrNiMoN 26-7-4	GX 2 CrNiMoN 26-7-4	GX 2 CrNiMoN 26-7-4	–	–	–	1.4469	–
–	X 2 CrNiMoCuWN 25 7 4	–	–	S32760	X 2 CrNiMoCuWN 25 7 4	X 2 CrNiMoCuWN 25-7-4	X 2 CrNiMoCuWN 25-7-4	–	–	F 55	1.4501	F55
2507	X 2 CrNiMoCuN 25 6 3	–	–	–	X 2 CrNiMoCuN 25-6-3	DMV25.7Cu	329SK	–	–	–	1.4507	Uranus 52N+
–	GX 2 CrNiMoCuWN 25 8 4	–	–	–	X 6 CrNiCu 18 10 4 KD	Z 4 CNUD 17-11-03 FF	–	–	–	–	1.4508	–
–	GX 2 CrNiMoCuN 25 6 3 3	–	–	–	GX 2 CrNiMoCuN 25-6-3-3	GX 2 CrNiMoCuN 25-6-3-3	GX 2 CrNiMoCuN 25-6-3-3	–	–	–	1.4517	–
–	X 4 CrNiMoNb 25 7	–	SCS 22	–	–	–	–	–	–	–	1.4582	PK343
–	BGH 4593	–	–	–	GX 3 CrNiMoCuN 24 6 2 3	–	–	–	–	–	1.4593	Noridur®
329	X 4 CrNiMo 27 5 2	–	SUS 329 J1	S32900	X 3 CrNiMo 27 5 2	X 2 CrNiMo 25-7-3	X 3 CrNiMo 27-5-2	2324	–	A240	1.4460	10RE51
–	GX 2 CrNiMoN 22 5 3	–	–	–	GX 2 CrNiMoN 22-5-3	GX 2 CrNiMoN 22-5-3	GX 2 CrNiMoN 22-5-3	–	–	–	1.4470	–
S32550	–	–	–	S32550	–	–	–	–	–	–	–	Ferralium® alloy 255
–	–	–	–	S32003	–	–	–	–	–	–	–	ATI 2003®
–	–	–	–	S80211	–	–	–	–	–	–	–	ATI 2102™
–	–	–	–	S32550	–	–	–	–	–	–	–	ATI 255™
–	–	–	–	S34565	–	–	–	–	–	–	–	ATI 4565™
–	X 2 CrNiMoN 25 6 3	–	–	–	–	–	–	–	–	–	–	Uranus 47N+
–	–	–	–	–	–	–	F60	–	–	32760	–	Zeron® 100

Cast Iron

K1 ■ Workpiece Materials Listing • Cast Iron • K1

K1 Grey Cast Iron *Tensile Strength RM (MPa)*: 125–500* *Hardness (HB): 120–290 (HRC): <32*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
–	GG-150HB	–	–	–	GJL-HB 170	–	–	–	–	–	0.6012	–
A48-25 B	GG-15	Grade 150	FC 150	–	GJL-150	FGL 150	G 15	0115-00	–	A 48 Class 25	0.6015	–
–	GG-170HB	–	–	N06985	GJL-HB 205	–	–	–	–	–	0.6017	–
–	GG-190HB	–	–	N06022	GJL-HB 230	–	–	–	–	–	0.6022	–
A48-35 B	GG-25	Grade 260	FC 250	–	GJL-250	FGL 250	G 25	0125-00	–	A 48 Class 35	0.6025	–
–	GG-26	–	FC260	–	–	–	G 26	0126-00	–	–	0.6026	–
–	GG-220HB	–	–	W06027	GJL-HB 250	FGL 250	–	–	–	–	0.6027	–
–	GG-240HB	–	–	–	GJL-HB 275	–	–	–	–	–	0.6032	–
A48-50 B	GG-35	Grade 350	FC 350	–	GJL-350	FGL 350	G 35	0135-00	–	A 48 Class 50	0.6035	–
–	GG-260HB	–	–	–	GJL-HB 275	–	–	–	–	–	0.6037	–
A48-20 B	GG-10	Grade 100	FC 100	–	GJL-100	FGL 100	G 10	0110-00	–	A 48 Class 20	0.6010	–
A48-30 B	GG-20	Grade 220	FC 200	W06020	GJL-200	FGL 200	G 20	0120-00	–	A 48 Class 30	0.6020	–
A48-45 B	GG-30	Grade 300	FC 300	–	GJL-300	FGL 300	G 30	0130-00	–	A 48 Class 45	0.6030	–
A48-55 B	GG-40	Grade 400	–	–	GJL-400	FGL 400	–	0140-00	–	A 48 Class 55	0.6040	–
A48-40	–	–	–	–	–	–	–	–	–	A 48 Class 40	–	–
A48-60	–	–	–	–	–	–	–	–	–	A 48 Class 60	–	–
–	–	–	–	–	–	–	–	–	G1800	A 159 G1800	–	–
–	–	–	–	–	–	–	–	–	G3000	A 159 G3000	–	–
–	–	–	–	–	–	–	–	–	G10H18	A 159 G3000	–	–
–	–	–	–	–	–	–	–	–	G11H18	A 159 G3000	–	–
–	–	–	–	–	–	–	–	–	G3500	A 159 G3500	–	–
–	–	–	–	–	–	–	–	–	G11H20	A 159 G3500	–	–
–	–	–	–	–	–	–	–	–	G4000	A 159 G4000	–	–
–	–	–	–	–	–	–	–	–	G13H19	A 159 G4000	–	–
–	–	–	–	–	–	–	–	–	G12H21	A 159 G4000	–	–
–	–	–	–	–	–	–	–	–	G9H12	A 159 G1800	–	–
–	GG-26-Cr	–	–	–	–	–	–	–	–	–	–	–
–	GG-25-Cr	–	–	–	–	–	–	–	–	–	–	–

K2 Workpiece Materials Listing • Cast Iron • K2

K2 Low- and Medium-Strength Ductile Irons (Nodular Irons) and Compacted Graphite Irons (CGI) *Tensile Strength RM (MPa)*: <600*
Hardness (HB): 130–260 (HRC): <28

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
–	GGL-NiMn137	L-NiMn 13 7	FCA NiMn 13 7	F43000	GJLA-XNiMn 13-7	L-NM 13 7	–	–	–	–	0.6652	–
A 436 Type 1	GGL- NiCuCr1562	L-NiCuCr 15 6 2	FCA-NiCuCr 15 6 2	F41000	GJLA-XNiCuCr 15-6-2	L-NUC 15 6 2	–	–	–	–	0.6655	–
A 436 Type 1b	GGL-NiCuCr1563	L-NiCuCr 15 6 3	FCA-NiCuCr 15 6 3	F41001	GJLA-XNiCuCr 15-6-3	L-NUC 15 6 3	–	–	–	–	0.6656	–
A 436 Type 2b	GGL-NiCr203	L-NiCr 20 3	FCA-NiCr 20 3	F41003	GJLA-XNiCr 20-3	L-NC 20 3	–	–	–	–	0.6661	–
–	GGL-NiSiCr2053	L-NiSiCr 20 5 3	FCA-NiSiCr 20 5 3	–	GJLA-XNiSiCr 20-5-3	L-NSC 20 5 3	–	–	–	–	0.6667	–
A 436 Type 3	GGL- NiCr303	L-NiCr 30 3	FCA-NiCr 30 3	F41004	GJLA-XNiCr 30-3	L-NC 30 3	–	–	–	–	0.6676	–
–	GGG-35.3	–	–	–	GJS-350-22	–	–	0717-15	–	–	0.7033	–
–	GGG-40.3	SNG 370/17	FCD 370	–	GJS-400-18	FGS 370-17	GSO 42/15	0717-15	–	–	0.7043	–
–	GGG-45	–	FCD 450	–	–	–	–	–	–	–	0.7045	–
–	–	–	–	–	–	FGS450.10	–	–	–	–	0.7049	–
–	GGG-65	–	–	–	–	–	–	–	–	–	0.7065	–
–	GGG-NiMn137	S-NiMn 13 7	FCDA-NiMn 13 7	–	GJSA-XNiMn 13-7	S-Mn 13 7	–	0772-00	–	–	0.7652	–
–	GGG-NiCrNb202	S2W	FCDA-NiCrNb 20 2	–	GJSA-XNiCrNb 20-2	–	–	–	–	–	0.7659	–
A 439 Type D-2B	GGG-NiCr203	S-NiCr 20 3	FCDA-NiCr 20 3	F43001	GJSA-XNiCr 20-3	–	–	–	–	–	0.7661	–
–	GGG-NiSiCr2052	S-NiSiCr 20 5 2	FCDA-NiSiCr 20 5 2	–	GJSA-XNiSiCr 20-5-2	S-NSC 20 5 2	–	–	–	–	0.7665	–
A 571 Type D-2M	GGG-NiMn234	S-NiMn 23 4	FCDA-NiMn 23 4	–	GJSA-XNiMn 23-4	S-NM 23 4	–	–	–	–	0.7673	–
A 439 Type D-3	GGG-NiCr303	S-NiCr 30 3	FCDA-NiCr 30 3	F43003	GJSA-XNiCr 30-3	S-NC 30 3	–	–	–	–	0.7676	–
A 439 Type D-3A	GGG-NiCr301	S-NiCr 30 1	FCDA-NiCr 30 1	F43004	GJSA-XNiCr 30-1	S-NC 30 1	–	–	–	–	0.7677	–
–	GGG-NiSiCr3055	–	FCDA-NiSiCr 30 5 5	–	GJSA-XNiSiCr 30-5-5	–	–	–	–	–	0.7679	–
A 439 Type D-5	GGG-Ni35	S-Ni 35	FCDA-Ni 35	F43006	GJSA-XNi 35	S-N 35	–	–	–	–	0.7683	–
A 439 Type D-5A	GGG-NiCr353	S-NiCr 35 3	FCDA-NiCr 35 3	F43007	GJSA-XNiCr 35-3	S-NC 35 3	–	–	–	–	0.7685	–
–	GGG-NiSiCr3552	–	FCDA-NiSiCr 35 5 2	–	GJSA-XNiSiCr 35-5-2	FGS Ni35 Si 5 Cr2	–	–	–	–	0.7688	–
–	GTW-35-04	W 35-04	FCMW 330 class 1	–	GJMW-35-0-4	MB 35-7	W 35-04	–	–	–	0.8035	–
–	GTW-S-38-1 2	W 38-12	–	–	GJMW-360-12	MB 300-12	–	–	–	–	0.8038	–
–	GTW-45-07	W 45-07	FCMWP 440 class 3	–	GJMW-450-7	MB 450-7	GMB 45	–	–	–	0.8045	–
–	GTW-55	–	–	–	–	–	GMB 55	–	–	–	0.8055	–
–	GTW-65	–	–	–	–	–	GMB 65	–	–	–	0.8065	–
32510	GTS-35-10	B 340/12	FCMP 330	–	GJMB-350-10	MN 350-10	–	815	–	–	0.8135	–
40010	GTS-45-06	P 440/7	FCMP 440	–	GJMB-450-6	MN 450 - 6	P 45-06	852	–	–	0.8145	–
50005	GTS-55-04	P 510/4	FCMP 490	–	GJMB-550-4	MN 550-4	P 55-04	854	–	–	0.8155	–
70003	GTS-65-02	P 570/3	FCMP 540	–	GJMB-650-2	MN 650-3	P 65-02	0858-00, 0856-00	–	–	0.8165	–
90001	GTS-70-02	P 690/2	FCMP 690	–	GJMB-700-2	MN 700-2	P 70-02	0862-03; 0864-03	–	–	0.8170	–
–	GGV-30	–	–	–	GJV-300	–	–	–	–	–	0.9991	–
A 436 Type 2	GGL-NiCr202	L-NiCr 20 2	FCA-NiCr 20 2	F41002	GJLA-XNiCr 20-2	L-NC 20 2	–	0523-00	–	–	0.6660	–
A 436 Type 4	GGL- NiSiCr3055	L-NiSiCr 30 5 5	FCA-NiSiCr 30 5 5	F41005	GJLA-XNiSiCr 30-5-5	L-NSC 30 5 5	–	–	–	–	0.6680	–
60-40-18	GGG-40	SNG 420/12	FCD 400 class 1	F32800	GJS-400-15	FGS400-12	GS400-12	0717-02	60-40-18	60-40-18	0.7040	–
65-45-12	GGG-50	SNG 500/7	FCD 500	F33100	GJS-500-7	FGS 500-7	GS 500/7	0727-02	65-45-12	65-45-12	0.7050	–
–	GGG-60	SNG 600/3	FCD 600-3	–	GJS-600-3	–	GS 600/3	–	80-55-06	80-55-06	0.7060	–
100-70-03	GGG-70	SNG 700/2	FCD 700	F34800	GJS-700-2	FGS 700-2	GS 700-2	0737-01	100-70-03	100-70-03	0.7070	–
120-90-02	GGG-80	SNG 800/2	FCD 800	F36200	GJS-800-2	FGS 800-2	GS 800-2	–	120-90-02	120-90-02	0.7080	–
A 439 Type D-2	GGG-NiCr202	L-NiCuCr 20 2	FCDA-NiCr 20 2	–	GJSA-XNiCr 20-2	L-NC 20 2	–	0523-00	–	–	0.7660	–
A 439 Type D-2C	GGG-Ni22	S-Ni 22	FCDA-Ni 22	F43002	GJSA-XNi 22	S-N 22	–	–	–	–	0.7670	–
A 439 Type D-4	GGG-NiSiCr3053	S-NiSiCr 30 5 5	FCDA-NiSiCr 30 5 4	F43005	GJSA-XNiSiCr 30-5-3	S-NSC 30 5 5	–	–	–	–	0.7680	–
–	GTW-40-05	W 40-05	FCMW 370	–	GJMW-400-5	MB 400-5	GMB 40	–	–	–	0.8040	–
–	GGV-40	–	–	–	GJV-400	–	–	–	–	–	0.9990	–
80-55-06	–	–	–	F33800	–	FGS 350-22	–	0732-03	D5506	–	–	–
–	–	–	–	–	–	–	–	–	D4018	–	–	–
–	–	–	–	–	–	–	–	–	D400	–	–	–
–	–	–	–	–	–	–	–	–	D4512	–	–	–
–	–	–	–	–	–	–	–	–	D450	–	–	–
–	–	–	–	–	–	–	–	–	M3210	–	–	–
–	–	–	–	–	–	–	–	–	M4504	–	–	–
–	–	–	–	–	–	–	–	–	M5003	–	–	–
–	–	–	–	–	–	–	–	–	M5503	–	–	–
–	–	–	–	–	–	–	–	–	M7002	–	–	–
–	–	–	–	–	–	–	–	–	D7003	–	–	–
–	–	–	–	–	–	–	–	–	M8501	A 602 M8501	–	–
–	GGV-45	–	–	–	GJV-450	–	–	–	–	–	–	–
–	GGG-SiMo3.08	–	–	–	–	–	–	–	–	–	–	–
–	GGG-SiMo4.10	–	–	–	–	–	–	–	–	–	–	–
–	GGG-SiMo5.10	–	–	–	–	–	–	–	–	–	–	–
–	–	–	–	–	–	–	–	–	–	–	–	HPI C13 06
–	GGV-35	–	–	–	GJV-350	–	–	–	–	–	–	–
–	GGV-50	–	–	–	GJV-500	–	–	–	–	–	–	–

K3 Workpiece Materials Listing • Cast Iron • K3

K3 High-Strength Ductile Irons and Austempered Ductile Iron (ADI) *Tensile Strength RM (MPa)*: >600* *Hardness (HB): 180–350 (HRC): <43*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
–	–	–	–	–	–	–	–	–	–	A 897 125-80-10	–	–
–	–	–	–	–	–	–	–	–	–	A 897 150-100-7	–	–
–	–	–	–	–	–	–	–	–	–	A 897 175-125-4	–	–
–	–	–	–	–	–	–	–	–	–	A 897 200-150-1	–	–
–	–	–	–	–	–	–	–	–	–	A 897 230-185	–	–

NOTE: For legend, see page Y217.

N1 Workpiece Materials Listing • Non-Ferrous Metals • N1

N1 Wrought Aluminium

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
1080	Al99.8	–	1A	–	–	–	–	–	–	–	3.0128	–
1050	Al99.5	L 31	1B	–	–	A 59050 C	–	–	–	–	3.0255	–
–	SG-Al 99,5	–	–	–	–	–	–	–	–	–	3.0259	–
1070	Al99.7	–	–	–	–	–	4508	–	–	–	3.0275	–
3103	AlMn	–	N3	–	–	–	–	–	–	–	3.0515	–
3003	AlMnCu	–	–	–	–	–	–	–	–	–	3.0517	–
3005	AlMn1Mg0.5	–	–	–	–	–	–	–	–	–	3.0525	–
3004	AlMn1Mg1	–	–	–	–	–	–	–	–	–	3.0526	–
–	AlMgSiPb	–	–	–	–	–	–	–	–	–	3.0615	–
–	SG-Al 99,5Ti	–	–	–	–	–	–	–	–	–	3.0805	–
–	SG-Al 99,5 Ti	–	–	–	–	–	–	–	–	–	3.0805	–
2014	AlCuSiMn	–	H15	–	–	A-U4SG	3581	–	–	–	3.1255	–
2017	AlCuMg 1	–	–	–	AW-2017 A	A-U4G	3579	–	–	–	3.1325	–
2024	AlCuMg 2	–	L97	–	AW-2024	A-U4G1	–	–	–	–	3.1355	–
–	AlCuMgPb	–	–	–	–	–	–	–	–	–	3.1645	–
2011	AlCuBiPb	–	FC1	–	–	A-U5PbBi	6362	–	–	–	3.1655	–
6082	AlMgSi 1	–	H30	–	AW-6005 A	A-SGM0.7	3571	–	–	–	3.2315	–
6060	AlMgSi0.5	–	–	–	–	–	–	–	–	–	3.3206	–
6063	AlMgSi0.7	–	H9	–	–	A-GS	3569	–	–	–	3.3206	–
6463	EAlMgSi0.5	–	91E	–	–	–	–	–	–	–	3.3207	–
5005	AlMg 1	–	N41	–	AW-6082	A-G0.6	5764-66	–	–	–	3.3315	–
5050	–	–	–	–	–	–	–	–	–	–	3.3316	–
5052	AlMg2.5	–	2L56	–	–	A-G2.5C	4574	–	–	–	3.3523	–
5754	AlMg 3	–	N5	–	–	A-G3M	3575	–	–	–	3.3535	–
5454	AlMg2.5Mn	–	N51	–	–	A-G2.5MC	7789	–	–	–	3.3537	–
5086	AlMg4Mn	–	–	–	–	–	–	–	–	–	3.3545	–
–	SG-Al Mg 4,5 Mn Zr	–	–	–	–	–	–	–	–	–	3.3546	–
5083	AlMg4,5Mn	–	N8	–	–	A-G4.5MC	7790	–	–	–	3.3547	–
5056	AlMg5	–	N6	–	–	A-G5	3576	–	–	–	3.3549	–
–	AlMg 5	–	–	–	–	–	–	–	–	–	3.3555	–
7050	AlZnMgCu0,5	L 86	–	–	–	AZ 4 GU/9051	811-04	–	–	–	3.4144	–
7020	AlZn4.5Mg1	–	H17	–	–	A-Z5G	–	–	–	–	3.4335	–
7022	AlZnMgCu0.5	–	–	–	–	–	–	–	–	–	3.4345	–
–	AlZn5,5MgCu	–	–	–	–	–	–	–	–	–	3.4365	–
7075	AlZnMgCu 1.5	–	DTD5074	A97075	AL-P7075	A-Z5GU	3735	–	7075	–	3.4365	–
1000	Al99.5H	L31	–	–	–	A59050C	–	–	–	–	3.0250	–
–	Al99.8	–	–	–	–	–	–	–	–	–	3.0280	–
–	AlMg3Mn	–	–	–	–	–	–	–	–	–	–	–
2025	–	–	A 2025 FD	A92025	–	–	–	–	2025	B 247 2025	–	–
1100	–	–	–	–	–	–	–	–	–	–	–	–
3105	–	–	–	–	–	–	–	–	–	–	–	–
5657	AlMg0.8Si	–	–	–	–	–	–	–	–	–	–	–
6070	–	–	–	–	–	–	–	–	–	–	–	–
6262	–	–	–	–	–	–	–	–	–	–	–	–
7003	–	–	–	–	–	–	–	–	–	–	–	–
2050	–	–	–	–	–	–	–	–	–	–	–	–
7475	–	–	–	–	–	–	–	–	–	–	–	–
7175	–	–	–	–	–	–	–	–	–	–	–	–
7178	–	–	–	–	–	–	–	–	–	–	–	–
5251	AlMg2Mo3	–	N4	–	–	A-G2M	3574	–	–	–	–	–
6151	–	–	–	–	–	–	–	–	–	–	–	–
7001	–	–	–	–	–	–	–	–	–	–	–	–
7040	–	–	–	–	–	–	–	–	–	–	–	–

N2 Workpiece Materials Listing • Non-Ferrous Metals • N2

N2 Low-Silicon Aluminium Alloys and Magnesium Alloys *Content: Si <12,2%*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
–	SG-Al99,8	–	–	–	–	–	–	–	–	–	3.0286	–
–	G-AlCu 4 TiMg	–	–	–	–	–	–	–	–	–	3.1371	–
–	G-AlCu 4 TiMg	–	–	–	–	–	–	–	–	–	3.1371	–
–	G-AlCu 5 Ni 1,5	–	–	–	–	–	–	–	–	–	3.1754	–
–	G-AlCu 4 Ti	–	–	–	–	–	–	–	–	–	3.1841	–
–	G-AlSi 5 Cu 1	–	–	–	–	–	–	–	–	–	3.2131	–
–	G-AlSi 6 Cu 4	–	–	–	–	–	–	–	–	–	3.2151	–
–	G-AlSi 8 Cu 3	–	–	–	–	–	–	–	–	–	3.2161	–
–	G-AlSi 9 Cu 3	–	–	–	–	–	–	–	–	–	3.2163	–
–	G-AlSi 1 1	–	–	–	–	–	–	–	–	–	3.2211	–
–	SG-AlSi 5	–	–	–	–	–	–	–	–	–	3.2245	–
–	SG-AlSi 5	–	–	–	–	–	–	–	–	–	3.2245	–
–	G-AlSi 5 Mg	–	–	–	–	–	–	–	–	–	3.2341	–
4218 B	G-AlSi 7 Mg	–	–	–	–	–	–	–	–	–	3.2371	–
–	G-AlSi 9 Mg	–	–	–	–	–	–	–	–	–	3.2373	–
–	G-AlSi 10 Mg	–	–	–	–	–	–	–	–	–	3.2381	–
–	G-D AlSi 10 Mg	–	–	–	–	–	–	–	–	–	3.2382	–
A 360.2	G-AlSi 10 Mg(Cu)	LM 9	–	–	–	–	–	4253	–	–	3.2383	–
A 413.0	G-D AlSi 12	–	–	–	–	–	–	4247	–	–	3.2582	–
–	SG-AlSi 12	–	–	–	–	–	–	–	–	–	3.2585	–
–	G-D AlSi 12(Cu)	–	–	–	–	–	–	–	–	–	3.2982	–
6061	AlMgSiCu	–	H20	–	–	A-GSUC	6170	–	–	–	3.3211	–
–	G-AlMg 3 Si	–	–	–	–	–	–	–	–	–	3.3241	–
–	G-AlMg 5 Si	–	–	–	–	–	–	–	–	–	3.3261	–
–	G-D AlMg 9	–	–	–	–	–	–	–	–	–	3.3292	–
–	G-AlMg5Si(Cu,Mn)	–	–	–	–	–	–	–	–	–	3.3458	–
–	SG-AlMg 3	–	–	–	–	–	–	–	–	–	3.3536	–

(continued)

N2 Workpiece Materials Listing • Non-Ferrous Metals • N2 *(continued)*

N2 Low-Silicon Aluminium Alloys and Magnesium Alloys *Content: Si <12,2%*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
–	G-AlMg 3	–	–	–	–	–	–	–	–	–	3.3541	–
–	SG-AlMg 4,5 Mn	–	–	–	–	–	–	–	–	–	3.3548	–
–	SG-AlMg 5	–	–	–	–	–	–	–	–	–	3.3556	–
–	G-AlMg 5	–	–	–	–	–	–	–	–	–	3.3561	–
ZE 41	G-MgZn 4 SE 1 Zr 1	MAG 5	–	–	MCMgZn 4 RE 1 Zr	G-Z 4 TR	–	–	–	–	3.5101	–
–	G-MgZn 5 Th 2 Zr 1	–	–	–	–	–	–	–	–	–	3.5102	–
EZ 33	MgSE 3 Zn 2 Zr 1	MAG 6	–	–	MCMgRE 3 Zn 2 Zr	G-TR 3 Z 2	–	–	–	–	3.5103	–
–	MgAl 9 Zn 1	–	–	–	–	–	–	–	–	–	3.5104	–
–	G-MgTh 3 Zn 2 Zr 1	–	–	–	–	–	–	–	–	–	3.5105	–
QE 22	G-MgAg 3 SE 2 Zr 1	MAG 12	–	–	MCMgRE 2 Ag 2 Zr	G-Ag 22,5	–	–	–	–	3.5106	–
–	G-D MgAl 6 Zn 1	–	–	–	–	–	–	–	–	–	3.5612	–
–	G-D MgAl 6	–	–	–	–	–	–	–	–	–	3.5662	–
AZ 81	G-MgAl 8 Zn 1	MAG 1	–	–	MCMgAl 8 Zn 1	G-A 9	–	–	–	–	3.5812	–
AZ 91	G-MgAl 9 Zn 1	MAG 7	–	–	MCMgAl 9 Zn 1	G-A 9 Z 1	–	–	–	–	3.5912	–
–	G-MgAl 8 Zn 1	–	–	–	–	–	–	–	–	–	3.5200	–
AS 41	G-D MgAl 4 Si 1	–	–	–	MCMgAl4Si	G-A4S 1	–	–	–	–	3.5470	–
–	G-AlZn10Si8Mg	–	–	–	–	–	–	–	–	–	–	–
AS 7 G	AlSi7Mg	–	–	–	–	–	–	–	–	–	–	–
2117	–	–	–	–	–	–	–	–	–	–	–	–
2218	AlCuMgNi2	–	–	–	–	–	–	–	–	–	–	–
2091	–	–	–	–	–	–	–	–	–	–	–	–
8090	–	–	–	–	–	–	–	–	–	–	–	–
2090	–	–	–	–	–	–	–	–	–	–	–	–
2224	–	–	–	–	–	–	–	–	–	–	–	–
2094	–	–	–	–	–	–	–	–	–	–	–	–
2095	–	–	–	–	–	–	–	–	–	–	–	–
2097	–	–	–	–	–	–	–	–	–	–	–	–
2098	–	–	–	–	–	–	–	–	–	–	–	–
2099	–	–	–	–	–	–	–	–	–	–	–	–
2195	–	–	–	–	–	–	–	–	–	–	–	–
2196	–	–	–	–	–	–	–	–	–	–	–	–
2197	–	–	–	–	–	–	–	–	–	–	–	–
2198	–	–	–	–	–	–	–	–	–	–	–	–
2297	–	–	–	–	–	–	–	–	–	–	–	–
2397	–	–	–	–	–	–	–	–	–	–	–	–
8017	–	–	–	–	–	–	–	–	–	–	–	–
8024	–	–	–	–	–	–	–	–	–	–	–	–
8091	–	–	–	–	–	–	–	–	–	–	–	–
8093	–	–	–	–	–	–	–	–	–	–	–	–
2199	–	–	–	–	–	–	–	–	–	–	–	–

N3 Workpiece Materials Listing • Non-Ferrous Metals • N3

N3 High-Silicon Aluminium Alloys and Magnesium Alloys *Content: Si >12,2%*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
A 413.1	G-AlSi 12(Cu)	LM 20	–	–	–	–	–	4260	–	–	3.2583	–
A 413.2	G-AlSi 12	LM 6	–	–	–	–	–	4261	–	–	3.2581	–
–	G-AlSi17Cu4Mg	–	–	–	–	–	–	–	–	–	–	–
–	GK-AlSi18CuNiMg	–	–	–	–	–	–	–	–	–	–	–
–	GK-AlSi21CuNiMg	–	–	–	–	–	–	–	–	–	–	–
–	GK-AlSi12CuNiMg	–	–	–	–	–	–	–	–	–	–	–
–	GK-AlSi25CuNiMg	–	–	–	–	–	–	–	–	–	–	–
–	G-AlSi 21 CuNiMg	–	–	–	–	–	–	–	–	–	–	–
4032	–	–	–	–	–	–	–	–	–	–	–	–

N4 Workpiece Materials Listing • Non-Ferrous Metals • N4

N4 Copper-, Brass-, Zinc-Based on Machinability Index Range of 70–100

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
C 11000	E-Cu 58	C 101	–	–	–	Cn-a2	–	–	–	–	2.0065	–
C 81100	G-CuL 45	HCC 1	–	–	–	–	–	–	–	–	2.0082	–
C 81100	G-Cu L 50	HCC 1	–	–	–	–	–	–	–	–	2.0085	–
–	CuZn 40 MnPb	–	–	–	–	–	–	–	–	–	2.0241	–
C 26000	CuZn 30	CZ 102	C 2600	–	–	CuZn 30	–	–	–	–	2.0265	–
C 27200	CuZn 37	CZ 108	–	–	–	CuZn 37	C 2720	–	–	–	2.0321	–
–	CuZn 36 Pb 1.5	–	–	–	–	–	–	–	–	–	2.0331	–
–	S-CuZn40	–	–	–	–	–	–	–	–	–	2.0366	–
–	CuZn 39 Pb 3 + D567	–	–	–	–	–	–	–	–	–	2.0401	–
–	CuZn 40 Pb 2	–	–	–	–	–	–	–	–	–	2.0402	–
B-198	G-CuZn 15Si 4	–	–	–	–	–	–	–	–	–	2.0492	–
–	CuZn 40Al 1	–	–	–	–	–	–	–	–	–	2.0561	–
–	G-KCuZn 38 Al	–	–	–	–	–	–	–	–	–	2.0591	–
C 86500	G-CuZn 35 Al 1	HTB 1	–	–	–	U-Z 36 N 3	–	–	–	–	2.0592	–
–	G-KCuZn 37 Al 1	–	–	–	–	–	–	–	–	–	2.0595	–
C 86200	G-CuZn 34 Al 2	HTB 1	–	–	–	U-Z 36 N 3	–	–	–	–	2.0596	–
–	G-CuZn 25 Al 5	–	–	–	–	–	–	–	–	–	2.0598	–
–	S - CuNi 30 Fe	–	–	–	–	–	–	–	–	–	2.0837	–
–	CuNi 10 Fe 1 Mn	–	–	–	–	–	–	–	–	–	2.0872	–

NOTE: For legend, see page Y217.

(continued)

N4 Workpiece Materials Listing • Non-Ferrous Metals • N4 *(continued)*

N4 Copper-, Brass-, Zinc-Based on Machinability Index Range of 70–100

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
–	S - CuNi 10 Fe	–	–	–	–	–	–	–	–	–	2.0873	–
–	CuNi 30 Mn 1 Fe	–	–	–	–	–	–	–	–	–	2.0882	–
–	SG-Cu Al 8	–	–	–	–	–	–	–	–	–	2.0921	–
–	SG-CuAl 8 Ni 2	–	–	–	–	–	–	–	–	–	2.0922	–
–	SG-CuAl 9 Ni5 Fe	–	–	–	–	–	–	–	–	–	2.0927	–
–	CuAl 10 Fe 3 Mn 2	CA 103	–	–	–	U-A 10 Fe	–	–	–	–	2.0936	–
–	SG-Cu Al 10 Fe	–	–	–	–	–	–	–	–	–	2.0937	–
C 63000	CuAl 10 Ni 5 Fe 4	Ca 104	–	–	–	U-A 10 N	–	–	–	–	2.0966	–
B-148-52	G-CuAl 10 Ni	–	–	–	–	–	–	–	–	–	2.0975	–
–	SG-Cu Sn	–	–	–	–	–	–	–	–	–	2.1006	–
–	SG-Cu Sn 6	–	–	–	–	–	–	–	–	–	2.1022	–
C 90800	G-CuSn 12	Pb 2	–	–	–	UE 12 P	–	–	–	–	2.1052	–
–	G-CuSn 12 Pb	–	–	–	–	–	–	–	–	–	2.1061	–
–	G-CuSn 10 Zn	–	–	–	–	–	–	–	–	–	2.1086	–
C 93200	G-CuSn 7 ZnPb	–	–	–	–	U-E 7 Z 5 Pb 4	–	–	–	–	2.1091	–
–	G-CuSn 6 ZnNi	LG 4	–	–	–	–	–	–	–	–	2.1093	–
C 83600	G-CuSn 5 ZnPb	LG 2	–	–	–	U-E 5 Pb 5 Z 5	–	–	–	–	2.1096	–
–	G-CuSn 2 ZnPb	–	–	–	–	–	–	–	–	–	2.1098	–
C 93700	G-CuPb 10 Sn	LB 2	–	–	–	U-E 10 Pb 10	–	–	–	–	2.1176	–
C 93800	G-CuPb 15 Sn	LB 1	–	–	–	U-Pb 15 E 8	–	–	–	–	2.1182	–
C 94100	G-CuPb 20 Sn	LB 5	–	–	–	U-Pb 20	–	–	–	–	2.1188	–
C 81500	G-CuCrF 35	CC1-FF	–	–	–	–	–	–	–	–	2.1292	–
C 18200	CuCrZr	CC 102	–	–	–	U-Cr 0,8 Zr	–	–	–	–	2.1293	–
–	SG-Cu Mn 13 Al 7	–	–	–	–	–	–	–	–	–	2.1367	–
–	SG-Cu Si 3	–	–	–	–	–	–	–	–	–	2.1461	–
CuSi 3 Mn	–	–	–	–	–	–	–	–	–	–	2.1525	–
–	OF-Cu	–	–	–	–	–	–	–	–	–	2.0040	–
B-120	E-Cu 57	–	–	–	–	–	–	–	–	–	2.0060	–
C 10300	SE-Cu	C 101	–	–	–	Cu-c1	–	–	–	–	2.0070	–
–	CuZn 5	–	–	–	–	–	–	–	–	–	2.0220	–
C 23000	CuZn 15	CZ 102	C 2300	–	–	CuZn 15	–	–	–	–	2.0240	–
–	G-CuZn 33 Pb	–	–	–	–	–	–	–	–	–	2.0290	–
–	CuZn 36 Pb 2	–	–	–	–	–	–	–	–	–	2.0330	–
–	G-CuZn 37 Pb	–	–	–	–	–	–	–	–	–	2.0340	–
–	CuZn 40	–	–	–	–	–	–	–	–	–	2.0360	–
–	CuZn 39 Pb 2	–	–	–	–	–	–	–	–	–	2.0380	–
–	CuZn 20 Al 2	–	–	–	–	–	–	–	–	–	2.0460	–
–	CuZn 37Al 1	–	–	–	–	–	–	–	–	–	2.0510	–
–	CuZn 40 Al 2	–	–	–	–	–	–	–	–	–	2.0550	–
–	G-CuZn 40 Fe	–	–	–	–	–	–	–	–	–	2.0590	–
–	G-CuAl 10 Fe	–	–	–	–	–	–	–	–	–	2.0940	–
C 90700	G-CuSn 10	CT 1	–	–	–	–	–	–	–	–	2.1050	–
C 91700	G-CuSn 12 Ni	–	–	–	–	–	–	–	–	–	2.1060	–
–	C35100	–	–	–	–	–	–	–	–	–	–	–
–	17665	–	–	C95500	–	–	–	–	–	–	–	–
–	MS60	–	–	–	–	–	–	–	–	–	–	–

N5 Workpiece Materials Listing • Non-Ferrous Metals • N5

N5 Nylon, Plastics, Rubbers, Phenolics, Resins, Fibreglass

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
–	LEXAN	–	–	–	–	–	–	–	–	–	–	–
–	HOSTALEN	–	–	–	–	–	–	–	–	–	–	–
–	Polystyrol	–	–	–	–	–	–	–	–	–	–	–
–	Makralon	–	–	–	–	–	–	–	–	–	–	–

N6 Workpiece Materials Listing • Non-Ferrous Metals • N6

N6 Carbon, Graphite Composites, CFRP

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
–	GFK	–	–	–	–	–	–	–	–	–	–	–
–	CFK	–	–	–	–	–	–	–	–	–	–	–
Graphite	–	–	–	–	–	–	–	–	–	–	–	–
CFRP	–	–	–	–	–	–	–	–	–	–	–	–

S1 Workpiece Materials Listing • High-Temp Alloys • S1

S1 Iron-Based, Heat-Resistant Alloys *Tensile Strength RM (MPa)*: 500–1200* *Hardness (HB): 160–260 (HRC): 25–48*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
–	X 10 Cr 25	–	–	–	–	–	–	–	–	–	1.3811	–
–	D 1 a	–	–	–	–	–	–	–	–	–	1.3915	–
–	D 3	BD 3	–	–	X 210 Cr 1 2	Z 200 C 12	X 205 Cr 12 KU	–	–	–	1.3916	–
–	RNi 12	–	–	–	–	–	–	–	–	–	1.3926	–
–	RNi 8	–	–	–	–	–	–	–	–	–	1.3927	–
–	GX 2 NiCoMoTi1 7 10	–	–	–	–	–	–	–	–	–	1.6351	Maraging
6501, 6512, 6520	X 2 NiCoMo 18 8 5	–	–	UNS K92890	S162	Z2NKD18.8	–	–	–	ASTM A646	1.6359	ATI VascoMax® C-250
–	X 2 NiCoMo 18-8-5	–	–	K92890	–	–	–	–	–	–	1.6359	Maraging
–	X 1 CrNiCoMo 13 8 5	–	–	–	–	–	–	–	–	–	–	Maraging
–	Ni 36	–	–	–	–	–	–	–	–	–	1.3910	Magnifer 36
–	Ni 46	–	–	–	–	–	–	–	–	–	1.3920	–
–	X 2 CrNiCoMo 12 8 5	–	–	–	–	–	–	–	–	–	1.6980	Maraging
ASTM B463	–	–	–	UNS N08020	–	–	–	–	–	ASTM B463	2.4660	20CB-3
ASTM A666	–	–	–	–	–	–	–	–	–	ASTM A666	–	6/21/09
ASTM B753	–	–	–	–	–	–	–	–	–	ASTM B753	–	AL 4750
S66286	–	–	NAS 660	UNS S66286	–	–	A-286	–	–	–	–	ATI A286™
–	–	–	–	UNS K92810	–	–	–	–	–	–	–	ATI VascoMax® C-200
6514	–	–	–	UNS K93120	–	–	–	–	–	–	–	ATI VascoMax® C-300
–	–	–	–	–	–	–	–	–	–	–	–	ATI VascoMax® C-350
–	–	–	–	–	–	–	–	–	–	–	–	ATI VascoMax® T-200
6518, 6519, 6591	–	–	–	–	–	–	–	–	–	–	–	ATI VascoMax® T-250
–	–	–	–	–	–	–	–	–	–	–	–	ATI VascoMax® T-300
5725	–	–	–	–	–	Z3NCT25	–	–	SAE 16-25-6	–	–	Discaloy 16-25-6
ASTM A638	–	–	–	–	–	Z3NCT25	–	–	Discaloy	ASTM A638	–	Discaloy 24
–	–	–	–	R30556	–	–	–	–	–	–	–	Haynes® 556
5768	X 12 CrCoNi 21 20	–	–	–	–	Z12CKNDWNb21.20.20	–	–	–	–	–	Haynes 556
ASTM F30	–	–	–	–	–	–	–	–	Invar	ASTM F30	–	Invar 42
5768	–	–	–	UNS R30155	–	Z12CNKDW20	–	–	–	–	–	Multimet N-155
–	–	–	–	–	–	–	–	–	–	–	–	Multimet N-156
5533	X 40 CoCrNi 20 20	–	–	–	–	Z42CKNDW	–	–	–	–	–	S 590
–	X 2 NiCrAlTi 32 20	–	–	–	–	–	–	–	–	–	–	Sanicro 30
AISI:665	–	–	–	–	–	Z8NCTDA2613	–	–	–	–	–	W-545

S2 Workpiece Materials Listing • High-Temp Alloys • S2

S2 Cobalt-Based, Heat-Resistant Alloys *Tensile Strength RM (MPa)*: 1000–1450* *Hardness (HB): 250–450 (HRC): 25–48*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
–	CoCr 26 Ni 9 Mo	–	–	–	–	–	–	–	–	–	2.4681	–
–	CoCr 25 NiW	–	–	–	–	KC25WN	–	–	–	ASTM A567	2.4682	Stellite® 31 (X40)
–	CoCr 22 NiW	–	–	–	–	–	–	–	–	–	2.4683	–
–	CoCr 28 Mo	–	–	–	–	KC27D5NFe	–	–	–	ASTM F-75	2.4691	HS 21
–	CoCr 20 Ni 15 Mo	–	–	–	–	–	–	–	–	–	2.4711	–
–	CoCr 29 Mo	–	–	–	–	–	–	–	–	–	2.4723	–
–	CoCr 33 W	–	–	–	–	–	–	–	–	–	2.4775	–
–	CoCr 28	–	–	–	–	–	–	–	–	–	2.4778	–
–	CoCr 28 Nb	–	–	–	–	–	–	–	–	–	2.4779	–
–	–	–	–	–	–	–	–	–	–	ASTM F90	2.4964	F 90
–	–	–	–	R30605	–	KC20WN	–	–	–	–	2.4964	Haynes 25
–	CoCr 20 W 15 Ni	HR 240	–	R30605	–	KC20WN	–	–	–	5759	2.4964	L 605
–	CoCr 20 W 15 Ni	–	–	CAST Version of L605	–	KC20WN	–	–	–	5759	2.4964	Stellite 25
AMS 5399	NiCr 19 Co 11 MoTi	–	–	–	–	NC 19 KDT	–	–	–	–	2.4973	–
–	CoCr 20 Ni 20 W	–	–	–	–	–	–	–	–	5534	2.4979	S 816
–	CoCr20NiW	–	–	–	–	–	–	–	–	–	2.4989	–
–	–	–	–	R31537 & R31538	–	CoCr28Mo	–	–	–	ASTM F1537	–	F 1537
–	–	–	–	–	–	–	–	–	–	ASTM F562	–	F 562
–	–	–	–	–	–	–	–	–	–	ASTM F563	–	F 563
–	–	–	–	R30188	–	KC22N22W14Fe	–	–	–	–	–	Haynes 188
AISI 670	CoCr 20 W 15 Ni	–	–	–	–	KC20WN	–	–	–	–	–	HS 25
–	CoCr 26 Ni 14 Mo	–	–	–	–	–	–	–	–	5380	–	HS 30
–	CoCr 19 W 14 NiB	–	–	–	–	–	–	–	–	–	–	HS 36
–	–	–	–	–	–	–	–	–	–	–	–	L 251
–	CoCrW 10 TaZrB	–	–	–	–	KC21W10Ta9	–	–	–	–	–	MAR-M 302
–	CoCr 22 W 9 TaZrNb	–	–	–	–	KC21W9Ta	–	–	–	–	–	MAR-M 322
–	CoCr 24 Ni 10 WTaZrB	–	–	–	–	KC23N10W7Ta	–	–	–	–	–	MAR-M 509
–	–	–	–	–	–	KC20N20Ta7	–	–	–	–	–	MAR-M 905
–	CoCr 20 Ni 20 Ta	–	–	–	–	KC20N20Ta7	–	–	–	–	–	MAR-M 918
–	–	–	–	R30159	–	–	–	–	–	–	–	MP159
–	–	–	–	R30035	–	–	–	–	–	–	–	MP35N
–	–	–	–	–	–	KC33W13	–	–	–	–	–	Stellite 1
–	–	–	–	–	–	KC28W8	–	–	–	–	–	Stellite 12
–	–	–	–	–	–	KC22N22W14Fe	–	–	–	–	–	Stellite 188
–	–	–	–	–	–	KC26NW	–	–	–	–	–	Stellite 6
–	–	–	–	–	–	–	–	–	–	–	–	Stellite 8 (F75)
–	CoCr 25 Ni 20 MoWNb	–	–	–	–	KC25N20DFeWNb	–	–	–	–	–	V-36
–	CoCr 21 Mo 11 W	–	–	–	–	KC21W11ANbT	–	–	–	–	–	WI-52
–	–	–	–	–	–	KC25N10W7Fe	–	–	–	–	–	X 45
–	–	–	–	–	–	–	–	–	J-1570	–	–	–
–	K13C20N126Fe15D7	–	–	R3003 & R3008	–	K13C20N126Fe15D7	–	–	–	ASTM F1058	–	–

NOTE: For legend, see page Y217.

S3 Workpiece Materials Listing • High-Temp Alloys • S3

S3 Nickel-Based, Heat-Resistant Alloys *Tensile Strength RM (MPa)*: 600–1700* *Hardness (HB): 160–450 (HRC): <48*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
–	X 7 NiCrCoMo 54 20	–	–	–	–	–	–	–	–	–	1.2789	–
–	Ni 99,7 Mg 0,07	–	–	J24053	–	–	–	–	–	A 915 J24053	2.4053	–
–	LC-Ni 99,6	–	–	N02201	–	–	–	–	–	–	2.4061	–
–	–	–	–	N02200	–	–	–	–	–	–	2.4066	200
Nickel 200	Ni 99,2	NA 11	–	N02200	–	–	–	–	–	–	2.4066	–
–	–	–	–	N02201	–	–	–	–	–	–	2.4068	201
Nickel 201	LC-Ni 99	NA 12	–	–	–	–	–	–	–	–	2.4068	–
–	NiMn 1	–	–	–	–	–	–	–	–	–	2.4106	–
–	NiMn 1 C	–	–	–	–	–	–	–	–	–	2.4108	–
–	NiMn 1,5	–	–	–	–	–	–	–	–	–	2.4109	–
–	NiMn 3 Al	–	–	–	–	–	–	–	–	–	2.4122	–
–	NiMn 3 SiMg	–	–	–	–	–	–	–	–	–	2.4126	–
–	NiCr 2 Mn	–	–	–	–	–	–	–	–	–	2.4145	–
–	NiCr 2 MnSi	–	–	–	–	–	–	–	–	–	2.4146	–
–	NiCr 5 MnSi	–	–	–	–	–	–	–	–	–	2.4151	–
–	SG-NiTi 4	NA32	–	–	NA 32	–	–	–	–	–	2.4155	–
CZ-100	G-Ni 93 C	–	–	–	–	–	–	–	–	–	2.4175	–
–	NiCr 4 Mn	–	–	–	–	–	–	–	–	–	2.4199	–
M 35-1/2	G-NiCu 30 Nb	–	–	N24030	–	–	–	–	–	–	2.4365	–
–	EL-NiCu 30 Mn	–	–	N04402	–	–	–	–	–	–	2.4366	–
M 30-H	G-NiCu 30 Si 3	–	–	–	–	–	–	–	–	–	2.4367	–
M-255	G-NiCu 30 Si 4	–	–	–	–	–	–	–	–	–	2.4368	–
–	NiCu 30 Al	–	–	–	–	–	–	–	–	–	2.4374	–
–	NiCu 30 Al	NA 18	–	N05500	3072.76	NU 30 AT	–	–	–	–	2.4375	Monel® K500
–	SG-NiCu 30 MnTi	NA 33	–	–	–	–	–	–	–	–	2.4377	–
–	NiFe 16 CuCr	–	–	–	–	–	–	–	–	–	2.4501	–
–	G-NiMo 16 CrW	–	–	–	–	–	–	–	–	–	2.4537	–
–	NiCr 21 Mo 14 W	–	–	N26022	–	–	–	–	–	–	2.4602	INCONEL® alloy 622
–	NiCr 30 FeMo	–	–	–	–	–	–	–	–	–	2.4603	Hastelloy® G-30
–	–	–	–	N06059	–	–	–	–	–	ASTM B575	2.4605	Allcorr
–	NiCr 23 Mo 16 Al	–	–	–	–	–	–	–	–	–	2.4605	–
–	SG/UP-NiCr 23 Mo 16	–	–	–	–	–	–	–	–	–	2.4607	–
–	NiCr 26 MoW	–	–	–	–	–	–	–	–	–	2.4608	–
–	SG-NiMo 27	–	–	–	–	–	–	–	–	–	2.4615	–
–	NiMo 28	–	–	N10665	–	NiMo 28	–	–	–	–	2.4617	–
–	NiCr 22 Mo 6 Cu	–	–	–	–	–	–	–	–	–	2.4618	–
–	–	–	–	N06985	–	–	–	–	–	–	2.4619	Hastelloy G-3
–	NiCr 22 Mo 7 Cu	–	–	N06985	–	–	–	–	–	–	2.4619	–
–	SG-NiCr 23 Al	NA 49	–	–	–	–	–	–	–	–	2.4626	–
–	SG-NiCr 22 Co 12 Mo	NA 50	–	–	–	–	–	–	–	–	2.4627	–
–	NiCr 20 Ti	HR5	–	N06075	HR5, 203.4	NC 20 T	–	–	–	–	2.4630	Nimonic® 75
–	NiCr 20 TiAl	NA 20	NCF 80A	N07080	HR401, 601	NC 20 TA	–	–	–	–	2.4631	Nimonic 80A
–	NiCr 20 Co 18 Ti	NA 36	–	N07090	HR2, 202	NC20KTA	–	–	–	–	2.4632	Nimonic 90
–	NiCo 20 Cr 15 MoAlTi	–	–	N13021	HR3	NCKD20ATV	–	–	–	–	2.4634	Nimonic 105
–	NiCo 15 Cr 15 MoAlTi	HR4	–	–	HR401, 601	NCVK15ATD	–	–	–	–	2.4636	Nimonic 115
AISI 687	NiCo 15 Cr 15 MoAlTi	–	–	–	–	NCKD20AT	–	–	–	–	2.4636	Udimet® 700
–	NiCr 22 Mo 8 AlCuTi	–	–	–	–	–	–	–	–	–	2.4637	–
–	SG-NiCr 20	NA 34	–	–	–	–	–	–	–	–	2.4639	–
–	NiCr 21 Mo 6 Cu	–	NCF 600 TP	–	–	–	–	–	–	–	2.4641	–
–	NiCr 29 Fe	–	NCF 690	N06690	–	NC 30 Fe	–	–	–	–	2.4642	INCONEL® alloy 690
–	NiCr 25 FeAlYC	–	–	–	–	–	–	–	–	–	2.4647	–
–	NiCr 20 CoMoTi	NA 38	NCF 690	N07263	HR10	NCK 20 D	–	–	–	–	2.4650	Nimonic C263
–	EL-NiCr 26 Mo	–	–	–	–	–	–	–	–	–	2.4652	–
–	NiCr 19 Co 14 Mo 4 Ti	–	–	N07001	–	NC20K14Y	–	–	–	–	2.4654	Waspaloy
–	SG-NiCr 29 Mo	–	–	–	–	–	–	–	–	–	2.4656	–
–	NiCr 70 30	–	–	N06008	–	–	–	–	–	–	2.4658	–
–	SG-NiCr 30 Mo 5 W	–	–	–	–	–	–	–	–	–	2.4659	–
–	EL-NiCr 29 Mo 5 W	–	–	–	–	–	–	–	–	–	2.4661	–
–	NiFe 35 Cr 14 MoTi	–	–	N09901	–	Z8NCDT42	–	–	–	–	2.4662	INCOLOY® 901
–	NiCr 13 Mo 6 Ti 3	–	–	N09901	–	Z8NCDT42	–	–	–	–	2.4662	Nimonic 901
–	NiCr 23 Co 12 Mo	–	–	N06617	–	NC22K12D9A	–	–	–	–	2.4663	INCONEL® alloy 617
–	NiCr 22 FeMo	–	–	N06002	HR6, 204	NC22FeD	–	–	–	–	2.4665	Hastelloy X
–	NiCr 22 Fe 18 Mo	NA 40	–	N06002	–	NC22FeD	–	–	–	–	2.4665	INCONEL alloy HX
–	NiCr 18 CoMo	–	–	–	–	NKCD20ATU	–	–	–	–	2.4666	Nimonic PK25
–	SG-NiCr 19 NbMoTi	NA 51	–	–	–	–	–	–	–	–	2.4667	–
–	NiCr 19 FeNbMo	–	–	N07718	HR8	NC 19 Fe Nb	–	–	–	–	2.4668	INCONEL alloy 718
–	NiCr 15 Fe 7 TiAl	–	–	N07750	–	NC 15 Fe 7 TA	–	–	–	–	2.4669	INCONEL alloy X750
–	G-NiCr 12 Al 6 MoNb	–	–	–	–	–	–	–	–	–	2.4671	–
–	G-NiCr 20 Co 20 MoTi	–	–	–	–	–	–	–	–	–	2.4672	–
–	NiCo 15 Cr 10 MoAlTi	–	–	N13100	–	NK15CAT	–	–	–	–	2.4674	IN 100
–	NiCo 15 Cr 10 MoAlTi	–	–	–	–	NK15C10A5T	–	–	–	–	2.4674	René 100
–	G-NiCo 15 Cr 10 AlTiMo	–	–	–	–	–	–	–	–	–	2.4674	–
–	G-NiCo 10 W 10 CrAlNb	–	–	–	–	–	–	–	–	–	2.4676	–
–	G-NiCr 50	–	–	–	–	–	–	–	–	–	2.4678	–
–	G-NiCr 35	–	–	–	–	–	–	–	–	–	2.4679	–
–	–	–	–	N10665	–	–	–	–	–	N7M	2.4685	Hastelloy B-2
CW-12 MW	G-NiMo 17 CrW	–	–	–	–	–	–	–	–	–	2.4686	–
–	NiCr 25 Mo 7 Ti	–	–	–	–	–	–	–	–	–	2.4693	–
–	NiCr 16 Fe 7 TiAl	–	–	N 07751	–	–	–	–	–	–	2.4694	INCONEL alloy 751
–	G-NiCr 20 Mo 15	–	–	–	–	–	–	–	–	–	2.4697	–
–	NiCr 22 W 14 Mo	–	–	–	–	–	–	–	–	–	2.4733	–
–	NiCr 20 AlY	–	–	–	–	–	–	–	–	–	2.4764	–
–	NiCr 17 AlWY	–	–	–	–	–	–	–	–	–	2.4765	–
–	SG-NiCr 20 Nb	NA 35	–	–	–	–	–	–	–	–	2.4806	–
–	G-NiCr 50 Nb	–	–	–	–	–	–	–	–	–	2.4813	–
–	NiCr 15 Fe	NA 14	NCF 600	N06600	3072.76	NC 15 Fe	–	–	–	–	2.4816	INCONEL alloy 600
–	G-NiMo 30	–	–	N10276	–	NC 15 D 14 KFe	–	–	–	–	2.4819	Hastelloy C-276
ASME SB575	NiMo 16 Cr 15 W	–	–	N10276	–	NC 17 D	–	–	–	–	2.4819	Nimonic C276

(continued)

S3 Workpiece Materials Listing • High-Temp Alloys • S3 *(continued)*

S3 Nickel-Based, Heat-Resistant Alloys *Tensile Strength RM (MPa)*: 600–1700* *Hardness (HB): 160–450 (HRC): <48*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
–	SG-NiCr 21 Mo 9 Nb	–	–	–	–	–	–	–	–	–	2.4831	–
–	NiCr 20 Mo 15	–	–	–	–	–	–	–	–	–	2.4836	–
–	SG-NiCr 20 Mo 15	–	–	–	–	–	–	–	–	–	2.4839	–
–	–	–	–	N06601	–	–	–	–	–	–	2.4851	Haynes® 601
–	NiCr 23 Fe	–	NCF 601	N06601	–	NC 23 Fe 14 A	–	–	–	–	2.4851	INCONEL alloy 601
–	NiFe 33 Cr 25 Co	–	–	–	–	–	–	–	–	–	2.4854	–
–	NiCr 19 Mo 9 Si	–	–	–	–	–	–	–	–	–	2.4855	–
ASME SB443	NiCr 22 Mo 9 Nb	–	–	N06625	–	NC 22 Fe DNb	–	–	–	–	2.4856	Haynes 625
ASME SB443.4	NiCr 22 Mo 9 Nb	NA 21	NCF 625	N06625	–	NC 22 Fe DNb	–	–	–	–	2.4856	INCONEL alloy 625
ASME SB163	NiCr 21 Mo	–	–	N08825	3072.76	NC21FeDU	–	–	–	–	2.4858	INCOLOY® 825
–	NiCr 60 15	–	–	–	–	–	–	–	–	–	2.4867	–
–	NiCr 80 20	–	–	–	–	–	–	–	–	–	2.4869	–
–	NiCr 20 AlSi	–	–	–	–	–	–	–	–	–	2.4872	–
–	G-NiCr 28 W	–	–	–	–	–	–	–	–	–	2.4879	Centralloy® 4879
–	NiCr 17 Mo 17 FeW	–	–	N10002	–	NC17DWY	–	–	–	CW12MW	2.4883	Hastelloy C
–	G-NiMo 16 Cr	–	–	–	–	–	–	–	–	–	2.4883	–
–	SG-NiMo 16 cr 16 W	NA 48	–	–	–	–	–	–	–	–	2.4886	–
–	G-NiCr 13 MoAl	–	–	–	–	–	–	–	–	–	2.4888	–
–	NiCr 20 Ti	HR 5	–	N06621	–	NC 20 T	–	–	–	–	2.4951	–
–	NiCr 20 TiAl	NA 20	NCF 80 A	N07080	–	NC 20 TA	–	–	–	–	2.4952	–
–	NiFe 25 Cr 20 NbTi	–	–	–	NiFe 25 Cr 20 NbTi	–	–	–	–	–	2.4955	–
–	NiCr 20 Co 18 Ti	NA 19	–	N07090	–	–	–	–	–	–	2.4969	–
–	NiCr 22 W 12 Fe	–	–	–	–	–	–	–	–	–	2.4972	–
–	NiCr 19 Co 11 MoTi	–	–	N07041	–	NC19KDT	–	–	–	–	2.4973	René 41
–	NiFeCr 12 Mo	–	–	–	–	–	–	–	–	–	2.4975	–
–	NiCr 20 Mo	–	–	–	–	–	–	–	–	–	2.4976	–
–	NiCr 20 CoMo	–	–	–	–	–	–	–	–	–	2.4982	–
–	NiCr 18 Co	–	–	N07500	–	–	–	–	–	–	2.4983	Co500
AISI 684	NiCr 18 CoMoAlTi	–	–	N07500	–	NCK19DAT	–	–	–	–	2.4983	Udimet® 500
–	Ni 99,6	NA 46	–	–	–	–	–	–	–	–	2.4060	–
–	NiMn 2	–	–	–	–	–	–	–	–	–	2.4110	–
SZ-100	G-Ni 95	–	–	–	–	–	–	–	–	–	2.4170	–
–	G-Ni 93 Si	–	–	–	–	–	–	–	–	–	2.4180	–
–	NiCu 30 Fe	–	–	N04400	3072.76	NU30	–	–	–	–	2.4360	Monel® 400
–	NiCu 30 Ti	–	–	–	–	–	–	–	–	–	2.4370	Monel 60
–	NiFe 44	–	–	–	–	–	–	–	–	–	2.4420	Magnifer 53
–	NiFe 16 CuMo	–	–	–	–	–	–	–	–	–	2.4530	Perm 77
–	NiFeK 6040	–	–	–	–	–	–	–	–	–	2.4560	–
–	NiMo 16 Cr 16 Ti	NA 45	–	N26455	–	–	–	–	–	–	2.4610	Hastelloy C-4
–	–	–	–	–	–	20CB-3	–	–	–	ASTM B463	2.4660	INCOLOY 020
–	NiCr 20 CuMo	–	–	N08020	–	–	–	–	–	–	2.4660	–
–	G-NiCr 13 Al 16 MoNb	–	–	–	HC203	NC13AD	–	–	–	–	2.4670	Nimocast 713
–	G-NiCr 50 Nb	–	–	–	–	–	–	–	–	–	2.4680	–
–	NiMo 23 Cr 8 Fe	–	–	–	–	–	–	–	–	–	2.4710	–
–	NiMo 30	–	–	–	–	ND27FeV	–	–	–	N-12 MV	2.4810	Hastelloy B
–	NiCr 45 23	–	–	–	–	–	–	–	–	–	2.4890	–
–	–	–	–	N13017	–	NK17C15D5AT	–	–	–	–	–	Astroloy
–	–	–	–	–	–	–	–	–	–	–	–	Centralloy® 60HTD
AISI 686	–	–	–	–	–	NC15Fe10D5AT	–	–	–	–	–	GMR 235
–	NiCr 16 MoAl	–	–	–	–	NC15D5FeAT	–	–	–	–	–	GMR 235-D
–	–	–	–	–	–	–	–	–	–	CW6M	–	Hastelloy C-22
–	–	–	–	N06007	–	NC22Fe19D6KTa	–	–	–	–	–	Hastelloy G
–	–	–	–	N10003	–	–	–	–	–	–	–	Hastelloy N
–	–	–	–	N06635	–	NC15D14KFe	–	–	–	–	–	Hastelloy S
–	–	–	–	N10004	–	–	–	–	–	–	–	Hastelloy W
–	–	–	–	N07263	–	NC20K20D6T	–	–	–	–	–	Haynes® 263
–	–	–	–	–	–	–	–	–	–	–	–	Haynes 282
–	NiCr 15 Fe	–	–	N06600	–	–	–	–	–	–	–	Haynes 600
–	–	–	–	–	–	–	–	–	–	–	–	Haynes 75
–	NiCo 32 Cr 26 Mo	–	–	–	–	–	–	–	–	–	–	HS27
–	–	–	–	N06102	–	–	–	–	–	–	–	IN 102
ASME SB409	X 10 NiCrAlTi 32-20	–	–	N08800	3082.76	Z10NC3221	–	–	–	–	–	INCOLOY 800
–	–	–	–	–	–	Z4NC3221	–	–	–	–	–	INCOLOY 802
–	–	–	–	–	–	NC29Fe25	–	–	–	–	–	INCOLOY 804
–	NiFe 42 K 15 Nb	–	–	N19903	–	Z3NK28	–	–	–	–	–	INCOLOY 903
–	–	–	–	N19907	–	–	–	–	–	–	–	INCOLOY 907
–	–	–	–	N09925	–	–	–	–	–	–	–	INCOLOY 925
–	–	–	–	N09945	–	–	–	–	–	–	–	INCOLOY 945
ASME SB575	–	–	–	–	–	NiMo16Cr15	–	–	–	–	–	INCONEL alloy 22
–	–	–	–	–	–	–	–	–	–	–	–	INCONEL alloy 230
–	–	–	–	–	–	–	–	–	–	–	–	INCONEL alloy 600SP
–	–	–	–	–	–	–	–	–	–	–	–	INCONEL alloy 62
–	–	–	–	N06626	–	–	–	–	–	–	–	INCONEL alloy 625LCF
–	–	–	–	–	–	NC15A	–	–	–	–	–	INCONEL alloy 702
–	–	–	–	N09706	–	NFe10C16NbT	–	–	–	–	–	INCONEL alloy 706
–	–	–	–	N07718	–	–	–	–	–	–	–	INCONEL alloy 718 OP
–	–	–	–	–	–	NC16Fe8TM	–	–	–	–	–	INCONEL alloy 721
–	NiCr 16 FeTi	–	–	N07722	–	NC16FeTi	–	–	–	–	–	INCONEL alloy 722
–	–	–	–	R30783	–	–	–	–	–	–	–	INCONEL alloy 783
–	–	–	–	N09925	–	–	–	–	–	B983 N09925	–	INCONEL alloy 925
–	–	–	–	N10276	–	–	–	–	–	–	–	INCONEL alloy C-276
–	–	–	–	N07754	–	–	–	–	–	–	–	INCONEL alloy MA754
–	–	–	–	N07751	–	–	–	–	–	–	–	INCONEL alloy X751
–	–	–	–	K93600 K93603	–	–	–	–	–	ASTM F1684	–	INVAR® 36
–	NiCr 20 Co 18 Ti	–	–	–	–	–	–	–	–	–	–	Jessop G81
–	G-NiCr 19 Co	–	–	N07252	–	–	–	–	–	–	–	M 252
–	–	–	–	N04405	–	–	–	–	–	–	–	Monel® R405

NOTE: For legend, see page Y217.

(continued)

S3 Workpiece Materials Listing • High-Temp Alloys • S3 *(continued)*

S3 Nickel-Based, Heat-Resistant Alloys *Tensile Strength RM (MPa)*: 600–1700* *Hardness (HB): 160–450 (HRC): <48*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
–	NiFe 33 Cr 17 Mo	–	–	–	–	–	–	–	–	–	–	Nimocast PD16
–	–	–	–	–	HC202	NC20N13	–	–	–	–	–	Nimocast PE10
–	–	–	–	–	–	NC19K18Fe5TA	–	–	–	–	–	Nimonic® 95
ASME SB575	–	–	–	N06022	–	–	–	–	–	–	–	Nimonic C22
–	NiCr 22 Fe 18 Mo	–	–	–	HR6, 204	NC22FeD	–	–	–	–	–	Nimonic PE13
–	NiFe 33 Cr 17 Mo	–	–	–	HR207	NW11AC	–	–	–	–	–	Nimonic PE16
–	NiCr 20 Co 16 MoTi	–	–	–	–	NC19KDUN	–	–	–	–	–	Nimonic PK33
–	–	–	NCF 3015	–	–	–	–	–	–	–	–	NiReVa 3015
AISI 686	–	–	–	–	–	–	–	–	–	–	–	R-235
AISI 690	–	–	–	–	–	Z6NKCDT38	–	–	–	–	–	Refractaloy 26
–	–	–	–	–	–	NK10C8W7ATaTD	–	–	–	–	–	René 125
–	–	–	–	–	–	NK15C14D6AWT	–	–	–	–	–	René 65
–	–	–	–	–	–	NC15K15ADT	–	–	–	–	–	René 77
–	–	–	–	–	–	NC14K9T5DWA	–	–	–	–	–	René 80
–	–	–	–	–	–	NC14K8	–	–	–	–	–	René 95
–	NiTa 9 Co 8 W 6 CrAl	–	–	–	–	NTa9K7C6W5A5DT	–	–	–	–	–	TRW VIA
–	NiCr 19 NbMo	–	–	–	–	NC18Fe18Nb6DWT	–	–	–	–	–	Udimet® 630
–	–	–	–	–	–	NCK18TDA	–	–	–	–	–	Udimet 710
–	–	–	–	–	–	NC18K15TDA	–	–	–	–	–	Udimet 720

S4 Workpiece Materials Listing • High-Temp Alloys • S4

S4 Titanium and Titanium Alloys *Tensile Strength RM (MPa)*: 900–1600* *Hardness (HB): 300–400 (HRC): 33–48*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
R 50250	Ti-99.8	2 TA 1	–	UNS R50250	TA6, TA7, TA8, TA9	AIR:9182T35	–	–	–	ASTM B381F1	3.7025	ATI 30 CP Grade 1
R 50400	Ti-99.7	2 TA 2-5	–	UNS R50400	TA2.5	AIR:9182T40	–	–	–	ASTM B381F2	3.7035	ATI 40 CP Grade 2
–	SG-Ti 2	–	–	–	–	–	–	–	–	–	3.7036	–
R 50550	Ti-99.6	TA 3	–	UNS R50550	TA2, TA3, TA4, TA5	AIR:9182T50	–	–	–	ASTM B381F3	3.7055	ATI 55 CP Grade 3
R 50700	Ti-99.5	2 TA 6-9	–	UNS R50700	–	AIR:9182T60	–	–	–	ASTM B381F4	3.7065	ATI 70 CP Grade 4
–	TiNi 0,8 Mo 0,3	–	–	UNS R53400	–	–	–	–	Ti-3Al-1.5Mn	ASTM Grade 12	3.7105	–
Ti 5Al-2.5Sn	TiAl 5 Sn 2,5	–	–	UNS R54520	TA 14,17	T-A5E	–	–	Ti-5Al-2.5Sn	–	3.7115	ATI Grade 6
–	TiCu 2	2 TA 21-24	–	–	–	–	–	–	Ti-2Cu	–	3.7124	–
R 54620	TiAl 6 Sn 2 Zr 4 Mo 2 Si	–	–	UNS R54620	–	–	–	–	Ti-6Al-2Sn-2Zr-4Mo-2Si	–	3.7145	–
–	TiAl 6 ZrMo 0,5	TA 43	–	–	–	–	–	–	Ti-6-5-0.5	–	3.7155	–
R 56400	TiAl 6 V 4	TA 10-13	TC4	UNS R56400	TA10 TA11 TA12 TA13 TA28 TA56	TA6V	–	–	Ti-6Al-4V	–	3.7164	ATI 6-4™
–	TiAl 6 V4	–	TC4	UNS R56400	TA10 TA11 TA12 TA13 TA28 TA56	TA6V; AIR:9183	–	–	Ti-6Al-4V (Beta)	–	3.7164	–
R 56620	TiAl 6 V 6 Sn2	–	–	UNS R56620	–	–	–	–	Ti-6Al-6V-2Sn	–	3.7175	ATI 6-6-2™
–	TiAl 4 Mo 4 Sn 2	TA 45-51	–	–	–	–	–	–	Ti-4Al-4Mo-2Sn	–	3.7185	–
–	TiAl 3 V2.5	–	–	UNS R56320	–	–	–	–	Ti-3Al-2.5V	ASTM Grade 9	3.7195	ATI 3-2.5-MIL™
R 52250	Ti 1 Pd	TP 1	–	UNS R 52250	–	–	–	–	–	ASTM Grade 11	3.7225	–
R 52400	Ti 2 Pd	–	–	UNS R 52400	–	–	–	–	–	ASTM Grade 7	3.7235	–
–	Ti 3 Pd	–	–	–	–	–	–	–	–	–	3.7255	–
–	TiAl 5 Fe 2,5	–	–	–	–	–	–	–	Ti-5Al-2.5Fe	–	3.7110	–
–	TiV13Cr11Al3	–	–	–	–	–	–	–	Ti-13V-11Cr-3Al	–	–	11/13/03
–	Ti-10V-2Fe-3Al	–	–	–	–	–	–	–	Ti-10.2.3	–	–	ATI 10-2-3™
–	–	–	–	UNS R58153	–	–	–	–	Ti-15-333	–	–	ATI 15-333™
–	–	–	–	–	–	–	–	–	Ti-15Mo (Alpha + Beta)	–	–	ATI 15Mo™ (Alpha + Beta)
–	–	–	–	–	–	–	–	–	Ti-15Mo (Beta)	–	–	ATI 15Mo™ (Beta)
–	Ti5Al2Sn2Zr4Cr4Mo	–	–	UNS R58650	–	–	–	–	–	–	–	ATI 17™
–	TIAl 3 V 8 Cr 6 Mo 4 Z 4	–	–	–	–	–	–	–	Ti-3Al-8V-6Cr-4Mo-4Zr	ASTN Grade 19	–	ATI 38-644™
–	–	–	–	UNS R54250	–	–	–	–	Ti-425	ASTM B265	–	ATI 425®
–	–	–	–	–	–	–	–	–	Ti-425 MIL	–	–	ATI 425®-MIL
–	TiAl 4 Mo 4 Sn 2 Si 0.5	–	–	–	5103	T-A4DE	–	–	Ti-4Al-4Mo-2Sn-0.5Si	–	–	ATI 4-4-2™
–	–	–	–	–	–	–	–	–	Ti-45Nb	–	–	ATI 45Nb™
–	–	–	–	–	–	–	–	–	Ti-5Al-5V-5Mo-3Cr	–	–	ATI 5-5-5-3 PM™
–	–	–	–	–	–	–	–	–	Ti-6Al-2Sn-2Zr-2Mn-2Cr-0.2Si	–	–	ATI 6-2222™
–	–	–	–	UNS R54620	–	–	–	–	Ti-6Al-4Zr-2Mo-2Sn	–	–	ATI 6-2-4-2 PM™
–	TiAl6Zr4Mo2Sn2	–	–	UNS R54620 modified	–	–	–	–	Ti-6Al-4Zr-2Mo-2Sn-0.2Si	–	–	ATI 6-2-4-2-Si PM™
–	–	–	–	UNS R56260	–	–	–	–	Ti-6-2-4-6	–	–	ATI 6-2-4-6™
–	–	–	–	UNS R56401	–	–	–	–	Ti-6Al-4V ELI	–	–	ATI 6-4 ELI™
–	TiAl 6 V4	–	–	UNS R56400	TA10 TA11 TA12 TA13 TA28 TA56	TA6V; AIR:9183	–	–	Ti-6Al-4V MIL	–	–	ATI 6-4-MIL™
–	TiAl 6 V4	–	–	UNS R56400	TA10 TA11 TA12 TA13 TA28 TA56	TA6V; AIR:9183	–	–	Ti-6Al-4V MIL (HT)	–	–	ATI 6-4-MIL™
–	–	–	–	UNS R56700	–	–	–	–	Ti-6-7	ASTM F 1295	–	ATI 6-7™
–	TiAl8Mo1V1	–	–	UNS R54810	–	–	–	–	Ti-8Al-1Mo-1V	–	–	ATI 8-1-1™
–	–	–	–	–	–	–	–	–	Ti-15Mo-3Nb-3Al-0.2Si	ASTM Grade 21	–	Beta 21-S
–	–	–	–	–	–	–	–	–	Ti-12Mo-6Zr-2Fe	–	–	TMZF
–	TiAl7Nb	–	–	–	–	–	–	–	Ti-6Al-7Nb	–	–	–
–	TiAl7Mo4	–	–	–	–	–	–	–	–	ASTM B381	–	–
–	TiAl 4 Mo 4 Sn 4 Si 0.5	–	–	–	5203	–	–	–	Ti-4Al-4Mo-4Sn-0.5Si	–	–	–
–	TiA6Zr5Mo0.5Si0.25	–	–	–	–	T.AGZ.50	–	–	Ti-6Al-5Zr-0.5Mo-0.25Si	–	–	–
–	TiAl6Zr5Mo4CuSi0.2	–	–	–	M201	–	–	–	Ti-6Al-5Zr-4Mo-Cu-0.2Si	–	–	–
–	–	–	TC18	–	–	–	–	–	Ti-5Al-5Mo-5V-1Cr-1Fe	–	–	–
–	–	–	–	UNS %58210	–	–	–	–	Ti Beta 21 S	ASTM Grade 21	–	–
Ti 98.8	Ti 98.8	–	–	–	–	–	–	–	–	–	–	–
Ti 99.9	Ti 99.9	–	–	–	–	–	–	–	–	–	–	–
–	TiAL 6 Sn 2 Zr 4 Mo 2	–	–	–	–	–	–	–	–	–	–	–

NOTE: For legend, see page Y217.

H1 ■ Workpiece Materials Listing • Hardened Steels and Irons • H1

H1 Hardened Materials *Hardness (HRC): 44–48*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
H 11	X 38 CrMoV 5 H1	BH 11	SKD 6	T20811	X 38 CrMoV 5 H1	Z 38 CDV 5	X 37 CrMoV 5 1 KU	–	–	–	1.2343	–
H11	X 38 CrMoV 5 H1	BH 11	SKD 6	T20811	X 38 CrMoV 5 H1	Z 38 CDV 5	X 37 CrMoV 5 1 KU	–	–	–	1.2343	–
H 13	X 40 CrMoV 5 1	BH 13	SKD 61	T20813	X 40 CrMoV 5 1	Z 40 CDV 5	X 40 CrMoV 5 1 1 KU	2242	–	–	1.2344	–
H 10	X 32 CrMoV 3 3	BH 10	SKD 7	T 20810	X 32 CrMoV 12H-28	32 DCV 28	30 CrMoV 12 27 KU	–	–	–	1.2365	–
H19	X 45 CrCoVW 5 5 5	–	–	–	–	–	–	–	–	–	1.2678	–
A 532 I B NiCr-LC	GX 260 NiCr 42	Grade 2 A	0512-00	F45001	GJH-X260NiCr 4-2	–	–	0512-00	–	–	0.9620	–
L6	–	–	–	–	–	55 NCDV 07 (HT)	–	–	–	–	–	–

H2 ■ Workpiece Materials Listing • Hardened Steels and Irons • H2

H2 Hardened Materials *Hardness (HRC): 48–55*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
A 532 I A NiCr-HC	G-X 330 NiCr 42	Grade 2 B	0513-00	F45000	GJH-X330NiCr 4-2	FB Ni 4 Cr2 HC	–	0513-00	–	–	0.9625	–
H 21	X 30 WCrV 93	BH 21	SKD 5	T 20821	X 30 WCrV 9 3	Z 30 WCV 9	X 30 WCrV 9 3 KU	–	–	–	1.2581	–
H 12	X 37 CrMoW 5 1	BH 12	SKD 62	T20812	–	Z 35 CWDV 5	X 35 CrMoW 05 KU	–	–	–	1.2606	–
–	G-X 300 NiMo 3 Mg	–	–	–	GJH-X300NiMo 3 Mg	–	–	–	–	–	0.9610	–
A 532 I B NiCr-LC	GX 260 NiCr 42	Grade 2 A	0512-00	F45001	GJH-X260NiCr 4-2	–	–	0512-00	–	–	0.9620	–
A 532 III A 25% Cr	GX 260 Cr 27	Grade 3 D	0466-00	–	GJH-X260Cr 27	–	–	–	–	–	0.9650	–
–	X 2 NiCoMoTi 180905	–	–	–	–	Z 2 NKD 180905	–	–	–	–	–	Durimphy
K12	–	–	–	–	–	–	–	–	–	–	–	ATI K12 MIL

H3 ■ Workpiece Materials Listing • Hardened Steels and Irons • H3

H3 Hardened Materials *Hardness (HRC): 56–60*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
A 532 IIC15% CrMo-HC	G-X 300CrMo 15 3	Grade 3 A	–	–	GJH-X300CrMo 15-3	–	–	–	–	–	0.9635	–
–	G-X 300 CrMoNi 15 2 1	Grade 3 B	–	F45005	GJH-X300CrMoNi15-2-1	–	–	–	–	–	0.9640	–
A 532 IID20% CrMo-LC	GX 260 CrMoNi 20 2 1	Grade 3 C	–	F45007	GJH-X260CrMoNi20-2-1	–	–	–	–	–	0.9645	–
A 532 III A 25% Cr	G-X 300 CrMo 27 1	Grade 3 E	–	–	GJH-X300CrMo 27-1	–	–	–	–	–	0.9655	–
A 2	X 100 CrMoV 5 1	SKD 12	–	–	BA 2	Z 100 CDV 5 (HT)	X 100 CrMoV 51 KU	2260	–	–	1.2363	–
D7 (HT)	–	–	–	T30407	–	Z 230 CVA 12 04	–	–	–	–	1.2378	–
O 2	90 MnCrV 8	BO 2	–	T31502	90 MnV 8	90 MnV 8	90 MnVCr 8 KU	–	–	–	1.2842	–
A 532 I D Ni-HiCr	G-X 300 CrNiSi 95 2	Grade 2 C	0457-00	F45003	GJH-X300CrNiSi 9-5-2	–	–	–	–	–	0.9630	Nihard type 4
S 1	60 WCrV 7	BS 1	–	–	6020 WCrV 8	55 WC 20	55 WCrV 8 KU	–	–	–	1.2550	–
S 1	60 WCrV 7	BS 1	–	–	60 WCrV 8	55 WC 20	55 WCrV 8 UK	–	–	–	1.2550	–
S 7	50 CrMoV 13 14	–	–	–	–	–	–	–	–	–	–	Cryodur 2357
K 12 (HT)	–	–	–	–	–	–	–	–	–	–	–	ATI K12-MIL

H4 ■ Workpiece Materials Listing • Hardened Steels and Irons • H4

H4 Hardened Materials *Hardness (HRC): >60*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
W 108	C 80 W 1	–	–	T72301	C 80 U	Y1 90	C 80 KU	1880	–	–	1.1525	–
D 2	X 155 CrVMo 12 1	BD 2	SKD §§	T 30402	X 153 CrMoV 12	Z 160 CDV 12	X 155 CrVMo 12 1 KU	2310	–	–	1.2379	–
–	100 WV4	–	SKS 21	–	–	–	–	–	–	–	1.2515	–
D 3	X 210 Cr 12	BD 3	SKD 1	T30403	X 210 Cr 1 2	Z 200 C 12	X 205 Cr 12 KU	–	–	–	1.2080	–
O 7	110 WCrV 5	–	–	–	–	–	–	–	–	–	–	–
–	Mh97 + Pb	–	–	–	–	–	–	–	–	–	–	LAW 100 Pb

■ Workpiece Materials Listing Legend

* 1 Mpa = 145 psi.
** Includes ASTM and SAE material specifications.
AISI — American Iron and Steel Institute
AFNOR — French National Organisation for Standardisation
AMS — Aerospace Material Specifications
ASTM — American Society of Mechanical Engineers
BS — British Standards
DIN — German Institute for Standardisation
EN — European Standards
JIS — Japanese Industrial Standards
SAE — Society of Automotive Engineers
SIS — Swedish Standards Institute
UNI — Italian Organisation for Standardisation
UNS — Unified Numbering System

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METALCUTTING SAFETY

IMPORTANT SAFETY INSTRUCTIONS

Read before using the tools in this catalogue!

Projectile and Fragmentation Hazards:

Modern metalcutting operations involve high spindle and cutter speeds and high temperatures and cutting forces. Hot metal chips may fly off the workpiece during metalcutting. Although cutting tools are designed and manufactured to withstand high cutting forces and temperatures, they can sometimes fragment, particularly if they are subjected to over-stress, severe impact, or other abuse.

To avoid injury:

- Always wear appropriate personal protective equipment, including safety goggles, when operating metalcutting machines or working nearby.
- Always make sure all machine guards are in place.

Breathing and Skin Contact Hazards:

Grinding carbide or other advanced cutting tool materials produces dust or mist containing metallic particles. Breathing this dust or mist — especially over an extended period — can cause temporary or permanent lung disease or make existing medical conditions worse. Contact with this dust or mist can irritate eyes, skin, and mucous membranes and may make existing skin conditions worse.

To avoid injury:

- Always wear breathing protection and safety goggles when grinding.
- Provide ventilation control and collect and properly dispose of dust, mist, or sludge from grinding.
- Avoid skin contact with dust or mist.

For more information, read the applicable Material Safety Data Sheet provided by Kennametal and consult General Industry Safety and Health Regulations, Part 1910, Title 29 of the Code of Federal Regulations.

These safety instructions are general guidelines. Many variables affect machining operations. It is impossible to cover every specific situation. The technical information included in this catalogue and recommendations on machining practices may not apply to your particular operation. For more information, consult the Kennametal Metalcutting Safety booklet, available free from Kennametal at 724 539 5747 or fax 724 539 5439. For specific product safety and environmental questions, contact our Corporate Environmental Health and Safety Office at 724 539 5066 or fax 724 539 5372.

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